

Shop: ASSEMBLY SHOP

Date of Implementation: 14/04/14

Machine / Location : A136 Tensioner Assembly

Before

1. Loading component on machine – 3 sec
2. Winding operation - 1.5 sec
3. Circlip pickup from right side bin & circlip fitment with component – 6
4. Unloading component – 2.5

Problem/Present Status: Circlip bin position on right side of winding machine, so that more time required for circlip pick up.

Cycle time – 13 sec.

Production per Hour – 277 nos.

After

1. Loading component on machine – 3 sec
2. Winding operation - 1.5 sec
3. Circlip pickup from left side bin & circlip fitment with component – 5
4. Unloading component – 2.5

Countermeasure : Circlip bin position changed from right side to left side of winding machine.

Cycle time – 12 sec.

Production per hour – 300 nos.

Benefit: Increase production per hour – 23 nos.