

# „BUILD-TO-ORDER“ IN THE ALL-NEW BMW CAR PLANT IN SAN LUIS POTOSÍ.

AUTOMOTIVE LOGISTICS CONFERENCE 26./27.02.2020 IN MEXICO-CITY



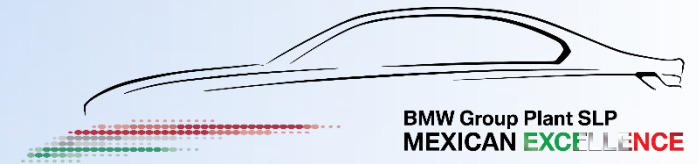
Karl-Friedrich Koch  
VP Production Control, Production System, Logistics

**BMW  
GROUP**

Planta San Luis Potosí



# PLANT SAN LUIS POTOSÍ - SOP 01.04.2019. CELEBRATING START OF SERIES PRODUCTION.



# PLANT SAN LUIS POTOSÍ - GRAND OPENING EVENT 06.06.2019. FROM MEXICO TO THE WORLD.

BMW Group Plant SLP  
MEXICAN EXCELLENCE

BMW  
GROUP



Planta San Luis Potosí



< VIDEO 1 : GRAND OPENING >

**BMW  
GROUP**



Planta San Luis Potosí



# THE NEW 3-SERIES LAUNCH IN PLANT SAN LUIS-POTOSÍ. ALL MILESTONES IN 2018 AND 2019 ACHIEVED.

FIRST VEHICLE F1, 04.10.2018

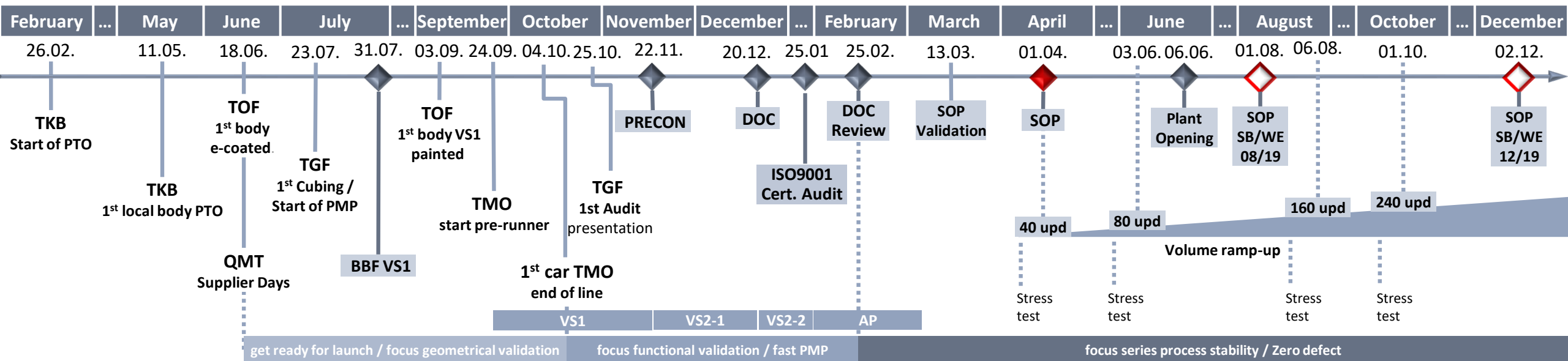
SOP 3-SERIES MEX, 01.04.2019

PLANT SLP OPENING, 06.06.2019



2018

2019



# PLANT SAN LUIS POTOSÍ - PRODUCTION RAMP-UP. KEY-FIGURES 2019.

431

Material suppliers worldwide within Delivery Control

30,499

White bodies produced

29,041

Painted bodies produced

25,538

G20 finished (F2)

