
Auto Alliance Thailand (タイ) 研修報告書

高効率化に向けた作業員の作業負荷に関する改善

工学研究科 化学工学専攻 京本 萌香

1. はじめに

Auto Alliance Thailand (AAT)

2. 研修先の概要

: Auto Alliance (Thailand) Co., Ltd. (AAT)
: 1995 11 28
: 50%, 50%
:
: 7188
: 847,542 m²
:

3. 研修スケジュール

7 31
8 9
8 20
8 21
9 14
9 16
10 26

4. 研修テーマの決定

as of September 2018)
chart(Update2017))

Final Line
(Production Scheduling by shift
(Unit05 yamazumi

5. 研修内容

5-1 改善するターゲットの決定

2018 9

Fig. 1

J03EF
J03EF

J03EF

Fig. 1

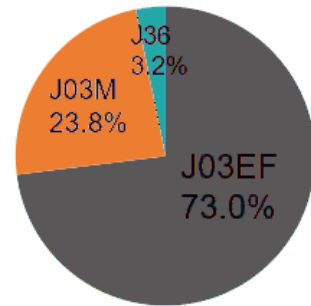


Fig.1 Proportion of production volume of each model¹⁾

Fig. 2

Final Line Unit5

J03F

J03EF

J03F

J03E

2

J03E: J03F=1: 1

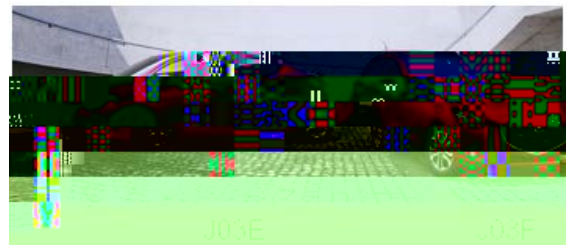
Fig. 2 56R

2

62L

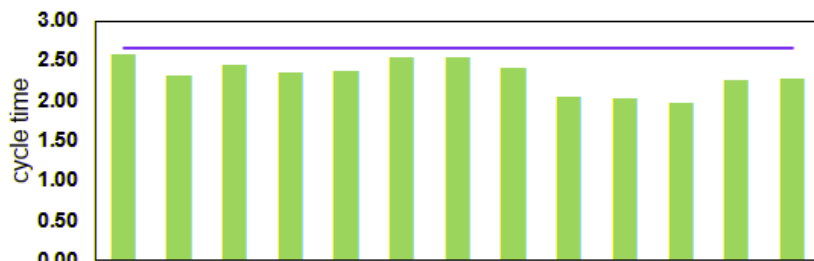
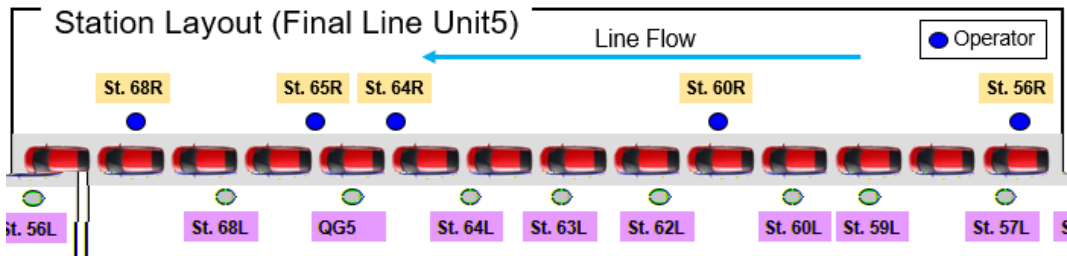
J03E
AAT

1) Production Scheduling by shift as of September 2018



56R

2



J03E and J03F²⁾

Fig.2 average cycle time of J0

2) Unit05 yamazumi chart (Update2017)

