

The calculation of Cp value for Body Shop Process (Jig)

KES S – R214

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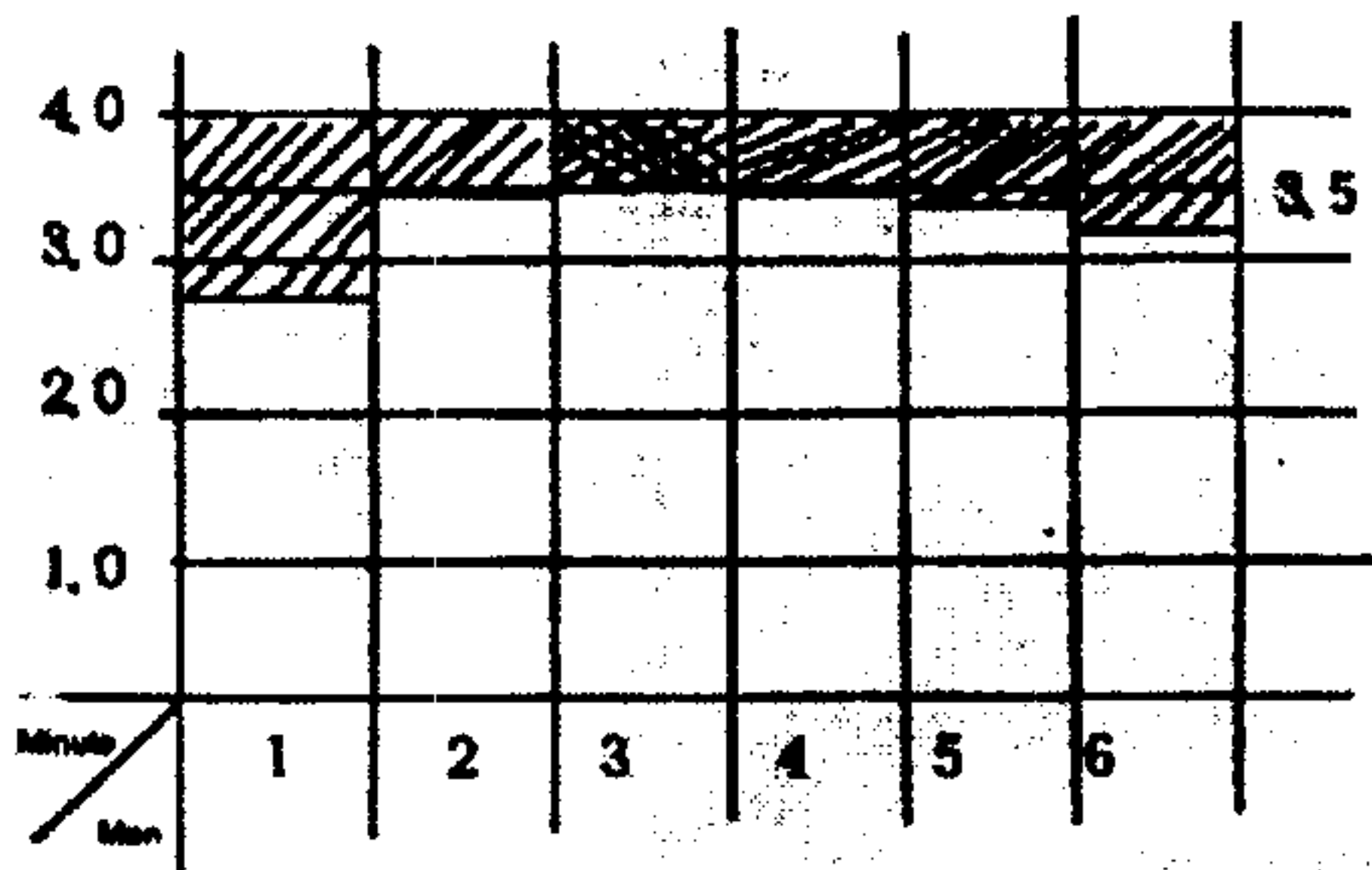
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1. Scope of Application

