

The Lean Simulation Game

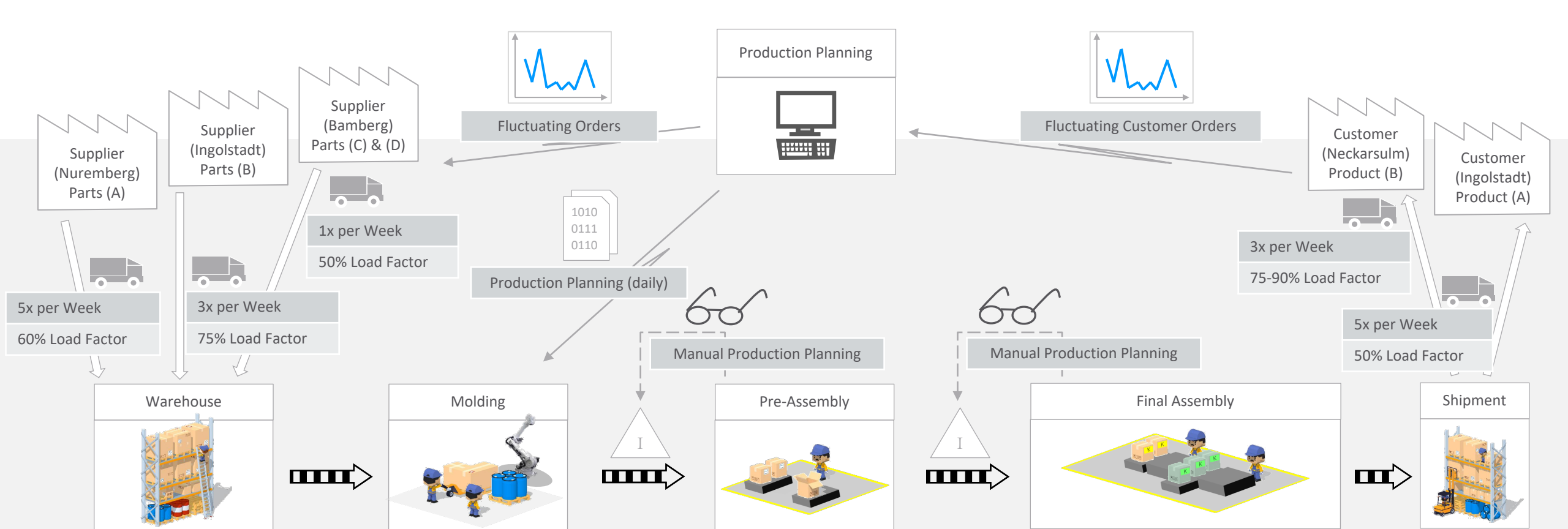
The following slide is almost completely based on an existing manufacturer based close to Munich, Germany.

Feel free to suggest whatever improvement for the process you come up with.

Let's gather all your ideas and summarize in which way this process may look like in a lean world.

Feel free to hand in your suggestions at info@leanactivity.com. We will provide feedback to all discussions and ideas.





Max. Inventory Parts (A)	24 Pallets (x100 Parts)
Max. Inventory Parts (B)	18 Pallets (x100 Parts)
Max. Inventory Parts (C)	36 Pallets (x100 Parts)
Max. Inventory Parts (D)	24 Pallets (x100 Parts)

Working Time / Day	480 min
Takt Time per Machine	30 s
Σ Machines	2
Σ Operators	6
Set-up time	60 min
OEE	80 %
Variants	(A), (B), (C), (D)
Variants Production Mix	25%, 25%, 25%, 25%

Working Time / Day	960 min
Takt Time per Machine	180 s
Σ Operators	12
Set-up time	5 min
OEE	90 %
Variants	(A), (D)
Variants Production Mix	50%, 50%

Working Time / Day	960 min
Takt Time per Machine	300 s
Σ Operators	32
Set-up time	5 min
OEE	90 %
Variants	(A), (D)
Variants Production Mix	50%, 50%

Max. Inventory Product (A)	34 GLT's x24 Products
Max. Inventory Product (B)	46 GLT's x24 Products

Company: Bumper Comp. XY
 Location: Munich, Germany
 Employee: 5.400
 Revenue (2016): 500 Mio. €