

I have ran several Kaizens on warehousing. A lot has to be considered to 'right-size' your warehouse to accommodate the myriad of items, articles, fixtures, fittings and materials. Once you have determined your volumes, capacities and 30 – 60 – 90 days forecasts (which are always wrong) we can begin a value stream mapping with a plan for every part.

This 5 days workshop included the design of a truck trailer parking lot to allow for management loading of trailers. Above are my AutoCAD drawings of the first draft to that plan.

Mapping out the process...

Once the truck trailer parking sign posts were install I printed out and laminated this mockup of the so-called trailer parking lot. This was adhered to a magnetic whiteboard and cutouts of magnetic tape wet erase trailer icons positioned according to the outside real world with identifying trailer numbers.

Much like the old fashioned air traffic control the strips are mounted in a boot and the then placed to the coordination parking location.

Inbound outbound scheduling visual display MDI boards. Staying with the old fashion air traffic control flight information strips the information of in-coming traffic is displayed on one MDI board and the out-going traffic is displayed on the other side posted to a time schedule.

## WAREHOUSE LAYOUT FACTORS

In no particular order I think we should consider these four basic factors as F.A.S.T:

- **FLOW**
  - LOGICAL FLOW OF PEOPLE / MATERIALS / VEHICLES
    - PEOPLE
      - Dedicated walkways
        - SC2
      - Location of main aisles
        - SC2
      - Safety requirements
        - SC1 and SC2 combined
    - MATERIALS
      - Raw
        - Carded Bales
          - How many and storage locations?
        - Color resin containers
        - Headers
          - SC1 / SC2 requirements?
        - Surfactants
          - SC1 / SC2 requirements?
        - Shrink wrap rolls
        - Cores racks
          - SC1 / SC2 requirements?
      - Work in process
        - Scrap / rework
          - End cuts
            - SC2
          - Drop cuts
            - SC2
          - Q2 rolls
            - SC2
          - Slab waste
            - SC2
          - Purge waste
            - SC2
          - Spin waste
            - SC2
          - Quarantined Hold products
            - SC1 / SC2
          - Trial Materials
            - SC1 / SC2 /
    - Finished goods
      - Rolls
        - SC1

F.A.S.T. This is the acronym that I have used to focus on laying out a warehouse.

- Flow
- Accessibility
- Space
- Throughput

Check it out...

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- **ACCESSIBILITY**
  - MOVEMENT AND TRANSPORTATION OF MATERIALS / MOVEMENT AND TRANSPORTATION OF MAINTENANCE REQUIREMENTS / MOVEMENT OF PEOPLE
    - **MATERIALS**
      - Bales – Access and Transportation Requirements
        - Transportation of raw bales
          - Move bales receiving to west bay docks and storage location to east bay area
      - SC1
        - Core carts?
          - Receive, transportation, storage, point of use storage and return considerations?
        - Slab waste?
        - Color resins?
        - End cuts?
      - SC2
        - Core Carts
          - Receiving, transportation, storage, point of use storage and return considerations?
        - Slab waste?
        - Color resins?
        - End cuts?
      - Work in process

**Accessibility Considerations:-**

- Receiving materials by the the truck load to the pallet to the box to the stock keeping unit levels
- Transportation and mobility of maintenance requirements vehicles

- **MAINTENANCE**
  - SC1
    - Reicofil
      - Extruder screws?
      - Press rolls?
      - Changing forming belt?
      - Transportation of forming belt cart?
      - Access and transportation of die pack cart?
    - Calender
      - Embossment / smooth rolls maintenance service and possible change outs?
      - Access of heavy equipment such as cranes, flatbed trucks etc.?
    - Winder
      - What maintenance considerations?
    - A Frames
      - Transverse transportation for reclaim to Erema room considerations
    - A-Frame

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- **SPACE**
  - CONSIDERATIONS OF SPACE TO VALUE ADDED FUNCTIONS AND ASSOCIATED PROCESSES
    - How much Q1 available space
      - SC1 / SC2 / Carded?
    - How much Q6 and Q2 available space
      - SC1 / SC2 / Carded?
  - Cubic as well as square free standing area considerations such as pallet rack space possibilities?

**Space considerations:-**

- Space for maintenance offices new locations?
- Space for maintenance large part storage?

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