

Plant data sheet

13 NOVEMBER 2015

The Renault Palencia plant

General information

- Plant opened **2 January 1978**
- Location: Villamuriel de Cerrato (Castilla y León region, Spain), 50 km north of Valladolid
- Surface area: 1,666,911 square metres (with buildings covering 304,286 square metres)
- Workforce: **4,200** (average age 34, 17% women)
- **More than 6 million vehicles made since 1978** (including more than 4 million Méganes since 1995): R12, R18, R14, R9, R11, R21, R19, Laguna, Mégane 1, Mégane 2, Mégane 3, Kadjar
- **Current production:** Kadjar, New Mégane, including GT, GT Line, and Mégane 3 (hatch, estate, coupé, RS) versions
- 88% of production exported

Evolution de la production

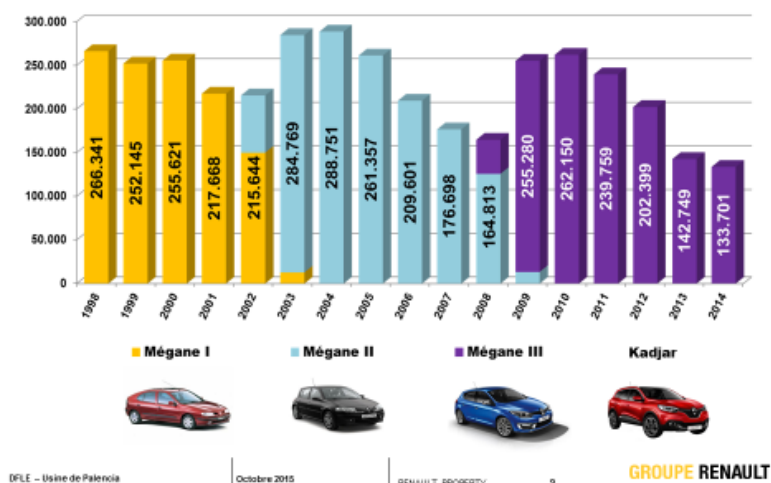


Image: Production from 1998 to 2014

- **€600 million** investment at Renault's Spanish plants from 2014 to 2016
- Quality certification: ISO 9001 since 1994
- Environmental certification: ISO 14001 since 1999

Plant transformation for Kadjar and New Mégane

- **Press shop:** more than **70 new tooling sets**
- **Sheet metal shop:** 874 robots
 - New chassis shop ("Main Floor"), with 250 high-tech robots
 - New body side assembly line ("Nissan Standard Line", NSL): 70 new robots
 - **Upgrade (carry-over) to existing door and body lines**, with upgrades to more than 70 robots

- **Paint shop:**
 - Upgrade to accommodate **new body colours**, with **six new robots**
 - New **light booth**

- **Assembly line:** single-flow line
 - Assembly line adapted to **dimensions** of new vehicles
 - New shop making **4x4 and 4Control** axle subsystems
 - Upgrade to **exhaust shop**
 - Upgrade to **slides and swings**
 - New **handling systems** for bumpers, wheels and assembled engines
 - Full-kitting process for managing component diversity (parts count 4,500, twice the previous figure): full parts kits brought right up to the assembly line, for improvements in workstation ergonomics (with fewer transfers and motions), safety (with less truck traffic), quality and overall plant performance
 - Expansion to **brake system** test area and upgrade to **run-in benches** (quality process)

- **Logistics:** two-fold increase in parts count, up to 4,500, requiring change in flow management

Training and skills development

- Personnel training in 2014 totalled 107,308 hours (i.e. **42 hours per person**) and would double with arrival of the new models.
- A hundred people from the Palencia plant visited the **Renault Vehicle Prototype Centre (CRPV)** as part of a product and process skills development programme in the run-up to production release of Kadjar and New Mégane.
- **All operators** attend courses at the plant's **Dexterity School (Dojo)**, to learn the practices required in volume production of Kadjar and New Mégane.
- New recruits take **special courses** on product characteristics, safety and quality.
- All personnel take courses at the plant's new **Perceived Quality School**.