

Step 6: Continuous Flow Worksheet

Purpose: To make decisions necessary for adding continuous flow elements to the future-state map.

- Directions:**
- 1. Discuss each item in sequence.
 - 2. Make sure the team comes to a decision for each item.
 - 3. Record the “minority” opinions; they may prove useful later.
 - 4. Ensure that the team scribe records the decisions.


Takt Time

Your takt time is _____

Your pitch is _____

Operator Balance Chart

- 1. Review your current state attributes.

| Operations  | | | | | | | |
|--|--|--|--|--|--|--|--|
| | | | | | | | |
| Cycle Time | | | | | | | |
| Changeover | | | | | | | |
| Operators | | | | | | | |
| Uptime | | | | | | | |
| Availability | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |

Step 6: Continuous Flow Worksheet

2. Create a current-state bar chart.



Operator Balance Chart–Current State

3. Determine the number of operators needed to meet takt time.

DETERMINING THE NUMBER OF OPERATORS

$$\# \text{ of operators} = \frac{\text{Total cycle time}}{\text{Takt time}}$$

$$\# \text{ of operators} = \frac{\text{____ (Total cycle time)}}{\text{____ (Takt time)}} = \text{____ Operators}$$

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4. After going to the shop floor and studying the current state further, set a new total cycle time (if appropriate) and decide on the number of operators needed.

$$\# \text{ of operators} = \frac{\text{Total cycle time}}{\text{Takt time}} = \text{Operators}$$

5. Complete a proposed operator balance chart by creating a bar chart of the future state.

Operator Balance Chart–Current and Proposed

Work Cells

Will you redesign any operations into work cells? Why? _____

Your operations to redesign into work cells are _____

Explain your decisions: _____

Production Flow

What methods will you use to control upstream production?

Type of Control

Location(s)

1. In-process supermarket
2. Kanban system
3. FIFO lane
4. MRP

Improvement Methods

List any additional improvement methods below: