

BU Assessment

Assessment Date: 12-Jul-06

XYZ Value Stream

Start Date: Oct-06

ABC Value Stream

Start Date: Mar-06

Area of Concentration		Expectations (Description)
Value Stream Mapping		
1	Product Family Matrix	Products are sorted into families based on similarities of processing steps.
2	Value Stream Mapping	Current & Future State maps & Implementation Plan posted and up to date.
Takt Time		
3	Takt Time Calculation	Takt time calculated for average annual demand rate.
Interval		
4	Interval Analysis	Interval analysis used to determine machine capabilities.
5	Quick Changeover	Changeover times are reduced to accommodate a shorter interval.
Single Piece Flow		
6a	Operator Balancing	Work Elements collected for initial single piece flow cell
7a	Layout Implementation	Single piece flow implemented, monitored and debugged.
8a	Standard Work (Level 1)	Standard Work for the build process created and posted. Use balance charts as base.
6b	Operator Balancing	Work Elements collected for initial single piece flow cell
7b	Layout Implementation	Single piece flow implemented, monitored and debugged.
8b	Standard Work (Level 1)	Standard Work for the build process created and posted. Use balance charts as base.
FIFO		
9a	FIFO Lanes	FIFO lane implemented to control inventory between two processes.
9b	FIFO Lanes	FIFO lane implemented to control inventory between two processes.
10	FIFO Standard Work (Level 2)	Standard Work created and posted. Includes actions for full and empty conditions.
Finished Goods Strategy		
11	Finished Goods Strategy	Finished goods strategy validated, implemented and in use.
Pull		
12	Pacemaker Supermarket	Component parts used at the pacemaker process are replenished using Pull.
13	Waterspider	Material delivery route to deliver product to (and take away from) the pacemaker process.
14	Waterspider Standard Work (Level 2)	Material replenishment Standard Work created and posted.
15	Process Family Matrix	Upstream processes are grouped into families. Shared resources are dedicated to create flow.
16	Value Stream Supermarkets	All value stream component parts are replenished using Pull.
17	Initial Raw Stock Supermarkets	10 raw stock part numbers ordered from suppliers using a Pull system (e.g. kanban).
18	Value Stream Raw Stock Supermarkets	All raw stock part numbers ordered from suppliers using a Pull system (e.g. kanban).
Scheduling		
19	Single Point Scheduling	Value stream scheduled at a single point in pitch increments.
20	Scheduling Standard Work (Level 2)	Scheduling standard Work created and posted.
Pitch		
21	Pitch	Value stream monitored at regular pitch increments to ensure customer demand met.
22	Metrics	5-8 key metrics posted on cell, value stream, and site boards.
23	Pitch Standard Work (Level 2)	Standard Work created and posted for how to track pitch.
24	Missed Pitch Standard Work (Level 3)	Standard Work created and posted to get value stream on pace after missing pitch.
Perfection		
25	Value Stream Mapping	Next iteration Current & Future State maps & Implementation Plan posted and up to date.
26	5S / 6S	5S implemented to further reduce waste within the value stream.
27	Visual Flow	Product flow is visible throughout the facility to the untrained eye.
28	Value Stream Focus	Support functions (sales, engineering, etc.) are assigned to value streams

Implementation				Sustainment		
25%	50%	75%	100%	1	2	3