

Key Ring Assembly

This is a mid-level, two-part press and push assembly.



Materials

- 40 key ring bases ①
- 40 key ring pins ②
- 2 small single-compartment bins
- 1 large single-compartment bin
- 1 red storage bin (not shown)

Setup

Place a small single-compartment bin with the key ring bases to the left. Place the other small bin with the key ring pins in the center. Place the large single-compartment bin to the right.

Procedure

- Take a key ring base with one hand.
- Take a key ring pin with the other hand.
- Holding the collar of the pin between the index finger and middle finger, press in the top of the pin (where the ring is attached) with the thumb. Hold. *(See detail at left.)*
- Insert the protruding pin on the bottom into the large hole in the key ring base. Release the top of the pin to secure it to the base.
- Place the finished unit in the large single-compartment bin.
- Repeat all the previous steps with the remaining key ring pieces.



Holding the pin collar

Note

The standard task is done with the rings attached to both the base and the pin. Some workers may find manipulation of the pieces easier with the rings removed.

Norms:

Per unit – 4 seconds
Per task (40 units) –
2 minutes, 40 seconds

Quality Criteria

All key rings must be fully assembled with the base and pin securely attached to each other. Finished units must be placed in the large single-compartment bin.

Variations

Significantly more difficult variations can be done if attaching the rings is included in the assembly process. Attaching a ring to the pin section is less difficult than attaching a ring to the base section. Use key rings on one or both ends to vary the difficulty. It may be helpful to use a small flathead screwdriver to separate the ends of the rings, but use caution as the screwdriver can slip and may cause injury.



Key Ring Disassembly

Setup

Arrange the materials as in the assembly task.

Procedure

- Take a completed key ring unit from the bin.
- Holding the pin collar between the index finger and the middle finger, push in the pin top with the thumb.
- Remove the base with the other hand.
- Place the pin end in the small single-compartment bin in the center. Place the base in the small single-compartment bin on the left.
- Repeat the previous steps for all units.

Norms:

Per unit – 3 seconds
Per task (40 units) – 2 minutes

Quality Criteria

All key ring units must be completely disassembled and placed in the correct bins.