

Shop: ASSEMBLY SHOP**Date of Implementation:** 21/04/14**Machine / Location :** A128/A157 Tensioner

Assembly

Before

1. Body Inspection & loading on machine – 5 sec
2. Cap nut with Spring assembly - 4 sec
3. Cap nut Disassemble – 3
4. **Winder locate & unallocated with cap nut & body - 3 Sec**
5. Winding Operation – 3 Sec
6. Circlip fitment operation – 5 Sec
7. Body remove from fixture to tray – 2 Sec

Problem/Present Status: Winder located in body is getting more time.

Cycle time – 26 sec.

Production per Hour – 138 nos.

After

1. Body Inspection & loading on machine – 5 sec
2. Cap nut with Spring assembly - 4 sec
3. Cap nut Disassemble – 3
4. **Spacer use for guide the cap nut - 2 Sec**
5. Winding Operation – 3 Sec
6. Circlip fitment operation – 5 Sec
7. Body remove from fixture to tray – 2 Sec

Countermeasure : Use Spacer for guide the cap nut & reduce winding locating time.

Cycle time – 24 sec.

Production per hour – 150 nos.

Benefit: Increase production per hour – 10 nos.