

**APPENDIX F**

**F: Analysis of Supply Chain Parameters with Lean Tools**

Supply chain parameters	JIT production	JIT Inventory	optimal cycle time	quality improvements	reduced inspections	optimal batch size	lead time reduction	setup cost reduction	reduced rework
No. of plants	26	27	31	48	34	24	16	10	12
Lean Tools Used	No. of plants using the lean tools								
kaizen	17	24	24	32	14	12	9	5	12
JIT/pull system	7	12	13	13	7	9	8	2	2
Safety Practices	2	4	2	3	5	1	0	0	2
six sigma	6	6	12	13	8	6	4	0	1
kanban	7	10	9	18	6	8	4	3	1
pokayoke	3	3	4	7	4	4	1	1	2
TPM	4	4	3	7	4	0	1	5	1
TQM	5	3	3	8	9	3	2	3	1
VSM	8	12	10	17	6	8	5	4	1
5S	17	10	16	25	7	4	6	3	4
R&D	2	4	2	2	5	4	3	1	1
SPC	4	4	0	3	2	1	1	2	1
hoshin planning	1	4	1	2	5	4	0	0	0
TPS	6	5	8	8	5	4	2	0	0