KAIZEN:	Doors lower frames time saving		Plant - EMC:	TMMF
			Responsible:	WELDING
☐ SAFETY	☐ QUALITY	☐ COST	Effect:	-
☐ ENVIRONMENT	☑ PRODUCTIVITY	☐ OTHER	Application Time:	4 months

BACKGROUND

PROCESS :
* Welding Shell- Body : Doors lowerframes used to be inserted at S/B in the B-pillar (front L/B) & Roof side inner (rear L/B)
* Assembly Trim 1 : Lowerframes are taken from B-pillars & Roof side inner & replaced in doors before dismantling for ganishing

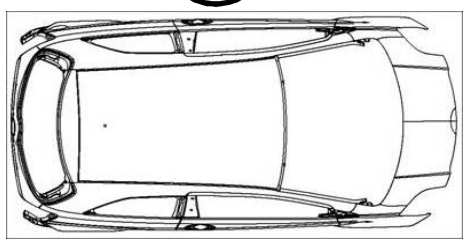
NEW CONSTRAINTS :
* welding shop : addition of new car type in weld shop (NA Yaris) = need additionnal space for Rear bumper

INITIAL CONDITION - BEFORE KAIZEN

DOORS

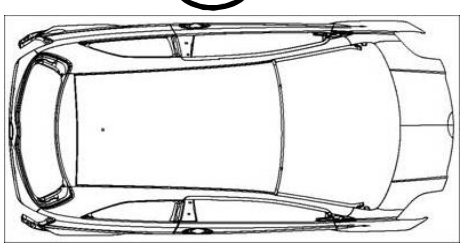
No action

SHELL BODY



T/M insert L/F in B-pillar & roof side inner 3sec x 4 = 12 sec
line side congested with
4 L/F containers

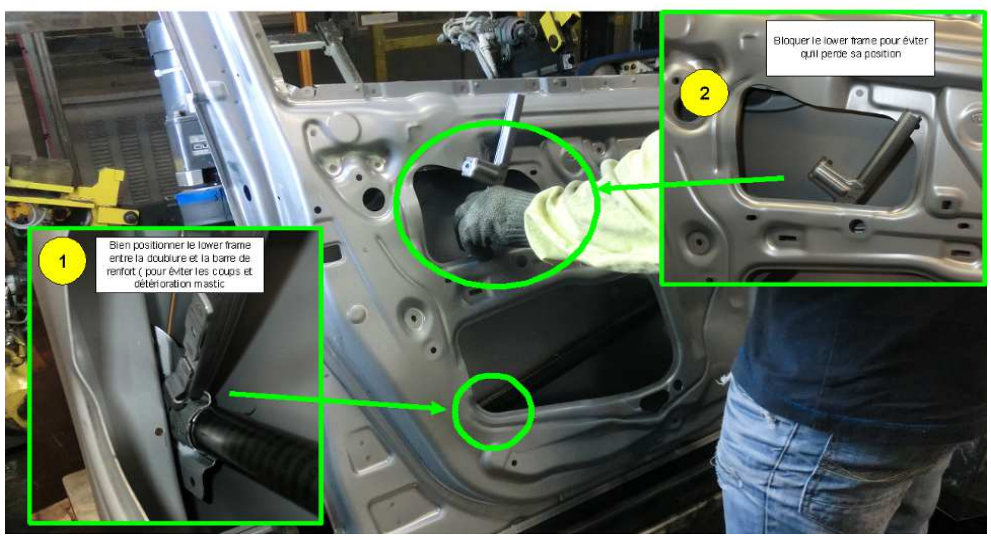
TRIM 1



T/M remove L/F from B-pillars & roof side inner & insert in doors : 3 sec x 4 = 12 sec

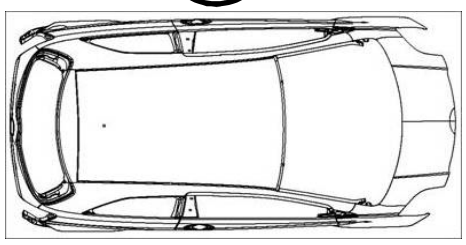
CURRENT CONDITION - AFTER KAIZEN

DOORS

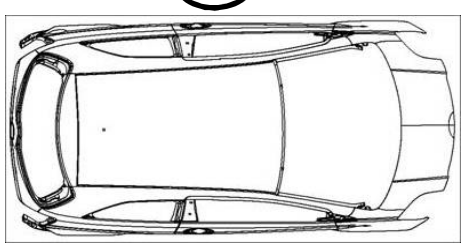


T/M insert L/F directly in the door before setting in the dolly.
Time available.

SHELL BODY



TRIM 1



no more job for lowerframes for S/B & Trim 1 T/M.
Space recovery for additionnal Rear bumper.
After rebalancing , save 1 potential additionnal process for NA Yaris

Saving : no additionnal process at S/B for NA Yaris (0,37€ / veh