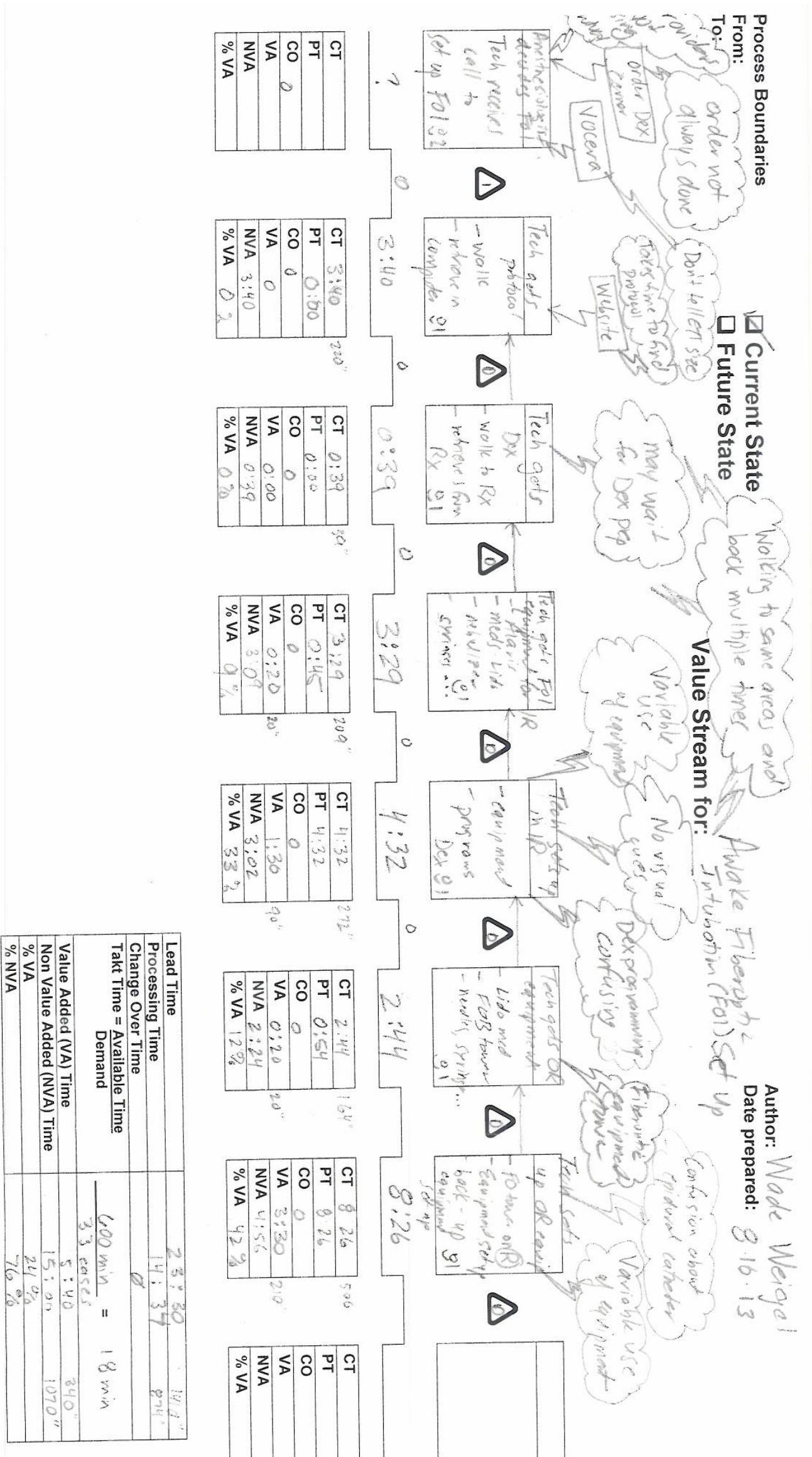


Lead Time	23:30	1414"
Processing Time	14:34	874"
Change Over Time	0	
Takt Time = Available Time / Demand	600 min = 18 min	
Value Added (VA) Time	5:40	340"
Non Value Added (NVA) Time	15:05	1070"
% VA	24%	
% NVA	76%	

**VIRGINIA MASON**  
**PRODUCTION SYSTEM**

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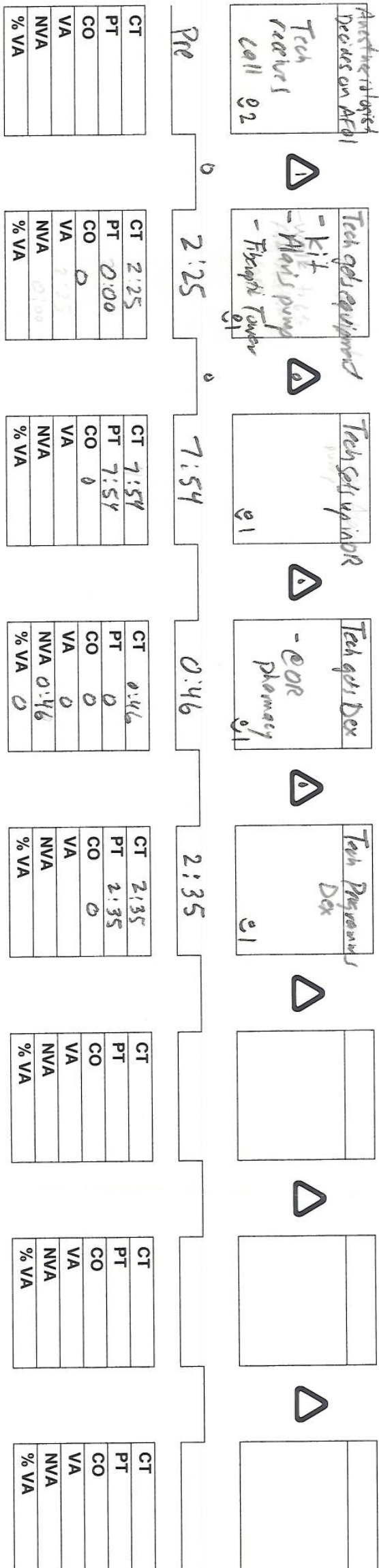


Process Boundaries  
From:  
To:

- Current State
- Future State

Value Stream for: *Aware Fiberoptic Intubation SET up*

*Author: Wade Weigel  
Date prepared: 3/19/14*



Lead Time	
Processing Time	
Change Over Time	
Takt Time = Available Time Demand	
Value Added (VA) Time	
Non Value Added (NVA) Time	
% VA	
% NVA	