5-2 62Lステーションにおける現状の分析
62L

5-3 motion chart と作業員の手順が異なる理由

motion chart

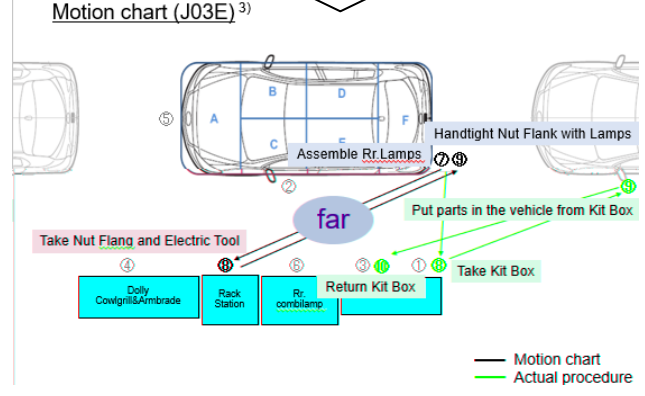
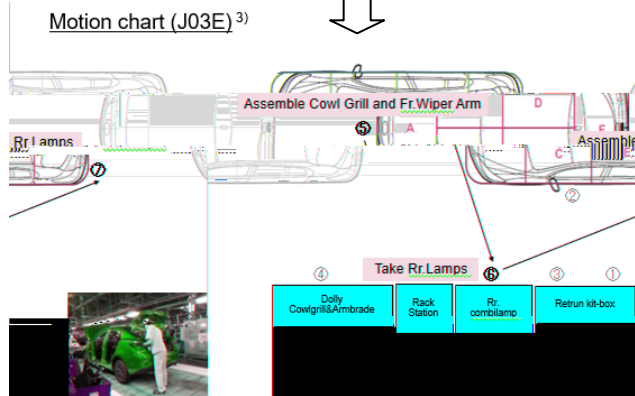
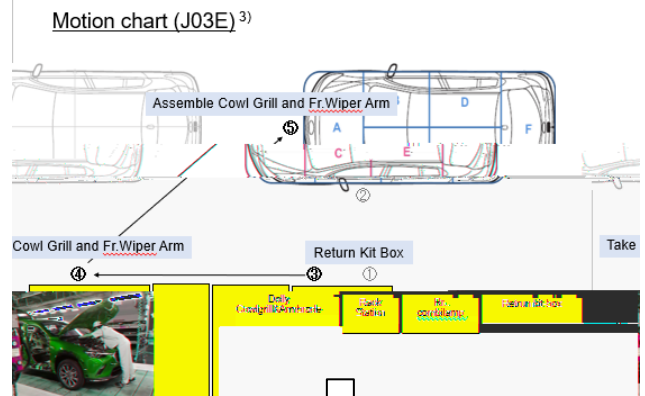
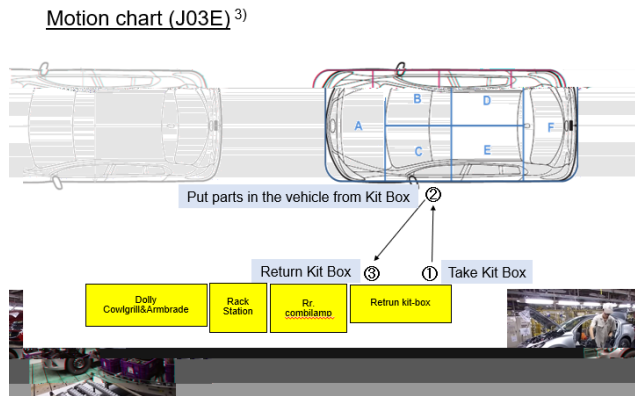
motion chart

