

Shop: ASSEMBLY SHOP

Date of Implementation: 19/07/14

Machine / Location : A328/A372 Oil pump Assembly

| Before                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | After                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
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| <ol style="list-style-type: none"> <li>1. Clearance Checking With shaft &amp; plate sub assly. (First operator)– 20 sec</li> <li>2. Hex bolt fitment Gear insertion in shaft (Second operator) – 20 Sec</li> <li>3. Pin insertion,Circlip fitment &amp; free rotation (Third operator) - 16</li> <li>4. Inspection – 16 Sec</li> <li>5. <b>Flushing &amp; Packing – 18 Sec.</b></li> </ol> <p><b>Problem/Present Status : Used 5 man power for total assembly of A328/A372 oil pump</b></p> <p><b>Cycle time – 20 sec.</b><br/><b>Out put per man – 294 Nos.</b></p> | <ol style="list-style-type: none"> <li>1. Clearance Checking With shaft &amp; plate sub assly. (First operator)– 20 sec</li> <li>2. Hex bolt fitment Gear insertion in shaft (Second operator) – 20 Sec</li> <li>3. Pin insertion,Circlip fitment &amp; Auto free rotation &amp; <b>flushing</b> (Third operator) – 24</li> <li>4. Inspection &amp; <b>Packing</b> – 23 Sec</li> </ol> <p><b>Countermeasure : Used 4 manpower for total assembly Of A328/A372 oil pump.</b></p> <p><b>Cycle time – 24 sec.</b><br/><b>Out put per man – 306 Nos.</b><br/><b>Benefit : increase in output per man by 12 nos. (4%)</b></p> |