

Friendly to the Global Environment

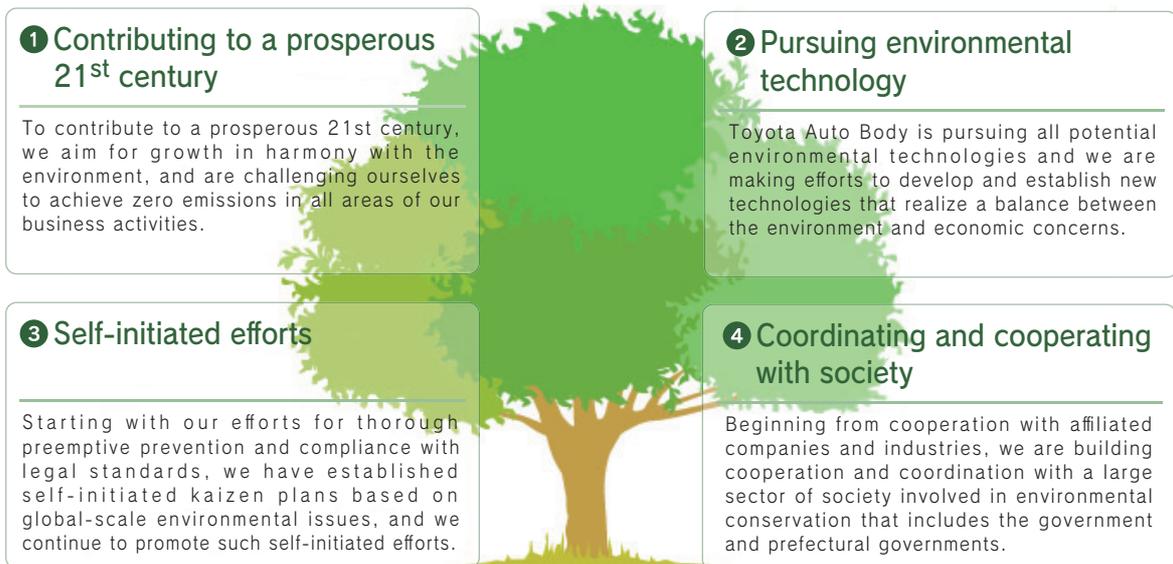
Our Fundamental Approach to the Environment

To Maintain a Society of Prosperity and Convenient Living into the Future

Adopting the fundamental principle of “Harmony with the Environment, in 1993 we established our “Toyota Auto Body Basic Environmental Policy” , and since then we have been formulating our “Toyota Auto Body Environmental Activity Plan” which describes our 5-year action plan for developing concrete activities.

In 2011 we began our “Fifth Toyota Auto Body Environmental Activity Plan” , which promotes 3-pillar activities of building a society that is “Low-carbon” , “Recycling-oriented” , and “Lives in Harmony with Nature.”

The Toyota Auto Body Basic Environmental Policy (Established in 1993, Revised in 2004)



The Fifth Toyota Auto Body Environmental Action Plan (2011-2015)

	Building a Low-Carbon Society	Building a Recycle-Oriented Society	Building a Society that Lives in Harmony with Nature
Product Environment (Development and design)	<ul style="list-style-type: none"> Develop and promote next-generation vehicles that use electrical energy Develop and commercialize lightweight technologies that contribute to improving fuel efficiency 	<ul style="list-style-type: none"> Promote further recycle design, improve part picking, and make efforts toward material separation and differentiation Expand use of recycled materials 	<ul style="list-style-type: none"> Soundly manage products containing chemical substances Promote the development of technologies that switch to fewer substances that burden the environment
Production Environment (Production and Logistics)	<ul style="list-style-type: none"> Intensify energy-saving activities and reduce greenhouse gas emissions volume Pursue transport efficiency in logistics activities and reduce CO₂ emissions volume 	<ul style="list-style-type: none"> Reduce emissions and take emissions point countermeasures such as effectively using resources and improving yields Reduce the volume of packaging material use 	<ul style="list-style-type: none"> Reduce Substances of Concern (SOC) in production activities Reduce VOCs through decreasing paint and cleaning thinner etc. in painting processes
Coordinating With Society	<ul style="list-style-type: none"> Promote involvement of companies in the introduction of super-compact mobility on a national scale 	<ul style="list-style-type: none"> Invest in building a recycle-oriented society promote new businesses 	<ul style="list-style-type: none"> Implement domestic and overseas reforestation activities Promote creating factories that harmonize with nature and coexist with the community
Environmental Management (Environmental administration)	<ul style="list-style-type: none"> Promote and strengthen global consolidated environmental management Promote global CO₂ management Promote further environmental activities coordinated with suppliers 	<ul style="list-style-type: none"> Promote sustainable activities Promote sound environmental education Actively participate in Toyota Eco-VAS 	

Three Priority Themes :

Low Carbon

Recycling Orientation

Harmony With Nature

Eco-Friendly Product Development



Product Environment Committee Chairperson:
Senior Managing Officer
Ryuutarou Yamazaki

Developing Products that are Environmentally Burden-Free

Though our top priority is the manufacturing of vehicles that bring joy to our customers, we at Toyota Auto Body contribute to society by promoting the development of environmentally friendly vehicles. Starting at the design stage, we develop and realize top-of-class technologies capable of contributing to a society that is “low-carbon”, “recycling-orientated”, and “environmentally conservationist and lives in harmony with nature.” At the same time, we anticipate trends in regulations on a global scale and maintain legal compliance via product auditing and other activities.