13,280,343

Parts supplied for BiW and Paint-Shop



BMW Group Plant SLP  
MEXICAN EXCELLENCE

24,105

G20 dispatched to 3 markets

115,449,425

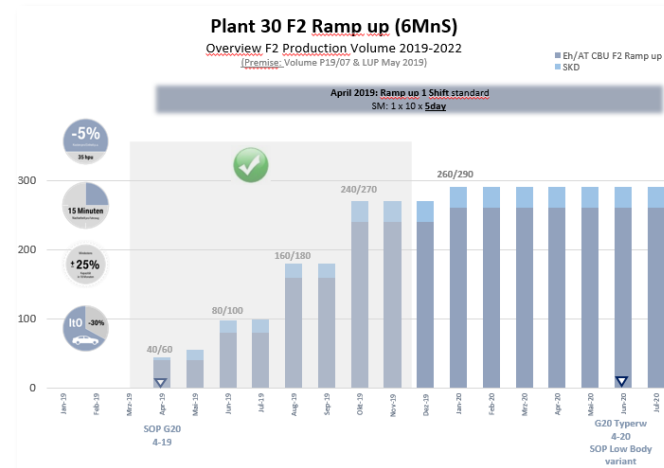
Parts supplied for Assembly

3,186

G20 SKD bodies exported to PNW2

17,338

Trucks processed



2,657

Trucks processed

# PLANT SAN LUIS POTOSÍ - STRATEGY. MEXICAN EXCELLENCE.

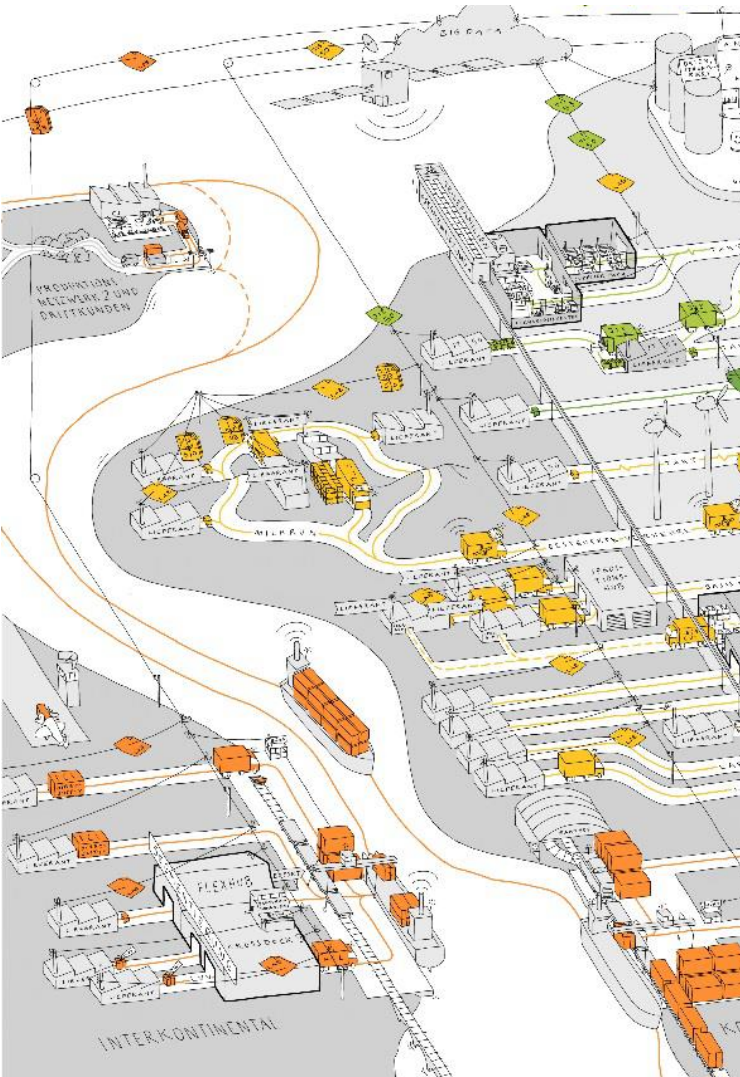


# PLANT SAN LUIS POTOSÍ - PLANT CONFIGURATION. HIGHLY ADAPTABLE TO FULFILL CUSTOMER DEMANDS, TODAY AND IN FUTURE.





# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. BASIC CHALLENGE.

