

WHOLE WHEELS		
Number	Activity	Individual time (Sec)
1	Put the cover for cheese	26,36
		26,37
		31,45
		25,25
		34,74
		27,61
		28,54
		44,4
		48,99
		35,6
2	Cut the paper	7,15
		9,75
		10,75
		10,13
		7,2
		6,6
		8,67
		7,93
		10,23
		14,7
3	Collect the cheese from the pallet and put it on top of the paper	7,12
		8,75
		5,31
		5,33
		5,28
		3,9
		6,06
		5,25
		5,54
		4,92
4	Wrap the cheese and paste the cheese type label	32,72
		42,24
		40,62
		36,13
		20,34
		21,66
		28,69
		39,77
		32,03

		34,94
5	Make the boxes and put the sticker sheets inside	11,81
		10,16
		11,57
		10,49
		10,21
		11,55
		9,63
		9,67
		12,02
		10,11
6	Weigh the cheese, put barcode, seal box and put on pallet	31,67
		33,48
		29,2
		44,83
		29,67
		23,69
		29,06
		38,75
		32,5
		35,79

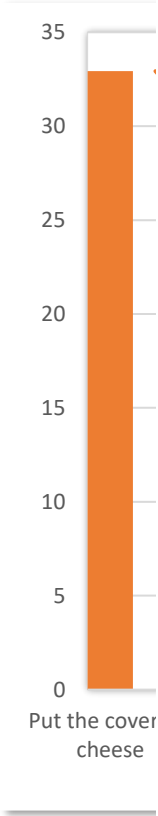
Average time for master box	8,01
	8,81
	8,44
	8,57
	8,1
	11,55
	13,58

Average time for set up station	15,05
	16
	14,5
	15,7

	15,3125

Average time for paste cheese type label	6,83
	6,91
	7,22
	6,986666667

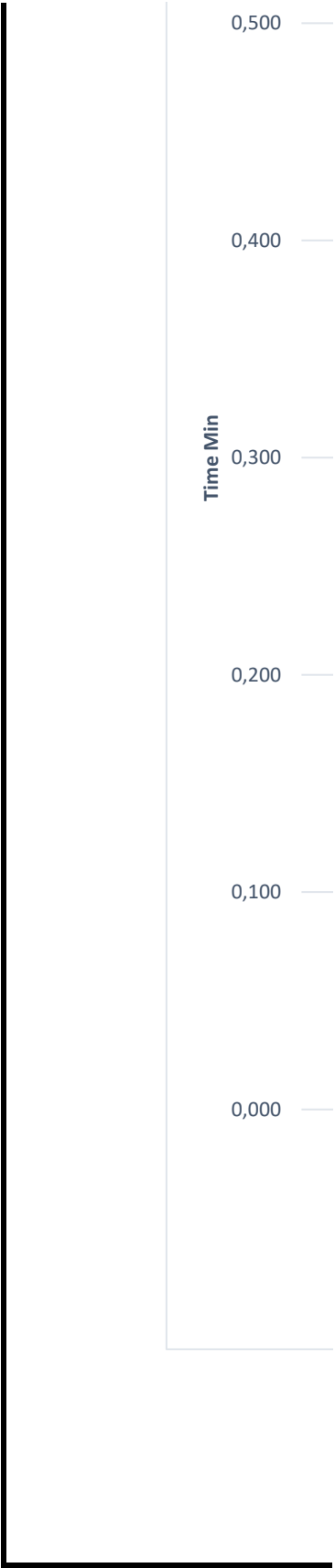
Average time (Sec)	Average time (Min)
32,931	0,549
9,311	0,155
5,746	0,096
32,914	0,549

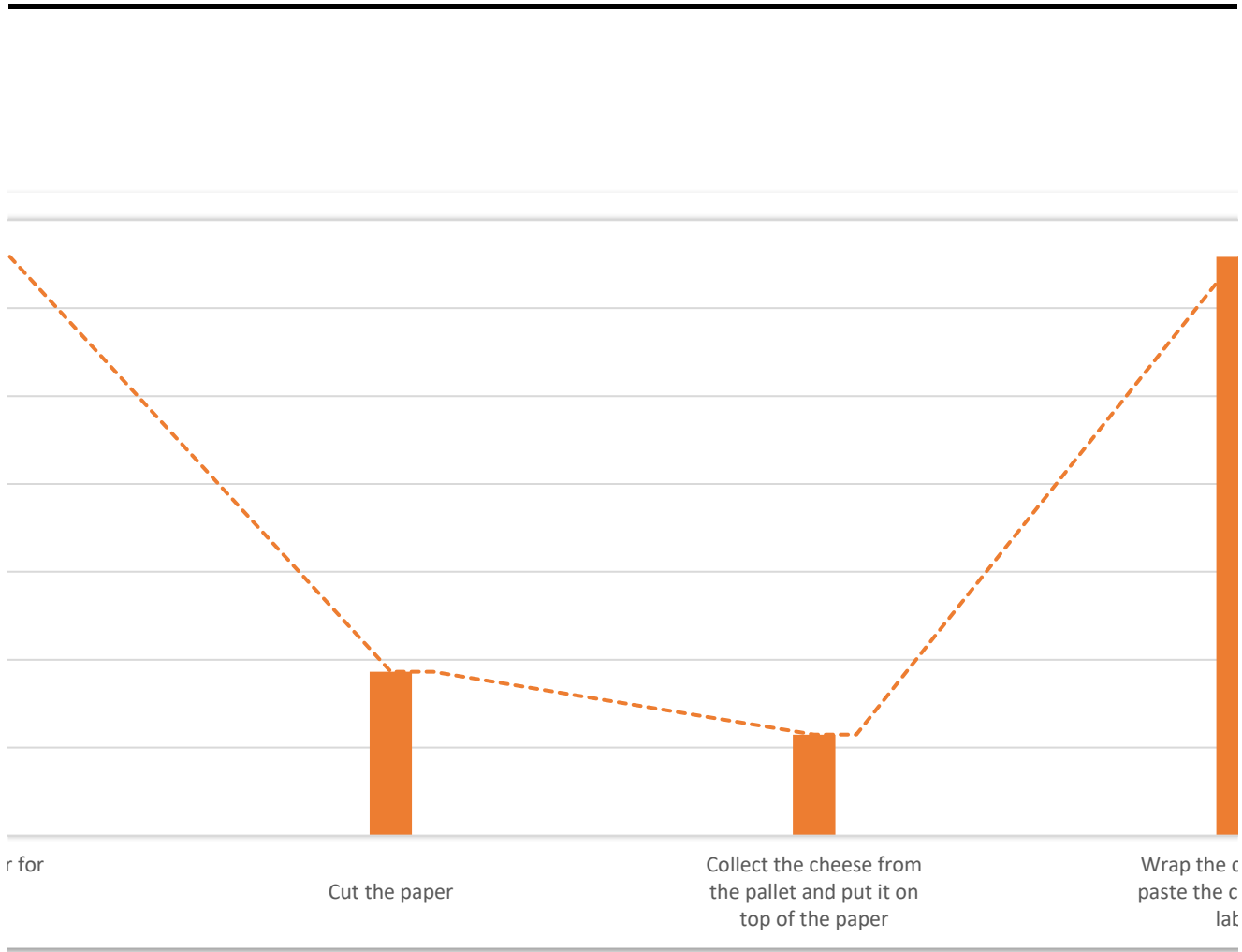


10,722	0,179
32,864	0,548
124,488 2,0748	2,0748 0,03458

- 1
- 2
- 3
- 4
- 5
- 6

0,600





\$ 8 Shift hours
75 Rest min on shift
12,00 Pay per hour

Operation	t(unit/min)
1	0,549
2	0,155
3	0,096
4	0,549
5	0,179

6	0,548
Total	2,075 Unit/min

Actually Operation	t(unit/min)	Workers
1	0,5489	1
$2(/2)+3(/2)+4(/2)$	0,7995	1
$2(/2)+3(/2)+4(/2)$	0,1787	1
5+6	0,5477	1
	2,0748	

