

Technical perfection, automotive passion.

# Lean en France 6 ENST Presentation

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## Lean & Logistics Stock Reduction Processes

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ACTION

TOOLS

INDICATORS

- 1. Understand your stocks
- ABC Analysis
- Visualization
- Segmentation

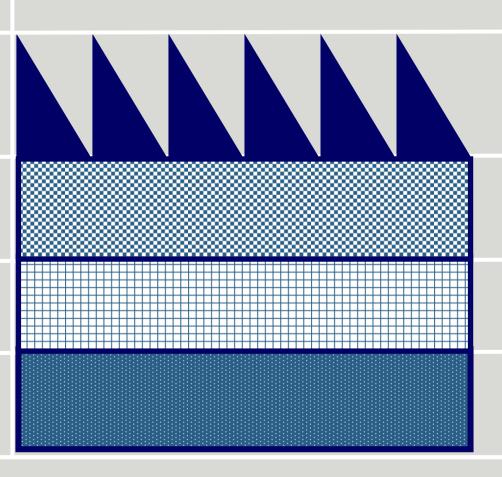
- Pareto
- Flat storage FIFO
- Stocks in € or days
- Nb of material shortage

2. Control Lead Time

3. Reduce Lead Time

### Raw Materiel inventory segmentation





Stock needed between 2 deliveries

Internal flow + supplier MPM

Safety stocks to cover transport risks

Stocks needed to cover variations of demand

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1.
Understand
your stocks

- ACTION
- ABC Analysis
- Visualization
- Segmentation

- TOOLS
- Pareto
- Flat storage FIFO
- Excel Software

- INDICATORS
  - Stocks in € or days
  - Nb of material shortage
  - Stocks in days

2. Control Lead Time

3. Reduce Lead Time

### **RM** - Supply most frequent process





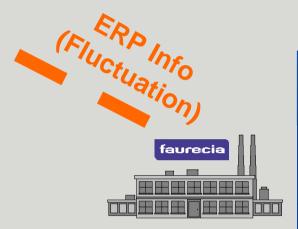
**DDP** Deliveries

Suppliers paies logistics

Supplier tries to fill up truck

Against Lead Time reduction!

