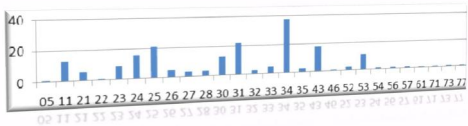


SERVICE BULLETINS ANALYSIS & CULTURE LEAN

SERVICE BULLETINS

ATA AFFECTED



FLEET AFFECTED

KIT REQUIRED

TOOLING REQUIRED

ACCOMPLISHMENT TIME

CULTURE LEAN

MANAGERS

TEAM LEADERS

STAFF

LEAN TEAM

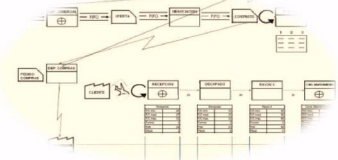
| Técnica Lean     | Directivos | Area | Prod. | Calidad |
|------------------|------------|------|-------|---------|
| Desperdicios     | X          | X    | X     | X       |
| Mejora continua  | X          | X    | X     | X       |
| 5s               | X          | X    | X     | X       |
| Grupos de mejora | X          | X    | X     | X       |
| Calidad Lean     | X          | X    | X     | X       |
| Gestión Visual   | X          | X    | X     | X       |
| Estandarización  | X          | X    | X     | X       |

LEAN MANUFACTURING IMPLEMENTATION STUDY

ACTUAL TIME MEASUREMENT

|                        | Tmin | Tme | Tmax |
|------------------------|------|-----|------|
| TOTAL Pintura          | 6    | 306 | 2049 |
| TOTAL Inspección       | 6    | 177 | 1050 |
| TOTAL Sistema Aeronave | 6    | 204 | 1460 |
| TOTAL Estructura       | 7    | 186 | 1099 |
| TOTAL Planta de        | 6    | 211 | 1144 |

ACTUAL VALUE STREAM MAPPING



FUTURE VALUE STREAM MAPPING



IMPLEMENTATION

5S

SMED

JIDOKA

KANBAN

PANEL LEAN

STANDARIZATION

KEY PERFORMANCE INDICATORS (KPIs)

CONTINUOUS IMPROVEMENT

ANALYSIS KPI's DEVIATIONS

SUGGESTIONS

Form for suggestions and KPI analysis, including fields for name, location, comment, and checkboxes for quality, infrastructure, personnel, and other categories.

