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Volume 22, 2009 - Issue 4: The Challenges of Manufacturing in the Globally Integrated Economy. Guest Editor: Robin G. Qiu

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**Articles** 

# The search for the optimal number of kanbans in unstable assembly-tree layout systems under intensive loading conditions

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Pages 315-324 | Received 07 Dec 2007, Accepted 04 May 2008, Published online: 06 Apr 2009

A https://doi.org/10.1080/09511920802206427 66 Cite this article

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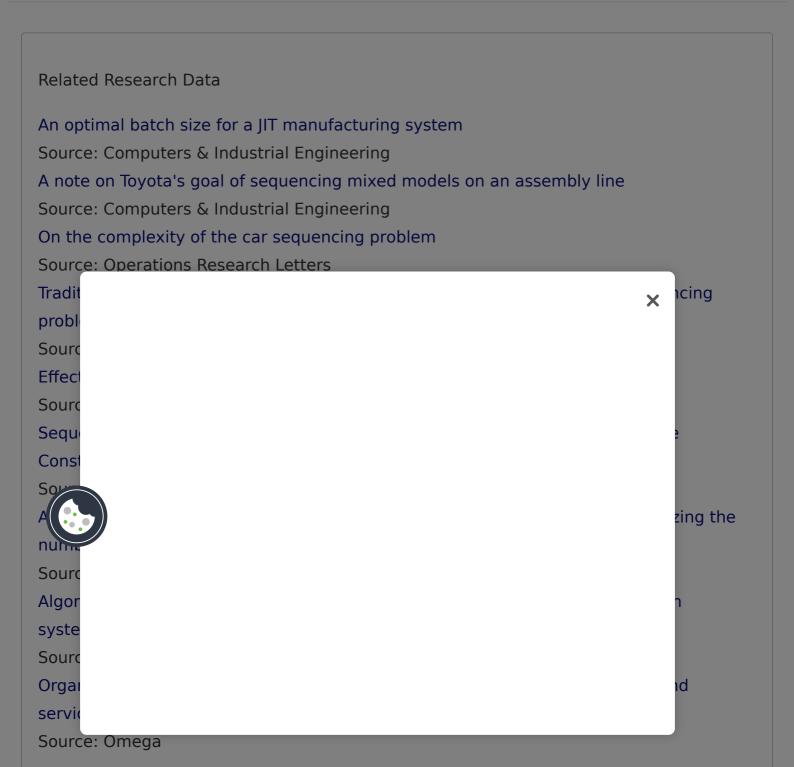
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of the number of kanbans depends both on the management method chosen at each stage of the process as well as on the fluctuation of operative variables. This study deals with the problem of choosing the optimal number of kanbans in a multi-stage productive environment organised in an assembly-tree layout. In particular, this paper proposes a heuristic procedure to determine the number of kanbans and compares it with the traditional methods applied in manufacturing contexts.

#### Keywords:

just-in-time system kanban simulation



A new heuristic method for mixed model assembly line balancing problem Source: Computers & Industrial Engineering A comparative analysis of sequencing heuristics for solving the Toyota Goal Chasing problem Source: Robotics and Computer-Integrated Manufacturing The relationship between JIT practices and type of production system Source: Omega An overview of design and operational issues of kanban systems Source: International Journal of Production Research The production performance benefits from JIT implementation Source: Journal of Operations Management Simulation analysis of a pull-push system for an electronic assembly line Source: International Journal of Production Economics Algorithms for the car sequencing and the level scheduling problem

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