LEAN FLOW TECHNOLOGY
"... TO BOOST PROFITS"

- Reduces Cycle Time.
- Improves Flexibility.
- Improves Quality.

→ MARKET SHARE GAINS

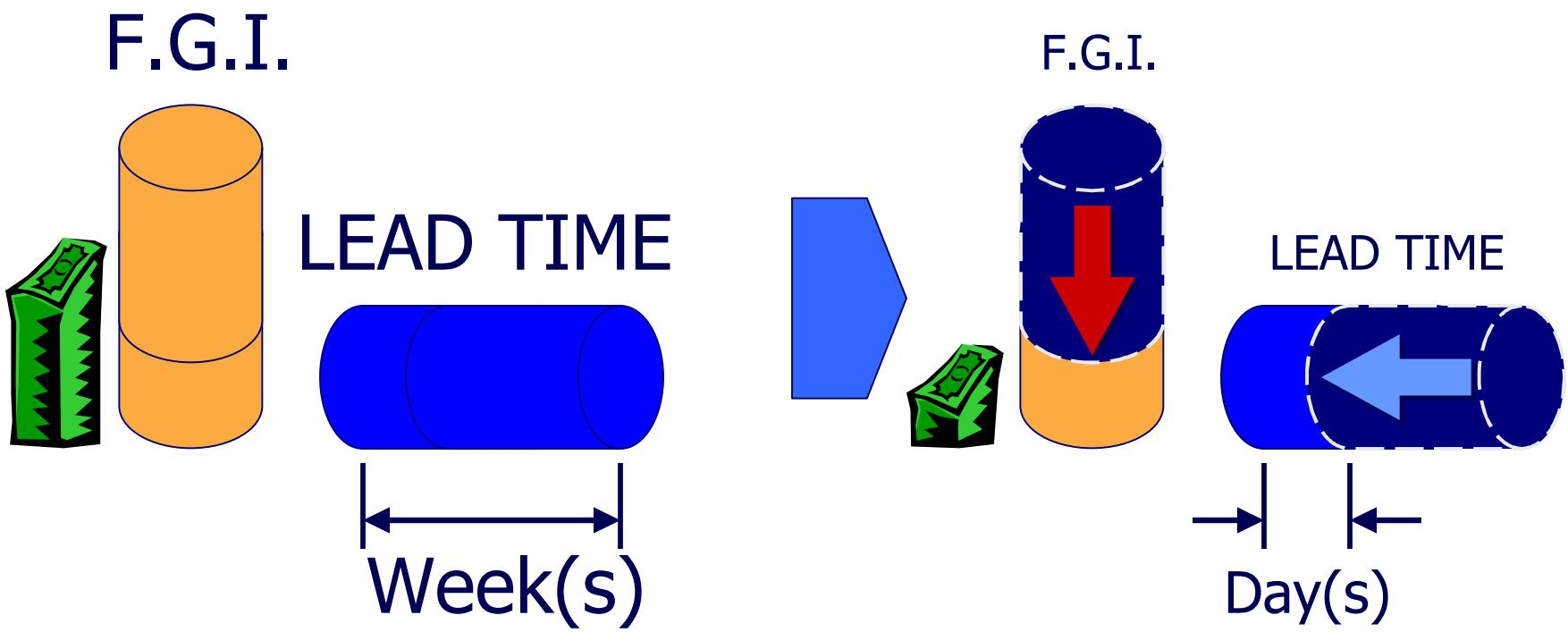
- Improves Productivity.
- Reduces Rework and Scrap.
- Improves Response Time.

