

Coupling Assembly

This is a basic, three-piece turning task.



Materials

- 50 bases (A)
- 100 nuts (B)
- 2 large single-compartment bins
- 1 storage box
- 1 red storage bin (not shown)



Completed unit coupling unit

Setup

Place the bin containing the nuts on the table to the left. Place the bin containing the bases in the center, and the open storage box to the right.

Procedure

- Simultaneously, take two nuts with one hand and one base with the other hand.
- While palming one nut (holding it against the palm of the hand with the fingers), position the other nut so the threaded end is aligned with the base.
- Engage and turn the nut until it is tight on the base. It should not rattle when shaken.
- Reverse the unit. Engage and turn the second nut until it is tight.
- Place the assembled unit in the storage box. It is not necessary to arrange the units in the storage box.
- Repeat the previous steps for the remaining 49 units.

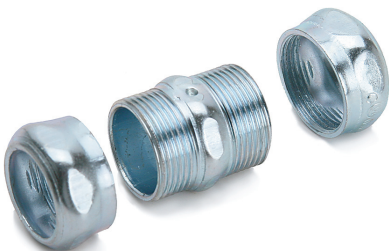
This standard procedure may be too complex for some workers. If so, begin by taking the nuts one at a time, then introduce taking two nuts with one hand, and then introduce palming one nut.

Norms:

Per unit – 5.8 seconds
Per task (50 units) –
4 minutes, 50 seconds

Quality Criteria

Assembled couplings must not rattle when shaken. Each unit must consist of two nuts and one base.



*Each unit has three items:
two nuts and one base.*

Coupling Disassembly

Setup

Arrange the materials as in the assembly task.

Procedure

- Remove a completed unit from the storage box. Disengage one nut by holding the base with one hand and turning the nut with the other hand.
- Palm the disengaged nut. Reverse the unit so the attached nut is grasped by the hand that is palming the disengaged nut.
- Disengage the remaining nut. Place the items in the appropriate bins.

Norms:

Per unit – 5.3 seconds
Per task (50 units) –
4 minutes, 25 seconds

Quality Criteria

Each unit must be completely disassembled and the items placed in the appropriate bins.