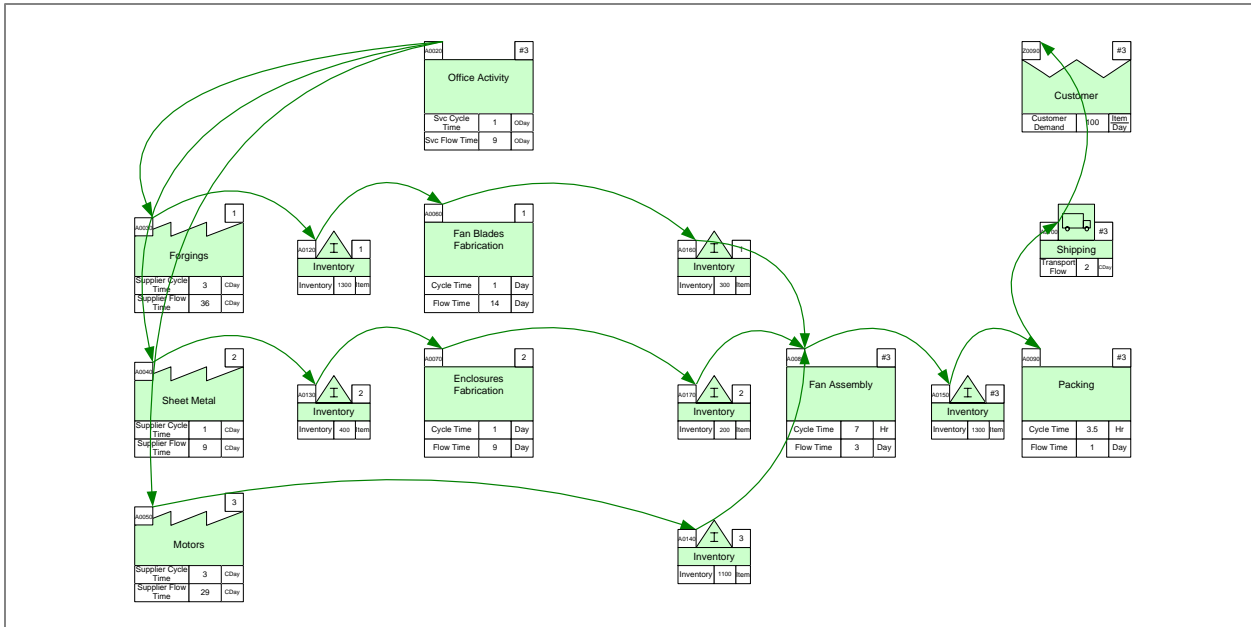


Quick MCT Tutorial

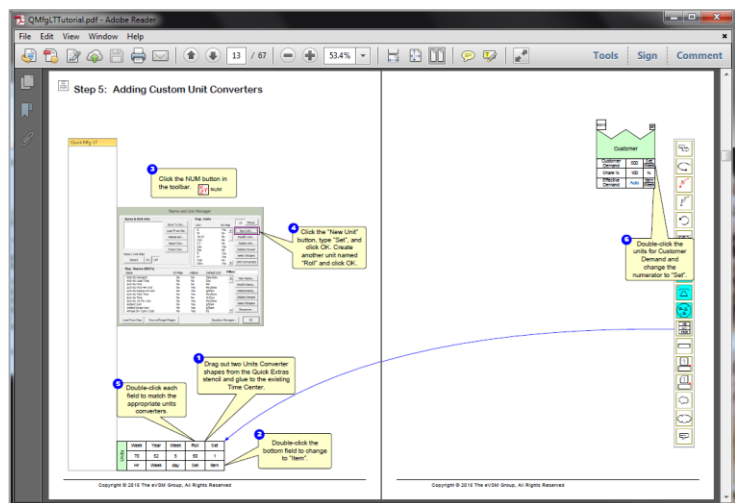
This tutorial will guide you through the steps to draw a simple map, perform common calculations, and plot charts using the Quick MCT stencil.



Viewing/printing eVSM Tutorial:

This tutorial is designed for two page layout. If printing, you will need double-sided print.

For on-screen viewing, save the PDF file to your PC and then open it in Acrobat Reader (not in a web browser). In the Acrobat menus, click “View>Page Display”, make sure “Show Cover Page in Two Page View” is checked and then select “Two Page View”.



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

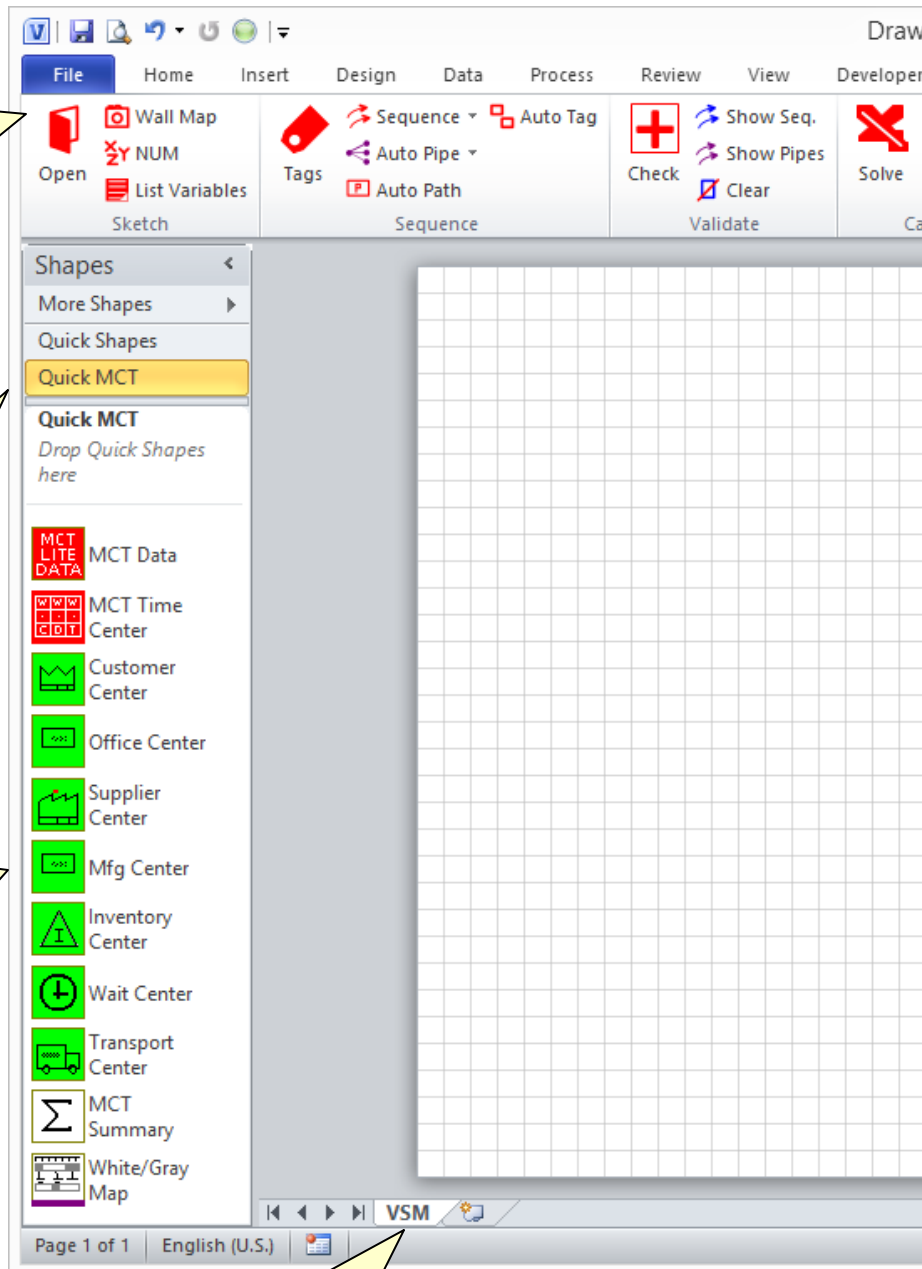
This area intentionally left blank

Step 2: Explore the eVSM Environment

A new map is initiated by selecting your application area from the "Open" button. Only the stencils required for your selected application area will open on the left side.

The left hand side has the Quick eVSM stencils which are optimized for specific application areas such as manufacturing vs office vs healthcare.

