

Chapter 10: lean manufacturing and activity analysis

Lean principles

- Lean enterprise
 - High quality
 - Low cost
 - Fast response
 - Immediate availability
- Lean manufacturing (just in time processing) accomplishes these objectives in a manufacturing setting
- Both manufacturing and nonmanufacturing businesses use lean principles to accomplish these service and cost objectives

Lean vs traditional manufacturing principles

Issue	Lean Manufacturing	Traditional Manufacturing
Inventory	Reduces inventory	Increases inventory to protect against process problems
Lead time	Reduces lead time	Increases lead time to protect against variability
Setup time	Reduces setup time	Increases setup time to set improvement priority
Production speed	Emphasizes product-oriented layout	Emphasizes process-oriented layout
Role of employees	Emphasizes team-oriented employee involvement	Emphasizes work of individuals following manager instructions
Production predictability	Emphasizes just manufacturing	Emphasizes stock manufacturing
Quality	Emphasizes zero defects	Accepts defects
Suppliers and customers	Emphasizes long-term relationships	Focuses suppliers and customers on "lowest-price" independent bidding

Reducing inventory

- Lean manufacturing views inventory as wasteful and unnecessary, and thus emphasized reducing or eliminating inventory
- Under traditional manufacturing, inventory often hides underlying production problems or problems caused by a shortage of trained employees, unreliable suppliers, or poor product quality
- In contrast, lean manufacturing solves and removes production problems
 - In this way, raw materials, work in process, and finished goods inventories are reduced or eliminated

Reducing lead time

- Lead time, sometimes called through put time, measures the time interval between a product entering production (started) and when it is completed (finished)
 - Lead time measures how long it takes to manufacture a product
- The value-added ratio is computed as follows
 - Value-added lead time/ total lead time
- Consider the lead time to manufacture a unit of product
 - The time taken for the tasks of machining, assembly, and packing is considered value-added lead time

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