

Shop: ASSEMBLY SHOP

Date of Implementation: 24/08/14

Machine / Location : A107/A262 Oil pump Assembly

Before	After
<ol style="list-style-type: none"> 1. Shaft & Inner rotor pressing sub assembly – 9 sec 2. Pull out load checking – 8 Sec 3. Center Drilling – 7 Sec 4. Dia.2.5 mm hole drilling- 8 sec. 5. Pin pressing in sub assembly- 8 sec. 6. 0.5 mm shaft pressing – 5 Sec 7. Manual free rotation checking – 48 Sec 8. CD checking & Dot Marking – 20 Sec 	<ol style="list-style-type: none"> 1. Shaft & Inner rotor pressing sub assembly – 9 sec 2. Pull out load checking – 8 Sec 3. Center Drilling – 7 Sec 4. Dia.2.5 mm hole drilling- 8 sec. 5. Pin pressing in sub assembly- 8 sec. 6. 0.5 mm shaft pressing – 5 Sec 7. Auto free rotation checking – 25 Sec 8. CD checking & Dot Marking – 20 Sec
<p>Problem/Present Status : For all these activities we are used 2.5 manpower with bottle neck cycle is free rotation</p> <p>Cycle time – 48 sec.</p> <p>Out put per man – 245 No's.</p>	<p>Countermeasure : For all these activity we are used 2 man power with free rotation convert manual to auto</p> <p>Cycle time – 45 sec.</p> <p>Out put per man – 327 No's.</p> <p>Benefit : increase in output per man by 82 nos. (33%)</p>