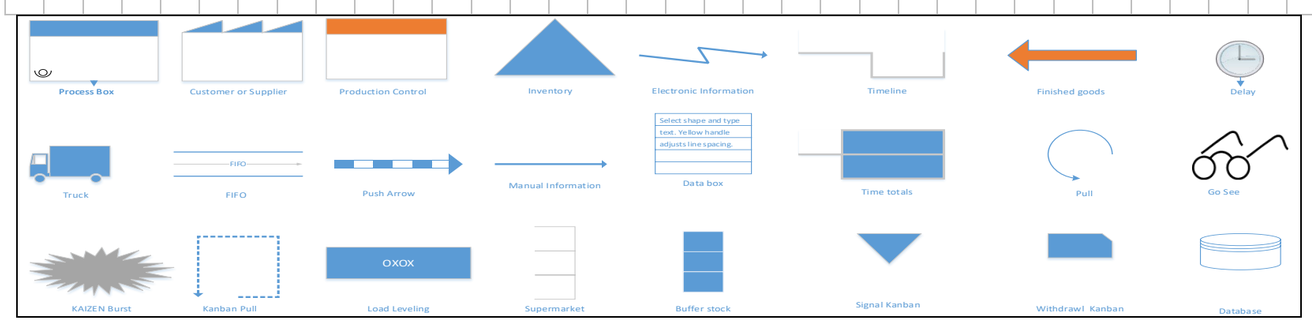
Value Stream Map Name: _____ Date: _____ Product Family:_____ Current State ☐ Future State ☐



Formulas:

Takt Time=Available Time/Customer Demand

Number of Operators=Work Content/Takt Time

Process Cycle Efficiency = (Value-added Time / Cycle Time)

OEE = (Good Count × Ideal Cycle Time) / Planned Production Time