Fundamental Approach to Activities

Toyota Auto Body is promoting environmental management Eco-VAS in product development based on the “Fifth Toyota Auto Body Environmental Action Plan”, in which we have raised the following themes.

- I. Development of weight reduction technologies that contribute to top-of-class fuel efficiency in looking to become a low-carbon society
- II. Further promotion of recycle design with care for efficient use of resources for a recycling-oriented society.
- III. Global promotion of chemical substances contained in products for environmental conservation and a society that lives in harmony with nature.

By categorizing these three major themes, we will contribute to sustainable expansion of society and the earth through providing vehicle manufacturing, products, services, and manufacturing that harmonize with the earth's environment.



- Eco-VAS 6 Environmental Targets
- Reduce environmental impact of fuel efficiency and the product life cycle
 - Improve recyclability and cutting SOCs
 - Vehicle external noise and exhaust gas

<Development Activities>

Organization	Activity Theme	Activity Content	
Product Environment Committee	I Improving fuel efficiency	■ Weight reduction	● We are progressing with the development of weight reduction technologies that provide the maximum contribution to improving fuel efficiency.
		■ Aerodynamics	● We are promoting the acquisition of air resistance reduction technologies to contribute to improving fuel efficiency, and are studying how to develop these to design and evaluation.
	II Recycling and Dismantlability	■ Expanded Use of Market Waste Materials	● We are investigating and promoting expansion of applications of recycled materials as renewable resources such as market-disposed resin.
		■ Improve dismantlability	● We are also making efforts toward reduction of dismantling time via and easy-to-dismantle design as one aspect of recyclability improvement.
		■ Promote recycling of COMS	● We are promoting efforts towards developing systems for recycling disposed COMS.
	III Chemical Substance Management	■ SOC *1 Auditing Activities	● We are promoting checks for presence of regulated environmental burden chemicals found in new products and in mass production, as well as auditing of management systems
		■ Managerial Regulations of Chemical Substances	● We aim to anticipate trends of environmental regulations in all countries and develop and changeover substitute technologies for regulated chemical substances.
		■ Management of Vehicle Interior VOC *3	● We aim to promote the development and management in mass production of new product technology to keep VOCs emitted into vehicle interior within each country's regulated value.

*1.SOC: Substance Of Concern
(General term given to substances that burden the global environment and humans)

*2.10 environmental substances of concern: Lead, cadmium, mercury, hexavalent chromium, asbestos, and others

*3.VOC : Volatile Organic Compounds
(General term for organic chemical substances easily released into the atmosphere at room temperature)

New model Voxy/Noah and COMS environmental specifications

Friendly to the Global Environment

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Eco-Friendly Product Development

Developing Weight Reduction Technology to Contribute to Targeted Top-in-Class Fuel Efficiency

We are progressing with efforts beginning in the design stage in coordination with the relevant departments to develop technology for environmentally friendly vehicle manufacturing, as we consider energy and global warming problems to be serious environmental issues that risk impacting humans and ecological systems.

Promoting the Development of Weight Reduction Technology to Contribute to Improved Vehicle Fuel Efficiency

We are progressing in joint technological developments at section meetings for a multitude of necessary issues for coordinating designs, testing, and production technology for developing and utilizing weight reduction technologies.

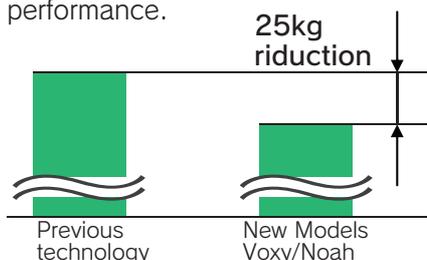
New Models Voxy/Noah

Development and Product Technology Division executives considering replacing a steel plate step with a plastic lower rail step.

Step assembly made as one solid plastic part

<Example: Main Weight Reduction Efforts for Body and Upholstery of the New Models Voxy/Noah>

By incorporating various weight reduction technologies, we succeeded in balancing body strength and a weight reduction of 25 kilograms while ensuring highly efficient rigidity that resulted excellent crash-safety performance.



*1 . Hot stamp :

A parts processing method where steel softened by heating to a high temperature is press formed, and at the same time hardened by cooling when coming into contact with the die.

< Body Weight Reduction Efforts >

Step assembly made completely of resin-plastic

Under Body

High-strength steel plate increase of 18.5%

- 1500MPa (Hot stamp *1)
- 980MPa
- 590MPa
- 440MPa

Doors

Minimization of reinforcement through vertical wall surface

Side members made straight

New Models Voxy/Noah Body Design Division Comments from the Person in Charge

Body Design Div. Yuusuke Asada



Through layered discussion regarding optimum frame structure (layout, cross-sectional configuration and materials) for the low minivan floors, we coordinated designs from the initial development period and achieved a balance between weight reduction and lowering of the cabin floor.

< Upholstery Weight Reduction Efforts >

Thinning materials (reduction between 0.2 and 0.5)

Studied and incorporated cost vs. effect

Changed to resin-plastic material making polypropylene material extremely light

Changed rear floor elevation material to light material RSPP→hard urethane foam

Eco-Friendly Product Development

Further Promotion of Recycle Design with Care for Efficient Use of Resources

Based on recognition of the limits of all resources, we have a three pillar approach—reduce, reuse, and recycle—in our efforts to improve dismantleability, expand use of recycled materials, and develop and design plant materials.

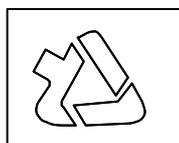
Promoting Efforts to Expand Use of Recycled Materials and Improve Vehicle Dismantleability

In order to effectively use spent vehicle resources, we are progressing with vehicle manufacturing that considers recyclability from the development stage. These efforts include expanding use of recycled materials and also efforts to make vehicle dismantlement easier.

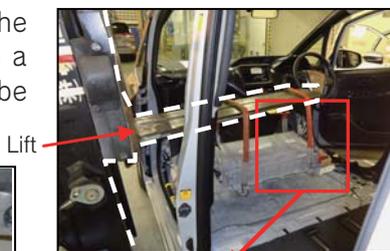
<Example: Efforts for safe reuse and easier recycling of HV batteries (new models Voxy/Noah)>

In order to allow safe and correct removal of spent HV batteries, we have set the dismantlement-improvement mark in a position to allow the heavy parts to be hoisted with proper balance.

Dismantlement-Improvement Mark
(An original Toyota mark indicating the starting position for an operation)



Setting of this mark is done with verification of the attachment position for well-balanced hoisting.



Lift



Suspending equipment

HV Battery

Dismantlement Assessment: Comments from the Person in Charge



Prototype Production Div.
Souichirou Ishikawa

I look to progress toward more earth-friendly vehicle manufacturing such that all used vehicles can be utilized as resources.

Efforts to expand use of market-disposed plastic and recycled felt material

We have improved recyclability by using recycled polypropylene recycled materials and recycled felt in the new Voxy and Noah models.

Parts 1-6 : Polypropylene (recycled materials from bumpers and other materials)

Part 7 : Recycled felt

2.Floor Under Cover RH/LH

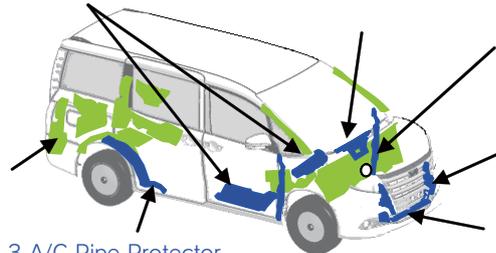
6.Nozzle ASSY Defroster

4.Fender Protector RH/LH

5.Radiator Side Reflector

1.Baffle plate

7.Silencer



3.A/C Pipe Protector

Developing Wood Materials That Use Forest Thinned Japanese Cedar

By mixing resin with processed wood flour from thinned trees, we have developed a material that achieves both strength and light weight (TABWD *1) We are using this new material for new Voxy and Noah models' service parts. Going forward we are also looking to develop various technologies for making use of thinned trees, as well as proceed to expand use to other vehicle types and parts. Such efforts contribute to recycling forests and making effective use of resources.

Voxy/Noah Fog lamp bracket service parts

Wood flour



+ Resin



*1.TABWD : Toyota Auto Body Wood plastic

Friendly to the Global Environment

Three Priority Themes :

Low Carbon

Recycling Orientation

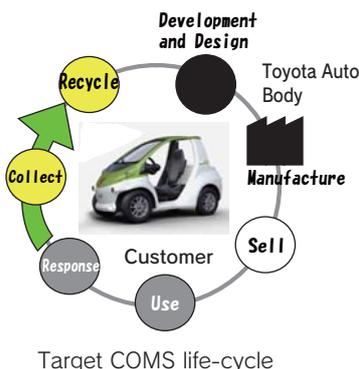
Harmony With Nature

Eco-Friendly Product Development

Efforts to Recycle Our Super-Compact EV COMS

Our environmentally friendly, super-compact EV COMS contains many recyclable resources.

COMS is not applicable to the Vehicle Recycle Law, and even at the disposal stage, we began self-initiated efforts for realizing a recycling-oriented society to make effective use of limited resources.



Meeting with related companies to study efforts to make clear easy-to-dismantle procedures and parts for recycling

Three Priority Themes :

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Harmony With Nature

Promoting Management of Chemical Substances Included in Products

We at Toyota Auto Body are coordinating with our raw material and parts business partners to understand the uses and assess risks of chemical substances included in our products, and we are working to conserve the environment via actions such as managing chemical substances and changing to use less environmental burdensome substances.

Proper Response to Global Chemical Substance Regulations, Starting with REACH

Response to Chemical Substance Regulations

Upon entering the 21st Century, chemical substance regulations, including ELV regulations *1 and REACH *2, became more stringent for all countries.

We at Toyota Auto Body are promoting the establishment of alternative technologies for SOCs in products and changeover of such SOCs while carefully observing the direction of regulations in order to properly handle these kinds of chemical substance regulations. In addition, Toyota Auto Body is cooperating with Toyota Motor Corporation and our business partners to build and administer a system for chemical substance management under these kinds of international regulations of chemical substances.

In fiscal year 2013, we held an IMPS *3 explanatory meeting for our business partners and we genuinely started IMPS recording in order to collect information on chemical substances in newly designed vehicle parts.

*1 European ELV Regulations : End-of-Life Vehicles
European Union regulations concerning vehicles for scrap.



We are taking proper action toward regulations through visiting and supporting business partners relevant to chemical substance recording (IMDS recording methods)

*2 REACH : Registration, Evaluation, Authorization and Restriction of Chemicals.

Regulations for clarifying the responsibility of industries in the management of chemical substances. These regulations also protect human health and the environment from such chemical substances

*3 IMDS : International Material Data System

A production material information system for the automotive industry

Action for VOC Regulations in Vehicle Cabins

VOC *4 (Volatile Organic Compounds), such as toluene, xylene, and formaldehyde, that volatilize from vehicle cabin parts are said to be potentially harmful to human health. We are using interior part materials in consideration of reducing vehicle cabin VOCs.

FY2013 New models on sale and full model change vehicles	Action status
Voxy / Noah	Cleared JAMA self-initiated targets

*4. VOC : Volatile Organic Compounds

Substances of Concern (SOC) Comments from the Person in Charge



Material Engineering Div.
Tsukinosuke Fujisaki

We are making efforts to establish alternative technologies and promote changeover of substances in order to provide products with minor environmental impact. Going forward, we look to promote further cooperation with our business partners for actions to reduce SOCs and also manage chemical substances in products.

Friendly to the Global Environment

Environmentally-Friendly Production Systems

Three Priority Themes :

Low Carbon

Recycling Orientation

Harmony With Nature



Production Engineering Headquarters
Production Environment
Committee Chairperson:
Vice President,
Akitsugu Ishiguro

Creating Eco-Friendly Factories that Exist Harmoniously with Nature

Starting from vehicle manufacturing that exists harmoniously with the Earth's environment, we are progressing with the further reduction of environmental burden from production activities.

- (1) Creation of simple and streamlined energy-saving production lines
- (2) Use of recyclable energy and development of resource-saving and recycling-oriented processing methods
- (3) Meticulous equipment operation management and daily kaizen
- (4) Promotion of factory greenification activities and creation of opportunities to interact with nature, such as with a biotope experience.

Going forward, we look to continue to contribute to the development of society and the earth via ongoing environmental conservation activities.

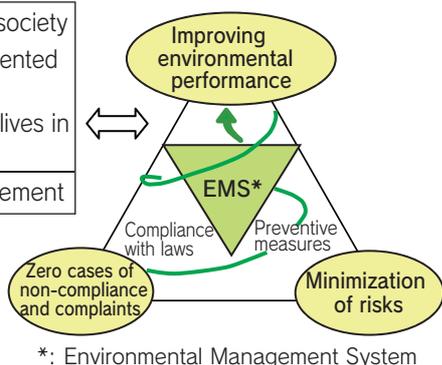
Fundamental Approach to Activities

With our Environmental Management System (EMS) as the core, we are promoting the three pillars of "Compliance with environmental laws," "Preventive measures," and "Performance improvement".

"Fifth Toyota Auto Body Environmental Action Plan"

Building a low-carbon society
Building a recycling-oriented society
Building a society that lives in harmony with nature
Environmental Management

Production Environment Activities: Three Important Pillars



Zero cases of non-compliance, compliants	①Establishment and management of self-initiated standard values ②Yokoten of cases of non-compliance and complaints, and case examples of near-miss accidents. ③Thorough daily management
Risk minimization	①Thorough development of risk reduction activities ②Promotion of prevention measures for things such as information leaks
Environment Performance Improvement (CO ₂ , resource-saving, etc.)	①Reduction of environmental burden by countermeasures taken at source of emission ②Elimination of waste through equipment operation kaizen ③Introduction and development of innovative technology for saving resources and energy

< Production Environment Activity Organization and Action Items >

	Organization	Action Items
Production Environment Committee	Production Environment Committee (At each plant)	①Reduction of environmental burden through improvement of productivity and kaizen of operational methods ②Appropriate daily equipment operation and maintenance management
	Energy Reduction Committee (Production Engineering Div.)	①Product streamlining via model changes, and kaizen of processing methods ②Creation of energy-saving production lines in plant renovations, and development of low CO ₂ emission production technology ③Introduction of renewable energy and improvement of energy supply efficiency
	Toyota Auto Body Group Production Environment Meeting (At each production consolidated subsidiary)	①Yokoten of environmental activities at Toyota Auto Body group companies ②Spreading of CO ₂ reduction activities in each business activity ③Thorough environmental hazard risk prevention and compliance with environmental laws in all countries and regions

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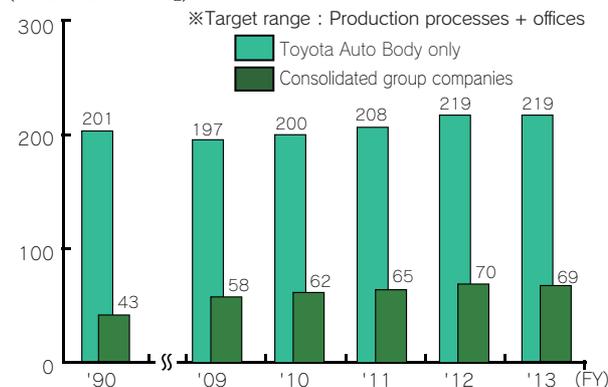
Thorough Energy-Saving Activities and Reduced CO₂ Emissions in Production Activities

We at Toyota Auto Body are introducing and developing production technologies for reducing CO₂, pursuing improved production line productivity, eliminating daily inefficiency thoroughly, and promoting correct operating of equipment. Additionally, we are making efforts to further improve transport efficiency in production logistics.

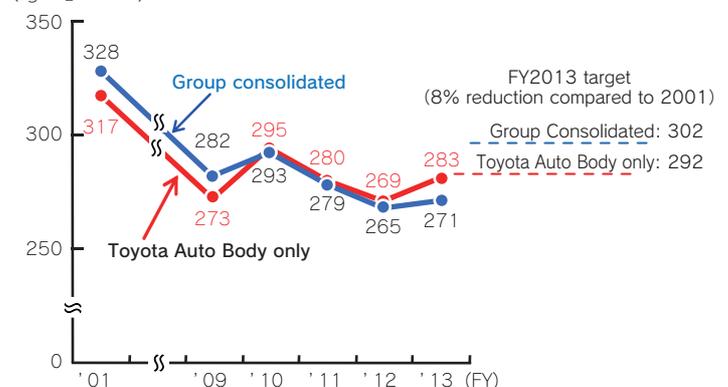
CO₂ Reduction Activities in Production Processes

- <1> Promoting thorough shutdown of equipment at times of non-operation
- <2> Introducing a cogeneration gas engine (7500cm) at the Inabe Plant Operation of the engine is scheduled for January 2015.
- <3> Saving energy in air conditioning for assembly operation processes and making high efficiency humidification for paint booth air conditioning units

CO₂ emissions volume
(Thousand tons-CO₂)



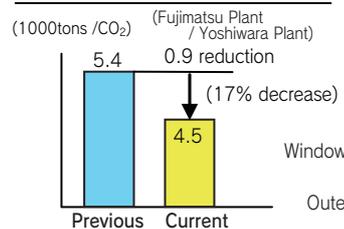
CO₂ emissions volume per vehicle
(kgCO₂/vehicle)



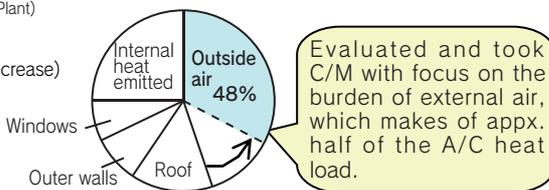
<Energy Saving in Air Conditioning of Assembly Plant Work Processes>

In our Fujimatsu and Yoshiwara Plant assembly processes, we conducted a building and A/C equipment energy-reduction evaluation and significantly reduced CO₂ emissions by countermeasures such as reducing the external heat load on A/C equipment. These efforts were taken for the purpose of both energy reduction and creating an easy-to-work environment. Going forward, we look to expand activities to other plants.

Assembly Plant Air Conditioning CO₂ Emissions



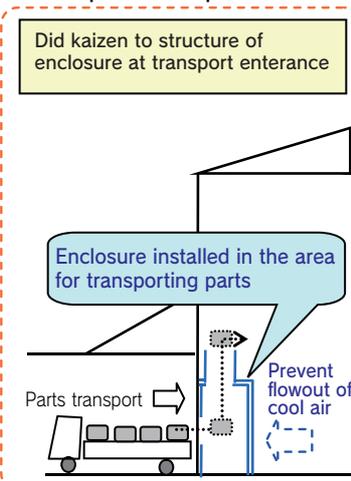
Air Conditioning Equipment Heat Burden Ratio (Summer)



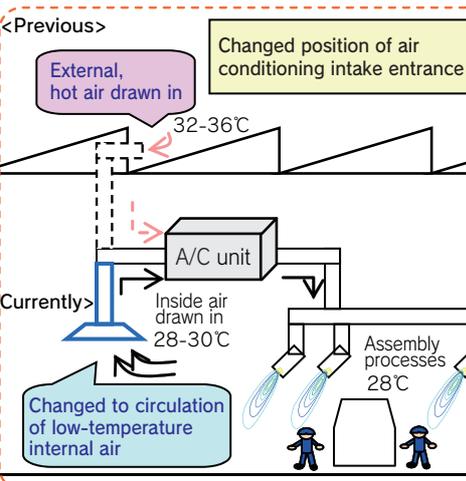
Energy-Savings Countermeasures

- <1> Prevent flowout of cool air to parts transport entrance
- <2> Change external air intake to circulation of internal air
- <3> Reduce flowout of cool air at logistics shutters

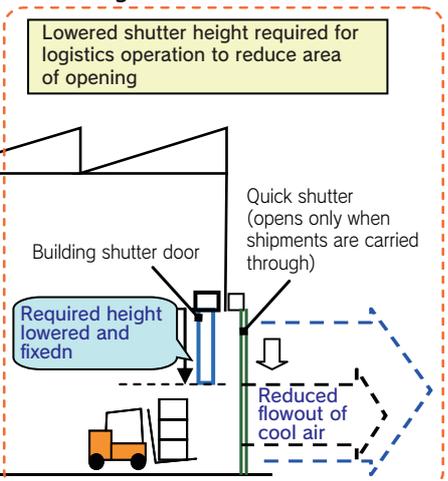
<1> Prevent flowout of cool air to parts transport entrance



<2> Change external air intake to circulation of internal air



<3> Reduce flowout of cool air at logistics shutters



Friendly to the Global Environment

Environmentally-Friendly
Production Systems

Three Priority Themes :

Low Carbon

Recycling
Orientation

Harmony
With Nature

Reducing Emissions and Effectively Using Resources

We are promoting improved yields on the production line as well as activities to effectively use resources, such as countermeasures to the source of emissions and reducing use of packaging materials in logistics.

Effectively Using Resources and Reducing Emissions In Products Model Changes

⟨Valuable materials: Recyclable items such as steel scraps⟩

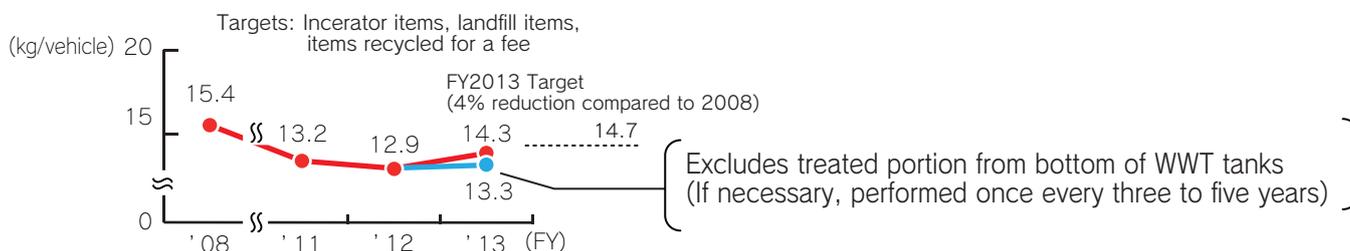
<1>Reduction of usage volume of steel stamping parts and resin material, etc. in production of new Voxy and Noah models.

⟨Waste materials: Incinerator items, landfill items, items recycled for a fee⟩

<1>Reduction of paint waste and wastewater sludge in production activities

<2>Detailed separation and recycling of metal composite parts

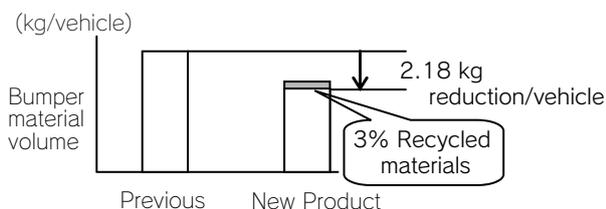
Volume of waste generated



<Effective use of resin material in new Voxy and Noah models at Fujimatsu Molding Plant>

We reduced volume of resin material used via things such as reduction of product thickness and recycling of resin waste in the design and production of new external bumper parts.

