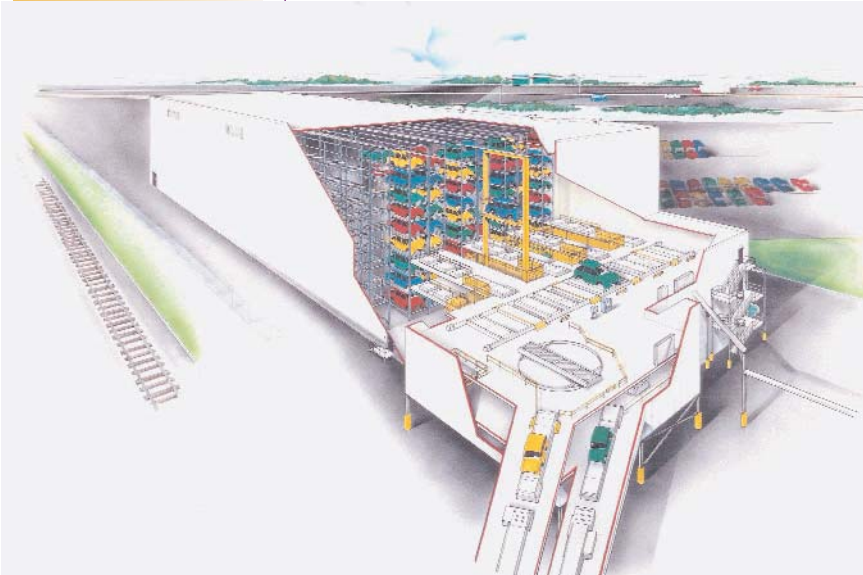


2-MINUTE OVERVIEW

Automotive Manufacturer Uses Automation for In-line Vehicle Sequencing



Features/Benefits Provided:

- Improved quality
- Improved productivity
- Allowed the customer and their suppliers to reduce in-process inventory
- Increased production scheduling window from 12 hours to 5 days

This customer initiated an in-line vehicle sequencing (ILVS) methodology. The objective was to introduce the same vehicle build schedule into Final Assembly as was started in the Body Shop. This enabled suppliers to receive, manufacture, assemble, ship, and deliver components in build sequence. The supplier contributed to the needed changes at this and an additional 15 of this customer's sites, making ILVS a reality.

This sequencing facility receives painted car bodies on skids from Paint operations and delivers them in sequence to Final Trim. The loads are stored in the AS/RS in the single deep position using only the rack locations between storage retrieval machine (SRM) aisles.

The supplier's scope of work for this project included 4 SRMs, rack supported storage, general construction, conveyor, and overall software controls.

The 4 aisle rack supported structure has 9 levels and 9 bays that provide a maximum of 648 load positions. Each storage position holds the current vehicle body on a skid. Based on predefined limits, positions were designed for both smaller and larger future body sizes.

If one aisle is taken out-of-service, all the loads in that aisle can be accessed from the adjacent aisle using the machine's double deep capacity.

The supplier provided 4 double-masted SRMs. Each machine is designed specifically to handle a car body on a skid weighing up to 2,200 pounds.

All construction activities were managed by the supplier. General construction included a 2 million cubic foot high rise AS/RS building. This 30,000 square foot facility included fire protection, a 300 foot conveyor trestle, and a computer controlled energy management system.

The final outcome was productivity and quality improvements, reducing costs for the entire manufacturing system. The customer and its suppliers were also able to reduce inventory.



**P.O. Box 1512
Milwaukee, WI 53201-1512
1.800.HKSystems
hkinfo@hksystems.com
www.hksystems.com**

Proud Member of the
AS/RS Product
Section of the
Material Handling
Industry