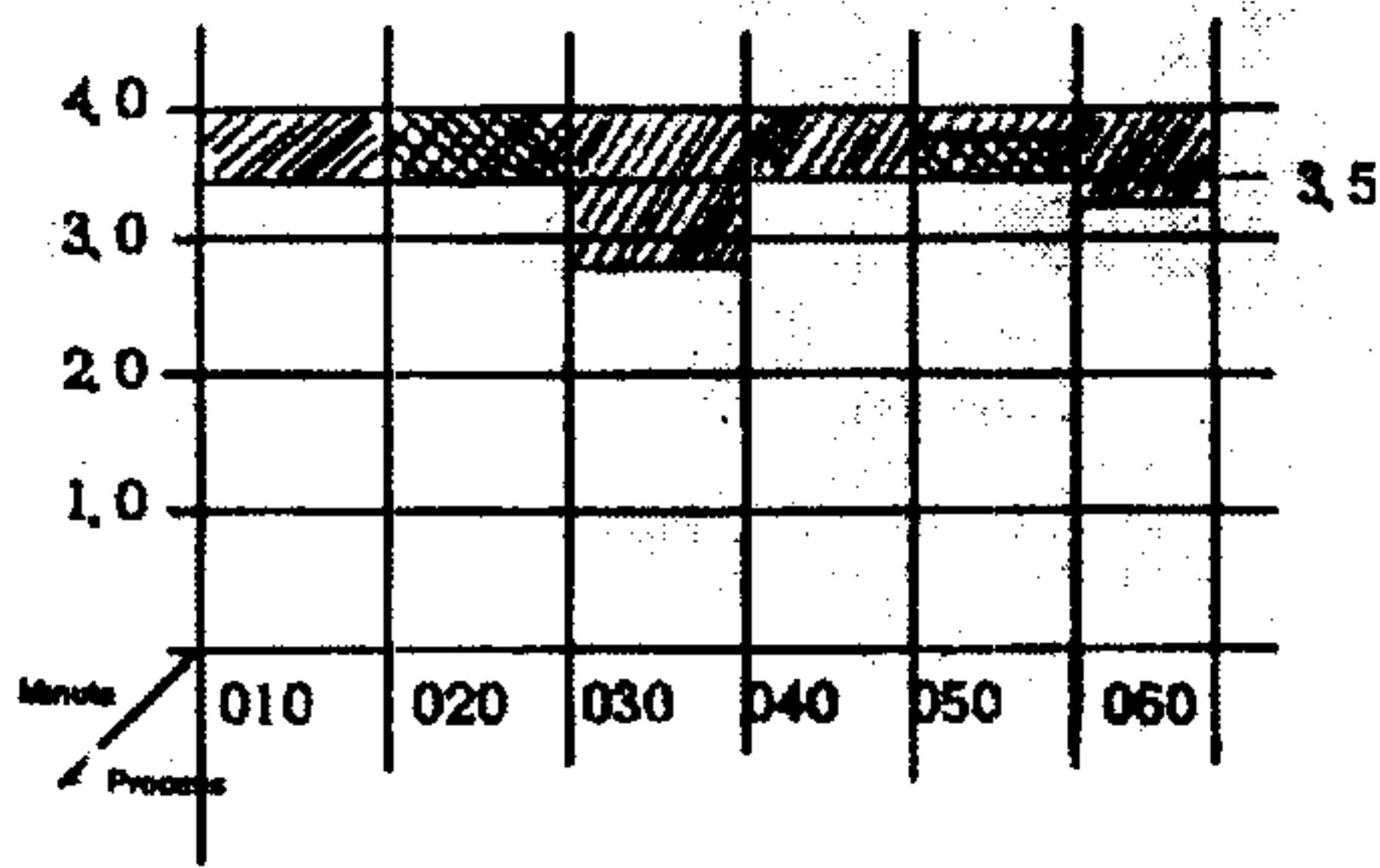
This standard applies to all welding working process, and which is needed for White Body Assy work.

2. Purpose

Jig, equipment installation's unification, division or lay out organization which a worker works. To establish the best production Line in the process formation, it's needed to produce the process ability(installation ability) as a way for effective application of worker's jig requirement with the best cost and reasonable control. Also as the below, you will notice that unbalance occurs in workshop's process distribution if you write graph between process and it's an object to find out Neck process counter plan about change of production plan and a point of view about the most effective automation.



- Equipment Tact Time 4.0 min/car
- If [shaded bar] reduced, Tact Time will be 3.5min/car.
(Namely, automation and process division investigation)



- Line Tact Time 4.0 min/car
- If [shaded bar] is process distributed, Tact Time will be 3.5 min/car
(Namely, automation and process distribution enforcement)

3. A Precondition About Process Ability Production

3.1 Establish standard work condition about each work, decide action time from AWF analysis rule and decide standard action time from data in the past about action of equipment.

3.2 If the size of work (small part is 2kg and less, Object is not less than 2kg) machine parts APSW MFSW's work are all based on object, and except these, work's construction, wire extension time value are decided from object and small part. action time of equipment is decided after Time Chart is framed.

3.3 In case, more than two workers work, the work time production ability should be decided by the opinion of the worker who has more amount of work done.

4.Process Ability (work time) Production Schemed Order of The Move

- (1) Judge the kind of work and the size of spare parts(object, small part).
- (2) Decide numerical value by substituting it in calculating formula.
- (3) Produce network time form calculating formula.
- (4) Produce process ability (work time) by considering the rate of allowance to net work time.