

Shop: ASSEMBLY SHOP

Date of Implementation:-20/05/2014

Machine / Location : A325 cam decomp Assembly

**Before**

Stage:- Roller pressing assembly

1. **Roller taken from bin – 2 Sec**
2. **Plate sub assembly taken from previous station.– 2**
- 3 Loading of roller & plate sub-assembly on fixture.- 8 Sec
- 4 Machine time ( Machine run time )- 3 sec.
- 5 Unloading of finish part from fixture & kept in final tray - 5

**Problem/Present Status:** Roller & plate sub-assembly taking time & FG keeping time is more.

**Cycle time of stage** – 20 sec.

**Production / Hr.**– 180 nos.

**After**

Stage:- Roller pressing assembly

1. **Roller taken from bin – 1 Sec**
2. **Plate sub assembly taken from previous station.– 1**
- 3 Loading of roller & plate sub-assembly on fixture.- 8 Sec
- 4 Machine time ( Machine run time )- 3 sec.
- 5 Unloading of finish part from fixture & kept in final tray – 4

**Countermeasure :** Rearrange bin position

1. Small bin provide for roller in front push button of machine
2. Remove roller bin & close minimize space between two machine & made provision for finish tray

**Cycle time of stage** – 17 sec.

**Production / Hour** – **212 Nos.**

**Benefit:** Increase production per hour –32 nos.