

(1) VALUE STREAM:

ACME VSM for Steering wheel bracket assembly. The product family has two variants (Left, Right)

(3) VSM ICONS



(2) DATE: 28/12/2021

(2) CHAMPION:

Barb Smith

(2) SPONSER:

Paul Doe

(2) TEAM MEMBERS :

Peter

Stephan

Jason

(4) VALUE STREAM GOALS

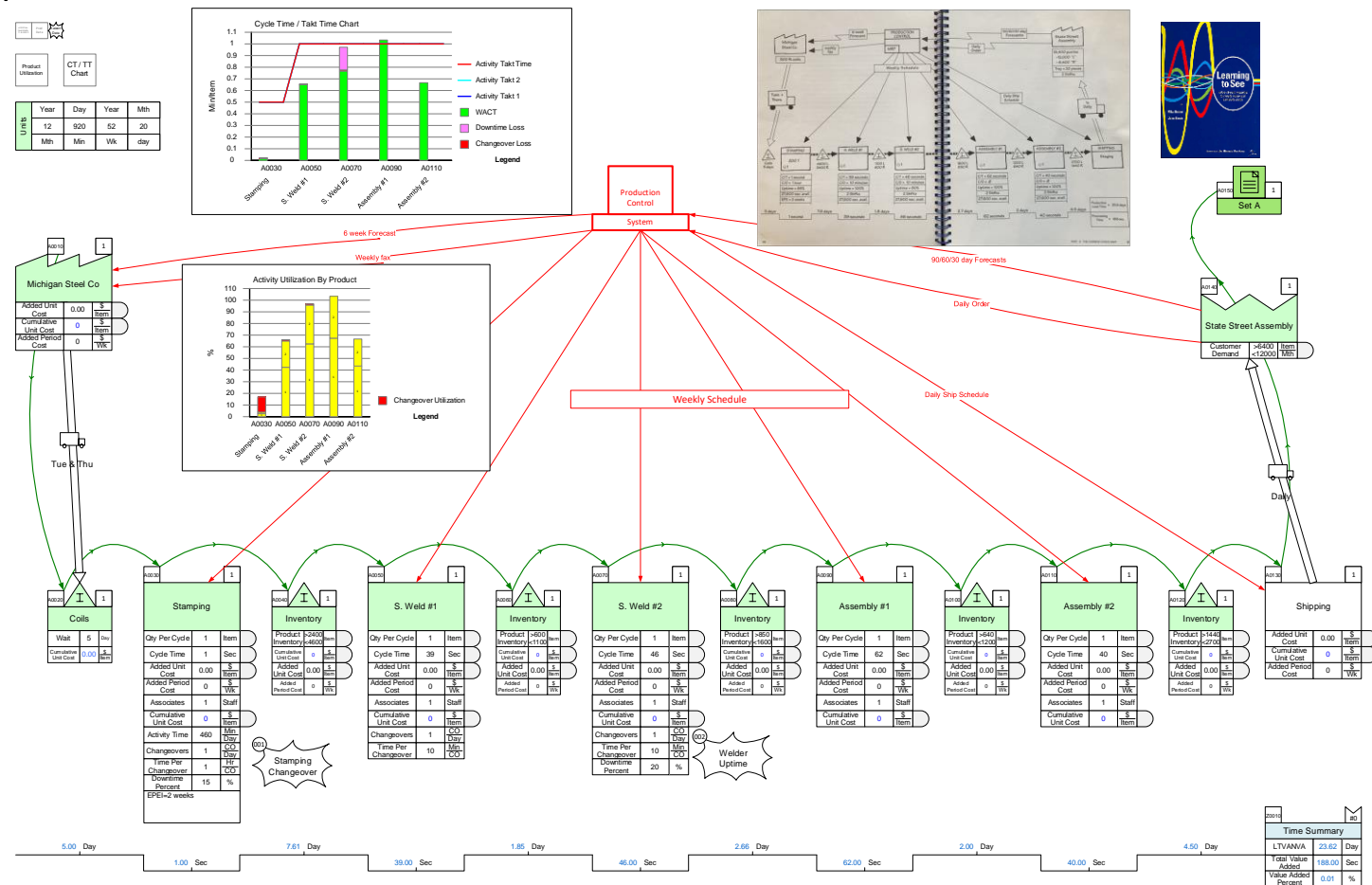
- Improve the lead time
- Identify and eliminate the wastes
- Implement single point scheduling
- Produce to Demand
- Flexible capacity with small production intervals