MILK RUN very difficult to implement





Advanced shipment Notice

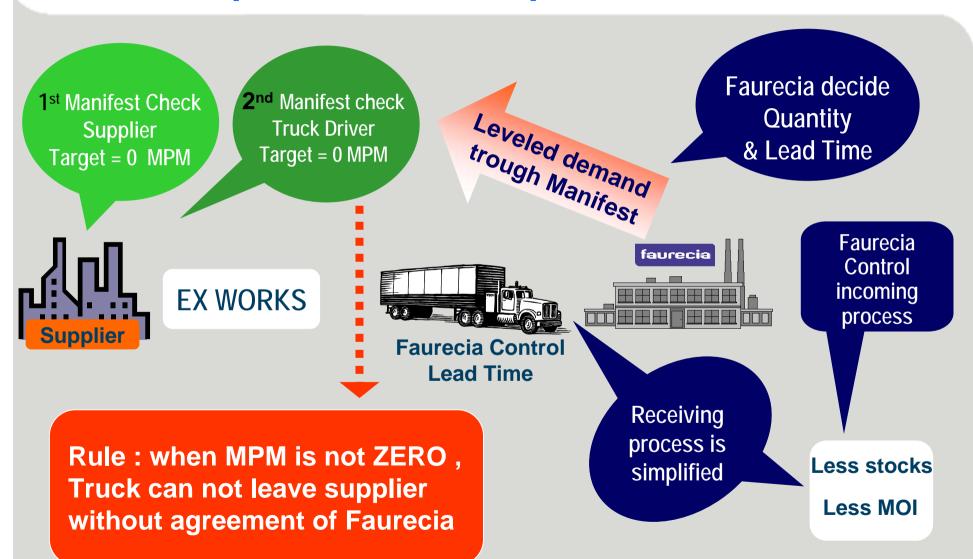
MPM RISK

Detailed check needed at receiving

MOI + Stocks

### **RM - New process to be implemented**

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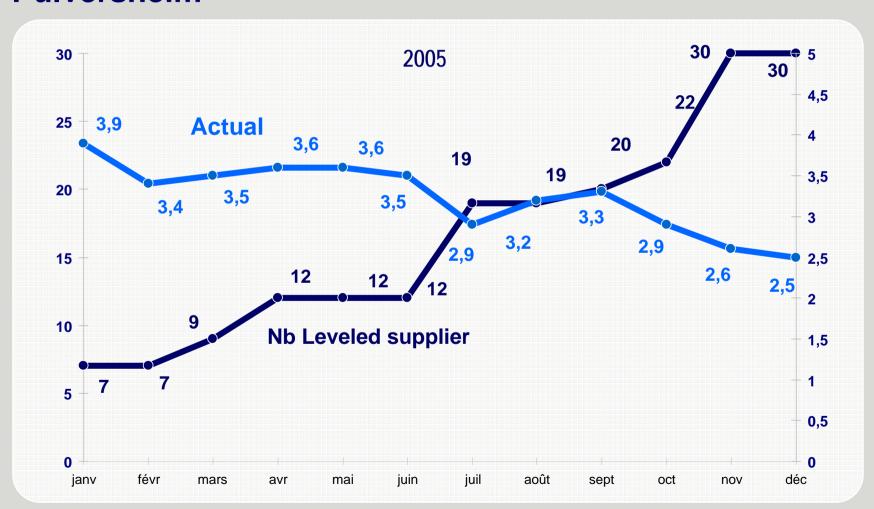
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ACTION TOOLS INDICATORS ABC Analysis Stocks in € or days Pareto Nb of material shortage 1. Understand Visualization Flat storage FIFO your stocks Stocks in days Excel Software Segmentation % suppliers Ex Works Manifest • Ex Works 2. Control Nb of leveled suppliers Leveling • LISA **Lead Time** 3. Reduce **Lead Time** 

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### Impact of suppliers leveling

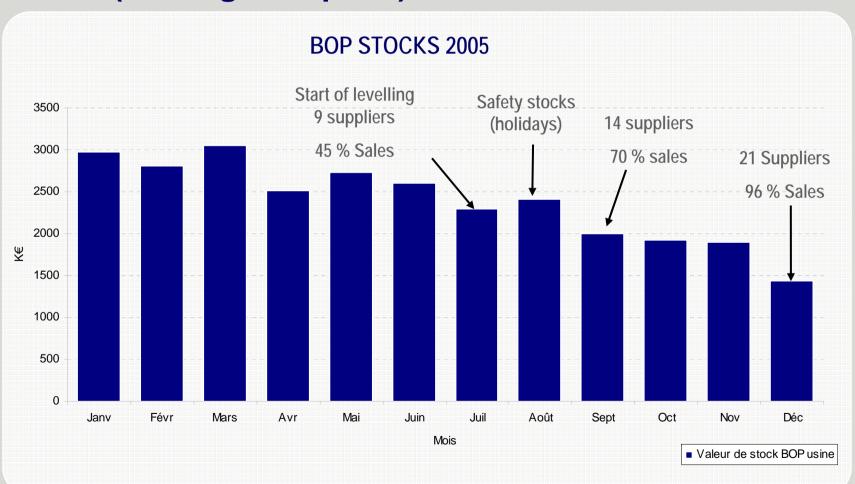
### **Pulversheim**



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### Impact of suppliers leveling

