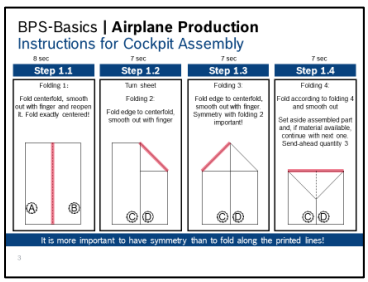
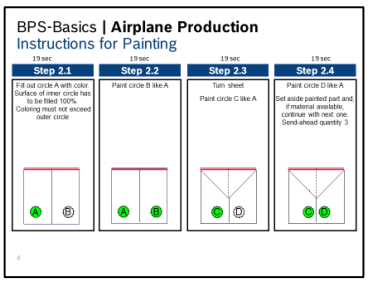
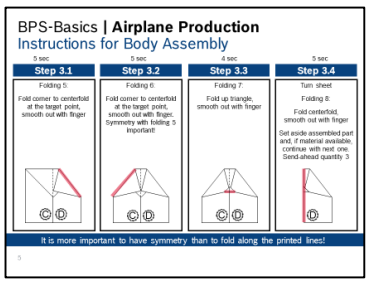
BPS-Basics | **Airplane Production**
Instructions for Participants

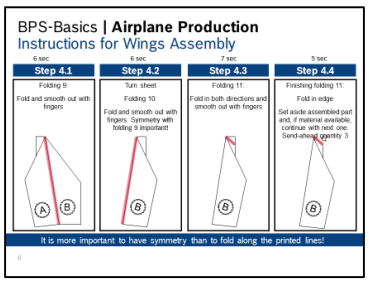
Material to be prepared before training (1/2)

1. Print Work instructions

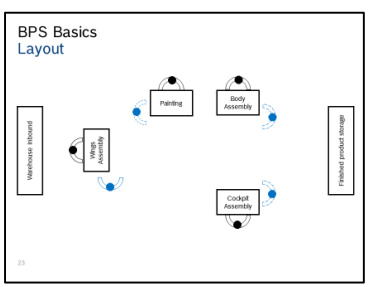








2. Print Cycle Times Diagram and Layout (2 pages)



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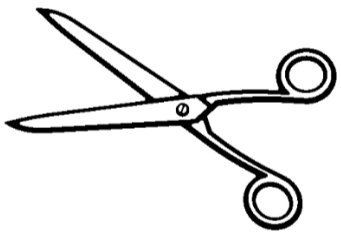
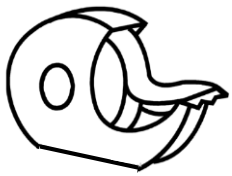
BPS-Basics | **Airplane Production**
Instructions for Partecipants

Material to be prepared before training (2/2)

3. Scissor



4. Adhesive tape



5. Stopwatch (or smatphone)

BPS-Basics | **Airplane Production**

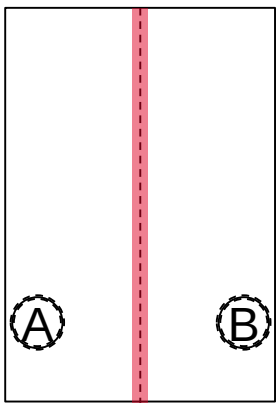
Instructions for Cockpit Assembly

8 sec

Step 1.1

Folding 1:

Fold centerfold, smooth out with finger and reopen it. Fold exactly centered!



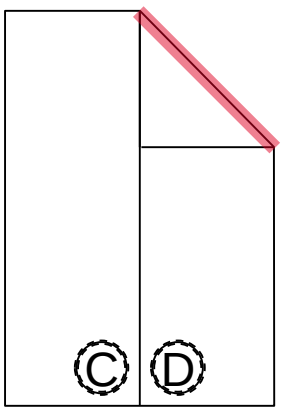
7 sec

Step 1.2

Turn sheet

Folding 2:

Fold edge to centerfold, smooth out with finger

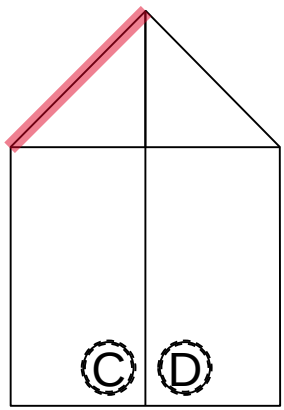


7 sec

Step 1.3

Folding 3:

Fold edge to centerfold, smooth out with finger. Symmetry with folding 2 important!



