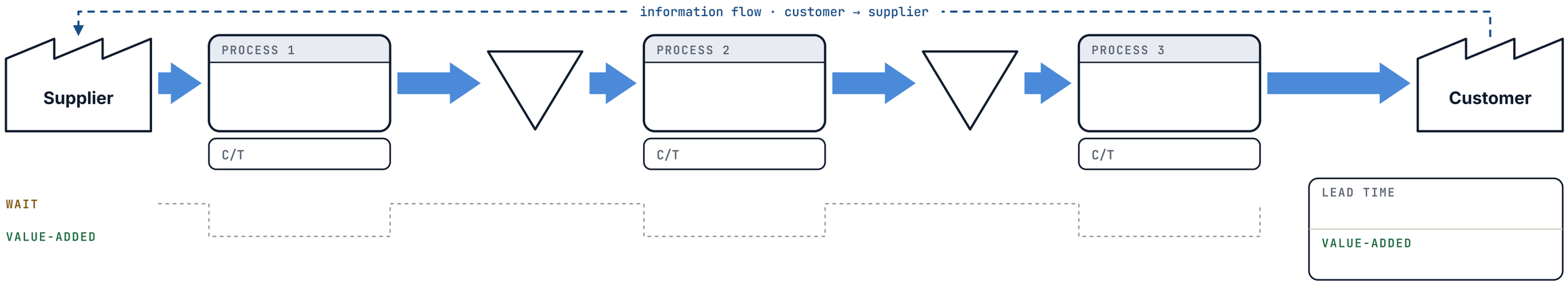
VALUE STREAM MAP (VSM) WORKSHEET · CONCLUSION

FAMILY	SCOPE	MAP	SHEET
PREPARED BY	CHECKED BY	DATE	UNIT

1 VALUE STREAM MAP · SUPPLIER TO CUSTOMER



2 HOW MUCH IS REAL WORK?

METRIC	FORMULA	VALUES	TARGET	RESULT
VALUE-ADDED	Σ C/T		—	
WAIT (INV.)	days × min/day		—	
LEAD TIME	wait + VA		—	
REAL WORK	VA ÷ lead time		≥ 25%	

3 INVENTORY TRIANGLES · PARETO

SEGMENT	DAYS	%	CUM.
Total			

4 RESULT AND ACTION

Real work =

ACTION

Owner: _____ · Review: _____