This map shows the entire lead time for product to come from the concept as a raw material to delivery to the end user in the current state. The principal measures in this map include Lead Time, value added and Process Cycle Efficiency. Sensitivity is apparent, and the engine manufacturer is the central player in lead time capacity to meet demand so their in-control state is a limiting factor.

There is no commentary herein about improving the Process Time or eliminating Waste within any one operation. This map attempts only to view the Whole System on the map.