

# LeanActivity.

## Value Stream

### Template for Production

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## Introduction

Welcome to this powerful Lean method. The Value Stream Method (VSM) is one of the basic tools for analyzing, evaluating and designing the Value Stream of your **production** or **administration processes**.

LeanActivity attaches great importance to easily understandable and visually clear tools. When using these templates, you will see how easy and clearly it is to design your value stream.

The symbols below serve as your template when applying the VSM:

1. Print out any quantity of the following pages and cut them out.

*Tips:*

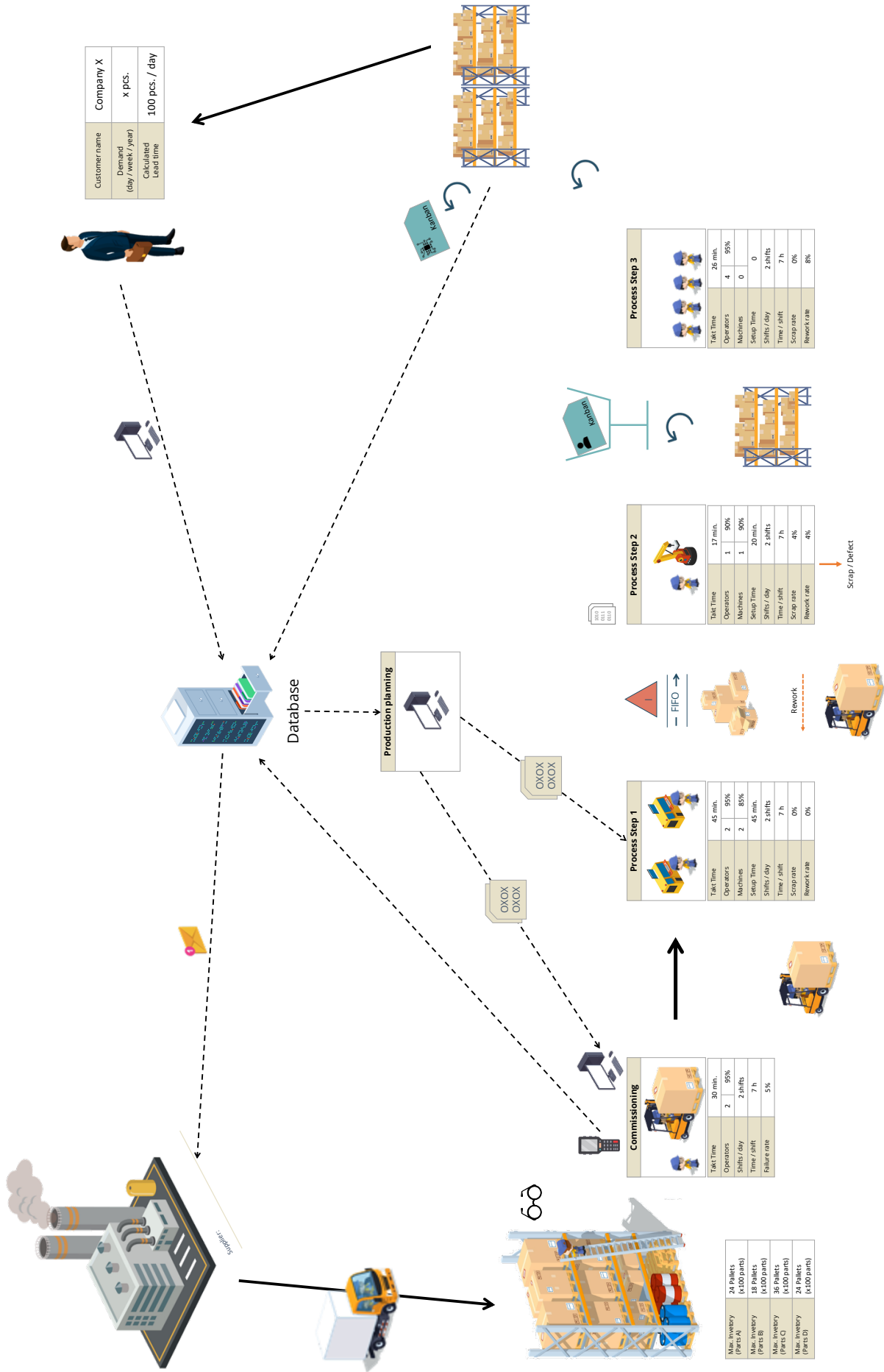
- If you want to use the templates more often, then print them out on thicker paper or laminate them.
- Print too much rather than too less.

