

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

Yi-Tong Ma



Industrial Engineering Time Motion Study Formula:

The book delves into Industrial Engineering Time Motion Study Formula. Industrial Engineering Time Motion Study Formula is a vital topic that must be grasped by everyone, from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into Industrial Engineering Time Motion Study Formula, encompassing both the fundamentals and more intricate discussions.

1. The book is structured into several chapters, namely:
 - Chapter 1: Introduction to Industrial Engineering Time Motion Study Formula
 - Chapter 2: Essential Elements of Industrial Engineering Time Motion Study Formula
 - Chapter 3: Industrial Engineering Time Motion Study Formula in Everyday Life
 - Chapter 4: Industrial Engineering Time Motion Study Formula in Specific Contexts
 - Chapter 5: Conclusion
 2. In chapter 1, this book will provide an overview of Industrial Engineering Time Motion Study Formula. This chapter will explore what Industrial Engineering Time Motion Study Formula is, why Industrial Engineering Time Motion Study Formula is vital, and how to effectively learn about Industrial Engineering Time Motion Study Formula.
 3. In chapter 2, the author will delve into the foundational concepts of Industrial Engineering Time Motion Study Formula. This chapter will elucidate the essential principles that need to be understood to grasp Industrial Engineering Time Motion Study Formula in its entirety.
 4. In chapter 3, the author will examine the practical applications of Industrial Engineering Time Motion Study Formula in daily life. This chapter will showcase real-world examples of how Industrial Engineering Time Motion Study Formula can be effectively utilized in everyday scenarios.
 5. In chapter 4, this book will scrutinize the relevance of Industrial Engineering Time Motion Study Formula in specific contexts. The fourth chapter will explore how Industrial Engineering Time Motion Study Formula is applied in specialized fields, such as education, business, and technology.
 6. In chapter 5, this book will draw a conclusion about Industrial Engineering Time Motion Study Formula. The final chapter will summarize the key points that have been discussed throughout the book.
- This book is crafted in an easy-to-understand language and is complemented by engaging illustrations. This book is highly recommended for anyone seeking to gain a comprehensive understanding of Industrial Engineering Time Motion Study Formula.

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Table of Contents Industrial Engineering Time Motion Study Formula

1. Understanding the eBook Industrial Engineering Time Motion Study Formula
 - The Rise of Digital Reading Industrial Engineering Time Motion Study Formula
 - Advantages of eBooks Over Traditional Books
2. Identifying Industrial Engineering Time Motion Study Formula
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Industrial Engineering Time Motion Study Formula
 - User-Friendly Interface
4. Exploring eBook Recommendations from Industrial Engineering Time Motion Study Formula
 - Personalized Recommendations
 - Industrial Engineering Time Motion Study Formula User Reviews and Ratings
 - Industrial Engineering Time Motion Study Formula and Bestseller Lists
5. Accessing Industrial Engineering Time Motion Study Formula Free and Paid eBooks
 - Industrial Engineering Time Motion Study Formula Public Domain eBooks
 - Industrial Engineering Time Motion Study Formula eBook Subscription Services
 - Industrial Engineering Time Motion Study Formula Budget-Friendly Options
6. Navigating Industrial Engineering Time Motion Study Formula eBook Formats
 - ePub, PDF, MOBI, and More
 - Industrial Engineering Time Motion Study Formula Compatibility with Devices
 - Industrial Engineering Time Motion Study Formula Enhanced eBook Features
7. Enhancing Your Reading Experience

- Adjustable Fonts and Text Sizes of Industrial Engineering Time Motion Study Formula
 - Highlighting and Note-Taking Industrial Engineering Time Motion Study Formula
 - Interactive Elements Industrial Engineering Time Motion Study Formula
8. Staying Engaged with Industrial Engineering Time Motion Study Formula
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Industrial Engineering Time Motion Study Formula
 9. Balancing eBooks and Physical Books Industrial Engineering Time Motion Study Formula
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Industrial Engineering Time Motion Study Formula
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Industrial Engineering Time Motion Study Formula
 - Setting Reading Goals Industrial Engineering Time Motion Study Formula
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Industrial Engineering Time Motion Study Formula
 - Fact-Checking eBook Content of Industrial Engineering Time Motion Study Formula
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

Industrial Engineering Time Motion Study Formula Introduction

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