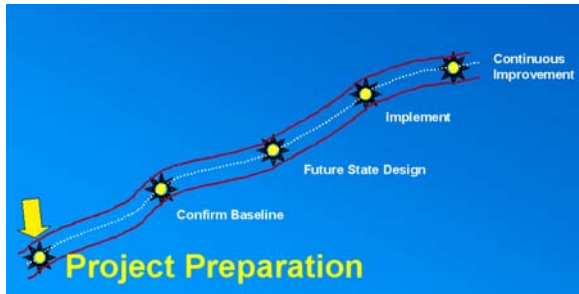
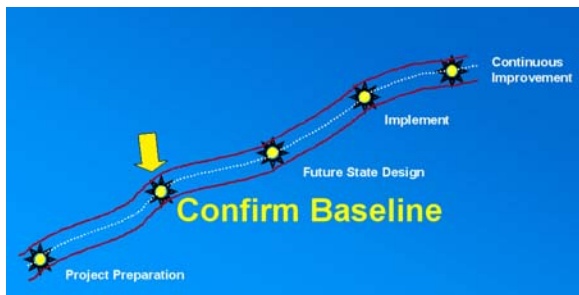


Lean Implementation Roadmap



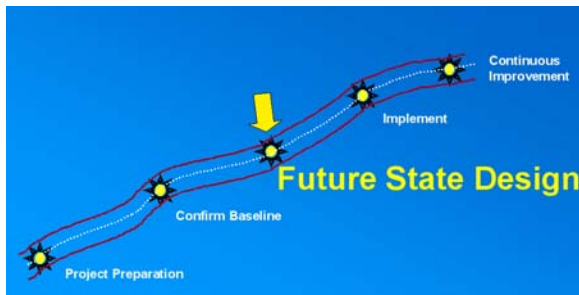
Deliverables for Phase 1 – Project Preparation (Training Days 1 & 2 – Sr. Staff)

- Project Organization (BPOG, Project Team, Implementation Teams)
- Teams Launched
 - Sponsor
 - Charter
 - Milestone Plan
 - Roles and Responsibilities
- Lean Assessment & Strategic Alignment
 - Benchmark Best Practices
 - Cell Audit
 - Market Segmentation
 - Customer Expectations (CR³)
- Competitive Analysis
- Communication Plan



Deliverables for Phase 2 – Confirm Baseline (Training Days 3 & 4 - Middle Mgmt.)

- Map material and information flow (value stream mapping)
- Current performance analysis
- Muda Matrix of 5 Key structural elements
 - Flow
 - Organizational Structure
 - Work Practices
 - Metrics
 - Materials Planning
- Design criteria defined, based on CR³s
- SIPOC Map
- Quick hit, short term improvement list
- Communication Plan



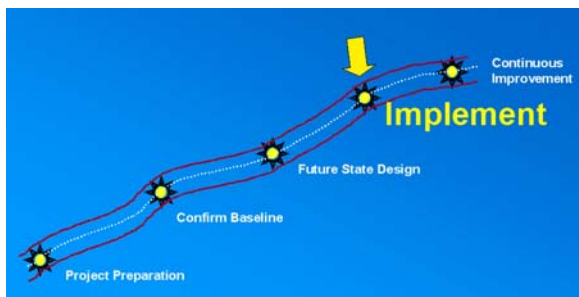
Deliverables for Phase 3 – Future State Design¹ (Training Day 5 – Middle Mgmt.)

- Demand Behavior Analysis
- Determine product groupings and production mode
- Number of Cells Required
- Revised Demand Management Process
- Block Layouts and Plant Load Profiles
- Revise Organization Structure
- Team Training for Operations Managers
- Finalize Design Criteria
- Confirm concept designs with process owners

BPOG TOLLGATE REVIEW

Deliverables for Phase 3 – Future State Design² (Training Day 6 – Middle)

- Weighted Design Criteria
- Documented cell workload analysis and staffing plan
- Initial “brown-paper” future state map
- Transition strategies
- Implementation plan
- Shop floor organization roles and responsibilities
- Confirm detailed design with process owners
- Shop floor training program
- Communication Plan



Deliverables for Phase 4 – Implement (Training Days 7 & 8 – Kaizen Teams)

- Kaizen event-based Implementation Plan
- 3-Phase Cell Transition Plan
 - Phase 1: Fundamentals
 - Phase 2: Continuous Improvement
 - Phase 3: Structural Change
- Establish baseline cell (Phase 1)
- Balance cell and Takt time
- Document standard work content
- Establish visual controls
- Create operating rules
- Intra-cell material pull
- Define team roles and responsibilities