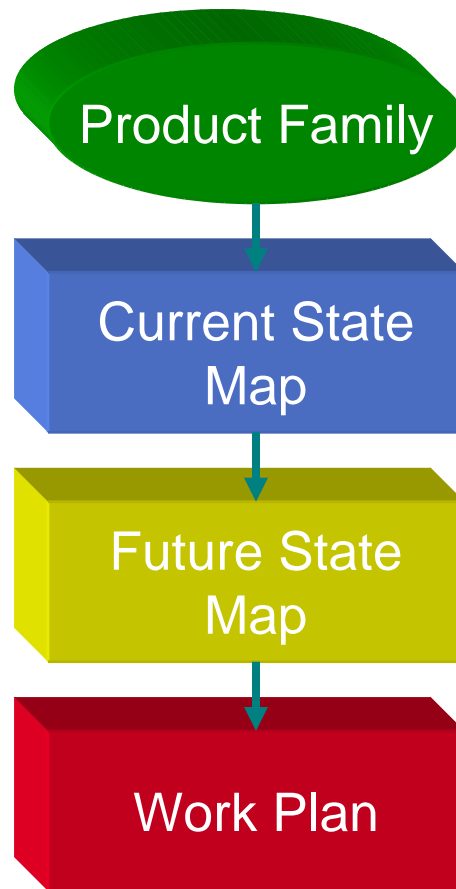


The VS Mapping Process



Mapping Methods

- Always collect current-state information by walking along the actual material and information flows.
- Start at shipping and work upstream.
- Use a stop watch to measure what is actually happening. Don't rely on standard times.
- Record the actual inventory. Count it.
- Even if several people are involved - map the whole value stream yourself. Don't spilt up the work.
- Draw it in pencil on a large sheet of paper. Do NOT use a computer.



Current State Value Stream Map Example

Caspian Corporation - OEM Products Value Stream

