



**THE MINI PRODUCTION
TRIANGLE IN THE UK.**





PLANT HAMS HALL MINI ENGINE ASSEMBLY.

Plant Hams Hall near Birmingham currently has 1,000 associates and is Plant Oxford's supplier of the new family of MINI petrol engines.

The plant is BMW Group's main supplier of all four-cylinder petrol engines. For the production of the New MINI engines around £30 million has been invested in the plant.

The production of the New MINI engines extends the current product range and will take annual total production volume to over 300,000 units.



THE MINI PRODUCTION TRIANGLE IN KEY NUMBERS.

- » 3 Plants: Hams Hall, Oxford, Swindon
- » 6,800 associates
- » 7 days a week and up to 23 hours per day MINI production
- » up to 800 MINIs produced every day
- » 240,000 MINIs per annum mid-term capacity
- » £200 million investment for the New MINI
- » $1,5 \times 10^{16}$ MINI variants could theoretically be built
- » 1,000,000th MINI in April 2007



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PLANT
HAMS HALL

PLANT
OXFORD

PLANT
SWINDON



PLANT OXFORD MINI BODYSHOP & PAINT & ASSEMBLY.

Since the first MINI drove off the line in April 2001, MINI production at the Oxford plant has developed into a success story in the automotive industry. Initial production forecasts of 100,000 units per annum have been surpassed with over 200,000 units produced in 2005. Today, a total number of 4,700 associates work at the plant.

The BMW Group has invested over £100 million in the plant to create the foundation for the production of the New MINI and to increase production capacity up to 240,000 units per year over the medium term.

Plant Oxford is responsible for body shell production, paint and final assembly of MINI.



PLANT SWINDON MINI PRESSINGS & SUB-ASSEMBLIES.

As the new main supplier of MINI pressings and sub-assemblies, a different chapter has begun for the Swindon plant in its fifty-year history. About 90% of the pressings and almost 80% of the sub-assemblies like doors and closures for MINI are produced in Swindon. During the past three years, around £60 million has been invested in the preparation for MINI production.

The plant with its 1,100 associates has gone through an extensive restructuring and modernisation programme. It works with the very latest pressings and sub-assembly technology in accordance with the high standards of the BMW Group.

MINI PRODUCTION.



BODYSHOP

Inside the bodyshop 429 robots assemble up to 425 individual body panels. The robots apply over 4,000 spot welds to the MINI body shell, thus ensuring a rigid body structure. This is the key to MINI's legendary go-kart feel as well as its safety protection.

PAINTSHOP

Before the spraying of paint MINI undergoes a complex preparation process including a full brush down with ostrich feathers. Paint robots of the latest technology generation then apply with highest precision the MINI typical colours to the body shell. Customers can order their MINI in 14 exterior colours and can opt for a contrast roof. This finish option is unique to MINI. All body variants can be painted in random sequence in any of the exterior colours.

Plant Oxford is the first vehicle plant worldwide to implement the Integrated Paint Process (IPP). This innovative process leads to significant energy savings and emission reductions in the paintshop.

ASSEMBLY

During the assembly process some 2,400 components are fitted to create a fully customised MINI. There are 372 different interior trim and 319 different exterior options for MINI. Therefore it is extremely unlikely that two completely identical MINIs will leave the plant within the same production year.

MINI Assembly at Plant Oxford is among the brightest and most operator-friendly in Europe. Wooden skillets on the assembly line and rotary slings allow the car to be raised, lowered and turned around by up to 90 degrees for ergonomic and quality benefits.



PRESSINGS

Plant Swindon produces 280 different pressed parts for the New MINI body shell. 19 press lines are used for production, incorporating a total of 50 modernised individual presses. The pressing power of the presses ranges from 400 up to 5,000 tonnes.

The plant's new sub-assemblies area uses a total of 135 welding robots to produce the doors and closures of the New MINI.



ENGINE

The 16 different country-specific variants of the three main petrol versions of the New MINI engines are delivered from Hams Hall just-in-sequence to the assembly line in Oxford. All engines are customised and provided by Plant Hams Hall with only four days notice.

MINI PRODUCTION LIVE.

Plant Tours need to be pre-booked. For further information please contact:

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MINI
BUILT IN OXFORD.



SOLD IN

