The House of the **TOYOTA PRODUCTION SYSTEM**

Customers

Shortest Lead Time

Lowest Cost

Highest Quality

Just-in-Time

(right part, amount & time)

Produe to Demand (takt time)

> Flow or Pull (kanban)

Minimize Batch Size (SMED)

espect for People

Jidoka (built-in quality)

Separate Man from Machine

Stop & Make Visible (andon)

Prevent Errors (poka-yoke)

Level Production

(heijunka)

Continuous Improvement (kaizen)

Tholovee Engagement

Visible Standards (std work, 5S, etc...)

without all of its bricks, the house comes crashing down

.. and it's the people inside that feel the pain, while the customers find a new place to dwell.

