



206 – PULL Systems (Kanban)

Onsite – 3 Days, 8 Hours/day – Optimum class size, 6 - 9 students

Training Description:

A pull system is a lean manufacturing strategy used to reduce waste in the production process. In this type of system, components used in the manufacturing process are only replaced once they have been consumed so companies only make enough products to meet customer demand.

This training designed to control inventory, manage bottleneck operations and shorten lead-times through the introduction of Pull Systems. Where flow ceases, a “supermarket” or “buffer inventory” is may be required to maintain the total system linkage with the customer and within the system itself. PULL Systems provides this system linkage where flow is not possible by establishing buffer inventory.

Training Objective:

Students will be taught a 5 – step process enabling them to design low cost solutions for reducing inventory, creating flow and improving lead-times. This in turn will help allow manufacturing to meet customer demands for high-quality, low-cost products, delivered quickly and without the expense of excess inventory.

- Supermarket, and FIFO
- Properly located inventory
- Properly sized inventory
- Capacity planning for EPEI -Every Part - Every Interval
- Order Points
- Order Quantities
- Kanban (signals for self-management)

Most PULL (Kanban) “Kaizens” result in an increase in cash flow by reducing inventory and improving lead-time through the plant 50 to 75% setup time reduction resulting from the initial activity.

Skill Attainment:

The workshop will provide a proven formula for a team to implement a PULL system. Once the team is fully trained this can be repeated in other areas of the plant or office. In this hands-on workshop the team will discovery how to:

1. Document The Current Process
2. Design The Pull System
3. Plan A Pull System
4. Create A Pull System
5. And Finally, Optimize The Pull System

These skills are transferable within the company, industry and are highly desirable by any manufacturer.



Training Agenda:

Day 1

Morning Training:

Document Current Process

- Select product(s) to Pull
- Determine if MTO or MTS or Hybrid
- Inventory basics, measures and data
- Draw Current State Map
- Draw current layout

Afternoon Training:

Design Pull System

- Define Pull System design goals
- Draw future state map
- Establish Pull locations
- Calculate order point and order quantities
- Decide on Kanbans (signals)
- Determine flow details
- Draw the pull system layout

Day 2

Morning Training

Plan Pull System

- List actions
- Test, test, test
- Set priorities
- Assign responsibilities
- Establish completion dates
- Post Pull / Kanban action plan

Afternoon Training

- Create Pull System
- Obtain all items
- Install Pull System
- Train workers
- Ensure the Pull and Replenish system works

Day 3

Optimize Pull System

- Adjust quantities as needed
- Install visual controls
- Develop a method to update KANBAN quantities based on demand.
- Investigate use of MRP to calculate KANBAN quantities
- Ensure the Pull and Replenish system works

All training will include Lecture, using Power point and handouts, Interactive discussion, and Hands on application of methods applying to client related issues. Impact will be recognized and reported at the completion of this training.