

Value Stream Mapping(VSM)

Presented by
Continuous Improvement Team

What is a Value Stream Map?



A Lean tool
that visually
demonstrates
a process!

What is the purpose of a Value Stream Map?

1

Identify a process and visually create a current state value stream map

2

Identify waste and pain points within the current state value stream map

3

Utilize process metrics for the current state value stream map. The process metrics will identify process time, wait time, delay time, and lead time

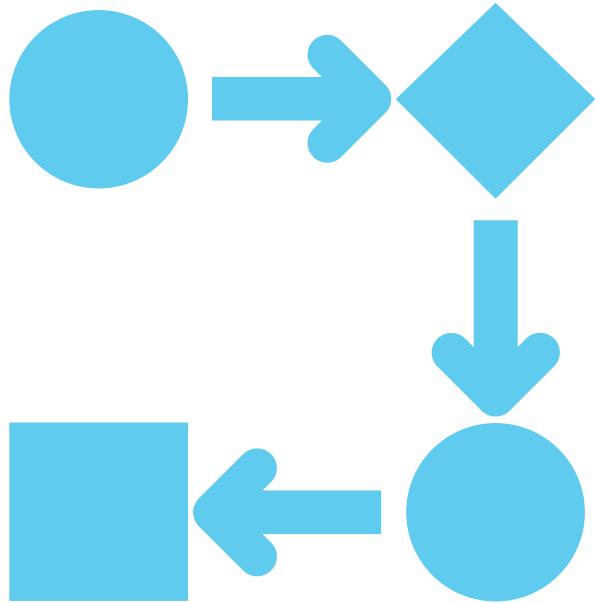
4

Create a future state value stream map based off removal of waste

5

Identify countermeasures that will guide your action plan towards the future state

8 Waste of Lean



- **Errors** - producing and correcting
- **Overproduction** - production of too much of a product, production of unwanted products
- **Waiting/Pending** - idle time, blocked work
- **Not utilizing talent** - the knowledge, skills, and abilities of all staff
- **Transportation** - relocating people, equipment, supplies
- **Motion** - movement by people
- **Inventory** - excessive equipment, supplies, products
- **Extra processing** - unnecessary steps, questions, paperwork, rework

Value Stream Map

Process Metrics

W/T	Wait Time	Before work enters a process(inbox)
P/T	Process Time	Time spent actually performing the work
D/T	Delayed Time	After work has entered a process but is delayed
L/T	Lead Time	Total of $W/T + P/T + D/T = \text{Lead Time}$

