Lean Flow Consulting
▶▶ *Creating World-Class Lean Enterprise*

Lean Flow Technology - Evaluation - Certification

Group :
Line / Cell :

Site / Plant :

Project :
Project Leader :

8 Mixed-Model Line Design Calculations

8.1	Calculations Completed for Each Process
8.2	Sum of Demands at Capacity
8.3	Takt Time :
8.3.1	Effective Work Hours are Defined
8.3.2	Effective Work Hours are Visually Verified
8.3.3	Number of Shifts by Process are Defined
8.4	Average Time Weighted
8.5	Resources :
8.5.1	Number of People
8.5.2	Number of Operations
8.5.3	Number of Machines
8.5.4	Number of Pieces in One Machine
8.6	Range of Actual Work Content Times Noted
8.7	Impact of Setup Times Evaluated (as Necessary) :
8.7.1	Matrix of Setup Times Defined (If Variable Product to Product)
8.7.2	Proper Dual Card Kanban Design Recovers Setups
8.7.3	Number of Setups Possible Estimated
8.7.4	Appropriate Sequencing Rules Defined
8.8	Data is Relevant and Up-To-Date

Validation   Formalization   Certification

9 Family of Products Definition
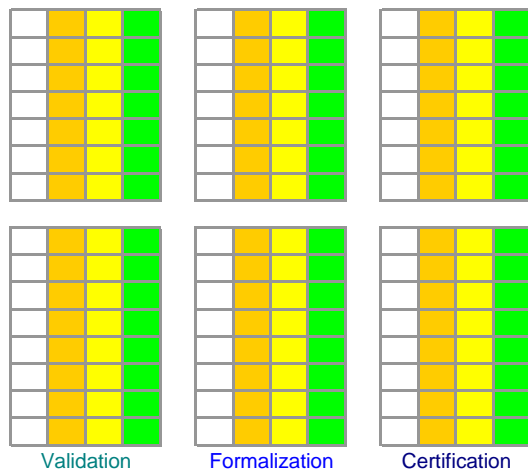
9.1	Product Families Defined to Lines Sharing Similar Requirements :
9.1.1	Processes
9.1.2	Work Content and Total Times
9.1.3	Facilities and Equipment
9.1.4	Setups
9.1.5	Material Presentation
9.1.6	Yields
9.2	Effective Efforts Defining Commonalties as well as Differences
9.3	Opportunities to Increase Mixed Modeling Exploited :
9.3.1	Increased Response Capability
9.3.2	Maximum Utilization of Common Resources
9.3.3	Reduction in Complexity of Kanban Management
9.3.4	Improved Employee Flexibility between Processes
9.3.5	Further Reductions In Space
9.3.6	Increase in Aggregate Capacity - Common Process Utilization
9.3.7	Improvement of Recovery Capacity, Planned Maintenance
9.3.8	Specialization Decisions are Supported by Data Analysis

Validation   Formalization   Certification