

Basic Value Stream Map

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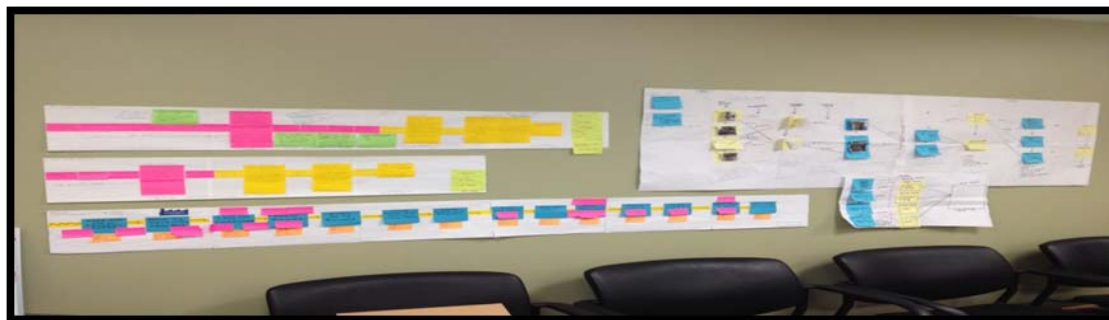
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LAMA-ATA
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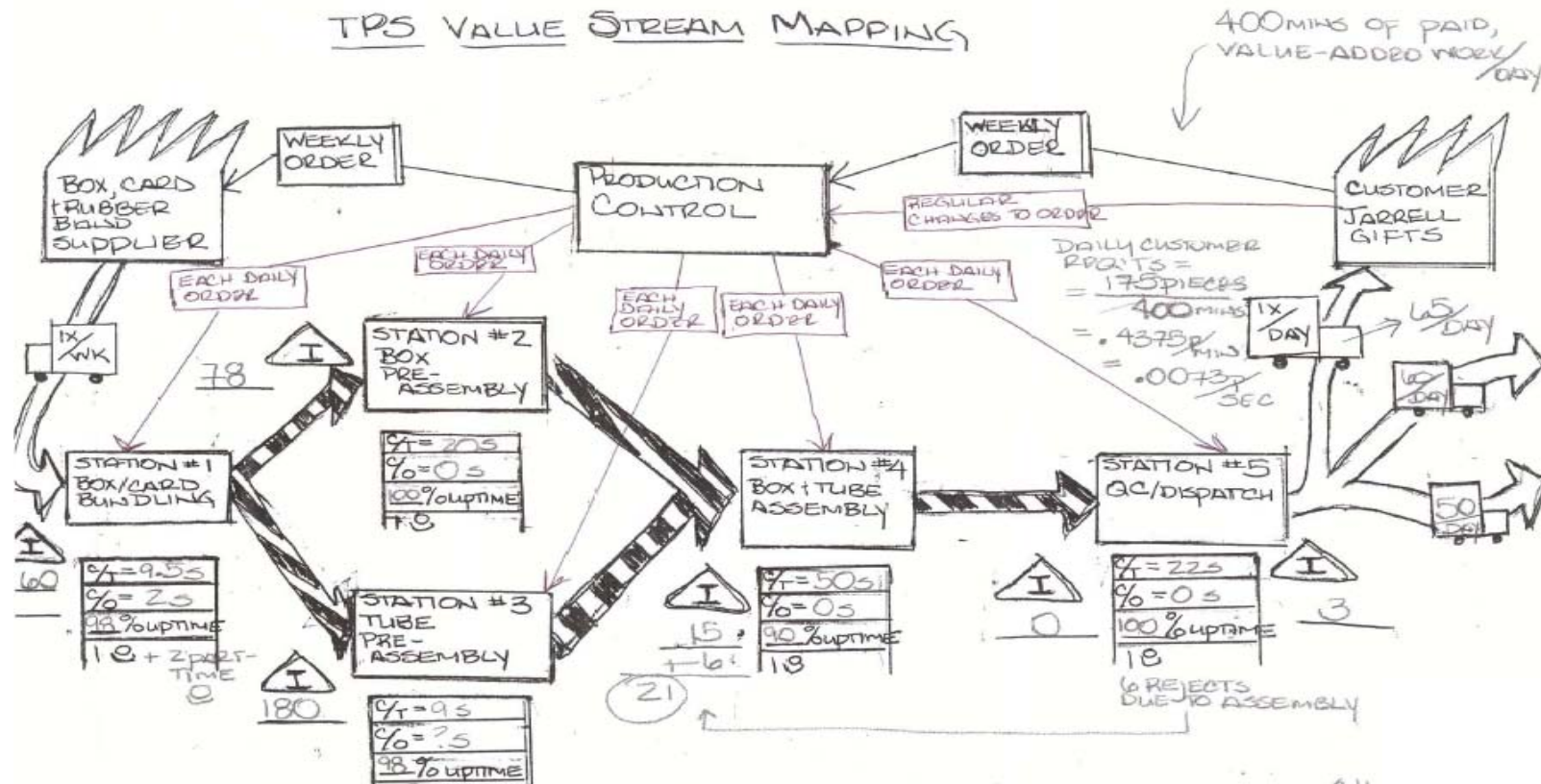
Process Flow & Value Stream Maps