2. Choose a large empty space. This could be a large table, a pin board or a whiteboard.

*Tip:*

- If you want to use a whiteboard, you have to equip the symbols with a small magnet.

3. Start to design your Value Stream!



# Value Stream Design - Example

# IT & Communication



Database



Computer



Print



Call



E-Mail



Database



Computer



Print



Call



E-Mail



Database



Computer



Print



Call



E-Mail

Scanner



# Process & Data Information

## Process Step 1



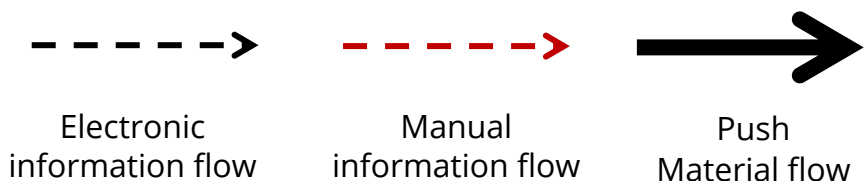
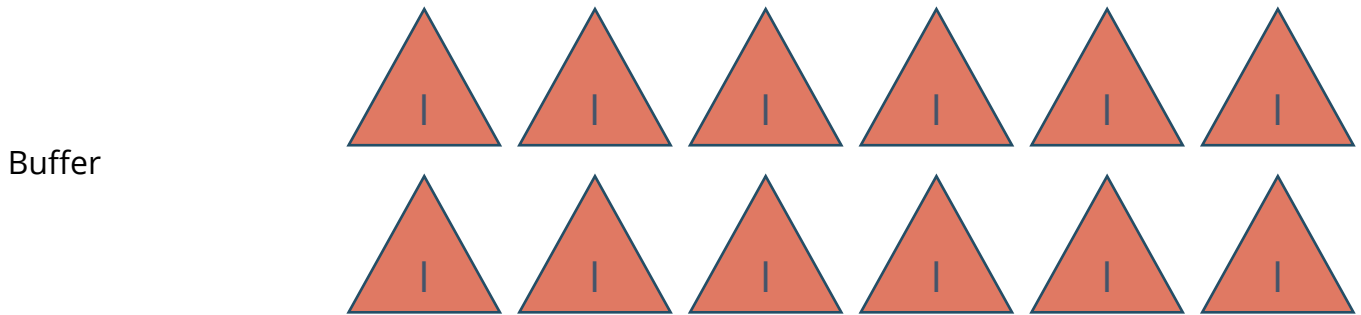
Process:

Process:

Takt Time	14 min.					
Operators	2	95%				
Machines	2	85%				
Setup Time	45 min.					
Shifts / day	2 shifts					
Time / shift	7 h					
Scrap rate	2%					
Rework rate	8%					

Process:		Process:		Process:	

