

1 **INTRODUCTION**

PPLH - DESCRIBE THE PARTSPRODUCED PER LABOUR HOUR. IT IS HELPFUL IN DEFINING THAT HOW MUCH PARTS AN OPERATOR CAN PRODUCE IN AN HOUR.

2 **PURPOSE**

- a) TO CALCULATE HOURLY PARTS PRODUCTION PER LABOUR
- b) TO COMPARE OPERATOR EFFECTIVENESS OR EFFICIENCY

3 **APPLIED AREA**

APPLICABLE FOR ALL FORGING, MACHINING, HEAT TREATMENT & ASSEMBLY SECTIONS

4 **PROCEDURE FOR PPLH CALCULATION**

FOR PPLH CALCULATION FOLLOWING PROCEDURE TO BE FOLLOWED:-

- a) CUMULATION OF SECTIONWISE PRODUCTION PLAN (PARTWISE PRODUCTION PLAN RECEIVED FROM FACTORY CONTROL DEPARTMENT) TO CALCULATE TOTAL PRODUCTION PLAN FOR CALCULATING PPLH.
- b) CALCULATE PLAN & ACTUAL MANPOWER BASED ON PRODUCTION PLAN & ACTUAL PRODUCTION.
- c-i) METHODOLOGY FOR PLAN PPLH CALCULATION :-

PLANNED =	TOTAL PRODUCTION PLAN (IN NOS.)
PPLH	TOTAL MANPOWER PLANNED (IN NOS.) x 8 HOURS (AVERAGE TIME/SHIFT)

TOTAL PRODUCTION PLAN - IS PLAN RELEASED BY FACTORY CONTROL DEPARTMENT FOR THAT PARTICULAR MONTH FOR WHICH PPLH CALCULATION REQUIRED FOR PLANNING.

TOTAL MANPOWER PLANNED - IS CALCULATED MANPOWER PLANNED BASED ON PRODUCTION PLAN RECEIVED FOR THAT PARTICULAR MONTH.

8 HOURS (AVERAGE TIME/SHIFT) -IS AVERAGE TIME/SHIFT TAKEN FOR PPLH CALCULATION. MULTIPLY MANPOWER BY 8 HOURS IS REQUIRED TO CONVERT MANPOWER INTO LABOUR HOUR.

- c-ii) METHODOLOGY FOR ACTUAL PPLH CALCULATION :-

ACTUAL =	TOTAL PRODUCTION ACHIEVED (IN NOS.)
PPLH	TOTAL MANPOWER USED (IN NOS.) x 8 HOURS (AVERAGE TIME/SHIFT)

TOTAL PRODUCTION ACHIEVED - IS ACTUAL O.K PARTS PRODUCED BY PRODUCTION DEPARTMENT AGAINST PRODUCTION PLAN FOR THAT PARTICULAR MONTH FOR WHICH PPLH CALCULATION REQUIRED.

TOTAL MANPOWER USED - IS ACTUAL MANPOWER USED FOR PRODUCING ACTUAL PARTS FOR PARTICULAR MONTH.

8 HOURS (AVERAGE TIME/SHIFT) -IS AVERAGE TIME/SHIFT TAKEN FOR PPLH CALCULATION. MULTIPLY MANPOWER BY 8 HOURS IS REQUIRED TO CONVERT MANPOWER INTO LABOUR HOUR.

5 **RULES FOR REVISION IN PPLH TARGET**

- a) PPLH TARGET TO BE REVISED AS PER CHANGE IN LAYOUT OF EXISTING LINES / MACHINES / INSPECTION STATIONS.
- b) PPLH TARGET TO BE REVISED AS PER CHANGE IN WORK CONTENTS AS PER FOLLOWING CATEGORIES:-
 - > CHANGE IN OPERATOR WORK CONTENTS (ADDITION OR DELETION IN OPERATOR'S ACTIVITY)
 - > CHANGE IN METHOD OF OPERATION
 - > CHANGE IN MANAGEMENT GUIDELINES FOR OPERATOR'S UTILIZATION
- c) REQUEST FOR REVISION IN PPLH TARGET DUE TO CHANGE IN WORK CONTENTS & LAYOUT CHANGE TO BE GIVEN TO THE PPLH CONTROLLING DEPARTMENT BY INFORMATION THROUGH MAIL BY CONCERNED DEPARTMENT'S SECTION HEAD.
- d) REVISION SHOULD BE DONE IN PPLH TARGET AFTER TIME STUDY / SOS STUDY FOR MANPOWER ALLOCATION FINALIZATION FOR PARTICULAR OPERATION WITHIN 2 MONTH AFTER CHANGE OCCURES AS PER ABOVE POINTS -5 a) & 5 b)

6 **RECORDS OF MEASUREMENT**

PPLH CONTROLLING DEPARTMENT WILL KEEP ALL LINES PPLH DATA FOR RECORD PURPOSE TO USE THE DATA FOR FUTURE ANALYSIS.

7 **PPLH RULES & PROCEDURE REVISION DETAILS**

INDUSTRIAL ENGINEERING DEPARTMENT WILL REVISE PPLH RULES & PROCEDURE FOR APPROPRIATE CHANGE AS PER MANAGEMENT GUIDELINES.

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0	23.11.16	NEW RELEASE			