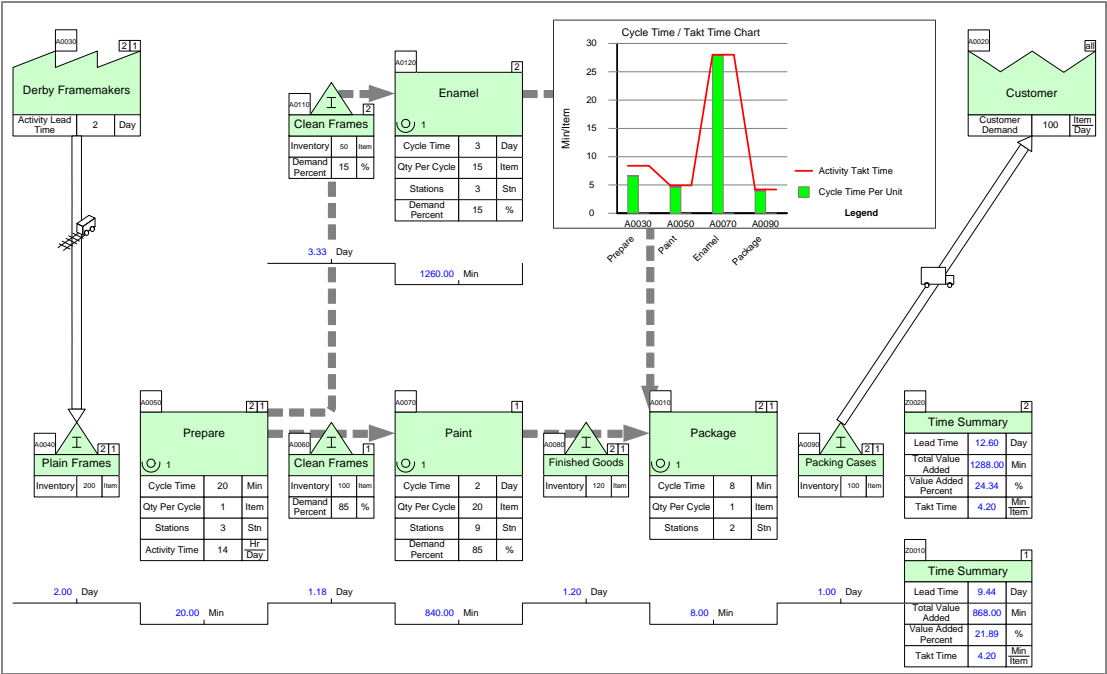


Quick Manufacturing Tutorial

This tutorial will guide you through the steps to draw the following map using the Quick Manufacturing stencil.



Step 1: Start eVSM

1 On your Desktop, click the "Start eVSM" icon.

2 If you see a message like this, you must "Enable" macros.

3 Click to enable macros.

4 Click "Trust all from publisher" to avoid the security notice in future.

Recycle Bin

Start eVSM

Microsoft Visio Security Notice

Microsoft Office has identified a potential security concern.

Note: The digital signature is valid, but the signature is from a publisher whom you have not yet chosen to trust.

File Path: C:\Program Files\evsm\Setup\Solutions\evsmIcons.vss

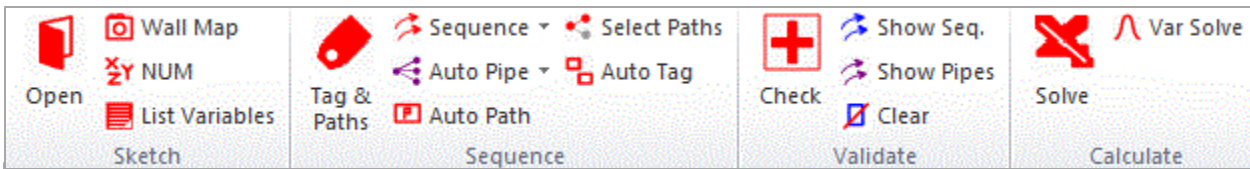
Macros have been disabled. Macros might contain viruses or other security hazards. Do not enable this content unless you trust the source of this file.

[More information](#)

[Show Signature Details](#)

Trust all from publisher Enable Macros Disable Macros

Step 2: Learn eVSM Basics



Quick Mfg LT

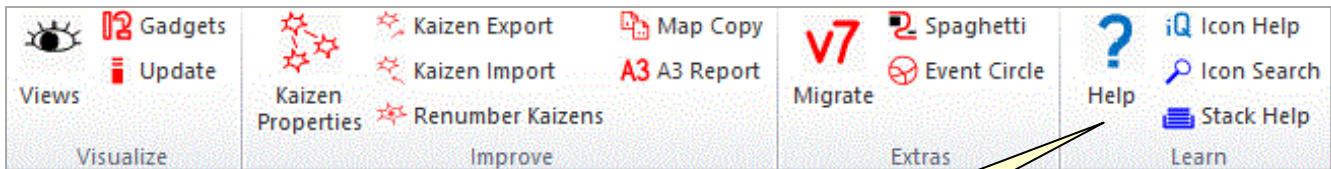
2 Avoid re-sizing eVSM shapes. Instead grow the drawing page when needed. To resize the page, hold down the “Ctrl” key, and then drag any page edge to the required size. This method works on all four edges of the page.



5 Save your Visio file and then insert a new page via the right-mouse menus on the page-tabs.

VSM

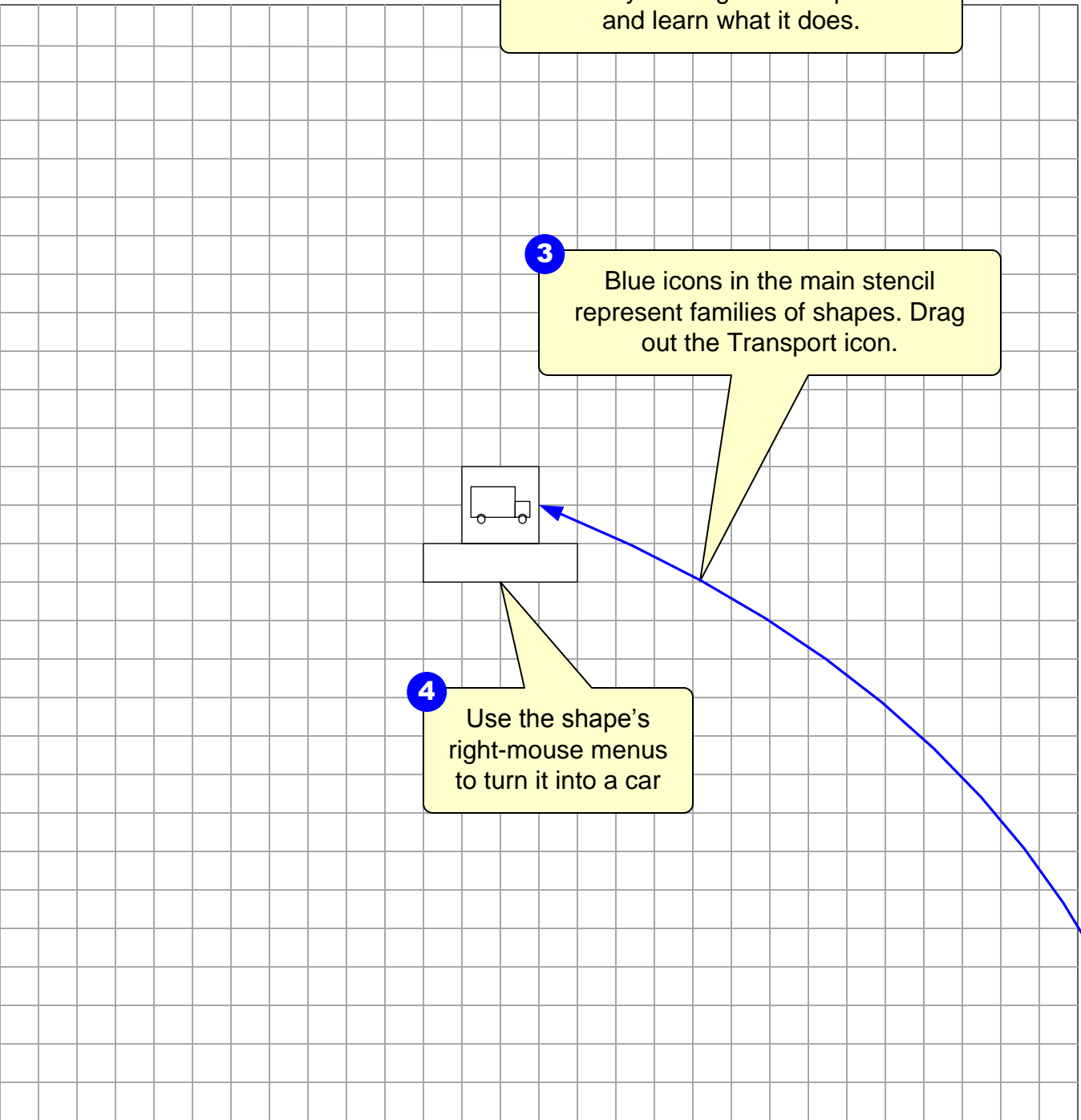
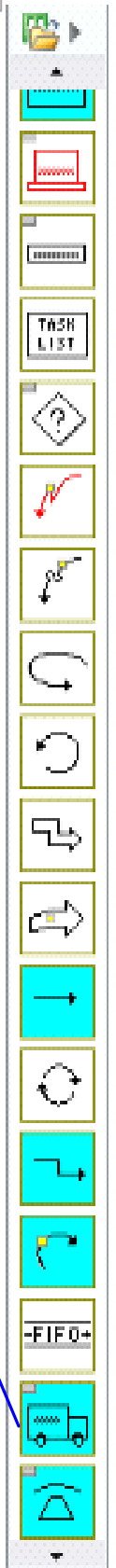
Quick_eVSM



1 eVSM Help resources are available here. Try clicking each help button and learn what it does.

3 Blue icons in the main stencil represent families of shapes. Drag out the Transport icon.

4 Use the shape's right-mouse menus to turn it into a car



Step 3: Initiate the map for Quick Manufacturing Lite

1 Click the Open button. Select Manufacturing and click OK.

2 The three Manufacturing stencils will open on the left. For this tutorial, use the Quick Mfg LT.

3 Drag out the two red icons first. This is very important!

6 Enter available hours per day here. This is actual work hours after subtracting break time.

shift	Wk	Wk
7	5	5
Hr	day	shift

eSMT Data
QuickMfg
7.17.2008
0

Views	Gadgets	Update	Kaizen Properties	Kaizen Export	Kaizen Import	Renumber Kaizens	Map Copy	A3 A3 Report	v7 Migrate	Spaghetti	Event Circle	Help	Icon Help	Icon Search	Stack Help	Learn
Visualize				Improve					Extras							

- Trash LIST
- Help
- Insert
- Move
- Rotate
- Flip
- Scale
- Refresh
- Zoom
- FIFO+
- Truck
- Inventory

4 Align all new shapes to the grid as you drop them.

5 Enter customer demand here.

A0030			all
Customer			
Customer Demand	100	Item	Day

Step 4: Draw the flow

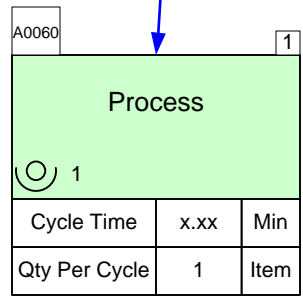
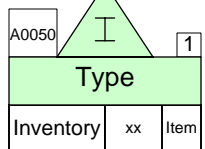
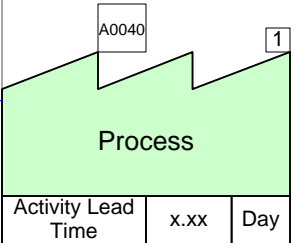
Open	Wall Map	Tag & Paths	Sequence ▾	Select Paths	Check	Show Seq.	Var Solve
List Variables	NUM	Auto Pipe ▾	Auto Path	Auto Tag	Show Pipes	Clear	Solve
Sketch		Sequence			Validate		Calculate

Quick Mfg LT

Outside Center

Activity Center







Inventory Center

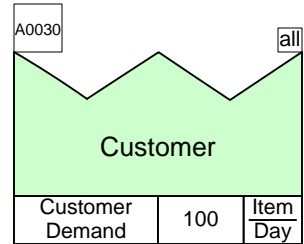


1 The green shapes are called "Centers". Use the centers to represent the flow.

2 If the VA and NVA timeline is not lined up, right-click it and use the "Align Timeline" feature.

Auto Day		Auto Min	
shift	Wk	Wk	
7	5	5	
Hr	day	shift	

 Views Visualize	 Gadgets Update	 Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	 Map Copy A3 A3 Report Improve	 v7 Migrate Spaghetti Event Circle Extras	 Help Learn Icon Help Icon Search Stack Help
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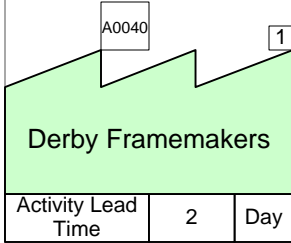


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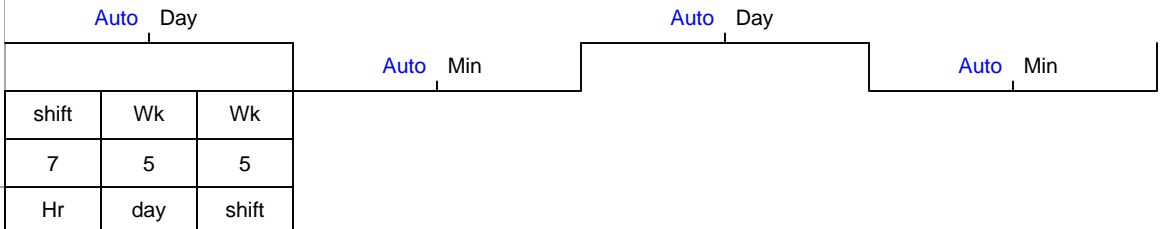
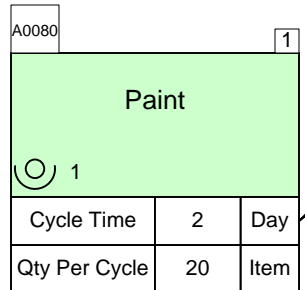
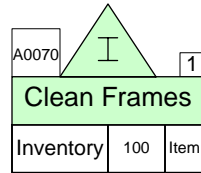
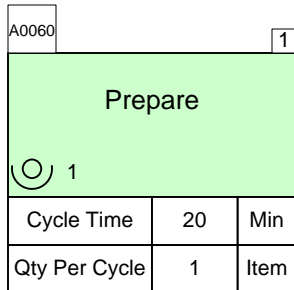
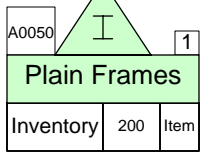
Step 5: Complete the flow and enter data

Open	Wall Map	Tag & Paths	Sequence ▾	Select Paths	Check	Show Seq.	Var Solve
List Variables	NUM	Auto Pipe ▾	Auto Path	Auto Tag	Show Pipes	Clear	Solve
Sketch		Sequence			Validate		Calculate

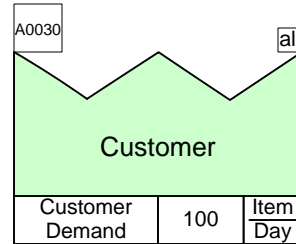
Quick Mfg LT



1 Complete as shown below, including annotation and data values.



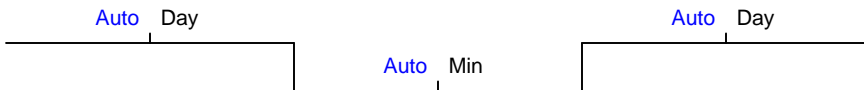
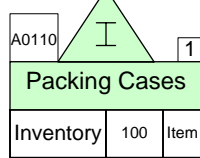
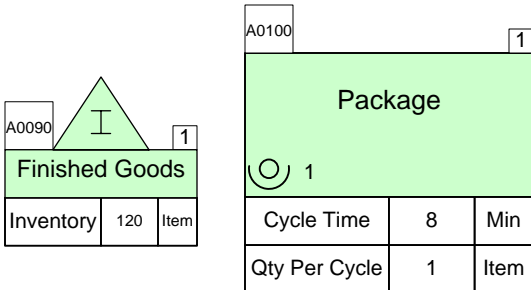
Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	



