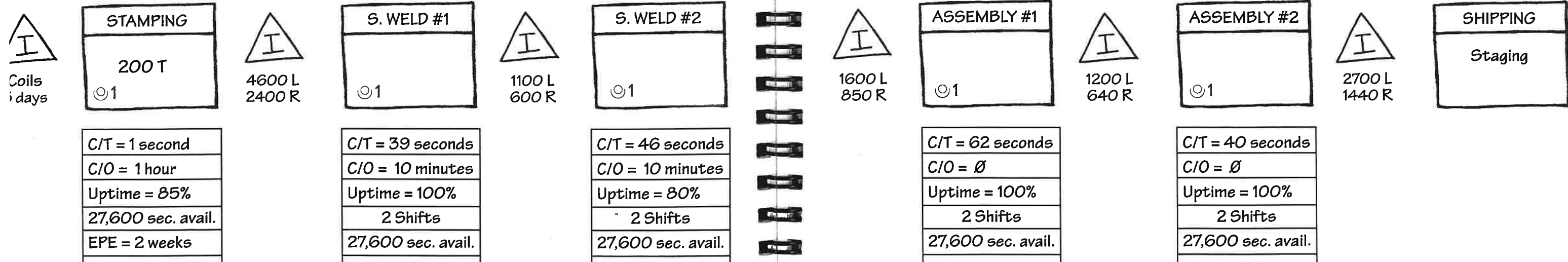
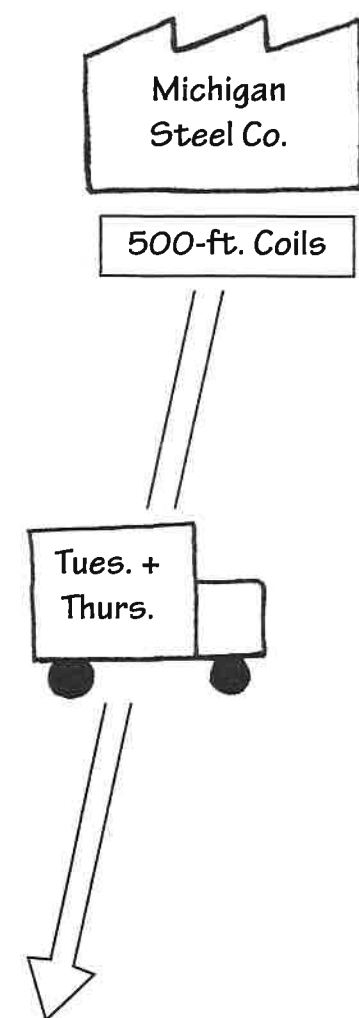


At Acme Stamping there is raw material inventory, finished-goods inventory, and inventory between each process. The observed amount of inventory is recorded below the triangles, in quantity and/or time.

**Second View of the Current-State Map
with all Processes, Data Boxes, and
Inventory Triangles**

State Street Assembly
18,400 pcs/mo -12,000 "L" - 6,400 "R"
Tray = 20 pieces
2 Shifts