# Information handling & processing



*Sketch flows and arrows by hand*



# Production Information & Kanban

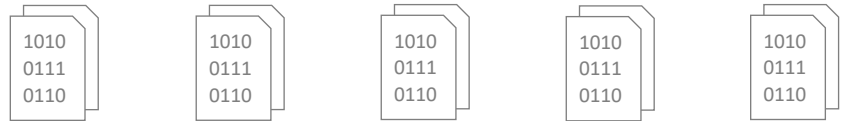
Kanban Box



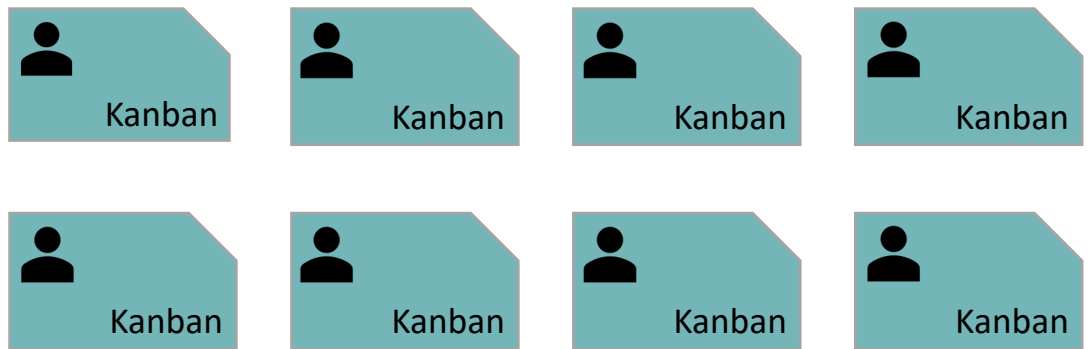
Go and see  
Manual control



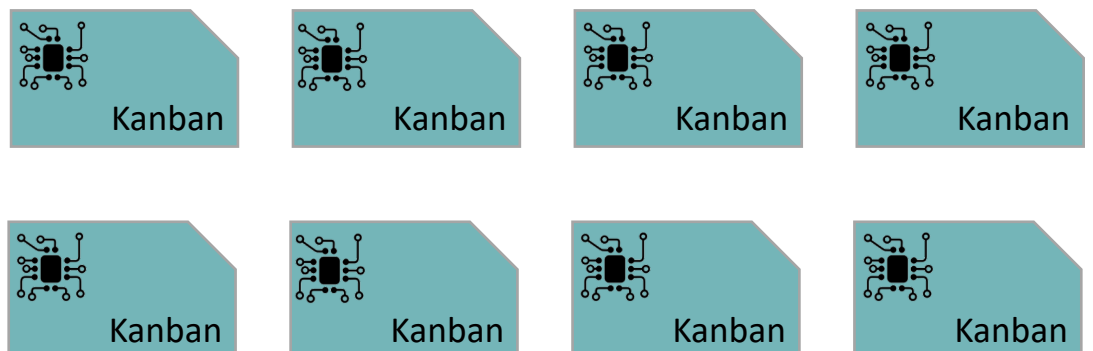
Printed  
Production order



Manual  
Kanban



Digital  
Kanban



# Information flow & Kaizen visualization

Kaizen  
(Area for Improvement)



Possibly potentials  
(take a closer look)