3 Double-click and change "Min" to "Day".

2 If text does not fit, avoid resizing eVSM shapes. Instead, make the font smaller.

4 Do not change any blue "Auto" values. These will get calculated automatically later.

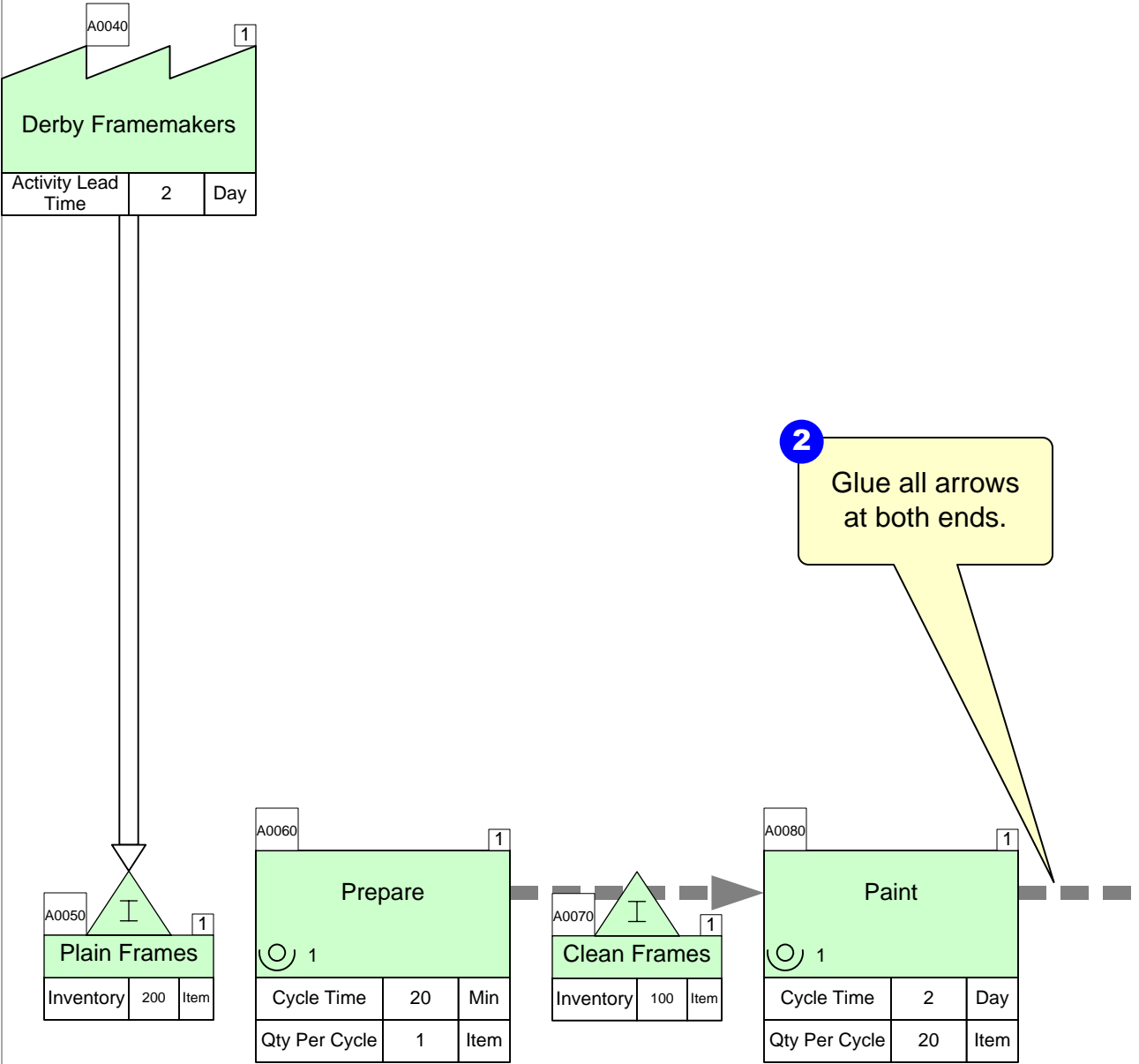


- Clipboard
- Eraser
- TASK LIST
- Help (?)
- Selection tools (arrow, lasso, pan)
- Undo/Redo
- Copy/Paste
- Navigation (up, down, left, right arrows)
- Simulation icons (truck, factory, etc.)

Step 6: Add Arrows from Main Stencil

Open	Wall Map	Tag & Paths	Sequence ▾	Select Paths	Check	Show Seq.	Var Solve
List Variables	NUM	Auto Pipe ▾	Auto Path	Auto Tag	Show Pipes	Clear	Solve
Sketch		Sequence			Validate		Calculate

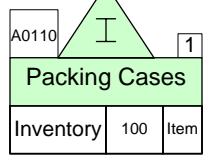
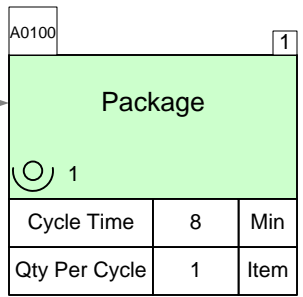
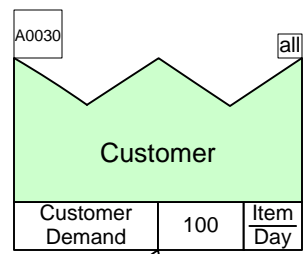
Quick Mfg LT



Auto Day			Auto Min			Auto Day			Auto Min		
shift	Wk	Wk									
7	5	5									
Hr	day	shift									

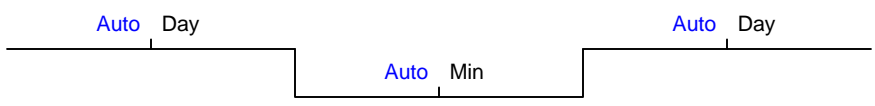
e/SMT
Data
QuickMfg
7.17.2008
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Gadgets	Kaizen Export	Map Copy	Spaghetti	Icon Help
Views	Kaizen Import	A3 Report	Event Circle	Icon Search
Visualize	Kaizen Properties	Renumber Kaizens	Migrate	Stack Help
	Improve		Extras	Learn



3 Use the right mouse button menu of the arrows to turn into a "Push" arrow.

1 Drag the arrows from the Main stencil on the right.



Step 7: Add Transport shapes and the Time Summary

Wall Map	Sequence ▾	Select Paths	Show Seq.	Var Solve
Open	Auto Pipe ▾	Auto Tag	Show Pipes	Solve
List Variables	Tag & Paths	Auto Path	Clear	
Sketch	Sequence	Validate	Calculate	

Quick Mfg LT

A0040
1

Derby Framemakers

Activity Lead Time	2	Day
--------------------	---	-----

1 Glue transport shape to arrow.

2 Use the right mouse button menu to change the shape to have "No Frame" and switch into a "Train" icon.

3 Drag out the Time Summary. Note, all fields are "Auto", so they will be calculated automatically.



Transport Shapes

A0050
1

Plain Frames

Inventory	200	Item
-----------	-----	------

A0060
1

Prepare

1

Cycle Time	20	Min
Qty Per Cycle	1	Item

A0070
1

Clean Frames

Inventory	100	Item
-----------	-----	------

A0080
1

Paint

1

Cycle Time	2	Day
Qty Per Cycle	20	Item



Time Summary

Auto Day			Auto Day		
Auto Min			Auto Min		
shift	Wk	Wk	Auto Min	Auto Min	Auto Min
7	5	5			
Hr	day	shift			

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help
Visualize		Improve		Extras	Learn

- Simulation Start/Stop
- Simulation Settings
- TASK LIST
- Help
- Navigation (Back, Forward, Home)
- Simulation Control (Pause, Play, Stop)
- Simulation Analysis (Gantt, Histogram, etc.)
- Simulation Output (Print, Export)

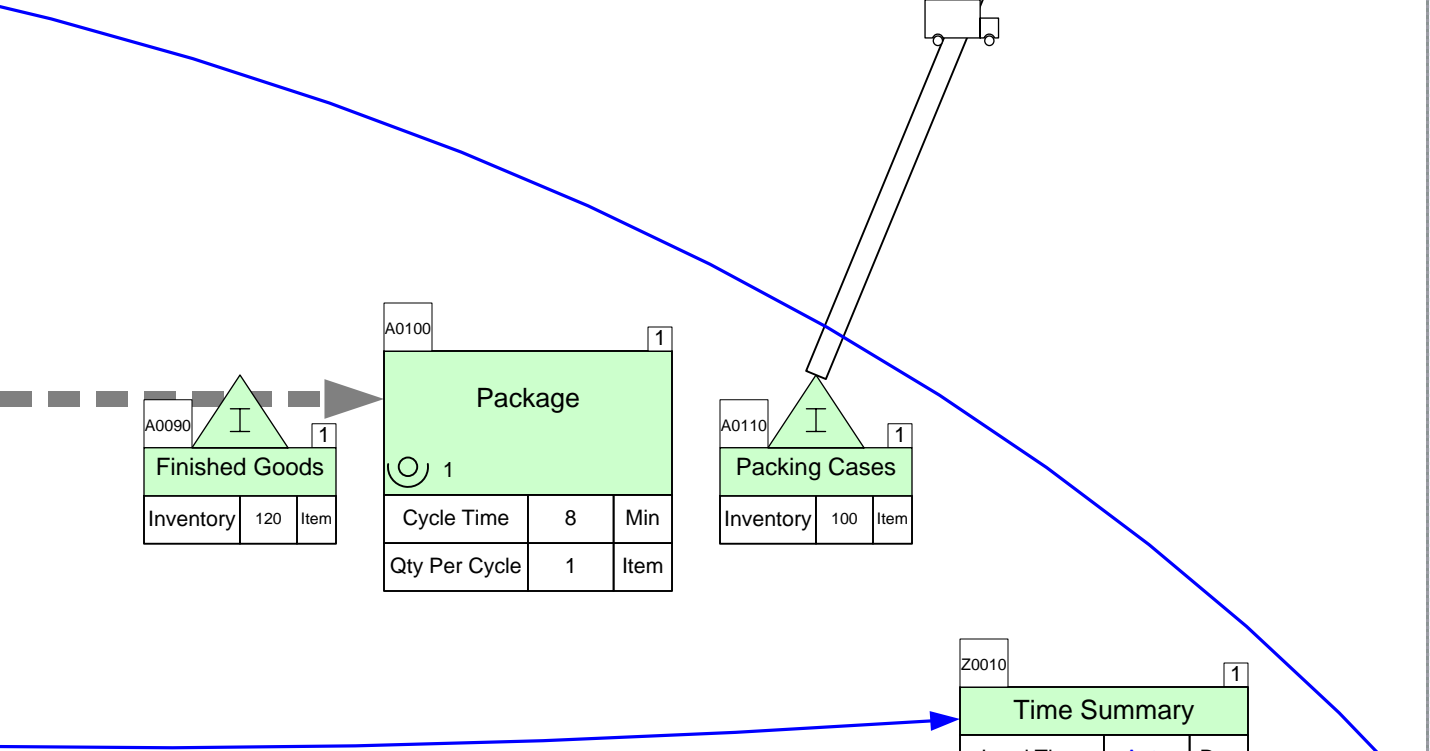
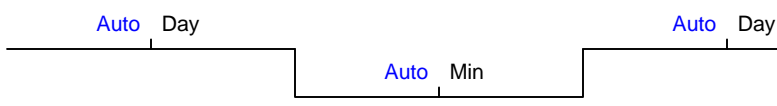
A0030	all
Customer	
Customer Demand	100 Item Day

A0100	1
Package	
Inventory	120 Item
Cycle Time	8 Min
Qty Per Cycle	1 Item

A0110	1
Packing Cases	
Inventory	100 Item

A0090	1
Finished Goods	
Inventory	120 Item

Z0010	1
Time Summary	
Lead Time	Auto Day
Total Value Added	Auto Min
Value Added Percent	Auto %
Takt Time	Auto Min Item



Step 8: Sequence Arrows

Open	Wall Map	Sequence	Select Paths	Check	Show Seq.	Var Solve
List Variables	NUM	Tag & Paths	Auto Pipe	Auto Tag	Show Pipes	Solve
Sketch		Sequence		Validate		Calculate

2 Click the Sequence button.

1 Sequence arrows are needed for upstream and downstream calculations. To add them, hold down the Ctrl key and select the green shapes in the order shown here.

A0040 1

Derby **A** makers

Activity Lead Time	2	Day
--------------------	---	-----

A0050 1

Pla **B** es

Inventory	Item
-----------	------

A0060 1

C

Cycle Time	20	Min
Qty Per Cycle	1	Item

A0070 1

Cle **D** es

Inventory	100	Item
-----------	-----	------

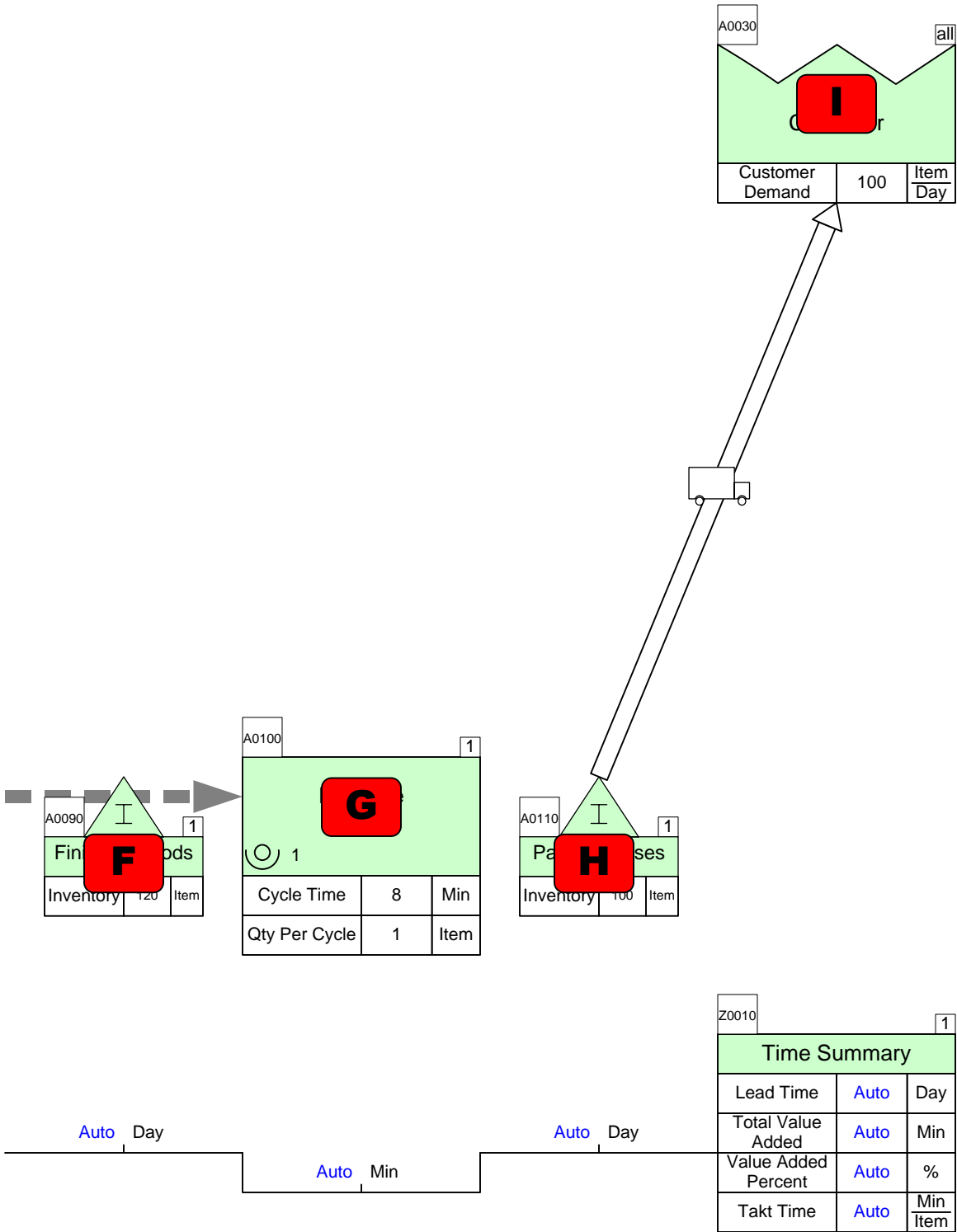
A0080 1

E

Cycle Time	2	Day
Qty Per Cycle	20	Item

Auto Day			Auto Day		
Auto Min			Auto Min		
shift	Wk	Wk			
7	5	5			
Hr	day	shift			

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help
Visualize		Improve		Extras	Learn

