Reassigning Human Operations

Line balancing with humans is performed to optimize the Takt time (maximum time allowed to produce a complete product, assembly, or machine) for each station. This involves moving/assigning human tasks/Human Activity Groups (HAGs), from one worker to another, or moving a workplace from one station to another. This section provides the ability to re-assign human operations within the same process document or across different process documents.

Any data with detailing that has two stations, or one station and two workplaces; the station must have manikin as resource, and the process activities must have human task set as active. The human task must contain Pick/Place/Operate activities.

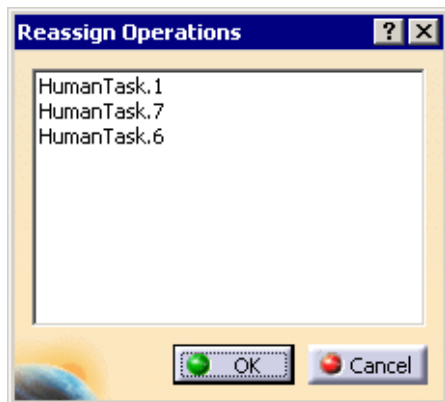The two stations must be opened in two different detailings.

1. Click **Reassign Operations** .

   ⓘ If the detailing of two Stations are opened in two different process documents, keep the process document where operations have to be moved (target station) as active window, and then click on this command.

   The **Reassign Operations** dialog box opens.

Reassign Operations
HumanTask.1
HumanTask.7
HumanTask.6
OK   Cancel

2. Select the Operations that have to be moved from one station to another (say, Station1 to Station2).
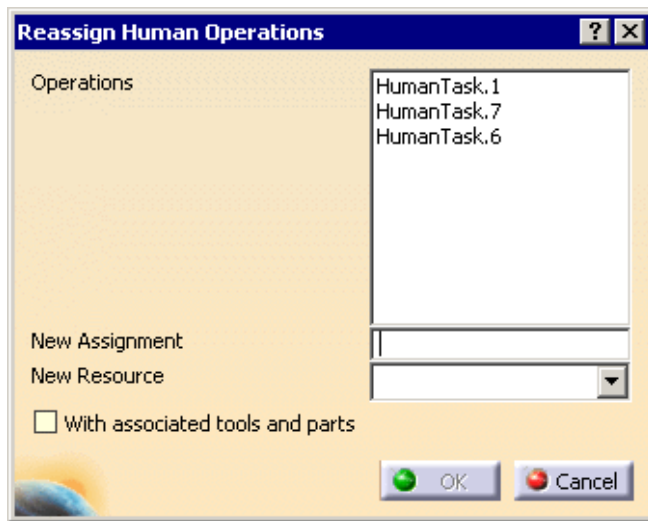
   The selected operations are displayed in the dialog box.

   ⓘ Selecting an operation twice will remove that operation from the dialog box.

3. After selecting the operations that have to be reassigned, Click **OK**.

   The **Reassign Human Operations** dialog box appears.

4. Select a value for the **New Assignment** field.

5. Select the **New Resource** from the drop-down.

6. *(Optional)* **With associated tools and parts** check box.

   ○ If this option is OFF, you will be prompted to select the different parts/tools to the activities under the Human Task.

   ○ If this option is ON, the command will automatically associate the same tools and parts to the activities under the Human Task in the new assignment.

   > (i) This option has to be turned OFF when reassigning human operations across different documents, so that the user will be prompted to select the parts/tools in the second detailing. It is not possible to automatically associate the tools and parts when reassignment is being executed within two different detailings.

7. Click **OK**.

   ○ Selected Operations are CUT from Station1 and PASTED under the selected activity in Station2.

   ○ The manikin resource selected in Station2 will be assigned as the resource for all the pasted operations in Station2.

