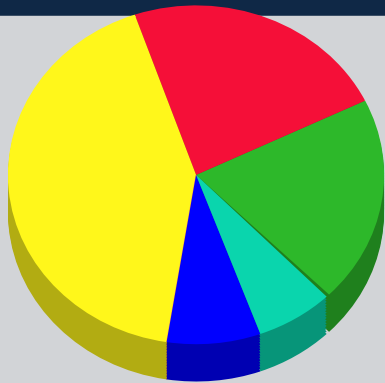
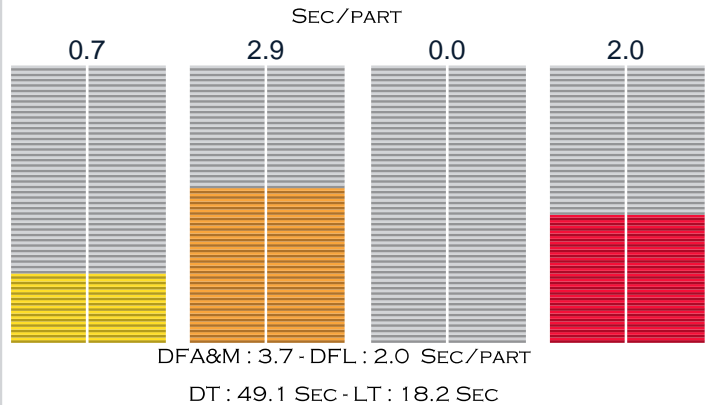
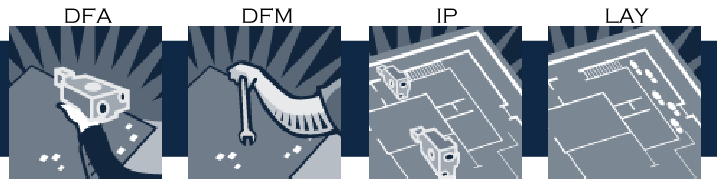


FILM



PARTS	8.0 M
	1 NM
AV	15.6 SEC
	23.2 %
DFA&M	33.4 SEC
	49.5 %
DFL	18.2 SEC
	27.1 %
DFE	0.0 SEC
	0.0 %

Eff=91 %
ST (T1 10+R8%): 72.8 SEC



Sequence	Redgreen	DT	LT	ST(Sec)
ID-01-TAKE NEW LEFTDOOR AND PLACE IN FIXTURE 2- 35 GO TO BIN AND TAKE LEFTDOOR PPIT / LEFTDOOR / FIXTURE 36- 55 GO TO FIXTURE AND PLACE LEFTDDOOR IN FIXTURE		2.5 2.33 1.02	5.0	7.6 3.0S 1.72S
ID-02-PRESS BUTTONS, TAKE AND PREFIX BOLTS WITH AIRTOOL 56- 61 GRASP TO BOLTS PPIT / BOLT HINGES / AIRTOOL BOLT HINGES 87- 92 PLACE BOLT 1 IN AIRTOOL 105- 109 PLACE BOLT 2 IN AIRTOOL 119- 124 PLACE BOLT 3 IN AIRTOOL 135- 140 PLACE BOLT 4 IN AIRTOOL 62- 69 UTOP / FIXTURE BUTTON TOP / LEFTDOOR 69- 74 UTOP / FIXTURE BUTTON BOTTOM / LEFTDOOR 75- 87 WTMP / AIRTOOL BOLT HINGES / BOLT HINGES 93- 104 110- 118 125- 134 141- 153		13.3 2.04 4.09	0.7	14.0 0.45S 0.45S 0.36S 0.45S 0.45S 0.63S 0.45S 1.09S 1.0S 0.72S 0.81S 1.09S
ID-03-TAKE AND PLACE SHIMS UNDER BOLTHEADS, FIX BOLTS WITH 154- 208 MNTP / SHIM 0- 0		18.3 2.04 4.09	0.7	19.0 4.9S 0.0S

IMPROVABLE: 72.0 %



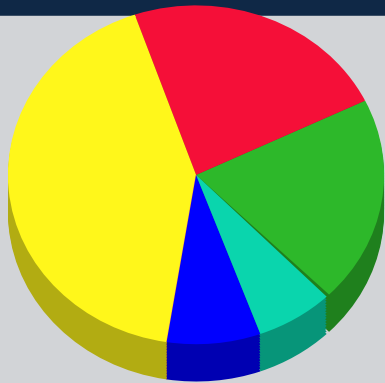
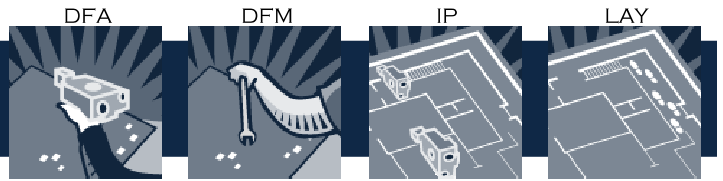
ST
(T1 10+R8%)