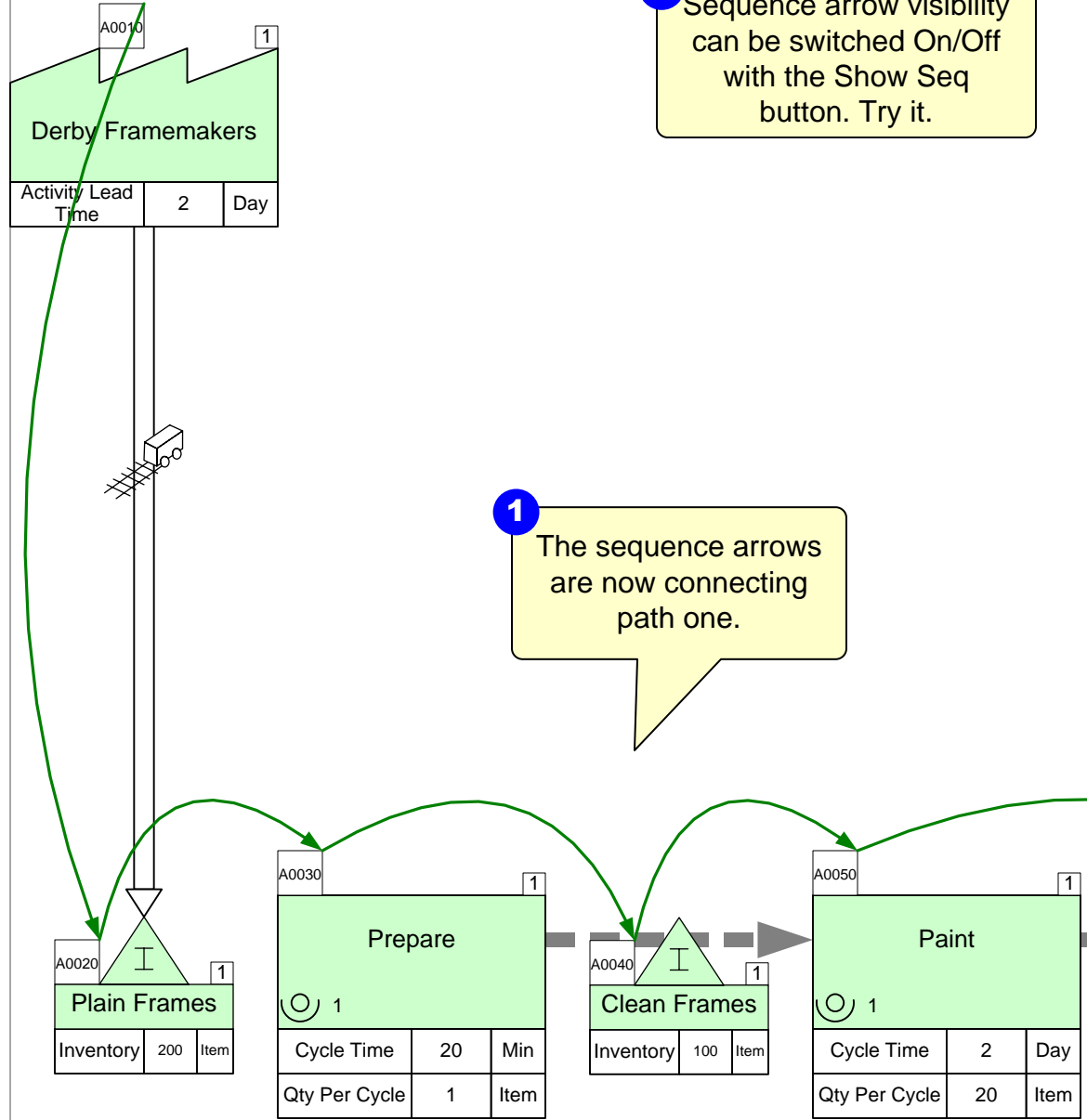


Step 9: Sequence Arrow Visibility

	Wall Map	Sequence ▾	Select Paths	Show Seq.	Var Solve
NUM	Tag & Paths	Auto Pipe ▾	Auto Tag	Show Pipes	Solve
List Variables	Auto Path			Clear	Calculate
Sketch	Sequence	Validate			

3 Sequence arrow visibility can be switched On/Off with the Show Seq button. Try it.

1 The sequence arrows are now connecting path one.



Auto Day			Auto Day		
Auto Min			Auto Min		
shift	Wk	Wk			
7	5	5			
Hr	day	shift			

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

2 These Path Locator tags can be used to specify paths. You can manually change these. You can add new ones with copy/paste or from the main stencil on the right. Another way to specify paths is with Sequence arrows and the Auto Path function.

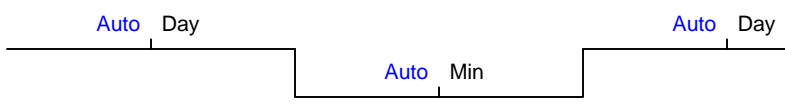
Customer		
Customer Demand	100	Item Day

Finished Goods		
Inventory	120	Item

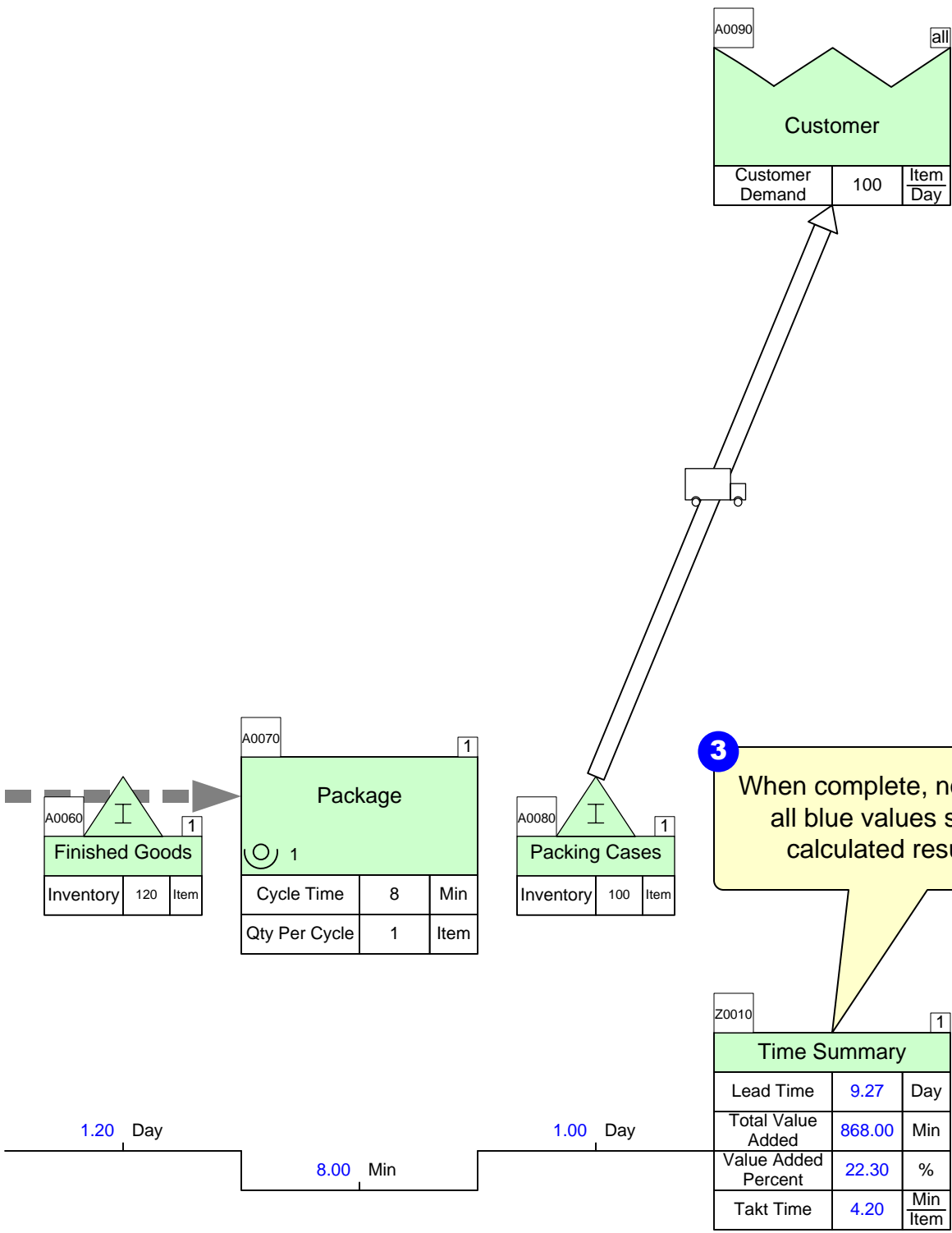
Package		
Cycle Time	8	Min
Qty Per Cycle	1	Item

Packing Cases		
Inventory	100	Item

Time Summary		
Lead Time	Auto	Day
Total Value Added	Auto	Min
Value Added Percent	Auto	%
Takt Time	Auto	Min Item



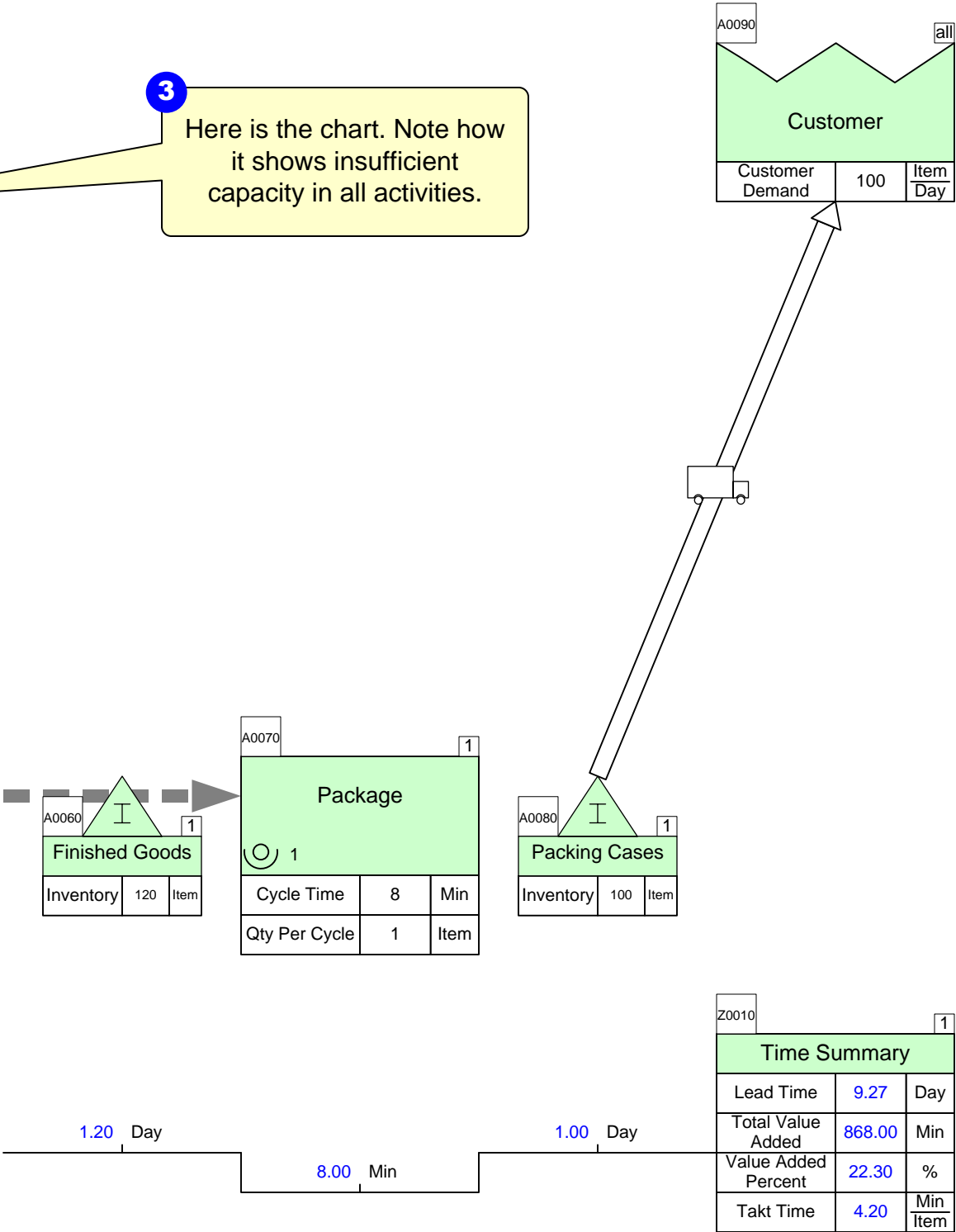
Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help
Visualize		Improve		Extras	Learn



3 When complete, note that all blue values show calculated results

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	

3 Here is the chart. Note how it shows insufficient capacity in all activities.

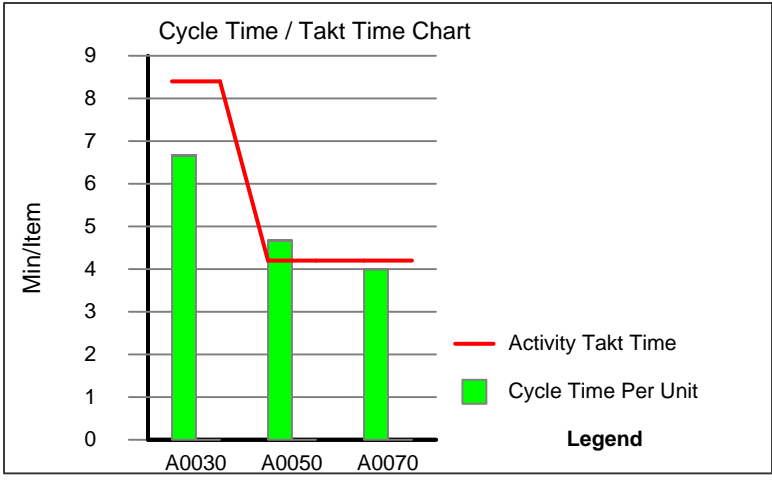


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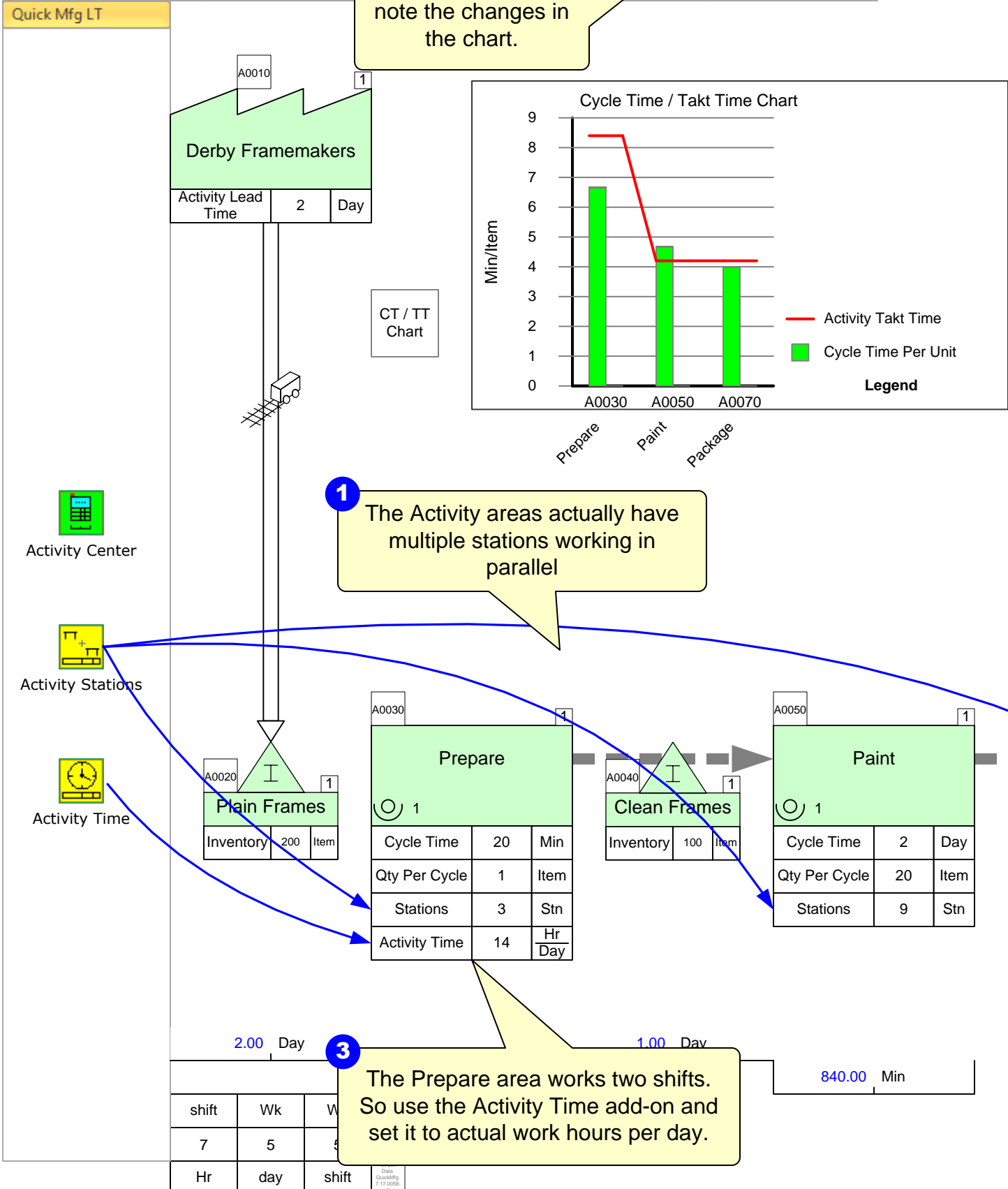
Step 12: Try Add-on Calculations