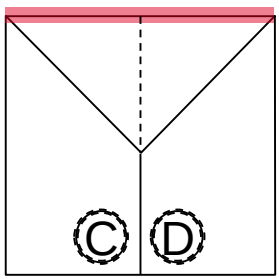
7 sec

Step 1.4

Folding 4:

Fold according to folding 4 and smooth out

Set aside assembled part and, if material available, continue with next one. Send-ahead quantity 3



It is more important to have symmetry than to fold along the printed lines!

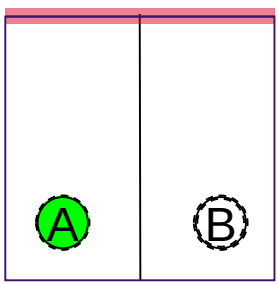
BPS-Basics | **Airplane Production**

Instructions for Painting

19 sec

Step 2.1

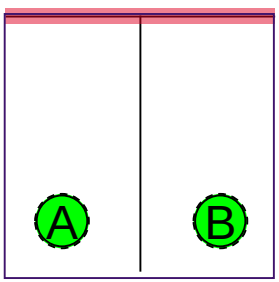
Fill out circle A with color. Surface of inner circle has to be filled 100%. Coloring must not exceed outer circle



19 sec

Step 2.2

Paint circle B like A

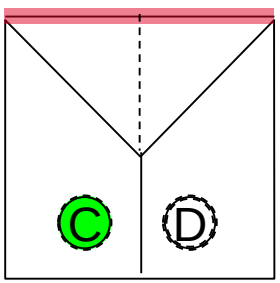


19 sec

Step 2.3

Turn sheet

Paint circle C like A

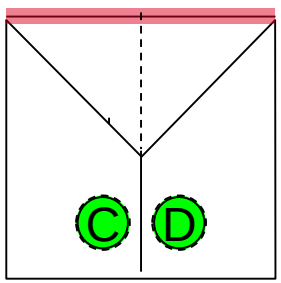


19 sec

Step 2.4

Paint circle D like A

Set aside painted part and, if material available, continue with next one. Send-ahead quantity 3



BPS-Basics | **Airplane Production**

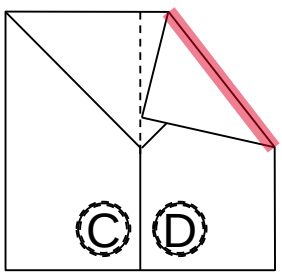
Instructions for Body Assembly

5 sec

Step 3.1

Folding 5:

Fold corner to centerfold at the target point, smooth out with finger

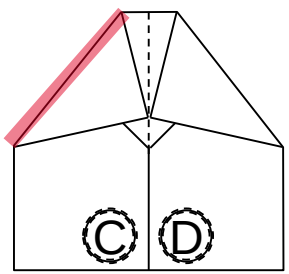


5 sec

Step 3.2

Folding 6:

Fold corner to centerfold at the target point, smooth out with finger. Symmetry with folding 5 important!

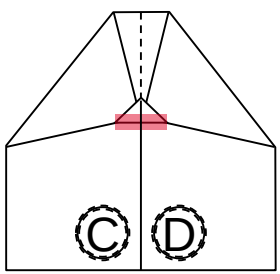


4 sec

Step 3.3

Folding 7:

Fold up triangle, smooth out with finger



5 sec

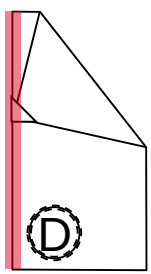
Step 3.4

Turn sheet

Folding 8:

Fold centerfold, smooth out with finger

Set aside assembled part and, if material available, continue with next one. Send-ahead quantity 3



It is more important to have symmetry than to fold along the printed lines!

BPS-Basics | **Airplane Production**

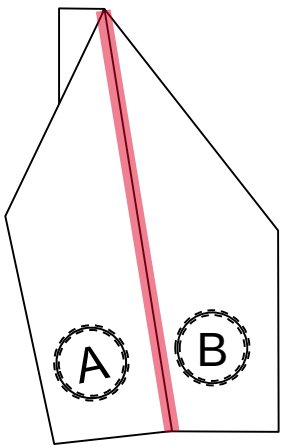
Instructions for Wings Assembly

6 sec

Step 4.1

Folding 9:

Fold and smooth out with fingers



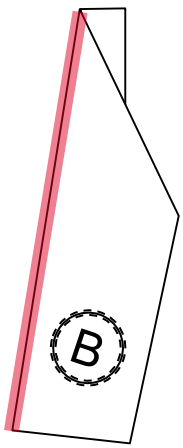
6 sec

Step 4.2

Turn sheet

Folding 10:

Fold and smooth out with fingers. Symmetry with folding 9 important!