2

motion chart

operator B

operator B



motion chart
Nut Flang

Electric Tool

Box

Kit

motion chart
Nut Flang Electric Tool
motion chart

motion chart

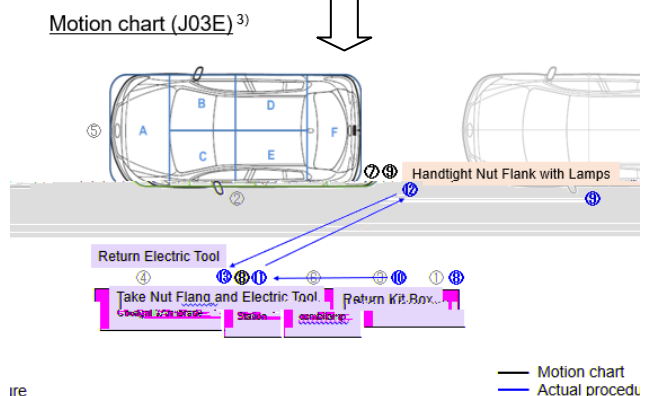


Fig. 4

Fig. 4 motion chart

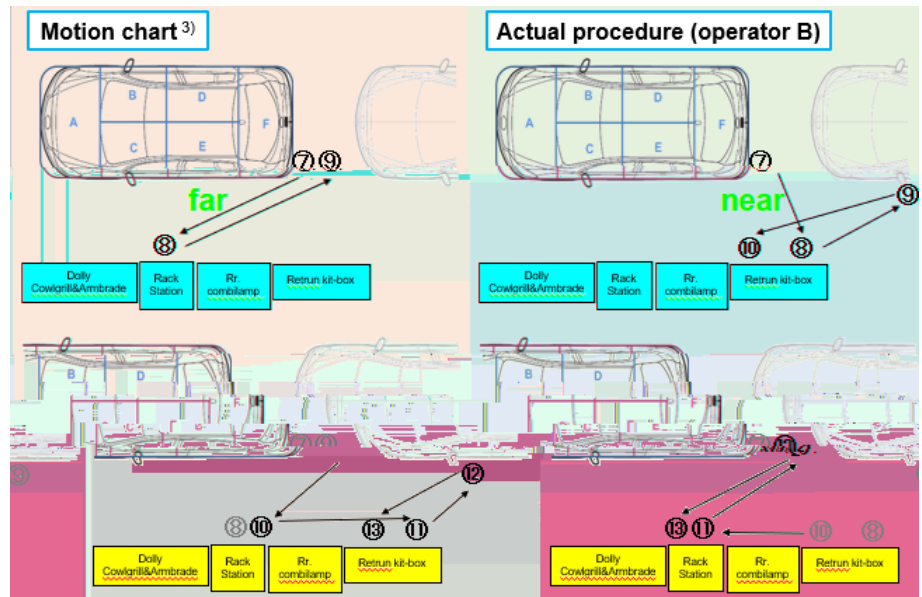


Fig.4 Comparison between motion chart and actual procedure

5-4 改善案の提案

1

Rack station Rr. Combilamp

motion chart

motion chart

Fig. 5

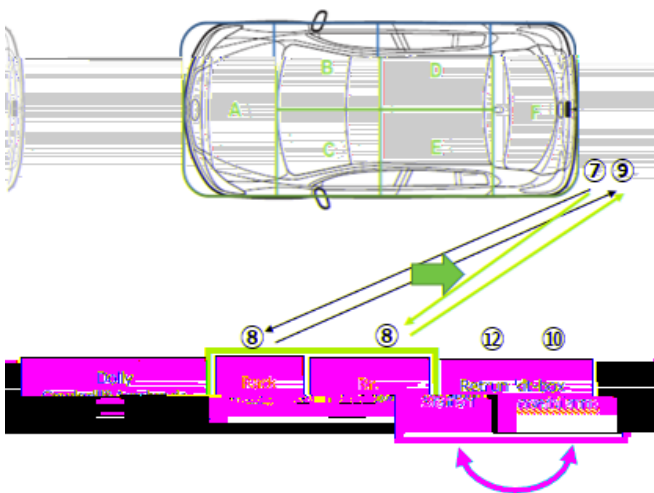


Fig. 5

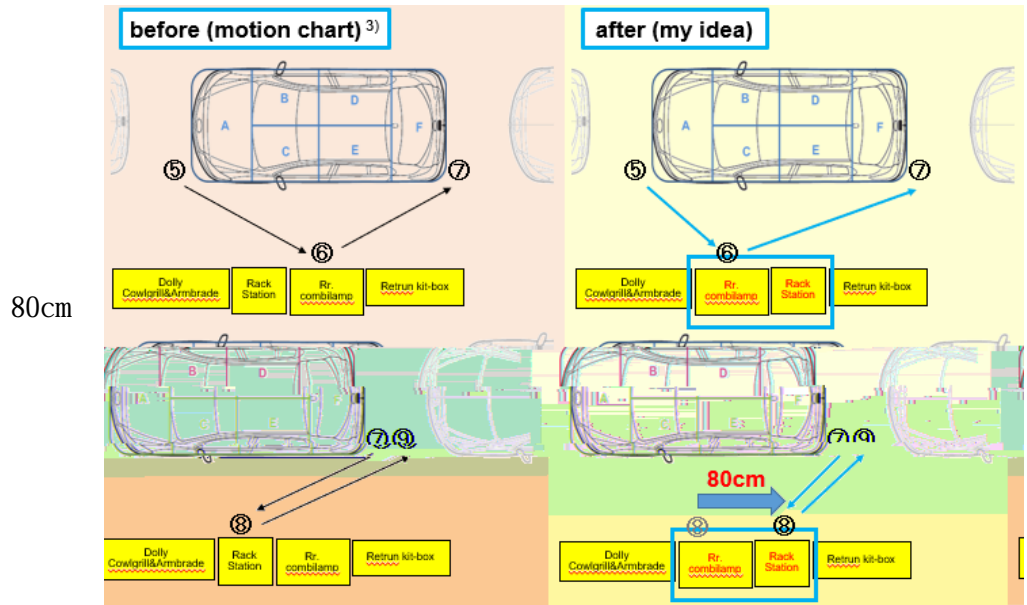


Fig.5 Comparison between motion chart and my suggestion

