Using Kanban In Batch Production

Overview

In this module we’re going to discuss the signal kanban which is often used when dealing with long changeovers requiring us to produce in lots or batches. By the end of this module you’ll know what a signal kanban is as well as how a Signal Kanban System works.

Definition of a Signal Kanban

A Signal Kanban, sometimes called a Triangle Kanban, is normally used when set-up time is too long to maintain one-piece or small-lot production. These cards are usually yellow in color and triangular in shape as shown below.

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Container Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>23-8765</td>
<td>50</td>
</tr>
</tbody>
</table>

Order Point | Store Location | Lot Size |
-------------|----------------|----------|
7            | 13-B-8         | 25       |

Line No. 11

This type of system uses a triangular signal kanban as the trigger to start production while the production kanban is used to authorize the preparation of raw materials for that order. It’s important to note that this type of system only works for fixed quantity/variable frequency orders. This type of kanban system is most definitely not the ideal situation since our focus should be on attacking the long changeovers and transitioning to a 2 card kanban system and eventually to one piece flow.

We don’t want any of our customers to feel as though implementing an amazing kanban system is the end, because it isn’t. We should always strive toward no kanban since all material flows one piece at a time through the process.

Please refer to the video to see a simulation of how this type of system works.