

Shop: ASSEMBLY SHOP

Date of Implementation: 23/04/14

Machine / Location : A354 Oil pump Assembly

Before	After
<p>A - Stage no-1 Total Cycle time – 12 Sec</p> <ol style="list-style-type: none"> Rotor Grouping with Shaft in body – 7 Sec Clearance checking loading & unloading – 5 Sec <p>B – Stage no – 2 Total cycle time – 17 sec.</p> <ol style="list-style-type: none"> Plate engage with sub assembly – 5 sec Screw fitment – 11 sec Weighing loading - 1 sec <p>C – Stage no – 3 Total cycle time – 11 sec</p> <ol style="list-style-type: none"> Weighing Unloading – 1 Sec Number Punching (Manual) – 5 Sec Loading & unloading on Free rotation – 5 sec <p>D – Stage no – 4 Total cycle time – 15 sec</p> <ol style="list-style-type: none"> Flushing Operation – 15 Sec <p>No of operators – 4 Nos.</p> <p>Out put per man – 432 Nos.</p>	<p>A - Stage no-1 Total Cycle time – 17 Sec</p> <ol style="list-style-type: none"> Rotor Grouping with Shaft in body – 7 Sec Clearance checking loading & unloading – 5 Sec Plate engage with sub assembly – 5 sec <p>B – Stage no – 2 Total cycle time – 18 sec.</p> <ol style="list-style-type: none"> Screw fitment – 11 sec Weighing loading & Unloading - 2 sec Loading & unloading on Free rotation– 5 sec <p>C – Stage no – 3 Total cycle time – 17 sec</p> <ol style="list-style-type: none"> Flushing Operation – 15 Sec Number Punching (Auto) – 2 Sec <p>No of operators – 3 Nos</p> <p>Out put per man – 544 Nos.</p> <p>Benefit: One operator eliminated</p> <p>Out put per man increased by – 112 Nos.</p>