

PRODUCTION 2026

- [TIME MOTION AND STUDY](#)
- [RUGBY MACHINE SOP/MANUAL](#)
- [Roller Machine SOP/Manual](#)

TIME MOTION AND STUDY

RUGBY BODY (TAAS /BABA)

TARGET TIME:

1000 PCS - 4 HOURS OF WORK TIME

500 PCS - 2 HOURS OF WORK TIME

250 PCS - 1 HOURS OF WORK TIME

4.2 PCS PER MINUTE



RUGBY PALAMAN

TARGET TIME:

1000 PCS - 2.5 HOURS OF WORK TIME

500 PCS - 1.25 HOURS OF WORK TIME

250 PCS - 30 MINS OF WORK TIME

1.2 PCS PER MINUTE



ROLLER PALAMAN

TARGET TIME:

1000 PCS - 4 HOURS OF WORK TIME

500 PCS - 2 HOURS OF WORK TIME

250 PCS - 1 HOURS OF WORK TIME

4.2 PCS PER MINUTE



ROLLER BOU

TARGET TIME:

1000 PCS - 4 HOURS OF WORK TIME

500 PCS - 2 HOURS OF WORK TIME

250 PCS - 1 HOURS OF WORK TIME

4.2 PCS PER MINUTE



EDGE CUTTING

TARGET TIME:

1000 PCS - 1 HOURS OF WORK TIME

500 PCS - 30 MINUTES OF WORK TIME

250 PCS - 15 MINUTES OF WORK TIME

15 PCS PER MINUTE



PUNCHING MANUAL

TARGET TIME:

1000 PCS - 3 HOURS OF WORK TIME

500 PCS - 1.5 HOURS OF WORK TIME

250 PCS - 45 MINUTES OF WORK TIME

6 PCS PER MINUTE



STAMPING MANUAL

TARGET TIME:

1000 PCS - 3 HOURS OF WORK TIME

500 PCS - 1.5 HOURS OF WORK TIME

250 PCS - 45 MINUTES OF WORK TIME

6 PCS PER MINUTE



HASA DULO

TARGET TIME:

1000 PCS - 4 HOURS OF WORK TIME

500 PCS - 2 HOURS OF WORK TIME

250 PCS - 1 HOURS OF WORK TIME

4.2 PCS PER MINUTE



PUNCHING ADJUSTER

TARGET TIME:

1000 PCS - 4 HOURS OF WORK TIME

500 PCS - 2 HOURS OF WORK TIME

250 PCS - 1 MINUTES OF WORK TIME

4.2 PCS PER MINUTE



PUNCHING PALAMAN

TARGET TIME:

1000 PCS - 2 HOURS OF WORK TIME

500 PCS - 1HOURS OF WORK TIME

250 PCS - 30 MINUTES OF WORK TIME

8.3 PCS PER MINUTE



RUGBY MACHINE SOP/MANUAL

MGA HAKBANG SA PAG GAMIT NG RUGBY MACHINE



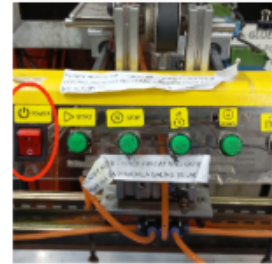
1. ISAKSAK ANG MGA
SAKSAKAN NG RUGBY
MACHINE



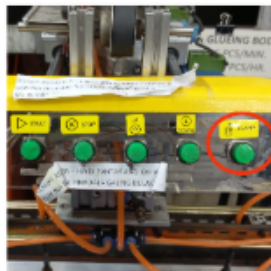
2. BUKSAN ANG HANGIN NG
RUGBY MACHINE



3. IKABIT ANG GUIDE SA
ROLLER MACHINE DAHIL DITO
PAPASOK ANG STRAP NG BELT



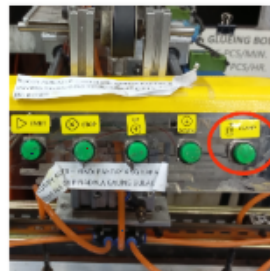
4. PINDUTIN ANG BOTTON NG
POWER ON PARA GUMANA
ANG CONVEYOR



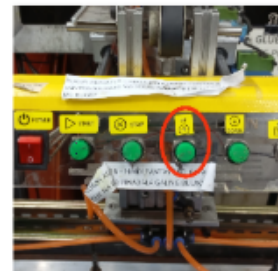
5. PINDUTIN ANG CLAMP PARA
BUMUKAS ANG LALAGYAN NG
STRAP BELT



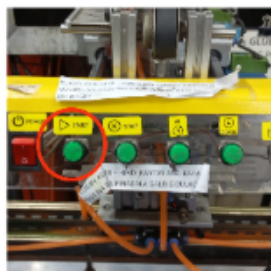
6. ILAGAY ANG STRAP BELT SA
LALAGYAN NETO



7. PINDUTIN MULI ANG CLAMP
PARA SUMARA ANG LAGAYAN
NG STRAP BELT PARA DI
GUMALAW OR MALAGLAG



8. PINDUTIN ANG UP BOTTON
PARA UMANGAT ANG
LAGAYAN NG STRAP BELT



9. PINDUTIN ANG START PARA
MAG SIMULA NANG MAG
OPERATE ANG RUGBY
MACHINE

Roller Machine SOP/Manual

LAGING TANDAAN SA PAG GAMIT NG ROLLER MACHINE



Siguraduhin na ang Position ng belt sa roller ay sakto at walang puwang para di mawala sa alignment ang belt



Siguraduhin na bang position ng Belt ay nasa Center Line Para pag ito ay Dumaan na sa roller Machine ay Pantay ito mula sa una hanggang Dulo



Siguraduhin na ang Top Vertical Aligning Roller ay naka Install Dahil ito ang mag guguide sa Belt Strap para di mawala sa Alignment ang Belt



Siguraduhin na ang Dulo ng Roller Machine ay naka Align into Center Para Pantay ito pag Labas ng Belt



HAKBANG SA PAG GAMIT NG ROLLER MACHINE



1. ISAKSAK ANG SAKSAKAN NG ROLLER MACHINE



2. BUKSAN ANG HANGIN NG ROLLER MACHINE



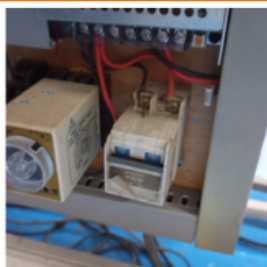
3. PALITAN ANG ROLLER GUIDE DEPENDE SA SUKAT NG BELT



4. BUKSAN ANG ROLLER MACHINE



HAKBANG SA PAG GAMIT NG ROLLER MACHINE



4. BUKSAN ANG SERVER NG ROLLER MACHINE



5. I ADJUST ANG GUIDE NG DOUBLE HEAD SERVER DEPENDE SA SUKAT NG BELT



6. ILAPAT NG MAIGI ANG ITAAS AT IBABA NG BELT PARA PANTAY ITONG TUMAKBO



