TIME STUDY

Using EXCEL 2016

Time Study Sheet (Polo Shirt)

Operation Name	Machine (M/C)	Cycle Time (Second)					Average (second)	Average (Minute)	SMV with Allowance
		1	2	3	4	5			
Back & Front Part Arrange	Manual	11	9	9	10	11	10	0.17	0.38
Shoulder Join	OL-4TH	9	9	11	9	10	9.6	0.16	0.39
Side Label Attach	SNL	13	14	13	12	13	13	0.22	0.45
Body Mark	Manual	15	14	22	13	16	16	0.27	0.48
Sleeve Hem	FL-FB	8	8	7	8	9	8	0.13	0.37
Body Arrange & Sleeve Hem Cut	Manual	10	10	7	12	9	9.6	0.16	0.38
Sleeve Shearing	SNL	10	8	10	10	10	9.6	0.16	0.39
Sleeve Join	OL-4TH	49	47	45	46	45	46.4	0.77	1.01
Placket Rolling	SNL	11	9	9	9	9	9.4	0.16	0.39
Placket Mark	Manual	9	9	12	11	10	10.2	0.17	0.39
Placket Join	SNL	26	26	24	25	24	25	0.42	0.65
Placket Scissoring	Manual	11	10	15	10	12	11.6	0.19	0.41

Standard Minute Value (SMV)

SMV	8.89	Minute for Making a Polo Shirt
SMV with Allowances	15.71	

Expected Allowances

Personal Allowance	5	Second
Machine Allowance	6	
Process Allowance	8	

Note:

0: Personal Allowance is with Manual Operation

0: Machine Allowance is with Machine Operation

0: Process Allowance is with both Manual & Machine

Industrial Engineering Time Motion Study Formula

Julia Schneider

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