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this monograph presents a reliable methodology for characterising the energy and eco efficiency of unit manufacturing processes the specific energy consumption sec will be identified as the key indicator for the energy efficiency of unit processes an empirical approach will be validated on different machine tools and manufacturing processes to depict the

relationship between process parameters and energy consumptions statistical results and additional validation runs will corroborate the high level of accuracy in predicting the energy consumption in relation to the eco efficiency the value and the associated environmental impacts of manufacturing processes will also be discussed the interrelationship between process parameters process value and the associated environmental impact will be integrated in the evaluation of eco efficiency the book concludes with a further investigation of the results in order to develop strategies for further efficiency improvement the target audience primarily comprises researchers and experts in the field but the book may also be beneficial for graduate students

in the 1950 s the design and implementation of the toyota production system tps within toyota had begun in the 1960 s group technology gt and cellular manufacturing cm were used by serck audco valves a high mix low volume hmlv manufacturer in the united kingdom to guide enterprise wide transformation in 1996 the publication of the book lean thinking introduced the entire world to lean job shop lean integrates lean with gt and cm by using the five principles of lean to guide its implementation 1 identify value 2 map the value stream 3 create flow 4 establish pull and 5 seek perfection unfortunately the tools typically used to implement the principles of lean are incapable of solving the three industrial engineering problems that hmlv manufacturers face when implementing lean 1 finding the product families in a product mix with hundreds of different products 2 designing a flexible factory layout that fits hundreds of different product routings and 3 scheduling a multi product multi machine production system subject to finite capacity constraints based on the author s 20 years of learning teaching researching and implementing job shop lean since 1999 this book describes the concepts tools software implementation methodology and barriers to successful implementation of lean in hmlv production systems utilizes production flow analysis instead of value stream mapping to eliminate waste in different levels of any hmlv manufacturing enterprise solves the three industrial engineering problems that were mentioned earlier using software like pfast production flow analysis and simplification toolkit sgetti and schedlyzer explains how the one at a time implementation of manufacturing cells constitutes a long term strategy for continuous improvement explains how product families and manufacturing cells are the basis for implementing flexible automation machine monitoring virtual cells manufacturing execution systems and other elements of industry 4 0 teaches a new method value network mapping to visualize large multi product multi machine production systems whose value streams share many processes includes real success stories of job shop lean implementation in a variety of production systems such as a forge shop a machine shop a fabrication facility and a shipping department encourages any hmlv manufacturer planning to implement job shop lean to leverage the co curricular and extracurricular programs of an industrial engineering department

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