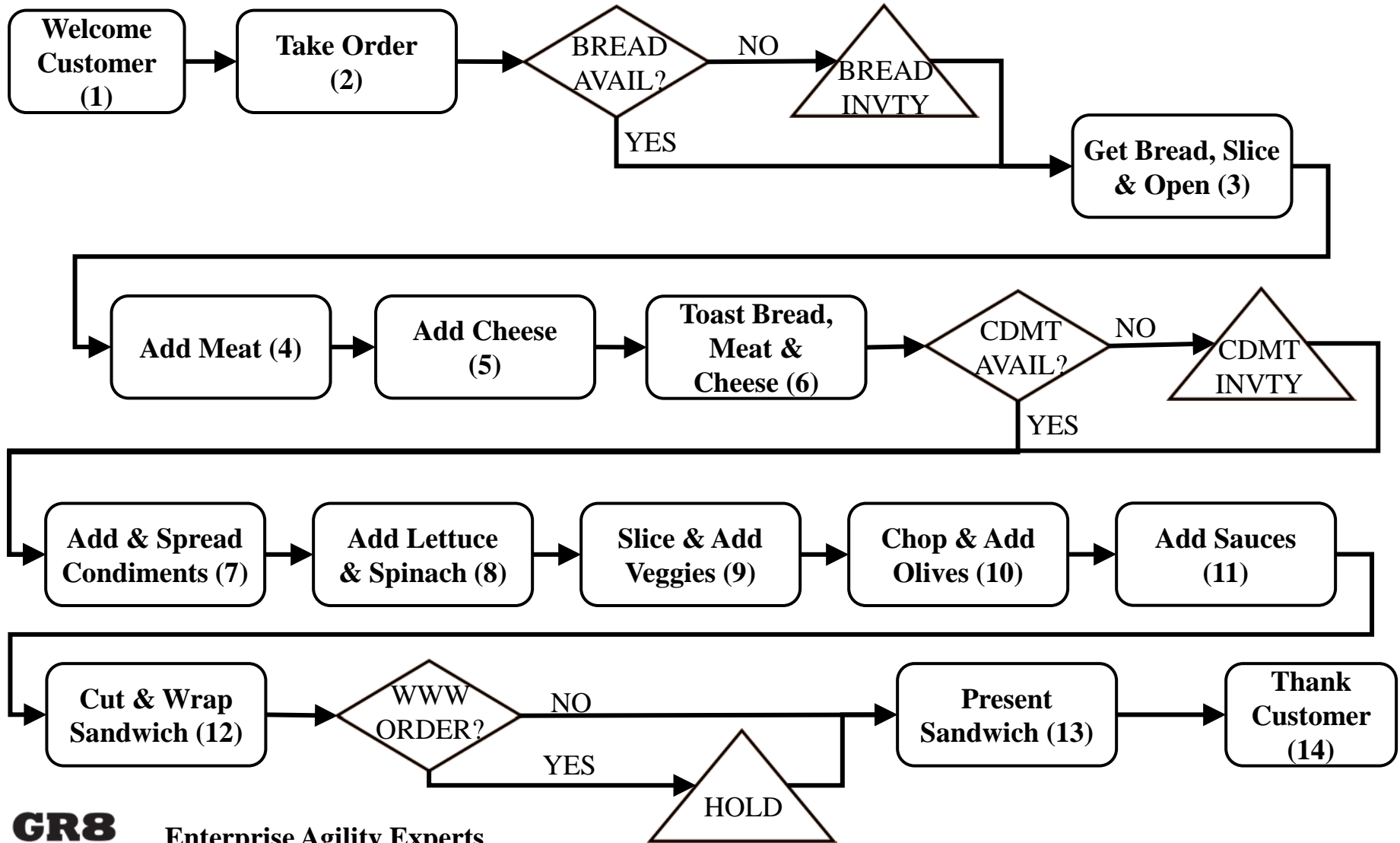


Power of Flow Exercise #2

Instructions: Complete, then email a copy to ops@gr8pm.com with Subject Line “DALSM 2020-06 Flow Exercise #2.”

Class: DALSM 2020-06 Team Name:

Project Manager’s Name:



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STEP #1: Assess the 14 process steps as Value Added Time (VAT) or Non-Value Added Time (NVAT)

- | | |
|-----------|-----------|
| 01. _____ | 09. _____ |
| 02. _____ | 10. _____ |
| 03. _____ | 11. _____ |
| 04. _____ | 12. _____ |
| 05. _____ | 13. _____ |
| 06. _____ | 14. _____ |
| 07. _____ | 15. _____ |
| 08. _____ | |

STEP #2: Identify 3 areas with waste, name the waste and briefly describe where and how it impacts the process flow.

01. _____

02. _____

03. _____

STEP #3: Assuming the following task durations:

- Welcome Customer = 60 seconds
- Take Order = 120 seconds
- Get & Slice Bread = 30 seconds
- Add Meat & Add Cheese = 30 seconds
- Toast = 180 seconds
- Add Condiments = 30 seconds
- Add Lettuce & Spinach = 30 seconds
- Slice & Add Veggies = 180 seconds
- Chop & Add Olives = 240 seconds
- Add Sauces = 30 seconds
- Cut & Wrap = 60 seconds
- Present & Thank Customer = 30 seconds, each

1. Calculate the total Cycle Time
 - * Assuming no rework, CT = _____.
 - * Assuming Toaster burns sandwich requiring restart, CT = _____.
 - * Assuming Veggies and Olives have to be redone, but restart is not required, CT = _____.
2. Using your assessments from STEP #1, calculate
 - * Total VAT = _____.
 - * Total NVAT = _____.
3. Select 1 of the 3 Wastes you identified in STEP #2, calculate
 - * Improved CT = _____.
 - * Reduction in NVAT = _____.

