

# Data Source

This is fictitious data just to illustrate mapping concepts. If you have ideas on improving this sample map please email to [dilesh.patel@evsm.com](mailto:dilesh.patel@evsm.com)

## eVSM Mix : VSM Leverage Ideas

- Identify / alleviate bottlenecks
- Look at lead time impacts with defective slices
- Plan resources at different demand rates

- Group resources into pools dedicated to adjacent groups of stations
- Consider shelf life of slices before consumption at the "pour"

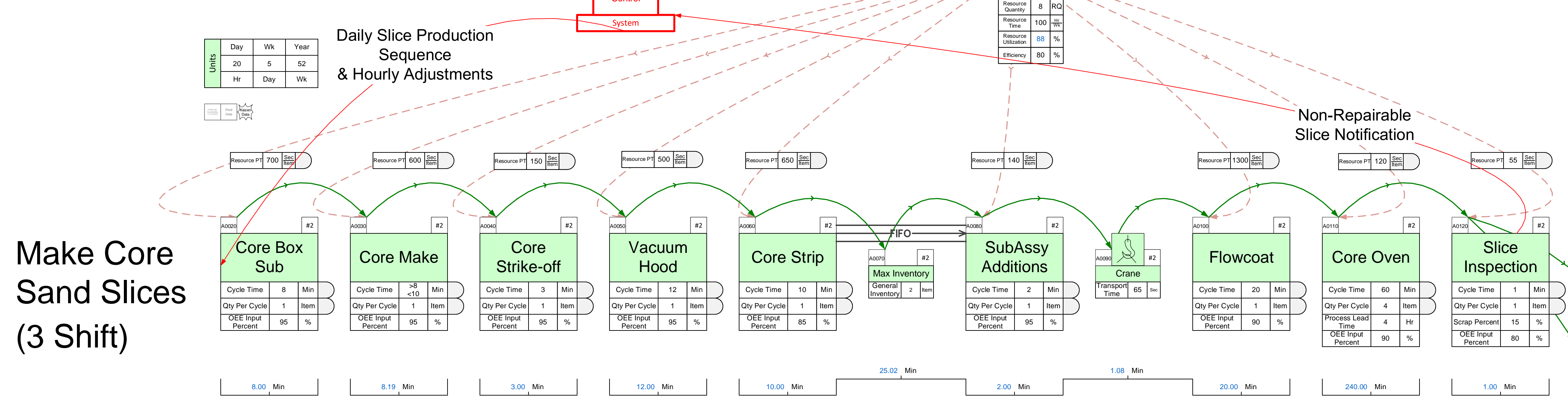
- Add another engine type as needed with correct computation of slices
- Enhance cycle time data with specific value for slice or block type where appropriate

- Create multiple map versions with different demand mix scenarios
- Add activity based cost info

