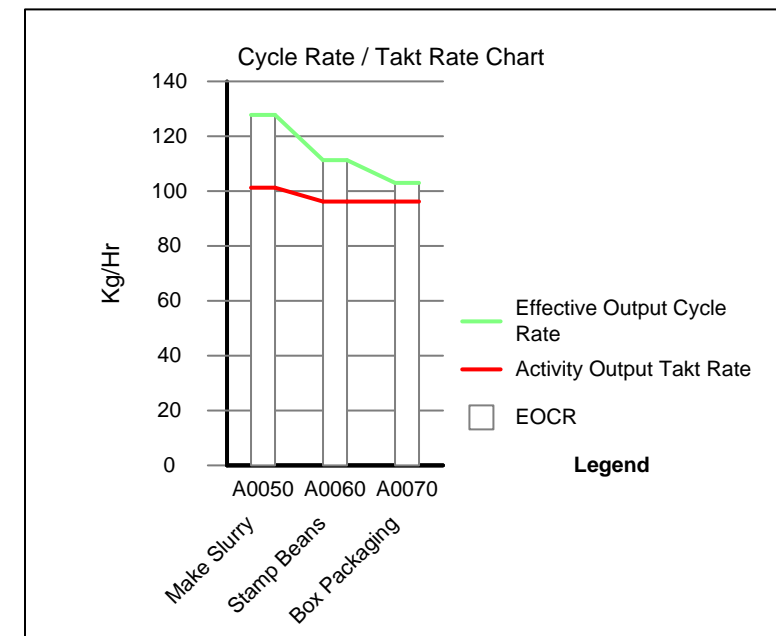
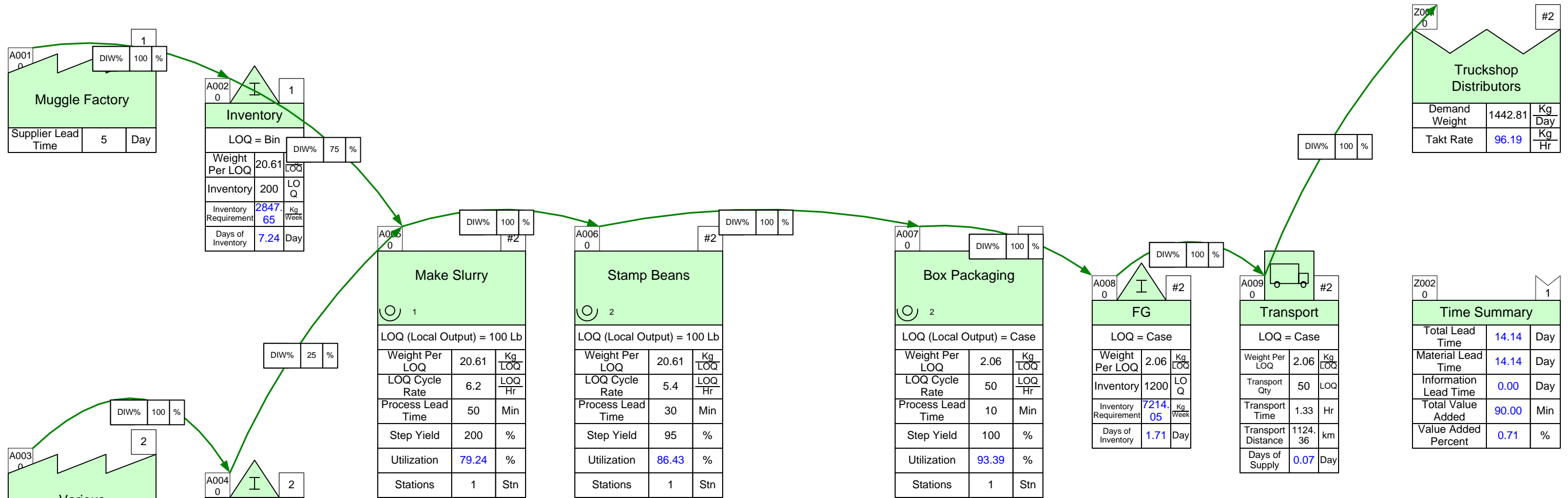


Processing Problem: Setup Time

At the beginning of each production day, each process step undergoes a certain amount of Setup Time (consisting of cleaning, sanitization, preventive maintenance, etc.). The setup times are as follows: Make Slurry = 1 hour, Stamp Beans = 30 min., Box Packaging = 30 min. How does this affect Capacity?