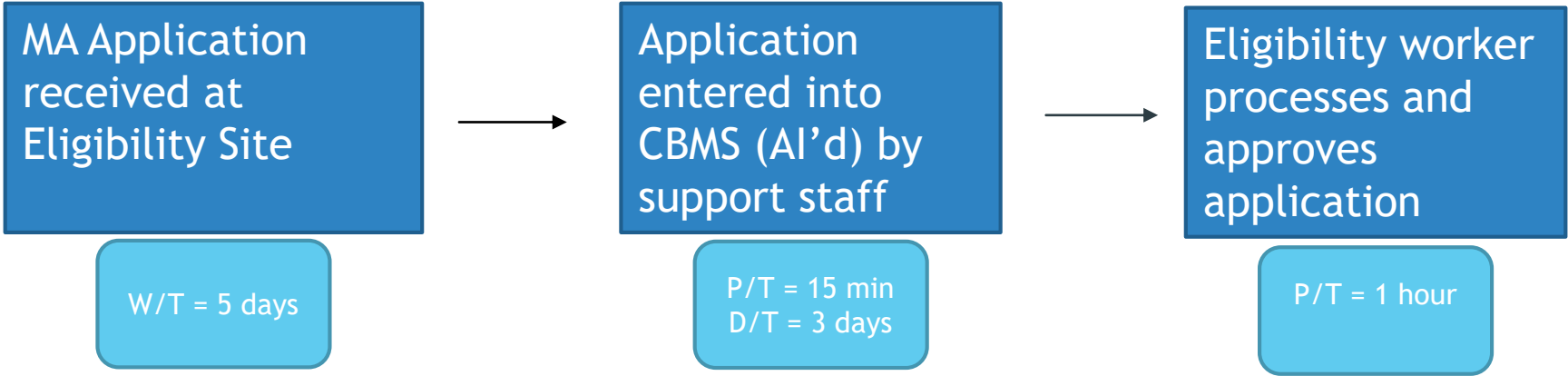


Questions

Current State

Value Stream Map

Can you identify any waste?
Idle/pending time, unnecessary steps

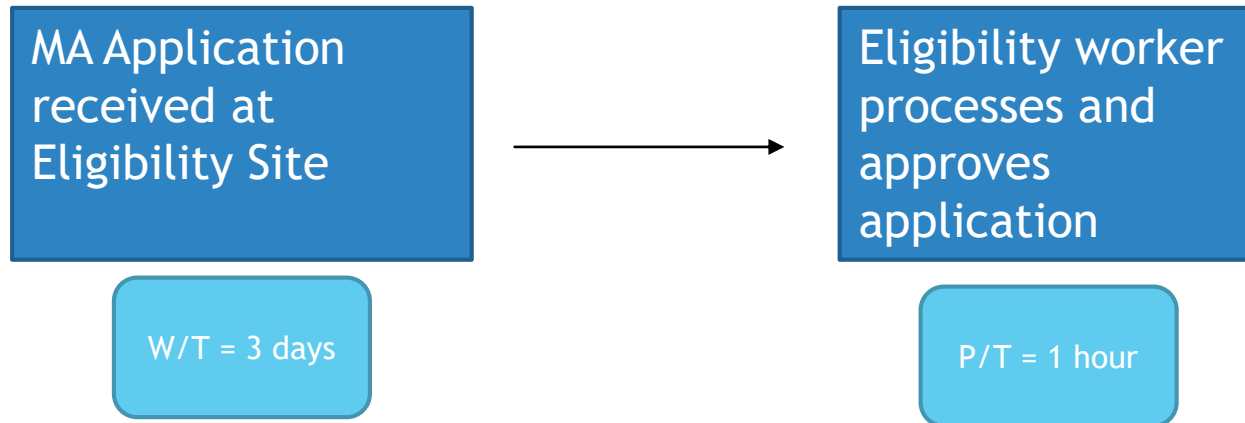


W/T	Wait Time	Before work enters a process(inbox)
P/T	Process Time	Time spent actually performing the work
D/T	Delayed Time	After work has entered a process but is delayed
L/T	Lead Time	Total of W/T + P/T + D/T = Lead Time

W/T	Wait Time	5 days
P/T	Process Time	1 hour and 15 minutes
D/T	Delayed Time	3 days
L/T	Lead Time	8 days 1 hour and 15 minutes

Future State

Value Stream Map




W/T	Wait Time	Before work enters a process(inbox)
P/T	Process Time	Time spent actually performing the work
D/T	Delayed Time	After work has entered a process but is delayed
L/T	Lead Time	Total of W/T + P/T + D/T = Lead Time

W/T	Wait Time	3 days
P/T	Process Time	1 hour
D/T	Delayed Time	
L/T	Lead Time	3 days. 1 hour

Lead Time C/S: 8 days, 1 hour 15 minutes
 Lead Time F/S: 3 days. 1 hour
 "5 days saving"

Countermeasures

A countermeasure is a suggested or proposed solution. We don't call them solutions because they're ideas about what might address the problem—you can call it a solution once you know it works.



List all the possible countermeasures and then prioritize them. Identify which countermeasure has the highest impact to reach the future state with the least amount of effort.

Countermeasure Action Plan(Experiment)

- ▶ Countermeasure (what will happen):
- ▶ Who will be responsible?
- ▶ What will we do next(timeline)?
- ▶ How and when will we measure. How will we know this plan is successful?



Questions



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