

TABLE 9S.2: Options for Balancing an Assembly Line

RULE OF THUMB	DESCRIPTION
Most-following-tasks rule	Assign tasks in the order of most number of following tasks. In Figure 9S.7, the frame installation has the most number of following tasks (3). Hence, it will be assigned first to the first workstation and so on. In the case of a tie, assign the task with the longest operating time first.
Ranked-positional-weight rule	Assign tasks in the order of highest positional weight. The positional weight of a task is computed as the sum of each task's time and the sum of all tasks following it. Thus, in Figure 9S.7, the positional weight of frame installation is equal to $9 + 25 + 6 + 10 = 50$. Similarly, the positional weights of engine installation, hood installation, and wheel installation are 41, 16, and 10, respectively. Since frame installation has the highest positional weight, it will be assigned first to the first workstation and so on. In the case of a tie, assign the task with the longest operating time first.
Longest-operating-time rule	Assign in the order of the task with the longest operating time.
Least-number-of-following-tasks rule	Assign tasks in the order of the least number of following tasks.
Shortest-operating-time rule	Assign in the order of the task with the shortest operating time.