

Stichting Work-Study, de Work-Factor Raad en de WFGD willen een platform bieden aan Work-Factor gebruikers, arbeidsanalisten, cost engineers en industrial engineers om problemen, oplossingen, ideeën en tips te bespreken. Daartoe zullen we regelmatig een WS Tip sturen aan "WF-leden" en geïnteresseerden. Mocht dit bericht niet op het juiste adres aankomen stuur het dan door naar geïnteresseerden en laat ons dat weten.

Vanaf de midden 60-er jaren heeft men de normaaltijden voor, met name, "assembly" verzameld en gerubriceerd. Geabonneerden kregen geregeld modificaties, updates en nieuwe normen toegestuurd, zodanig dat de nieuwe gegevens door de oude konden worden vervangen door een systeem van inlegvellen met bijbehorende code. Hieronder een voorbeeld.

Dear Sir,

Enclosed you receive a number of new and modified pages, designated for the combined synthetics for apparatus assembly, that are in your possession.

Below pages are cancelled and must be removed.

Table of contents: combined synthetics for assembly.

Table of contents: synthetics assembly department.

Mechanical connections: drilling and tapping page 17.654.13.

In connection with questions about the used coding, the following:

The first and second figure of the coding indicate "predetermined time systems". (Probably: 17 = DWF)

The third up to the sixth figure indicate the date of the pages beginning with the year then the month.

The last two figures indicate the groups, 00 up to 09 are tables for running-in, pre-calculation and task setting, for assembly, 10 up to 19 are the synthetics for assembly, 20 up to 29 are the combined synthetics for assembly.

T.E.O. - P.E.R.M. / P.E.R.U. Mr. M.G. van Hagen.

Date: 27.08.1969

N.V. PHILIPS GLOEILAMPENFABRIEKEN, EINDHOVEN, NEDERLAND

Synthetics for assembly

17.685.00	page 1 up to 4	Cycle and Running-in Allowances for Assembly
17.685.01	page 1 up to 4	Tables for Pre-calculation and Task Setting
17.654.10	page 1 and 2	Taking and Transport
17.654.11	page 1 up to 3	{ Screwing
17.654.12	page 1	{ Riveting
17.691.13	page 1 up to 4	{ Drilling-reaming and tapping
17.654.14	page 1 up to 3	Electrical Assembly
17.654.16	page 1 and 2	{ Cable form on board
17.654.18	page 1 and 2	{ Cutting leads on Artos(machine)
17.654.19	page 1 and 2	{ Twisting
17.654.20	page 1 up to 13	{
17.656.20	page 1 up to 4	{
17.657.20	page 1 and 2	{ Component Assembly
17.677.20	page 1 and 2	{
17.691.20	page 1 up to 19	{
17.696.20	page 1 and 2	{
17.664.21	page 1 up to 3	Screwing
17.654.22	page 1	Soldering
17.661.23	page 1	{
17.657.23	page 1	{ Connecting
17.669.23	page 1 and 2	{

17.672.24	page 1 up to 5	Print Assembly
17.657.25	page 1	Wiring
17.654.26	page 1	Miscellaneous
17.677.26	page 1	Miscellaneous

Hieronder een voorbeeld.

Synthetic for assembly			Taking and transport to assy point	
	weight dimension	Reach distance	Time in seconds Single Sim	
Isolated components preposition not necessary	up to 0.9 kg.	25 cm.	1.3	---
		40 cm.	1.5	---
		65 cm.	1.8	---
	from 0.9 up to 3.2 kg.	25 cm.	1.5	---
		40 cm.	1.8	---
		65 cm.	2.1	---
Isolated components from table - preposition required	up to 9.5 mm.	25 cm.	1.7	1.9
		40 cm.	2.-	2.2
		65 cm.	2.2	2.4
	from 9.5 up to 76 mm. weight 0.9 kg.	25 cm.	1.5	1.6
		40 cm.	1.7	1.9
		65 cm.	2.-	2.1
	from 76 up to 200 mm. from 0.9 up to 3.2 kg.	25 cm.	1.9	---
		40 cm.	2.2	---
		65 cm.	2.5	---
	from 76 up to 200 mm. from 3.2 up to 5.9 kg.	25 cm.	2.1	---
		40 cm.	2.4	---
		65 cm.	2.8	---
Random piles no preposition necessary	from 4.8 up to 9.5	25 cm.	1.6	1.8
		40 cm.	1.8	2.-
		65 cm.	1.9	2.2
	from 9.5 up to 100 mm.	25 cm.	1.5	1.6
		40 cm.	1.7	1.8
		65 cm.	1.9	2.-
Allowance for flat component up to 1.2 mm. thickness			0.1 sec.	
Random piles preposition necessary	from 4.8 up to 9.5 mm.	25 cm.	2.1	2.3
		40 cm.	2.3	2.5
		65 cm.	2.4	2.7
	from 9.5 up to 100 mm.	25 cm.	1.8	2.2
		40 cm.	2.-	2.4
		65 cm.	2.2	2.6
Allowance for flat components up to 1.2 mm. thickness			0.1 sec.	
T.E.O. P.E.R.M.		ONDERWERF:	17.654.10	
			BL 1	A 2
			PAR. 1/1/80	
			UITG. NR.	DAT. 6.8.1980

P.S. Weet iemand de betekenis van: / does anyone know the meaning of: PERM and/or PERU?

Voor reacties naar

G. de Vrij

Secr.: Stichting Work-Study / WORK-FACTOR Raad / WFGD

Tel: +31.40.2046048

E-mail: work-study@onsmail.nl of info@work-factor.nl

Website: www.work-factor.nl

