

C4-B

Used Space in Work-Site

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PE Manager	PE SPV	PE Engineer

CONFIDENTIAL

Rev.01

- ① Purpose of “**Used Space in Work-Site**”
- ② Grasp used space and area rate.
- ③ Consideration of mixed production on the same line.
- ④ Pursue efficiency of used space.



Purpose

To **understand used space in production area** and **pursue area efficiency** with awareness of cost.

❖ “**Used space in production area**” – areas under production’s control such as production line, kitting area, indirect material warehouse.



RULES

#1

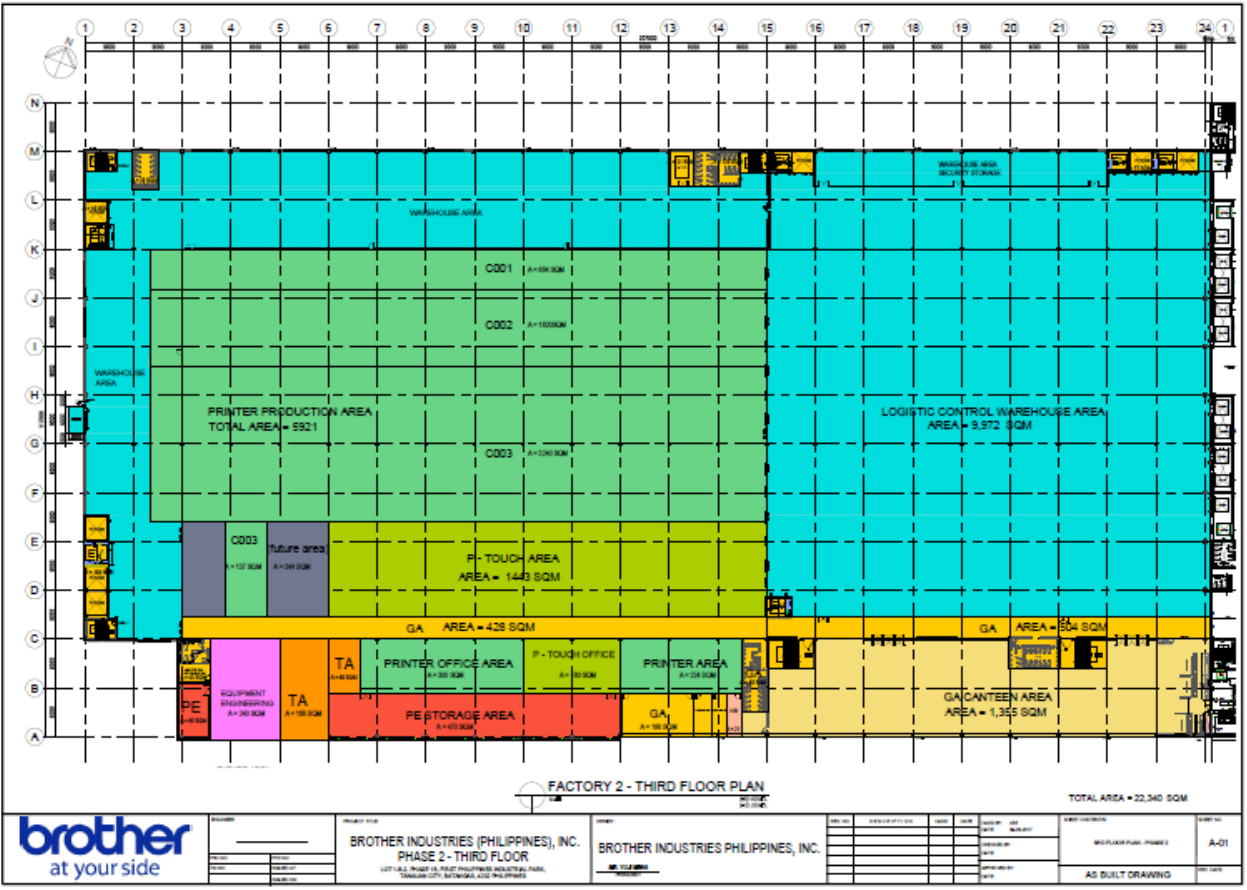
Must grasp used space and area rate per square meter.

Must be able to answer the used space and its area rate per square meter.

- ❖ Should grasp the used space at the time of layout change.
- ❖ Should obtain information from area management section (General Affairs) and budget control section (Finance).



Grasp Used Space and Area Rate



Basically, only
Managers (GA and
FI) have the data of
cost per square
meter

F2-3F ACTUAL LAYOUT FEB2018
(USED AREA PER SQUARE METER IS INCLUDED IN LAYOUT BELOW)

Consideration of mixed production on the same line.

RULES

#2

Consider **mixed production** when reviewing production system of **new model** and **transfer model**.

- ❖ Item is not applicable if there is **no reviewing of production system** of new model and transfer model in the past year.

