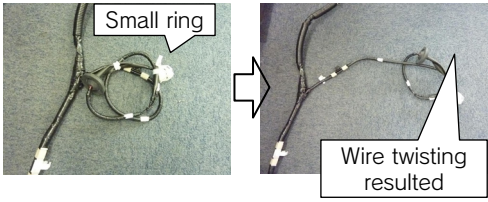


■ Concrete Case Examples of Difficult to Perform Operations

<Prius wire harness (electrical wiring) layout *kaizen*>

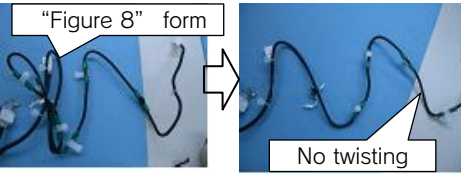
【Previous layout】



Small ring

Wire twisting resulted

【Layout after kaizen】



"Figure 8" form

No twisting

By lay the wire in the shape of a "figure 8" , the wiring is easier to be straightened and untwisting the wire is not necessary. Layout change reduced assembly defects and improved operations.

<Prius power window switch layout *kaizen*>

【Previous layout】

- Products would lean during shipping ⇒
- Difficult to remove
- Concern about scratching
- Concern about dust and/or water entry into the back of the connector



Divider

【Layout after kaizen】

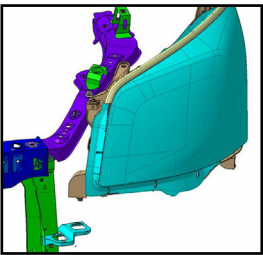
Support material conforming to the shape of the product



- Addition of support material that conforms to the shape of the product
- Leaning of parts corrected ⇒
- Product removal set without scratching and no longer any concern about dust or water entering from the back of connectors

<Alphard headlamp wire connecting operation *kaizen*>

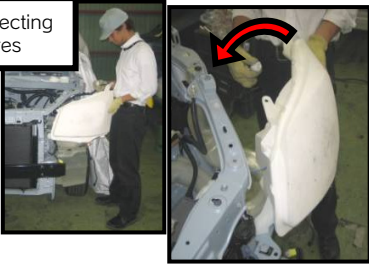
【Virtual view considerations:
"Structural considerations for ease of manufacturing"】



Establishing on the headlamp a structure for temporary positioning

【Considerations for trial production:
"Anxiety-free operation considered"】

Connecting wires



Determining the standing position of the line operator

Connecting wires by one's preferred hand able to be done for both the right and left headlamp so that anyone can perform the same operation