The House of the TOYOTA PRODUCTION SYSTEM

Customers

- Shortest Lead Time
  - Just-in-Time
    - (right part, amount & time)
  - Produce to Demand
    - (takt time)
  - Flow or Pull
    - (kanban)
  - Minimize Batch Size (SMED)

- Lowest Cost
  - Continuous Improvement (kaizen)

- Highest Quality
  - Jidoka
    - (built-in quality)
  - Prevent Errors
    - (poka-yoke)
  - Separate Man from Machine
  - Stop & Make Visible (andon)

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.