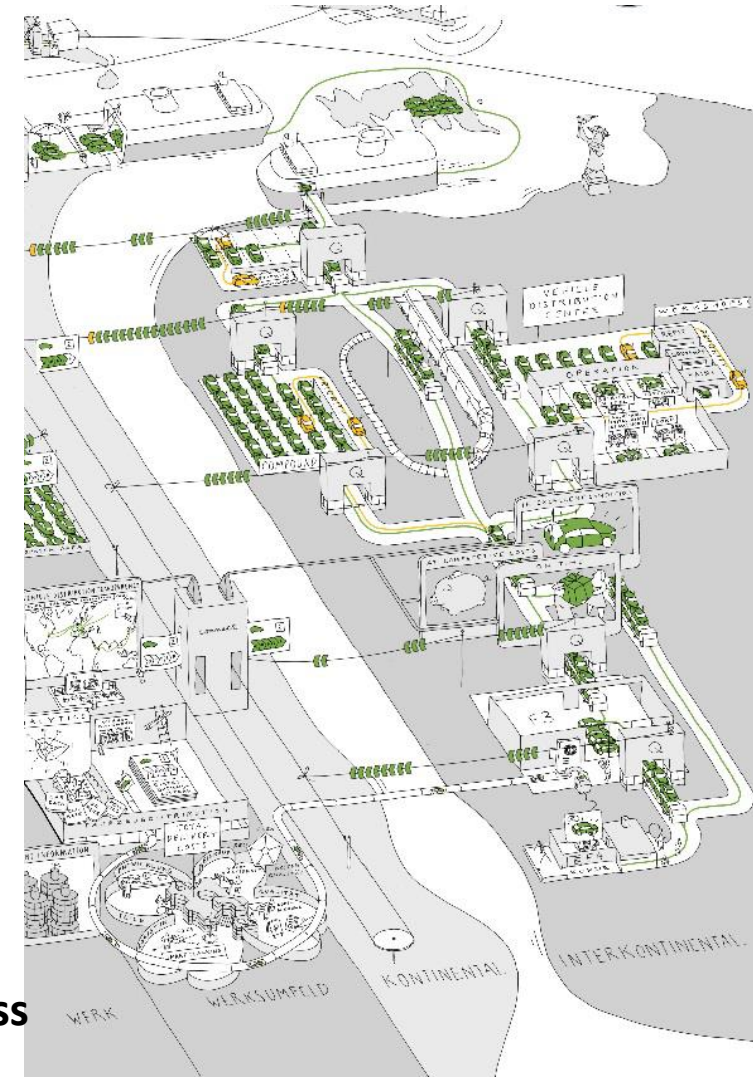


**Customer Focus** : State-of-the-Art Technology,  
Product Quality and **Individuality**

**> 10,000,000,000 Variants** of BMW 3-Series

BMW Cars are **Build-to-Order**

**Complexity & Stability of Order-to-Delivery Process**  
(Inbound Supply Chain, Production, Distribution)




# < VIDEO 2 : BUILD TO ORDER >



# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. ACHIEVEMENTS 2019.