# Customer Information



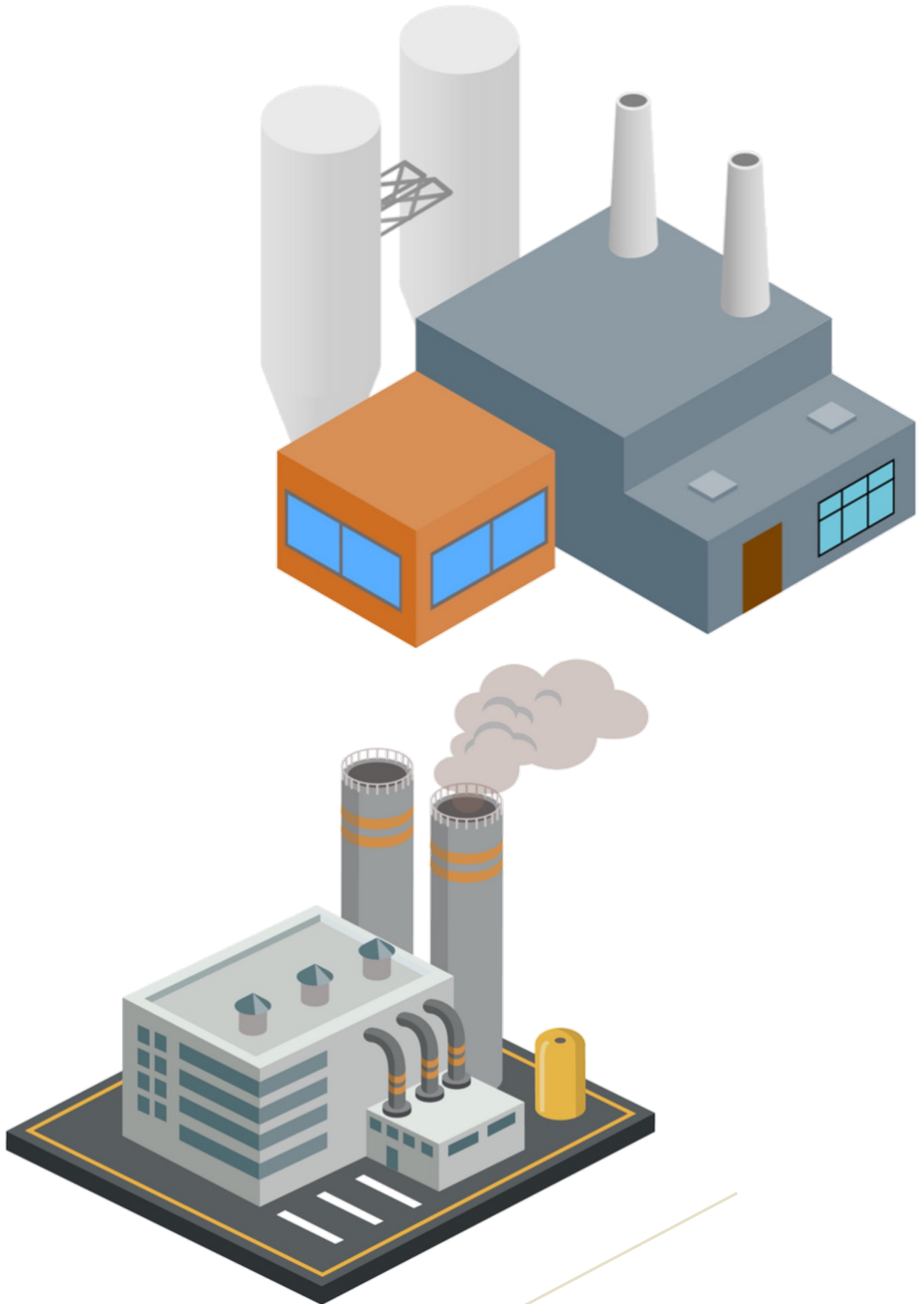
Customer name	
Demand (day / week / year)	
calculated Takt time	



