

Q1: Which is Takt Time?

Stages	Formula	Value	Notes
mac cut fin	2 shift	1,8	min/pz
paint pack	3 shift	2,7	min/pz

Q2: Direct shipping or Finished good warehouse

Choice	FGw
Drivers	quite variable +/-25%
	variants not huge in number
	low LT
	not perishable

Q3: Where to put Continuous flow?

CONTINUOUS FLOW 1

Stages to be coupled mac cut fin

Variables	Formula	Value	Notes
N ope		3,333333333	4 ope
CT		90	sec
CO		60	min
A		0,864	
# shifts		2	

DECAF CONDITION

Dedicated?	yes		
Capable?	1,5<1,8	yes	
Available?	1,736111111	<1.8	yes
Flexible?	EPEt=2d		
	1916,1111111	<=?	1800
New CO	21,2962963	min	

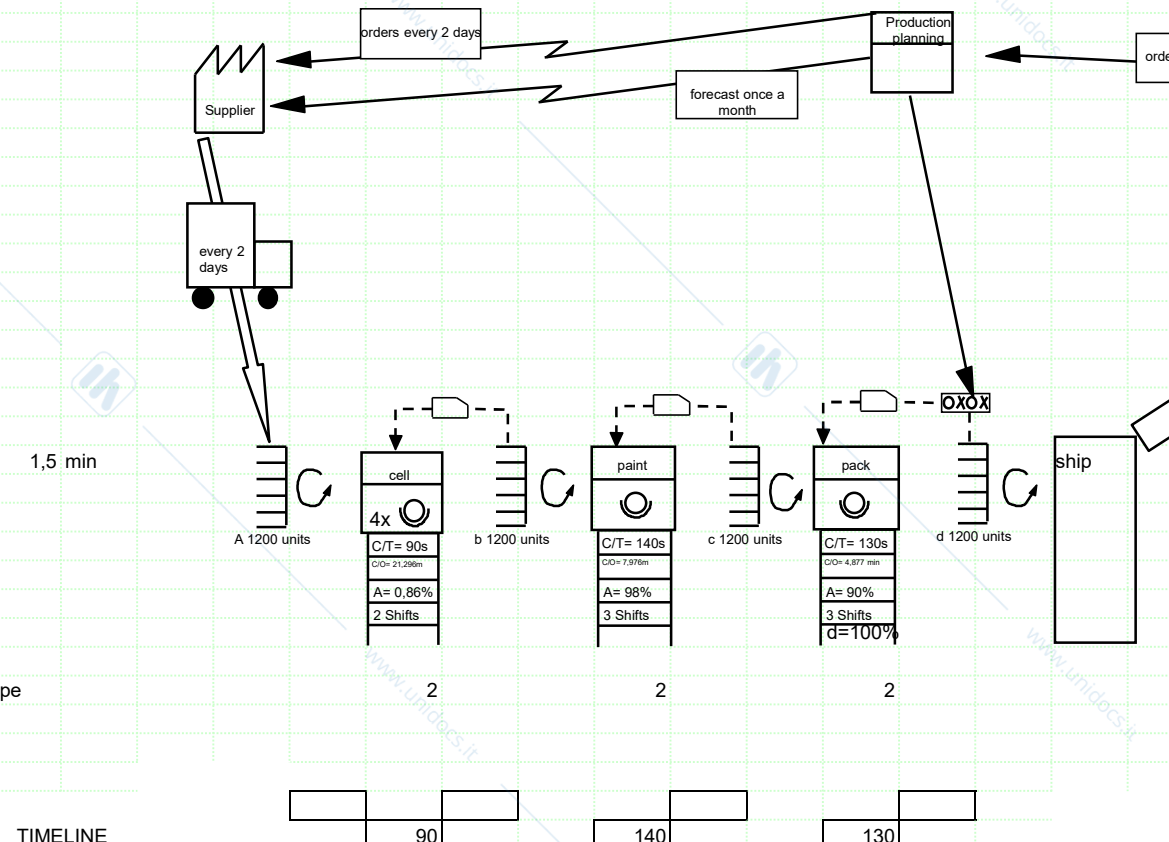
CONTINUOUS FLOW 2

Stages to be coupled

Variables	Formula	Value	Notes
N ope			
CT			
CO			
A			
# shifts			

DECAF CONDITION

Dedicated?			
Capable?			
Available?			



press analysis
paral to serie
#ope= 0,8025 1 ope
CT= 130 s 2,1667 min
wct= 130 s
dedication

paint analysis
epe calculated before
new co
7,9762 min