**W**  
Wirksamkeit  
Effectiveness

  
**Plant Installation**  
Goods Receipt, Yards,  
Warehouses NSM-OCS, Waste  
Distribution

  
**OtD Process Excellence**  
100% E2E Process  
Orientation

  
**Transparency and Control**  
Prod. Control Cockpit,  
Prod. Control Room


**Ramp-Up and On-Time  
Delivery Performance**

AP	100%	✓
40 upd	100%	✓
80 upd	100%	✓
160 upd	100%	✓
240 upd	100%	✓

**I**  
Integration

  
**Partner Management**  
7 LSP's (> 900 FTE's)  
68 SP's in total

  
**Qualification & Training**  
BMW Employees,  
LSP Employees.


  
**Supplier Logistics Qualification  
(LQS) 135 MEX**  
3-Series Suppliers

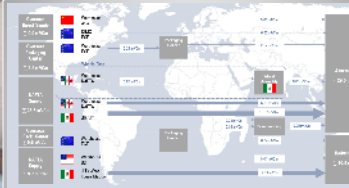
  
**Supplier EDI-Integration**  
ASN, Bordero,  
SmartCM, CSC...

  
**EFQM-Award**  
Plant SLP recognized  
for Excellence

**N**  
Netzwerk  
Network

  
**BMW Technology Network**

  
**BMW Production Network  
worldwide**

  
**Supplier Network  
worldwide**

**Logistics Service Providers**



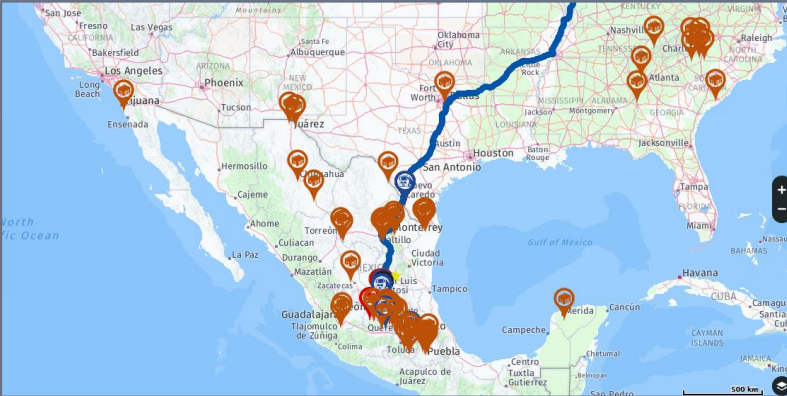
# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. HIGHLIGHT : CONNECTED SUPPLY CHAIN.




# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. HIGHLIGHT : CONNECTED SUPPLY CHAIN.

Connected Supply Chain
🔍 🌐 🏠

Line Stoppage
Track & Trace
BMW Overview
SPAB Monitoring MEX
Supply Control List
Overall Work Basket
WEB MD04
Contact Data
Event Chain
TK-M-120 Proc ess Board



HALL 50  
Tracking Point (SAP): Z4500  
Assembly Quantity: 4 pcs



14/02/2020 07:09 am    14/02/2020 07:13 am    14/02/2020 07:17 am    14/02/2020 07:20 am    14/02/2020 07:24 am

Current Days of Supply 3.4 Day(s)

SAN LUIS POTOSÍ | All Material planners | Several Part families

Parts family (call-off type)	Supplier name	Covered until	Parts booked goods receipt (V)			DOS Check
			SWET	Order	Sequ_V	
Exhaust System ABGKBR2 (K)	Boysen	11.02.2020 07:39	10.02.2020 15:17	0620993	0000032078	I.O.
Axle Front ACHKBR1 (K)	ZF	11.02.2020 08:44	11.02.2020 06:51	0636878	0000032144	I.O.
Axle Rear ACHKBR2 (K)	ZF	11.02.2020 08:51	11.02.2020 06:58	0636878	0000032144	I.O.
Rear Parcel Shelf ALBKBR1 (S)	Greiner	12.02.2020 13:58	11.02.2020 13:38	0632530	0000032969	I.O.
Carpets BVKKBR1 (S)	Autoneum	11.02.2020 08:09	10.02.2020 11:17	0628414	0000032348	DOS S chet

### Supply Track and Trace of Material Shipments (LIVE)

\*Material  
7422294-09    ASSY RH SUPPORT LOCK

Plant	Plant name	Supplier note	Warehouse Stock	Current Range	User Name	MRP Controller phone
LY78	BMW SLP S.A. de C.V.	04/19 HR	1,244	3.4	Lagunas, Dia	444-2-046190
A167	BMW AG Versorgungszentrum PNW2		0	999.9	Auslauf	
A120	BMW AG WERK DINGOLFING FZG	T1402-28: MR.ORACZEWSKI / TRZASKA-RYBICKA G23-11/20	60	16.1	Falter, Prak	8731-7621026
A115	BMW AG FIZ/Werk 0		73	999.9	Manevski, Su	015160137117
A156	BMW AG VZ LEIPZIG		0	999.9	ANLAUF 997	
A110	BMW AG WERK MÜNCHEN FZG	SHB,T1202-32 SORTIERAKTION, TRANSPORTSCHADEN	2,754	2.6	Conk, Stepha	089-38236981
A190	BMW AG DYNAMIKZENTRUM		282	0.0	Tsamo, Josia	089382-94340

