Standard Work Combination Table

From:		Date:		Required Units per Shift:	
To:		Area:		Takt Time:	

———	Manual Work
- - - - - - - - - -	Machine Time
∿∿∿	Walking
⟺	Wait Time

#	Work Element	Manual	Auto	Walk
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				
22				
23				
24				
25				
26				
27				
28				
TOTAL				

Seconds

5 10 15 20 25 30 35 40 45 50 55 60 65 70 75 80 85 90 95

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Seconds

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