

Q1: Which is Takt Time?

Stages	Formula	Value	Notes
S1 S2 S3 S4		54	
S5		81	

Q2: Direct shipping or Finished good warehouse

Choice	DIRECT PER SHIPPING
Drivers	HIGH OBSOLESCENCE RISK
	VERY LOW LEAD TIME

Q3: Where to put Continuous flow?

CONTINUOUS FLOW 1

Stages to be coupled **S5**

Variables	Formula	Value	Notes
N ope		3,580246914	4
CT		72,5	
CO		157,5	
A		0,98	
# shifts		3	

DECAF CONDITION

Dedicated?	YES
Capable?	CT<TT 72,5<81 YES
Available?	CT/A<TT 74<81 YES
Flexible?	TA=1350 TP=1000*72,5/60*0,98=1233 MIN TS=10*157,5=157,5
New CO	11,70068027

CONTINUOUS FLOW 2

Stages to be coupled **S2 S3 S4**

Variables	Formula	Value	Notes
N ope		2,259259259	3
CT		40,66666667	
CO		22	
A		0,874552	
# shifts		2	

DECAF CONDITION

Dedicated?	YES
Capable?	CT<TT 37<54
Available?	CT/A<TT
Flexible?	TA=900 TP=1000*40,67/60*0,98=691,67 MIN