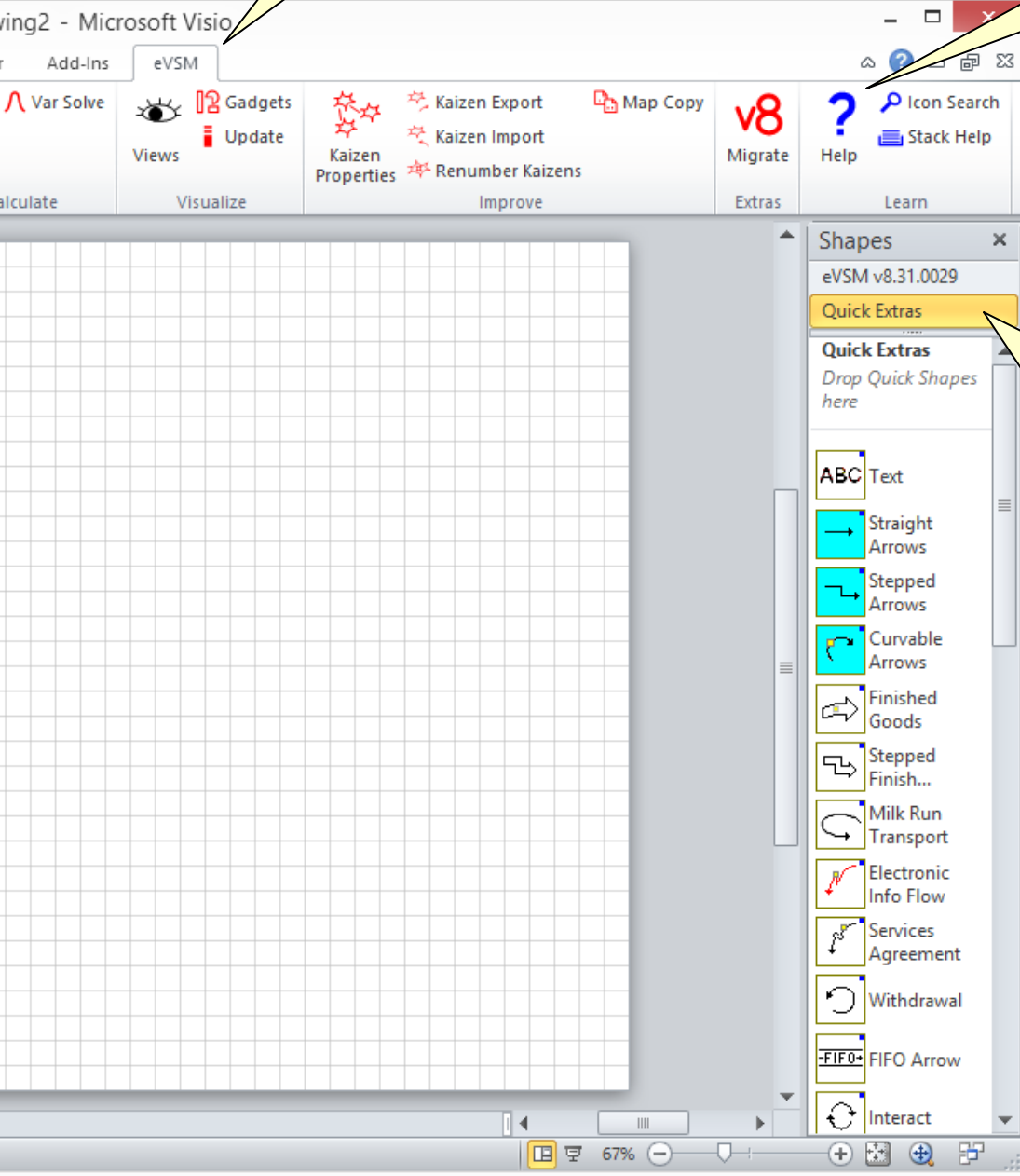
The Quick stencils contain macro shapes which are often collections of individual eVSM shapes with pre-built names, units, equations, and other properties.



A Visio file can have multiple pages which are accessed with these tabs. Each page gets locked to a chosen eVSM application and then not be used for other applications.

eVSM adds this toolbar to Visio as well as the stencils on the left and right. If the eVSM toolbar disconnects, click File>Save As and save the file, close the file, then re-open it. This tip can be used for other crashes in eVSM.

Hover over each button in the eVSM Toolbar to learn what it does. Detailed help and tutorials are available at the eVSM help site which can be accessed via this button.



The right side has two stencils. The main eVSM stencil, showing the eVSM version number, and the eVSM Extras stencil which is just a subset of the main stencil to help new users.

Step 3: Learn Visio Basics

Quick MCT

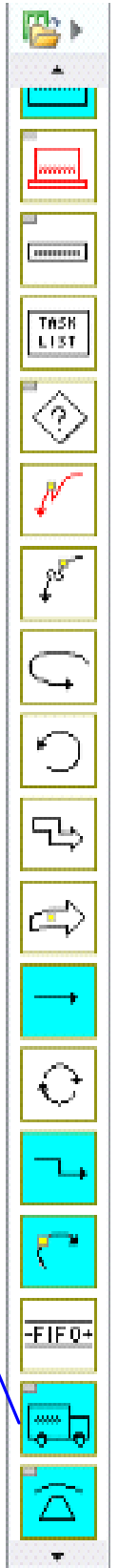
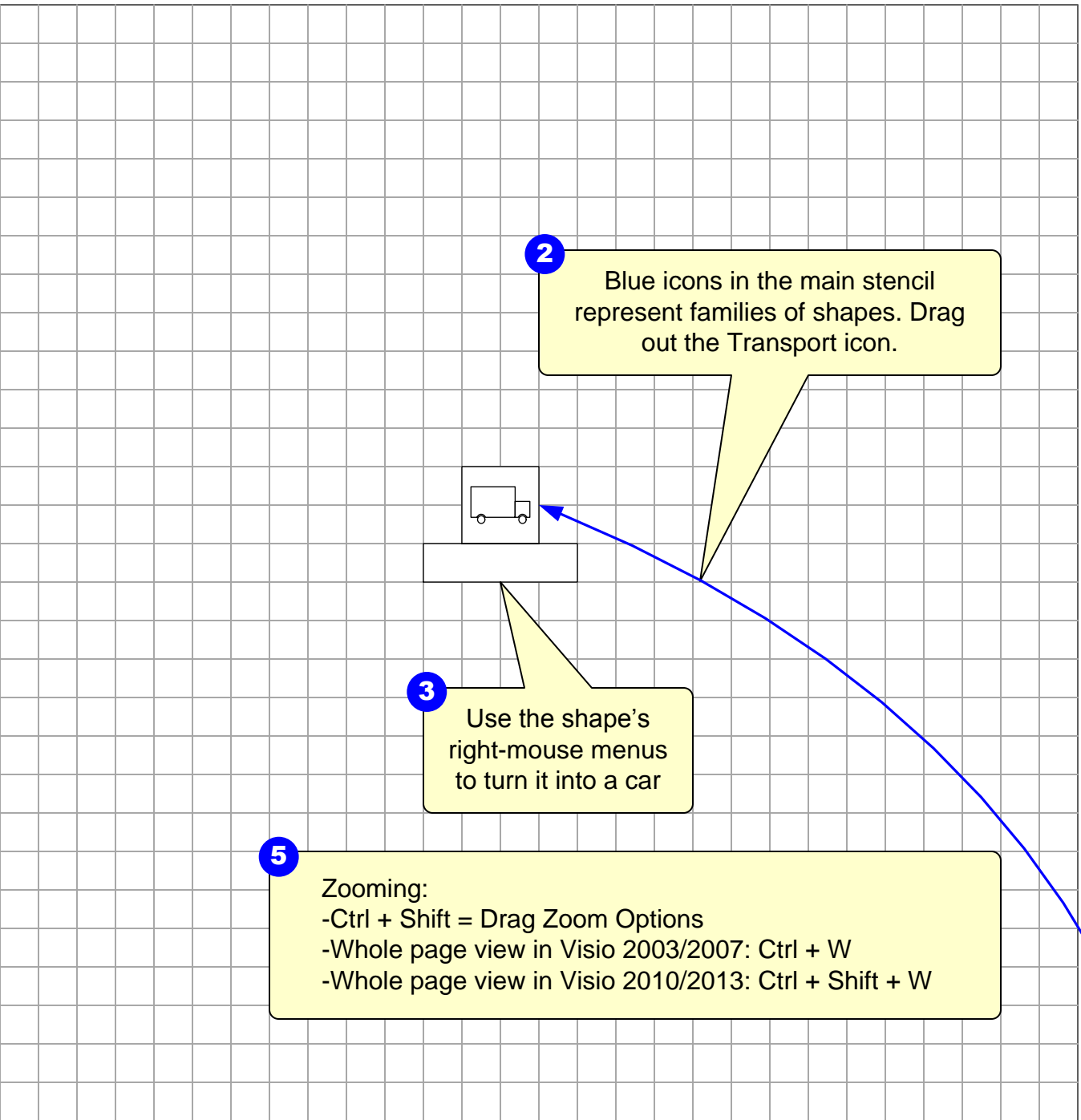
1 Avoid re-sizing eVSM shapes. Instead grow the drawing page when needed. To resize the page, hold down the “Ctrl” key, and then drag any page edge to the required size. This method works on all four edges of the page.



