

BPAKS Sharing Sheet

Rev.1

Affiliated company

TOYOTA MOTOR THAILAND (TMT)

Shop :

Plant :

Ref. No. :
In case ykt from other source (ex.shop jiku)

Reg. No. :
for MD only

☐ Safety

☒ Cost

☐ Quality

☐ TM Development

☒ Productivity (Smooth/Slim)

I. Title :

(W) BP Man power reduction : Deck ID Card Reader Machine

II. Description :

According of cost reduction and PEFF improvement activity, (W) try to reduce MUDA and KAIZEN process for minimize cost. So, we start from TPS basic knowledge and apply new equipment to KAIZEN our process.


III. Yokoten Essence :

☐ Direct Yokoten

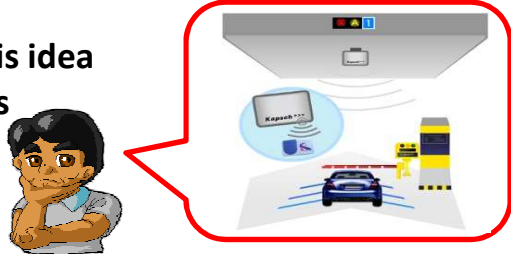
☐ Yokoten by Essence

☒ New Initiative

Idea form :EASY PASS"



How to adapt this idea to kaizen process



IV. Previous Status / Problem / Background :

Processs Lay-out

Before

9 ID Card

7 Cup Jig

6 Repair

5 Fitting

4 T/G

3 H/B

2 H/S

8

1

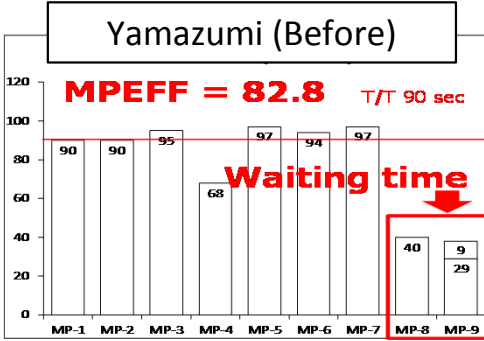
MP = 9 คน

Σ CT= 709 Sec.

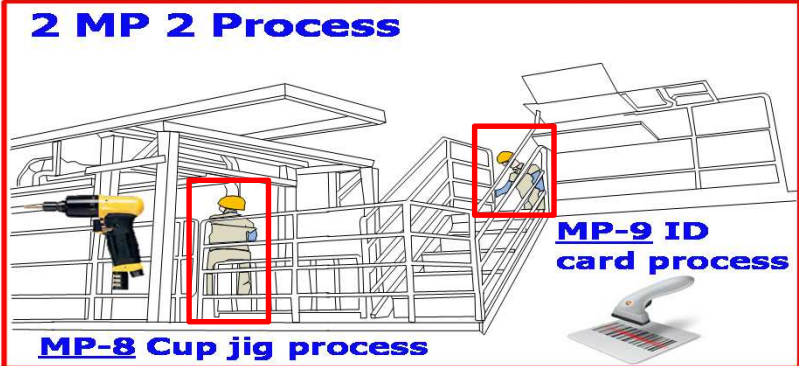
Σ TT= 986 Sec.

MPEFF = 71.90 %

Yamazumi (Before)



2 MP 2 Process



Problem

- MP-8 , MP-9 have a many waiting time.

- Ergonomic Problem from walk up-down the stairs.

Rank :

only for safety

V. Kaizen or Improvement :


Kaizen Idea

- How to reduce job scan ID card?

- It possible to change method from manual to auto scan ID card?

Trial Method

- Study for auto scan ID card by camera.



ID CARD automatic tracking
กล้อง IR
เซ็นเซอร์ SENSEX

Processs Lay-out

After

7 Cup Jig & ID Card

6 Repair

5 Fitting

4 T/G

3 H/

2 H/S

8

1

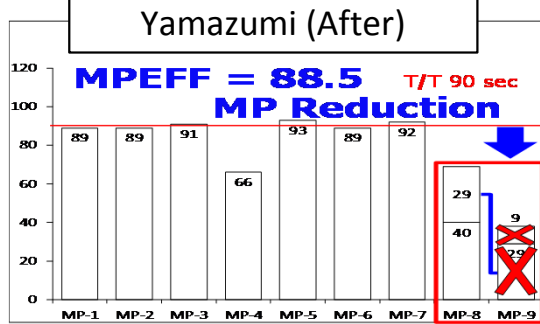
MP = 8 คน

Σ CT= 689Sec.

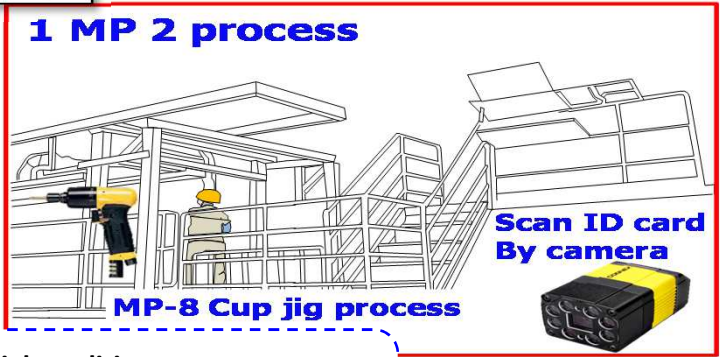
Σ TT= 896 Sec.

MPEFF = 76.89 %

Yamazumi (After)



1 MP 2 process



Improvement

- Install auto scan ID card by camera

- Balance Job from MP-9 to MP-8

TOYOTA VEHICLE ID CARD (Banpho Plant)

V144 V086 V011

V026 V001 V122 BAR_V011

A001 B132 A165 B184 B456 B487 BW11 V110

B122 B710 V227 BAR_V011 S121 S098 B487

Trial condition

Best condition Step 5 lock position by ED jig (Hood)

Rank :

Future Yokoten process expansion :

VI. Result Evaluation :

(Result KPI / Process KPI impacted from improvement)

Reduce MP : 2 Person

MPEFF : 82.8% ---> 88.5% (+5.7%)

Ergonomic : Reduce walk up-down the stair [Every cycle time]

VII. Daily Mgmt / How to maintain :

(PDCA Concept for Genba)

☐ No Need

☒ Need

☒ New Std.

☐ Review Std. sheet

☒ Control sheet for TM/TL/GL / MTN.
(Who/Method/Frequency/Abnormal Mgmt)

☐ Others

Details (or Ref. Document) :
.....
.....
.....

VIII. Approval

For safety : Rank

Rank

Investment Cost : 330,000 Baht

Cost Saving/Reduction : 1.302 MB

ROI :

Year

GM (MD dept.)

GM (PA)

GM initiator