→ MARGIN IMPROVEMENT

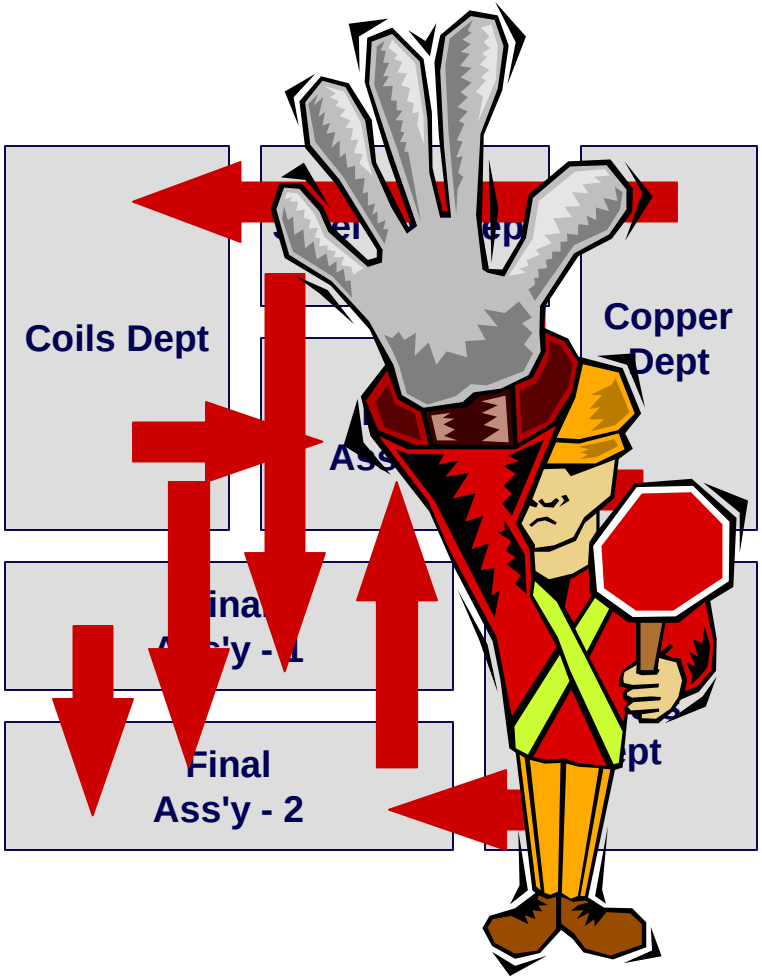
- Reduces Space.
- Reduces Investment.
- Reduces Inventory.

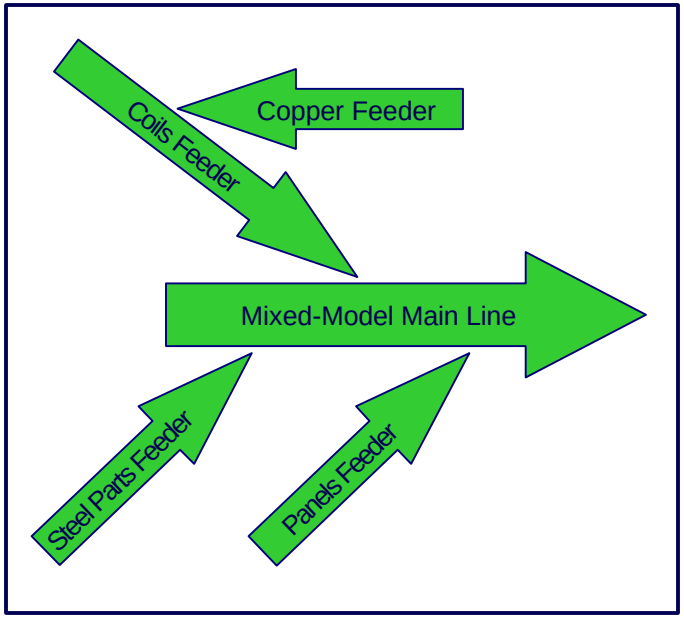
→ PAY-BACK IMPROVEMENT

LEAN FLOW TECHNOLOGY
"... BY PRODUCING IN DEMAND"



LEAN FLOW TECHNOLOGY
TRADITIONAL MANUFACTURING





LEAN FLOW TECHNOLOGY
… MEASURABLE RESULTS

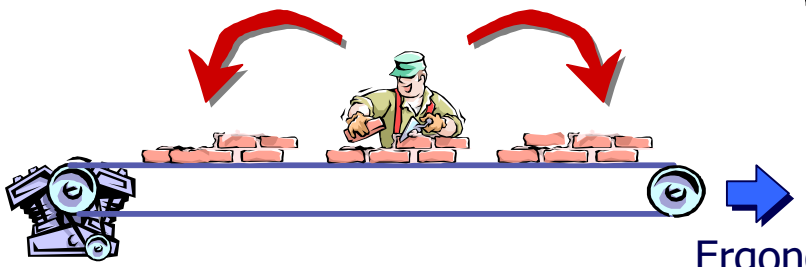
- Reduction in Injuries-Rate : 10-15%.
- Reduction in Non-Quality Costs : 5-20%.
- On-Time Delivery Improvement : 98%.
- Reduction in Work In Process : >70%.
- Space Savings : 25-35%.
- Capacity or Productivity Improvement : 25-50%.
- Reduction in Cycle Time : >60%.
- "Double Digit" Inventory Turns.
- …
- **Flexible Employees, Trained and Certified.**

LEAN FLOW TECHNOLOGY
WORKING SMARTER – NOT HARDER

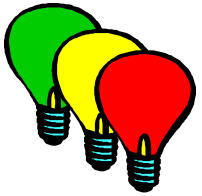
Training - Certification

PLANT A T : In Training C : Certified M : Master	Process											
	Assembly 1	Bending	Coils Test	Tubes	Brazing	Proof Test	Vacuum	HFC22	Insulation	Montage 2	Final Test	Packing
François					C				C	C	C	T
Alain	C	M	C	C	M	C	C	C	M	M	M	M
Peter	M	M	C	C		M	C	C				
Zlimir	M	C	M	M	C	C	M	M	C	C	C	C
Henri			C	C	M		C	C	M	M	M	C
Gilles		T	C	M	T	T	C	M	T	C	C	M
Steve	C	T	M			C	M			T		