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

VSM

Quick_eVSM



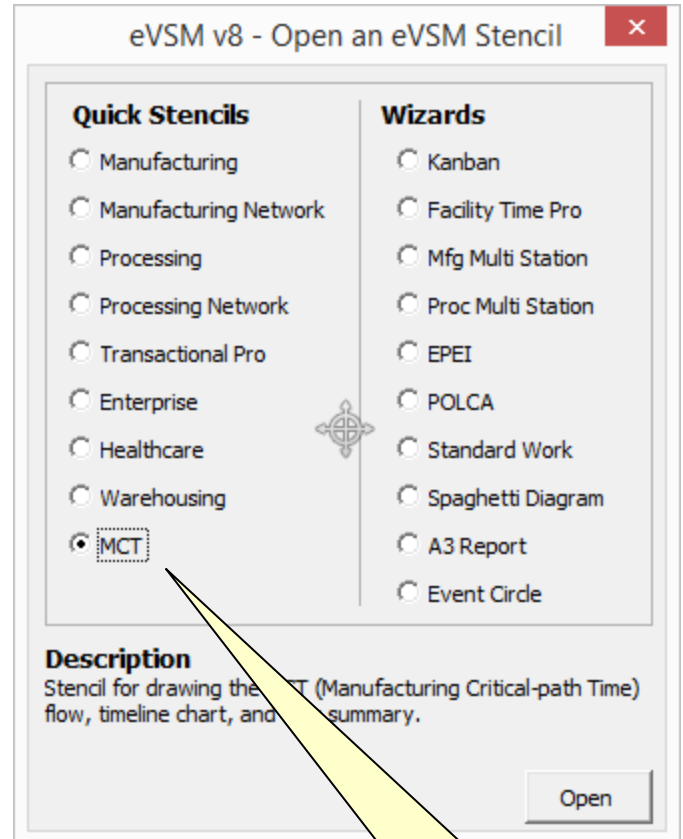
Step 4: Open the Quick MCT Stencil

1

Click the  Open button in the eVSM toolbar.

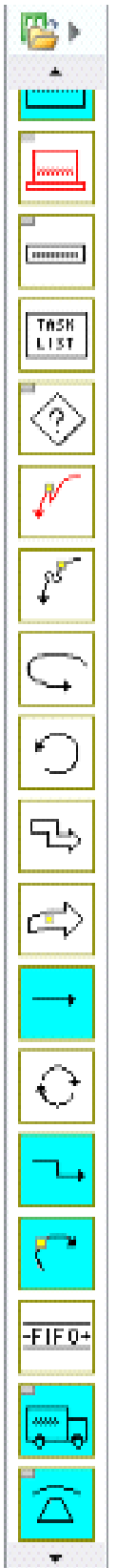
3

The Quick MCT stencil will open on the left.



2

Select MCT, and click Open.



Step 5: Initiate the map for Quick MCT Simple

Quick MCT

MCT LITE DATA
MCT Data

MCT Time Center

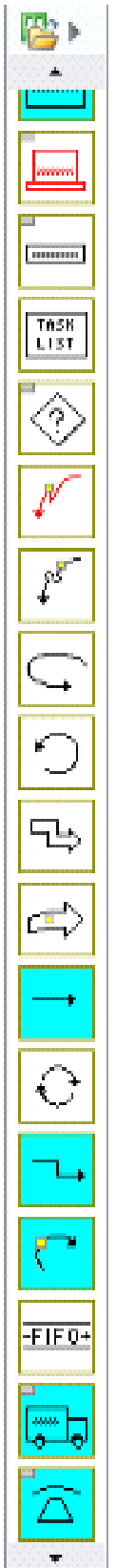
1 Drag out the two red icons first. This is very important!

3 The Units center allows you to specify the work hours.

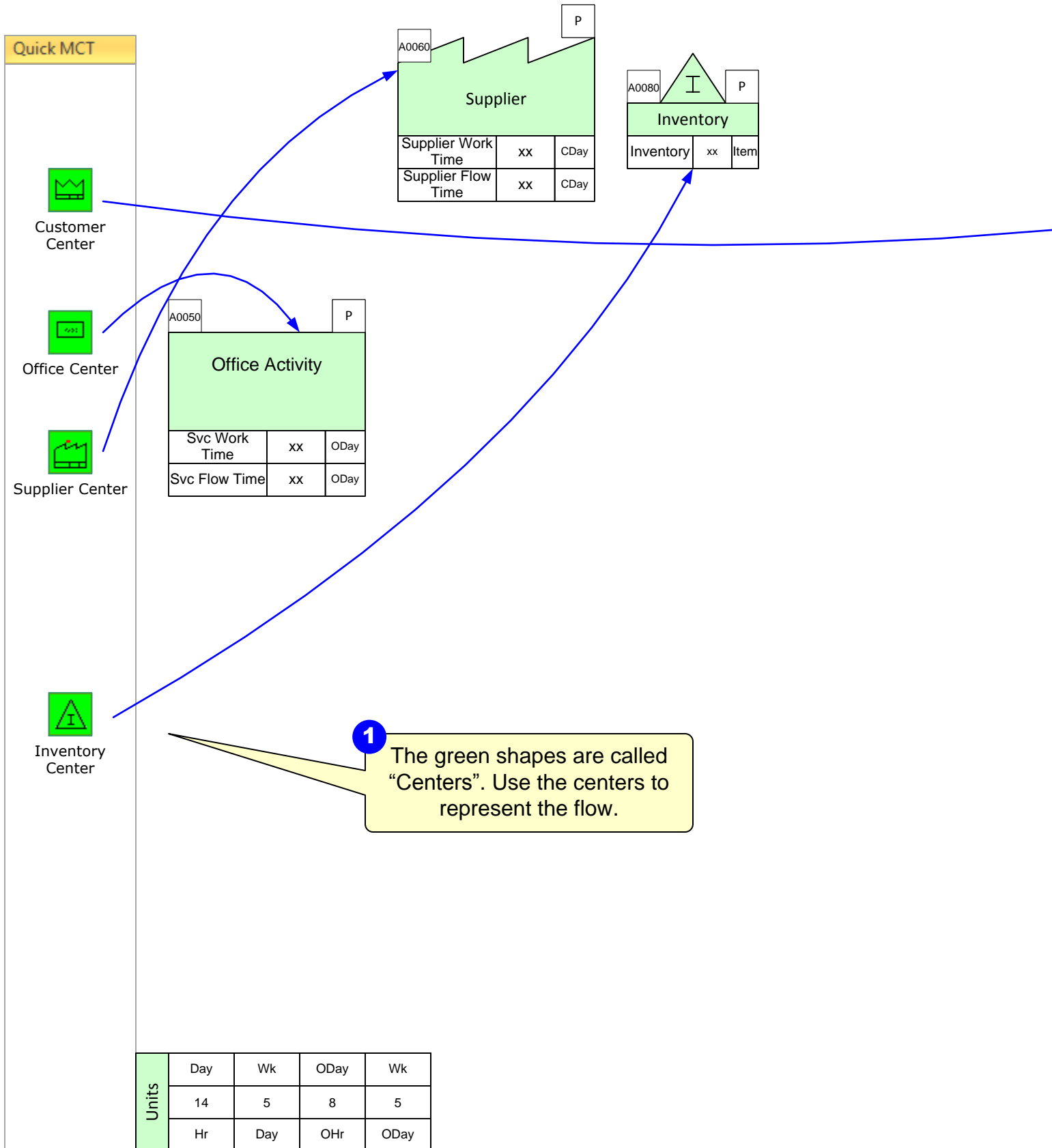
CHr = Calendar Hours
OHr = Office Hours
Hr = Production Hours

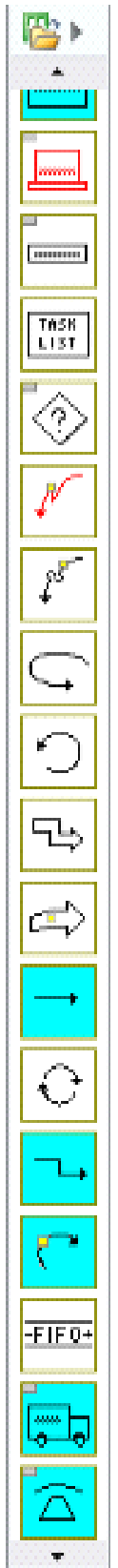
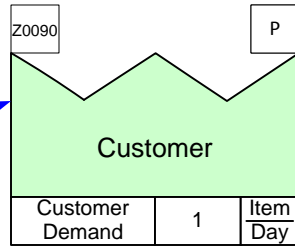
2 Align all new shapes to the grid as you drop them.

