# OVERSEA CAREER TRAINING IN SUMITOMO RUBBER THAILAND

**TRAINING PROGRAM** 

WORK OBSERVE ACTIVITY(WOA)

**DEPARTMENT:** IE(KAIZEN)

DATE: 4-15 AUG' 2014

\*9-13.AUG IS HOLIDAY

BY: LI MENGLU BANTITA CH. (Yaikaew)







- TIRE KNOWLEDGE
- OUR KAIZEN PROJECT
- IMPRESSION OF THIS TRAINING



## Sumitomo Rubber (Thailand) Co., Ltd Overview • PRESIDENT : MR. TORU



NAGAHATA

- PRODUCTS : RADIAL TIRES FOR PASSENGER CAR
- FOUNDATION : MAY 2005
- LAND AREA : 608,880 m<sup>2</sup>
- HEADCOUNT : 6,311 EMPLOYEES INCLUDING 33 JAPANESE



### SCHEDULE OF OVERSEA CAREER TRAINING

- 4 Aug'14 > Present Company Profile
  - > Factory Tour
- 5 Aug'14 > Explain Basic WOA(3STD Chart)
- 5-7 Aug'14
- > On The Job Training in Line ; Material Process
- 8 Aug'14 > TPS Study: Find "MUDA" in Process
- 14 Aug'14 > Factory Tour
- 15 Aug'14 > Factory Tour(SRT)

> Final presentation and free discussion



#### WORK OBSERVE ACTIVITY PROCESS



Meeting



#### WORK OBSERVE ACTIVITY PROCESS



# Studying



#### WORK OBSERVE ACTIVITY PROCESS



**Observation** 



### **Components of the tire**









#### **Step working Bead Apex**



### 1. Get C/B put in M/C





#### **Step working Bead Apex**



2. Run M/C





#### **Step working Bead Apex**



3. Join rubber





#### **Step working Bead Apex**



4. Run M/C





#### **Step working Bead Apex**



### 5.Get B/A put in arm





# **BEAD APEX M/C#7**



# ANALYZE DATA PROCESS (BEAD APEX





#### STANDARD WORK TABLE - - - > BEAD APEX M/C#7





#### STANDARD WORK COMBINATION CHART ---> BEAD APEX M/C#7



#### Before



## STANDARD WORK TABLE - - - > BEAD APEX M/C#7



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Before

**KAIZEN** 

After



### STANDARD WORK COMBINATION CHART

---> BEAD APEX M/C#7





#### STANDARD WORK TABLE - - - > BEAD APEX M/C#7

After



Quality	Safety	Stock	
$\Diamond$			

SUMITOMO RUBBER THAILAND

## CAPACITY UP



22

SIZE CHANGE USE TIME

BEFORE 635.34 SEC/TIME

AFTER 591.81 SEC/TIME

REDUCE 43.58 SEC/TIME

SIZE CHANGE DIE PLATE 15 TIMES/DAY REDUCE USE TIME 43.58 X 15= 652.95 SEC/DAY ACTUAL TAKT TIME = 17.02 SEC/PCS CAPACITY UP =652.95/17.02 TARGET 4500 PCS/DAY





# **BEAD APEX M/C#10**



## ANALYZE DATA PROCESS (BEAD APEX M/C#10)



# STANDARD WORK TABLE M/C#10



After Before Standard Work Table Standard Work Table 46/18/2010 Date: Date: 16/08/2014 Record By: Record By: LI MENG LU Start Start Acres The Record Plata Step Operation Step Operation Finish Finish Eachert and Atmile Run Boad Apox Assomble A Akea Area Pecorol da AND INCOME # >0 Q P MI Area Ans Good and Area Beach A Pre Suppy Grae Bear NIH talli Dimeter machino Plater Moder machine Quality Safety Stock Selety Stock Quelty **e**  $\Diamond$ 0 -(P 0

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#### STANDARD WORK COMBINATION CHART --> BEAD APEX M/C#10

Before



Making Red Personal Bead APEX M/C#10 \$ 108/14 4000 pcs/day (bate) Standard Work Combination Chart Takt Time: Product (size) size change 695660 84 11 MENGLU 16.8 sec/pcs 144 Time Time Work Content hand Auto Ww8 34 30 32 34 34 34 . 180 104 141 -..... .... 14:58 supply c/B 12.79 45.91 change Dieplate 452 24:34 Set data /scan barcede 0/B 3.44 CT=400.31 7.97 scan barcode pieplace 305 8.14 Scan barrade Compound 33.10 Setting M/c 2.82 1788 Freed compound 2202 Zuri M/C 109.19 check Dimeter 512 set plata 12.64 Run M/c and 18 3724 26.47 Total

### STANDARD WORK COMBINATION CHART ---> BEAD APEX M/C#10





## CAPACITY UP



28

Size Change use time

Before 400.31 sec/time After 390.74 sec/time Reduce 9.57 sec/time Size Change Die Plate 13 times/day Reduce use time  $9.57 \times 13 = 124.41 \text{ sec/day}$ Actual Takt time = 16.43 sec/pcs Capacity up =124.41/16.43 =8 pcs/day (TARGET **5000** PCS/DAY)



# IMPRESSION

- KAIZEN
- SAFETY FIRST
- COMMUNICATION







# รักษากฎนะค่ะ Roo-Ru-Oh-Ma-Mo-Ru

ルールを守る



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