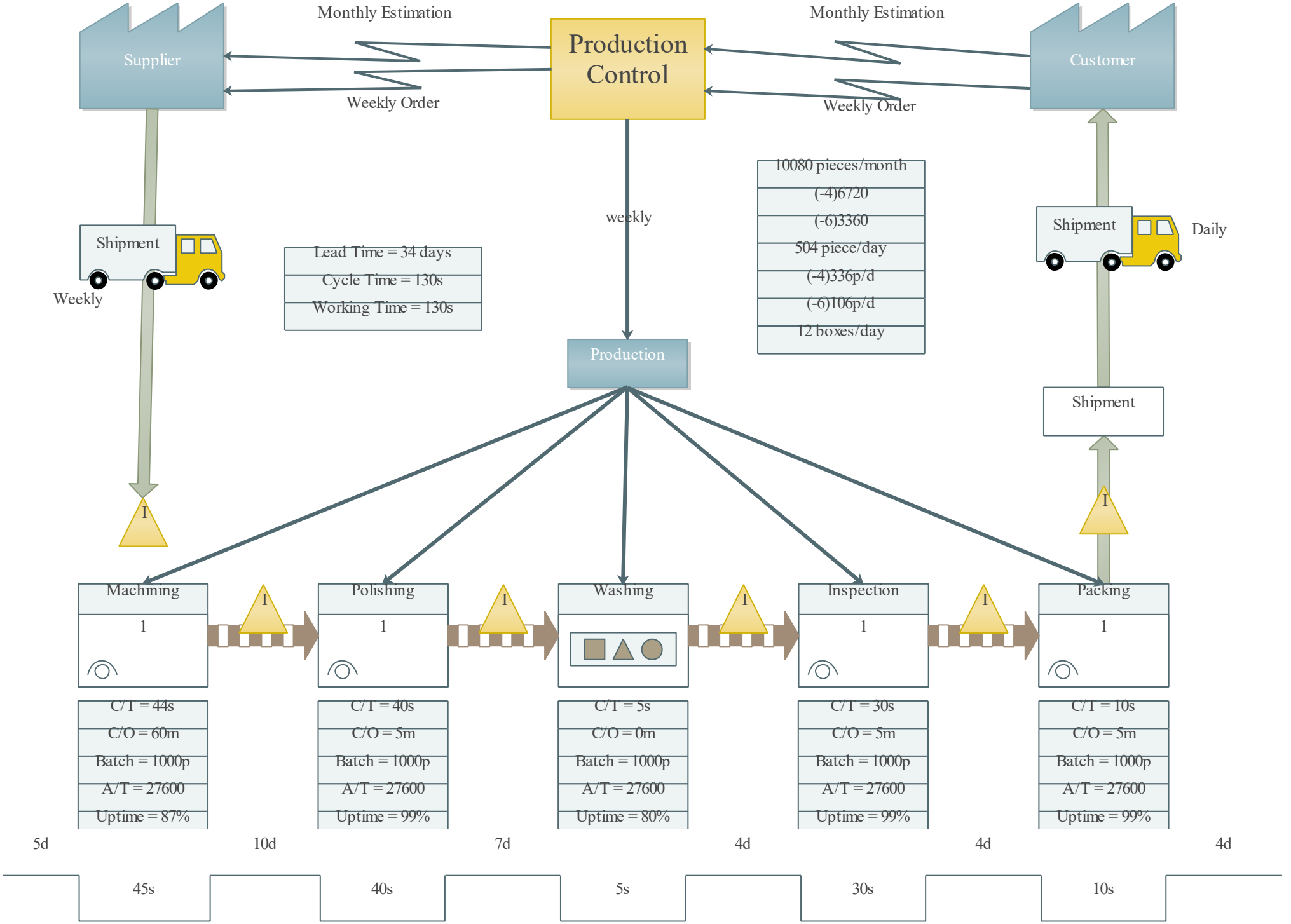
Supplier
Monthly Estimation
Weekly Order
Production Control
Monthly Estimation
Weekly Order
Customer
Shipment
Weekly
Lead Time = 34 days
Cycle Time = 130s
Working Time = 130s
weekly
10080 pieces/month
(-4)6720
(-6)3360
504 piece/day
(-4)336p/d
(-6)106p/d
12 boxes/day
Shipment
Daily
Production
Shipment
I
I
Machining
1
C/T = 44s
C/O = 60m
Batch = 1000p
A/T = 27600
Uptime = 87%
I
Polishing
1
C/T = 40s
C/O = 5m
Batch = 1000p
A/T = 27600
Uptime = 99%
I
Washing
C/T = 5s
C/O = 0m
Batch = 1000p
A/T = 27600
Uptime = 80%
I
Inspection
1
C/T = 30s
C/O = 5m
Batch = 1000p
A/T = 27600
Uptime = 99%
I
Packing
1
C/T = 10s
C/O = 5m
Batch = 1000p
A/T = 27600
Uptime = 99%
5d
10d
7d
4d
4d
4d
45s
40s
5s
30s
10s