

Work measurement



Work Measurement on Katsa Bag Production (Gifts and Graces: Cainta, Rizal)

I. Rationale Environmental issues and problems started to arise last decade. Awareness and drive to solve these problems has grown to 89% (NIHERST, 2008) since 2008. This has resulted to different campaigns and movements such as the Earth Hour Campaign, where everyone is encouraged to switch off household lights for an hour and the birth of eco-friendly products into the market. One of the most in demand and popular eco-friendly products is the cloth or katsa bags.

Several big companies such as Rustan's and SM have invested and promoted the use of this product not only because of its earth friendly feature but also due to the convenience and cost-saving advantage it gives to them and to their customers. Katsa bags have widened its range of usability. Before it is only used when people go to wet markets. Now, it is seen and used not only in supermarkets but in high end malls and places as well. With the continuous expansion of its market and increasing demand, production of katsa bags is now seen as a critical process as its production cost and market value is now a concern of the public.

II. Problem Statement Without an existing time standard for the production of katsa bags, the management allocates extensive time allowance for the completion of job orders. This results to excessive avoidable delays taken by the workers. III. Objectives This study is an application of the theories learned in the IE32: Methods Engineering Class. It aims to utilize the problem solving tools and work measurement techniques discussed in the course.

Moreover, this study intends to help Tahanang Walang Hagdanan by accomplishing the following specific objectives: * To improve the productivity and efficiency of Tahanang Walang Hagdanan's katsa bag production * To determine the time standard for producing a katsa bag using time study * To improve systems and procedures for selected processes IV. Scope and Limitations PRODUCT SCOPE The study focuses on the processes involved in the manufacturing of Tahanang Walang Hagdanan's katsa bags. Since there are different varieties of katsa bags, production of Antipolo katsa bags will be the premiere focus.

TIME STANDARD SCOPE Even though Antipolo katsa bag production will be observed in this study, standard time for all the all other processes except silkscreening will be applicable for other 9 | 0. 068966 | 10 11 12 13 14 15 16 | 0. 068966 | | 0. 034483 | Table 2. Work Distribution Percentage VI'. Work Measurement Results and Analysis After familiarization of the katsa bag process, the group used the time study method to gather information for the evaluation of the katsa bag operation and to establish time standards. The snapback method was used in timing each of the processes identified in the flowchart (Figure 8).

The processes were identified with the help of THW's sewing department supervisor. The time study observation form found in the appendix shows the data gathered from the examination. For the determination of sample size, the group used the recommended sample size from Niebel's Methods, Standards, and Work Design book. The book states that for an operation with cycle time cycles are enough. For this reason, cycles were used in the study.

Five cycles were taken for each of the following processes: layout, trace, cut (LTC). On the other hand 10 cycles were taken for the remaining processes.