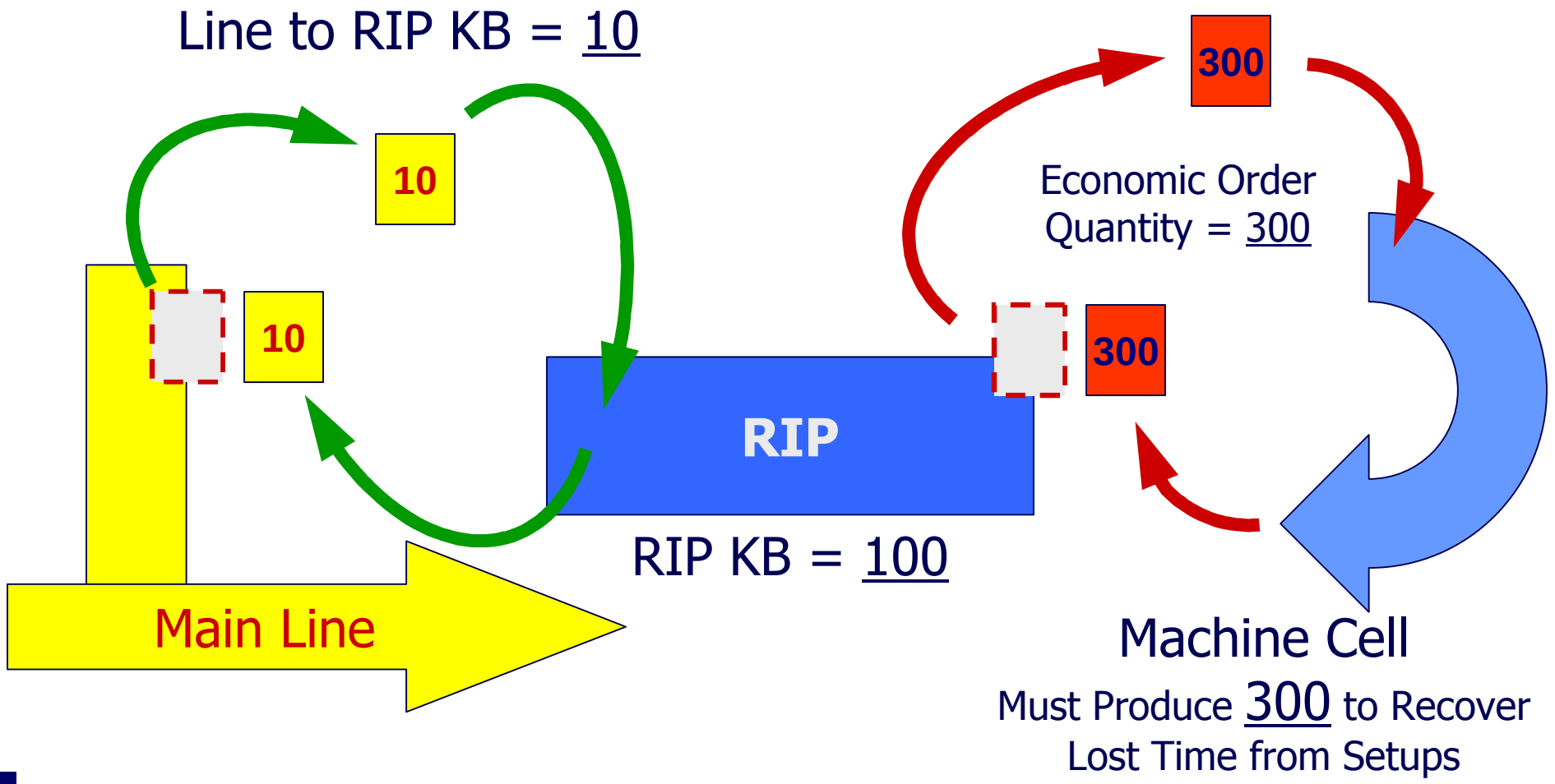
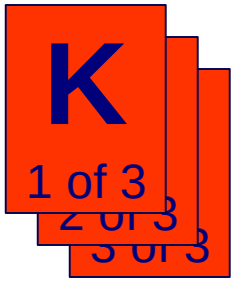
UNATTACHED FABRICATION FEEDER MATERIAL PULL STRATEGIES



