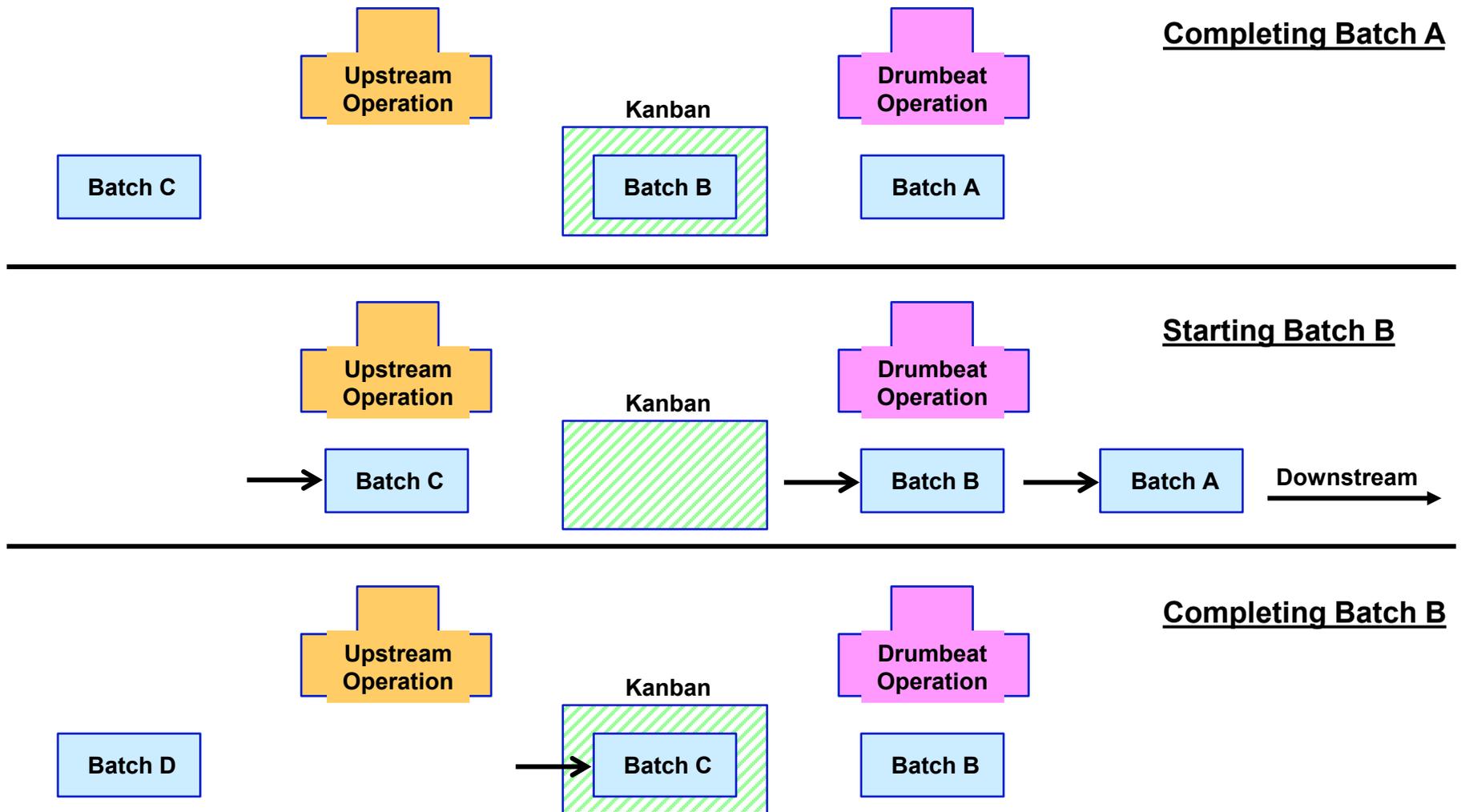