4 Employers

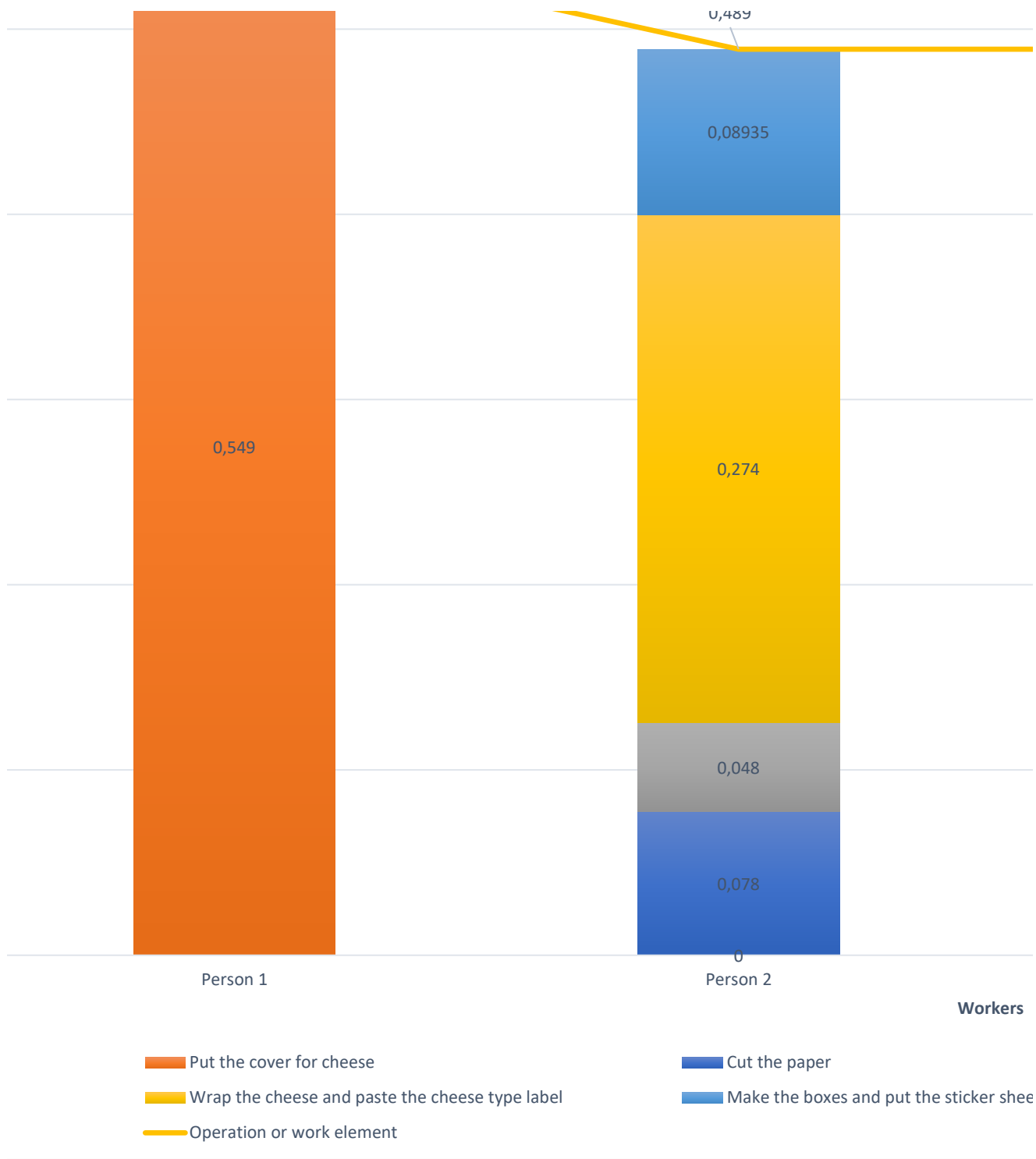
Conditions: Person 1 (performs activity 1, 2 and assists in activity 3), Person 2 (performs activity 3 and assists in activity 4), Person 3 (performs activity 5 and assists in activity 6), Person 4 (Performs activity 7 and assists in activity 8)

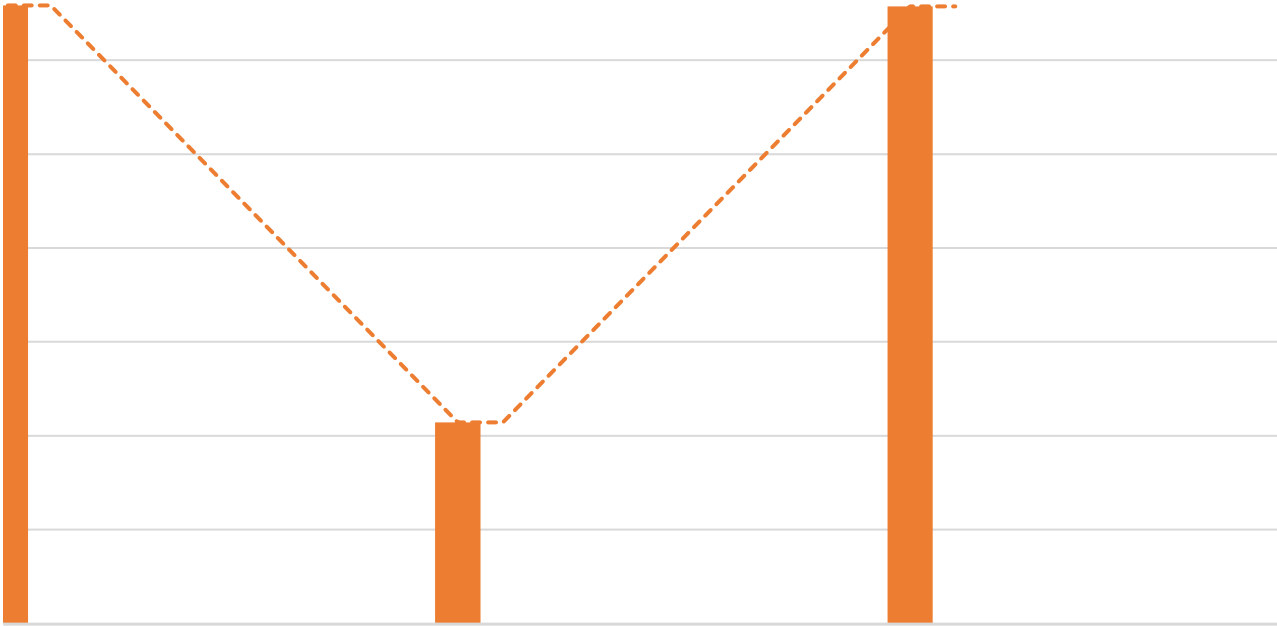
Operation or work element	Operator	
	Person 1	Person 2
Put the cover for cheese	0,549	
Cut the paper		0,078
Collect the cheese from the pallet and put it on top of the paper		0,048
Wrap the cheese and paste the cheese type label		0,274
Make the boxes and put the sticker sheets inside		0,08935
Weigh the cheese, put barcode, seal box and put on pallet		
Total time	0,549	0,489

Average time for master box	13,58
Average time for set up station	15,3125
Average time for paste cheese type label	6,98666667

Operation or work e







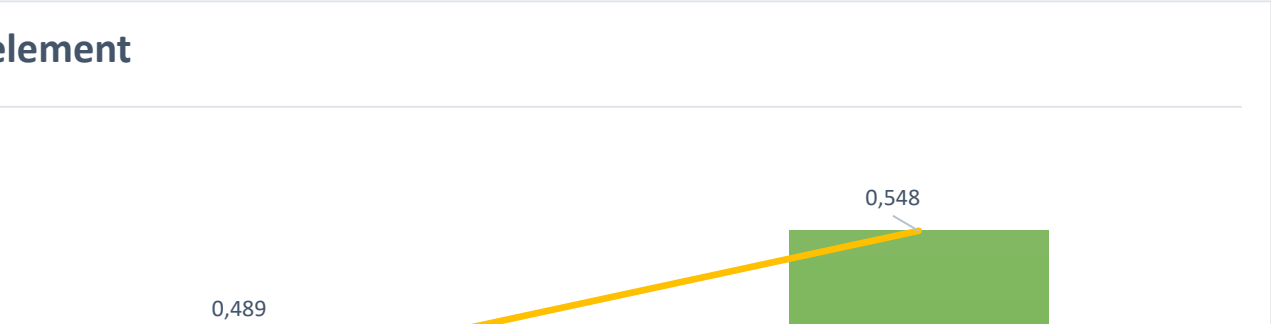
cheese and
cheese type
del

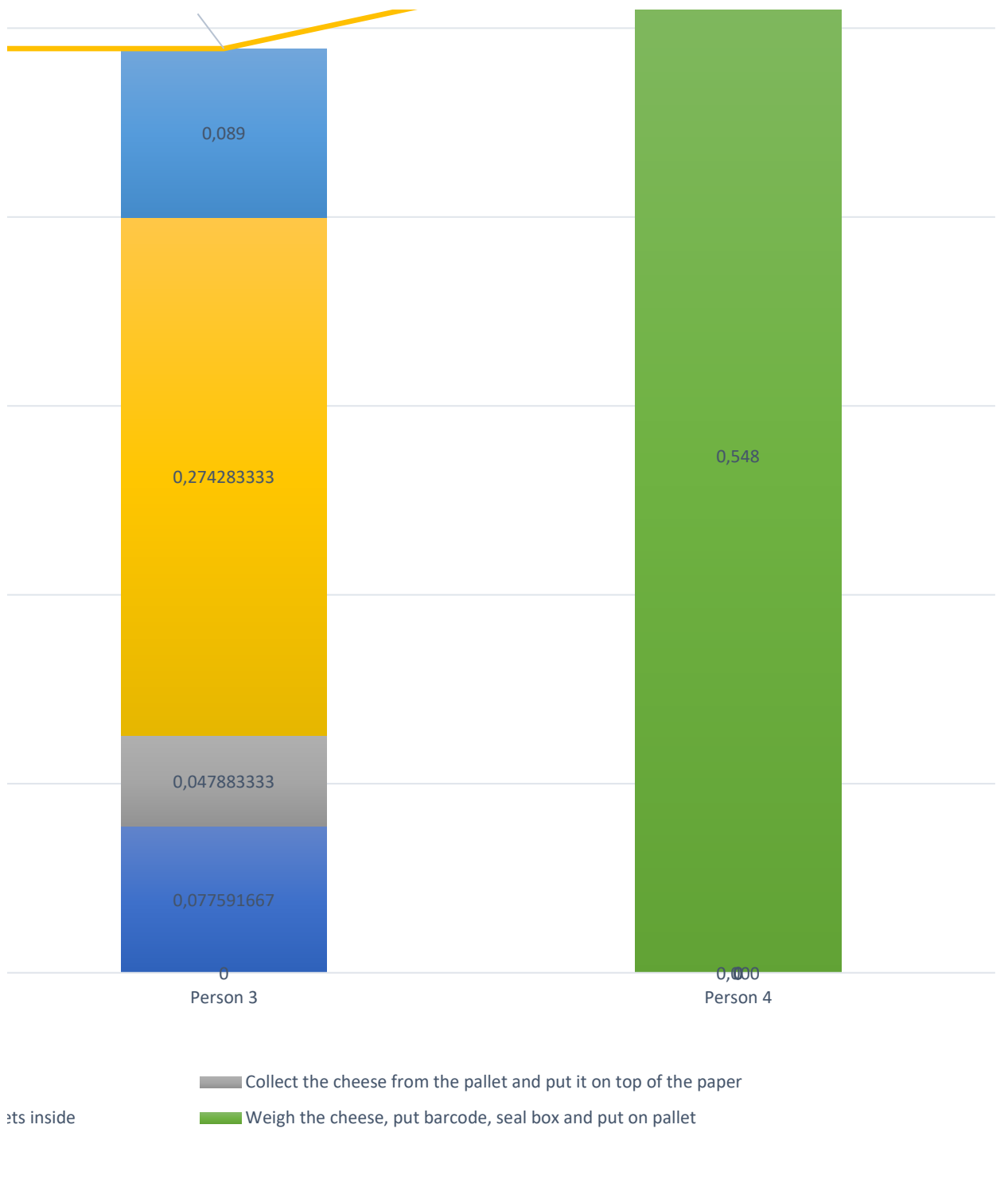
Make the boxes and
put the sticker sheets
inside

Weigh the cheese, put
barcode, seal box and
put on pallet

and activity 4), Person 3
)

Person 3	Person 4		
		0,549	It's correct
0,07759167		0,155	It's correct
0,04788333		0,096	It's correct
0,27428333		0,549	It's correct
0,089		0,179	It's correct
	0,548	0,548	It's correct
0,489	0,548	2,075	Min









1. % Efficiency
2. Cycle Time (min/unit)
3. Exit rate (unit/min)
4. Exit rate (Unit/hours)
5. Unit / dia
6. Tack Unit/hours
5. Tack Unit/Min
7. Cost/Unit
8. Productivity per operator
9. Productivity per operator/hour
10. What would be the minimum unit selling price so as not to lose money?

Target units

11. Cyle Time Objetivo (min/unit)
12. Exit rate objective (unid/min)
13. Exit rate objective (Unit/hours)
12. Unit / day
14. What maximum time should the bottleneck operation be? (Min/unit)
15. What maximum time should the bottleneck operation be? (hours/unit)
16. Cost objective/Unid
17. Productivity per Operator
18. Productivity per Operator.hour

100%				
2,07	124,488			
0,48	0,5489	124,488		
28,92				
195,20				
24,40				
0,4066657				
1,97				
24,40				
3,25				
1,97				
1		Time for	1	Quarters
		Units for hour	Takt time	
0,1915				Workers
5,2210				
313,2614				
2114,5144				
0,5489				
0,0091				
96,0000				
0,1250				
0,01851852				

0,04	Hours	2,45902222
24,40	Unit/hours	
4		