304 - Current/Future State Mapping

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Overview

A high level look at the details in a manufacturing process from start (Scheduling) to finish (Shipping Final Goods) which expose the obstacles of process flow either in materials, scheduling, equipment downtime, cycle time performance, etc. The current state map defines the existing process whereas the future state map outlines action plans to improve the overall lead time through the system. (Based upon the "Learning to See" methodology by Mike Rother/John Shook.) Also known by Value Stream Mapping.

Objective

- To increase overall awareness related to process lead-time in a selected product process.
- To utilize process data and process flow metrics to analyze where opportunities for improvements exist.
- To initiate a better flow of information and materials to balance operations for reducing process lead-time.

Topics

1. Mapping Symbols and definitions
2. Takt Time and other lean operational metrics
3. Constraints
4. Value Stream
5. Lead Time

Activity

Team gathers current state data on a selected product process and constructs a current state map. The team reviews their findings, analyses the CSM, and discusses approaches of eliminating non-value elements to shorten the overall process lead-time. The team develops a future state map for future implementation. Both maps need to be displayed for tracking follow up actions.

Course Timing

This course is a classroom session combined with a floor process walk, which generally will require a minimum of 8 hours to develop both the Current State Map and discuss plans for removing the obstacles in the Future State Map development. Complexity of process may extend timing into another day.

Materials

Overhead projector
Slide Show Presentation
Blank sheet of paper
Butcher paper
Mapping symbols
Flip charts
Pencils
White Board/ Markers

Participants (5-6)

Manufacturing Engineer
Quality Engineer
Manager/supervisor
Shipping & Receiving
Scheduler

Milestones

Pre-Requisite – All Fundamental Orientation Courses (101-105); Takt Time; Lean Measurables; Kanban

Incorporation of all lean principles in developing an improved process flow.

90 Day Review

Team Leader reports status of incorporation of FS items. Updates FSM with latest data and calculates new lead-time.

6 Months after Orientation

Same as above. Initial project should have defined deadlines. Team works project until completion.