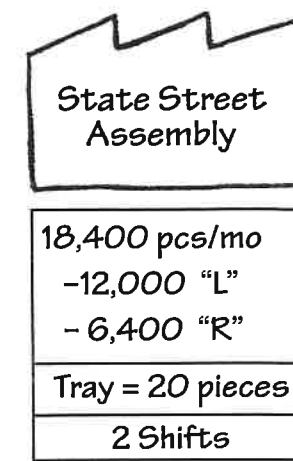
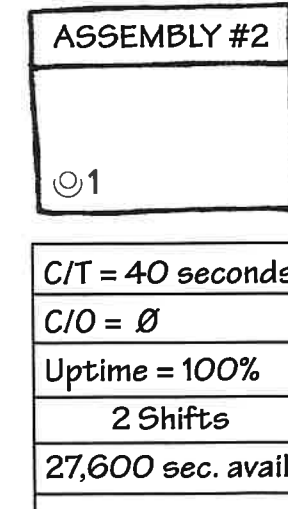
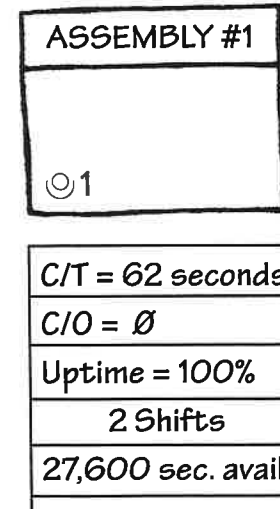
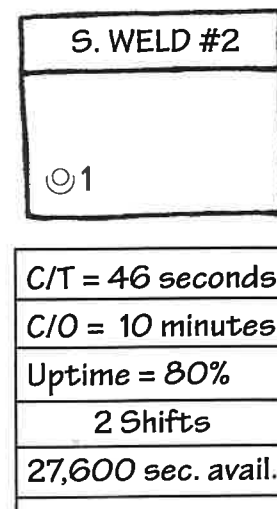
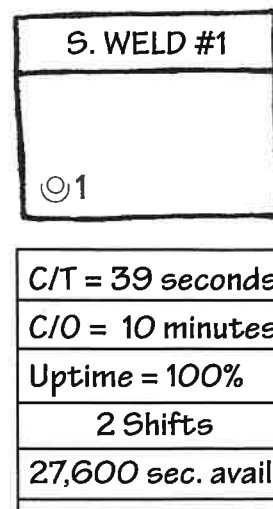
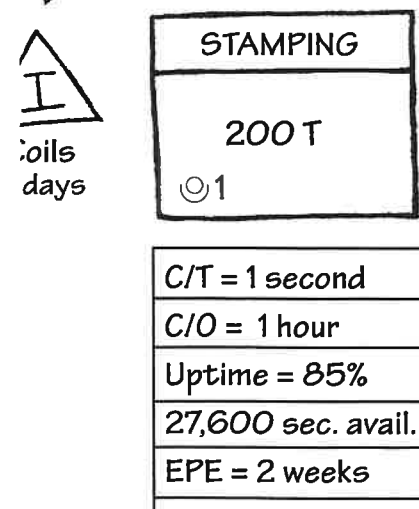


After Acme's last assembly workstation, steering brackets in trays are taken to a storage area (triangle icon). They are then staged in the shipping area according to the daily shipping schedule and delivered daily by truck to the customer's assembly plant. A **truck** icon and a **broad arrow** indicate movement of finished goods to the customer. (Create rail or air freight icons if you need them.)