### BMW World-Wide Inventory Transparency

### Revision of Current Material Coverage

### Monitoring of all JIX Material with Alert Function

AL Conference CDMX | TK-M-1 KFK | 26.02.2020

Template DID-MX-0000775 | V 6.0

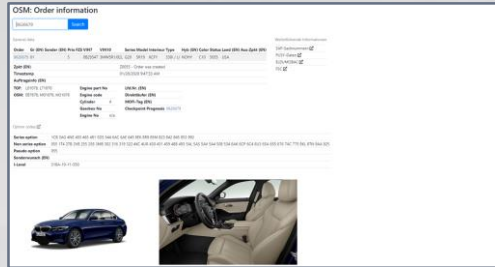
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# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. HIGHLIGHT : PRODUCTION CONTROL ROOM.



# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS.

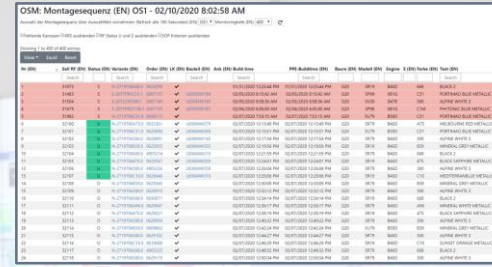
## HIGHLIGHT : PRODUCTION CONTROL ROOM.



