

# TIME STUDY

## Using EXCEL 2016

Time Study Sheet (Polo Shirt)

Standard Minute Value (SMV)

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

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

# Industrial Engineering Time Motion Study Formula

**Marco Cascella**



**Industrial Engineering Time Motion Study Formula:**

## Whispering the Secrets of Language: An Emotional Quest through **Industrial Engineering Time Motion Study Formula**

In a digitally-driven earth wherever screens reign great and instant conversation drowns out the subtleties of language, the profound strategies and mental nuances hidden within words usually get unheard. Yet, nestled within the pages of **Industrial Engineering Time Motion Study Formula** a captivating fictional value blinking with fresh thoughts, lies an extraordinary journey waiting to be undertaken. Penned by a talented wordsmith, this wonderful opus invites readers on an introspective journey, lightly unraveling the veiled truths and profound influence resonating within the cloth of each word. Within the emotional depths with this poignant evaluation, we can embark upon a heartfelt exploration of the book is key subjects, dissect their captivating publishing type, and succumb to the strong resonance it evokes heavy within the recesses of readers hearts.

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