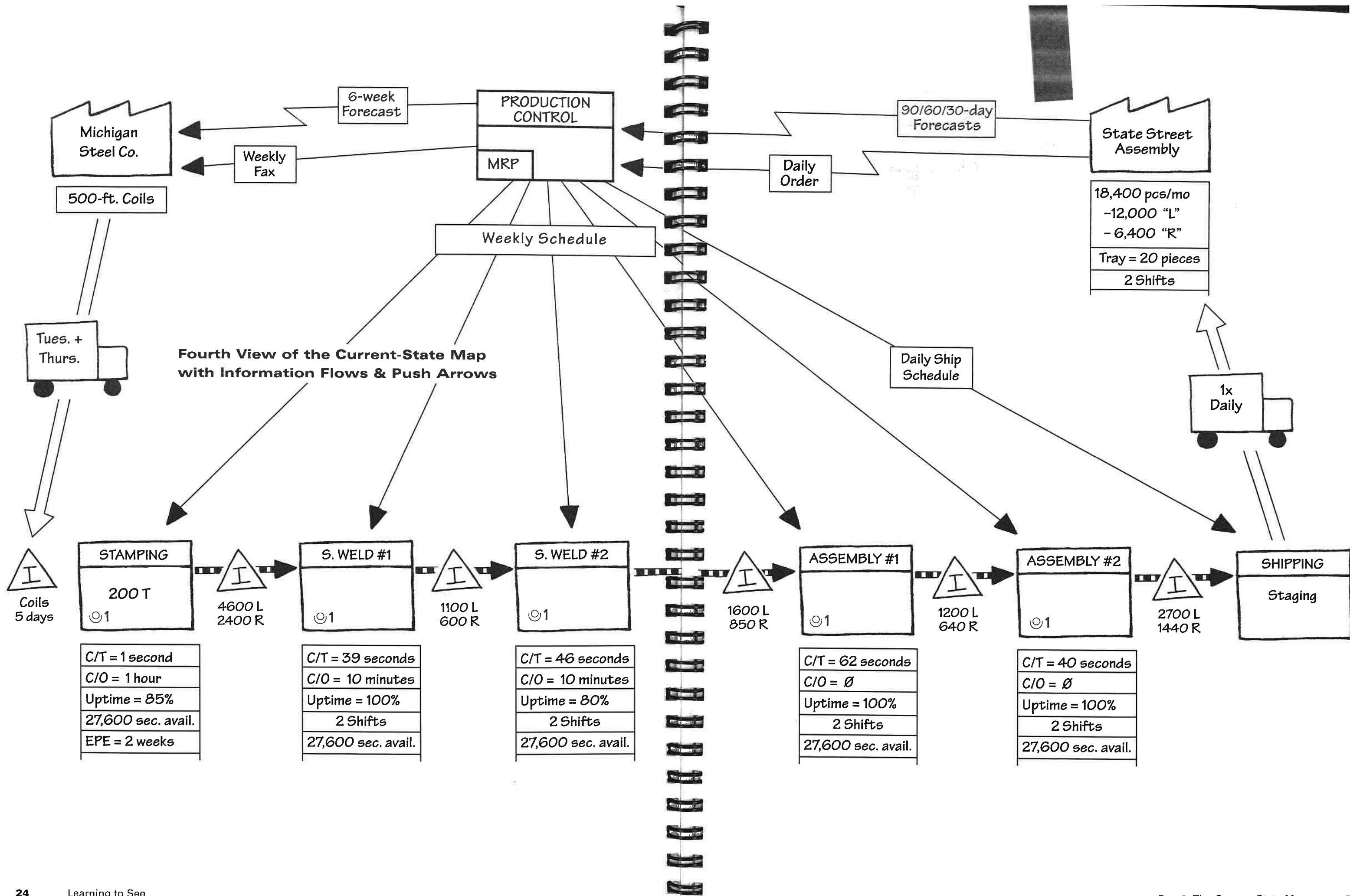
At the other end of the map, we'll represent the steel supplier with another factory icon. We use the same truck icon and broad arrow to show movement of material from the supplier to Acme. The steel supplier receives a weekly order from Acme and ships twice a week. We record in a **data box** that the supplier's pack size is a 500-foot roll of coiled steel. (In other words, the supplier cannot deliver less than a full coil but can deliver any number of full coils, as requested.) Once at Acme, the coil steel is taken to a storage area, as shown by the inventory triangle.