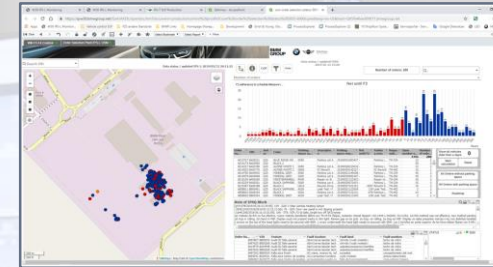
Customer Order Steering



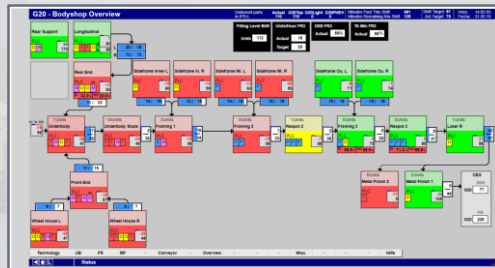
Supply Chain Steering



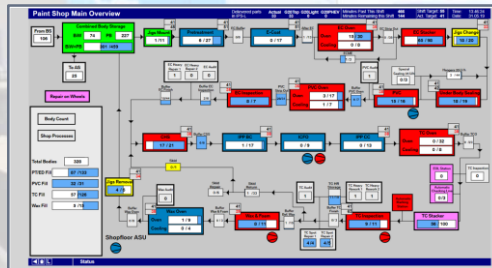
Production Order Sequence Steering



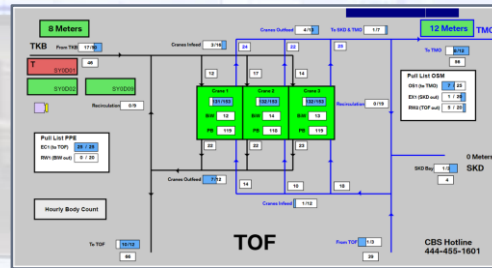
Vehicle Tracing, Distribution Steering



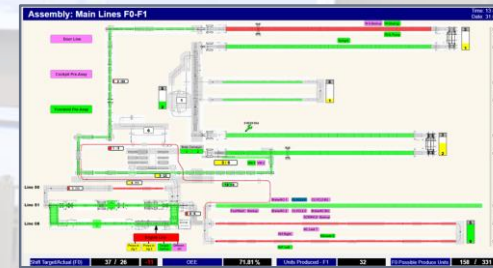
BIW Technology Steering



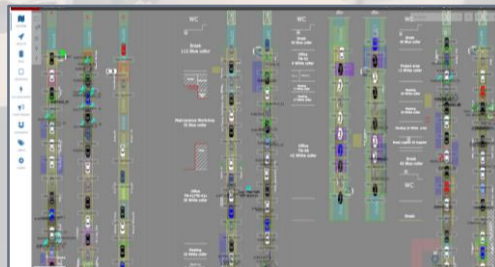
Paint Technology Steering



CBS and Conveyor Steering



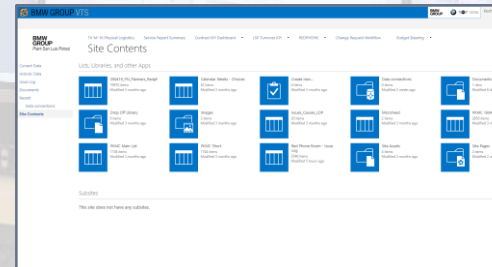
Assembly Technology Steering



Workplace Operations Status



Maintenance Operations Status

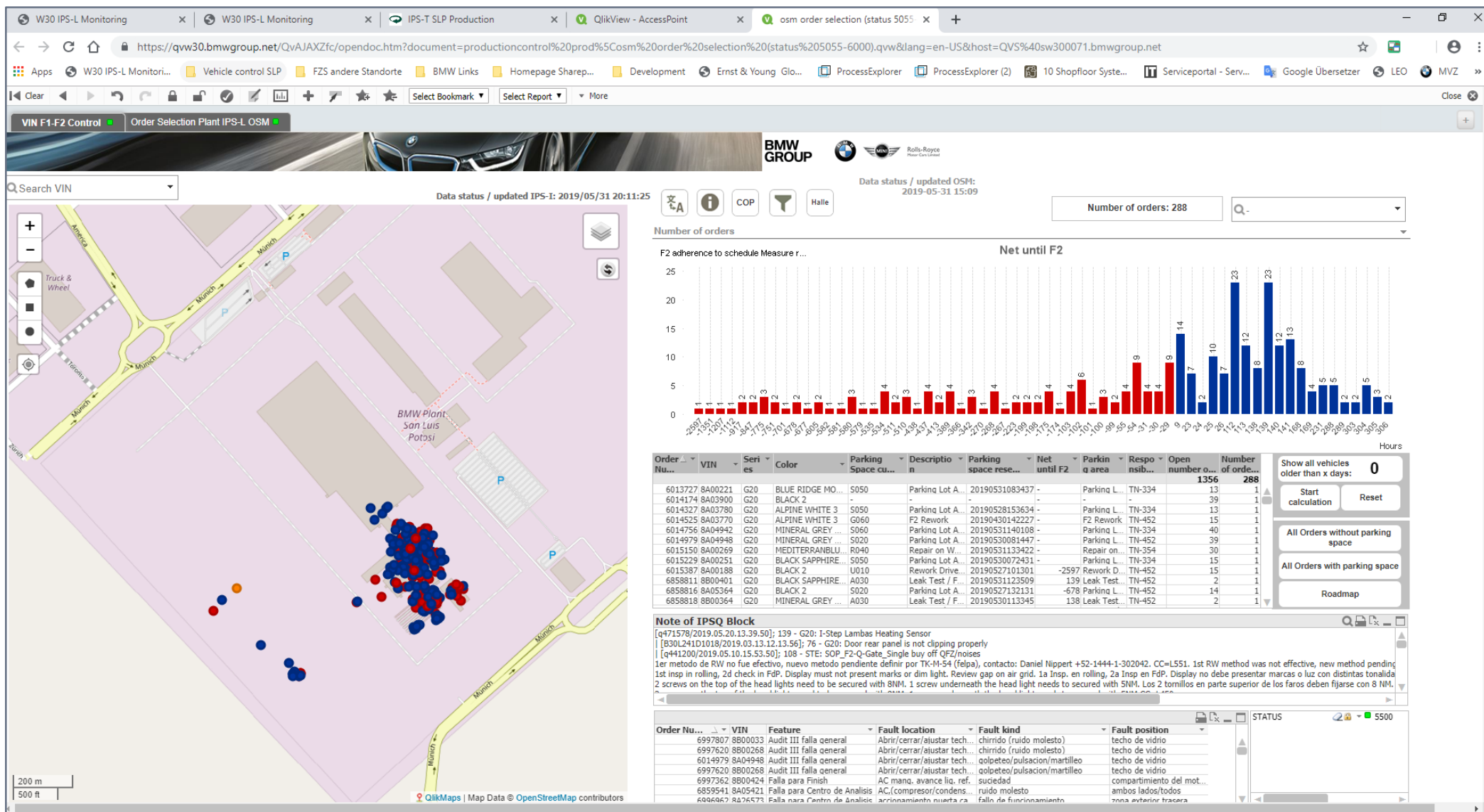


Lineside Material Supply Status



56x WebCam-Status View

# PLANT SAN LUIS POTOSÍ - PRODUCTION SYSTEM, LOGISTICS. HIGHLIGHT : CONNECTED DISTRIBUTION (IN PROGRESS).



**Search VIN** [input field]

Data status / updated IPS-I: 2019/05/31 20:11:25

Number of orders: 288

**F2 adherence to schedule Measure r...**

**Net until F2**

Order Nu...	VIN	Seri...	Color	Parking Space cu...	Descriptio...	Parking space rese...	Net until F2	Parkin...	Respo...	Open number o...	Number of orde...