Wall Map Sequence Select Paths Show Seq. Var Solve
NUM Auto Pipe Auto Tag Show Pipes Solve
List Variables Tag & Paths Auto Check Calculate

4 Run "Solve" and note the changes in the chart.



1 The Activity areas actually have multiple stations working in parallel



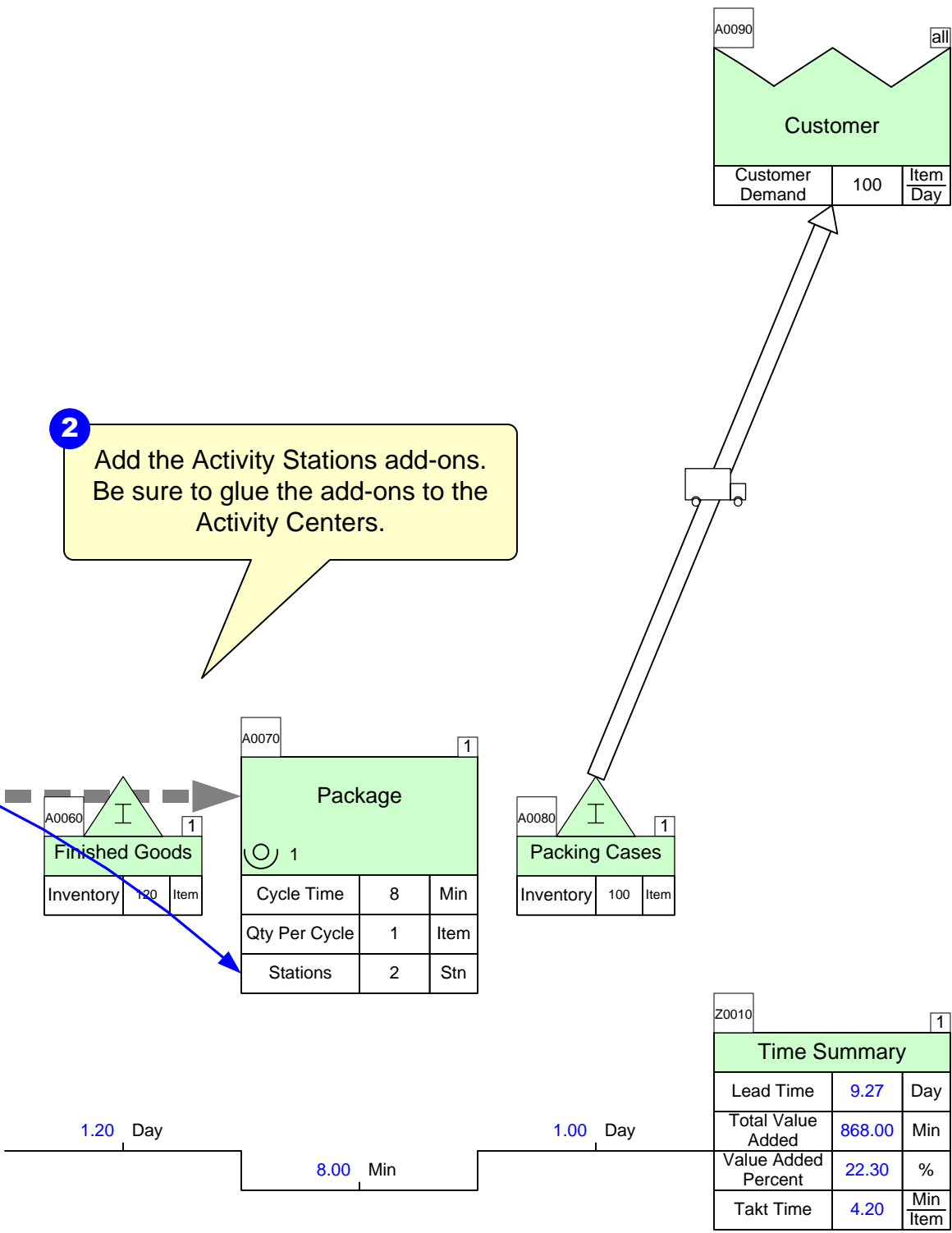
3 The Prepare area works two shifts. So use the Activity Time add-on and set it to actual work hours per day.

Activity Center
Activity Stations
Activity Time

shift	Wk	W
7	5	5
Hr	day	shift

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumbr Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

2 Add the Activity Stations add-ons. Be sure to glue the add-ons to the Activity Centers.



Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

2 Delete the chart to create space to draw the parallel path.

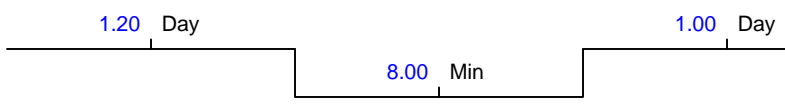
A0090			all		
Customer					
Customer Demand	100	Item	Day		



A0070			1		
Package					
Inventory	120	Item	Cycle Time	8	Min
			Qty Per Cycle	1	Item
			Stations	2	Stn

A0080			1		
Packing Cases					
Inventory	100	Item			

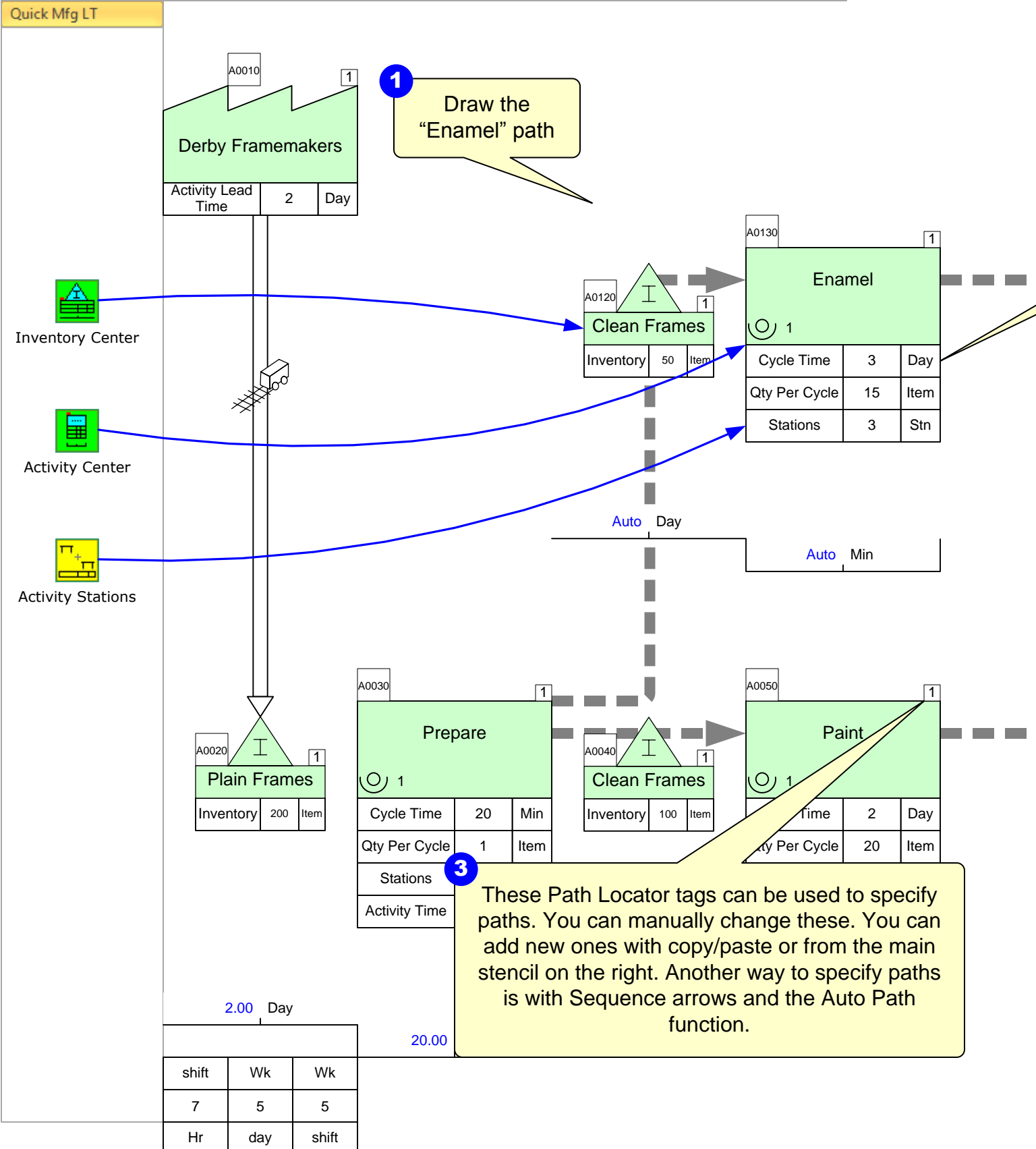
Z0010			1		
Time Summary					
Lead Time	9.27	Day			
Total Value Added	868.00	Min			
Value Added Percent	22.30	%			
Takt Time	4.20	Min	Item		



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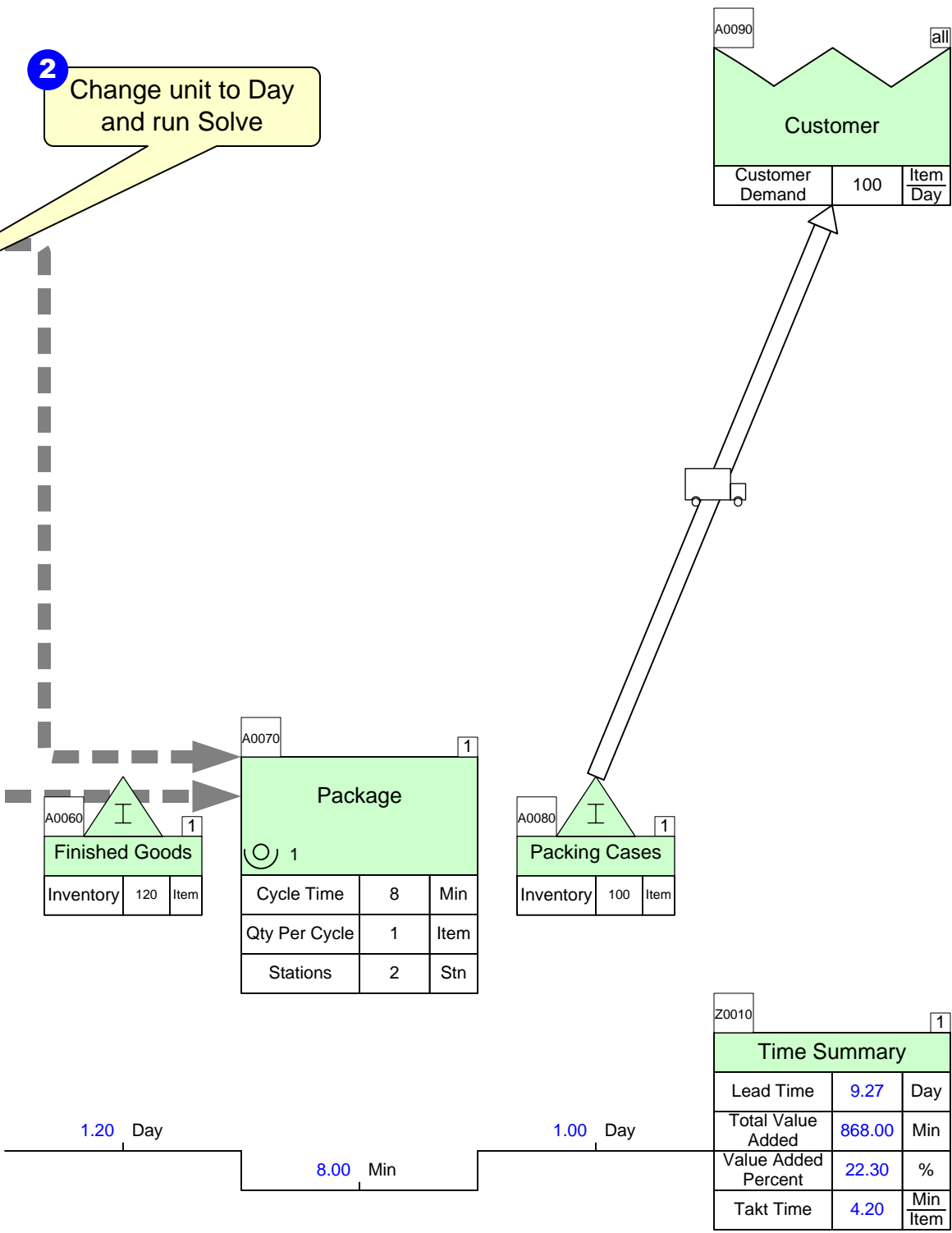
Step 14: Multi-path Modeling

Wall Map	Sequence ▾	Select Paths	Show Seq.	Var Solve
Open	Auto Pipe ▾	Auto Tag	Show Pipes	Solve
List Variables	Tag & Paths	Auto Path	Clear	
Sketch	Sequence	Validate	Calculate	



Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumbr Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

2 Change unit to Day and run Solve

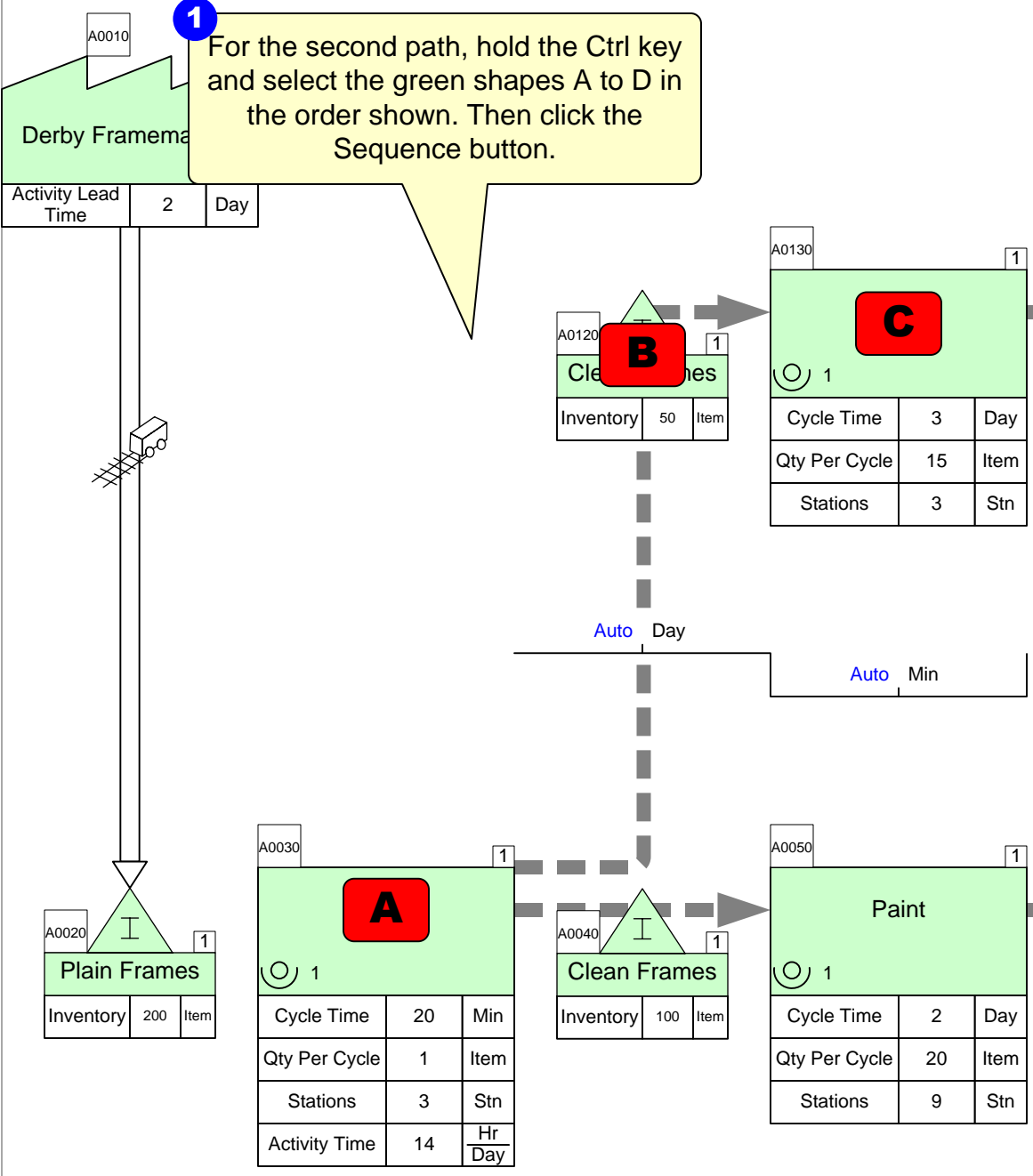


20010			1
Time Summary			
Lead Time	9.27	Day	
Total Value Added	868.00	Min	
Value Added Percent	22.30	%	
Takt Time	4.20	Min	Item

