



DFC-LT-09 · The numbers behind the map. Collect at the process, on one pass, in the direction the product flows.

Walk the stream backwards from the customer and collect the data yourself. Cycle time is machine-to-machine on one piece. Lead time is how long a part waits plus how long it runs — the gap between them is the whole opportunity.

VALUE STREAM / FAMILY	MAPPED BY	DATE

CUSTOMER DEMAND

Customer demand per day (pcs)	0
Available work time per day (sec)	27,000
TAKT TIME (sec / pc)	

PROCESS DATA

#	Process step	Cycle time (s)	Changeover (min)	Uptime %	Operators	Shifts	Scrap %	Batch / EPE	Inventory after (pcs)	Inventory (days)	Process time (days)	Notes
1												
2												
3												
4												
5												
6												
7												
8												
9												
10												
11												
12												
	TOTALS	0.0			0				0	0.00	0.000	

SUMMARY — THE NUMBER THAT MATTERS

Total value-adding time (days)	0.000
Total lead time (days)	0.00
Process cycle efficiency (VA ÷ lead time)	
Total cycle time vs takt (sec)	0.0

Process cycle efficiency under 5% is normal for a first map and is not a failure — it is the size of the prize. Attack the inventory days first: they are almost always the largest block of lead time and the cheapest to remove.