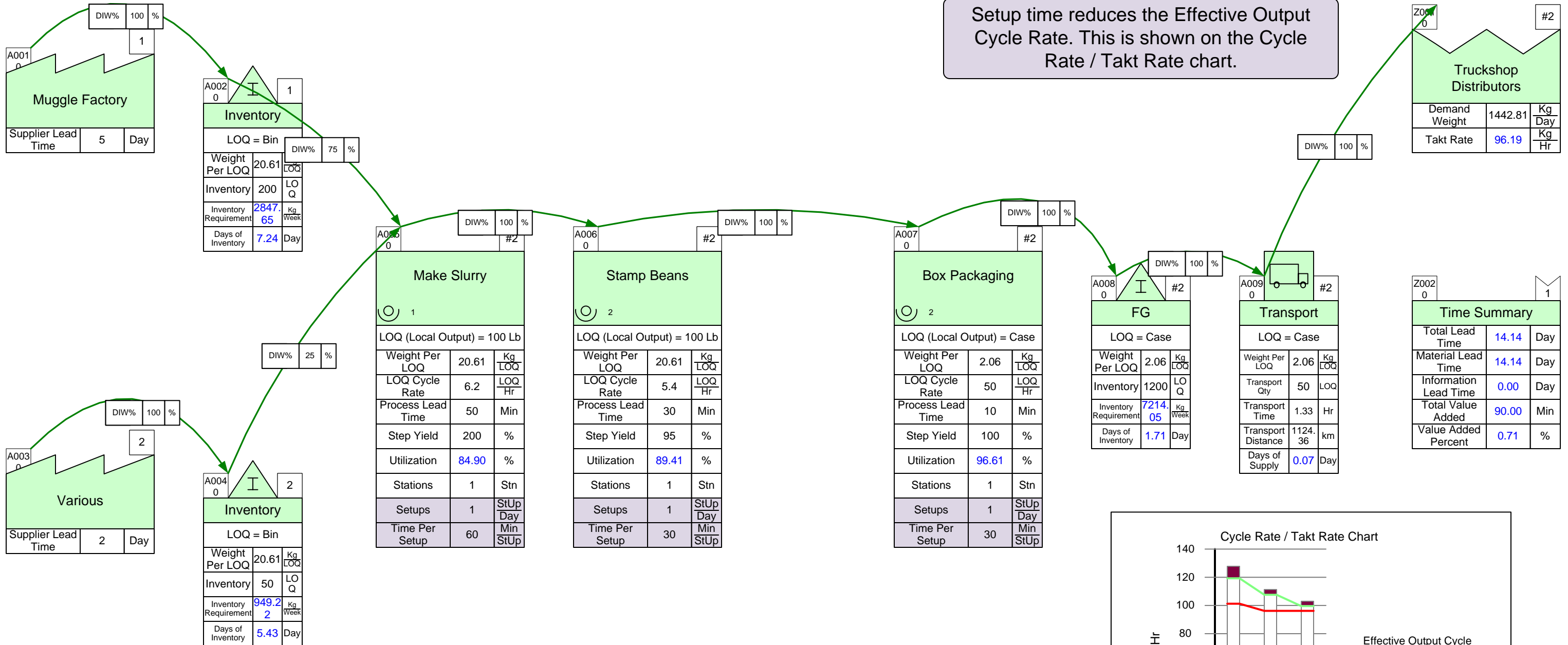
Units	Week	day
	5	15
	day	Hr



Processing Solution: Setup Time

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	5	15
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Answer

Setup time reduces the Effective Output Cycle Rate. This is shown on the Cycle Rate / Takt Rate chart.

$$\text{Setup Rate Loss} = (\text{Setup Time} / \text{Available Time}) * \text{Cycle Rate}$$