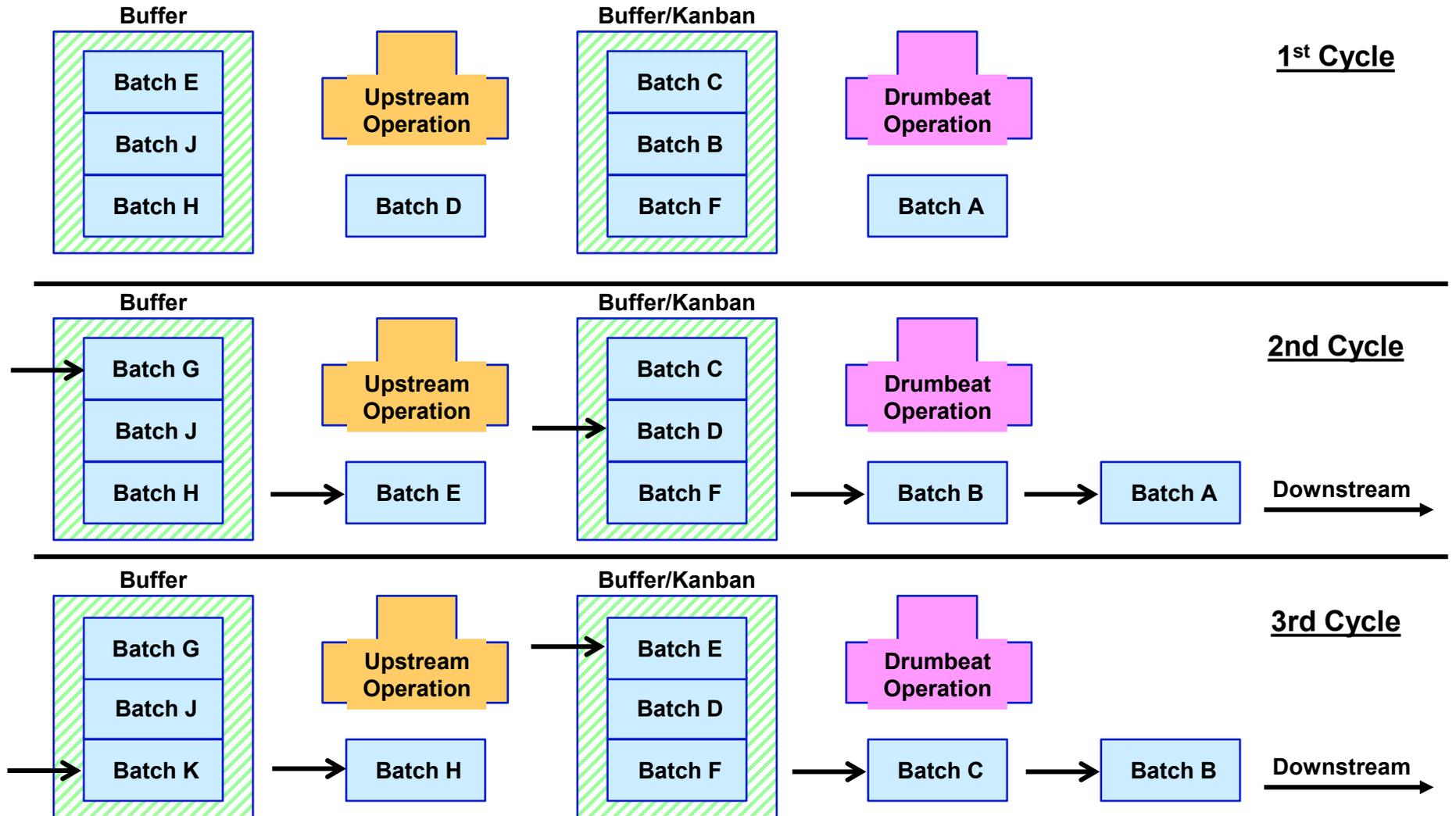