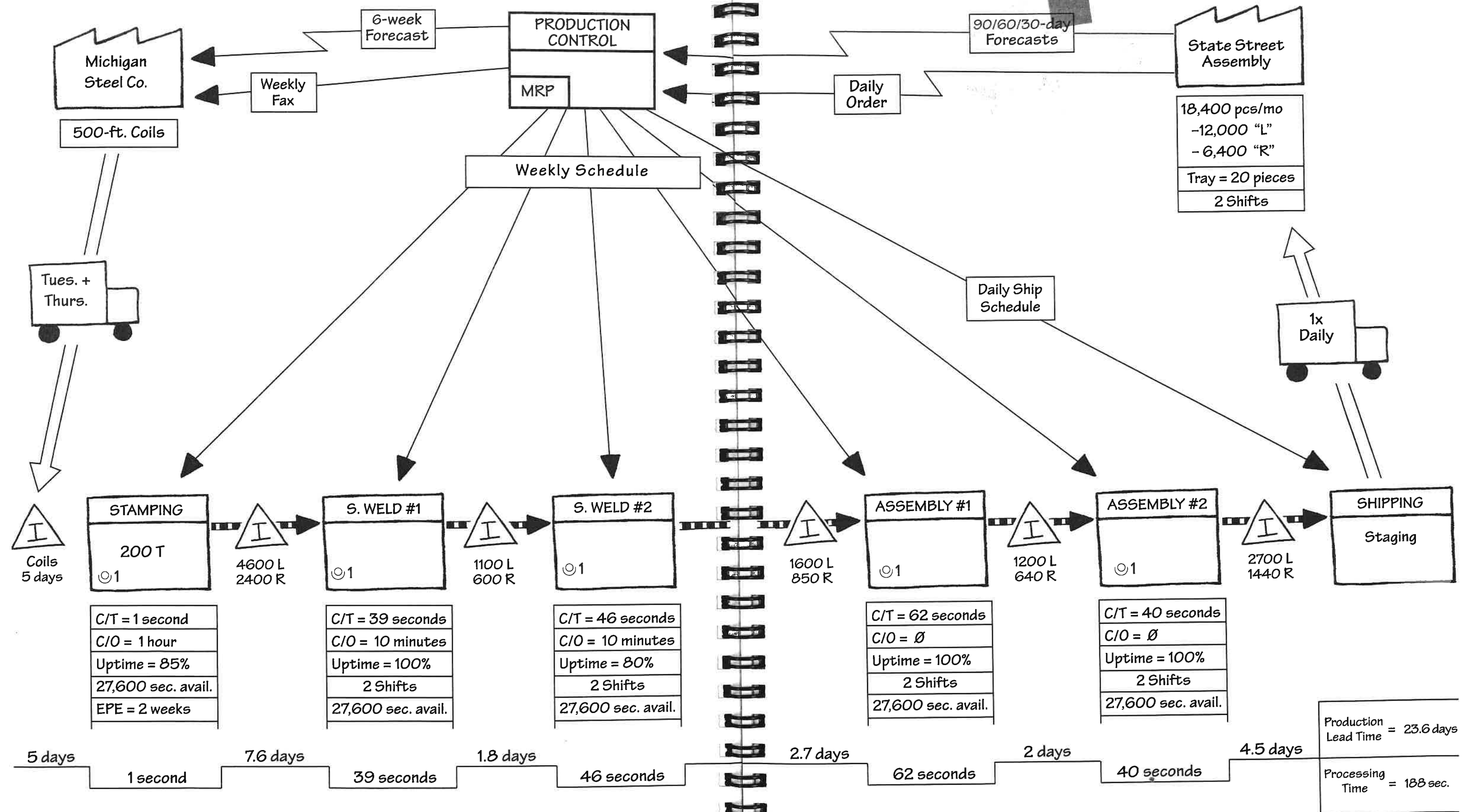
Note:

Do not map every purchased part in your product family. Just draw the flow for one or two main raw materials. Presentation of all purchased parts is best shown on a process-level layout diagram.

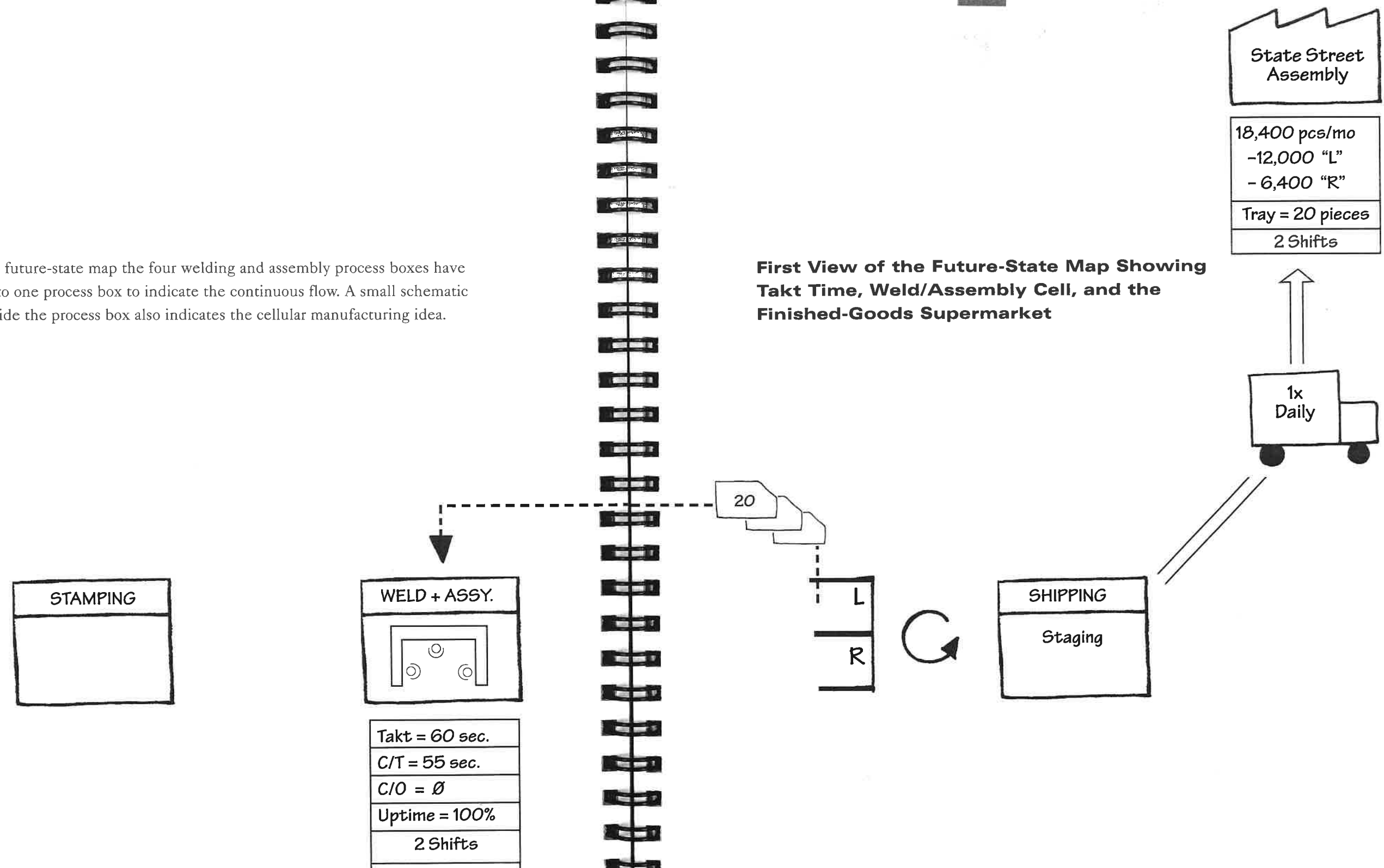


**Third View of the Current-State Map
Showing the Material Flow**

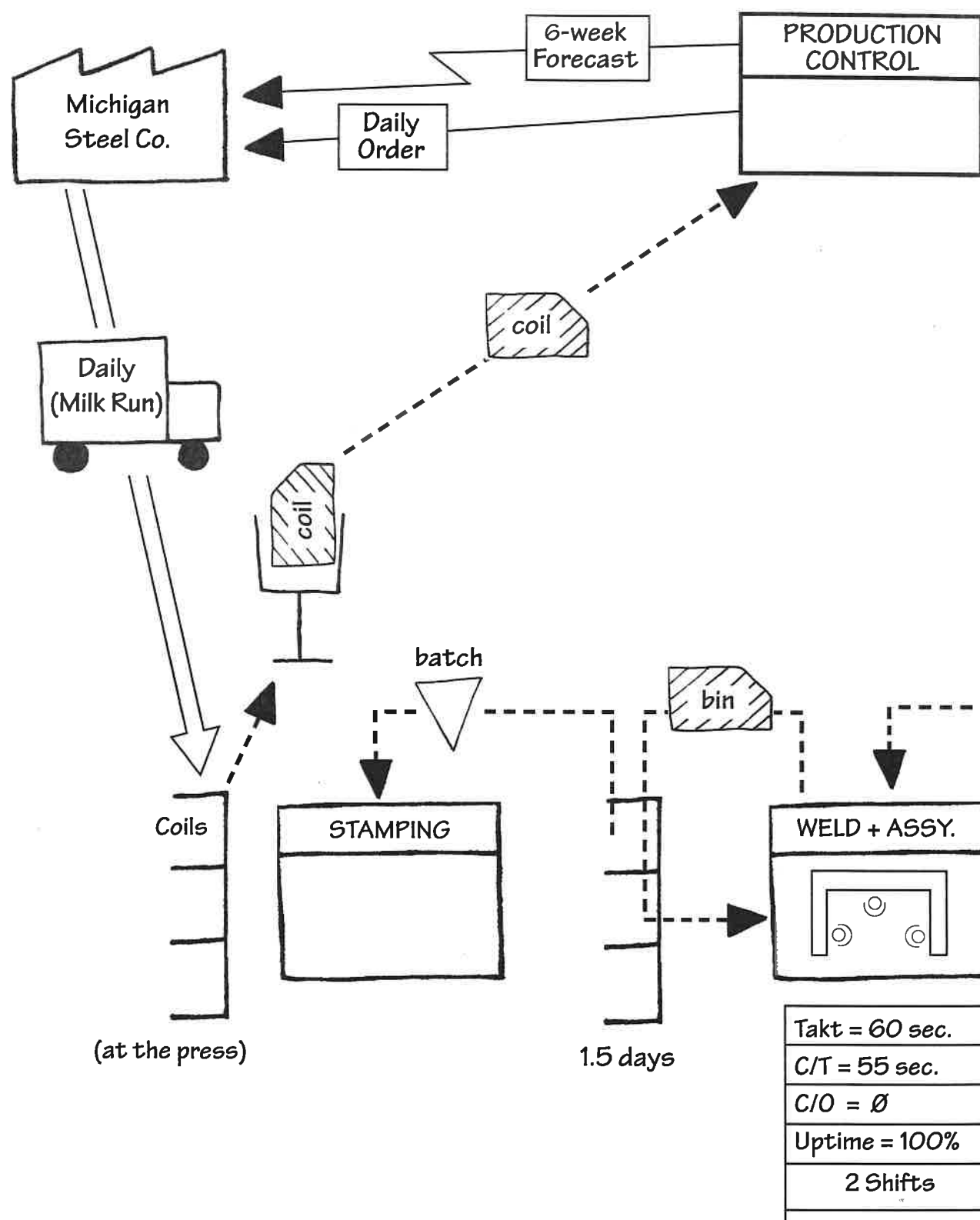




Notice that on this future-state map the four welding and assembly process boxes have been combined into one process box to indicate the continuous flow. A small schematic sketch of a cell inside the process box also indicates the cellular manufacturing idea.



First View of the Future-State Map Showing Takt Time, Weld/Assembly Cell, and the Finished-Goods Supermarket



Second View of the Future-State Map Showing Stamping and Raw Material Supermarkets