eVSM Data QuickMCT #25.0000.1 2	Day	Wk	ODay	Wk
Units	14	5	8	5
	Hr	Day	OHr	ODay



Step 6: Start Drawing the Flow





Step 7: Complete Drawing the Flow

Quick MCT



Customer Center



Office Center



Supplier Center



Mfg Center



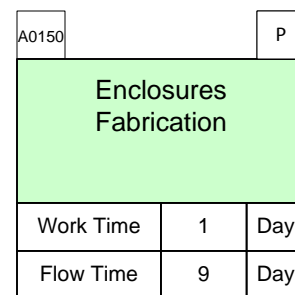
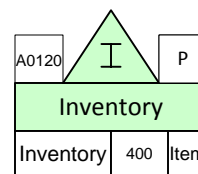
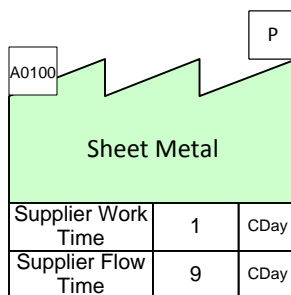
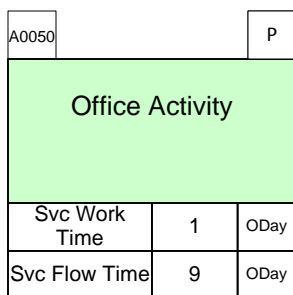
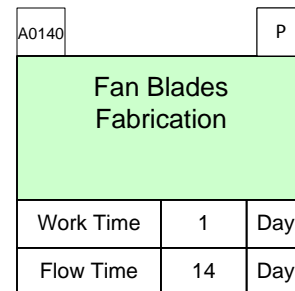
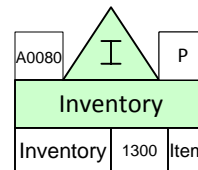
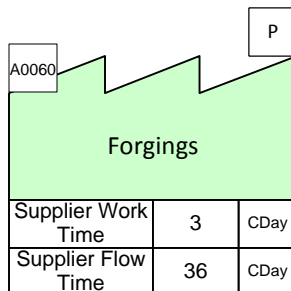
Inventory Center



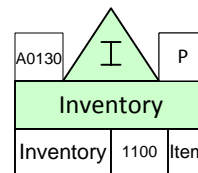
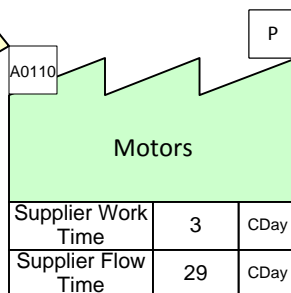
Wait Center



Transport Center



4 Do not worry about matching these Operation Tag numbers. They will get regenerated automatically later



Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	OHr	ODay

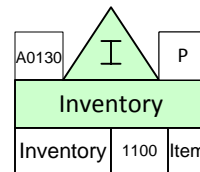
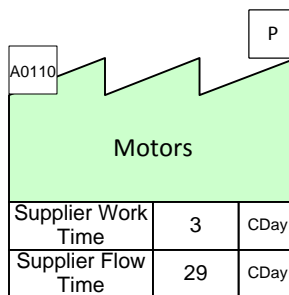
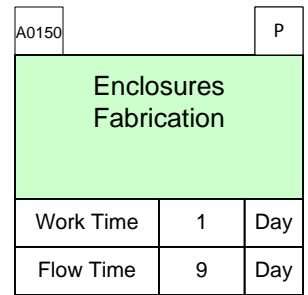
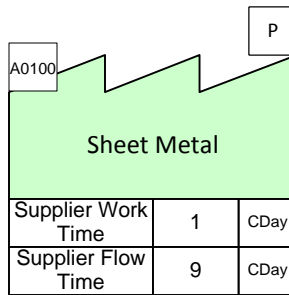
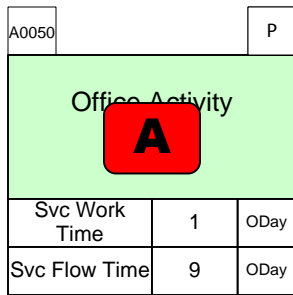
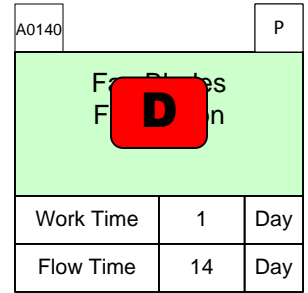
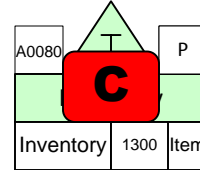
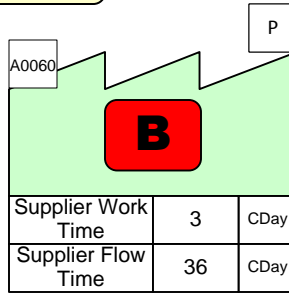


Step 8: Specify the Flow Sequence

1

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

Quick



Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	Ohr	ODay

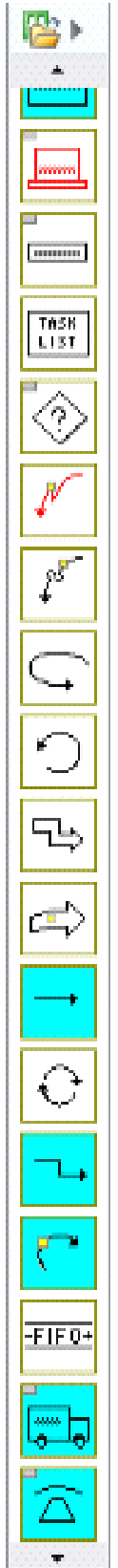
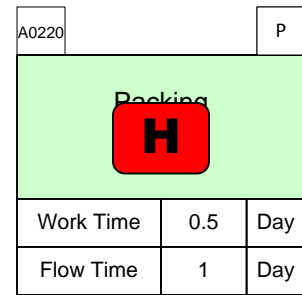
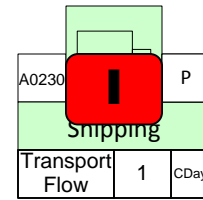
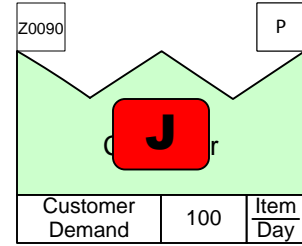
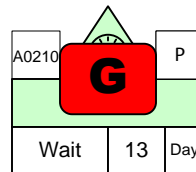
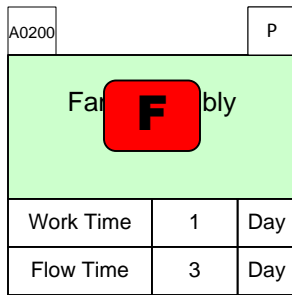
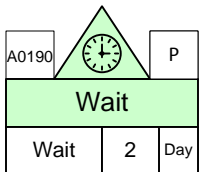
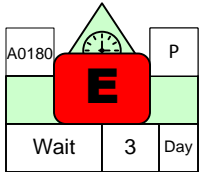


2

Click the Sequence button in the eVSM Toolbar.



