**Lean Tape Exercise**

1. **Set-up layout…2 pieces of tape about 10 feet long that are parallel to each other, place chairs or objects (barrier) in the middle of the tapped area.**
2. **Split group into two teams**
3. **Place groups on outside of opposite tape sides**
4. **Provide Directions:**
* **Teams must switch sides**
* **They will be timed in doing this**
1. **Now that they have completed…give them their times**
2. **Now ask them if they can do it faster:**
* **Teams must switch sides**
* **They will be timed in doing this**
1. **Repeat for 3 to 5 times until they get a faster time**

**Note for Instructor:** The object is to eliminate barriers in the process, cut-back on the time it takes to complete the process. Eventually, the team will realize they can move the barriers within the tape and eventually figure out they can move the tape as well.

**Note for Instructor:** The fastest time this can be done in is 1 second, but you cannot provide this answer until the exercise has been completed.

**Note for Instructor:** The final outcome to be discussed is the barriers that were implemented for the exercise, the initial or assumed rules, and what kept them from achieving the fastest speed.

**Note for Instructor:** In order to relate to Lean Operations, Manufacturing, or Management…what are the barriers to the process. The intent is to derive the concepts and context of the operation in order to ensure proficiency through process changes.