- A “big picture” graphical representation of an individual processes.
- Compares all actions as either *value added* or *non-value added*.
- Involves both materials and information flows



Value Stream Map

TPS VALUE STREAM MAPPING



Process Flow Map



Creates a common platform for understanding workflow and problem solving.

Gather Data

- Involve Active Participants
- Gather Data
- Keep it simple

Daily NHP Cage Time Tracking Sheet - CLEA
Please record when you start each step in the Cage Washing process and record

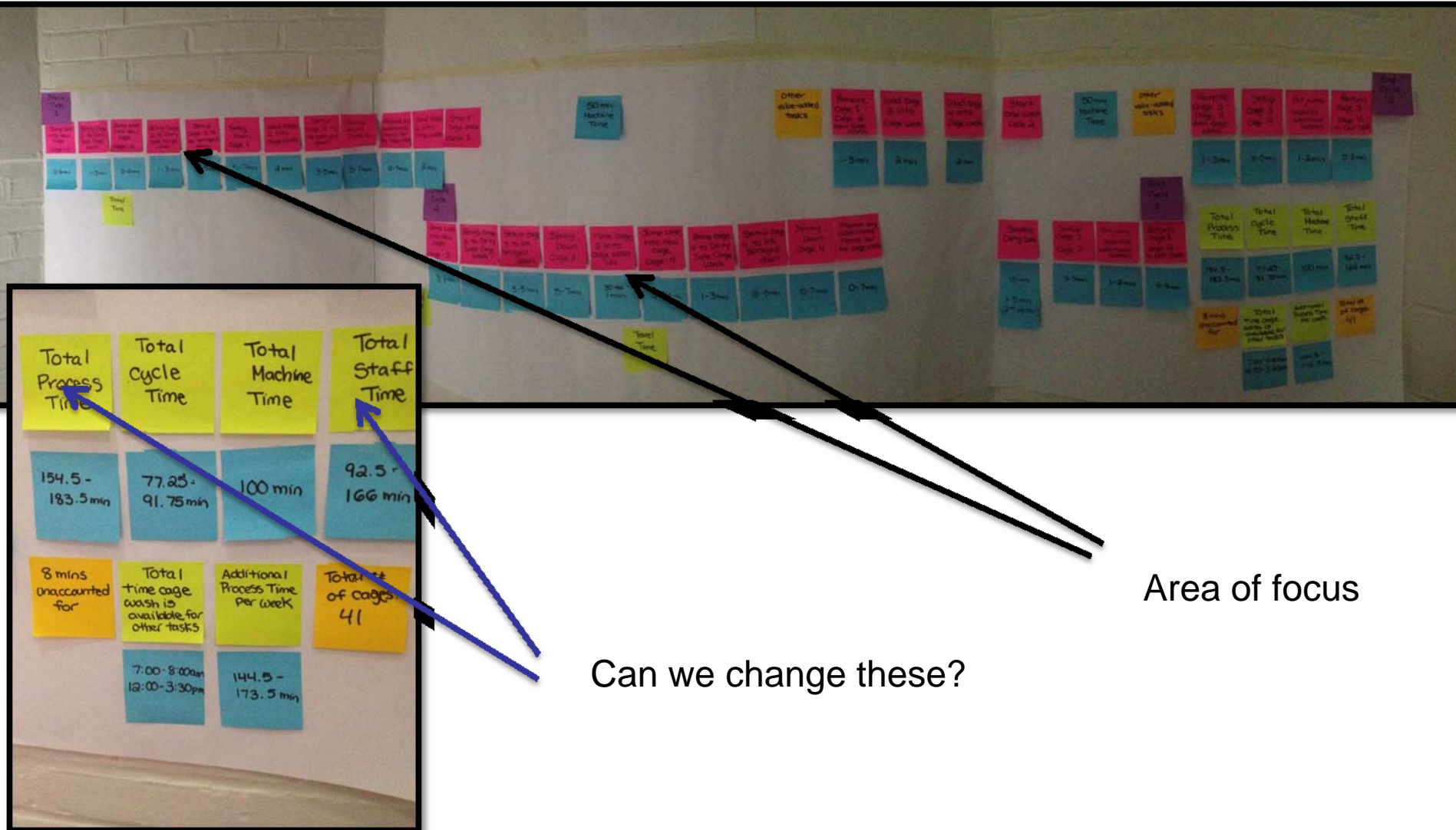
DATE: 3/27/14

	Cage #	Unload Cage from Cage Wash	Put Away Supplies -Cleaning Tools -Enrichment -Water Bottles -Misc.	Setup Cages	Return Cage to NHP Housing Room	
