

Manufacturing Awareness Limited Case Study – Value Stream Mapping

Client Sheet Metal Manufacturer (NW)

Problem Waste was apparent in the process of moving finished items in the press shop to through a packing area to the point of despatch to the warehouse. This waste resulted in excessive material movements and inventory.

Strategy A value stream mapping process was carried out using a multi-disciplinary team to prepare both a current state and a future state map of the process.

Timing Two days

Results

	Current State	Future State
Steps on Process	14	5
Added Value Time per piece	16.58 seconds	16.58 seconds
Added Value Time per pallet	11.48 hours	11.48 hours
Lead Time	57minutes	1 minute
Inventory	20 days	Zero
People involved in process	10	5

Financials Reduction identified applies to between 85 and 100 pallets per day. The solution requires major changes to the process and a change in philosophy whereby the press is formed in to a cell. Two people will operate the cell and will press, label and pack the components.

The finished pallet of components will then be moved from the press directly to the warehouse, rather than moving through the intermediate storage and holding areas.

Financial benefits are significant when the philosophy is applied across the major presses in the press shop.

