

PROGRAM TRANSFER AND CONTRACT ASSEMBLY | MEDICAL PRODUCTS

Moved in from out of state. Running in under four weeks.

A Wisconsin injection molder wanted mask assembly moved from out of state to sit closer to its molding operation. RELY time-studied the work so the labor requirement was known before the move, then had production running in under four weeks.



Bagging and packout on the mask program at RELY.

Program photo

104,609 Medical masks
assembled

<4 wks From go-ahead to
production at RELY

307,347
Molded components
assembled into masks

3
Mask sizes run under
one controlled program

7
Product lines for the same
customer: masks, then six more

Production figures from RELY ERP records. Masks: 31 completed work orders, April 2021 to May 2022. Product lines: April 2021 to August 2022. Customer name withheld.

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The risk was the gap between the old line and **the new one.**

The customer's mask assembly ran out of state, far from its Wisconsin molding operation. Before committing to a move, the customer needed real numbers on labor content and throughput. Once the decision was made, any gap between the old line stopping and the new one starting put supply at risk.

RELY'S SCOPE

01 TIME STUDY BEFORE THE MOVE

Measured the assembly work so the move decision rested on real labor data.

02 FAST START

Production at RELY in under four weeks from go-ahead.

03 CLEANING, KITTING AND GMP

Ran under RELY's GMP policies, with cleaning and kitting built in.

04 THREE SIZES, ONE PROCESS

Small, medium and large masks assembled under one controlled program.

05 PEAK MONTHLY OUTPUT

Mask output peaked at 17,375 in September 2021.

06 BAGGED AND PACKED OUT

More than 102,000 masks individually bagged and packed for shipment.

One fast start became **seven product lines.**

Mask assembly started first, in April 2021. Beginning in May 2021, the same customer moved six more product lines to RELY: molded parts that needed assembly, kitting or packout.

Product line	First run at RELY	Units
Medical masks	Apr 2021	104,609
Portion trays	May 2021	41,666
Crowfoot holders	May 2021	19,433
Pivot pins	Jun 2021	24,507
Three smaller lines	Jun 2021 to Mar 2022	20,474
Total, seven product lines	Apr 2021 to Aug 2022	210,689

210,689

Total units across seven product lines.

Masks plus six additional product lines. April 2021–August 2022.

A specific transfer need became a broader manufacturing relationship **once RELY showed it could execute.**

MOVING ASSEMBLY CLOSER?

Let's talk through the move.

Tell us what needs to move, your volumes and your timing. We'll identify the next step, whether that's a time study, sample review or transfer plan.



Scan to discuss your program

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Discuss your program

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