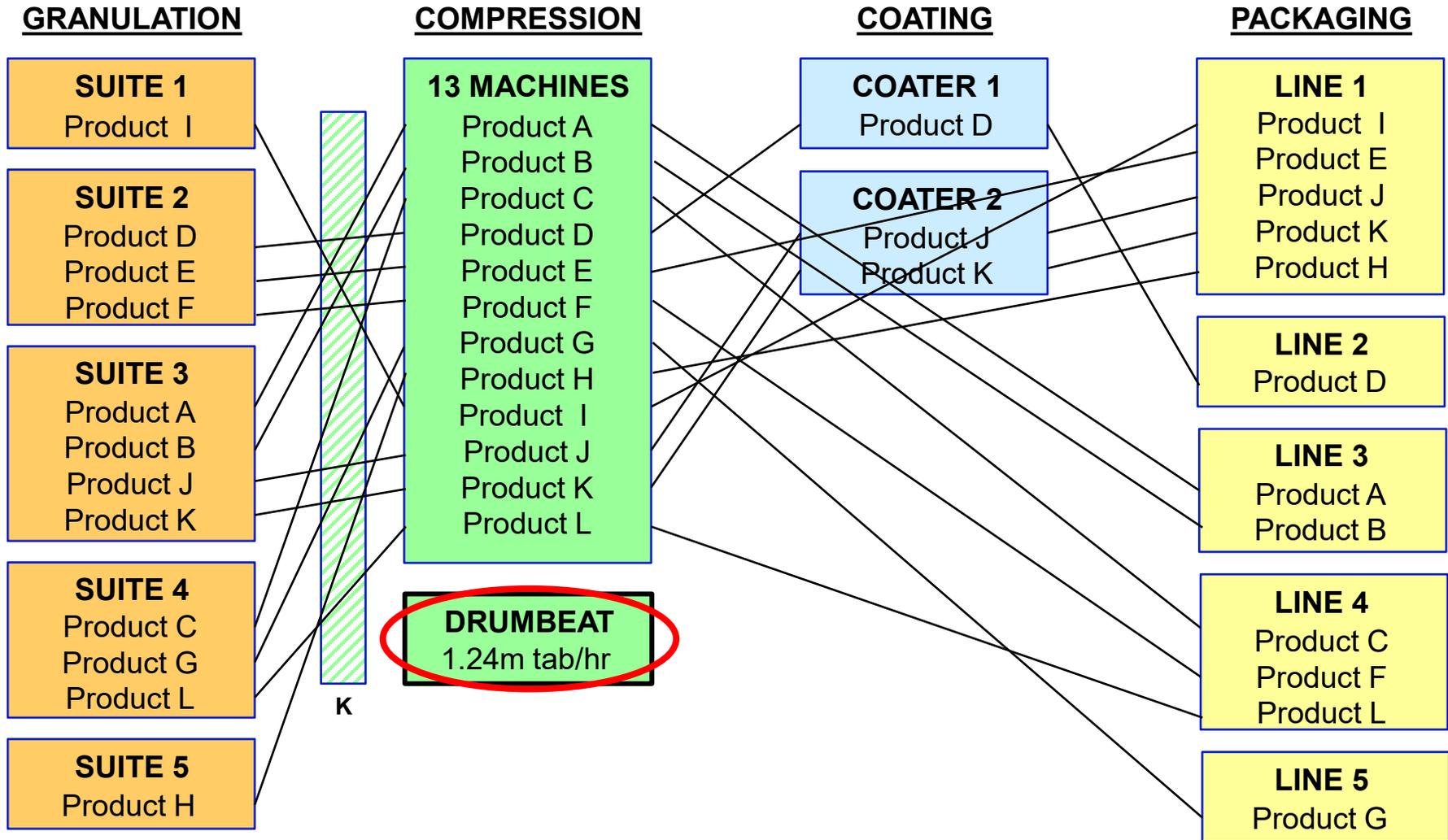
# Fig 3-1 Kanban Principle



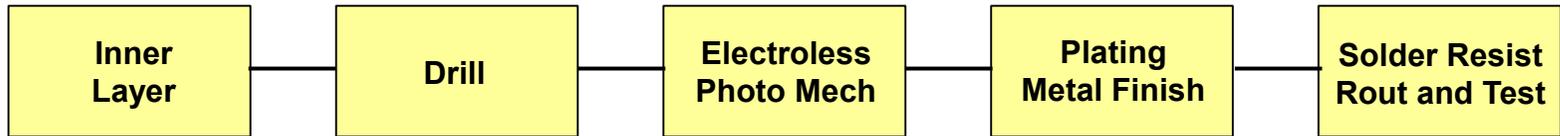
# Fig 3-2 Buffer / Kanban Principle



# Fig 3-3 Pharma Manufacturer

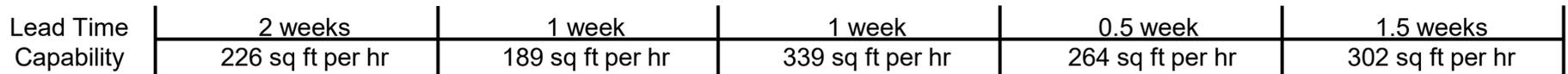


# Fig 3-4 PCB Manufacturer



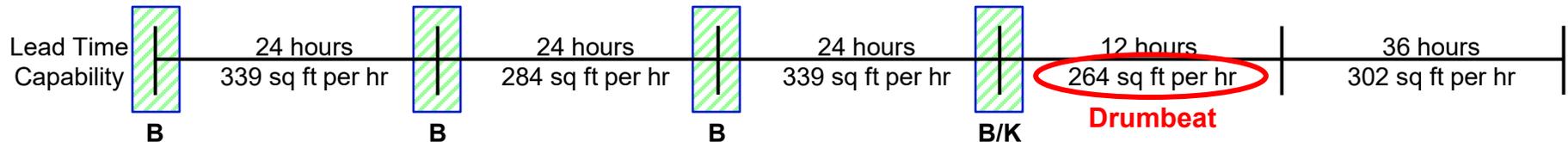
**Before 'Elite':**

**Demand Rate:** 151 sq ft per hr  
**Thruput Rate:** 151 sq ft per hr  
**Manuf Lead Time:** 6 weeks

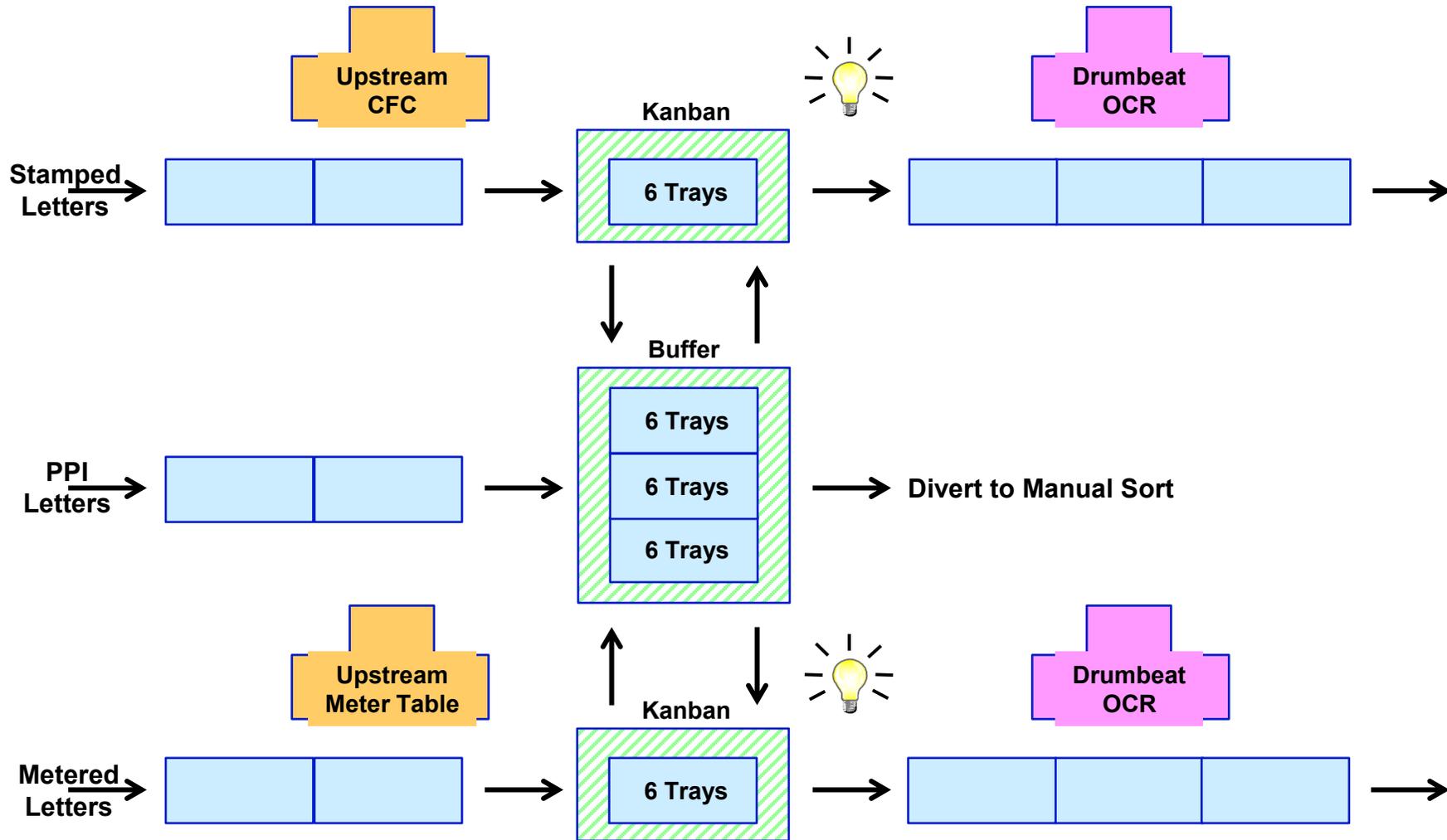


**After 'Elite':**

**Demand Rate:** 264 sq ft per hr  
**Thruput Rate:** 264 sq ft per hr  
**Manuf Lead Time:** 5 days



# Fig 3-5 Time-based Kanban Principle – Mail Sorting Centre



## Fig 3-6 Milestone 3. TPT/PLT – Briefing Document

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**SCOPE:** To achieve TPT/PLT targets for ACD

**KEY CHANGE ISSUES:**

- Keep batch moving
- Introduce Kanbans
- Integration of all other Milestones
- Do PV run for TPT in month 5
- Develop inbound and outbound improvements

**CRITERIA FOR SUCCESS:**

- PV run successful
- Meet targets for all ACD batches over one month

# Fig 3-7 Milestone 3. TPT/PLT – Activity Plan