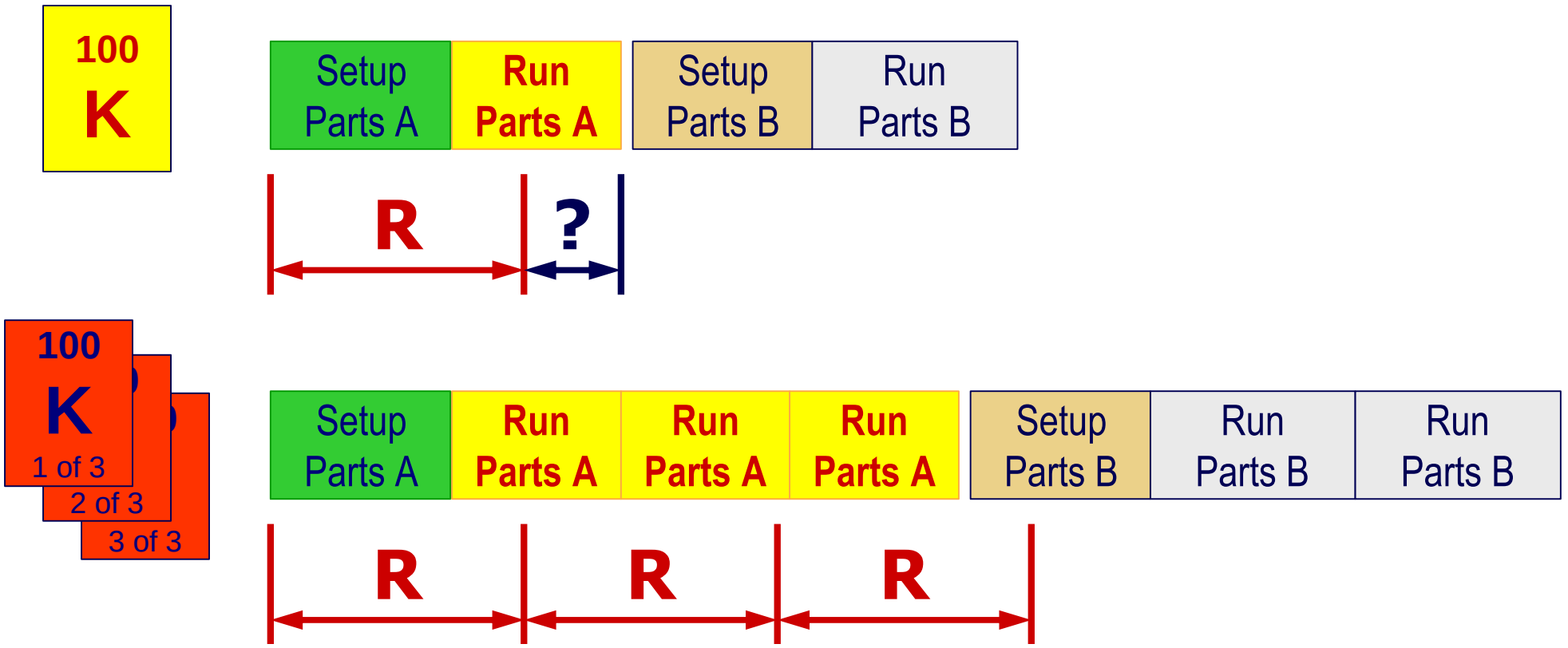
DUAL-CARD KANBAN OVERVIEW

- When we cannot Signal, Setup, Run and Move – Replenish – all Quantities demanded within the Consumption Time of the Downstream Process.
  - Long Setup Times to make Parts.
  - We need to Calculate a Run Quantity Sufficient to Recover the Lost Setup Time.
- When all Parts in a Kanban Quantity cannot fit in One Container.