   ○ All the Human Tasks that were set as Active in the Operations that were moved from Station1 to Station2, will be COPIED and PASTED under the selected manikin in Station2. In case Human Activity Group (HAG) was set as Active, only the HAG will be cut and pasted under a newly created task in the manikin assigned to Station2. The Active Task link will be retained in Station2

     ■ Note: The human tasks/human activity group can be set as active task in multiple operations; not all the operations may be selected during reassignment. Hence, the human tasks/human activity group will be copied and pasted (not cut & pasted) in the new manikin resource

(i) Managing "Items Assignment" within the command

As long as the reassignment takes place within the same detailing, all the items assigned to the Operation(s) will be retained.
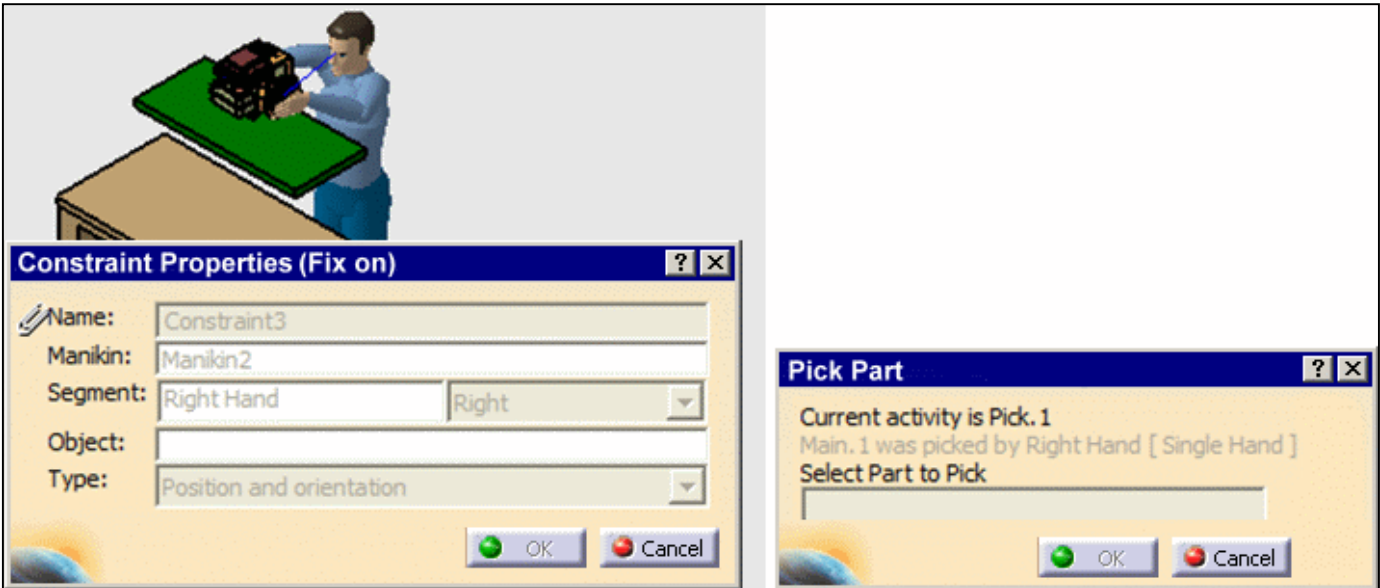
Managing "Resource Assignment" within the command

Only one Manikin resource will be assigned to the Operation (that has to be reassigned).

After Pasting the Operation under new Station/Workplace, the selected Manikin (**New Resource** drop-down list) will be assigned to the Operation. In case there are other resources (like robot, device, etc.,) assigned to the Operation, they will be lost when the operations are CUT and PASTED under the new assignment.

Managing "Constraints and Picked Objects" within the command

- If the Operation that has been re-assigned has Human Task (set active) with constraints, then, you will be prompted to select the target objects to re-establish the constraints.

- If the Operation that has been re-assigned has Human Task (set active) with Pick Activities, then, you will be prompted to select the picked parts.

Managing "Operate Activity and Move Activity" within the command

- The operations to be reassigned must be leaf nodes.

- If the Operation that has been re-assigned has a Move Activity and a Human Task with Operate (set as active), then:
    - The Move Activity will be retained & moved along with the Operation.
    - The Items associated with the Move Activity will be retained and moved with the Operation (only when reassignment is done within the same detailing).
    - You will be prompted to select the MoveActivity referenced by the Operate activity.