**Tabel 3.** Perhitungan *Desain For Assembly* Mesin pencetak bakso Konsep B

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  |  |  |  |  |  |  |  |  |
|  | 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 | Lampu led | 1 | 4.0 | 3.6 | 0.1 | 2.5 | 6.1 | 0 |
| 2 | Panel Listrik | 1 | 8.3 | 5.6 | 3.8 | 6.0 | 11.6 | 1 |
| 3 | Servo | 3 | 5.8 | 8.0 | 3.8 | 6.0 | 42.0 | 1 |
| 4 | Motor Listrik | 1 | 9.5 | 4.0 | 9.2 | 5.0 | 9.0 | 1 |
| 5 | Puli 3 inch | 2 | 4.0 | 3.6 | 3.8 | 6.0 | 19.2 | 1 |
| 6 | *Worm Gear Reducer* | 1 | 8.3 | 5.6 | 3.8 | 6.0 | 11.6 | 1 |
| 7 | Pengaduk adonan | 1 | 1.1 | 1.8 | 3.8 | 6.0 | 7.8 | 1 |
| 8 | Hopper | 1 | 3.0 | 1.95 | 0.1 | 2.5 | 4.45 | 1 |
| 9 | Sensor Ultrasonic | 1 | 1.0 | 1.5 | 3.8 | 6.0 | 7.5 | 0 |
| 10 | Mekanisme Pencetak Otomatis | 1 | 7.0 | 5.1 | 3.8 | 6.0 | 11.1 | 1 |
| 11 | Kerangka 20x20x1,5 mm | 1 | 4.1 | 6.85 | 9.6 | 12 | 18.85 | 1 |
| Total |  | 14 |  |  |  |  | 149.2 | 9 |
|  |  |  |  |  |  |  | TM | NM |