Customer name	
Demand (day / week / year)	
calculated Takt time	



# Supplier Information

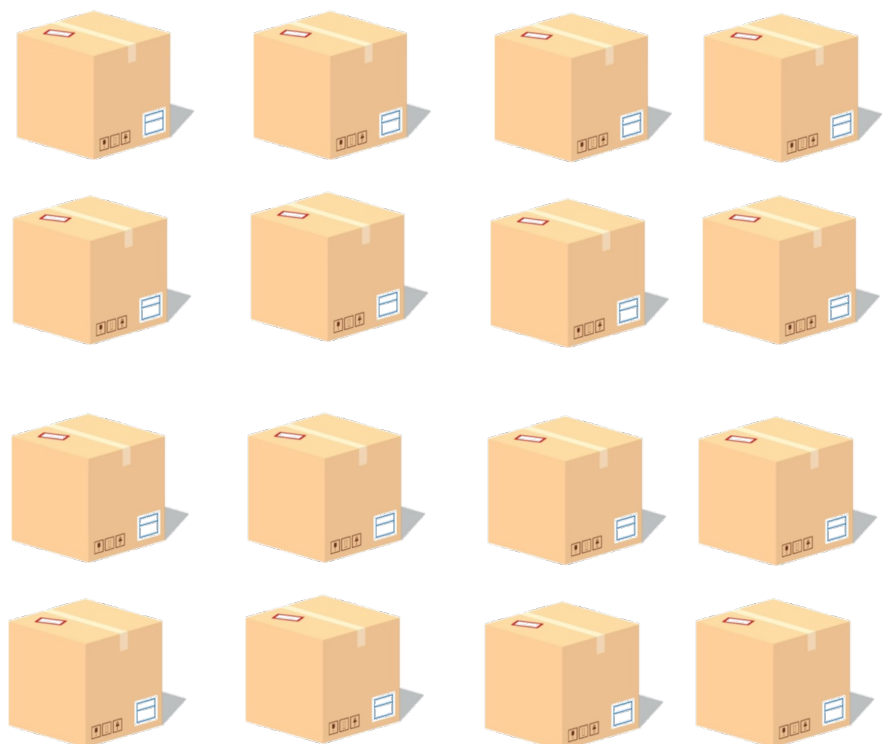
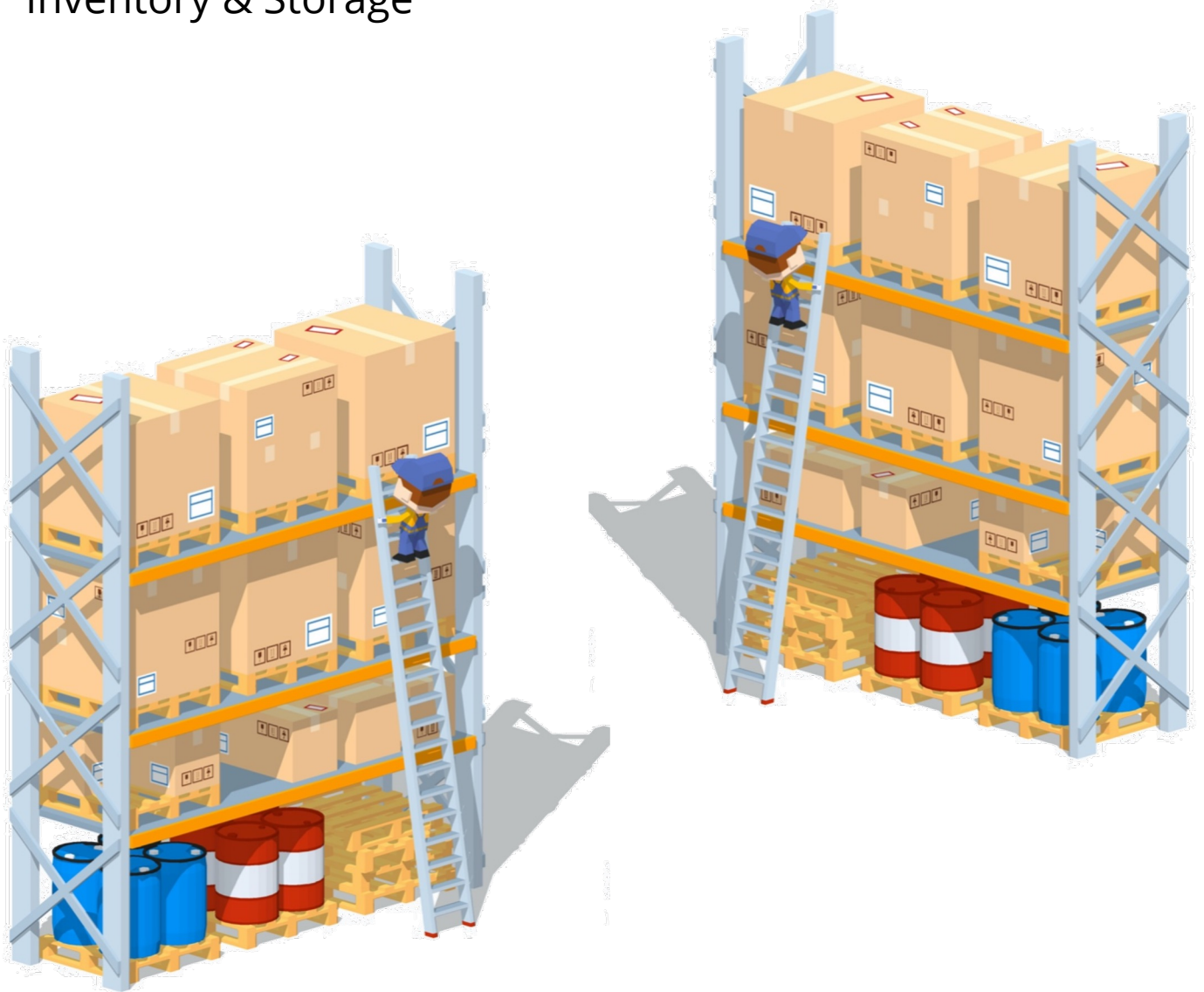