6013727	8A00221	G20	BLUE RIDGE MO...	S050	Parking Lot A...	20190531083437	-	Parking L...	TN-334	13	1
6014174	8A03900	G20	BLACK 2	-	-	-	-	-	-	39	1
6014327	8A03780	G20	ALPINE WHITE 3	S050	Parking Lot A...	20190528153634	-	Parking L...	TN-334	13	1
6014525	8A03770	G20	ALPINE WHITE 3	G060	F2 Rework	20190430142227	-	F2 Rework	TN-452	15	1
6014756	8A04942	G20	MINERAL GREY	S060	Parking Lot A...	20190531140108	-	Parking L...	TN-334	40	1
6014979	8A04948	G20	MINERAL GREY	S020	Parking Lot A...	20190530081447	-	Parking L...	TN-452	39	1
6015150	8A00269	G20	MEDITERRANBLU	R040	Repair on W...	20190531133422	-	Repair on...	TN-354	30	1
6015229	8A00251	G20	BLACK SAPPHIRE...	S050	Parking Lot A...	20190530072431	-	Parking L...	TN-334	15	1
6015387	8A00188	G20	BLACK 2	U010	Rework Drive...	20190527101301	-2597	Rework D...	TN-452	15	1
6858811	8B00401	G20	BLACK SAPPHIRE...	A030	Leak Test / F...	20190531123509	139	Leak Test...	TN-452	2	1
6858816	8A05364	G20	BLACK 2	S020	Parking Lot A...	20190527132131	-678	Parking L...	TN-452	14	1
6858818	8B00364	G20	MINERAL GREY...	A030	Leak Test / F...	20190530113345	138	Leak Test...	TN-452	2	1

