Hose Nozzle Assembly

This task uses multiple turning motions in the assembly of a three-piece unit.

A   B   C

top   base   connector

Materials

- 24 nozzle tops (A)
- 24 nozzle bases (B)
- 24 connectors (C)
- 2 large single-compartment bins
- 1 small single-compartment bin
- 1 storage box
- 1 jig
- 1 red storage bin (not shown)
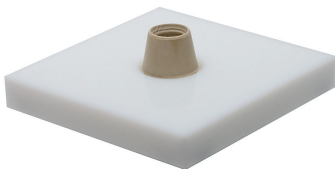
The jig is provided for workers who need help with turning.

Setup

Place the bin containing the nozzle tops on the table to the left. Place the bins containing the nozzle bases and connectors in the center and the storage box to the right or behind the connectors.

Procedure

- Simultaneously take one nozzle top with the left hand and one nozzle base with the right hand.

- Screw the base onto the nozzle top.

- Holding the nozzle in the left hand, take one connector with the right hand.

- Insert the threaded end of the connector into the nozzle and turn the connector until tight.

- Place the assembled nozzle in the storage box. No positioning of the assembled hose nozzle units is necessary.

Note

To use the turning jig, insert a nozzle top with the threaded end up. (It's not necessary to insert the piece all the way — this would make removal more difficult.) Insert nozzle base into the nozzle top and turn until it is securely attached. Insert connector and turn until securely attached. To remove completed piece, tip the piece slightly and pull out.

Norms:

Per unit — 6 seconds

Per task (24 units) —
2 minutes, 30 seconds

Quality Criteria

Each assembled nozzle has one top, one base, and one connector.
The parts should be turned tight.

Hose Nozzle Disassembly

Setup

Arrange the materials as in the assembly task.

Procedure

- Take one assembled unit from the storage box.

- Holding the nozzle in the left hand, unscrew the connector with the right hand and place it in the appropriate bin.

- Continuing to hold the nozzle in the left hand, unscrew the base and place it in the appropriate bin.

- Place the nozzle top in the appropriate bin.

Norms:

Per unit — 6 seconds

Per task (24 units) —
2 minutes, 30 seconds

Quality Criteria
The hose nozzle must be completely disassembled
and the parts placed in the appropriate bins.