Bumper resin material reduction

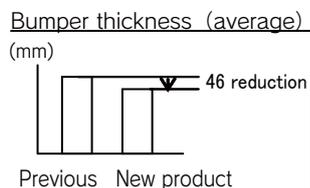
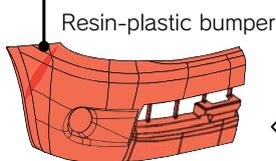


(Efforts to effectively use resources)

- <1> Bumper thickness reduction, lightweight design
- <2> Thin panel bumper molding
- <3> Recycling resin waste materials

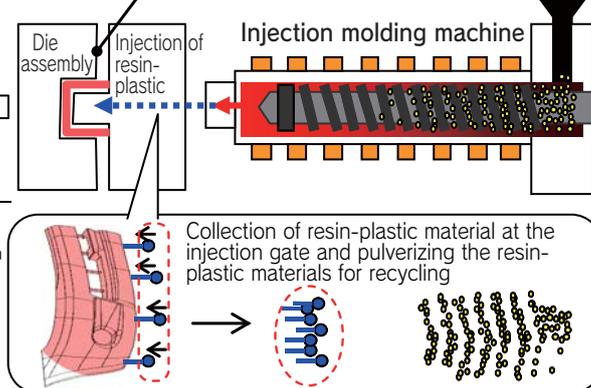
<1>Bumper thickness reduction, lightweight design

We made thorough weight reduction efforts via rigidity evaluations resin bumper



<2>Thin panel bumper molding

We achieved thin resin molding with mold design and molding parameter setting using resin flow and mold release simulations.



<3>Recycling resin waste materials

We are collection, pulverizing, and reusing waste material such as mold injection area gate material.

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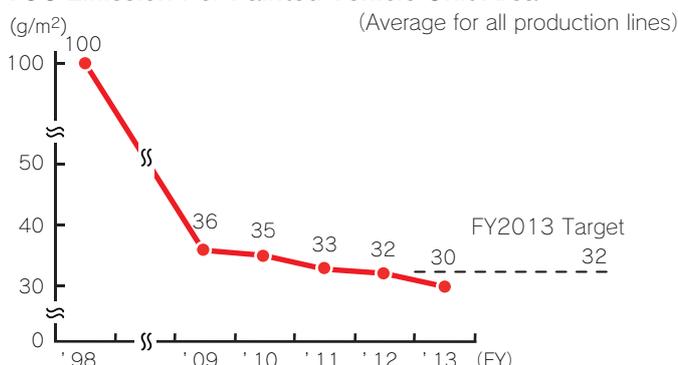
Reducing SOCs in Production Activities

In order to maintain a clean atmospheric environment, we are promoting a reduction of VOC (Volatile Organic Compounds) in coordination with our suppliers of materials and parts. We are also grasping SOC use and assessing risks, as well as switching to substances that burden the environment less or using less of such substances.

Activities to Reduce VOC Emissions Volume in Production Processes

- <1> Switching to waterborne paint for the basecoat in vehicle painting processes
- <2> Improvement of paint adhesion efficiency and reduction of paint usage volume by making the paint film thickness appropriate
- <3> Reduction of purge thinner usage volume and improvement of thinner recovery ratio

VOC Emission Per Painted Vehicle Unit Area



< Switch to Waterborne Paints for base topcoat >

Completion of Switch to
Planned Waterborne Paints

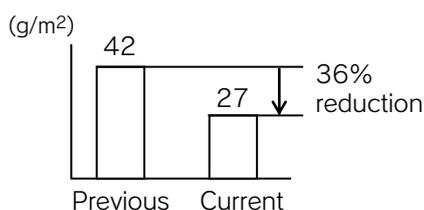
	2007	2010	2013
Fujimatsu Plant	Switch complete		
Yoshiwara Plant	Switch complete		
Inabe Plant			Switch complete

<VOC Reductions in Inabe Plant No. 1 Paint Line>

Beginning in FY 2012, we completed the switch to use waterborne paints of all colors for the basecoat in vehicle painting processes.

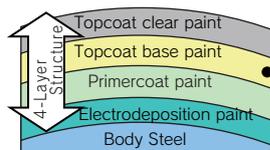
In addition, we improved paint adhesion efficiency during spray to significantly reduced VOC emissions volume.

Inabe Plant Body Paint VOC Emissions Per Unit of Painted Area



Efforts to Reduce VOCs

<1> Switched to waterborne paints



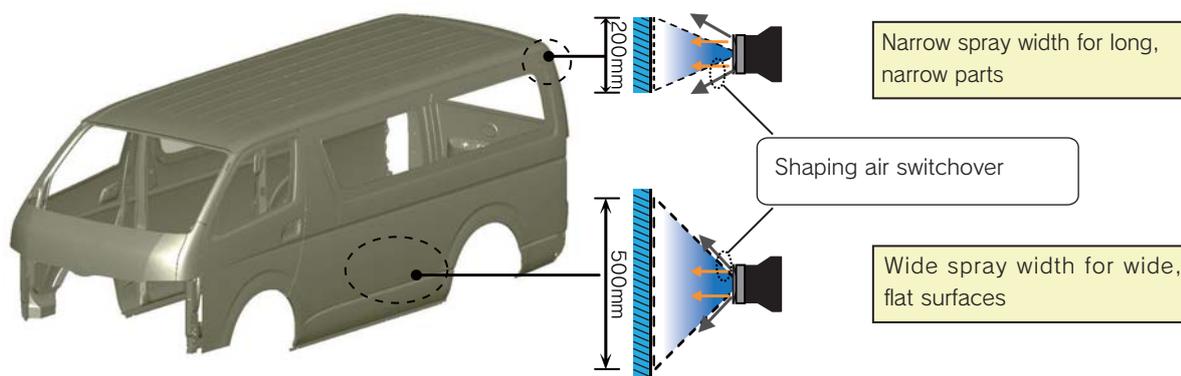
Use of waterborne paints for the topcoat base paint and thinner (organic solvent) without volatilizing elements led to reduced VOC emissions

