

warehouse in delivering the fabric. The converting fabric into pieces cutting department send the stitching floor for the sewing process after which it is moved to checking department to check the quality of the sewing process and the defects of the fabric and then to packing department for consumer packing and palletization for shipping warehouse.

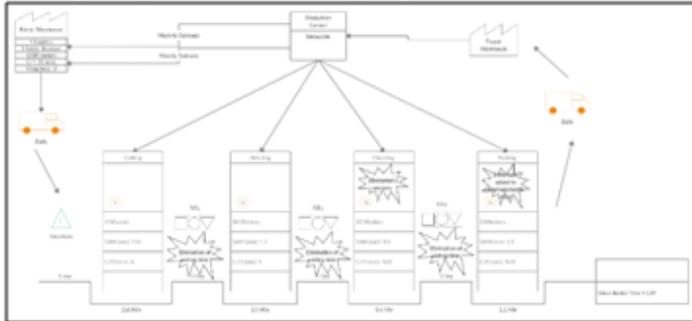


Figure 3. Current State Value Stream Mapping

3 RESULTS

The development of the value stream mapping current state which highlighted the many factors. During the process it is observed that the checking department of had the over capacity of the work force which can be eliminated to optimize the manufacturing cost of the product. The packing section was found working under capacity due to which there were bottle necks in the packing process, so the required workforce was added to eliminate the bottle neck form the packing section. The other tool to optimize the production process in future state Figure 4 was the elimination of the waiting inventory form the process and induct fifo to ensure that the gets entered in the process will be converted into the output by the end to the day, the inventory which comes form the fabric warehouse to the cutting department will not be eliminated, the reason for keeping this inventory was to ensure the availability of the raw material for the production in case of any delay.



Figure 4 Future State Value Stream Mapping

4 CONCLUSION

Lean Manufacturing is a tool used to eliminate the waste and can be applied to monitor the process or flow of production. The values stream this is one of the most powerful tools which visualize the process and eliminate waste in terms of waiting process over production or over processing. The main objective of the value stream mapping is to identify the non-value-added activities of the process and reduce the lead time of the production. The value stream mapping ultimately impacts on the in-process inventory and the production output. The working of the value stream mapping and its implementation has resulted in the reduced inventory as compare to the previous process flow of the production and great output of the finish product. The lowering of the inventory means that more lean tools can be applied and there is a room

of developing more resources for process improvement.

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