204 – Kanban/Material Control

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Overview

Kanban is an essential tool that provides a means of scheduling upstream operations without the need of a sophisticated MRP System. The Japanese methodology is simplistic and based on the concept of replenishing what is consumed. It is a very commonly used in Just-In-Time manufacturing where what is essential needs to be stored line side and nothing more. Line side inventory is often sized to match an hourly consumption rate with material handlers backfilling the consumed stock in a timely manner. This type of system using the Kanban or "signal board" is often referred to a Pull System.

Objective

- To increase the awareness that excess stock stored at the point of use is wasteful and adds no value to the operations.
- To develop pull system where applicable to smooth flow.
- Establishes baseline for synchronous flow systems.
- To eliminate complex MRP or paper schedules within the plant.

Topics

1. The Push System
2. Creating a Pull System
3. Internal and External Material Flow Plans
4. Internal Logistics
5. Pull Cards & the 7 Rules

Activity

TBD – Simulation and/or development of Kanban for a specific process. The preferred activity is to gather data on commonly consumed goods and create Kanban cards (Supply & Demand) to be immediately put into effect.

Course Timing

TDB. Material presentation is extensive and which generally should be completed in 3 hours, if simulation is incorporated a minimum of 4 hours is expected.

Materials

Overhead projector
Slide Show Presentation
Pencils
White Board/ Markers

Participants (8-10)

Operators
Manufacturing Engineer
Scheduler
Material Handlers
Support staff (Administrative)
Manager/supervisor

Milestones

Pre-Requisites – All Fundamental Courses (101-105); Takt Time; Standardized Work

Simplifying the material control process through manufacturing direction signals based upon downstream consumption of materials. Develop Kanban for a given area.

60 Day Review

Trail period to determine upstream issues not defined in classroom training. Supervision works with Team and material handlers to ensure signals are being used correctly. Kanban may need re-sizing.

6 Months

Determine your measure of success. Productivity measures "before" and "after" Kanban. Downtime or production delays related to material shortages or incorrect material deliveries.