

ICQCC 2011-Yokohama

Improvement of production efficiency in the parts processing site.

- Reduction of the average processing time for resin parts -

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Country: China

⑧ Announcement purpose (less than 800 characters)

<Introduction>

We, the DEVICE production department of Konica Minolta Business Technologies, Inc. (DongGuan) China Branch, are located in Guangdong, China, and we, Konica Minolta, are manufacturing products such as resin / press parts, function parts, and unit components used for office information appliance products, which we develop and sell.

In order to deal with the steep rise of personnel expenses in China and to deal with the small LOTS of the product, we began production innovation activity in the latter half of 2008. We were promoting efficiency improvements such as removing unnecessary aspects of production as well as automating production where possible.

This time, we present that the QCC team, "CiJiuYingXin (辞旧迎新)" works to first improve the production efficiency of the parts processing site and then to achieve activity with substantial reduction in the average processing time for resin parts.

<Goals for improvement>

As a result of the current conditions analysis, it became clear that 2 problems are the important points, which are the "secondary processing work" hours for the parts such as deburring during the processing of resin parts, and the "waiting to work" hours produced by the difference between a molding cycle and secondary processing time. We started the improvement with the following three goals.

1. Reduction of "deburring" work.
2. Improvement of "packing" work.
3. Reduction of "waiting to work" hours.

<Results of the activities>

- ◆ As result of these improvement activities, the average processing time for resin parts was reduced by more than 30%.
- ◆ Not only "improvement consciousness", "QC knowledge", and "cooperation power" of each team member were improved, but these findings also had a positive influence on the improvement awareness of the whole department.

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部品加工現場における生産効率の向上

－ 樹脂部品の平均加工時間の削減 －

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⑧発表主旨 (800字以内)

<はじめに>

私たち、コニカミノルタビジネステクノロジーズ (東莞) 有限公司、DEVICE 生産部は、中国の広東省にあり、コニカミノルタが開発、販売するオフィス情報機器製品に使用される樹脂/プレス部品・機能部品・ユニット製品等の生産を行っています。

中国での人件費の高騰、製品の小 LOT 化等に対応するために、2008 年下期より生産革新活動に取り組み、ムダ取り、カラクリ化などによる効率改善を推進しています。

今回は、QCC チーム” 辞旧迎新 (CiJiuYingXin) ” が部品加工現場の生産効率の向上を目指し、樹脂部品の平均加工時間の大幅な削減を達成した取り組みをご紹介します。

<改善のポイント>

現状分析の結果、樹脂部品の加工において、バリ取りなどの部品の“二次加工作業”時間、成型サイクルと二次加工時間の差によって生じる“作業待ち”時間の2点が改善の重要なポイントであることが判明し、以下の3つのポイントの改善に取り組みました。

1. “バリ取り”作業の削減。
2. “梱包”の作業の改善。
3. “作業待ち”時間の削減。

<活動の成果>

- ◆ 改善活動の成果として、樹脂部品の平均加工時間を30%以上削減。
- ◆ チーム員各自の“改善意識”“QC知識”“連携力”等が向上しただけでなく、部全体の改善意識等に良い影響が広がっている。