Example	1	9:01am	N/A	9:10am	9:16am	I setup the
Example	2	9:03am	9:05am	9:14am	9:22am	
1st Load	1	10:04 2min 10:05	10:05 2min 10:07	10:07 2min 10:09	10:09 2min 10:11	
1st Load	2	10:06 2min 10:08	10:08 2min 10:10	10:10 2min 10:12	N/A (9.0)	+ 2 minutes adding minors w/ Lohrite (Secret's age)
2nd Load	3	11:21 5min 11:26	11:26 2min 11:28	11:28 2min 11:30	11:30 2min 11:32	
2nd Load		11:33 1min 11:34	11:33 2min 11:37	11:37 2min 11:39	11:39 2min 11:41	
3rd Load	NA					Cage for
3rd Load						

Cage Wash Data

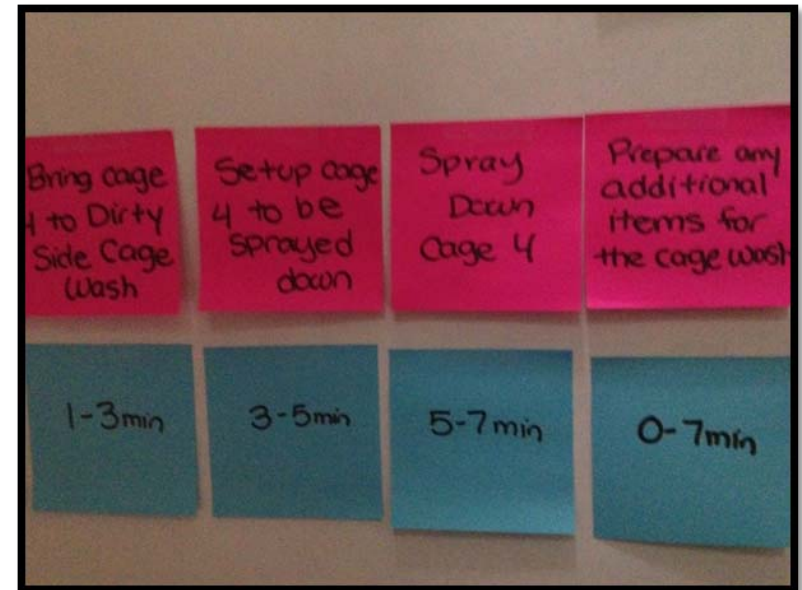
- How much more machine time we have
- How much labor time we gave back

