

Delivery in sustainment projects through Lean process management

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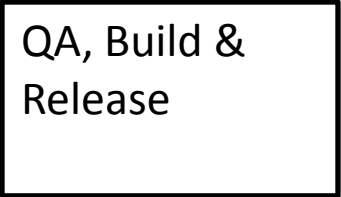
Customer request



1 Day.-Team

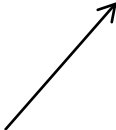


2 Day.-Team



1 Day.-Team

Customer acceptance





Item size →

Arrival rate →

CR priority →

Station defect
rate →

Time deviation
per station →

Throughput →

Lead Time →

Cost/ CR →

Exercise 1

1. Arrival rate is constant = 1 CR/day
2. All CRs are of Standard size
3. No defect produced by any station
4. Items are processed FIFO basis
5. Every station always take same duration per CR

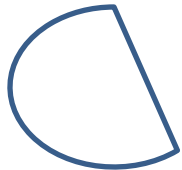
Exercise 2

Exactly same rules as exercise 1, we just added one more team for Test & Development station.

Exercise 3

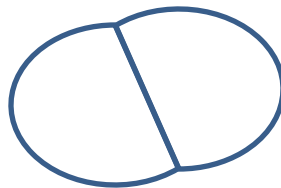
Same rules. Size is uniformly distributed.

Tiny



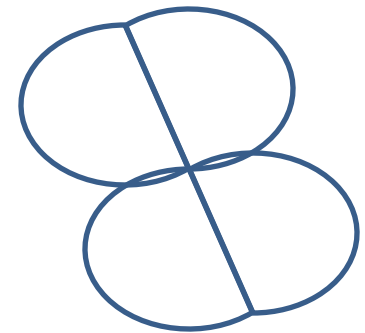
0.5 Team-Day

Standard



1 Team-Day

Large



2 Team-Day