Lean Flow Consulting
Creating World-Class Lean Enterprise

VALUE STREAM MAPPING
ICONS

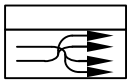
Material

ASSEMBLY
Process

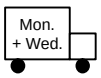
XYZ Corporation
Outside Source

Takt = 50 sec.
C/T = 45 sec.
C/O = 30 min.
Uptime = 95%
Scrap = 2%
3 Shifts
25200 s./Shift

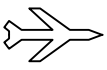
Data Box


Cross-Dock

Warehouse



Truck Shipment


2 x Year
Plane Shipment

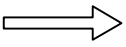
2 x Day
Train Shipment

2 x Month
Boat Shipment

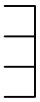
Material

300 Pieces
1 Day
Inventory

Movement of Production Material by Pushing


Movement of Finished Goods to the Customer

Milk Run

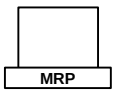

Supermarket

Material Pull or Withdrawal

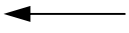
FIFO Transfer between processes (Controlled Quantities)

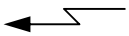
Buffer or Safety Stock

Information

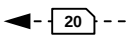


Control Center


Manual Information Flow

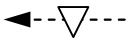

Electronic Information Flow

Information

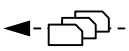


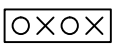
Production Kanban (Dotted line indicates kanban path)

Withdrawal Kanban


Signal Kanban

Kanban Card Post or Collection Box


Kanban Arriving in Batches


Load Leveling

Sequenced Pull Ball

Information

"Go-See" Scheduling

Phone

Fax

E-Mail

Orders

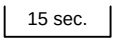
General

Operator

Kaizen Lightning Burst

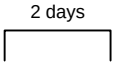
Quality Problem

Time



Processing Time

2 days


Production Lead Time

Release E

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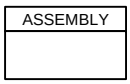
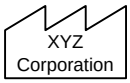
VALUE STREAM MAPPING
ICONS

Material



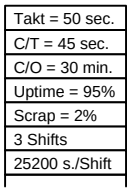
Process

One Process Box equals an area of flow. All processes should be labeled. Also used for departments, such as Production Control.



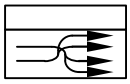
Outside Source

Used to show Customers, Suppliers, and outside Manufacturing Processes.



Data Box

Used to record information concerning a Manufacturing Process, Department, Customer, etc.

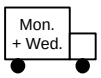


Cross-Dock

Materials are not stored but rather moved from In-Bound Trucks to shipping lanes for Out-Bound Trucks.

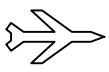
Warehouse

Materials are placed in Storage Locations (Binned) and then picked for Out-Bound shipment at some later point.



Truck Shipment

Note frequency of shipments.



2 x Year

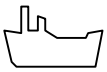
Plane Shipment

Note frequency of shipments.

2 x Day

Train Shipment

Note frequency of shipments.



2 x Month

Boat Shipment

Note frequency of shipments.

Release E

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VALUE STREAM MAPPING
ICONS

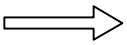
Material

300 Pieces
1 Day
Inventory

Count and Time should be noted.

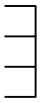
Movement of Production Material by Pushing

Material that is produced and moved forward before the next Process needs it, usually based on a Schedule.



Movement of Finished Goods to the Customer

Milk Run



Supermarket

A controlled Inventory of parts that is used to schedule production at an upstream Process. The open side faces the supplying Process.

Material Pull or Withdrawal

Pull of Materials, usually from a Supermarket.

FIFO Transfer between processes (Controlled Quantities)

Indicates a method to Limit Quantity and assure FIFO Flow of Material between Processes. Maximum quantity should be noted.

Buffer or Safety Stock

"Buffer" or "Safety" Stock must be noted.

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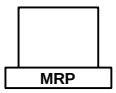
VALUE STREAM MAPPING
ICONS

Information



Control Center

Often a Computerized System such as a Material Requirements Planning (MRP) System.

Manual Information Flow

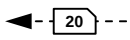
For example : Production or Shipping Schedule.

Electronic Information Flow

For example : via Electronic Data Interchange (EDI).

Information

Describes an Information Flow.

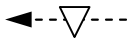


Production Kanban (Dotted line indicates kanban path)

The "One-per-Container" kanban. Card or device that tells a Process how many of what can be produced and gives permission to do so.

Withdrawal Kanban

Card or device that instructs the Material Handler to get and transfer parts (i.e. from a Supermarket to the Consuming Process).

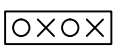

Signal Kanban

The "One-per-Batch" kanban signals when a reorder point is reached and another batch needs to be produced. Used where Supplying Process must produce in batches because changeovers are required.

Kanban Card Post or Collection Box

Place where kanban are collected and help for conveyance.

Kanban Arriving in Batches


Load Leveling

Tool to intercept batches of kanban and level the volume and mix of them over a period of time (Pitch).

Sequenced Pull Ball

Gives instructions to immediately produce a pre-determined type and quantity, typically one unit. A pull system for subassembly processes without using a Supermarket.

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VALUE STREAM MAPPING
ICONS

Information

"Go-See" Scheduling

Adjusts Schedules based on checking inventory levels.

Phone

Usually for Expedited Information.

Fax

E-Mail

Orders

Often in Electronic form.

General

Operator

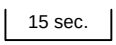
Represents a Person viewed from above.

Kaizen Lightning Burst

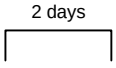
Highlights Improvement needs on a Value Stream Map at specific processes that are critical to achieving the Value Stream Vision, can be used to plan Kaizen Workshops.

Quality Problem

Time



Processing Time



Production Lead Time

Under processes & inventories icons, they are used to calculate Total Flow Process Lead Time (FPLT) and Total Product Cycle Time, to bring a product from order to delivery.

Release E

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