

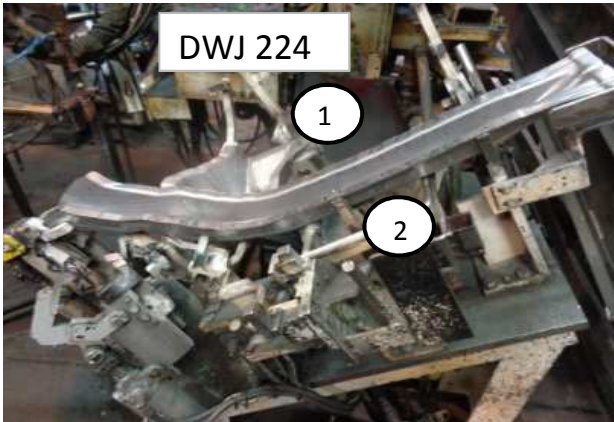
FSM MANUAL JIGS COMMONISATION

TMMF

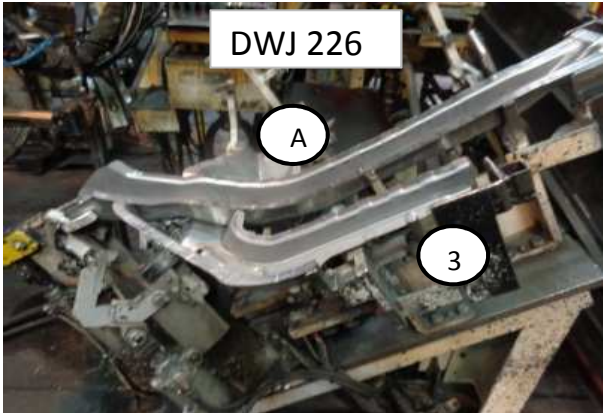
<input type="checkbox"/> SAFETY	<input type="checkbox"/> QUALITY	<input checked="" type="checkbox"/> COST	<input checked="" type="checkbox"/> YOKOTEN SbS
<input type="checkbox"/> ENVIRONMENT	<input checked="" type="checkbox"/> PRODUCTIVITY	<input type="checkbox"/> OTHER	

BACKGROUND - INITIAL CONDITION - BEFORE KAIZEN

Initially, 2 manual jigs to assemble FS/M rear part RH



PROCESS 1 :
1 man process : 1 gun 4 spots C-Gun
assemble -1-Fr side inner rr x - 2-torque box

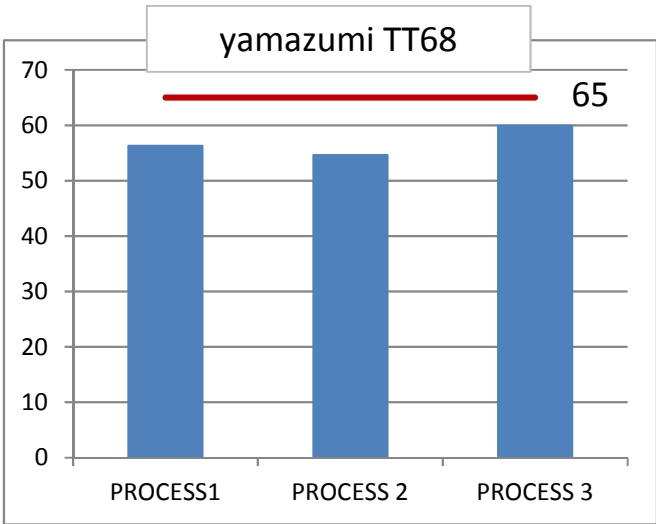


PROCESS 2 :
1 man process : 2 guns 4 spots C-Gun 3 spots X-Gun
assemble A-DWJ224 sub assy x -3-fr susp mbr rr

Same for LH

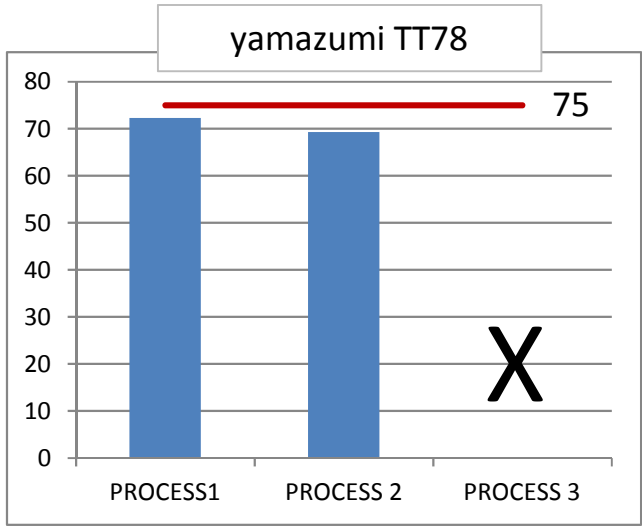
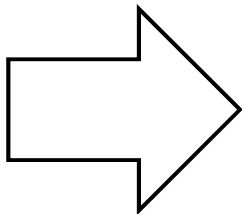
BENEFITS AND TARGET

Kaizen = Commonisation of the 2 jigs



ΣCT =170,8 sec

saving = 29 sec

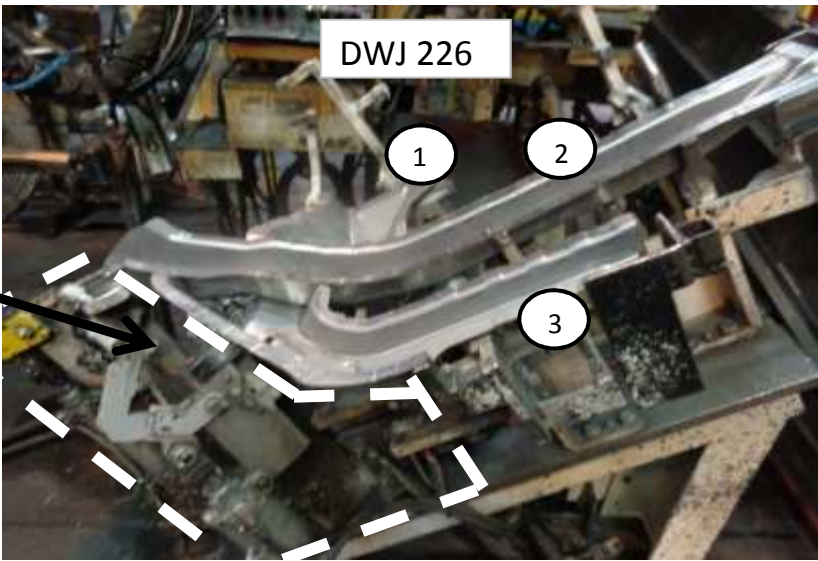


ΣCT =141,7 sec

1+ 1 MAN PROCESS SAVING / SHIFT = 1,04€ /veh
Payback = immediate (internal kaizen)

CURRENT CONDITION - AFTER KAIZEN

- * REMOVE DWJ 224
- * ADD -3- fr ssup mbr rr datums & clamp unit IN DWJ 226
- * 3 spots transferred in EC Respot line on EMR 3-3



NEW PROCESS 1 :
1 man process : 2 guns 5 spots C-Gun 3 spots X-Gun
assemble -1-Fr side inner rr x - 2-torque box
x -3-fr susp mbr rr