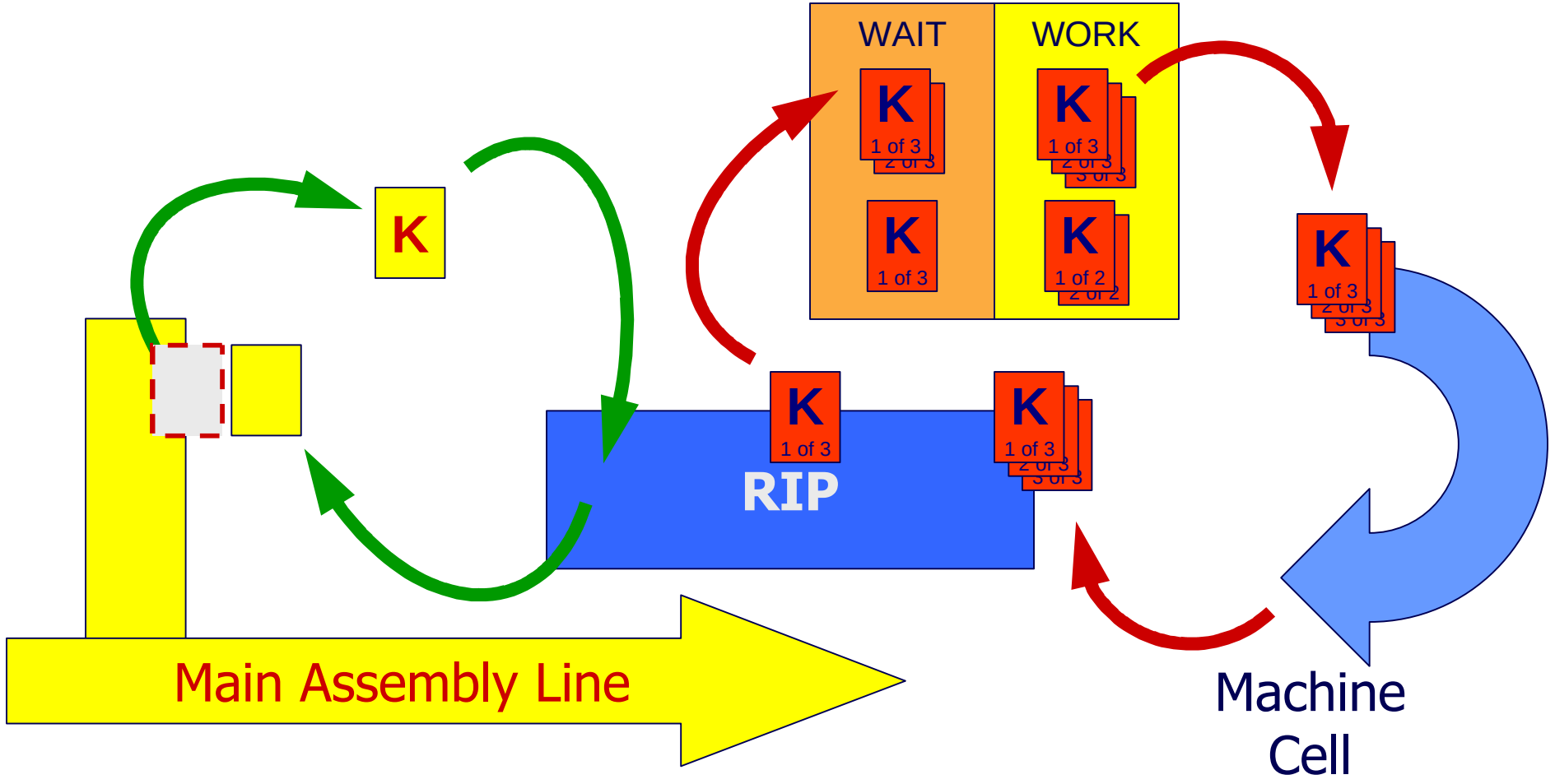
SETUP TIME = NVA



DUAL-CARD KANBAN
RUN TIME TO RECOVER LOST SETUP



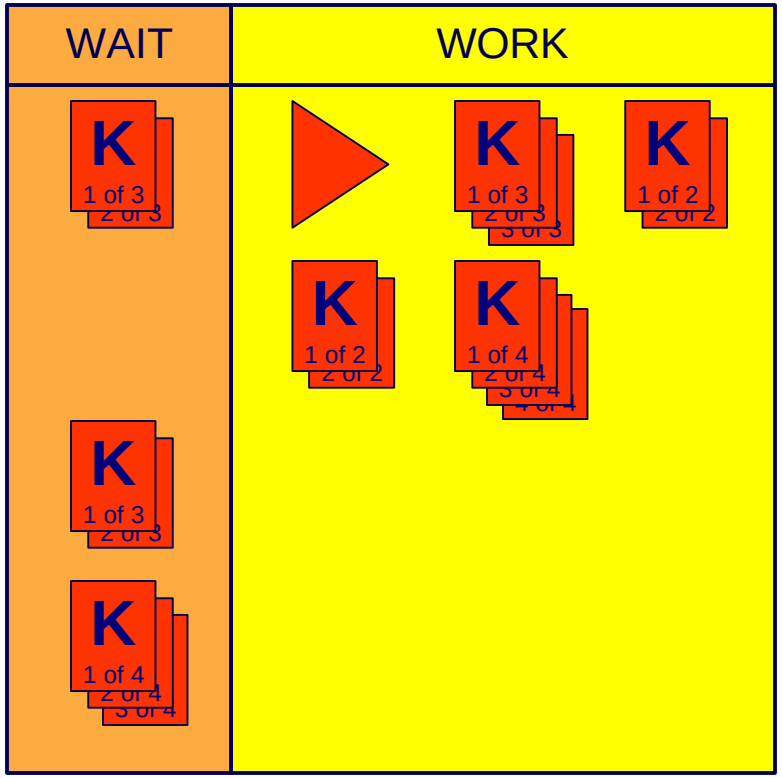
DUAL-CARD KANBAN PULL SEQUENCES CHAIN



DUAL-CARD KANBAN
KANBAN LABEL

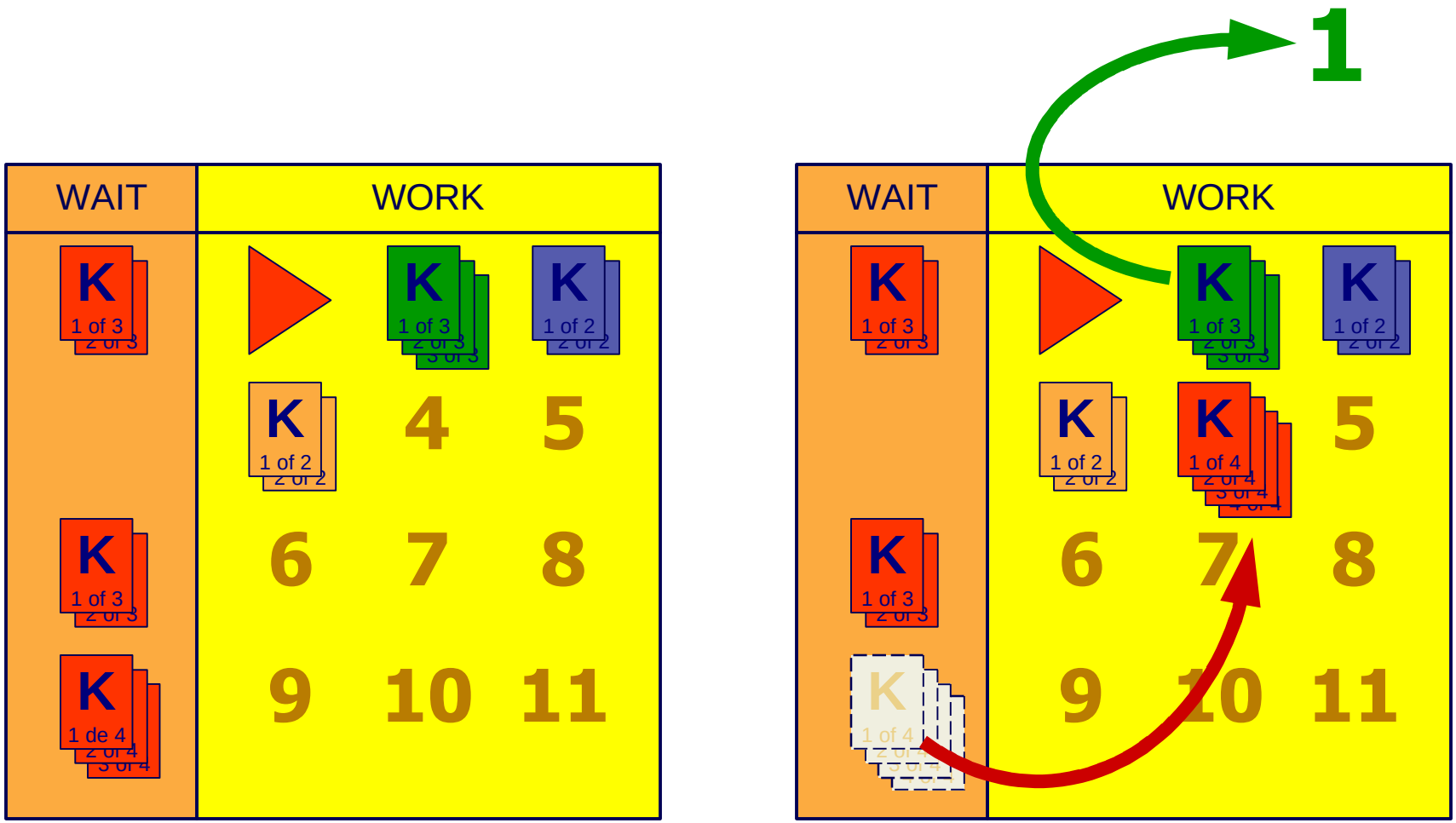
- Labels should be consistent across the organization, with following clear INFORMATION :
  - Part Identification or Item Number.
  - Description.
  - Quantity.
  - Supply Location – **"PULL FROM"**.
    - Replenishment Point.
  - Usage Location – **"DELIVER TO"**.
    - Consumption Point.
  - Position Number.