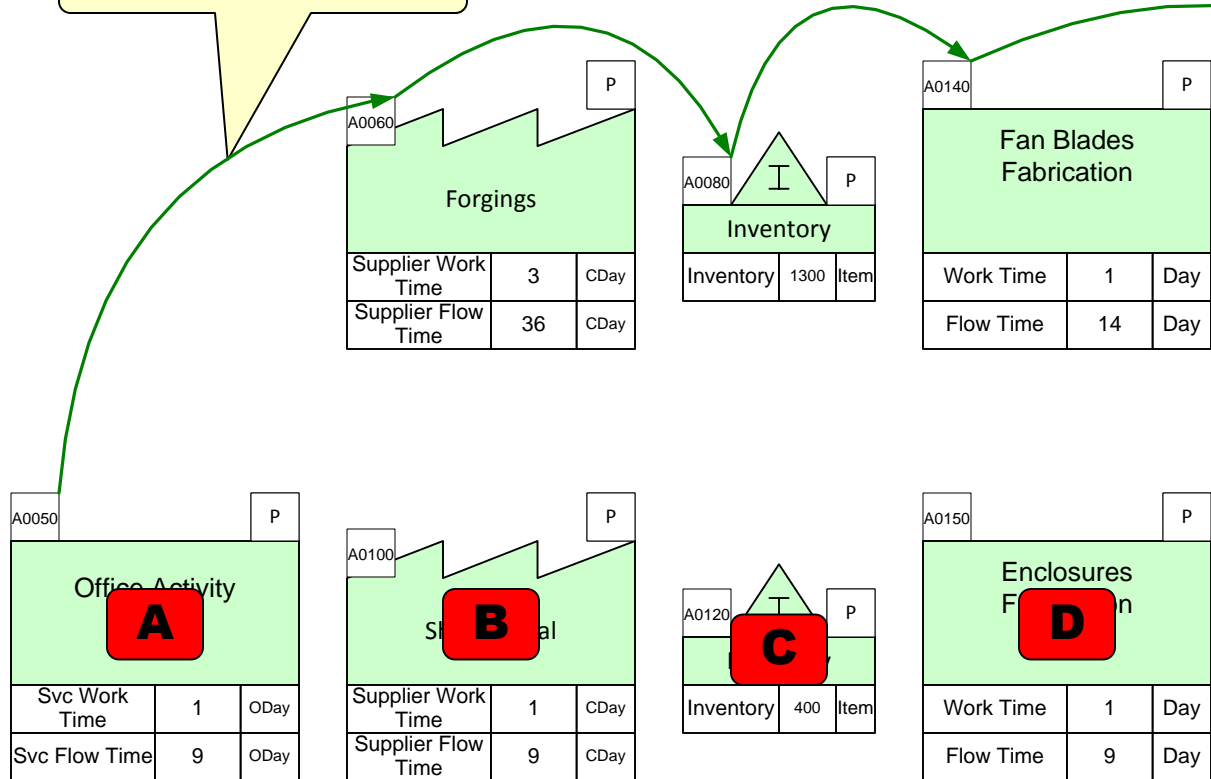
Sequence



Step 9: Specify the Flow Sequence Path 2

1 Sequence arrows for path 1 are now connected.

Quick MCT



A0060				P
Forgings				
Supplier Work Time	3	C	Day	
Supplier Flow Time	36	C	Day	

A0080				I	P
Inventory					
Inventory	1300	I	Item		

A0140				P
Fan Blades Fabrication				
Work Time	1	D	Day	
Flow Time	14	D	Day	

A0050				P
Office Activity				
A				
Svc Work Time	1	O	Day	
Svc Flow Time	9	O	Day	

A0100				P
Supplier				
B				
Supplier Work Time	1	C	Day	
Supplier Flow Time	9	C	Day	

A0120				I	P
Inventory					
Inventory	400	I	Item		

A0150				P
Enclosures Fabrication				
D				
Work Time	1	D	Day	
Flow Time	9	D	Day	

2 Hold the SHIFT key and follow the sequence for path 2.

A0110				P
Motors				
Supplier Work Time	3	C	Day	
Supplier Flow Time	29	C	Day	

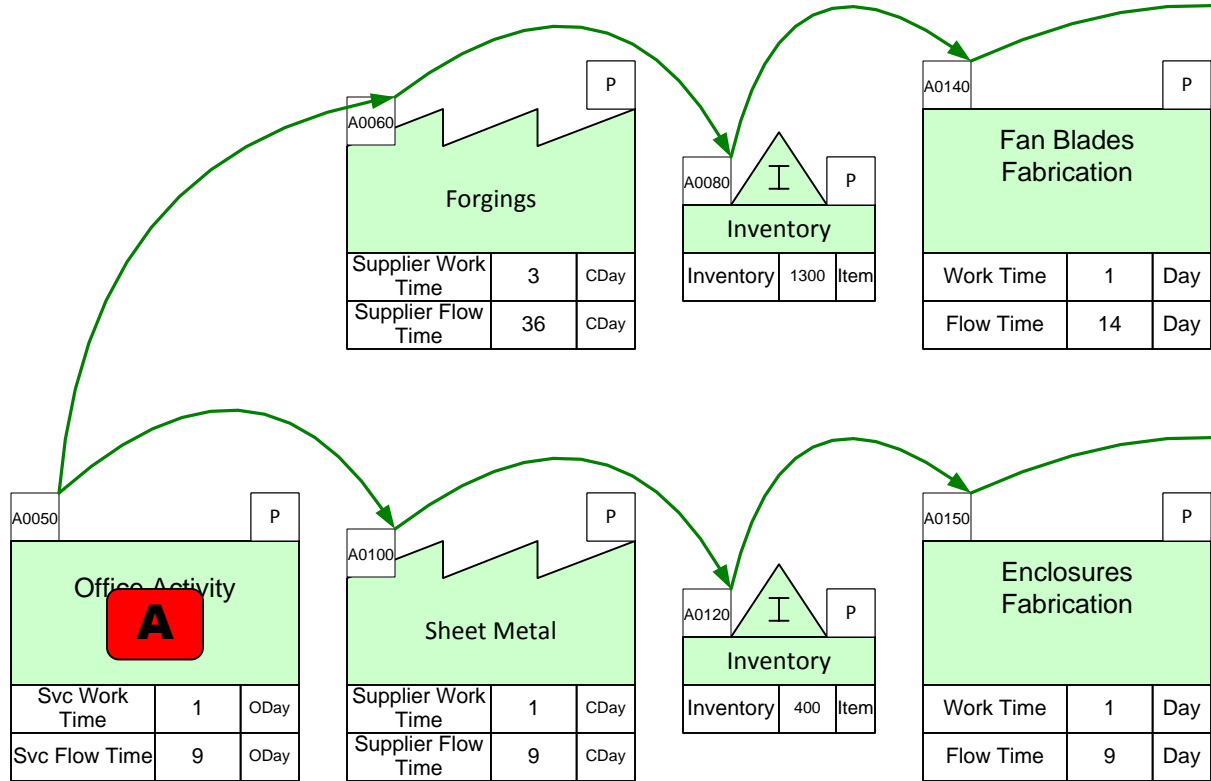
A0130				I	P
Inventory					
Inventory	1100	I	Item		

Units	Day	Wk	O	Day	Wk
	14	5	8	5	
	Hr	Day	O	Hr	O

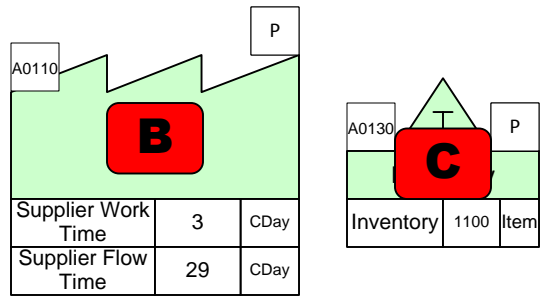


Step 10: Specify the Flow Sequence Path 3

Quick MCT




1 Hold the SHIFT key and follow the sequence for path 3.

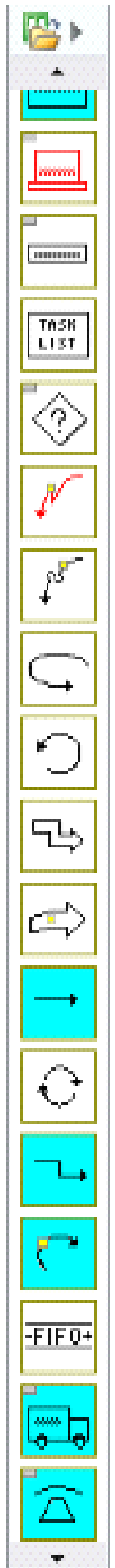
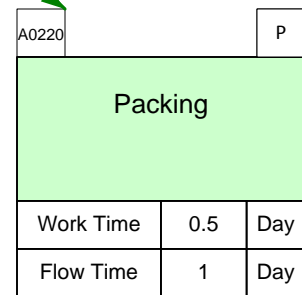
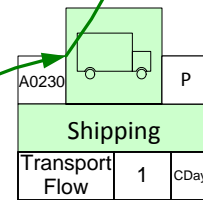
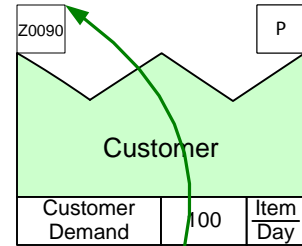
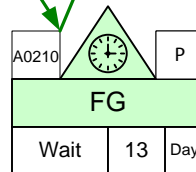
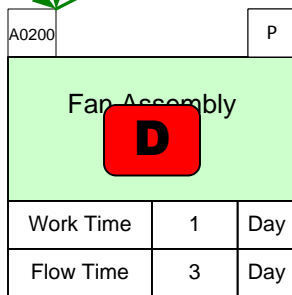
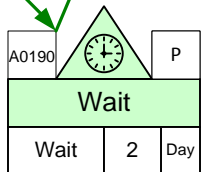
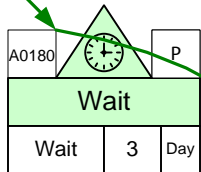


Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	Ohr	ODay



2

Click the Sequence button in the eVSM Toolbar.  Sequence

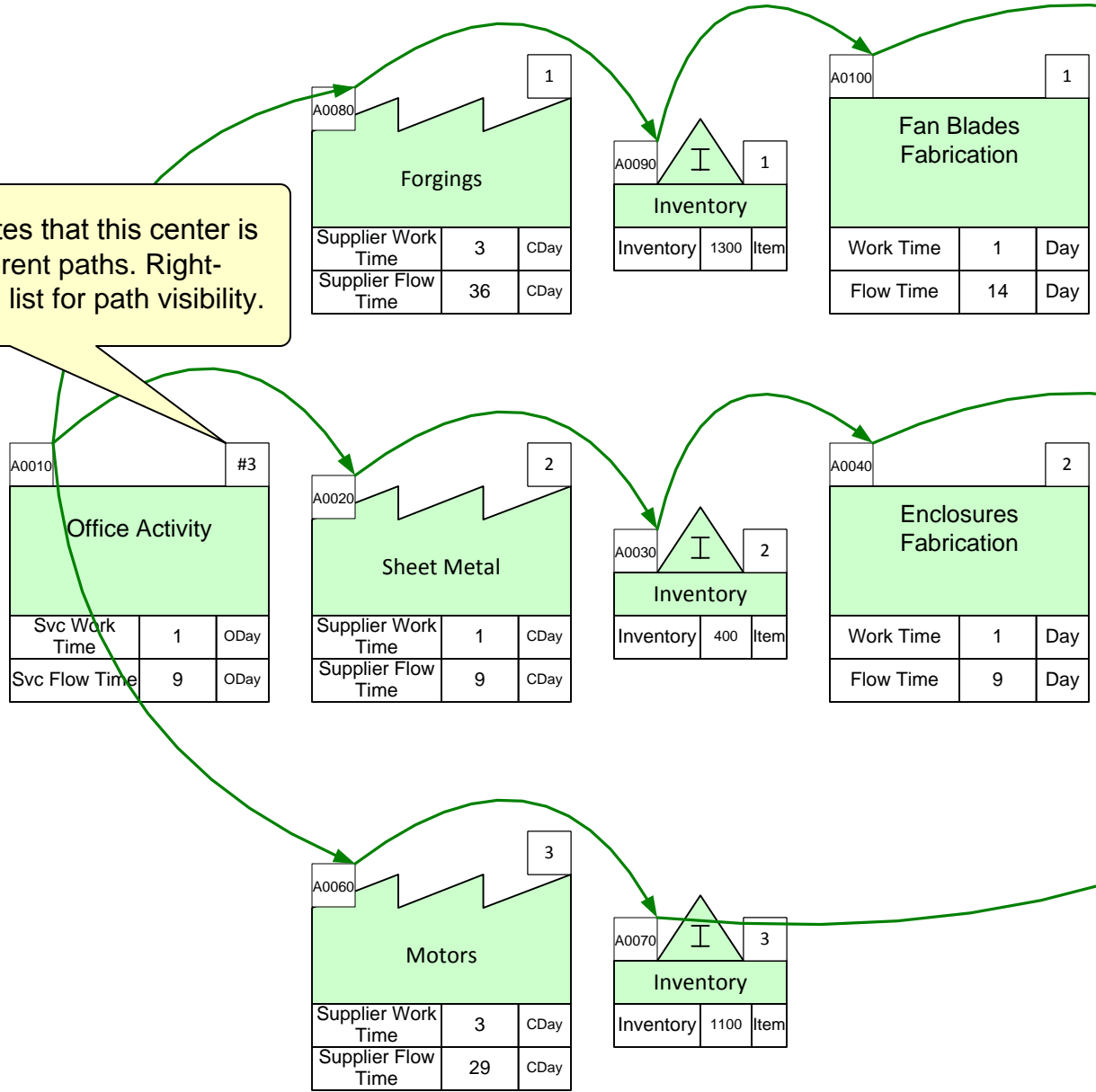


Step 11: Auto Path and Auto Tag

Quick MCT

2

A "#3" indicates that this center is on three different paths. Right-click the path list for path visibility.

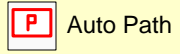


Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	OHr	ODay



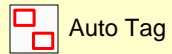
1

Click Auto Path to automatically generate Path numbers based on Sequence arrows. The path numbers on your map might not exactly match the ones on this example, and that is okay.



3

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



A0110		1
Wait		
Wait	3	Day

A0050		2
Wait		
Wait	2	Day

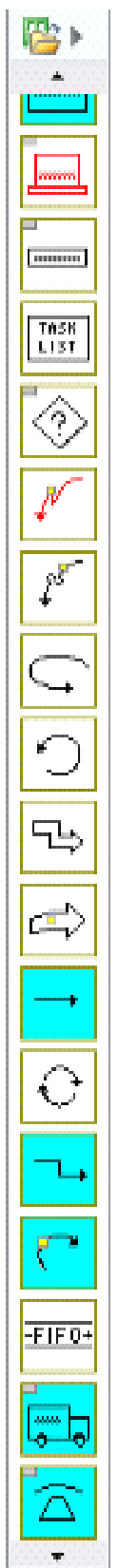
A0120		#3
Fan Assembly		
Work Time	1	Day
Flow Time	3	Day

A0130		#3
FG		
Wait	13	Day

Z0010		#3
Customer		
Customer Demand	100	Item Day

A0150		#3
Shipping		
Transport Flow	1	CDay

A0140		#3
Packing		
Work Time	0.5	Day
Flow Time	1	Day



Step 12: Add a Time Summary and Calculate

1 Drag out the MCT Summary center on the map.

Quick MCT



MCT Summary

A0080 1

Forgings			
Supplier Work Time	3	CDay	
Supplier Flow Time	36	CDay	

A0090 1

Inventory		
Inventory	1300	Item

A0100 1

Fan Blades Fabrication		
Work Time	1	Day
Flow Time	14	Day

A0010 #3

Office Activity			
Svc Work Time	1	ODay	
Svc Flow Time	9	ODay	

A0020 2

Sheet Metal			
Supplier Work Time	1	CDay	
Supplier Flow Time	9	CDay	

A0030 2

Inventory		
Inventory	400	Item

A0040 2

Enclosures Fabrication		
Work Time	1	Day
Flow Time	9	Day

A0060 3


Motors			
Supplier Work Time	3	CDay	
Supplier Flow Time	29	CDay	


A0070 3


Inventory		
Inventory	1100	Item


Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	OHr	ODay




2 Click the "Check" button and fix any errors flagged.  Check

3 Click the "Solve" button to calculate.  Solve


A0110		1
Wait		
Wait	3	Day

A0050		2
Wait		
Wait	2	Day

A0120		#3
Fan Assembly		
Work Time	1	Day
Flow Time	3	Day

A0130		#3
FG		
Wait	13	Day

Z0010		#3
Customer		
Customer Demand	100	Item Day

A0150		#3
Shipping		
Transport Flow	1	CDay

A0140		#3
Packing		
Work Time	0.5	Day
Flow Time	1	Day

Z0160		P
MCT Summary		
MCT Total	Auto	CDay
Total Gray Time	Auto	CDay
Total White Time	Auto	CDay
White Time %	Auto	%



