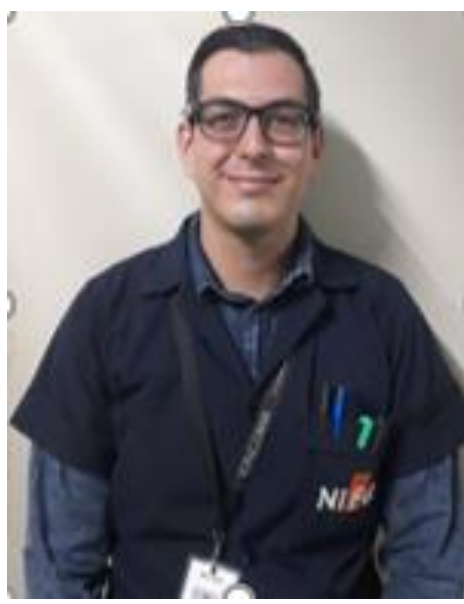




Miguel Cardenas  
Jidouka Engineer



Alejandro Pena  
Jidouka Engineer



Jose Derat  
Maintenance Manager



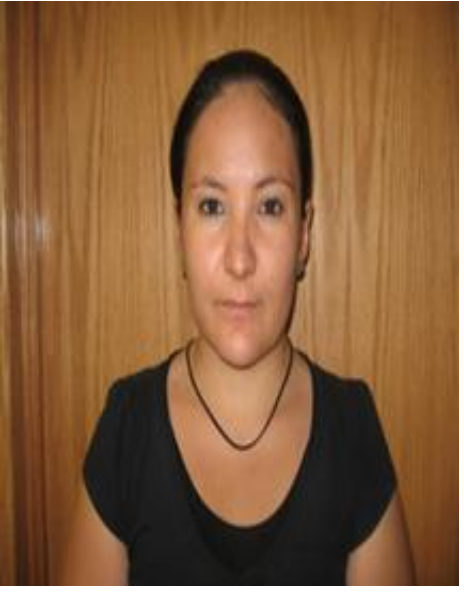
Juan De Dios  
Process Engineer



Luis Perez  
Jidouka Intern



Daniel Villa  
Maintenance Technician

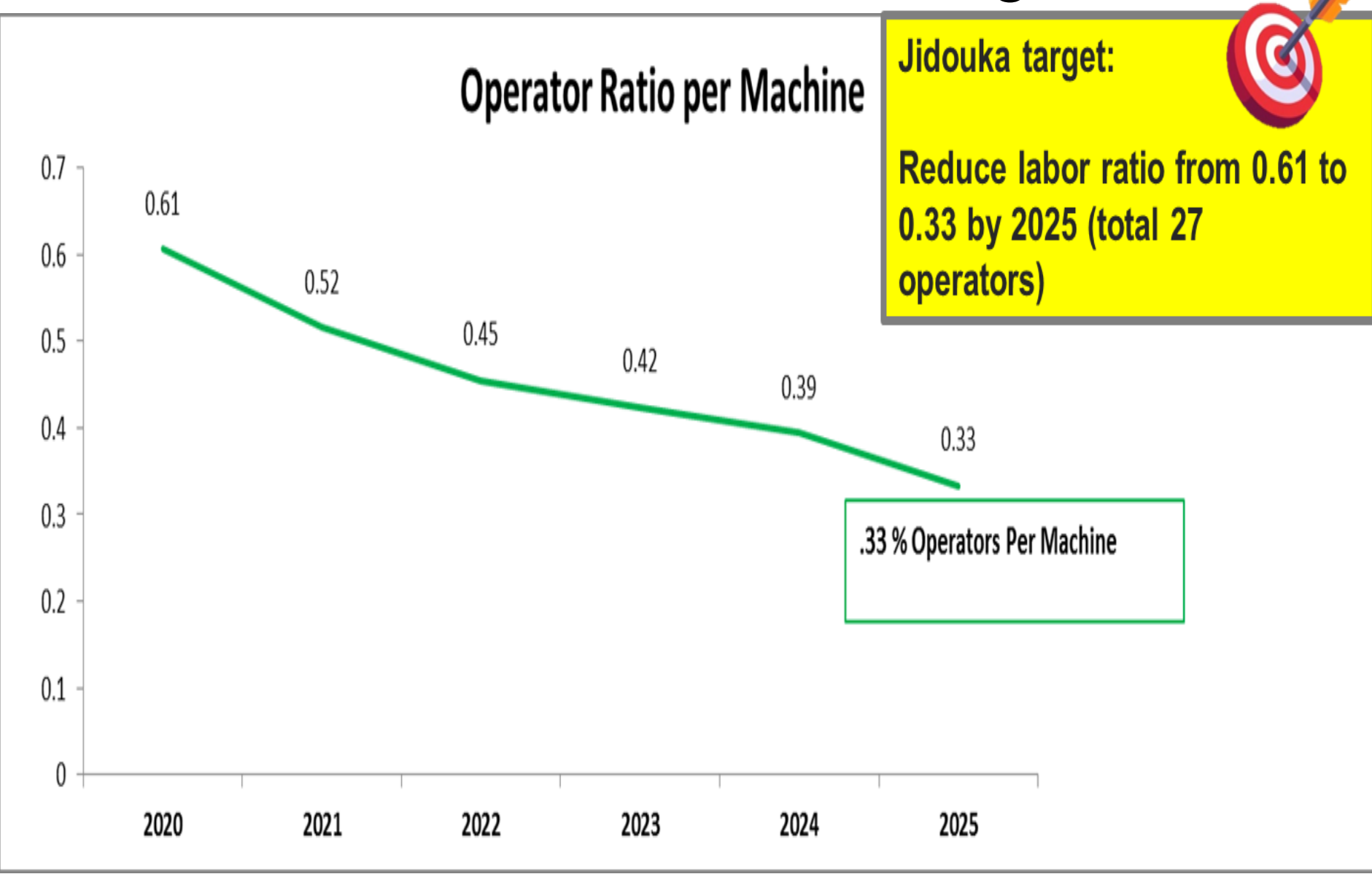
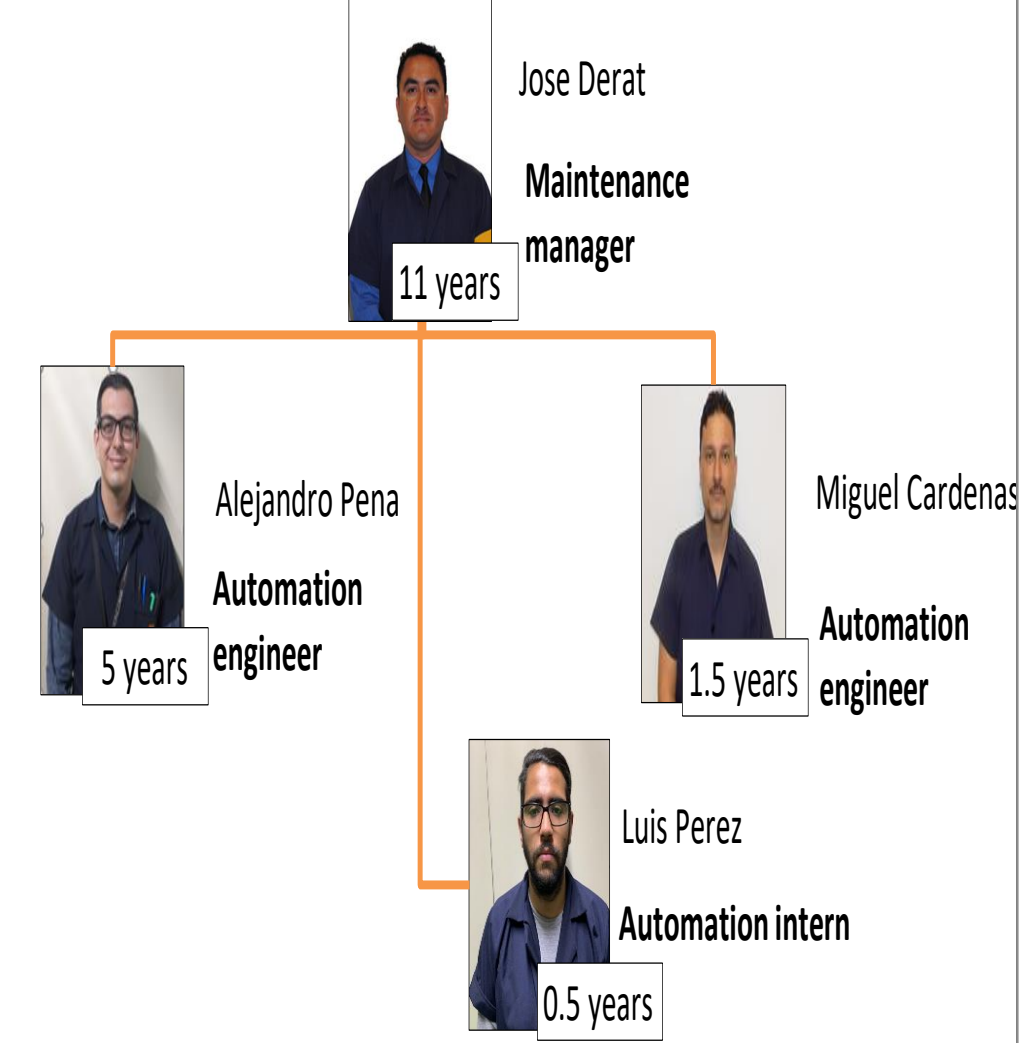


