

Shop: ASSEMBLY SHOP**Date of Implementation:** 22/07/14**Machine / Location :** A285 Oil pump Assembly**Before**

1. Grouping & Clearance checking – 12 Sec
2. **Plate Sub Assly.** Screw fitment & Put on Weighing machine - 15 Sec
3. Free Rotation & Number Punching – 10 Sec

Problem/Present Status: Bottle neck cycle time at plate sub assembly & Screw fitment**Cycle time** – 15 sec.**Production per Hour** – 240 nos.**After**

1. Grouping & Clearance **checking With Plate Sub Assly.** – 13 Sec
2. Screw fitment & Put on Weighing machine - 14 Sec
3. Free Rotation & Number Punching – 10 Sec

Countermeasure : Made plate sub assly. At first stage .**Cycle time** – 14 sec.**Production per hour** – 257 nos.**Benefit:** Increase production per hour – 17 nos.