Date:	13.02.2018		
Work center:	W021	PT-Prt02_H/D	
Plant:	N102	P-Touch	

Prod.Ord#	Sales Order#	Material	Description	Total
1. New Model	4. Finished	7. For Rework	10. With DCI	
2. Cut Plan	5. On-going	8. Additional Order	11. For Test Run	
3. Last Month Del	6. Next Model	9. Advance Order	12. Priority BIL & Shipping	

000111018246	0124639097/000010	8VA135J6502	PT-H110	216
000111005745	0124703778/000010	8VA135J6502	PT-H110	216
000111005760	0124703774/000010	8VA135J6502	PT-H110	216
000111005809	0124703773/000010	8VA135J6502	PT-H110	216
000111005783	0124703691/000010	8VA135J6502	PT-H110	216
000111005769	0124703776/000010	8VA135J6502	PT-H110	216
000111005771	0124703758/000010	8VA135J6502	PT-H110	111
000111005799	0124703775/000010	8VA135J6502	PT-H110	216
000111005747	0124703779/000010	8VA135J6502	PT-H110	207
000111005854	0124703690/000010	8VA135J6502	PT-H110	216
000111005750	0124703912/000010	8VA135J6325	PT-H110	120
000111005759	0124703815/000010	8VA135J6587	PT-H110	204
000111005780	0124703814/000010	8VA135J6587	PT-H110	216
000111005873	0124703994/000010	8VA136U4002	PT-E110	180
000111005884	0124704001/000010	8VA136U4083	PT-E110VP	12
000111005875	0124703985/000010	8VA136U4087	PT-E110VP	120

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In one line, can run different models

There is a **record of considering mixed production** (if there's actual production line with mixed production, then it'll be checked in the production line).

Consideration of mixed production on the same line.

- ❑ It is desirable to think when the number of orders became low compared to the start of production of new models, and consider mixed-flow production with the same model and other models when studying the production method of the new model.
- ❑ The results of the study (to apply or not) are not required.
- ❑ Mixed-flow production is a production method that aims to incorporate the cost reduction effect of high-volume production into low-volume production. It is done to collect products with low production volumes and similar production to secure production volumes that can be effective for mass production. It is also expressed as a multiple models low-volume production.

RULES


#3 Must pursue efficiency of the used space.

Improvement of used area efficiency

【DPP14-1】Improvement of used area efficiency
使用面積効率向上

Reduction of Space

BEFORE




L=12.20m

W=3.98m

Total Area= 48.56m²

AFTER



L=10.54m

W=2.87m

Total Area= 30.25m²

Status of Activities

Line	PLAN	ACTUAL	STATUS
All Main Lines	Aug. 23 – Sept. 26	Aug. 27 – Oct. 1	DONE

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at your side

【DPP14-1】Improvement of used area efficiency
使用面積効率向上

Improvement

BEFORE

LOCATION	LENGTH (m)	WIDTH (m)	QUANTITY	AREA (sq. m)
HEAD / KITTING	17.2	12.2	1	209.84
CHASSIS / FOLDING	12.2	6.4	1	78.08
MAIN LINE 1	12.2	3.98	1	48.556
MAIN LINE 2-6	12.2	3.5	5	213.5
OFFICE	12.5	8	1	100
FINISHED GOODS	12.2	10	1	122
QUALITY GROUP	14	3.7	1	51.8
STORAGE	4.15	3.15	1	13.0725
PATHWAY 5	12.2	1.3	1	15.86
PATHWAY 6	12.2	1.26	5	76.86
PATHWAY 7	12.2	1.49	1	18.178
TOTAL AREA				947.7465

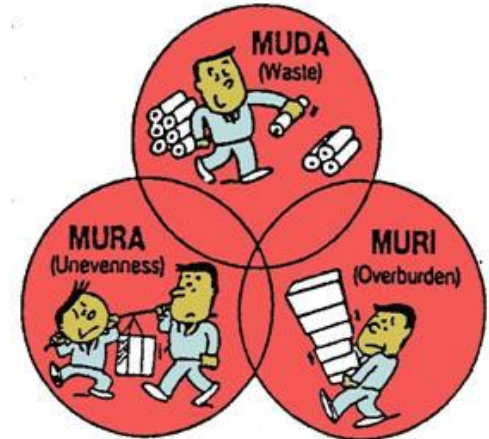
AFTER

LOCATION	LENGTH (m)	WIDTH (m)	QUANTITY	AREA (sq. m)
HEAD / KITTING	17.2	12.2	1	209.84
CHASSIS / FOLDING	10.54	6.4	1	67.456
MAIN LINE 1	10.54	3.98	1	41.9492
MAIN LINE 2-6	10.54	3.5	5	184.45
OFFICE	12.5	8	1	100
FINISHED GOODS	10.54	10	1	105.4
QUALITY GROUP	14	3.7	1	51.8
STORAGE	4.15	3.15	1	13.0725
PATHWAY 5	10.54	1.3	1	13.702
PATHWAY 6	10.54	1.26	5	66.402
PATHWAY 7	10.54	1.49	1	15.7045
TOTAL AREA				869.7763

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Pursue efficiency of used space.

- ❖ Must **conduct discussion** or **improvement of layout change** according to production plan (production fluctuation).
- ❖ Grasp **Muda, Muri, Mura** of **used space** and carry out used area efficiency improvement activity.
 - There is an activity record of used area efficiency improvement activity in the past year.



Muda, Mura, Muri on the use of area:

Muda

Idle equipment, inventory, & accessories **left unattended for layout change** and decide if not to **implement** or do the change on layout.

Mura

The **layout** or the **area** used is **different at the same line or cell**.

Muri

Locating things that **people can't pass** through them.

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