ATLAS Scissors Assembly
Current State Map

Wks	Days	Shifts	Hrs	Mins
5	2	7.5	60	60
Days	Shifts	Hrs	Mins	Secs

Production Control

Daily

Daily

Weekly Order

Forecast 30 days

ATLAS Warehouse

A70

Cross Dock

Daily Demand	18000	Pairs

Triangle area gadget showing inventory levels. Inventories greater then 30,000 are automatically shown in red

Weekly Schedule

Daily Ship Schedule

Frequency	
1	Per Week

Frequency	
1	Per Week

A10

Mold Handles

Cycle Time	130	Secs
Changeover Time	2	Hrs
Operators	2	Staff
Batch Size	50	Pairs

Scissors

75000	Pairs

Scissors

38500	Pairs

A20

Sharpen

Cycle Time	75	Secs
Changeover Time	15	Mins
Operators	1	Staff
Batch Size	50	Pairs

Scissors

27000	Pairs

A30

Drill

Cycle Time	20	Secs
Operators	1	Staff
Batch Size	50	Pairs

Scissors

31000	Pairs

A40

Assemble

Cycle Time	30	Secs
Operators	1	Staff
Batch Size	50	Pairs

Scissors

7000	Pairs

A50

Test

Cycle Time	10	Secs
Operators	1	Staff
Batch Size	50	Pairs

Scissors

5000	Pairs

A60

Ship

Defects	500	ppm

B10

Summary

Production Lead Time	10.19	Days
Processing Time	265.00	Secs

Gadget Data

4.17 Days	2.14 Days	1.50 Days	1.72 Days	0.39 Days	0.28 Days
130.00 Secs	75.00 Secs	20.00 Secs	30.00 Secs	10.00 Secs	