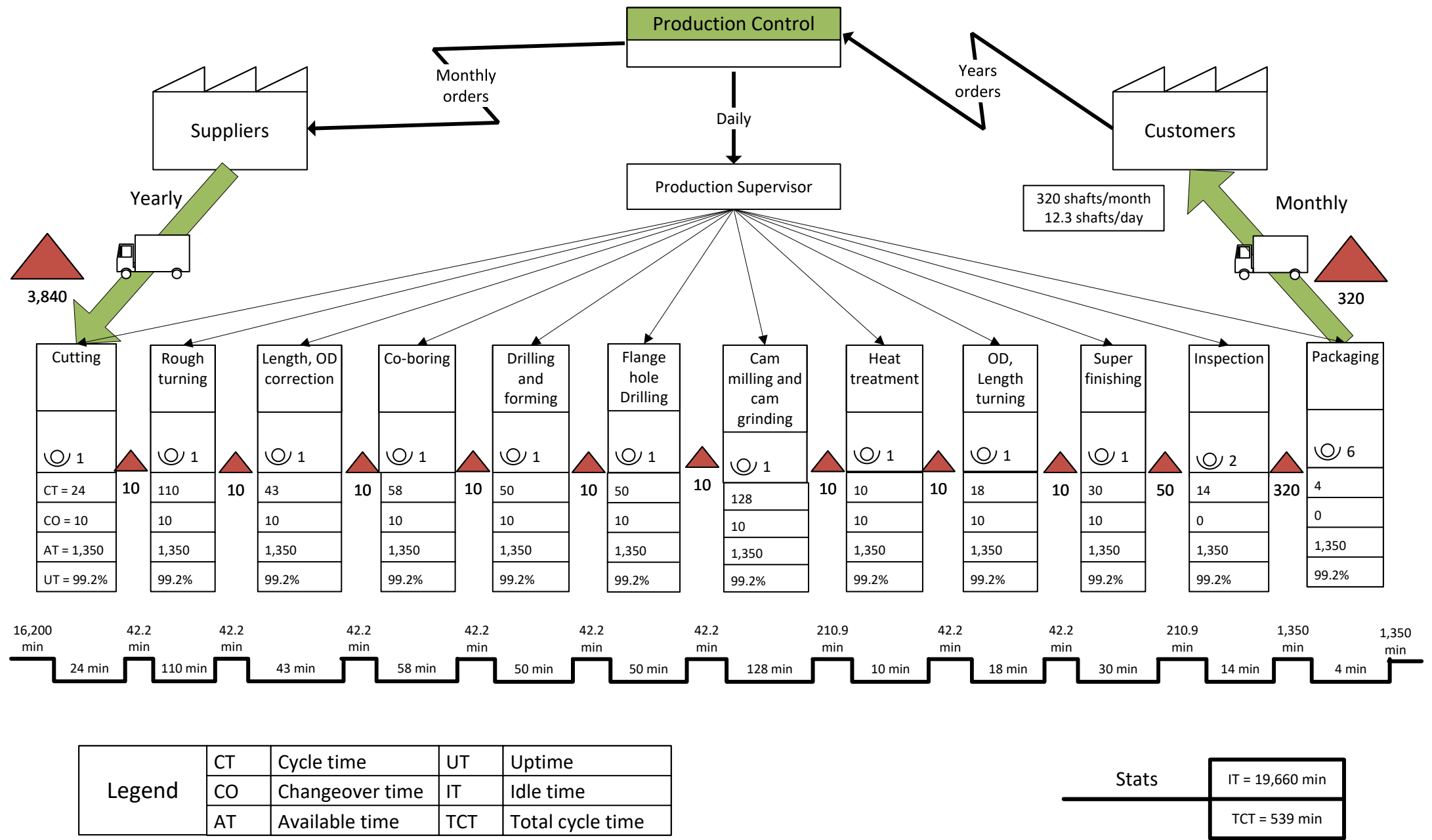
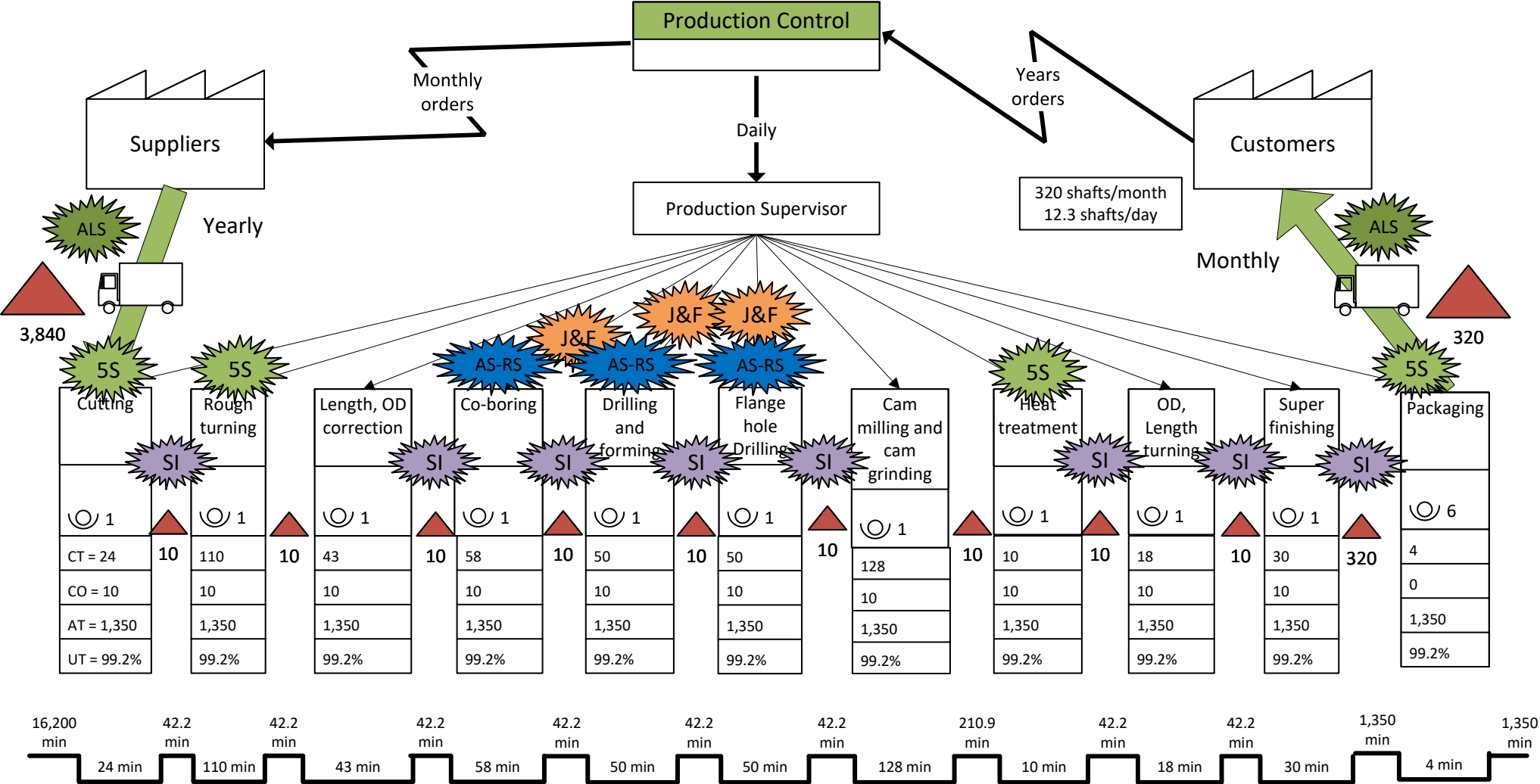


Current State Map – Stiffer Cam Shaft Manufacturing



Future State Map – Stiffer Cam Shaft Manufacturing



Legend	CT	Cycle time	UT	Uptime	J&F	Jigs & Fixtures
	CO	Changeover time	IT	Idle time	AS-RS	Automatic Storage and Retrieval System
	AT	Available time	TCT	Total cycle time	SI	Stage Inspection
	5S	The 5S Principle	ALS	Advanced Logistics System		

Stats	IT = 19,660 min
	TCT = 525 min