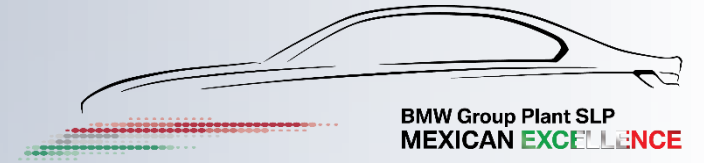
**Note of IPSQ Block**

[q471578/2019.05.20.13.39.50]; 139 - G20: 1-Step Lambas Heating Sensor  
 [B30L241D1018/2019.03.13.12.13.56]; 76 - G20: Door rear panel is not clipping properly  
 [q411200/2019.05.10.15.53.50]; 108 - STE: SOP\_F2-Q-Gate\_Single buy off QZ/Inoses  
 1er metodo de RW no fue efectivo, nuevo metodo Pendiente definir por TK-M-54 (Felpa), contacto: Daniel Nippert +52-1444-1-302042. CC=L551. 1st RW method was not effective, new method pending  
 1st insp in rolling, 2d check in FdP. Display must not present marks or dim light. Review gap on air grid. 1a Insp. en rolling, 2a Insp en FdP. Display no debe presentar marcas o luz con distintas tonalidad  
 2 screws on the top of the head lights need to be secured with 8NM. 1 screw underneath the head light needs to be secured with 5NM. Los 2 tornillos en parte superior de los faros deben fijarse con 8 NM.

Order Nu...	VIN	Feature	Fault location	Fault kind	Fault position	STATUS
6997807	8B00033	Audit III falla general	Abrir/cerrar/ajustar tech...	chirrido (ruido molesto)	techo de vidrio	5500
6997620	8B00268	Audit III falla general	Abrir/cerrar/ajustar tech...	chirrido (ruido molesto)	techo de vidrio	
6014979	8A04948	Audit III falla general	Abrir/cerrar/ajustar tech...	golpeteo/pulsacion/martilleo	techo de vidrio	
6997620	8B00268	Audit III falla general	Abrir/cerrar/ajustar tech...	golpeteo/pulsacion/martilleo	techo de vidrio	
6997362	8B00424	Falla para Finish	AC mano, avance liq. ref.	suciedad	compartimiento del mot...	
6858841	8A05421	Falla para Centro de Analisis	AC,(compresor/condens...	ruido molesto	ambos lados/todos	
6806667	8476573	Falla para Centro de Analisis	aproximamiento muestra ca	fallo de funcionamiento	zona exterior trasera	



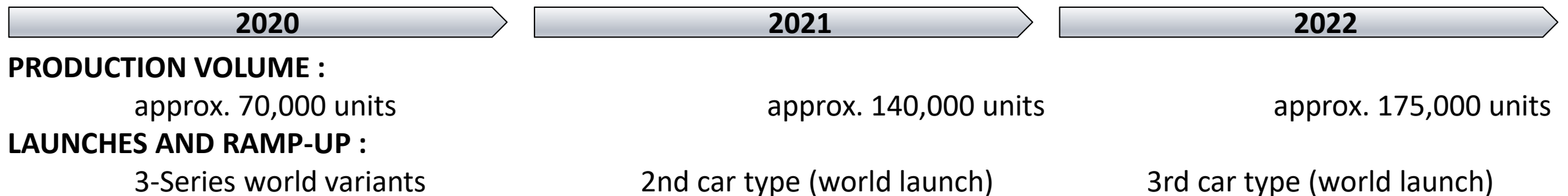
# PLANT SAN LUIS POTOSÍ - FROM MEXICO TO THE WORLD.



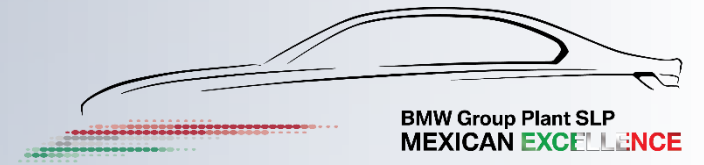
**< VIDEO 3 : FROM MEXICO TO THE WORLD >**



# BMW GROUP - PLANT SAN LUIS POTOSÍ. WHAT IS STILL AHEAD OF US ...



**PLANT SAN LUIS POTOSÍ - FROM MEXICO TO THE WORLD.  
2019 WAS JUST THE START.**



**THANK YOU FOR YOUR ATTENTION.  
GRACIAS POR SU ATENCIÓN.**