Alondra Rodriguez  
Molding Planner

1. Kaizen point

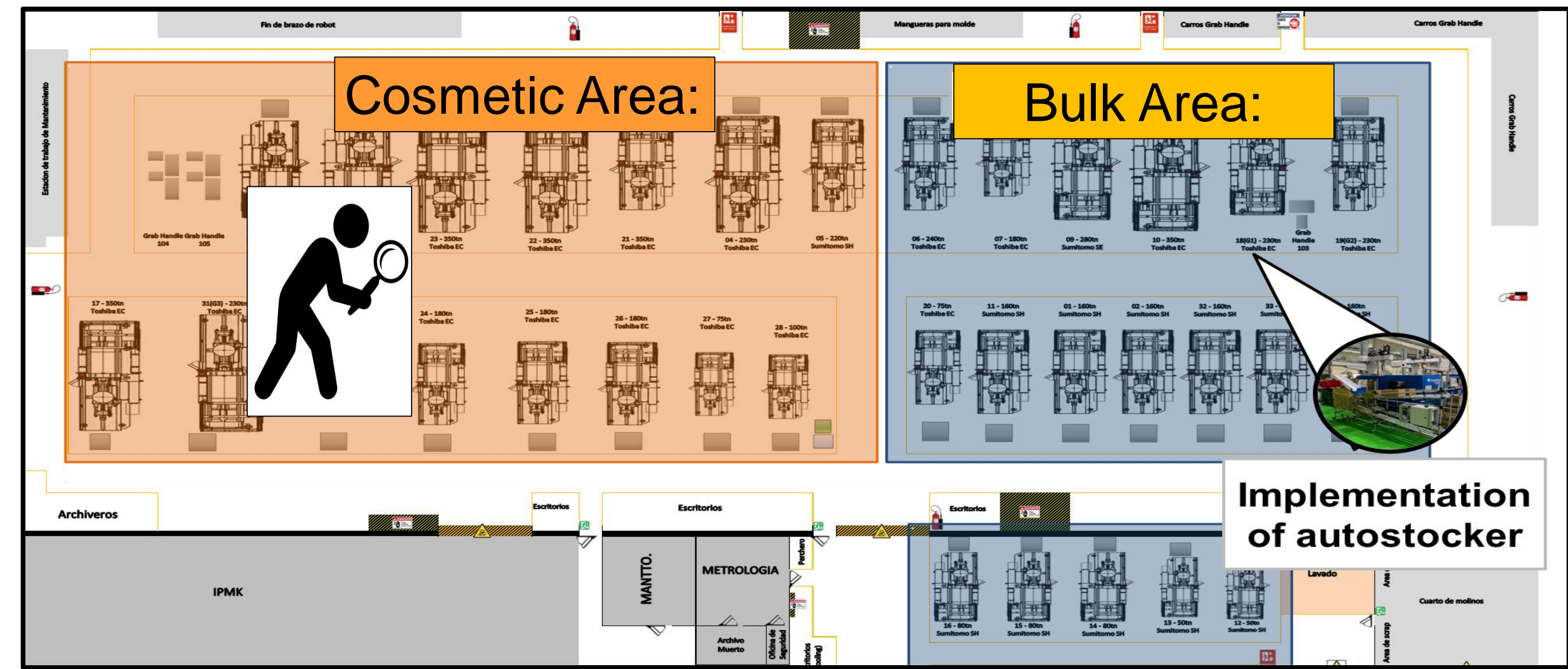
The kaizen point is based on a projection of salary reduction. Our Current labor ratio per machine is **0.61** and projection for 2025 is **0.33** that represents a 55% of labor reduction at molding area.

