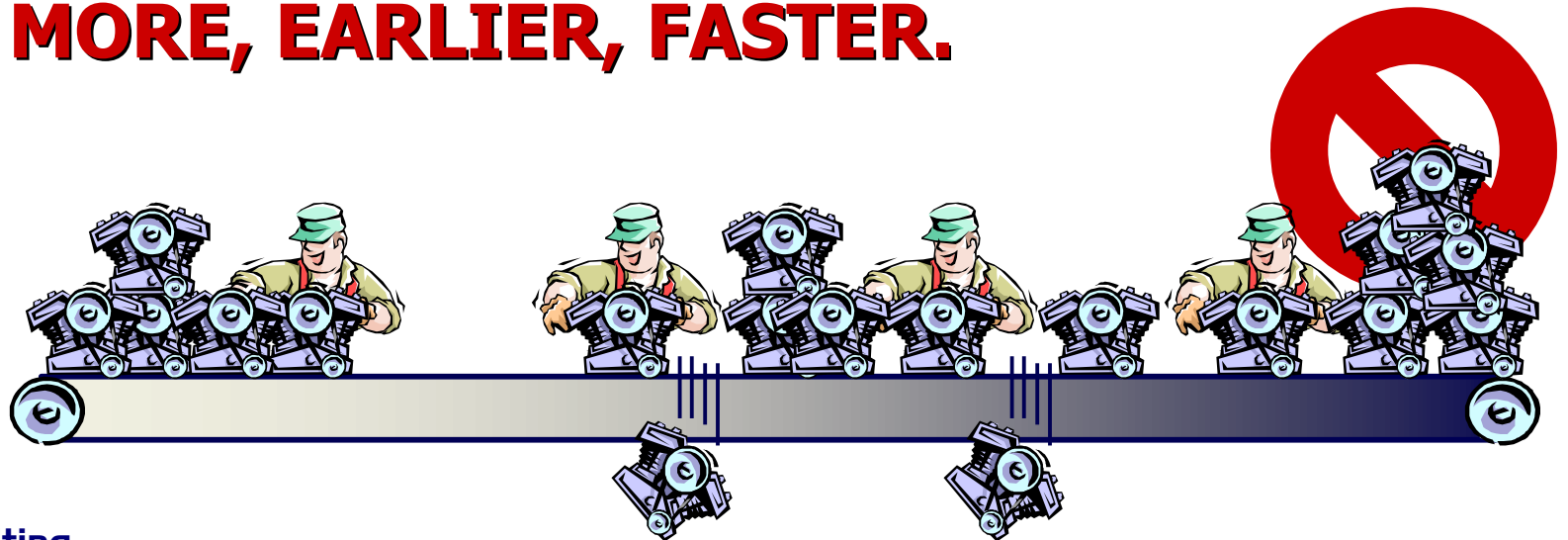


LEAN FLOW PRODUCTION OVER-PRODUCTION

- Making More than is required by the Downstream Process.
- Making Earlier than is required by the Downstream Process.
- Making Faster than is required by the Downstream Process.
- Mass Production Symptoms.
- Produce **MORE, EARLIER, FASTER.**



LEAN FLOW PRODUCTION

TAKT-TIME

- Translates **Customer Demand** to a Unit of Time.
 - Synchronizes Pace of Production to match Pace of Sales,
 - Rate for producing a Product based on **Customer Demand**.

$$\text{Takt-Time} = \frac{H \times S}{\Sigma D_c}$$

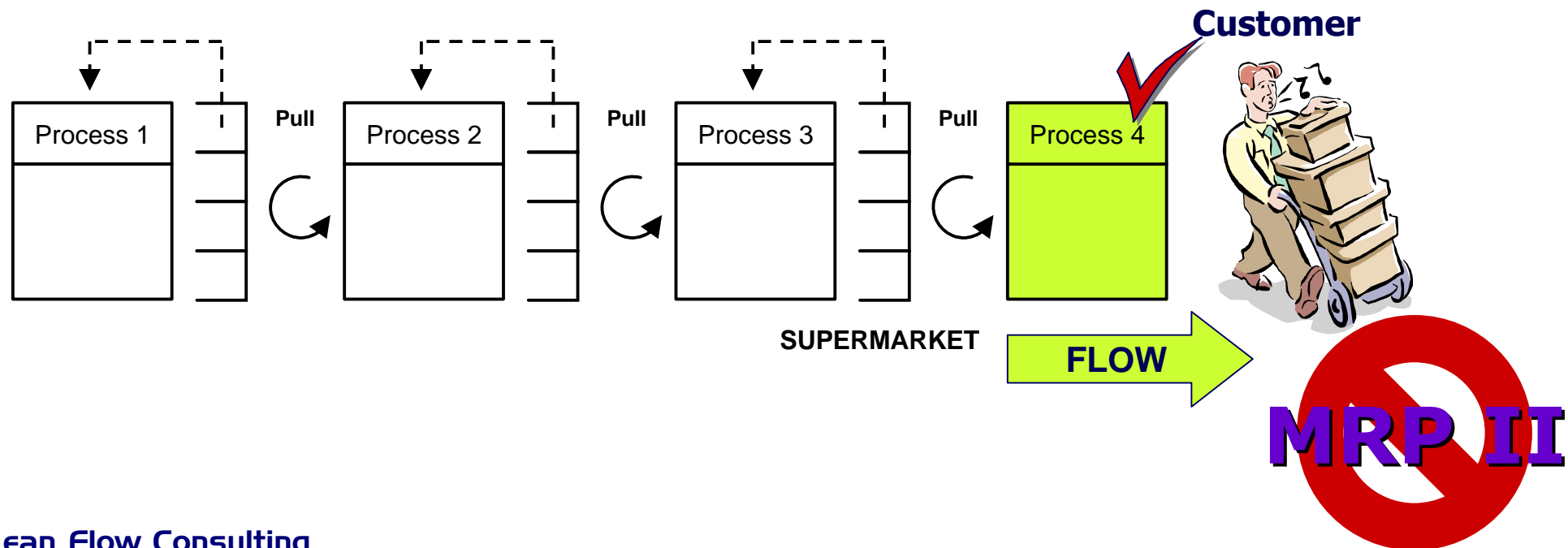
Where : H : Effective Work Time per Shift.
S : Number of Shifts.
D_c : Daily Customer Demand.

- **Question :**
 - **Processes Takt-Time of ABC Company ?**



LEAN FLOW PRODUCTION SEQUENCING & LEVELING

- Try to Schedule **ONLY ONE** Point :
 - PACEMAKER PROCESS**,
 - More **DOWNSTREAM** from Value Stream (Close to the Customer).



LEAN FLOW PRODUCTION MIXED-MODEL PRODUCTION

- **Mass Production :**

- **Products grouped by Reference.**



- **Increase Lead Times, and Finished Goods Inventory,**
 - ... Do you have the Right Product available in Stock for your Customers ?

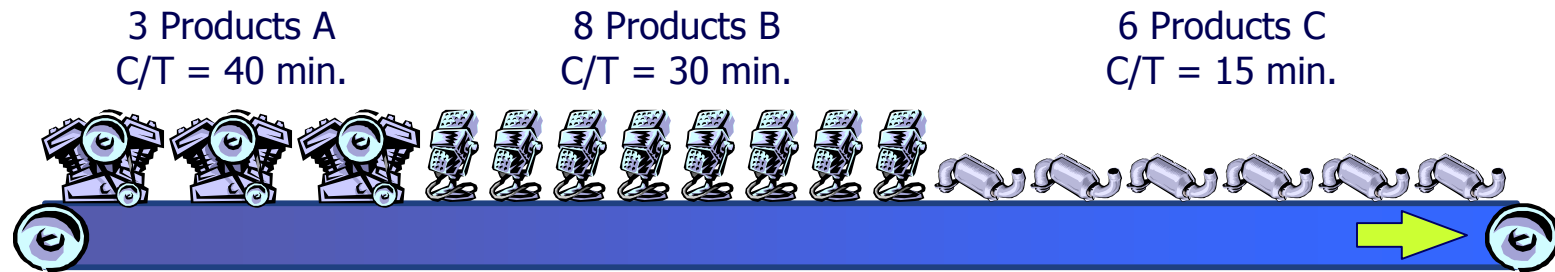
- **Mixed-Model (One-Piece Flow) Production :**



- **Simple Method for Leveling Daily Customer Demands,**
- **Increase Flexibility to Respond Faster and more Efficiently, ...**

LEAN FLOW PRODUCTION MIXED-MODEL PRODUCTION

■ Mass Production :



■ Mixed-Model Production :