### **Crevin (Seating - JIT plant)**

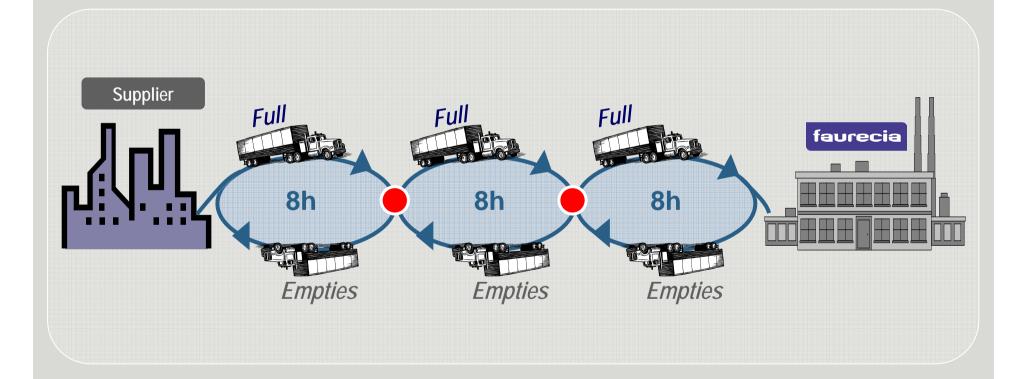


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	ACTION	TOOLS	INDICATORS
1. Understand your stocks	<ul><li>ABC Analysis</li><li>Visualization</li><li>Segmentation</li></ul>	<ul><li>Pareto</li><li>Flat storage F</li><li>Excel Softwar</li></ul>	
2. Control Lead Time	<ul><li>Ex Works</li><li>Leveling</li><li>Educate suppliers</li></ul>	<ul><li> Manifest</li><li> LISA</li><li> Alert System</li></ul>	<ul><li>% suppliers Ex Works</li><li>Nb of leveled suppliers</li><li>Supplier MPM</li></ul>
3. Reduce Lead Time	<ul> <li>Increase frequency</li> <li>Reduce transport time</li> </ul>	<ul><li>Milk runs</li><li>Switch points</li></ul>	Nb deliveries / day

### **Switch point**





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	ACTION	TOOLS	INDICATORS
1. Understand your stocks	<ul><li> ABC Analysis</li><li> Visualization</li><li> Segmentation</li></ul>	<ul><li>Pareto</li><li>Flat storage F</li><li>Excel Softwar</li></ul>	
2. Control Lead Time	<ul><li>Ex Works</li><li>Leveling</li><li>Educate supplier</li></ul>	<ul><li>MANIFEST</li><li>LISA</li><li>Alert System</li></ul>	<ul><li>% suppliers Ex Works</li><li>Nb of leveled suppliers</li><li>Supplier MPM</li></ul>
3. Reduce Lead Time	<ul> <li>Increase frequency</li> <li>Reduce transport time</li> <li>Consolidate with other plant</li> </ul>	<ul><li>Milk runs</li><li>Switch points</li><li>Cross docks</li></ul>	<ul> <li>Nb deliveries / day</li> <li>Lead Time + packaging Capex</li> <li>Frequency of Deliveries</li> </ul>

### Stock reduction process (WIP, RM, FG)



### ACTION

### TOOLS

### INDICATORS

FG

- Absorb customer fluctuations
- Pull System
- Split Stocks

- Pool stock
- Levelling board
- Kanban

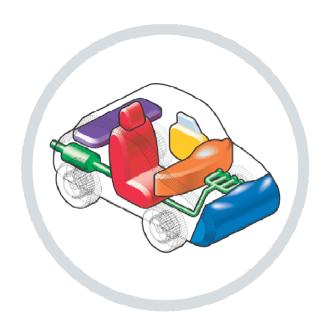
Stocks in days

MPM \_\_

**External** 

**WIP** 

- Improve quality
- Improve reliability
- Reduce batch size every part / every shift
- QR/QC
- 7 Quality basics
- TPM
- Fix batch Kanban, SMED
- PPM, Rework, scrap
- % of breakdown
- Days of stocks
- Tool change time





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