TIMESTUDY = CHRONO

ADDED VALUE	23.2 %	15.6 SEC
DFA	10.6 %	7.1 SEC
DFM	38.9 %	26.2 SEC
IP	0.4 %	0.2 SEC
S&B (25 S/ O B)	26.6 %	18.0 SEC
REST		

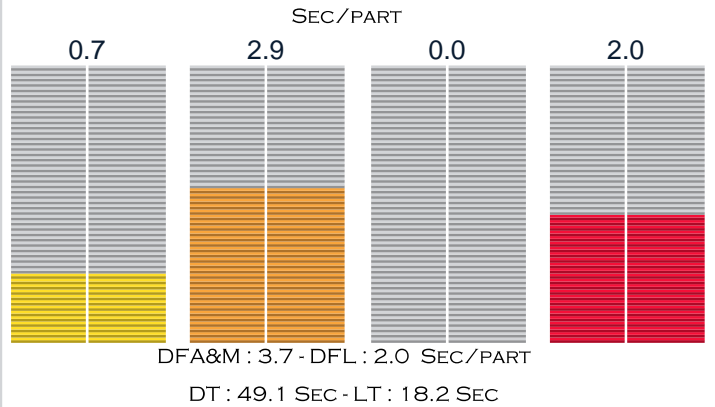
TOTAL = 72.8 SEC

FILM



PARTS	8.0 M
	1 NM
AV	15.6 SEC
	23.2 %
DFA&M	33.4 SEC
	49.5 %
DFL	18.2 SEC
	27.1 %
DFE	0.0 SEC
	0.0 %

Eff=91 %
ST (T1 10+R8%): 72.8 SEC



Sequence	Redgreen	DT	LT	ST(Sec)
209 - 229 UTOP / AIRTOOL BOLT HINGES / BOLT HINGES				1.81 S
230 - 247 UTOP / AIRTOOL BOLT HINGES / BOLT HINGES				1.54 S
248 - 264				1.45 S
265 - 281				1.45 S
282 - 288				0.54 S
ID-04-PRESS BUTTON AND LOAD HINGES INTO FIXTURE	■ ■ ■	8.1	0.7	8.8
288 - 292 UTOP / FIXTURE BUTTON TOP / LEFTDOOR				0.36 S
293 - 337 MNTP / HINGES BOTOM & TOP		2.04		4.0 S
342 - 350		4.09		0.72 S
338 - 341 UTOP / FIXTURE BUTTON TOP / LEFTDOOR				0.27 S
ID-05-TAKE AND PUT TWO PROTECTIONS ON DOOR	■	0.1	6.0	6.2
351 - 392 UTOP / PROTECTION PLATE RIGHT / LEFTDOOR		2.04		3.72 S
392 - 393 DPOT / LEFTDOOR				0.09 S
ID-06-PLACE FINISHED LEFTDOOR INTO SHUTTLE	■ ■	5.6	5.0	10.7
422 - 490 PPIT / LEFTDOOR / SHUTTLE		2.33		6.18 S
490 - 496 UTOP / BUTTON SHUTTLE / LEFTDOOR				0.54 S
NEW SEQUENCE	■	0.9		0.9
1 - 100 MNTP /				9.0 S
FREQUENTIAL - 10%				

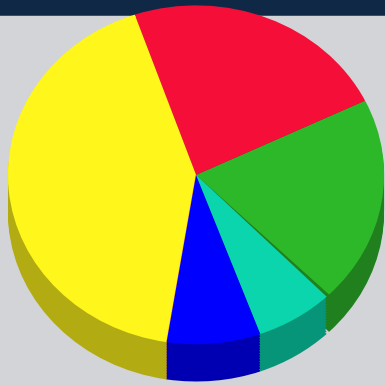
IMPROVABLE: 72.0 %



ST
(T1 10+R8%)

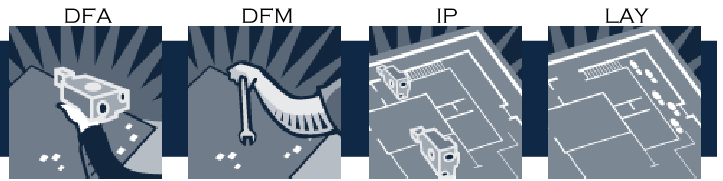
ADDED VALUE	23.2 %	15.6 SEC
DFA	10.6 %	7.1 SEC
DFM	38.9 %	26.2 SEC
IP	0.4 %	0.2 SEC
S&B (25 S/ O B)	26.6 %	18.0 SEC
REST		

FILM



PARTS	8.0 M
	1 NM
AV	15.6 SEC
	23.2 %
DFA&M	33.4 SEC
	49.5 %
DFL	18.2 SEC
	27.1 %
DFE	0.0 SEC
	0.0 %

Eff = 91 %
ST (T1 10+R8%): 72.8 SEC



Sequence	Redgreen	DT	LT	ST(Sec)

IMPROVABLE: 72.0 %



ST
(T1 10+R8%)

ADDED VALUE	23.2 %	15.6 SEC
DFA	10.6 %	7.1 SEC
DFM	38.9 %	26.2 SEC
IP	0.4 %	0.2 SEC
S&B (25 S/ O B)	26.6 %	18.0 SEC
REST		

DESIGN OPPORTUNITIES

T	Name	Object	Fin	Time(Sec)
DFM	AIRTOOL USE TO FIX BOLTS HINGES SMALLER BOLTS	BOLT HINGES 50.0 %	286.0 € -143 €	14.6 -7.3
DFM	NOT CATEGORISED DFM DIFFICULTY FOR OBJECT LEFTD NO SUGGESTIONS	LEFTDOOR 0 %	138.0 €	7.0
DFM	FIXTURE USE TO BLOCK LEFTDOOR SHUTTLE USE TO BLOCK DOOR	LEFTDOOR 100.0 %	88.0 € -88 €	4.5 -4.5
DFA	NOT CATEGORISED DFA DIFFICULTY FOR OBJECT HINGE NO SUGGESTIONS	HINGES BOTOM & TOP 0 %	54.0 €	2.7
DFA	POSITION NO SUGGESTIONS	SHIM 0 %	39.0 €	2.0
DFM	NOT CATEGORISED DFM DIFFICULTY FOR OBJECT BOLT NO SUGGESTIONS	BOLT HINGES 0 %	0.0 €	

IMPROVABLE: 17.0 % OF ST



DFA&M

DFA	4.4 SEC
DFA OPPORTUNITIES	76.8€ 0.0 SEC
DFM	23.8 SEC
DFM OPPORTUNITIES	76.8€ 11.8 SEC

LAYOUT OPPORTUNITIES

T	Layoutplan	S	B	Opp	Fin	Time(Sec)
S&B	FROM SHUTTLE TO BIN TO FIXTURE BRING SHUTTLE AND FIXTURE 90CM TO BIN	14		-8.6	98.0 €	10.0
S&B	AIRTOOL TAKE AND EVACUATE	2		-1.4	14.0 €	1.4
S&B	NOT CATEGORISED	15		-9.3	216.0 €	11.0
S&B	FROM FIXTURE TO BIN TO FIXTURE	16		-10.0	112.0 €	11.5
S&B	FROM FIXTURE TO SHUTTLE BRING FIXTURE 90CM TO SHUTTLE	12		-7.1	84.0 €	8.6

IMPROVABLE: 54.0 % OF ST



DFL

IP		0.0 SEC
IP OPPORTUNITIES	0.0€	0.0 SEC
S&B		38.6 SEC
S&B OPPORTUNITIES	476.3€	36.7 SEC

PARTS

Part	Redgreen	Time
LEFTDOOR		11.62
BOLT HINGES		5.42
SHIM		3.82
HINGES BOTOM & TOP		3.42
		9.02

PARTSCOUNT 5#



PARTS

PARTS OCCURENCE

#	Part	Redgreen	%	ST(Sec)	DT(Sec)
1.0	LEFTDOOR		41.1	27.7	11.6
4.0	BOLT HINGES		34.6	23.3	21.9
2.0	SHIM		11.4	7.7	7.7
2.0	HINGES BOTOM & TOP		11.2	7.6	6.8
0.1			1.3	0.9	0.9



PART

ADDED VALUE	23.2 %	15.6 SEC
DFA	10.6 %	7.1 SEC
DFM	38.9 %	26.2 SEC
IP	0.4 %	0.2 SEC
BENDS & STEPS	26.6 %	18.0 SEC
REST		