Step 15: Sequence Arrows for Second Path

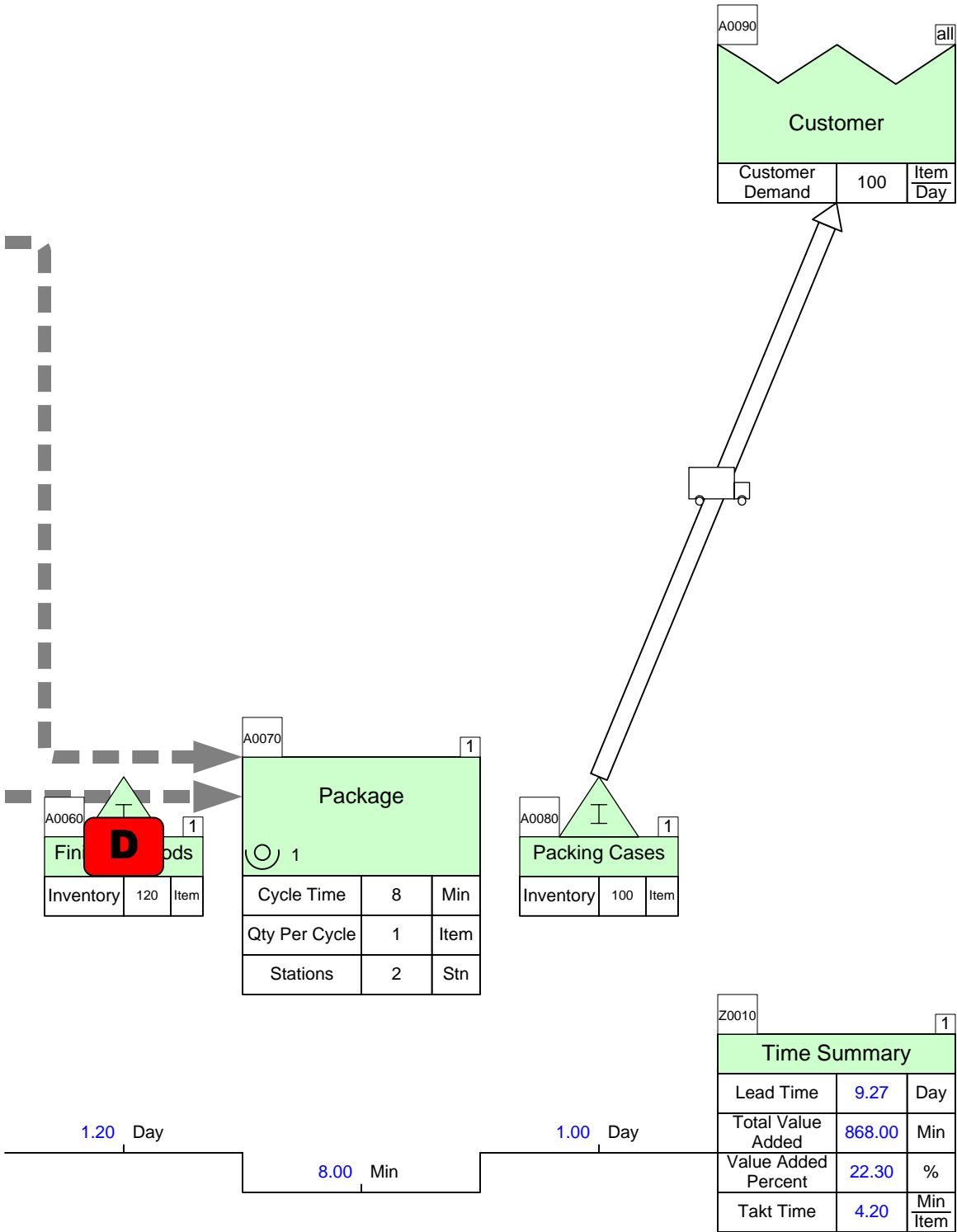
Open	Wall Map	Tag & Paths	Sequence ▾	Select Paths	Check	Show Seq.	Var Solve
List Variables	NUM	Auto Pipe ▾	Auto Path	Auto Tag	Show Pipes	Clear	Solve
Sketch		Sequence			Validate		Calculate

Quick Mfg LT



2.00 Day			20.00 Min			1.00 Day			840.00 Min		
shift	Wk	Wk									
7	5	5									
Hr	day	shift									

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn



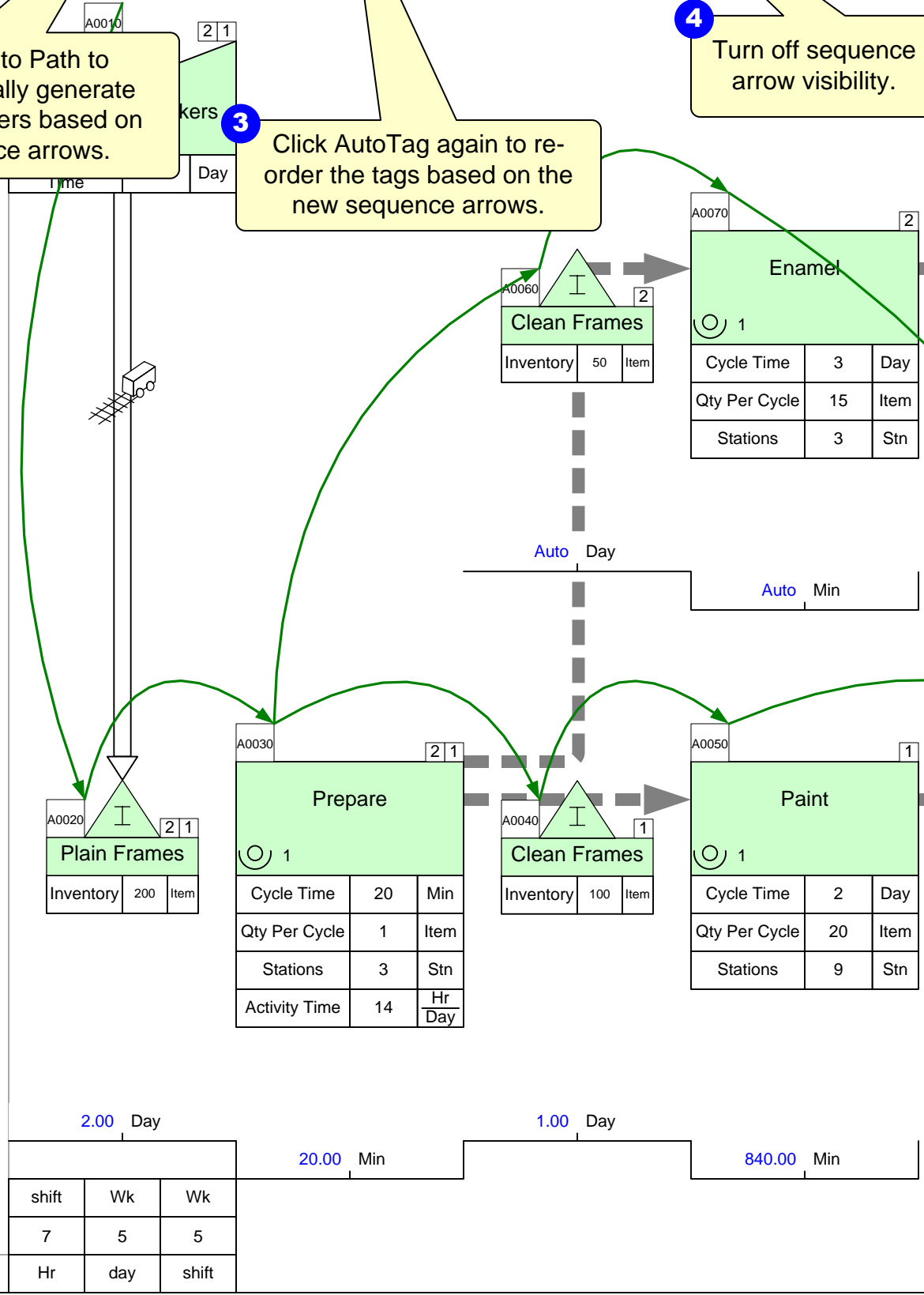
Step 16: Use Auto Path to Generate Path ID's based on Sequence Arrows

Open	Wall Map	Sequence	Select Paths	+	Show Seq.	✗	Var Solve
NUM	List Variables	Tag & Paths	Auto Pipe	Auto Tag	Show Pipes	✗	
Sketch		Auto Path			Validate	✗	Calculate

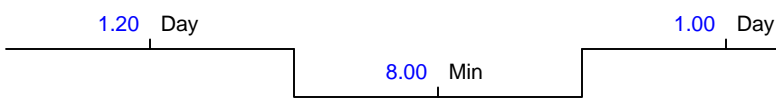
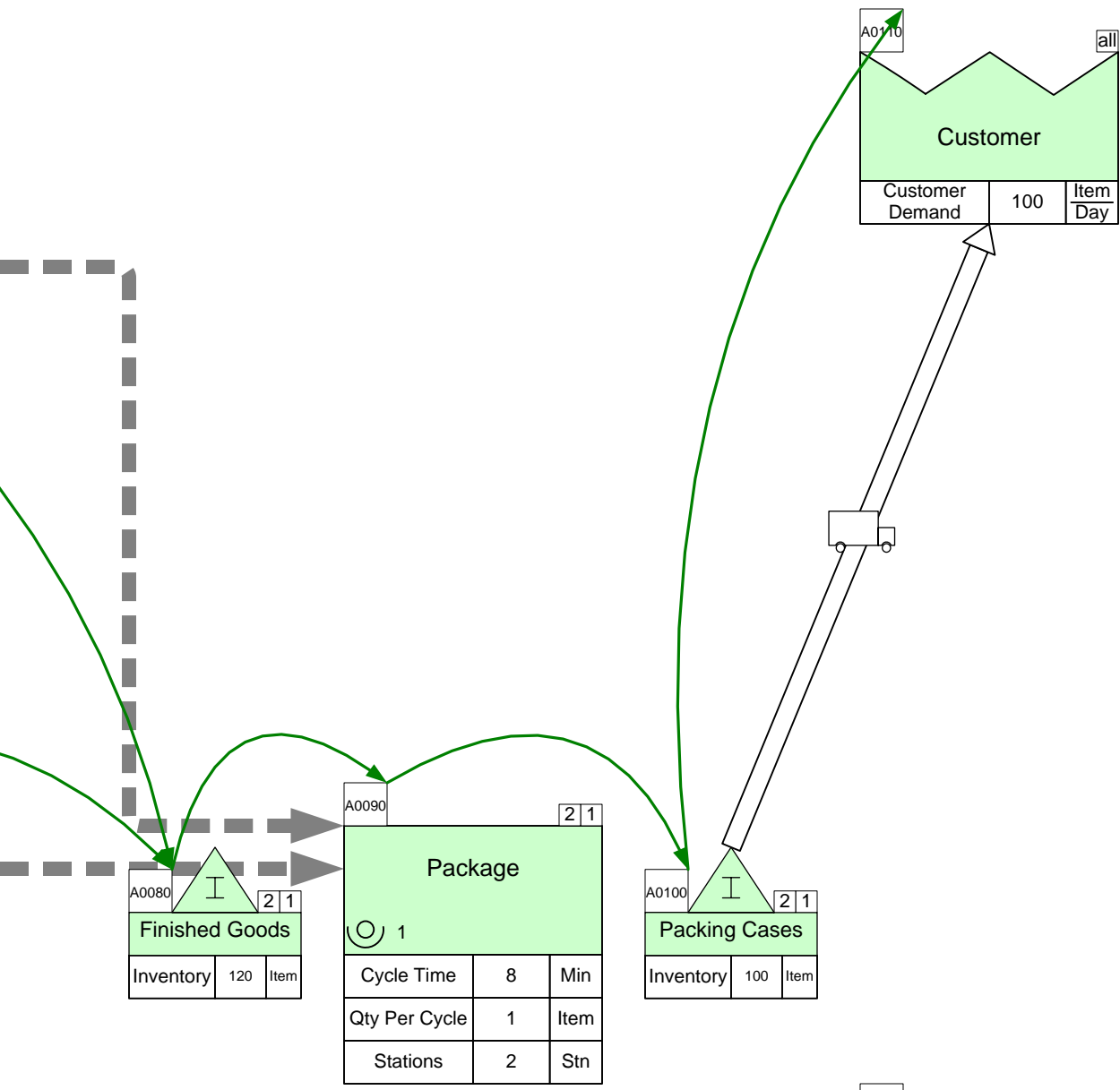
2 Click Auto Path to automatically generate Path numbers based on Sequence arrows.

3 Click AutoTag again to re-order the tags based on the new sequence arrows.

4 Turn off sequence arrow visibility.



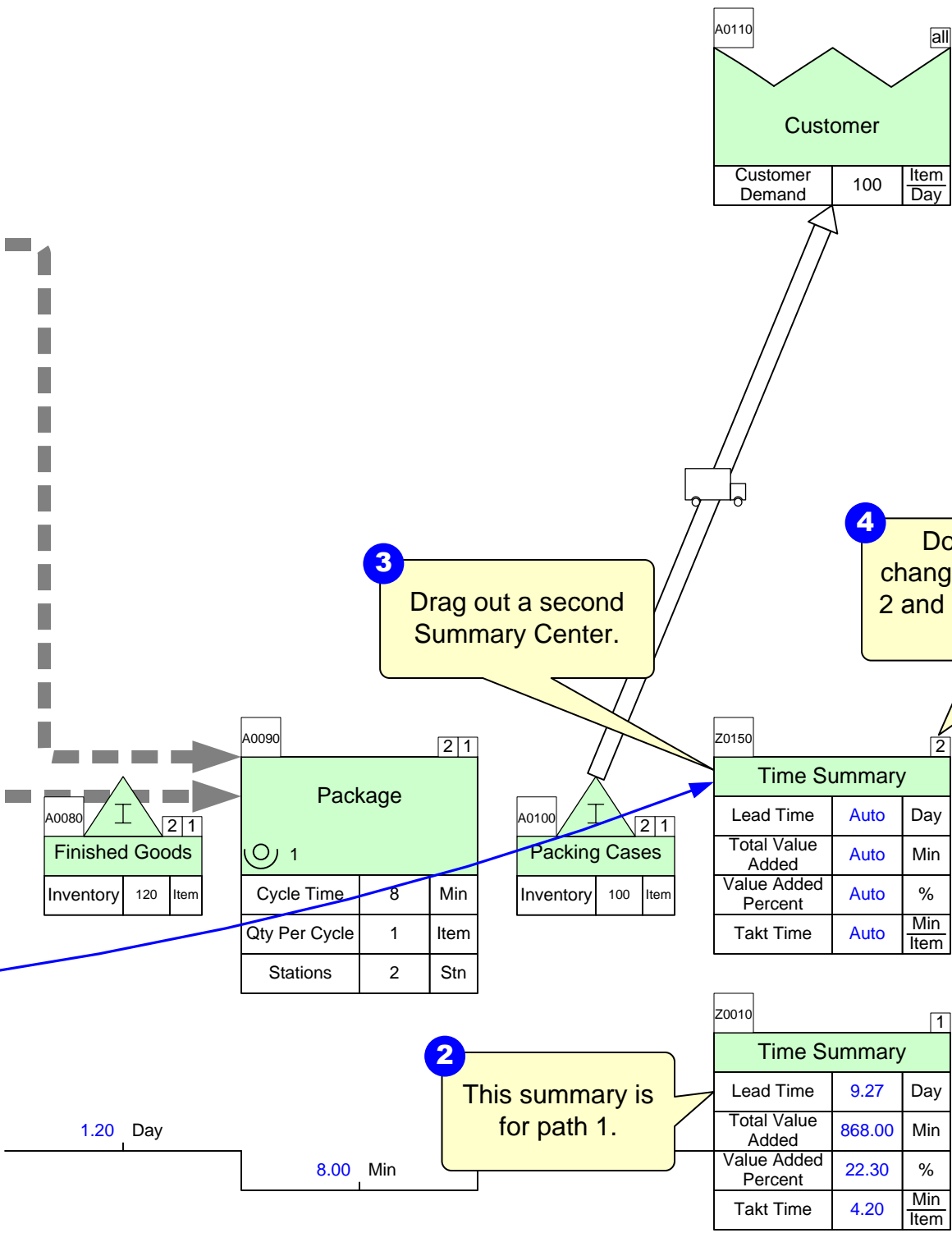
Views	Gadgets Update	Kaizen Properties	Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate	Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize			Improve		Extras		



20010			1
Time Summary			
Lead Time	9.27	Day	
Total Value Added	868.00	Min	
Value Added Percent	22.30	%	
Takt Time	4.20	Min	Item

A vertical toolbar on the right side of the screen containing various icons for navigation and editing, including arrows, a trash can, a question mark, and a truck.

