

# TIME STUDY

## Using EXCEL 2016

Time Study Sheet (Polo Shirt)

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:**

- Personal Allowance is with Manual Operation
- Machine Allowance is with Machine Operation
- Process Allowance is with both Manual & Machine

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	SM	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	SM	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	SM	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	SM	26	26	24	25	24	25	0.42	0.65
Placket Scissoring	Manual	11	10	15	10	12	11.6	0.19	0.41

# Industrial Engineering Time Motion Study Formula

**F Rizvi**



**Industrial Engineering Time Motion Study Formula:**

## Adopting the Beat of Appearance: An Emotional Symphony within **Industrial Engineering Time Motion Study Formula**

In a world eaten by screens and the ceaseless chatter of immediate transmission, the melodic splendor and emotional symphony created by the prepared word frequently fade in to the backdrop, eclipsed by the persistent noise and distractions that permeate our lives. But, set within the pages of **Industrial Engineering Time Motion Study Formula** a marvelous fictional prize filled with natural feelings, lies an immersive symphony waiting to be embraced. Crafted by an elegant composer of language, that captivating masterpiece conducts visitors on a psychological trip, well unraveling the hidden tunes and profound influence resonating within each carefully crafted phrase. Within the depths with this touching review, we shall investigate the book is main harmonies, analyze their enthralling writing type, and submit ourselves to the profound resonance that echoes in the depths of readers souls.

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