2

J03F

Rr. Wi per Arm

J03F

Fig. 6

Rr. Wi per Arm

J03Eモデルの作業手順

- Kit Boxから車内に部品を置く
- Cowl GrillおよびFr.Wiper Armの取り付け
- Rr.Lampsの取り付け
- ねじの締め付け(Rr.Lampsの固定)

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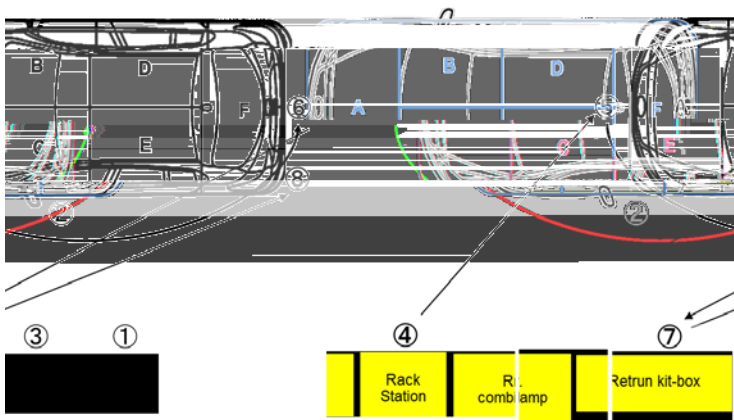


Fig.6 Procedure of J03F model

Fig. 7

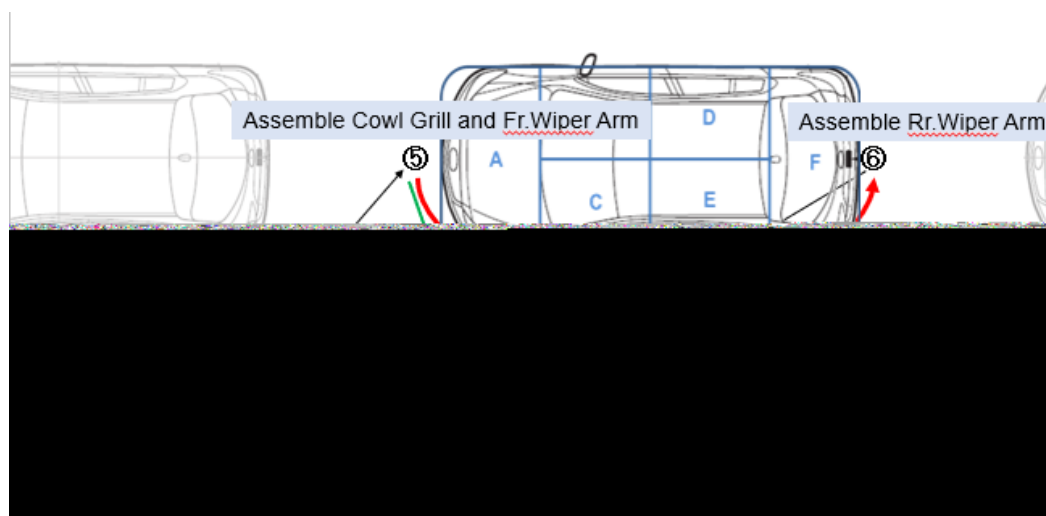


Fig.7 After using kangaroo bag

6. まとめ

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7. 謝辞

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ECBO

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