Alpha Motors Assembly Plant, West Orange, NJ — Future State

**Steps**

- Total Steps = 7
- Value-Creating Steps = 2

**Time**

- Production Lead Time = 1.3 days
- Processing Time = 120 sec.

**Summary**

- Alpha HQ: Production Control
- Dearborn, MI: Weekly Schedule
- Alpha Plant: Materials Control
- Alpha Plant: Production Control
- Final Assembly & Test: C/T = 60 sec., C/O = Ø sec., 2 Shifts
- Wiper Subassembly: C/T = 60 sec., C/O = Ø sec., 2 Shifts
- Alpha Cross-Dock
- El Paso, TX
- Alpha Dist. Center
- Alpha Sales Order Bank

**Facility Summary**

- RM: 15 h.
- WIP: 2 h.
- FG: 14 h.
- 2 Shifts
- 5 Days
- EPE: 1 Day
- Defects = 5 ppm
- Defective = 1%

- Alpha Plant: 960/day
- 640 A
- 320 B

**Additional Notes**

- 3 Shifts
- 2 Shifts
- Daily
- Weekly
- El P aso, TX
- Alpha Cross-Dock
- Alpha Dist. Center
- Facility Summary
- RM 15 h.
- WIP 2 h.
- FG 14 h.
- 2 Shifts
- 5 Days
- EPE = 1 Day
- Defects = 5 ppm
- Defective = 1%
Beta Wipers Assembly Plant, Reynosa, Mexico — Future State

**Weekly Schedule**

** gamma stamping**

** Beta Warehouse**

** Stamped Parts **
- 200/Box
- 1,600/Pallet
- 12 Pallets

** At the Cell **
- ** Assembly Cell **

** C/T = 30 sec. **
- ** C/O = 5 min. **
- ** Uptime = 100% **
- ** 2 Shifts **

** Weekly Schedule**

** Beta HQ Production Control **

** Beta Plant Production Control **

** Harlingen, TX **

** 1 x Day **

** 1920 Wipers/Day **
- 640 A
- 640 B
- 16 Wipers/Tray
- 320 Wipers/Pallet
- 4 Pallets A
- 2 Pallets B

** Facility Summary **
- ** RM 16 h. **
- ** WIP 0 h. **
- ** FG 12 h. **
- ** 2 Shifts **
- ** 5 Days **
- ** EPE = 1 Day **
- ** Defects = 400 ppm **
- ** Defective = 5% **

** Detroit, MI **

** Alpha Motors **

** Beta Cross-Dock **

** Harlingen, TX **

** Tonawanda, NY **

** Motions **
- ** 28.1 hr. **
- ** 30 sec. **

daily

** Weekly **

** Daily **

** Alpha **

** Harlingen, TX **

** At the Cell **

** 16 h. **

** 0.1 h. (30 s.) **

** 12 h. **

** TIME **
- ** Production Lead Time = 28.1 hr. **
- ** Processing Time = 30 sec. **

** STEPS **
- ** Total Steps = 8 **
- ** Value-Creating Steps = 3 **