

Shop: ASSEMBLY SHOP

Date of Implementation: 25/08/14

Machine / Location : A347 Oil pump Assembly

Before	After
<ol style="list-style-type: none"> 1. Cover Sub Assembly & Clearance Checking – 15 Sec 2. Spring Pin fitment with guide bush - 16 Sec 3. Free Rotation & Number Punching – 14 Sec <p>Problem/Present Status: Bottle neck cycle time at spring pin fitment . Difficult to press spring pin in shaft by holding the pin in one hand to avoid the mismatch of zigzag position.</p> <p>Cycle time – 16 sec.</p> <p>Production per Hour – 225 nos.</p>	<ol style="list-style-type: none"> 1. Cover Sub Assembly & Clearance Checking – 15 Sec 2. Spring Pin fitment with Magnetic guide bush - 15 Sec 3. Free Rotation & Number Punching – 14 Sec <p>Countermeasure : Make Magnetic guide bush for spring pin pressing in shaft to avoid the holding time of pin by hand to match the zigzag position w.r.t. shaft</p> <p>Cycle time – 15 sec.</p> <p>Production per hour – 240 nos.</p> <p>Benefit: Increase production per hour – 15 nos.</p>