WAIT-WORK BOARD OVERVIEW

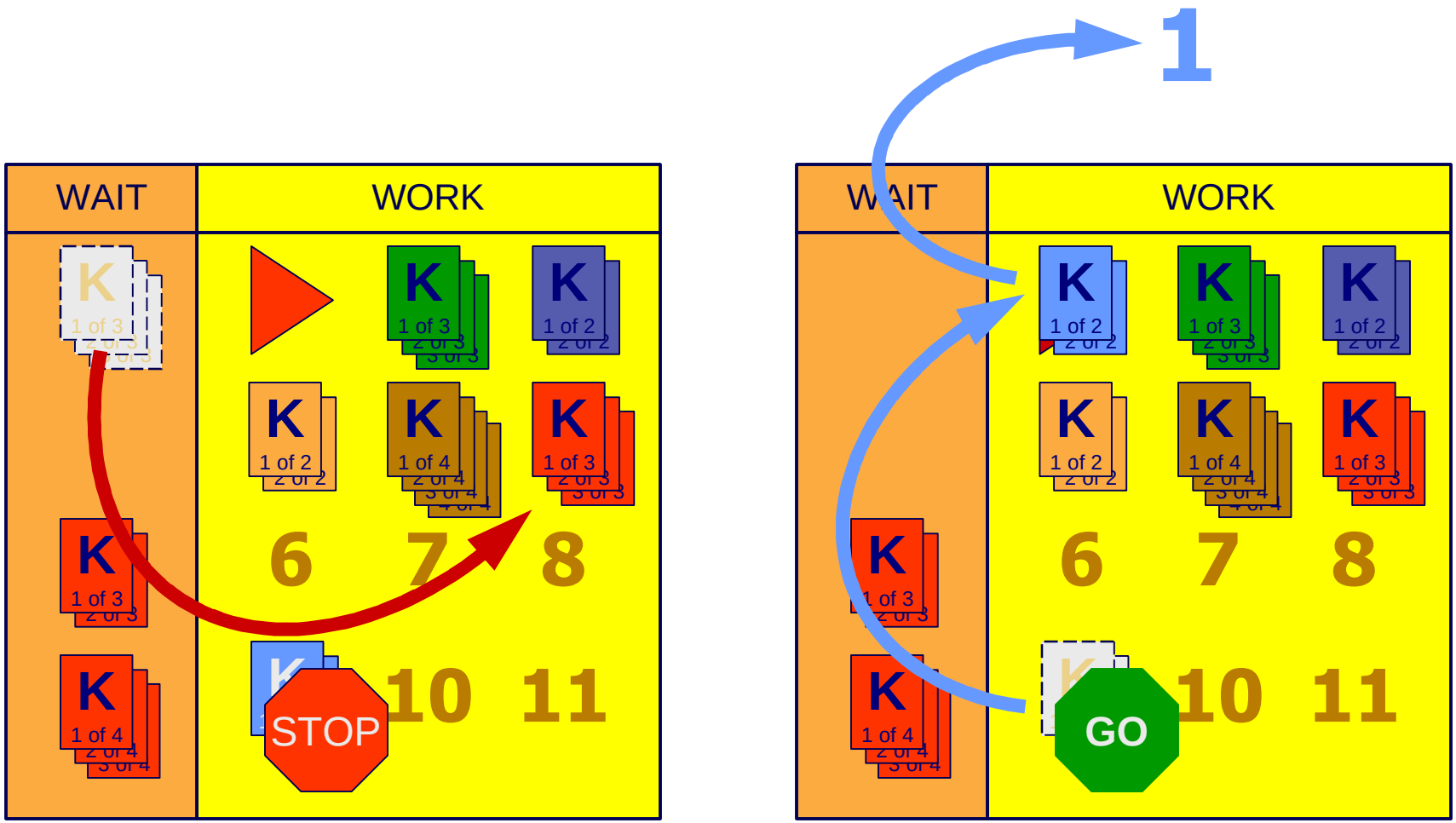


- " WAIT " Side.
  - To accumulate COMPLETE Piles of Cards.
- " WORK " Side.
  - To signal WORK when the TOTAL Required Quantity of Cards have been accumulated, in FIFO Order.

WAIT-WORK BOARD
DIRECTION OF WORK



WAIT-WORK BOARD
FIRST IN – FIRST OUT



WAIT-WORK BOARD
WHEN PROBLEMS OCCUR