

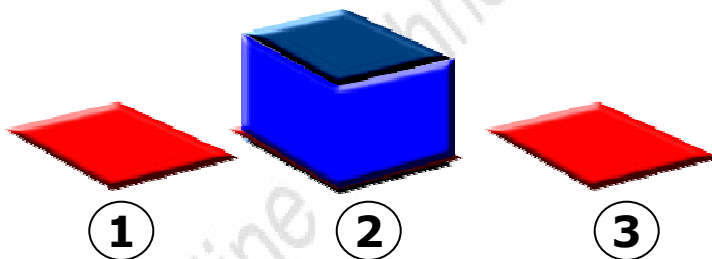
Simple kanban systems: in line Kanban

"Position" kanban or inline kanban

 Texte disponible en Français

If originally *kanban* means "sign", the usage of the method let many types of media serve as kanban; virtual kanbans, e-kanban or marked reserved spaces, "position" kanbans.

In the following example, the inventory buffer zone is divided in rows according to part numbers (displayed in red and orange). For the convenience of visual recognition, the IPK is in the color dedicated to the parts.



Red parts have two empty IPK, orange parts only one. The red line shows the **emergency state**, which means any empty IPK in front of the red line are top priority to supply. Orange parts are still available in the remaining box.

In the example above, a marked position on the ground, on a table, on a production line serves as a kanban, that works in a binary mode:

1. The position is empty and the kanban marking is apparent, it is equal to a call for supply
2. The position is occupied => do nothing
3. The position is free again => supply

Such kanban signs are sometimes called **Inline Production Kanban** or **IPK**.

IPK may be used as triggers to pull the flow, but also as regulators, as the rule allows to supply only an empty IPK place and forbids any deposit elsewhere.



Example : machine M1 has shorter cycle time than M2:

- if IPK empty => supply M2
- if IPK full => M2 saturated

Advantages:

- very simple system
- visual => everybody shares information and can understand current situation, from distance.

Utilizations:

- display location of palettes, boxes, crates...
- preparation and kitting zone
- shipping zones
- line inventory, buffer zones, feeders...
- ...