Supplier:

# Transportation



# Inventory & Storage



# Inventory & Storage

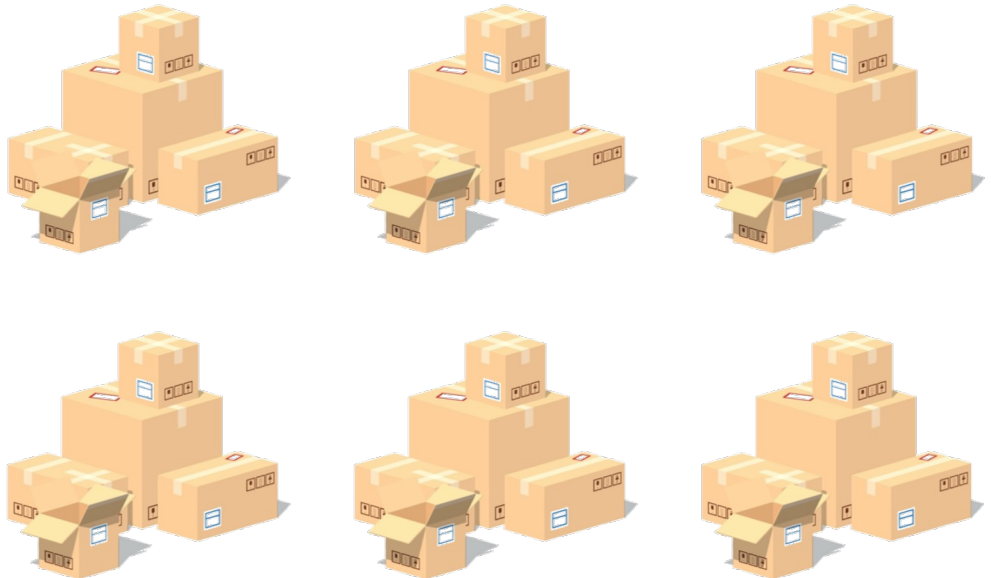


Supermarket

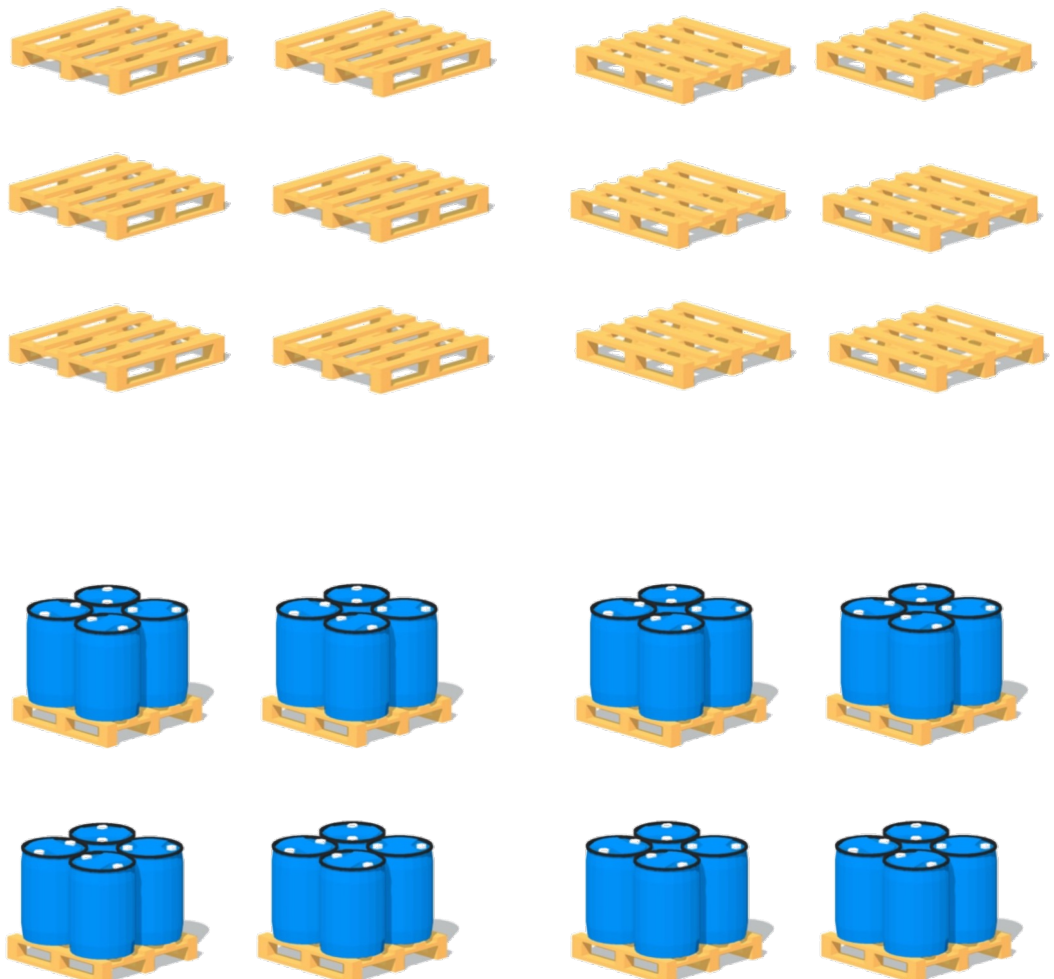


# Inventory & Storage

Buffer



