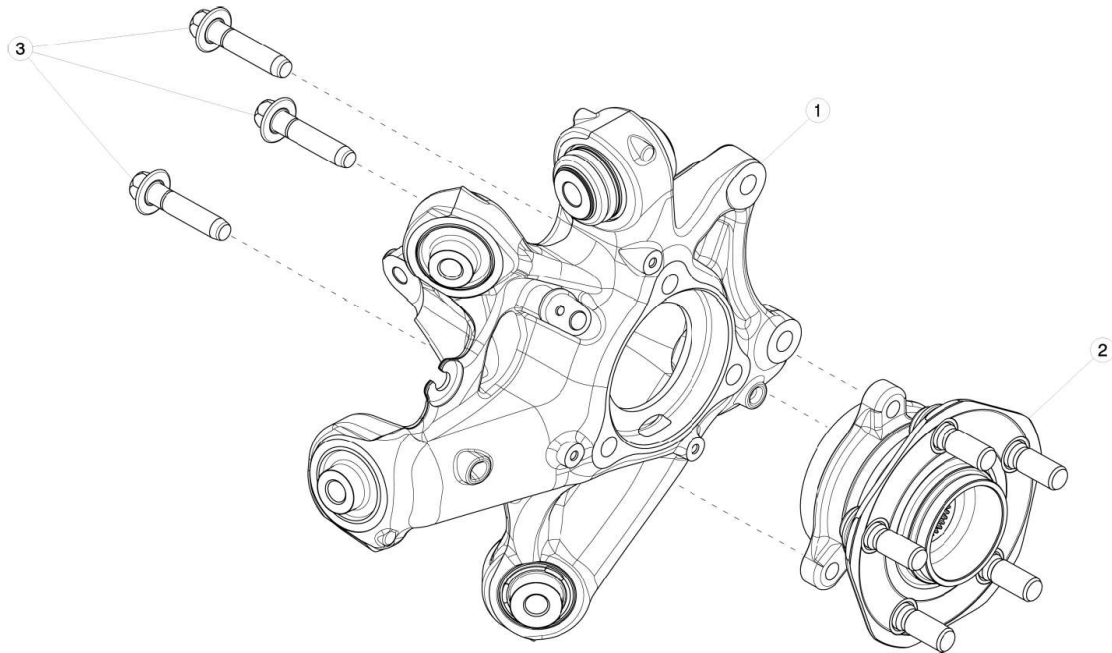


6ENT1148 - 2021 REF-DEF Assignment 3

Appendix 1 – Part List

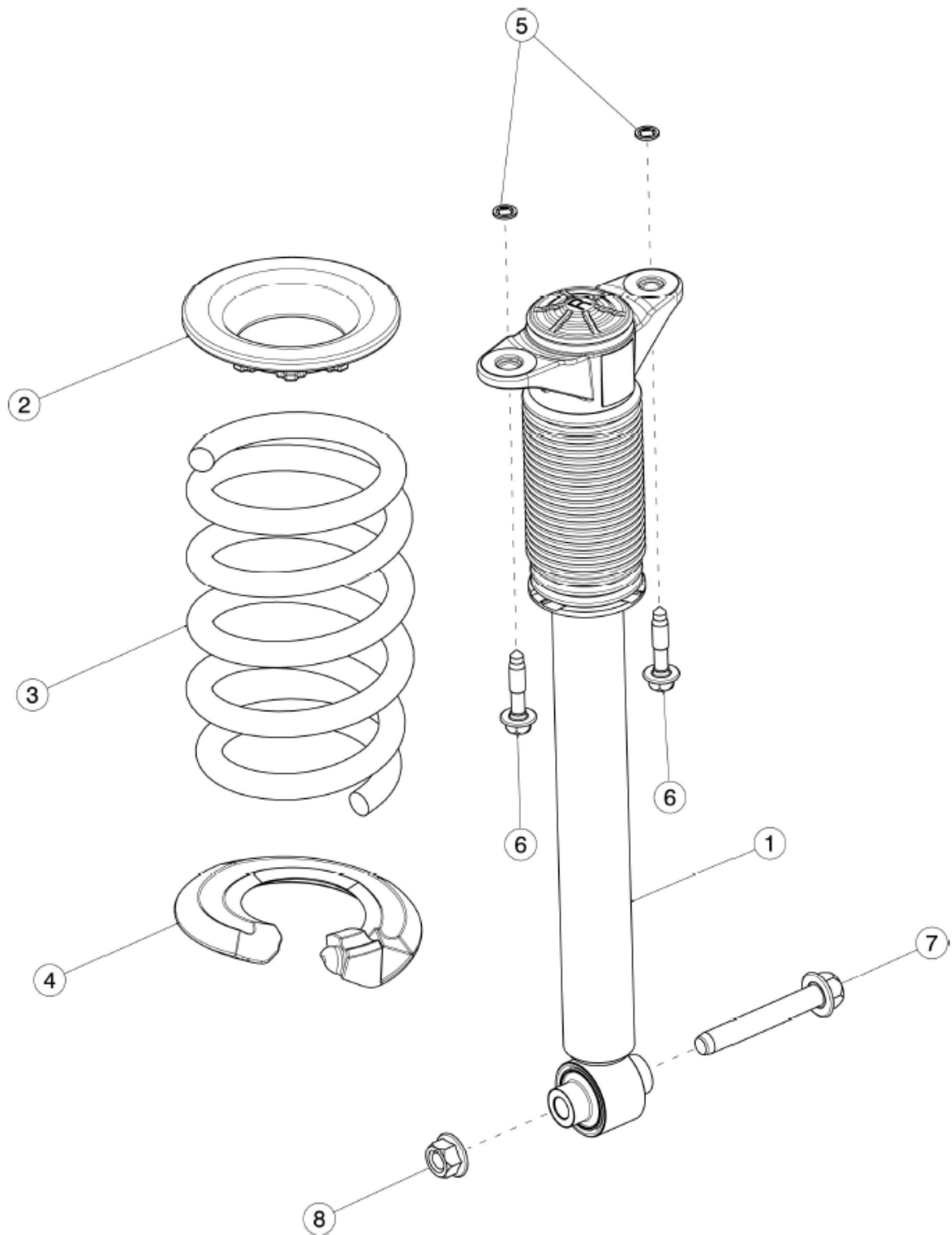
Station 1

Subassembly A: Rear Knuckle L&R - Hub and Bearing



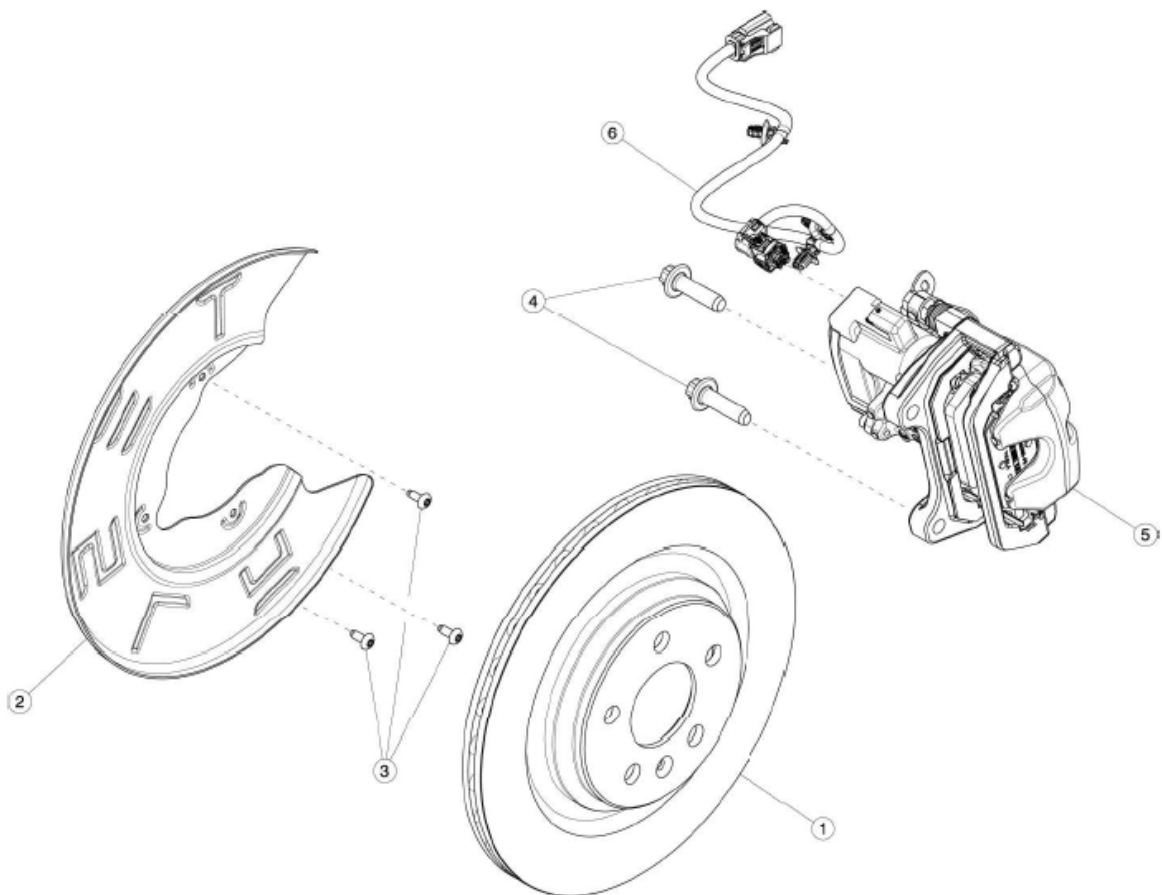
#	PART	PART NUMBER	QTY PER BOX / PALLET	BOX / PALLET SIZE	CONTAINER	QUANTITY*	Assembly time (per item) in seconds**
1	RR KNUCKLE ASSY, LH	1044411-00-F	50	1000X1000	PALLET	1	15
1	RR KNUCKLE ASSY, RH	1044416-00-F	50	1000X1000	PALLET	1	15
2	HUB ASSY, DRIVEN	1044121-00-E	27	300X300X300	Box	2	22
3	BOLT HF M12x1.75x35 [10.9]-G720	2007111	500	300X300X300	BOX	6	6