(9) COST BENEFITS

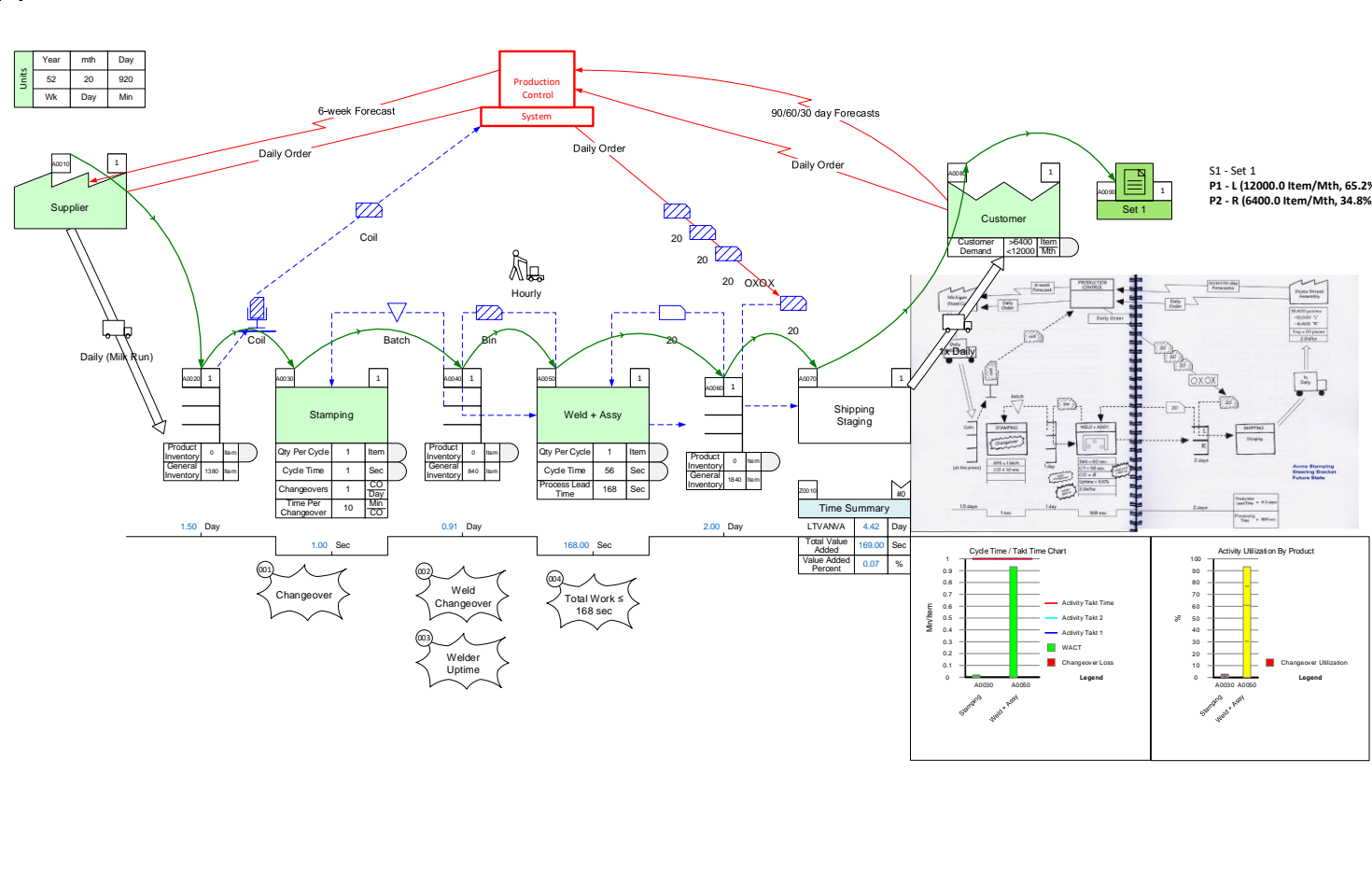
ONE TIME SAVING:

ANNUAL SAVING:

(5) CURRENT STATE MAP



(7) FUTURE STATE MAP



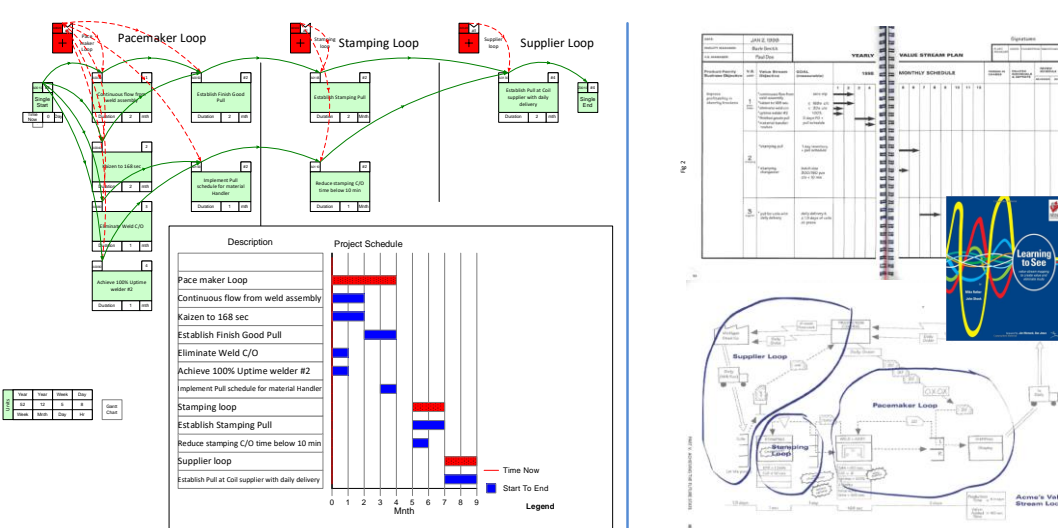
(8) METRICS

Lead Time: CS: 23.6 days
 FS: 4.4 days
 C/O Time CS: 60 Min
 FS: 10 Min
 EPEI: CS: 2 weeks
 FS: 1 shift
 Max Station Utilization CS: 103 %
 FS: 93%

(6) IMPROVEMENT ACTION PLAN

○ Not Started ● In progress ● Completed ⊗ Past Due

- • Reduce the stamping change over from 1 hr to less than 10 min
- • Create continuous flow from weld to assembly to eliminate the WIP accumulation
- ⊗ • Design material handler route
- • Improve OEE of weld #2 station
- • Create supermarket after stamping to establish pull
- • Improve stamping change over
- • Reduce the stamping batch size from 300 to 150
- • Implement pull at coil supplier with daily shipment and 1.5 days of RM inventory



(1) Define Value Stream

(2) Gain management commitment

(3) Review Lean Principles

(4) Define value stream goals

(5) Draw current state map

(6) Improvement Action plan

(7) Design Future state map

(8) Metrics

(9) Cost benefits