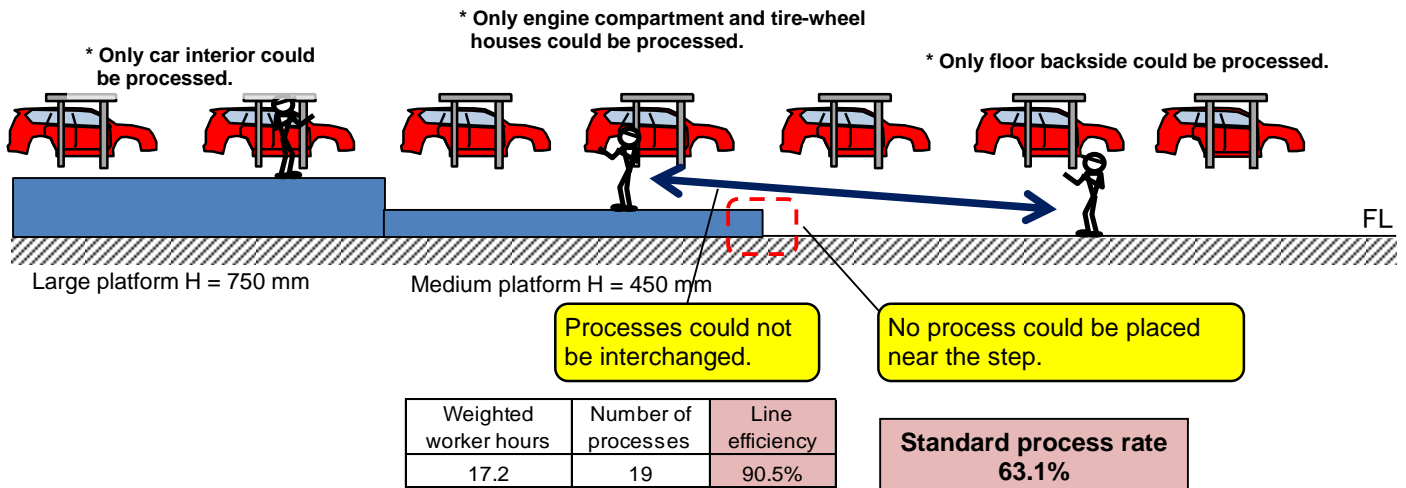


Process	Assembly	Approach for Kaizen	(8) Other	Presented by	Kazuma Takeuchi
Company name	Toyota Motor Corporation				
Section	Tahara Plant Final Assembly Div. Assembly Section No. 1				
<b>Title</b>	C1 line: Productivity kaizen by platform removal				

#### Before Kaizen (situation and problem)

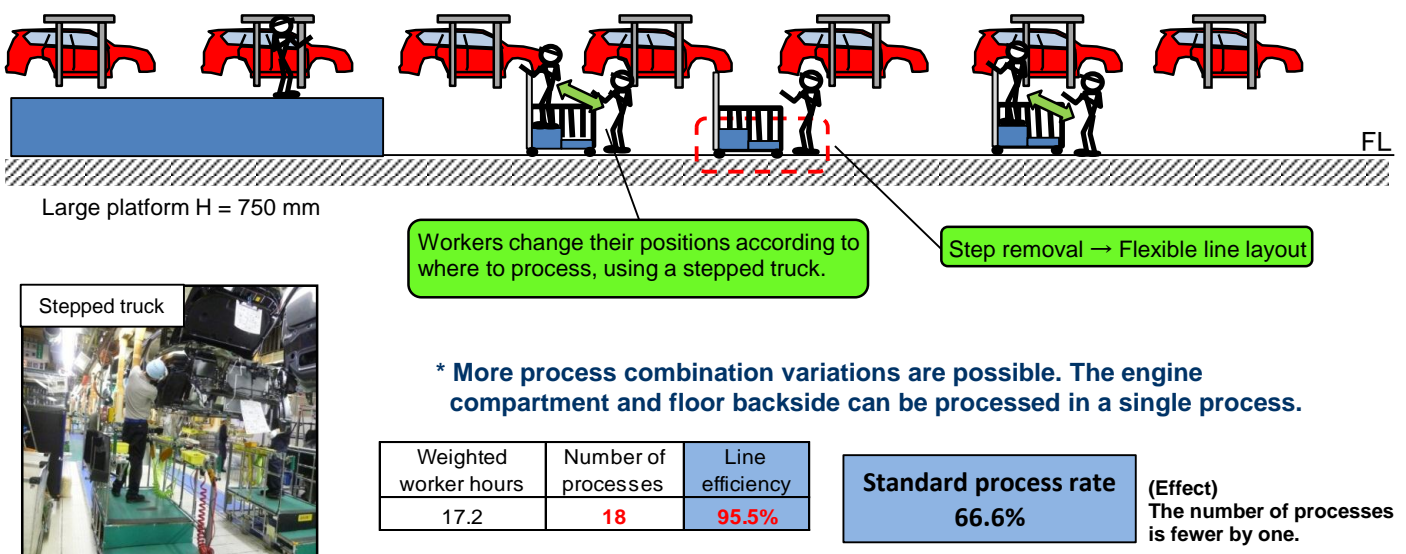
Platforms placed to suit to working height restrained line layout flexibility. → **Low line efficiency**



#### After Kaizen (description of Kaizen and point of view for Kaizen)

**Point of view** Can restraints in floor height be removed while working height remains changeable?

**Stepped trucks were introduced and medium platforms were removed,**  
reducing restraints in line layout. → **Improved line efficiency**



#### Cost-effectiveness (expenses for Kaizen versus cost reduced by Kaizen)

**Facility investment (incl. all internal and external purchases)**  
¥17,000,000

**Effect (in worker hours)**

• Reduction in worker hours: 1 process × 8 hr.  
× 2 shifts × 20 days = 320 hr./mo.

**Investment recovery: 11.8 mo.**

**¥1,440,000 (per mo.)**