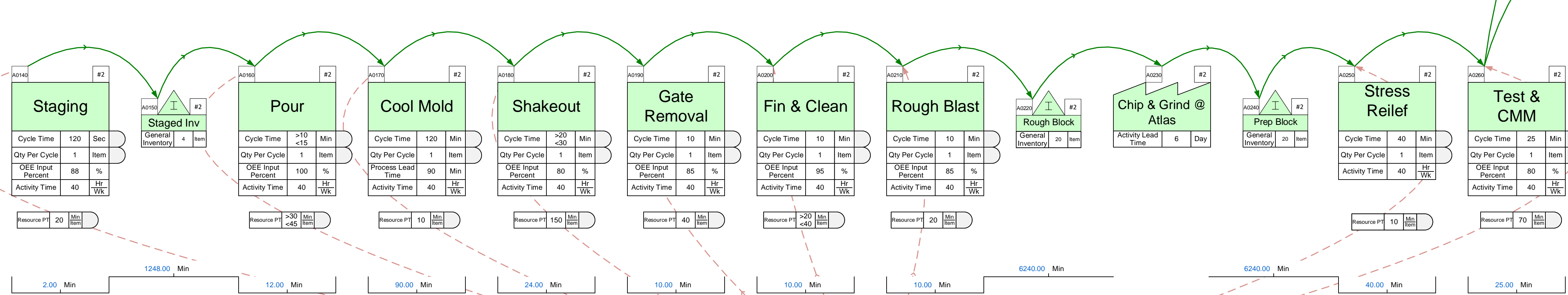
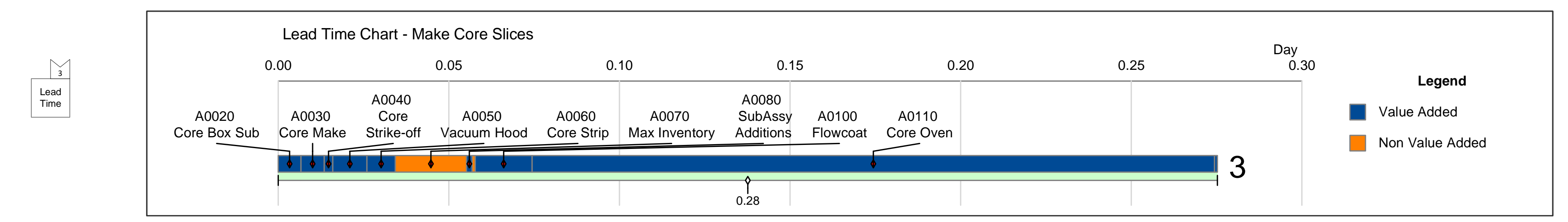
- Calculate total inventory qty & holding costs
- Annotate map with quality/root cause

- Visually annotate with improvement ideas and prioritize with impact matrix

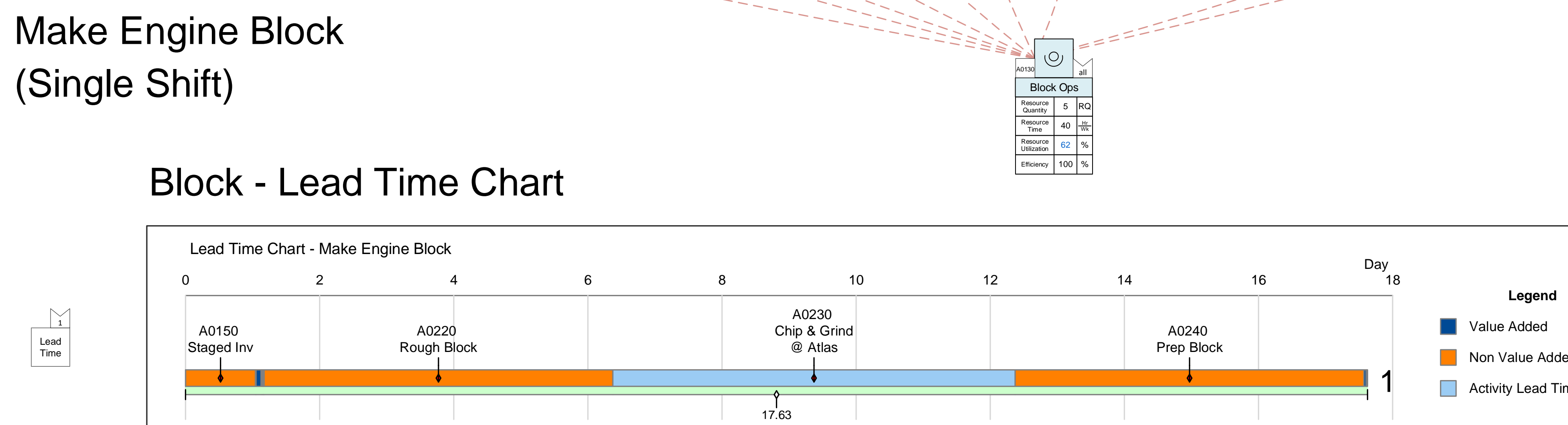
# ACME 2700 Line 9 – v8 & v12 Engine Block Casting / Current State Map / Oct 2019