Gadgets Views Visualize	Update	Kaizen Properties	Kaizen Export	Kaizen Import	Renumber Kaizens	Map Copy	A3 A3 Report	v7 Migrate	Spaghetti	Event Circle	Help	Icon Help	Icon Search	Stack Help	Learn
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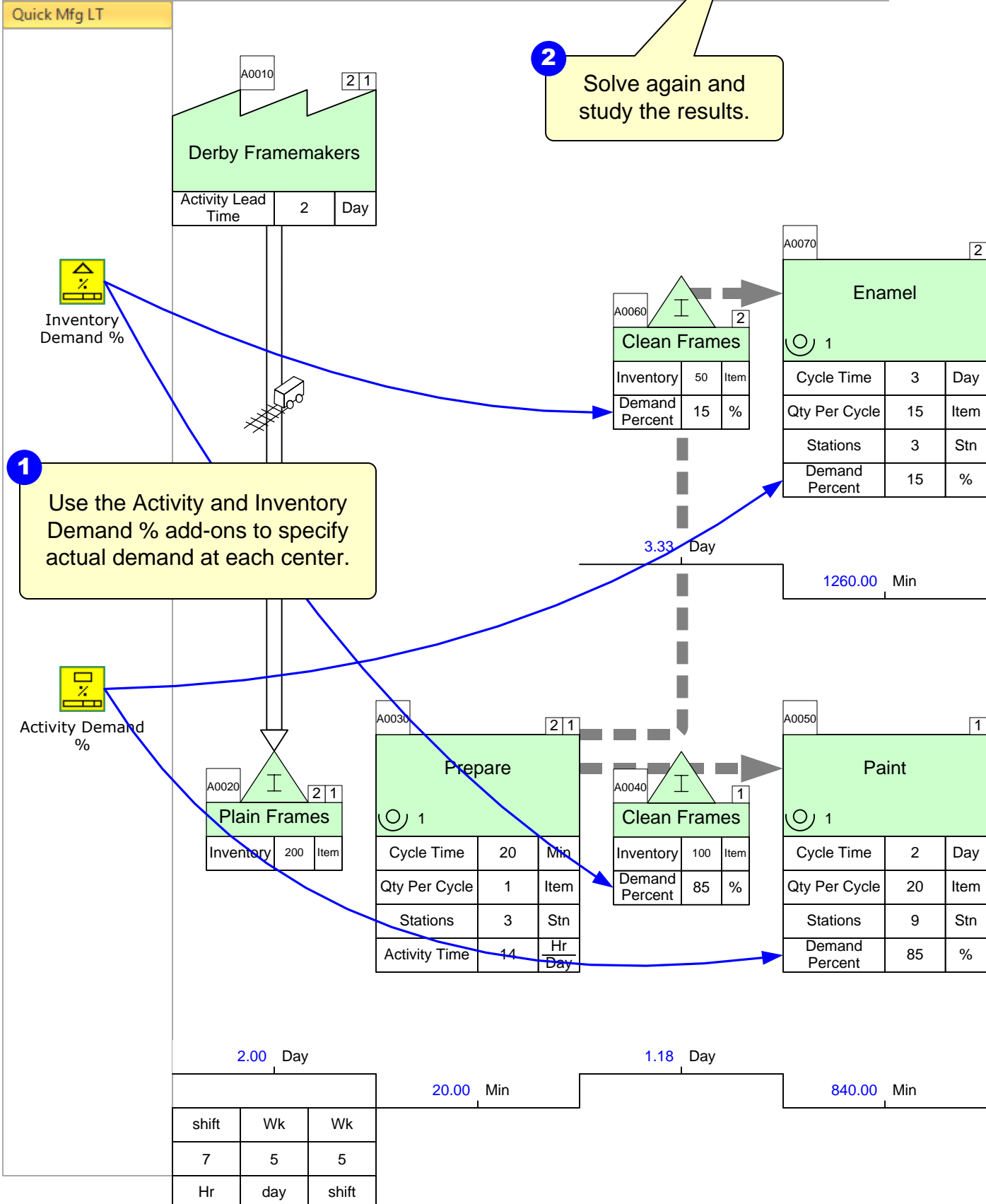
3 Drag out a second Summary Center.

4 Double-click to change this path ID to 2 and click the "Solve" button.

2 This summary is for path 1.

Step 18: Demand % for Each Path

Wall Map	Sequence ▾	Select Paths	Show Seq.	Solve	Var Solve
Open	Auto Pipe ▾	Auto Tag	Show Pipes	Check	Clear
List Variables	Tag & Paths	Auto Path	Validate	Calculate	
Sketch		Sequence		Calculate	



A0010	2	1
Derby Framemakers		
Activity Lead Time	2	Day

A0060	2
Clean Frames	
Inventory	50 Item
Demand Percent	15 %

A0070	2
Enamel	
1	
Cycle Time	3 Day
Qty Per Cycle	15 Item
Stations	3 Stn
Demand Percent	15 %

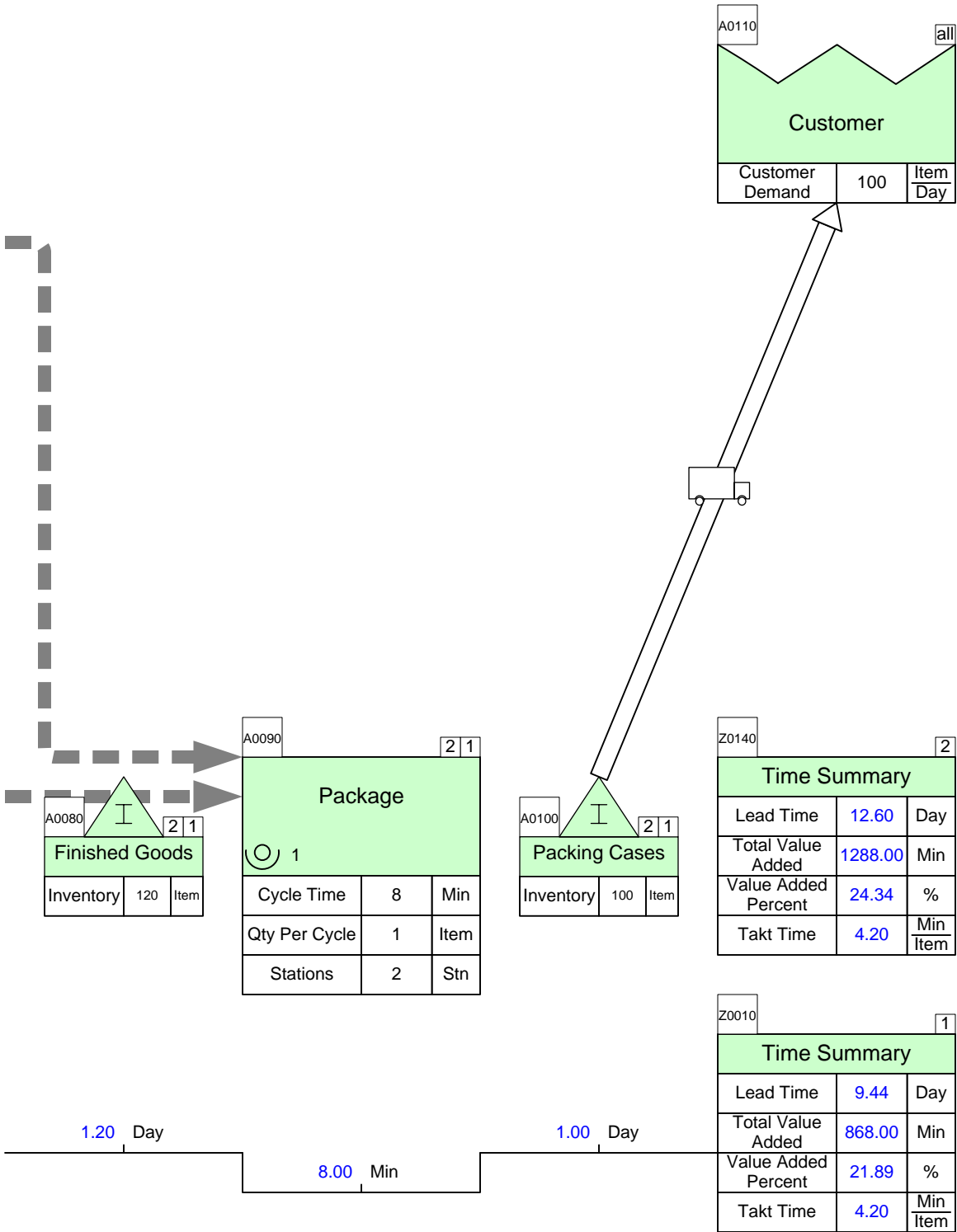
A0020	2	1
Plain Frames		
Inventory	200	Item

A0030	2	1
Prepare		
1		
Cycle Time	20 Min	
Qty Per Cycle	1 Item	
Stations	3 Stn	
Activity Time	44 Hr Day	

A0040	1
Clean Frames	
Inventory	100 Item
Demand Percent	85 %

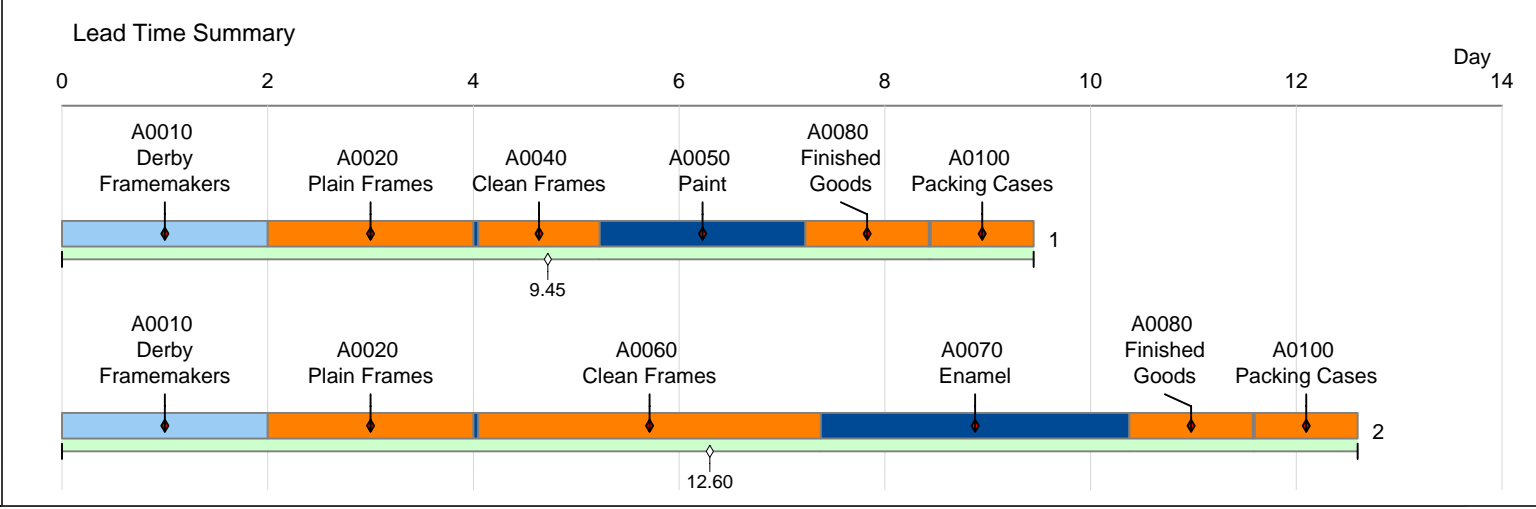
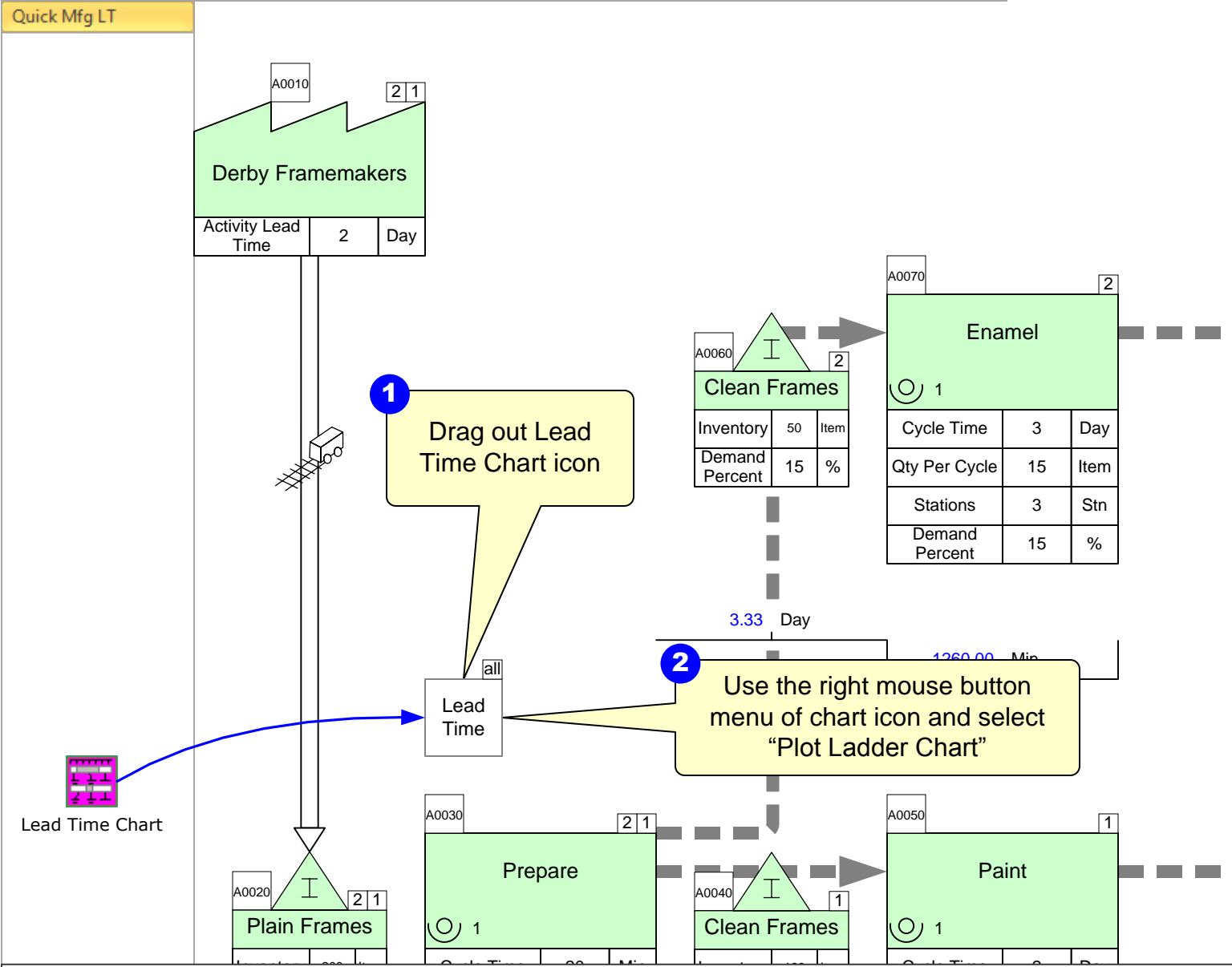
A0050	1
Paint	
1	
Cycle Time	2 Day
Qty Per Cycle	20 Item
Stations	9 Stn
Demand Percent	85 %

Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

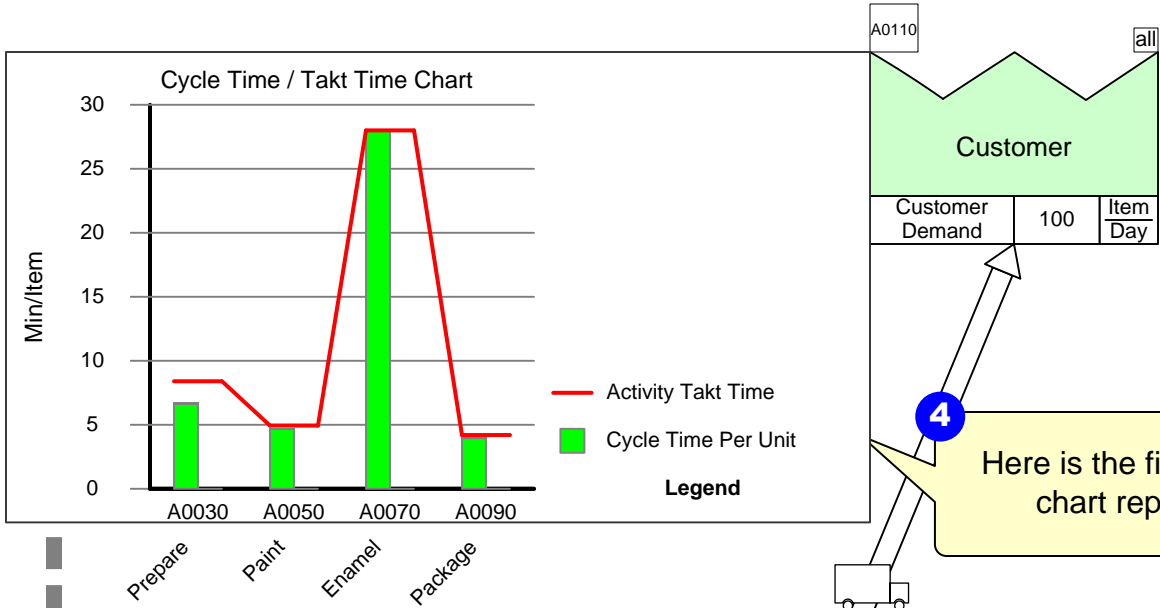


Step 19: Plot Lead Time Chart

Open	Wall Map	Sequence	Select Paths	Check	Show Seq.	Var Solve
List Variables	Tag & Paths	Auto Pipe	Auto Tag	Auto Path	Show Pipes	Solve
Sketch		Sequence		Validate		Calculate

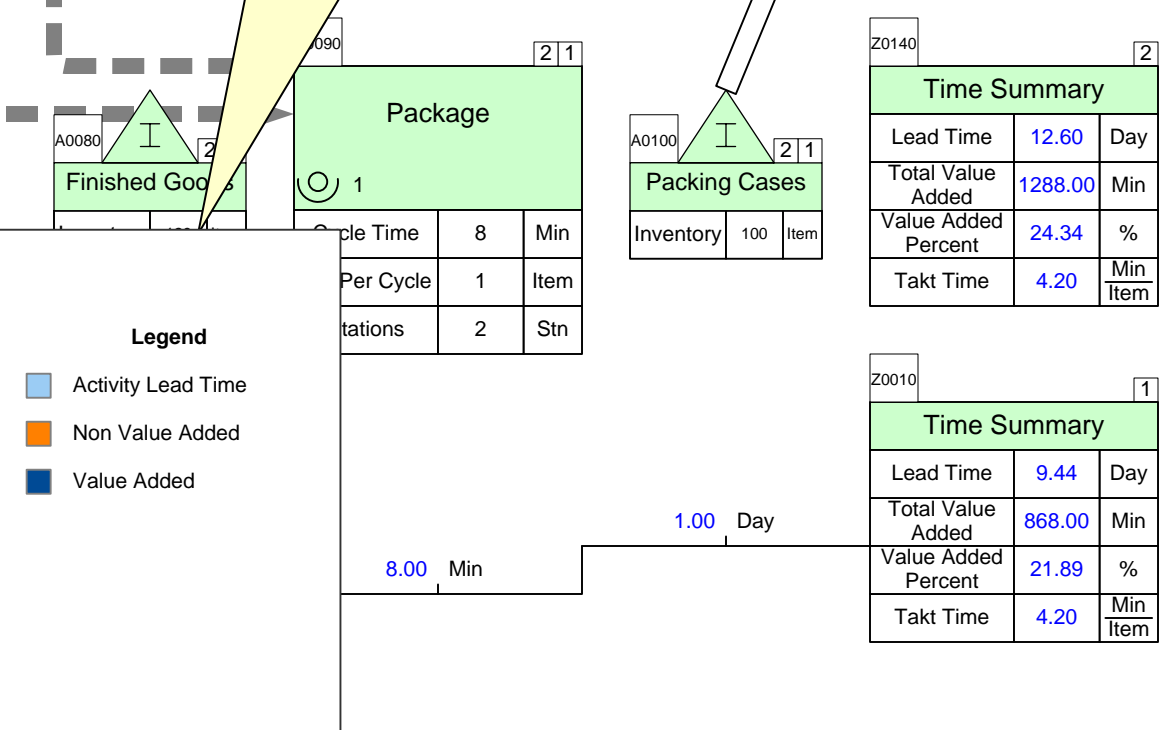


Views	Gadgets Update	Visualize	Kaizen Properties	Kaizen Export Kaizen Import Renumber Kaizens	Improve	Map Copy A3 A3 Report	Extras	v7 Migrate	Spaghetti Event Circle	Learn	Icon Help Icon Search Stack Help
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4 Here is the final CT/TT chart replotted.

3 Here is the Lead Time chart showing the two paths.



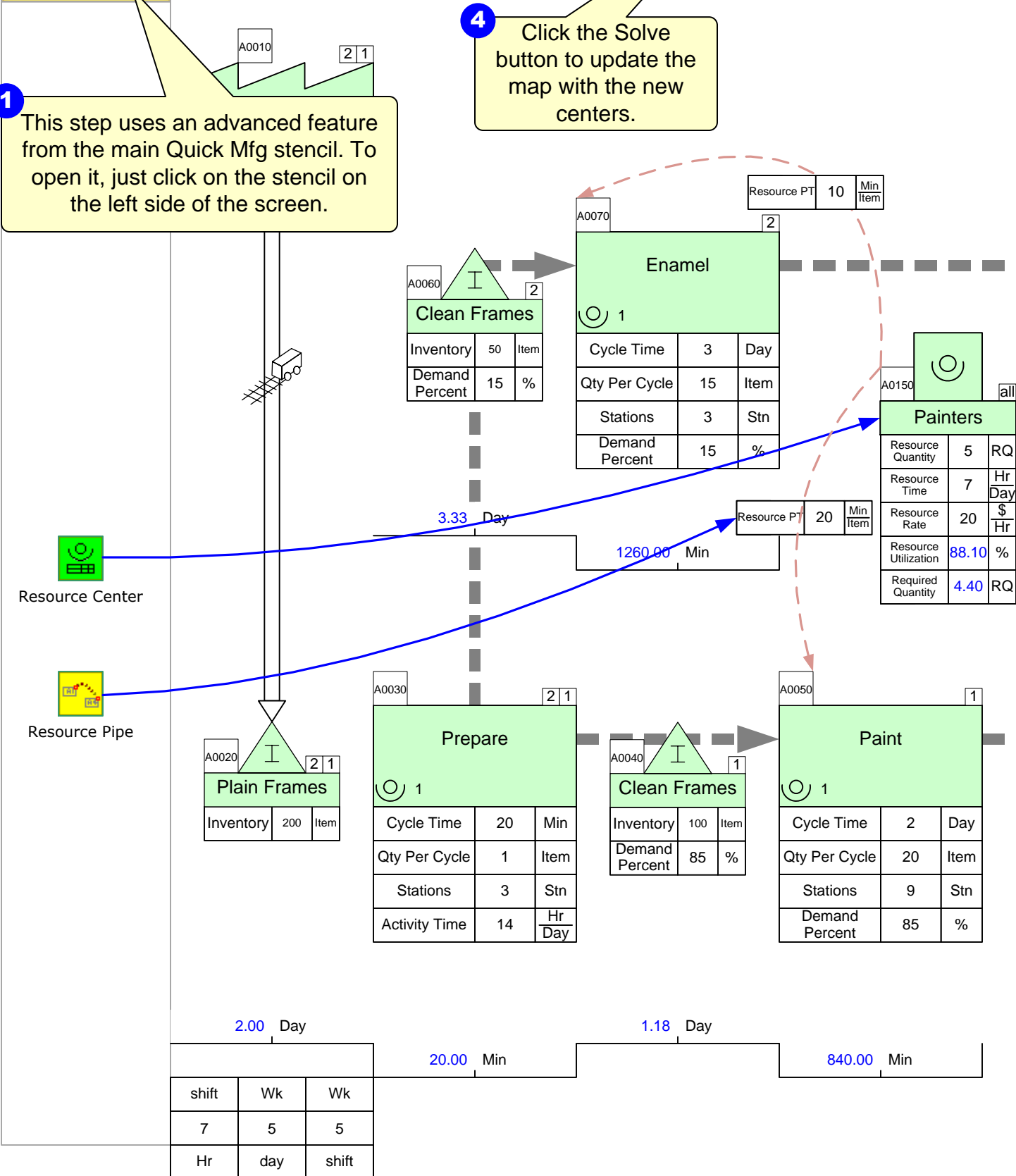
Step 20: Add Resource Center

	Wall Map		Sequence		Select Paths		Show Seq.		Var Solve
	Open		Tag & Paths		Auto Pipe		Show Pipes		Solve
	List Variables		Auto Path		Auto Tag		Clear		Calculate
Sketch			Sequence			Validate		Calculate	

Quick Mfg

1 This step uses an advanced feature from the main Quick Mfg stencil. To open it, just click on the stencil on the left side of the screen.

4 Click the Solve button to update the map with the new centers.



Views	Gadgets Update	Kaizen Properties Kaizen Export Kaizen Import Renumber Kaizens	Map Copy A3 A3 Report	v7 Migrate Spaghetti Event Circle	Help Icon Help Icon Search Stack Help Learn
Visualize		Improve		Extras	Learn

2 Drag out the Resource Center from the Quick Mfg stencil and enter the values.

A0160 all		
Packers		
Resource Quantity	3	RQ
Resource Time	6	Hr Day
Resource Rate	10	\$ Hr
Resource Utilization	74.07	%
Required Quantity	2.22	RQ

Resource PT	8	Min Item
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3 Drag out the Resource Pipe from the Quick Mfg stencil and glue the ends to the Operation Tags.

A0080 2 1		
Finished Goods		
Inventory	120	Item

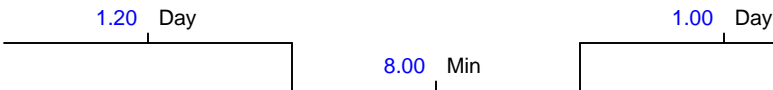
A0090 1		
Package		
Cycle Time	8	Min
Qty Per Cycle	1	Item
Stations	2	Stn

A0100 2 1		
Packing Cases		
Inventory	100	Item

A0110 all		
Customer		
Customer Demand	100	Item Day

Z0140 2		
Time Summary		
Lead Time	12.60	Day
Total Value Added	1288.00	Min
Value Added Percent	24.34	%
Takt Time	4.20	Min Item

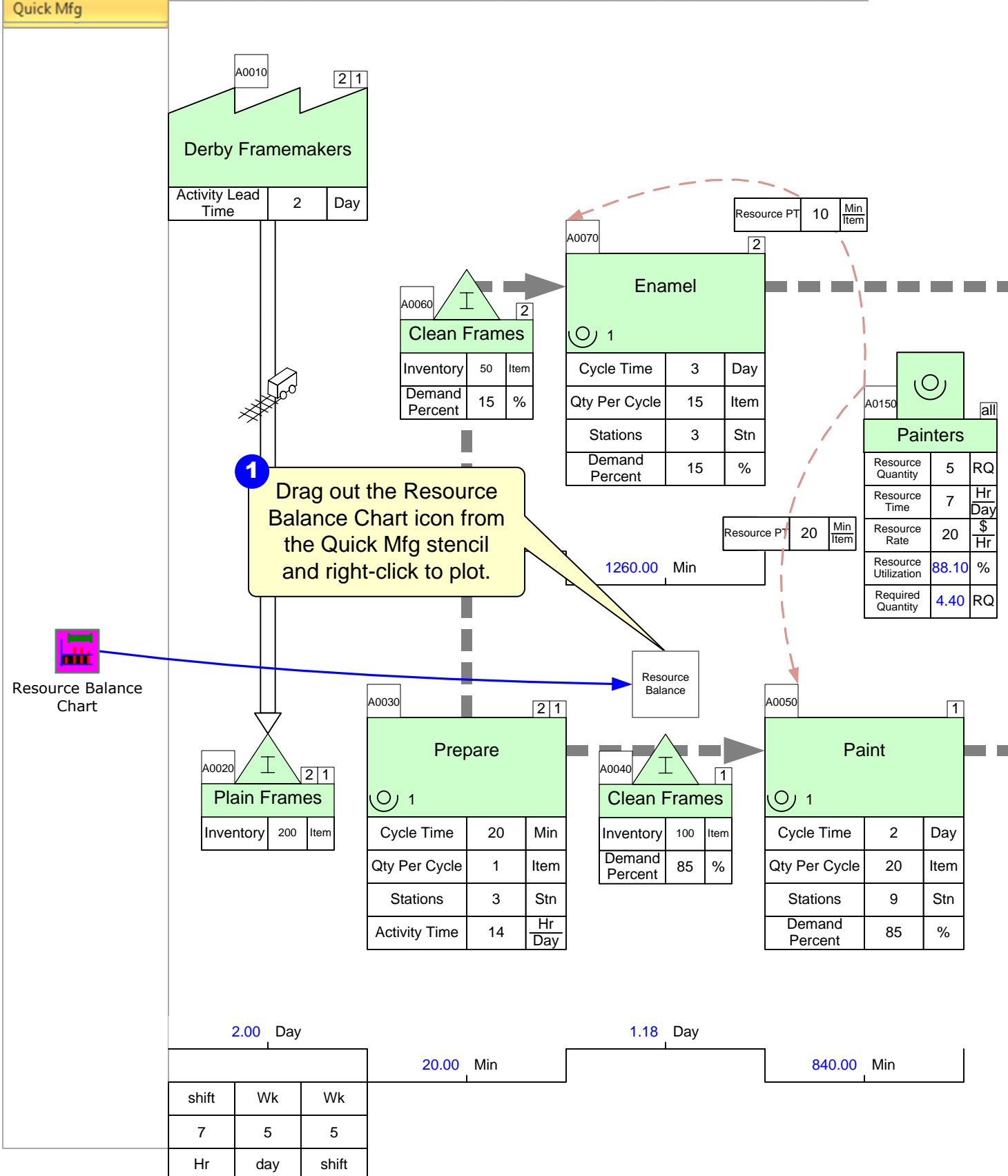
Z0010 1		
Time Summary		
Lead Time	9.44	Day
Total Value Added	868.00	Min
Value Added Percent	21.89	%
Takt Time	4.20	Min Item



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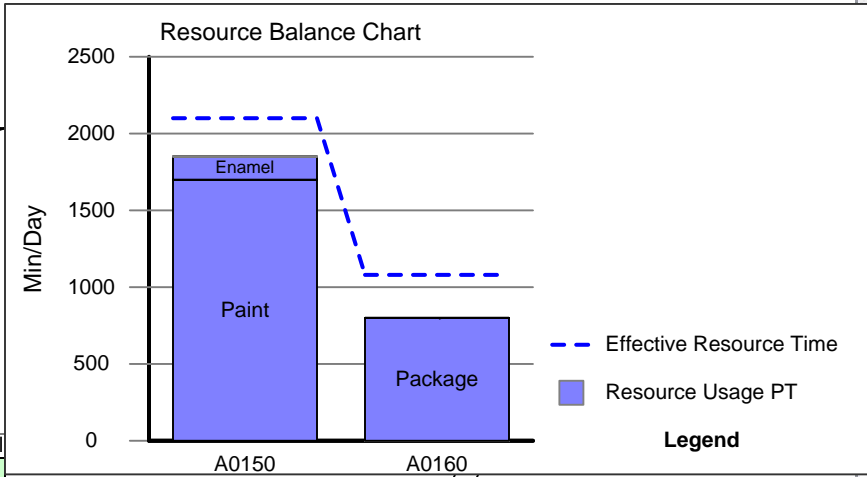
Step 21: Add Resource Balance Chart

Wall Map	Sequence ▾	Select Paths	Show Seq.	Var Solve
Open	Auto Pipe ▾	Auto Tag	Show Pipes	Solve
List Variables	Tag & Paths	Auto Path	Clear	Calculate
Sketch		Sequence		Validate



Views	Gadgets	Kaizen Properties	Kaizen Export	Kaizen Import	Renumbr Kaizens	Map Copy	A3 A3 Report	v7 Migrate	Spaghetti	Event Circle	Help	Icon Help	Icon Search	Stack Help	Learn
Visualize	Update		Improve					Extras							

2 Here is the chart plotted



Packers		
Resource Quantity	3	RQ
Resource Time	6	Hr Day
Resource Rate	10	\$ Hr
Resource Utilization	74.07	%
Required Quantity	2.22	RQ

Resource PT	8	Min Item
-------------	---	----------

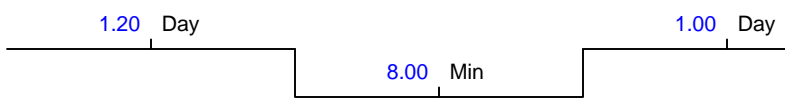
Finished Goods		
Inventory	120	Item

Package		
Cycle Time	8	Min
Qty Per Cycle	1	Item
Stations	2	Stn

Packing Cases		
Inventory	100	Item

Time Summary		
Lead Time	12.60	Day
Total Value Added	1288.00	Min
Value Added Percent	24.34	%
Takt Time	4.20	Min Item