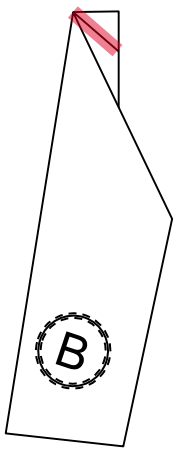


7 sec

Step 4.3

Folding 11:

Fold in both directions and smooth out with fingers



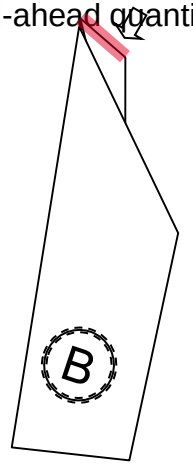
5 sec

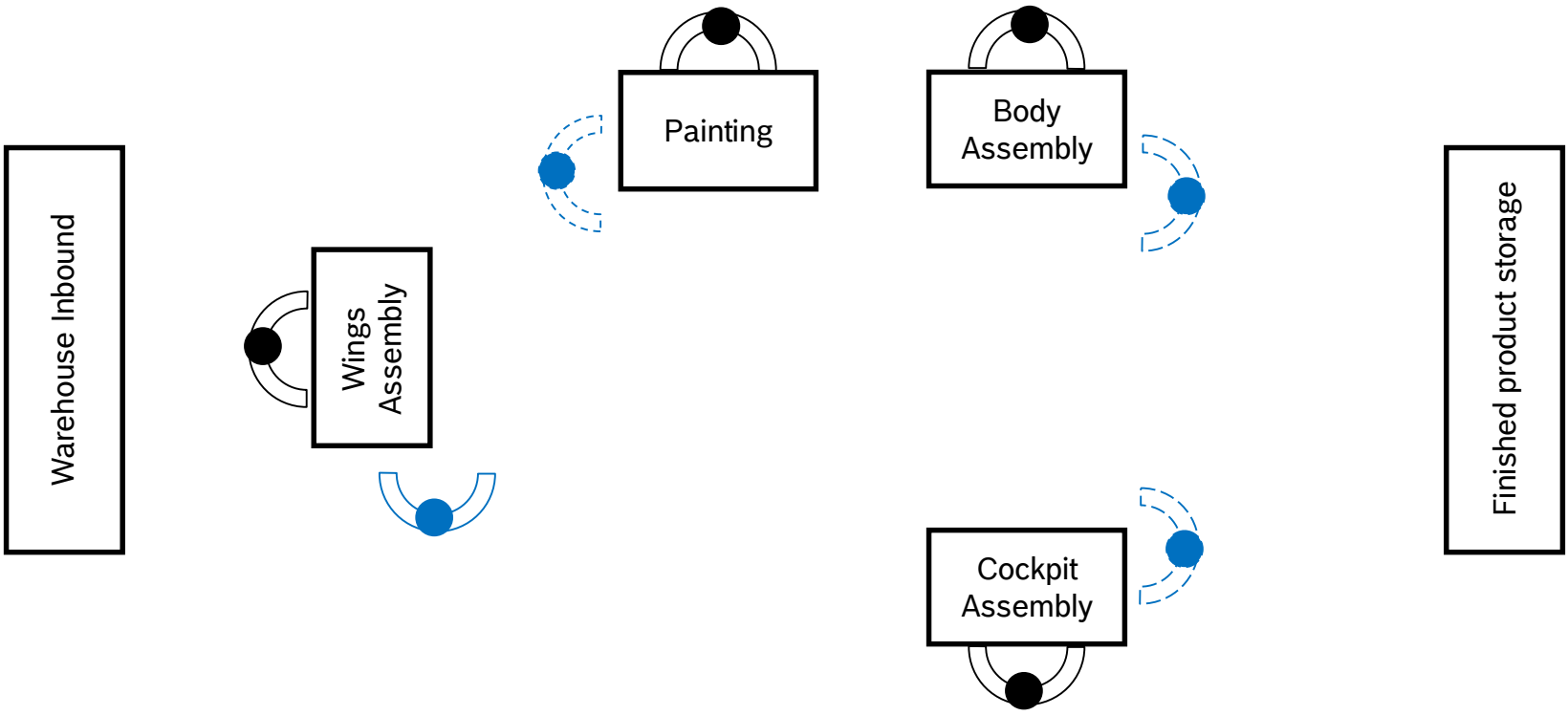
Step 4.4

Finishing folding 11:

Fold in edge

Set aside assembled part and, if material available, continue with next one. Send-ahead quantity 3



It is more important to have symmetry than to fold along the printed lines!

BPS Basics
Layout