Station 1 - Subassembly B: Rear Coil Spring and Damper



#	PART	PART NUMBER	QTY PER BOX / PALLET	BOX / PALLET SIZE	CONTAINER	QUANTITY *	Assembly time (per item) in seconds **
1	RR DAMPER ASSY - COIL RWD	104446 1-02-D	400	1000X1000	PALLET	2	9
2	REAR SPRING UPPER ISOLATOR, COIL	104447 5-00-E	250	500X500X500	BOX	2	12
3	RR SPRING, COIL 74.7-7250 E3	104447 2-91-E	120	1000x1000	PALLET	2	10
4	RR SPRING LOWER ISOLATOR	104447 9-00-D	200	500X500X500	BOX	2	5
5	RETENTION WASHER, M10	104440 7-00-A	2000	400X400X400	BOX	4	3
6	BOLT HF M10X1.50X40 [10.9]-G720	104404 0-00-B	500	300X300X300	BOX	4	8
7	BOLT, HF, M14-2.0X95, [109], ZNFL, SMAT	111152 2-00-A	200	300X300X300	BOX	2	7
8	NUT, HF, M14-2.0, [10], ZNNI	111153 3-00-A	1000	300X300X300	BOX	2	9

Station 2 Subassembly C & D: LH&RH Rear Brake Rotors - Callipers And Pads



#	PART	PART NUMBER	QTY PER BOX / PALLET	BOX / PALLET SIZE	CONTAINER	QUANTITY*	Assembly time (per item) in seconds**
1	RR BRAKE ROTOR, BASE CAST IRON	104463 1-00-D	36	1000x1000	PALLET	2	8
2	RR BRAKE SHIELD, LH	104466 5-00-C	200	1000x1000	PALLET	1	5
2	RR BRAKE SHIELD, RH	104466 6-00-C	200	1000x1000	PALLET	1	5
3	BOLT TRX BTNHD M6x1.0x16[6.8]U-MP-ZnAIW	200706 7	1000	250X250X200	BOX	6	8
4	BOLT,TE,M12x45,STL[109],ZN FL[BLCK]	108896 9-00-B	400	300X300X360	BOX	4	9

5	RR BRAKE CALIPER BASE, LH	104462 3-97-F	20	300X300X3 60	BOX	1	5
5	RR BRAKE CALIPER BASE, RH	104462 4-97-F	20	300X300X3 60	BOX	1	5
6	ASY,EPB JUMPER,LH,BASE,M3	109848 2-00-F	30	1000x300x 300	BOX	1	6
6	ASY,EPB JUMPER,RH,BASE,M3	109848 3-00-F	30	1000x300x 300	BOX	1	6

*per vehicle

**** IMPORTANT**

This assembly time includes part fitment, fastening (as applicable) and getting and replacing any tools needed. It does not include time for obtaining the item from its pallet / box as this will vary depending on the layout.

You should provide time for obtaining the part from its pallet or box at an amount of 1 seconds per meter (or part thereof) that the operator needs to move to obtain the part. In addition to this add 2 seconds per part for grabbing the part.

You should also provide time for moving parts from one station to the next - estimate the times involved.

You should also provide time for combining the above sub-assemblies to form a completed rear strut unit: i.e. a single completed assembly should leave you line. You are to estimate the times involved.

Source:

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