JIDOUKA ORGANIZATION CHART



2. Before Kaizen status

After segregation of bulk and cosmetic area in molding layout we started to implement autostocker in bulk area and **look for jidouka opportunities in cosmetic area**.

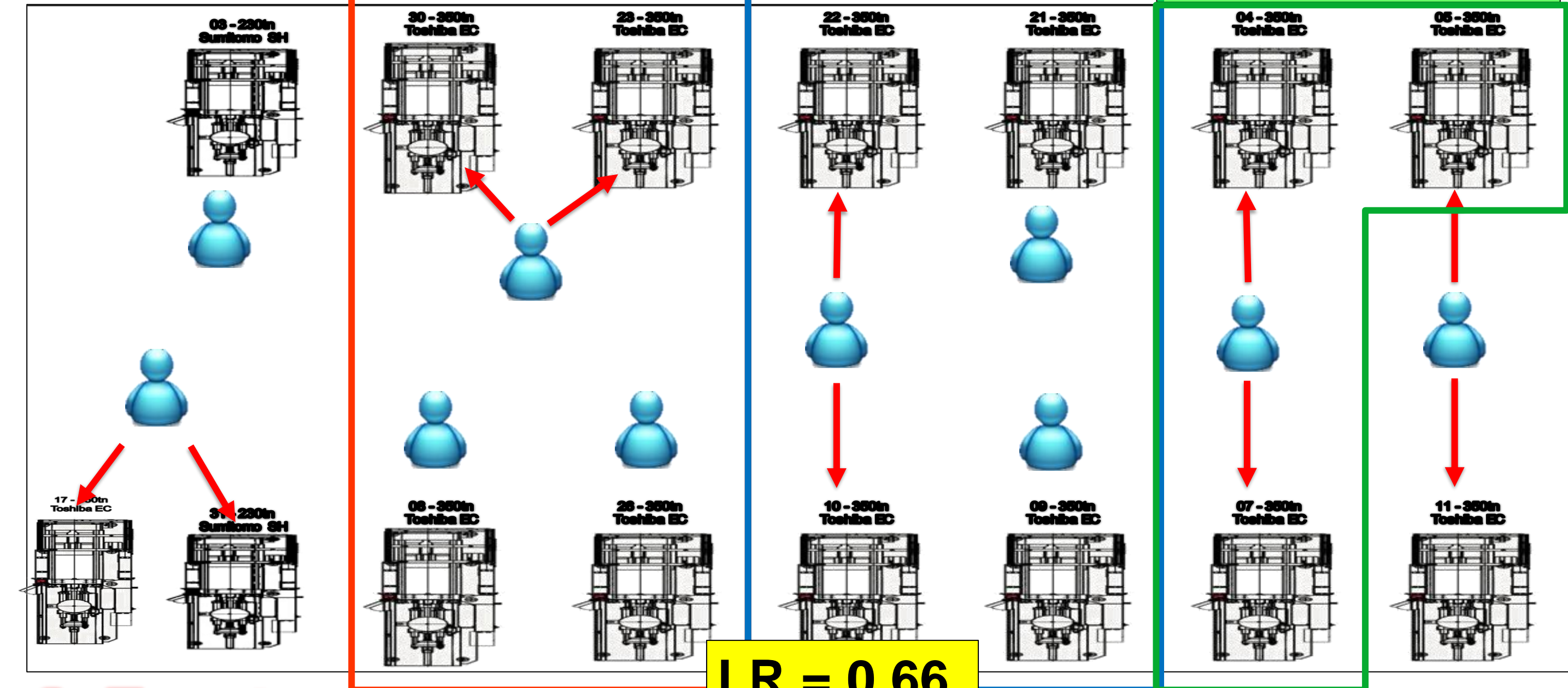


We look the opportunity to optimize Yushin robot due to wrong distribution of parts on conveyor  
Added, the conveyor speed was not configured according to robot signal to go forward and stop.

With this condition we have transportation waste



Layout distribution of cosmetic area before kaizen: 10 Operators



3. Target

Optimized the use of Yushin Robot on conveyors for cosmetic area in order to contribute to 2020-2023 HC molding reduction labor:

2022 labor reduction: **LR = 0.60**  
2023 labor reduction: **LR = 0.53**

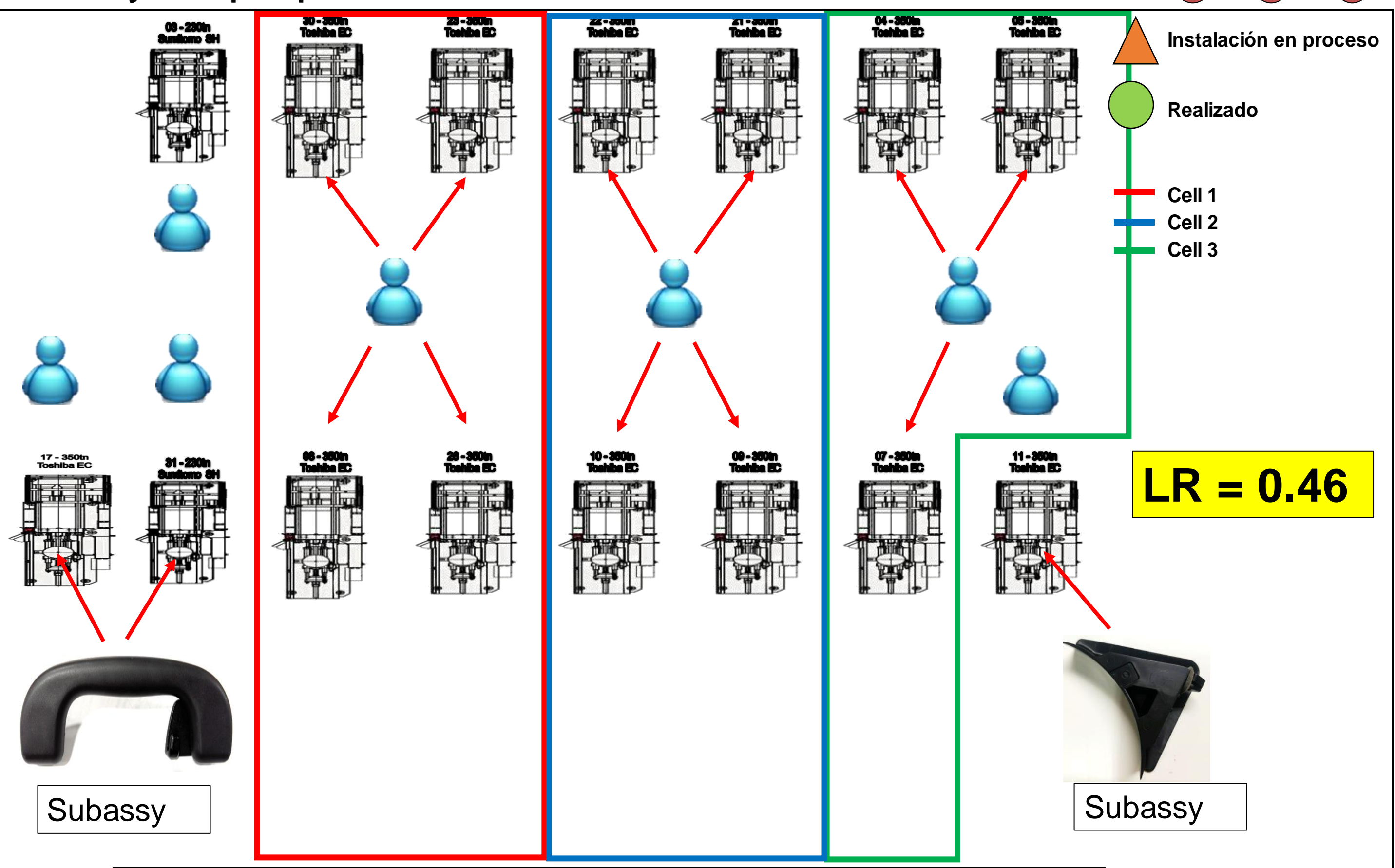
4. After Kaizen status

Improvements implemented:



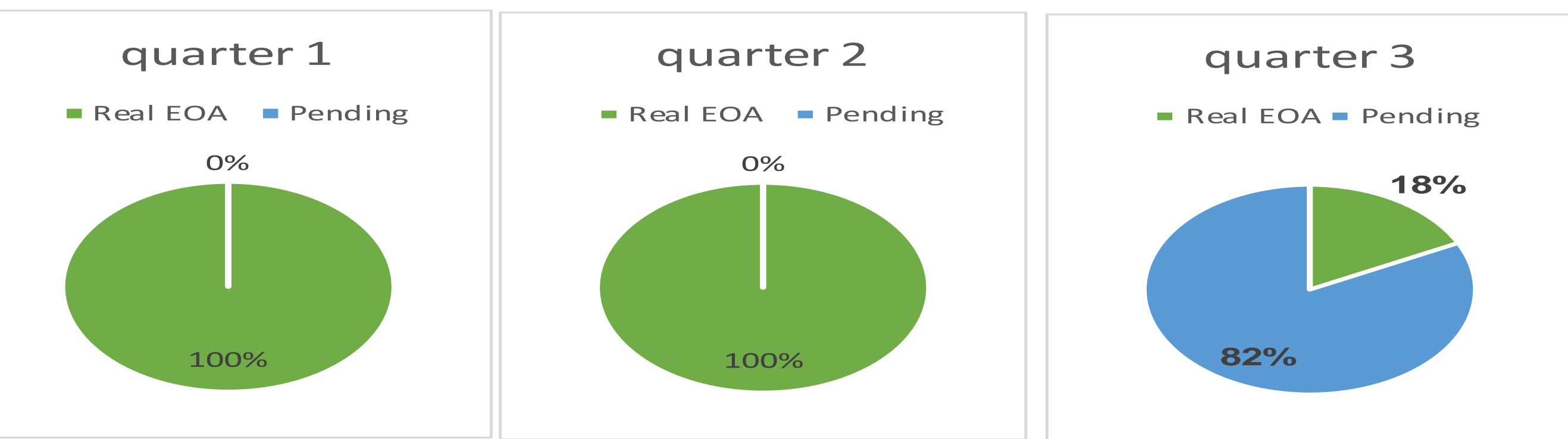
- 1. Yushin Robot optimization in parts distribution on conveyor and synchronize robot signal to move & stop.
- 2. Andon system.
- 3. Conveyor closed (safety guard), avoid transportation of parts

New layout proposal with machines cells: 7 Operators



Taking advance, we have implemented EOA and CBOX manufacturing plan for small machines

	Jan	Apr	Jul	Sep	Total
Box	14	13	14	13	54
EOA	3	3	3	3	12
Plan EOA	17	16	17	16	66
Real EOA	17	16	3		36
Pending	0	0	14		14



5. Results

August 2022 we'll reduce: **Saving \$21,000 USD/ year**

6. Next steps

After this kaizen implementation we're planning a development of **sonoba kansei and autopacking**:

