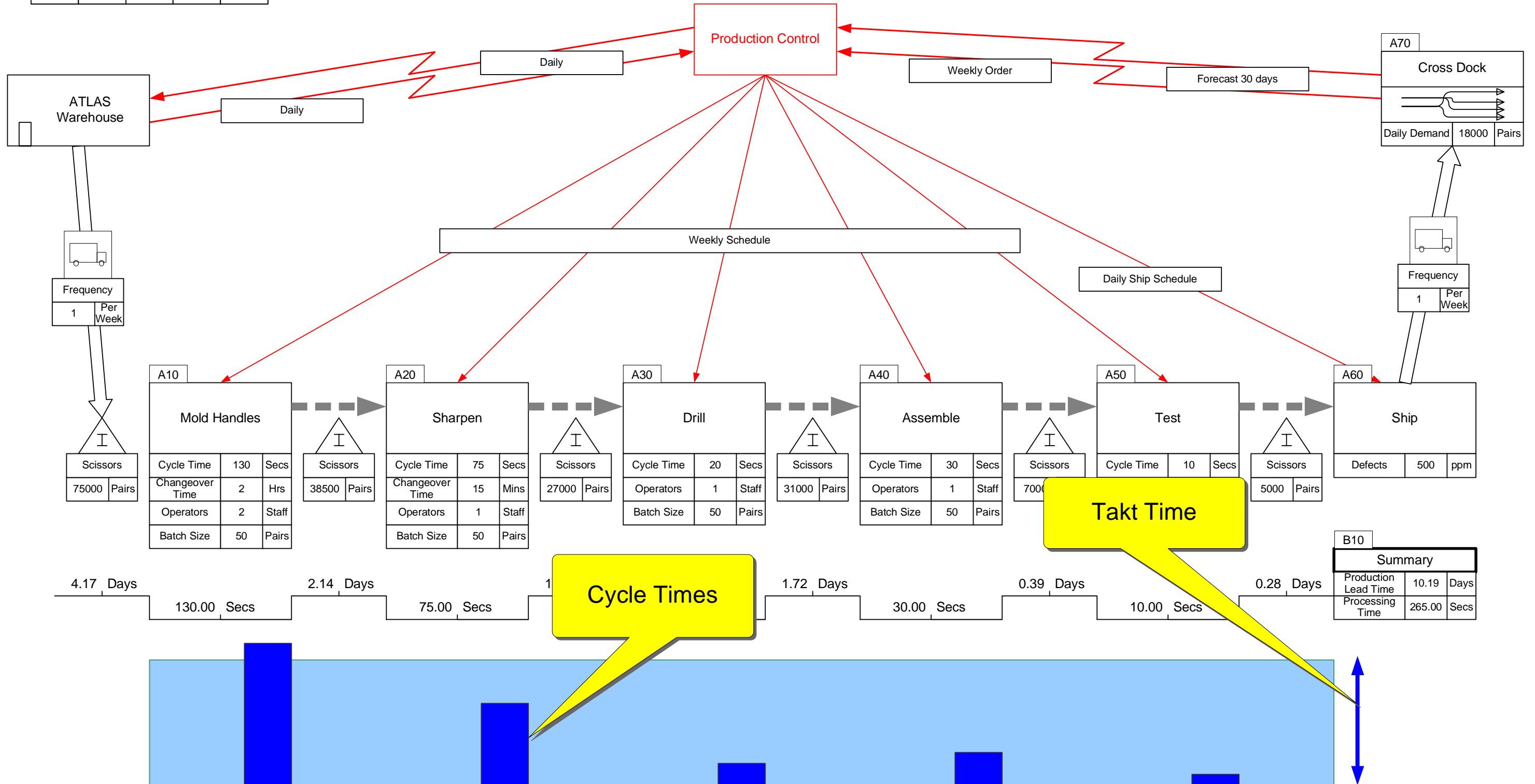


ATLAS Scissors Assembly Current State Map

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



Production Control

Daily

Weekly Order

Forecast 30 days

Daily

Weekly Schedule

Daily Ship Schedule

Frequency

1 Per Week

Frequency

1 Per Week

A10

A20

A30

A40

A50

A60

Mold Handles

Sharpen

Drill

Assemble

Test

Ship

Scissors

75000 Pairs

Scissors

38500 Pairs

Scissors

27000 Pairs

Scissors

31000 Pairs

Scissors

7000 Pairs

Scissors

5000 Pairs

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

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

Cycle Time	20	Secs
Operators	1	Staff
Batch Size	50	Pairs

Cycle Time	30	Secs
Operators	1	Staff
Batch Size	50	Pairs

Cycle Time	10	Secs
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Defects 500 ppm

Takt Time

Cycle Times

B10

Summary		
Production Lead Time	10.19	Days
Processing Time	265.00	Secs

4.17 Days

130.00 Secs

2.14 Days

75.00 Secs

1

1.72 Days

30.00 Secs

0.39 Days

10.00 Secs

0.28 Days