Current/Past State

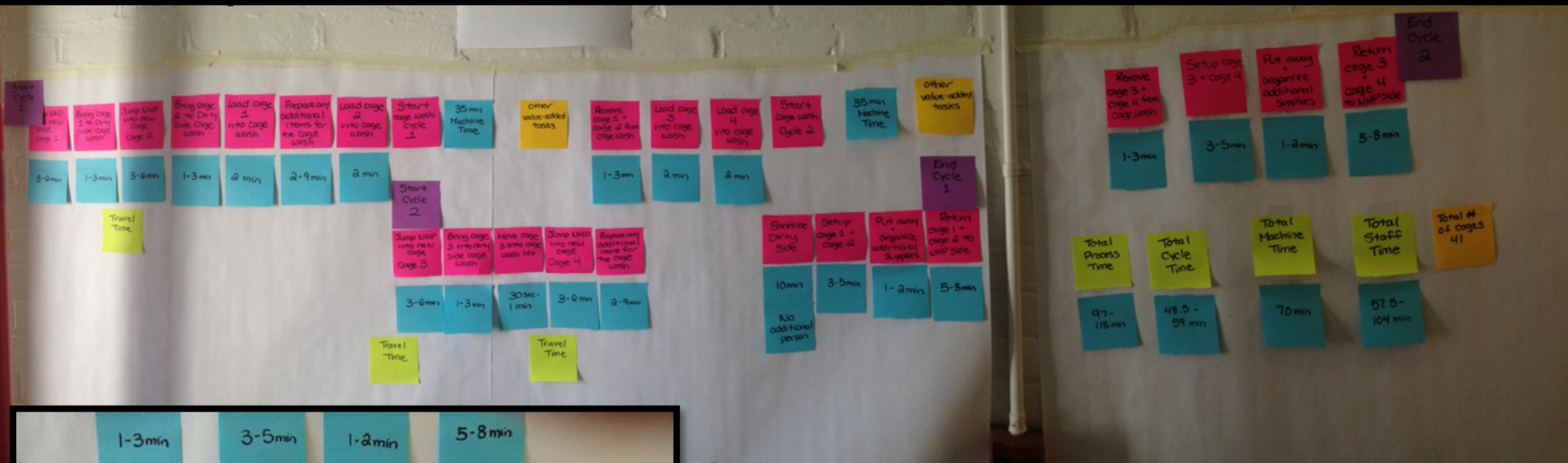


Target Improvements

- Find Opportunities to Improve
 - Efficiency/Waste
 - Quality
 - Safety



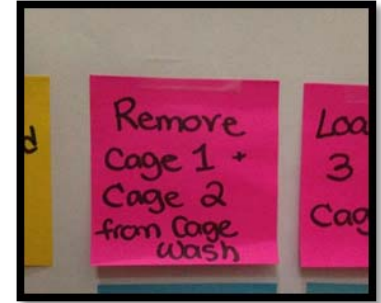
Future State



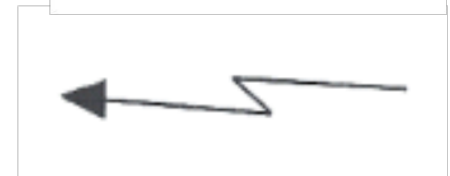
- Test New Process and Measure impact

Common Icons

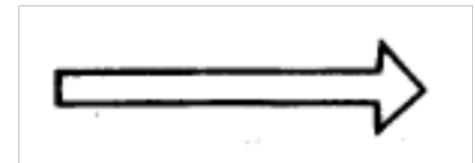
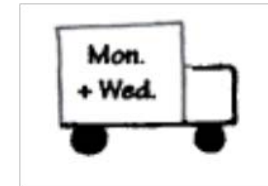
- Process Boxes – Rectangles
- Specific Process Information Data Box
- Electronic Information Flow - Bent Thin Arrow
- Information Flow - Thin Arrow



C/T = 45 sec.
C/O = 30 min
3 Shifts
2% Scrap



- Inventory – Triangles
- Transportation of Goods – Carts/Trucks/?
- Push System – Striped Horizontal Arrow
- Pull System – Open Horizontal Arrow



Team Exercise

- Watch Video
