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Analyse value stream & framework conditions

- Current takt time
- Coarse value flow
- Material flow incl. process data
- Information flow
- Key performance indicators
- If required: In-depth analyses
 - Data analyses
 - Process observations
- Derive core statements from the value stream
- Coordinating future framework conditions
- Set goals

Design material flow

- Define type of order fulfillment :
 - Finished goods warehouse
 - Order manufacturer
 - Mixed form
- Calculate target takt time
- Design material flow
 - Arrange process boxes
 - Visualize inventory locations
 - Visualize transports
- Define kinds of inventory
- Define incoming goods inventory
- Define range of inventory

Derive process requirements

- Output & quantity fluctuations
- Replenishment time
- Process availability
- Material supply
 - Feeding
 - transport-frequency
 - Picking
- Documenting requirements in the value stream

Design information flow

- Define point of order placement
- Create scheduling pattern
- Define loops of informations
- Design Pull-System: e.g.
 - Kanban
 - Conwip
- Connect IT-System
- Design administrative processes

Key performance indicators & patterns

- Visualize timeline
 - Range of Inventory
 - Cycle time
 - transport time
- Calculate lead time & flow factor
- Define savings (e.g.
 - Lead time
 - Inventory
 - cycletime
 - Capacity
- Visualize fundamental pattern

Improvement planning

- Definition of ...
 - ... Value stream loops
 - ... Responsibilities
 - ... Projects
 - Goal & framework conditions
 - Start & end date
 - Team / Improver
 - Mentor / Coach
 - Available capacity
 - Implementation mode
 - Develop implementation roadmap