<2> Reduced paint usage volume

Improved painting efficiency through control of spray width of the painted area

Improved Painting Efficiency Through Control of Spray Width of the Painted Area

By controlling the positions for spray paint on vehicles and allowing the width to vary, we achieved improvement in painting efficiency. Continuing from implementing in clear coat processes in FY2012, we expanded to implementation in primer painting processes in FY2013.



Friendly to the Global Environment

Environmental Management

Promoting Global Consolidated Environmental Management

Within our management system that coordinates domestic and overseas group companies, business partners, and our communities, we are promoting eco-factory activities that thoroughly incorporate environmental countermeasures from planning through operation at the time of constructing new plants or installing production equipment for new products. In addition, we are making efforts in environmental education to develop human resources capable of enhancing their knowledge and taking action.

Activities to Prevent Environmental Abnormalities in Production Processes

We are implementing on-site inspection at all Toyota Auto Body Group companies and setting checkpoints to prevent environmental abnormalities in production processes and at chemical storage locations.

- <1> Chemical containment dike functional inspections
- <2> Inspection of management status of production system wastewater drains and stormwater drains
- <3> Inspection of daily, periodic management conditions for chemical storage facilities



Inspection of chemical containment dikes (Toyota Auto Body, Fujimatsu Plant)



Inspection of production wastewater drains (Tokai Utility Motor Co., Ltd.)

Environmental Communication With Overseas Subsidiary Companies

Looking to thoroughly achieve environmental efforts beyond our previous annual on-site inspection, we have begun TV teleconferences once a month with overseas consolidated companies. Through these efforts, we are sharing timely expansion of solid environmental efforts, mutual confirmation, and examples of environmental countermeasures.

For our overseas trainees, we have incorporated environmental education into their curriculum. In FY2013, we provided environmental *Kiken Yochi* (KY) education using examples of environmental near-miss incidents and education for daily inspection of waste water treatment sites for trainees at Thai Auto Conversion Co., Ltd. (TAC) and Indonesia PT Sugity Creatives (SC).



Confirming environmental effort status through TV teleconferencing (Indonesia T-TEC)



Inspecting and educating at waste drainage treatment facilities (Indonesia SC trainees)

Environmental Build-in for Plated Parts in a New Factory in Indonesia

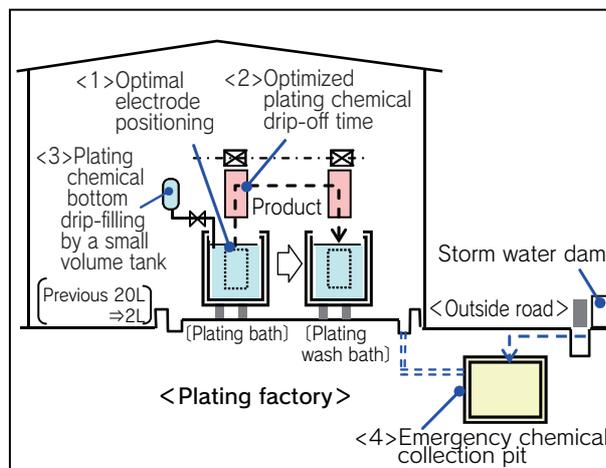
In the construction of our parts plating production factory that utilizes RPT (PT. Resin Plating Technology: Indonesia Bukashi), we implemented build-in activities with considerations for the environment. These activities include coordinating with specialized manufacturers from the plant planning stage to on-site business operations for effective use of plating chemicals and prevention of chemical flowout.

<Effective Use of Resources>

- <1> Prevention of excessive layering through optimum positioning of electrodes in the plating bath
- <2> Minimizing the volume of plating liquid chemicals removed from the plating tank by optimizing the completed drip-off time for liquid plating chemicals

<Preventing Chemical Release>

- <3> Reducing liquid spill risk during manual operations by maintaining the level of a small volume, chemical tank
- <4> Installation of an emergency chemical collection pit in preparation of spill in processes or outdoor stormwater drains



Environmentally friendly design at our plating factory (Indonesia RPT)

Other Environmental Data

[Volume of Resources Invested Into and Emitted From Our Business Operations]

[Environmental Education]

[Environmental Accounting]

[Active Releasing of Environmental Information]

In order to utilize the valued opinions of all readers to enhance further and reflect information more accurately for these CSR activities and this report of Toyota Auto Body for the future, please enter information in the survey.

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