Flexible Employees



Simple, Visual Signals

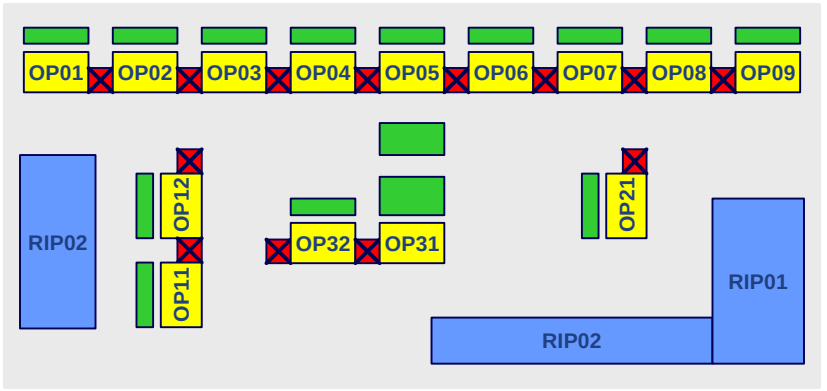


Ergonomic Implementations

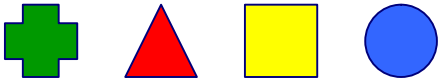
DEMAND FLOW TECHNOLOGY — Process I.D. Assemblage Coffret

VA		Setup Mach	Setup Labour	Setup DS	Setup Qty	Setup I/E	Required Mach	Required Labour	Move Mach	Move Labour	Move DS	Move Qty	Move I/E	Move Dist.	TQC	Description
			0.2													
X								0.2								
X								0.6							X	Type 45CG20AJ / 45FG20AJ
X								0.3								
X								0.6							X	A l'opposé du pli. Taille 530 : Type 3ARR3CT1OV5 Taille 536 : Type 3ARR3CT6A5
X							0.3	0.5								Relais à l'intérieur du coffret
X								0.5								A gauche - Marquage visible - 4µF
X								0.3							X	Cosse M/F sur borne Gauche
X								0.3								Cosse M/F sur borne Centre/Droite
X								0.6								Au centre - Marquage visible Taille 530 : 35µF Taille 536 : 40µF
X								1.0								Côté gauche au ras du pli.
X								0.3							X	Borne Inférieure/Gauche
X								0.3								Borne Repère "N"
X								0.3							X	Borne Repère "L"
X								0.3							X	Borne Repère "N"
X								0.3								Borne Repère "N"
X								0.3								Borne Repère "Terre"
X								0.3							X	Borne Haut/Supérieur/Gauche.
X								0.3								Borne Droite.
										0.1				0.2		

40	Fixer contacteur 24V - 1 vis - 1 rondelle	
50	Fixer relais de démarrage sur support - 1 vis	
60	Fixer S/Ens. Relais sur tôle coffret - 2 vis	
70	Fixer condensateur ventilateur - 1 Ecrou (Gauche)	
80	Raccorder Fil N°7 sur condensateur ventilateur (Gauche)	
90	Raccorder Fil N°7 sur contacteur puissance	
100	Fixer condensateur compresseur - 1 Ecrou	
110	Fixer S/Ens. Support borniers - 2 vis	
120	Raccorder Fil N°2 sur condensateur compresseur	
130	Raccorder Fil N°2 sur bornier puisance	
140	Raccorder Fil N°21 sur bornier puissance	
150	Raccorder Fil N°20 sur bornier puissance	
160	Raccorder Fil N°6 (Rouge) sur bornier puissance	
170	Raccorder Fil de Terre (V/J) sur bornier puissance	
180	Raccorder Fil N°4 (Noir) sur contacteur puissance	
190	Raccorder Fil N°5 (Bleu) sur condensateur compresseur	
200	Evacuer S/Ensemble Coffret	



Graphic Methods – Safety Tools



LEAN FLOW TECHNOLOGY
20 MAJOR STEPS

1. Organization.
2. Identification of Products.
3. Product Synchronization.
4. Mixed-Model Process Map.
5. Demand at Capacity – Dc.
6. Factors Influencing Demand.
7. Sequence of Events.
8. Mixed-Model Line Design.
9. Family of Products.
10. Response Optimization.
11. Operational Definition.
12. Kanban Management.
13. Operational Method Sheets.
14. Physical Implementation.
15. Employees Involvement.
16. Daily Demand Management.
17. Daily Staffing – Flexibility.
18. Continuous Improvement.
19. Suppliers Management.
20. Key "LFT Measures".