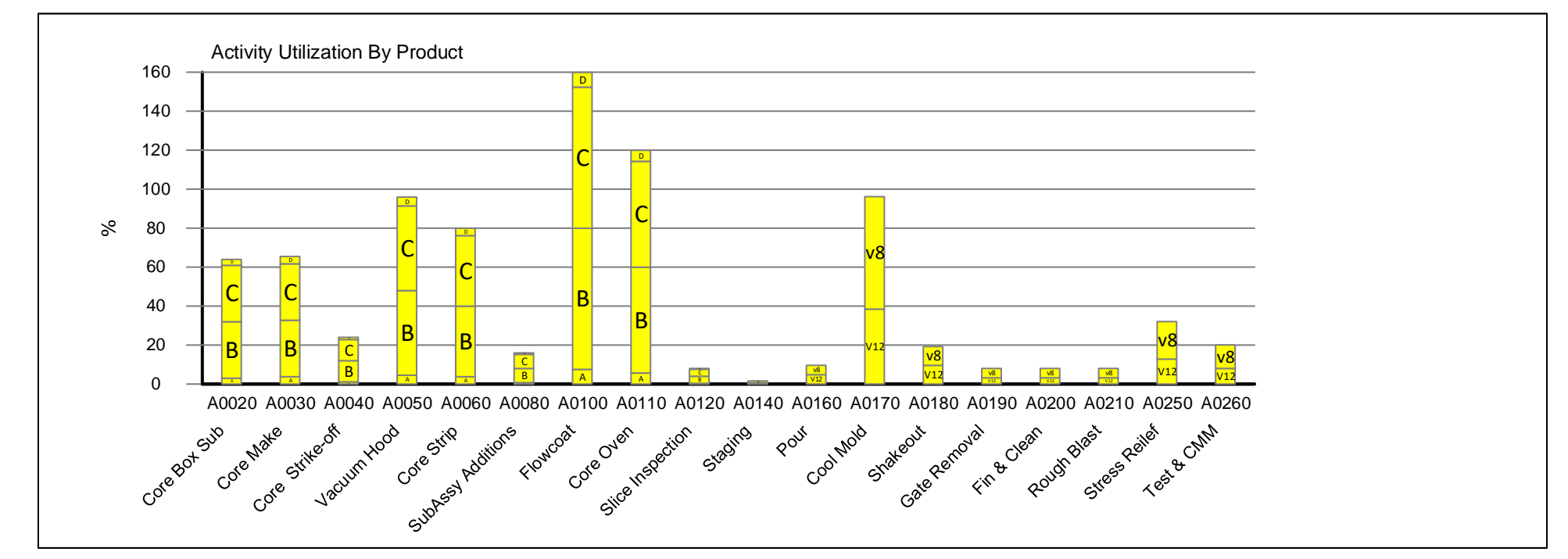
## Slices - Lead Time Chart



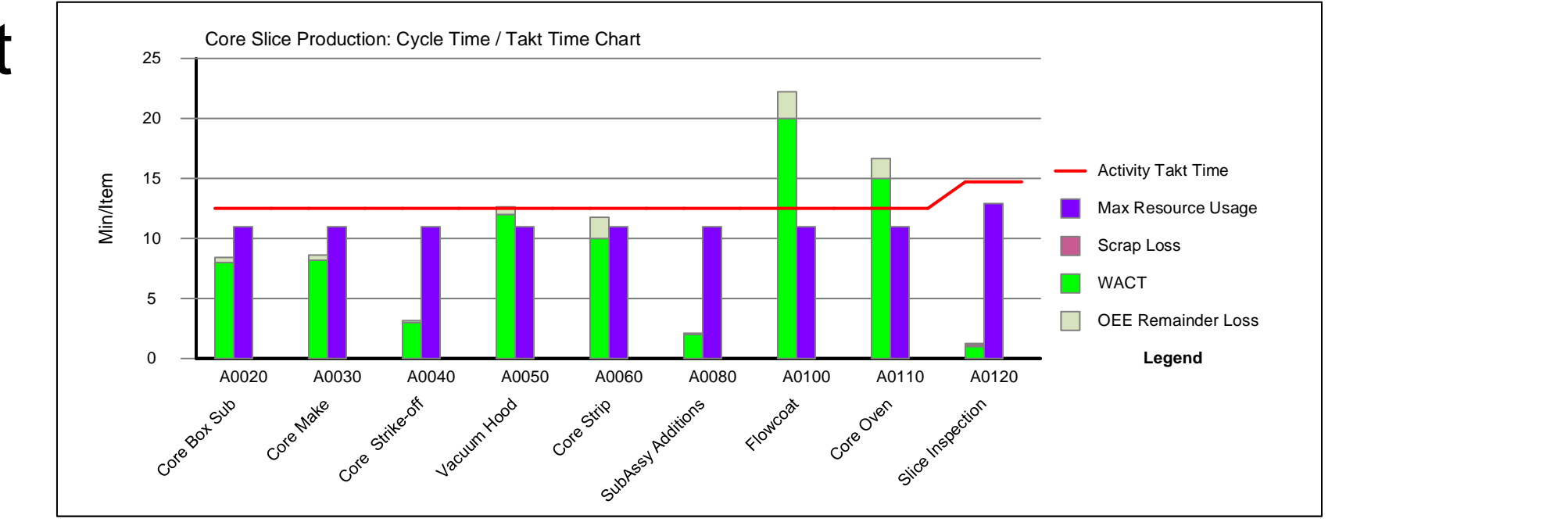
## Make Engine Block (Single Shift)



