

Prajon pakdeekul : PRODUCTIVITY IMPROVEMENT OF ASSEMBLING REFRIGERATOR INDUSTRY. THESIS ADVISOR : ASSO.PROF. DR. SIRICHAN THONGPRASERT
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Most continuous manufacturing processes consist of two types of production activities. These are the assembling activity and the machining activity, with human operator in between. Production efficiency is always lost in terms of waiting, delay, and transportation, causing an imbalance of processes. With a proper planning and control, it is possible to minimize the lost and thus attaining balance and continuity of processes.

A study on the refrigerator manufacturing plant is presented which could be summarized as follows:

1. In the assembly line:

1.1 The waiting time was reduced by 5.7 % for the body assembling, 5.43 % for the front panel assembling, and 4.07 % for the back panel assembling.

1.2 The working time was reduced by 12.5 % for the body assembling, 4.8 % for the front and back panel assembling.

2. In material handling:

2.1 Workers' time used in material handling was reduced by 51.1 %

2.2 Material handling time was reduced by 60.5 %

2.3 Handling distance was reduced by 59.2 %

With the balancing of the assembly line, and the improvement in the delivery system for major parts to the production line, overall labour productivity was increased by 6.38 %, and man-hour productivity was increased by 7.69 %.

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