

# Implementation Program Levelled Schedule

## Implement a Levelled Schedule through 'Green Stream Thinking'

This Implementation Program delivers a 'Levelled Schedule' to create Levelled and Stable Production for your 'Green Stream' products, with 'Make-to-Stock' Windows for Yellow-Stream products and 'Make-to-Order' windows for Blue/Red Stream items.












By creating 'Levelled and Stable Production' we achieve 'Economies of Repetition' to dramatically improve Productivity, decrease Cost, increase Throughput and achieve big reductions in Inventory.



Levelled Schedule is the Foundation for **All** Improvement Activities

## Levelled Schedule Implementation Activities

The learning topics covered and resources in this workshop are:

-  Levelled Schedule as the foundation for all Lean improvement activities.
-  Why we should 'Level the Schedule' – and why most organisations don't!!!!
-  Benefits and payoffs for Levelling the Schedule.
-  Levelled Schedule Case Studies.
-  Identify Barriers to Levelling the Schedule.
-  Determine stock levels, buffers and triggers for Green Stream items.
-  Calculate buffer sizes, stock levels and triggers for 'Make to Stock' windows.
-  Calculate order quantities and batch sizes for Make to Order windows.
-  Trial/pilot initial draft 'Levelled Schedule.'
-  Build Visual Workplace Management Board to track progress, issues and results of Levelled Schedule.
-  Apply PDCA Cycle and schedule revisions to Levelled Schedule.

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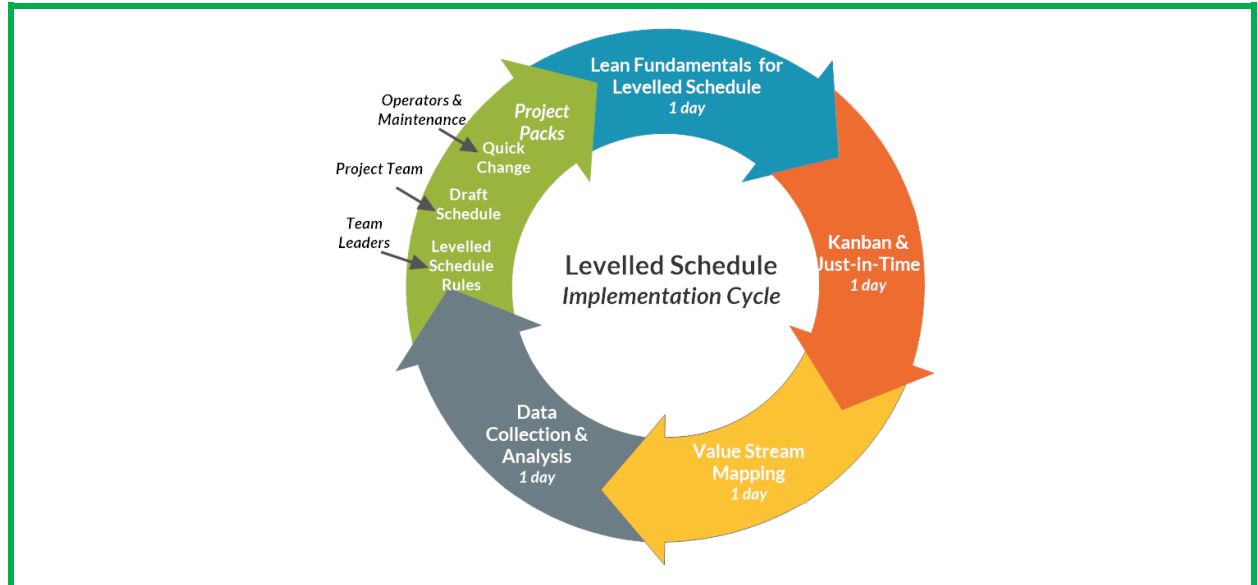
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## Implementation Program Concepts

Green Stream Thinking	We introduce the 'Glenday Sieve', demand segmentation and identify your Green/Yellow/Blue and Red product/service streams.
Takt Time	We calculate the 'Takt time' – rate of customer demand – for your 'Green Stream' products as the first step to 'Level the Schedule'
Kanban	We introduce Kanban as a Just-in-Time tool to create right-sized buffers for your Green Stream products.
Value Stream Mapping	We map your current state 'Green Streams' to identify appropriate 'Lot Sizes' for your Green stream items.
Right-size Work-in-Process	From our Value Stream Maps we 'right-size' batch and lot sizes to deliver to 'Takt' and maximise productivity.
Make to Schedule	We determine the 'pitch' – management time frame – that we schedule and calculate batch sizes for Green Stream items.
Make to Stock	We determine the size, in time, of your 'Make to Stock' windows and calculate stock limits for Yellow Stream items.
Make to Order	We map the Value Streams of Blue/Red items and create rules for 'Make to Order' windows with your sales and marketing teams.
Draft Level Schedule	We calculate a 'draft' Level Schedule and run simulations using historical data to 'stress test' the proposed Levelled Schedule.
Customer-Supplier Agreements	The draft Levelled Schedule is shared with internal and external suppliers to agree delivery schedules and right-sized lots of raw materials, parts and work-in-process.
Quick Changeovers	We engage with Production and Maintenance to establish optimum product sequencing for Quick Changeovers.
All hands on deck!	We develop an implementation plan for 'Levelling the Schedule' and kick-off the Levelled Schedule Implementation Team.
Project Team Support	Project Team meetings are scheduled, Project Plan agreed – and off we go to 'Level the Schedule.'