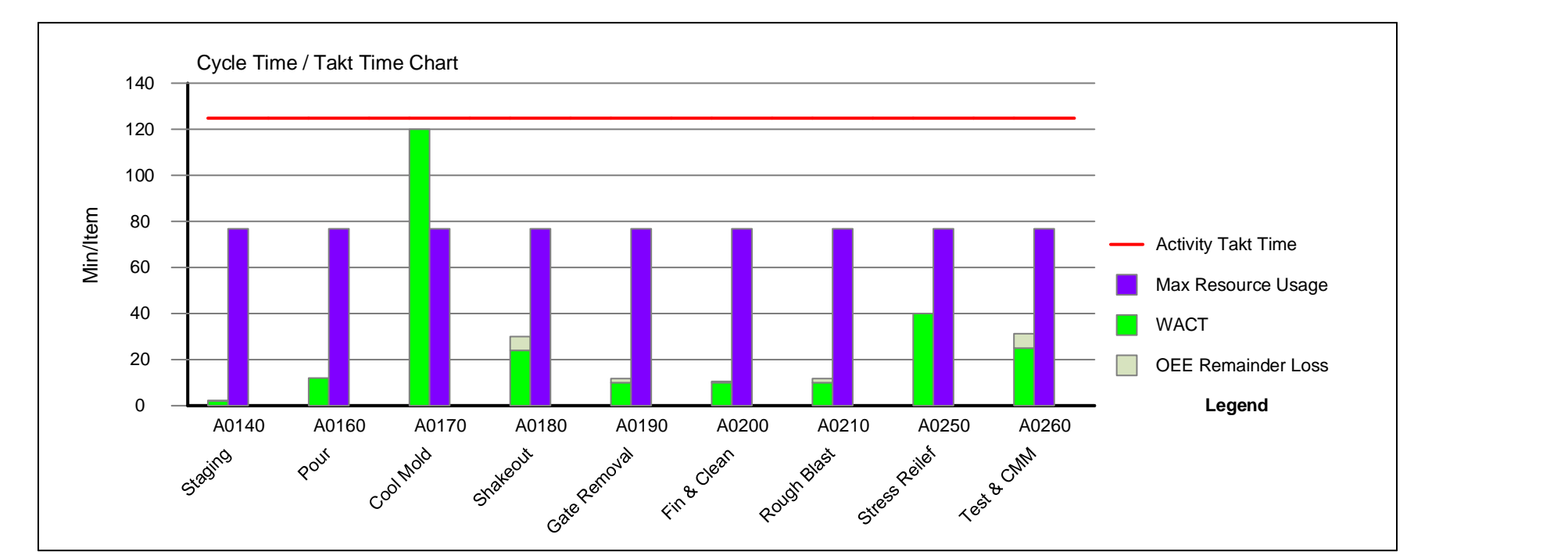
## Utilization Chart by Product



## Core CT/TT Chart



## Block CT/TT Chart



## Resource Balance Chart