Pallets



# Illustration of Operators & Machines



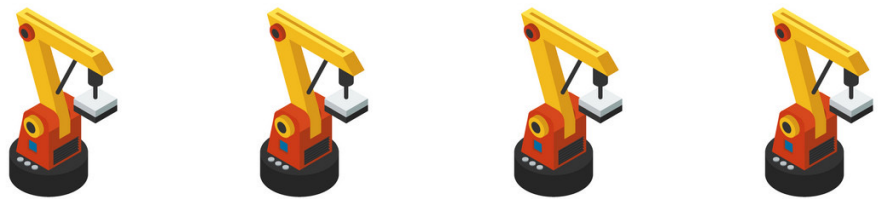
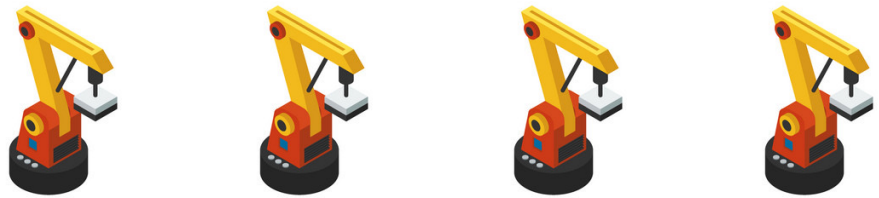
Operators



Team meeting



Robot



Machine