## Levelled Schedule Sample Implementation Program

This Implementation Program will be customised to deliver a ‘Levelled Schedule’ to create Levelled and Stable Production for your ‘Green Stream’ products, with ‘Make-to-Stock’ Windows for Yellow-Stream products and ‘Make-to-Order’ windows for Blue/Red Stream items. The Implementation Program may look something like this:



### Day One – Introduction to Levelled Schedule

Topic – Activity	Audiences	Purpose	Time
Lean Fundamentals: Why Level the Schedule?	Leadership Team	<ul style="list-style-type: none"> <li>Engage all key staff</li> <li>Introduce Levelled Schedule</li> </ul>	4 hrs
	Finance, Operations, Sales		3 hrs

### Day Two – Kanban, Buffers and Production Triggers

Topic – Activity	Audiences	Purpose	Time
Kanban and Just-in-Time	Leadership Team	<ul style="list-style-type: none"> <li>Calculate production buffers for Green Stream items</li> <li>Brainstorm triggers and batch sizes for all other items</li> </ul>	4 hrs
	Finance, Operations, Sales		3 hrs












### Day Three – Value Stream Mapping

Topic – Activity	Audiences	Purpose	Time
Value Stream Mapping	Leadership Team	<ul style="list-style-type: none"> <li>Map changes to Current State with Levelled Schedule</li> <li>Brainstorm Improvement Projects required</li> </ul>	4 hrs
	Finance, Operations, Sales		4 hrs

### Days Four-Five – Begin Levelled Schedule Implementation Projects

Topic – Activity	Audiences	Purpose	Time
Commence Implementation Projects	Leadership Team	<ul style="list-style-type: none"> <li>Gather data and analyse</li> <li>Draft initial Levelled Schedule</li> <li>Commence Improvement Projects</li> </ul>	4 hrs
	Finance, Operations, Sales		4 hrs

## Workshop Details

Duration	Five-Day Implementation program over 4 weeks
Locations	 <b>On-Site</b> at your premises, or  <b>On-line</b> delivery through Zoom, MS-Teams, or  <b>Blended</b> Delivery
Who will participate?	Multiple teams and individuals are engaged as required, including: <ul style="list-style-type: none"> <li> Leadership Team</li> <li> Finance, Purchasing, Sales</li> <li> Production Planners, Scheduling</li> <li> Front-line production, logistics and maintenance teams</li> </ul>
Implementation Activities	‘Levelled Schedule’ Implementation Team will engage in a program of learning, discovery and implementation, including: <ul style="list-style-type: none"> <li> ‘Lean Fundamentals’ to create engagement</li> <li> ‘Green Stream Thinking’ workshop for Demand Segmentation</li> <li> ‘Kanban’ Workshop to calculate Inventory Levels</li> <li> ‘Value Stream Map’ the current state for Green Stream items</li> <li> Levelled Schedule Implementation Project</li> </ul>
Can this workshop be customised?	<b>Yes.</b> This Implementation Program is fully customised.
Can we build In-House capability and deliver ourselves?	<b>Yes.</b> We are happy to help you build In-House capability. Contact Glen for pricing.
Is this workshop available for delivery in regional locations?	<b>Yes.</b> We enjoy travelling and delivering in regional locations. We minimize travel costs. Contact Glen for an estimate of t&a costs for your location.
Is this workshop available on-line?	<b>Yes.</b> The Levelled Schedule Implementation Program can be delivered on-line.
Is there any prework required?	<b>Yes.</b> We require data for analysis and some pre-reading will be advised.
Is this workshop accredited?	<b>No.</b> For maximum flexibility, to enable customisation, and minimise cost, we do not offer accredited programs.
Is there post-workshop support?	<b>Yes.</b> We make Fridays available for ‘free’ <sup>1</sup> post-workshop support.

<sup>1</sup> Free workshop support is available any Friday – up to one hour per client company, upon booking any available slot through our Scheduling Calendar.