 - Determine the individual steps
 - Record the time for each step
- Map out the process with your team
- Flag area's for improvement
- Create a new process with your Team



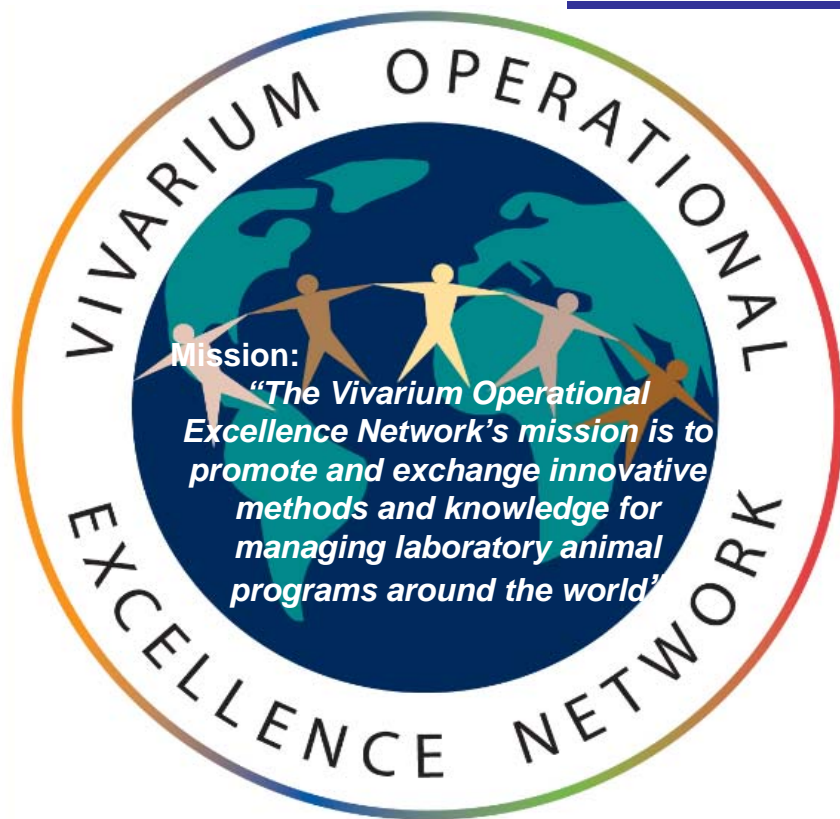


How Did It Go?

- Did you find opportunities to improve the process?
- Was your team able to agree on the current process?
- Were there quality issues in the process?
- Was everyone able to participate?
- Was the second video like your improved process?



The **Vivarium Operational Excellence Network**



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- ***Peer-to-peer Mentoring***
- ***Training Opportunities***
- ***Excellence Recognition***
- ***Site Visits***

- www.voenetwork.com
- [More information: ccmlean@partners.org](mailto:ccmlean@partners.org)