- Home
- Simulation Start
- Simulation Stop
- Simulation Pause
- Simulation Play
- Simulation Step
- Simulation Step Back
- Simulation Step Forward
- Simulation Step Back 2
- Simulation Step Forward 2
- Simulation Step Back 5
- Simulation Step Forward 5
- Simulation Step Back 10
- Simulation Step Forward 10
- Simulation Step Back 30
- Simulation Step Forward 30
- Simulation Step Back 60
- Simulation Step Forward 60
- Simulation Step Back 120
- Simulation Step Forward 120
- Simulation Step Back 240
- Simulation Step Forward 240
- Simulation Step Back 480
- Simulation Step Forward 480
- Simulation Step Back 960
- Simulation Step Forward 960
- Simulation Step Back 1920
- Simulation Step Forward 1920
- Simulation Step Back 3840
- Simulation Step Forward 3840
- Simulation Step Back 7680
- Simulation Step Forward 7680
- Simulation Step Back 15360
- Simulation Step Forward 15360
- Simulation Step Back 30720
- Simulation Step Forward 30720
- Simulation Step Back 61440
- Simulation Step Forward 61440
- Simulation Step Back 122880
- Simulation Step Forward 122880
- Simulation Step Back 245760
- Simulation Step Forward 245760
- Simulation Step Back 491520
- Simulation Step Forward 491520
- Simulation Step Back 983040
- Simulation Step Forward 983040
- Simulation Step Back 1966080
- Simulation Step Forward 1966080
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- Simulation Step Forward 15728640
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- Simulation Step Forward 16106127360
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- Simulation Step Back 2061584302080
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- Simulation Step Forward 4123168604160
- Simulation Step Back 8246337208320
- Simulation Step Forward 8246337208320
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- Simulation Step Forward 16492674416640
- Simulation Step Back 32985348833280
- Simulation Step Forward 32985348833280
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- Simulation Step Forward 65970697666560
- Simulation Step Back 131941395333120
- Simulation Step Forward 131941395333120
- Simulation Step Back 263882790666240
- Simulation Step Forward 263882790666240
- Simulation Step Back 527765581332480
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- Simulation Step Back 4222124650659840
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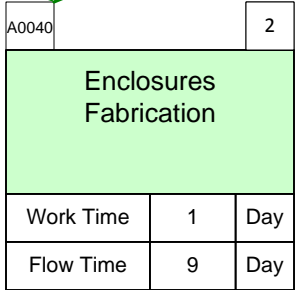
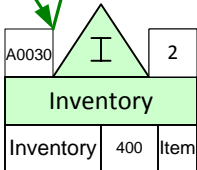
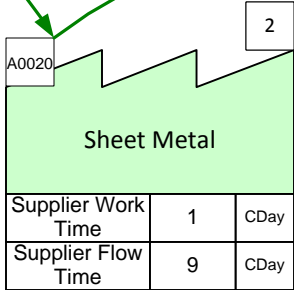
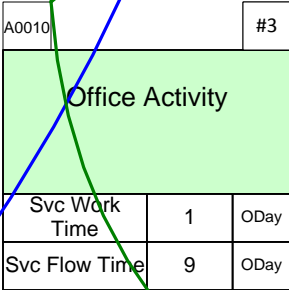
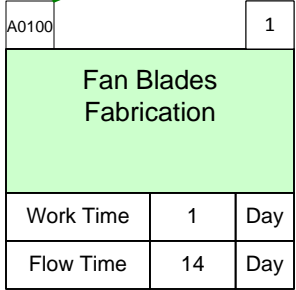
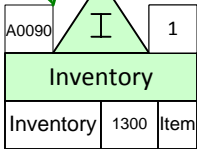
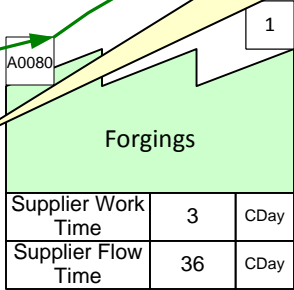
Step 13: Add Timeline Chart to Summarize all Paths

Quick MCT

1 Drag out the White/Gray Map shape on the drawing page.

2 Use the right mouse button menu of chart icon and select "Plot Ladder Chart"

MCT Map

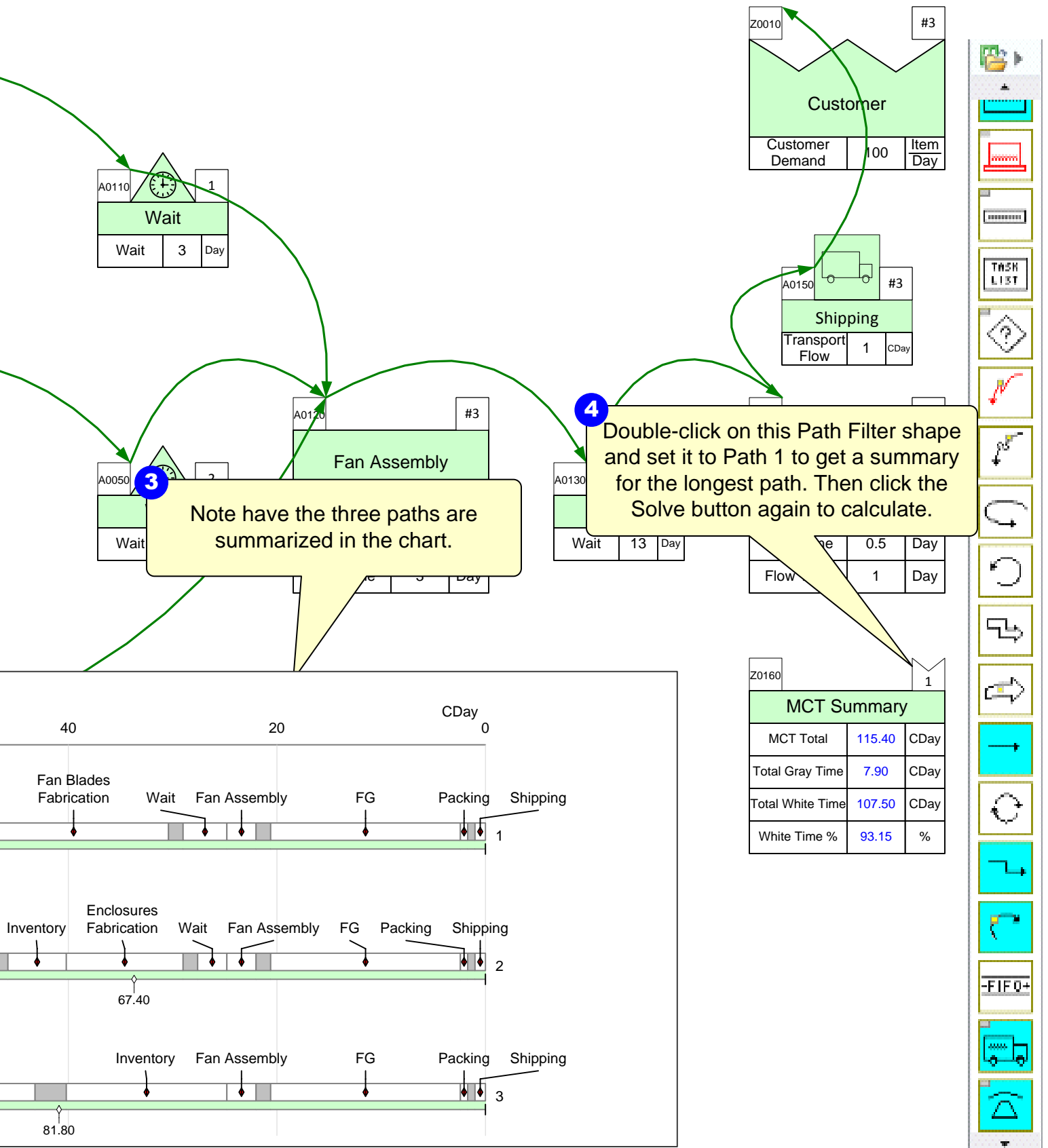


White/Gray Map



Units	Day
	14
	Hr





Step 14: Identify Improvement Ideas

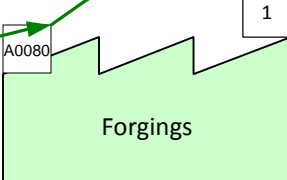
1 Drag out Kaizen Starbursts from the Quick Extras stencil on the right.

002 Large Flow Time at Forgings

2 Double-click to add text.

Quick MCT

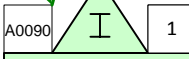
A0080 1



Forgings

Supplier Work Time	3	CDay
Supplier Flow Time	36	CDay

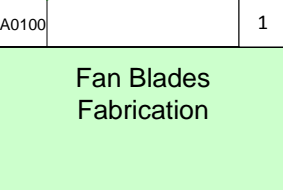
A0090 1



Inventory

Inventory	1300	Item
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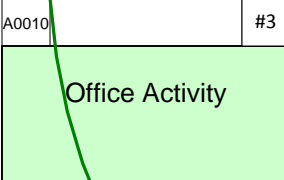
A0100 1



Fan Blades Fabrication

Work Time	1	Day
Flow Time	14	Day

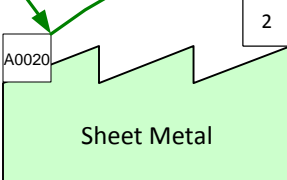
A0010 #3



Office Activity

Svc Work Time	1	ODay
Svc Flow Time	9	ODay


A0020 2



Sheet Metal

Supplier Work Time	1	CDay
Supplier Flow Time	9	CDay

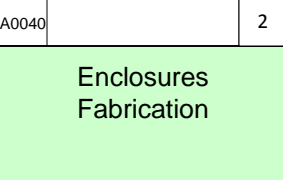
A0030 2



Inventory

Inventory	400	Item
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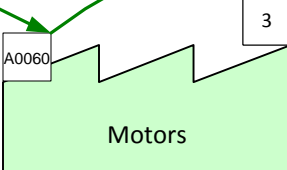
A0040 2