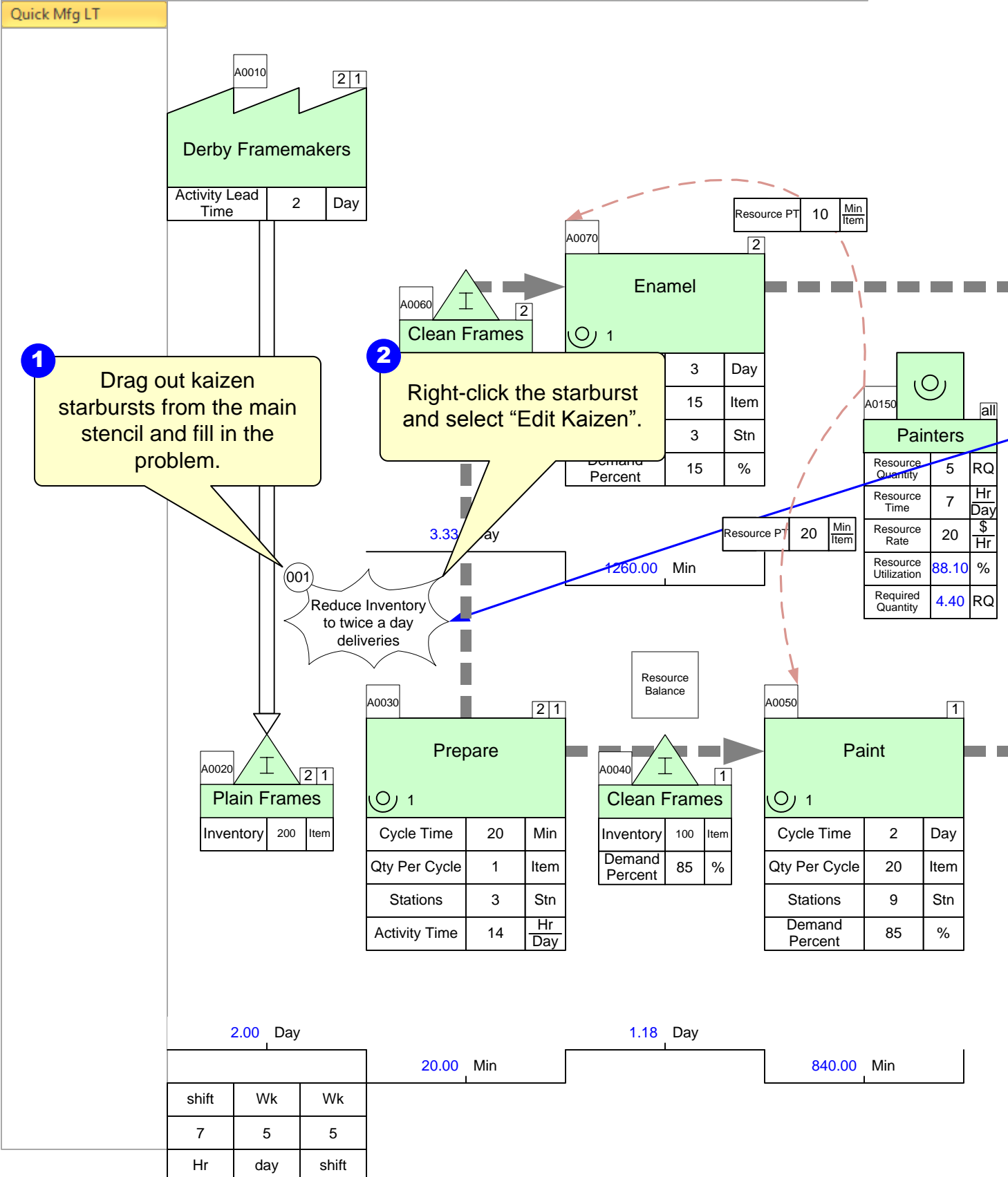
Time Summary		
Lead Time	9.44	Day
Total Value Added	868.00	Min
Value Added Percent	21.89	%
Takt Time	4.20	Min Item



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Step 22: Add Kaizens

Open Wall Map NUM List Variables Sketch	Tag & Paths Auto Pipe Auto Path Sequence	Select Paths Auto Tag Check Validate	Show Seq. Show Pipes Clear Calculate	Var Solve Solve
---	---	---	---	--------------------



A0010	2	1
Derby Framemakers		
Activity Lead Time	2	Day

A0060	2
Clean Frames	

A0070	2	
Enamel		
Resource PT	10	Min Item
Cycle Time	3	Day
Qty Per Cycle	15	Item
Stations	3	Stn
Demand Percent	15	%

A0150	all	
Painters		
Resource Quantity	5	RQ
Resource Time	7	Hr Day
Resource Rate	20	\$ Hr
Resource Utilization	88.10	%
Required Quantity	4.40	RQ

A0020	2	1
Plain Frames		
Inventory	200	Item

A0030	2	1
Prepare		
Cycle Time	20	Min
Qty Per Cycle	1	Item
Stations	3	Stn
Activity Time	14	Hr Day

A0040	1	
Clean Frames		
Inventory	100	Item
Demand Percent	85	%

A0050	1	
Paint		
Cycle Time	2	Day
Qty Per Cycle	20	Item
Stations	9	Stn
Demand Percent	85	%

Edit Kaizen Properties

001 - Reduce Inventory to twice a day deliveries

Description
Problem Description

Comments

Finances
Estimated One Time Savings
Estimated Annual Savings

Priority
Impact: 2
Ease of Implementation: 4
Priority

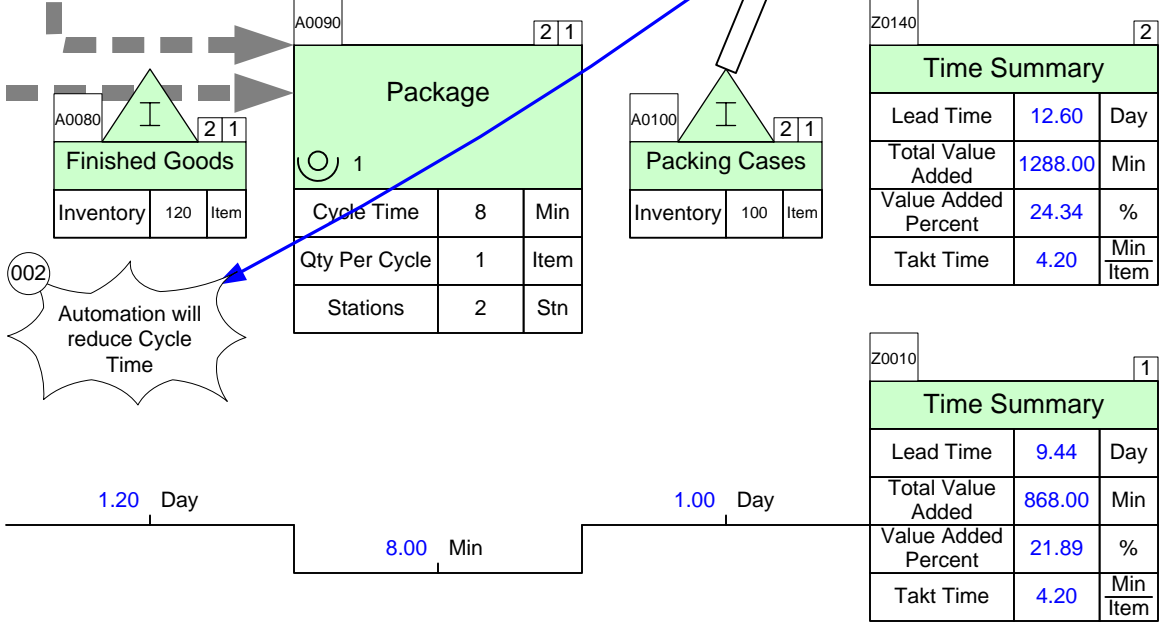
Impact: What impact this project will have on the Value Stream. 1 = Low, 5 = High

Cancel OK

3 Enter the impact and ease of implementation for each starburst.

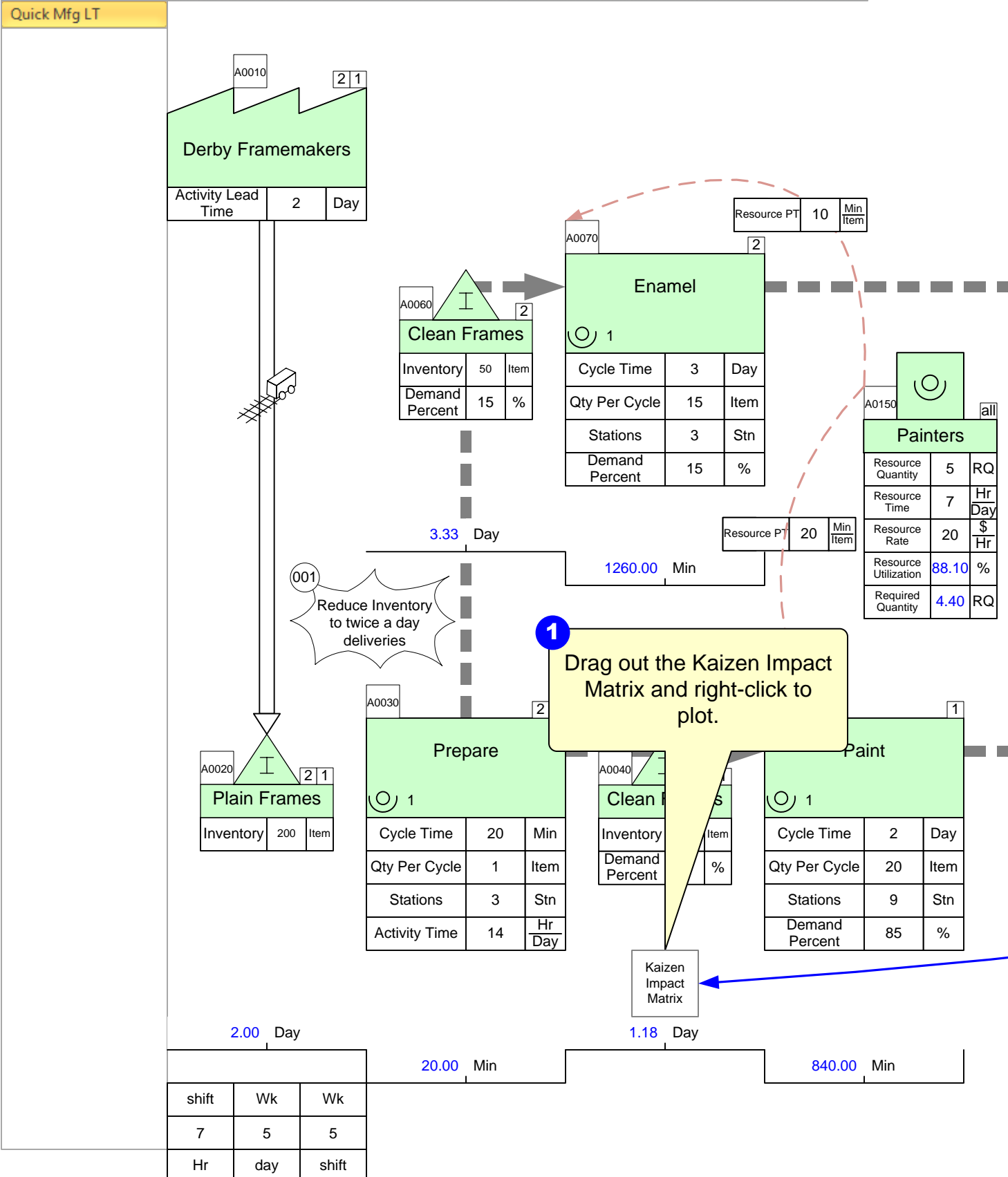
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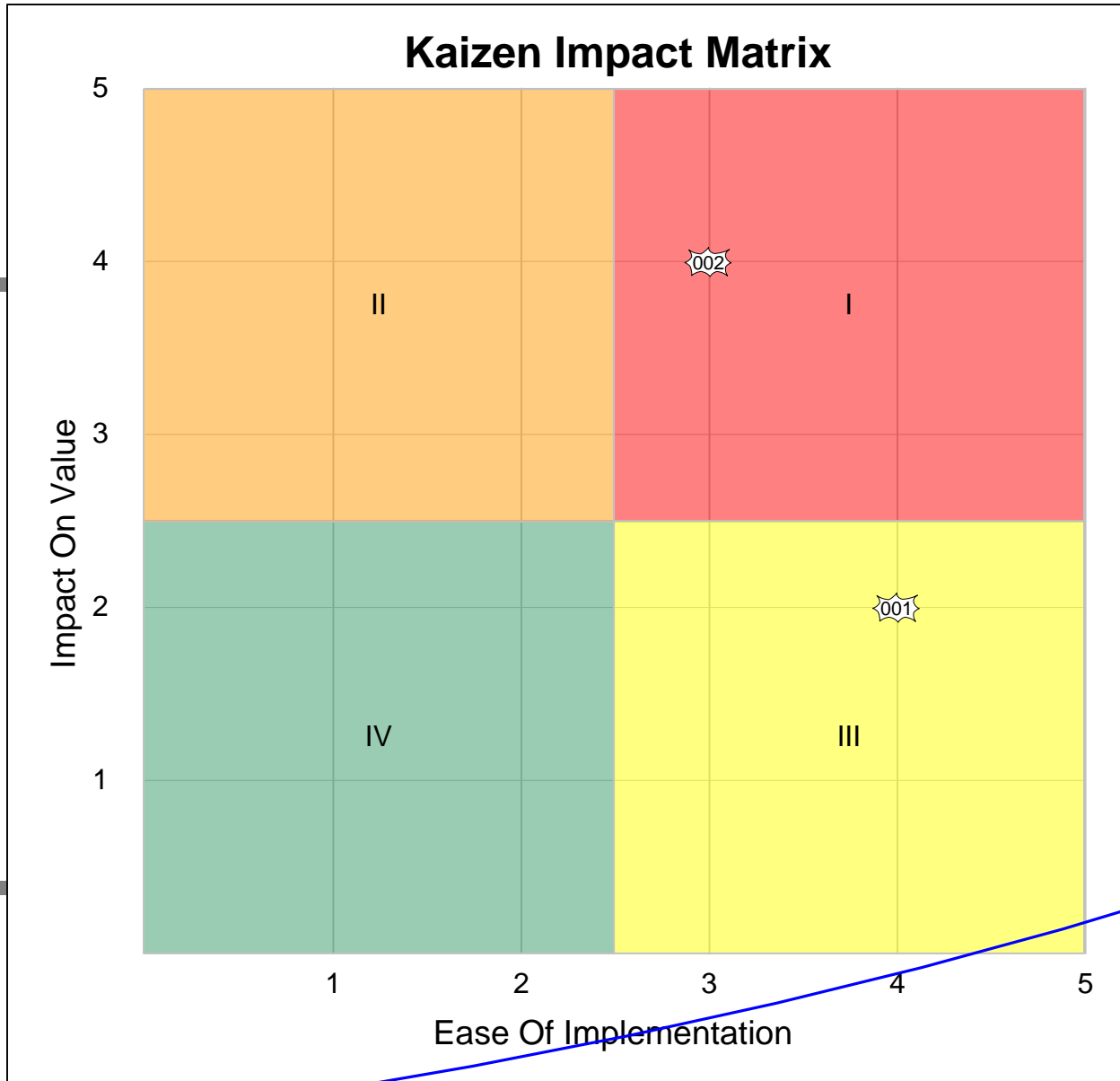
Step 23: Plot the Kaizen Impact Matrix

Wall Map	Sequence ▾	Select Paths	Show Seq.	Var Solve
Open	Auto Pipe ▾	Auto Tag	Show Pipes	Solve
List Variables	Tag & Paths	Auto Path	Clear	Calculate
Sketch	Sequence	Validate		

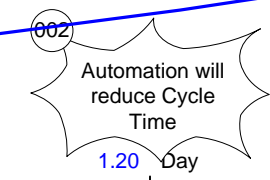


Views Visualize Gadgets Update Kaizen Properties Improve Kaizen Export Kaizen Import Renumbr Kaizens Map Copy v7 Spaghetti ? iQ Icon Help Icon Search Stack Help Learn

3 To generate a Kaizen report in Excel, click the Kaizen Export button in the toolbar.



Vertical toolbar with icons for various functions including a 'KAIZEN KEY' icon.



(001) Reduce Inventory to twice a day deliveries
(002) Automation will reduce Cycle Time

2 Drag out the Kaizen Key Creator.