

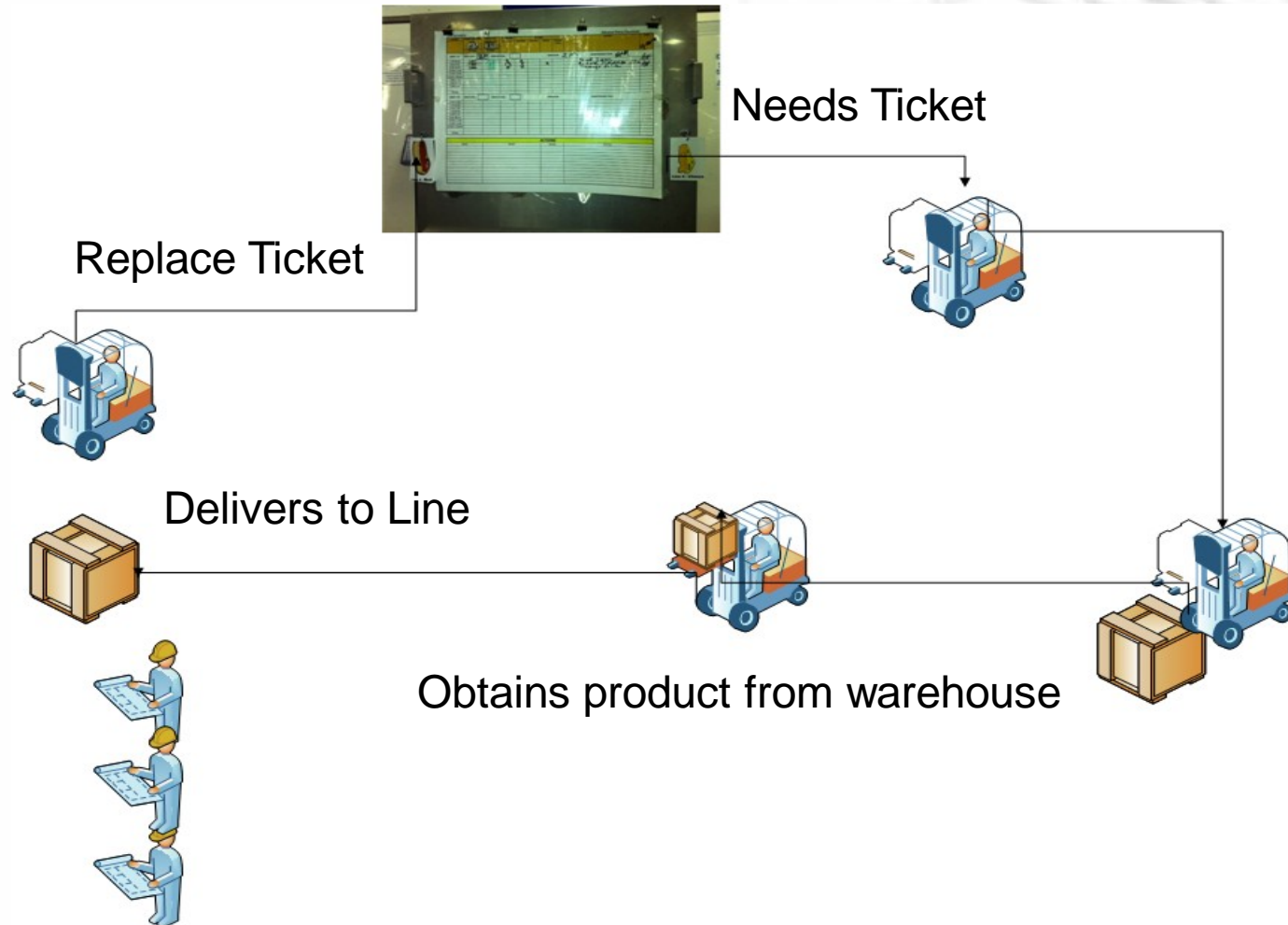
Assembly Pull System

Food Manufacturing

Kanban Cards



Kanban System



Process

- The kanban (signal) cards are located on the scorecard boards at the beginning of each line
- Two hooks are labeled – NEED and FILLED
- When the production line starts on the last row of the pallet of meats, cheeses or eggs -- The **Line Lead** places the kanban card on the NEED hook to bring another pallet out
- When ½ pallet of bread is left – The line lead places the kanban card on the need hook to bring 2 more pallets

Note: each card has the respective line number on it.

Process

- The Material Handling Group - removes the cards from the NEED hooks and goes to the respective staging area to pick the pallet(s) and return them to the appropriate production line
- Upon delivery the card is placed on the respective FILLED hook
- All of the above material is to be scanned from a location to a production line through the verification system

Benefits

- The Cheese coolers and Meat coolers added a staging area for each production line.
- Allows the material handling group to access required materials without assistance from receiving.
 - Eliminates waiting
 - Eliminates extra manpower
 - Eliminates line downtime due to material shortages
- Eliminates need for the Assembly Lead to hunt down the Material Handling
- Eliminates the need for the Material Handler to keep checking and evaluating if the line needs something