**Tabel 2** Perhitungan *Desain For Assembly* Mesin pencetak bakso Konsep A

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  |  |  |  |  |  |  |  |
|  | Name Of Assembly | Number Of Time The Operation Is Carried Out Consecutivity | Manual Handling Code | Manual Handling Time Per Part | Manual Insertion Code | Manual Insertion Time Per Part | Operation Time,Second = [(5) + (7)] | Figures For Estimation 0f Theoritical Minimum Part |
| Part ID No |  |
| 1 | Puli 10 Inch | 1 | 5.0 | 2.73 | 5.9 | 12 | 14.73 | 1 |
| 2 | Puli 2 Inch | 4 | 4.0 | 2.73 | 3.8 | 6.0 | 34.92 | 1 |
| 3 | Hopper | 1 | 3.0 | 1.95 | 0.1 | 2.5 | 4.45 | 1 |
| 4 | Gir Penggerak | 1 | 3.0 | 2.73 | 5.9 | 12 | 14.73 | 1 |
| 5 | Puli 6 Inch | 1 | 3.0 | 2.73 | 4.8 | 8.5 | 11.23 | 0 |
| 6 | Motor Listrik | 1 | 9.5 | 4.0 | 9.2 | 5.0 | 9 | 1 |
| 7 | Lampu Led | 1 | 0.1 | 1.8 | 3.8 | 6.0 | 7.8 | 0 |
| 8 | Rangka 35x35x5mm | 1 | 4.1 | 1.95 | 9.6 | 12 | 13.95 | 1 |
| 9 | Pengaduk Adonan | 1 | 1.1 | 2.73 | 3.8 | 6.0 | 8.73 | 1 |
| 10 | Sensor Ultrasonic | 1 | 1.0 | 2.25 | 3.8 | 6.0 | 8.25 | 0 |
| 11 | Pemotong Manual | 2 | 4.1 | 2.25 | 4.8 | 8.5 | 21.5 | 1 |
| Total |  | 19 |  |  |  |  | 149.29 | 8 |
|  |  |  |  |  |  |  | TM | NM |