

Q1: Which is Takt Time?

Stages	Formula	Value	Notes
ass	1 shift	3 min/pz	
drill mac paint	2 shift	6 min/pz	

Q2: Direct shipping or Finished good warehouse

Choice	FGW
Drivers	demand fluctuation 30%
	LT very short

Q3: Where to put Continuous flow?

CONTINUOUS FLOW 1

Stages to be coupled mach paint

Variables	Formula	Value	Notes
N ope		2,416666667	3 ope
CT		4,833333333	min/pz
CO		11,25	min
A		0,9	
# shifts		2	

DECAF CONDITION

Dedicated?	yes
Capable?	4,8 < 6 yes
Available?	5,37037037 < 6 yes
Flexible?	EPET= 2,430107527
	2182,586619 <=? 2187,096774
	yes
New CO	\

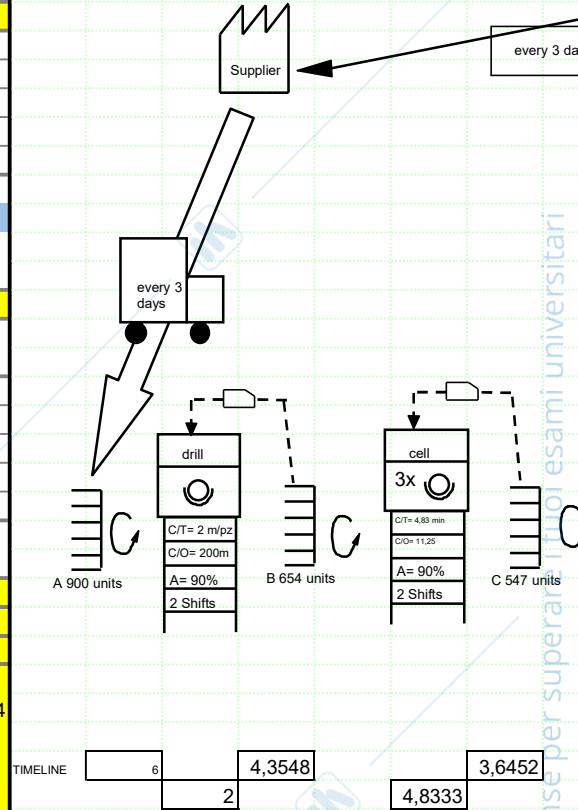
CONTINUOUS FLOW 2

Stages to be coupled assembly from parall to serie

Variables	Formula	Value	Notes
N ope		4,666666667	5 ope
CT		2,8	min
CO		16,66666667	min
A		0,95	
# shifts		1	

DECAF CONDITION

Dedicated?	yes
Capable?	2,8 < 3 yes
Available?	2,947368421 < 3 yes
Flexible?	EPET= 3
	1526,315789 <=? 1350



mach to serie

#ope=	1,6667	2 ope
CT=	5	min/pz
wct=	10	min/pz
20>	2*150*LT	2*3+3*1,5+x*1,5+3*2=20
	1,5*150*EPET	2,4
	1,5*150*EPET	
	2*150*EPET1	

2*150*LT < 900	LT <= 3days
1,5*150*EPET < 900	EPET < 4days
2*150*EPET1 < 900	EPET1 < 3days