Enclosures Fabrication

Work Time	1	Day
Flow Time	9	Day

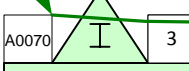
A0060 3



Motors

Supplier Work Time	3	CDay
Supplier Flow Time	29	CDay

A0070 3

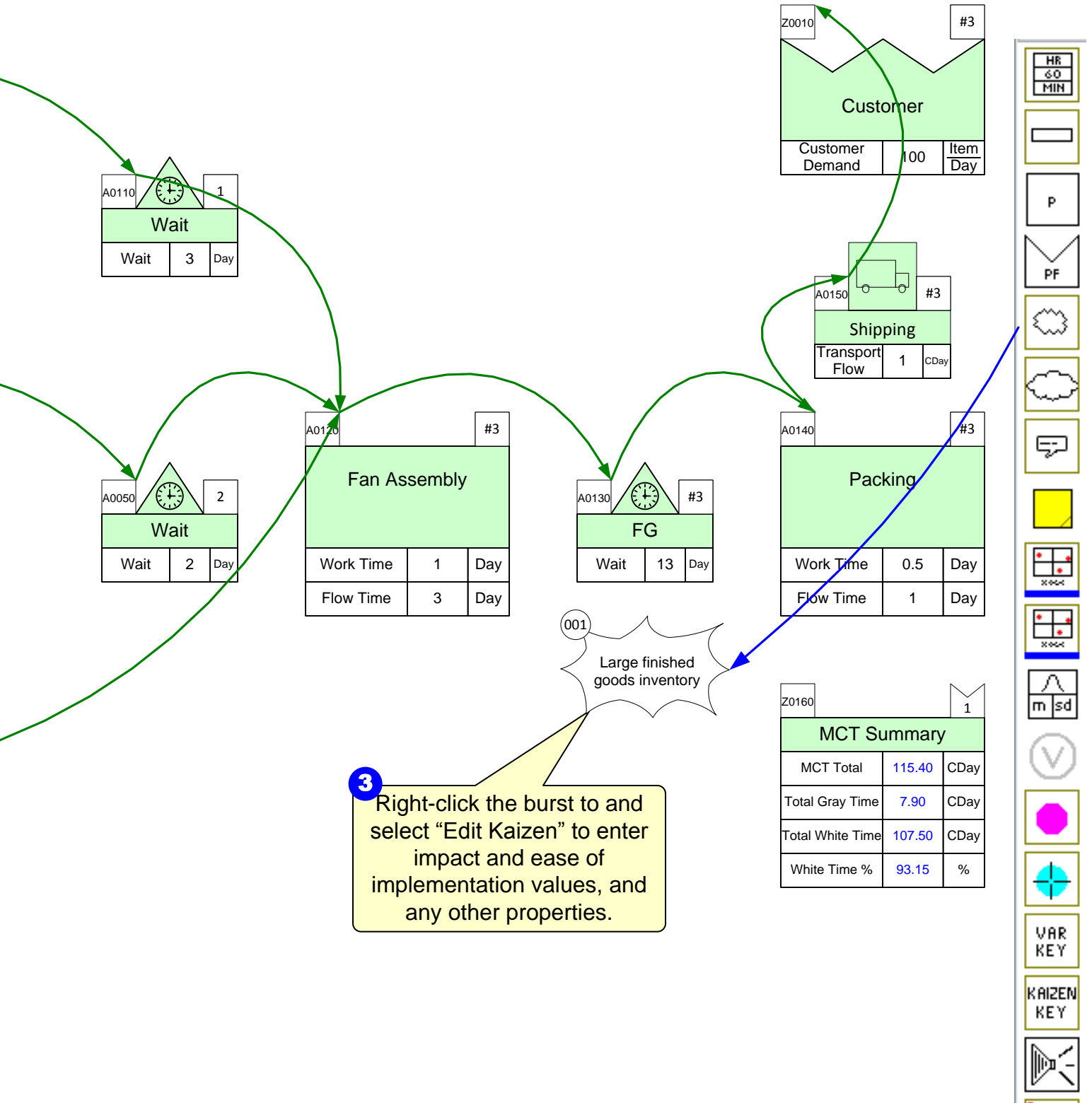


Inventory

Inventory	1100	Item
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Units	Day	Wk	ODay	Wk
	14	5	8	5
	Hr	Day	OHr	ODay





Step 15: Kaizen Impact Matrix

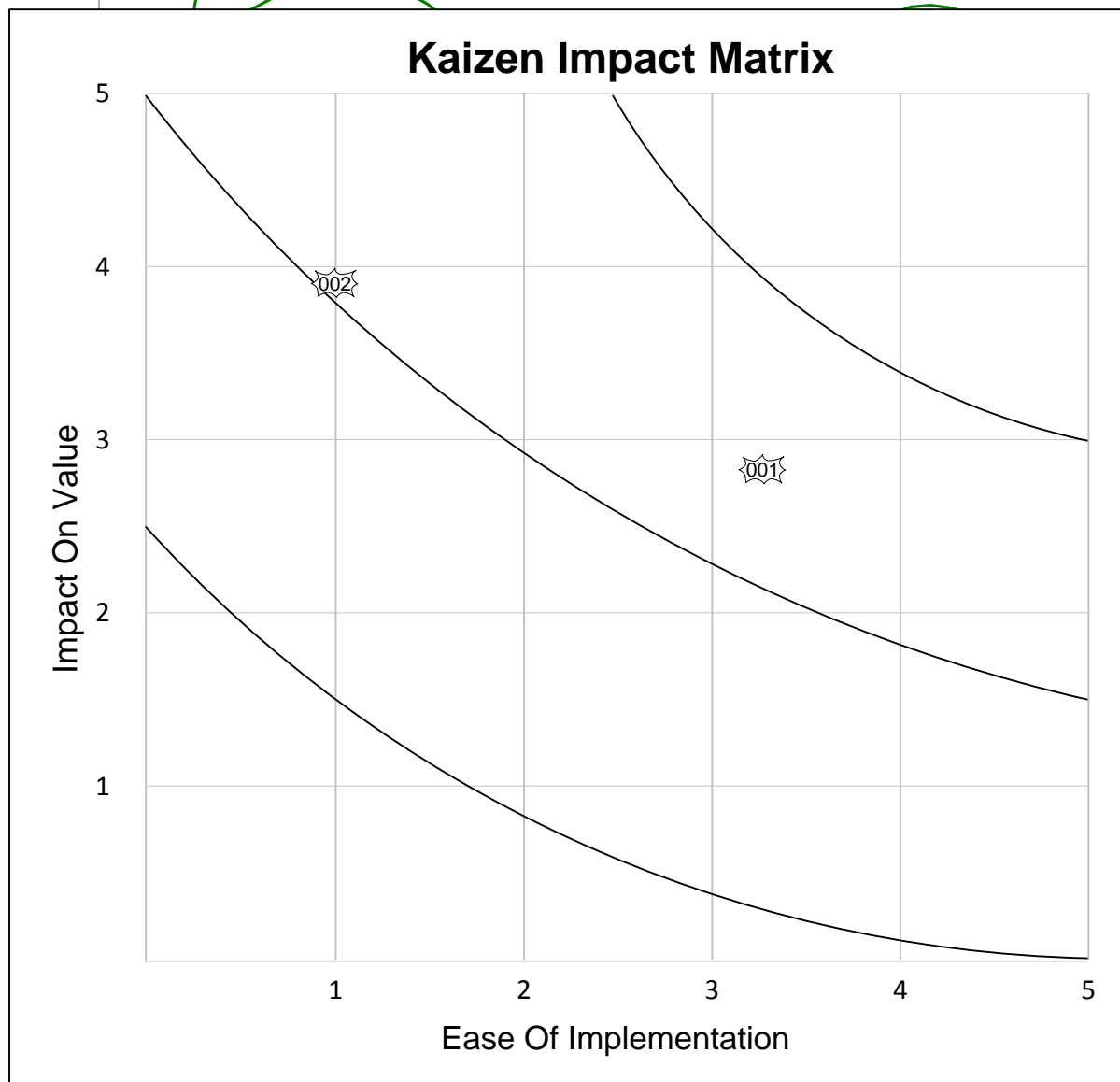
Quick MCT

002
Large Flow Time at Forgings


A0080	1	
Forgings		
Supplier Work Time	3	CDay
Supplier Flow Time	36	CDay

A0090	1	
Inventory		
Inventory	1300	Item

A0100	1	
Fan Blades Fabrication		
Work Time	1	Day
Flow Time	14	Day



2	
asures cation	
1	Day
9	Day

1 Click the Kaizen Export button in the toolbar to export the kaizen properties to Excel.  Kaizen Export

2 Drag out the Kaizen Impact Matrix from the Quick Extras stencil and right-click to plot.

A0110		
Wait	3	Day

Kaizen Impact Matrix

Z0010	#3	
Customer		
Customer Demand	100	Item Day

A0150	#3	
Shipping		
Transport Flow	1	CDay

A0050	2	
Wait		
Wait	2	Day

A0120	#3	
Fan Assembly		
Work Time	1	Day
Flow Time	3	Day

A0130	#3	
FG		
Wait	13	Day

001 Large finished goods inventory

A0140	#3	
Packing		
Work Time	0.5	Day
Flow Time	1	Day

Z0160	1	
MCT Summary		
MCT Total	115.40	CDay
Total Gray Time	7.90	CDay
Total White Time	107.50	CDay
White Time %	93.15	%

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