19 Operators

H61L/X61 B ROW 2 (60/40) 27JPH Analysis (Projected)

Legend: ■ minimum □ maximum ✕ average — Takt Time

Stations	60 CUSHION START	60 CUSHION FINISH	40 CUSHION START	40 CUSHION CLOSE	40 BACK START	40 BACK CLOSE	60 BACK START	60 BACK FINISH	BACK FRAME PREP	RISER PREP/LINE LOAD	CUSHION MARRIAGE	BACK MARRIAGE	STEAM AND FINESSE	PLASTIC INSTALL	STEAM AND FINESSE	ARMREST/HEADREST INSTALL	STEAM AND FINESSE	INSPECTION/OFFLOAD	ARMREST/HEADREST BUILD	0	0	Sum
minimum	96	96	118	118	69	69	92	92	45	42	53	46	20	54	20	30	20	38	64			1179
average	100	100	122	122	76	76	98	98	52	44	58	54	24	60	24	39	24	45	66			1282
maximum	107	107	127	127	85	85	102	102	63	46	62	61	28	65	28	51	28	53	68			1394
Takt Time	133	133	133	133	133	133	133	133	67	67	67	67	67	67	67	67	67	67	67			

17.5946786
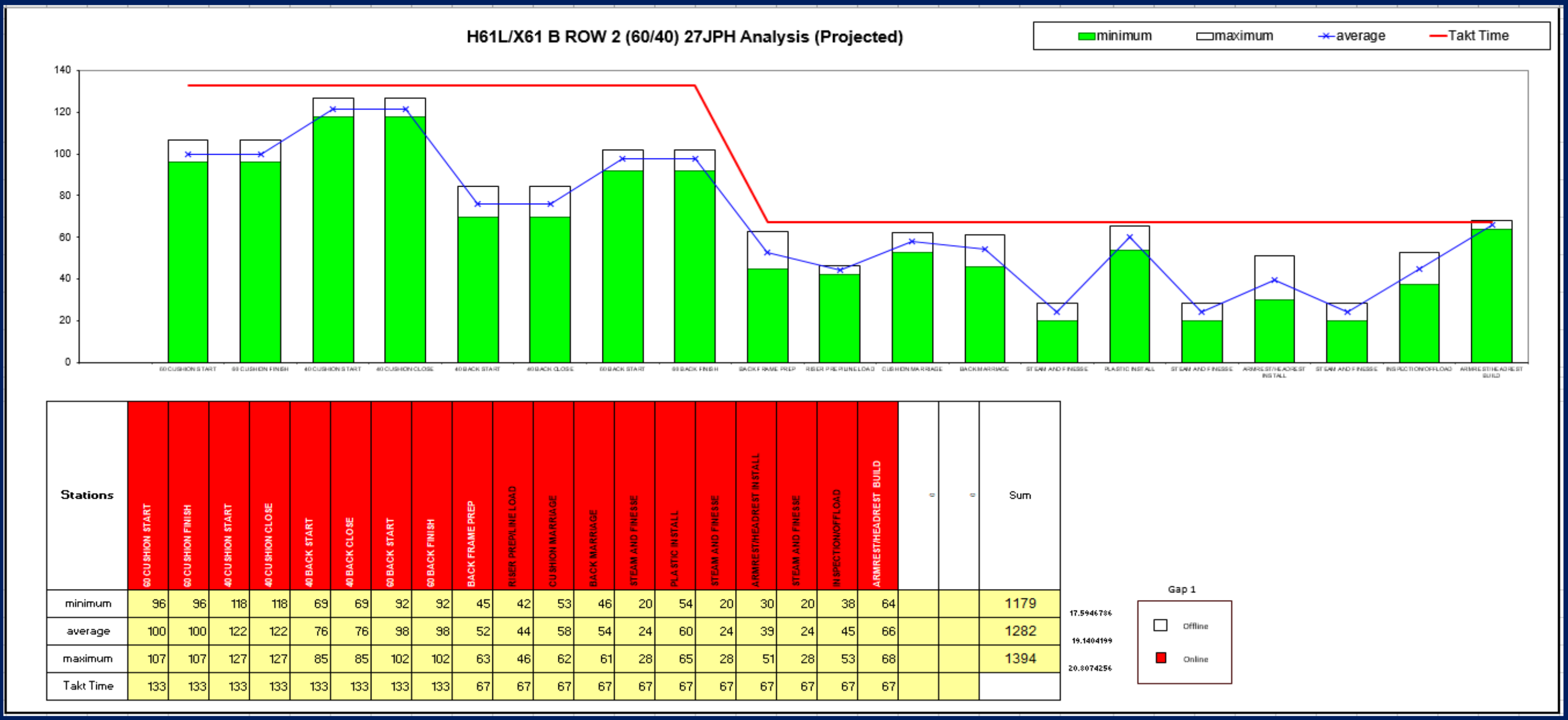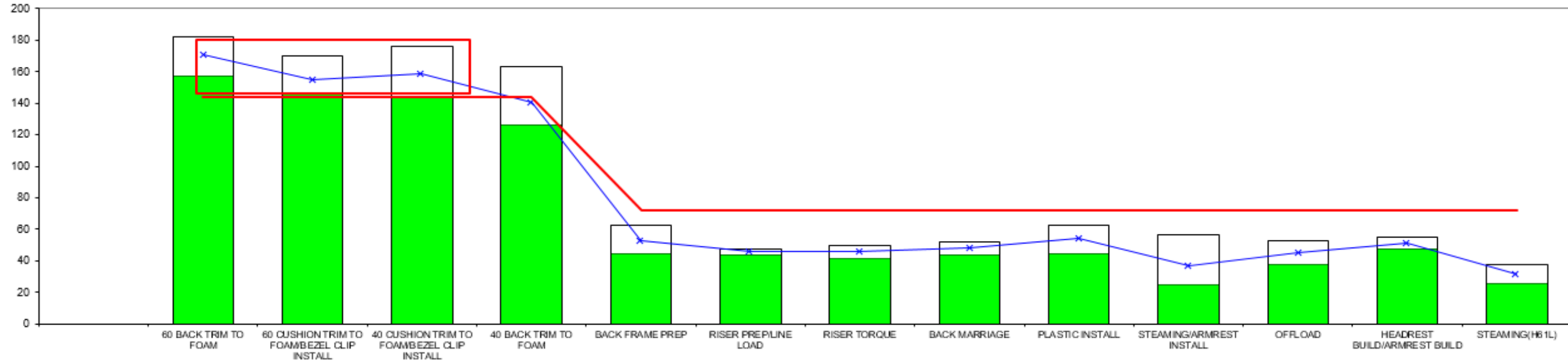19.1404199
20.8074256

Gap 1

□ Offline
■ Online

13 Operators

H61L/X61 B ROW 2 (60/40) 25 JPH Analysis

Legend: ■ minimum ☐ maximum ✳ average — Takt Time

Stations	60 BACK TRIM TO FOAM	60 CUSHION TRIM TO FOAM/BEZEL CLIP INSTALL	40 CUSHION TRIM TO FOAM/BEZEL CLIP INSTALL	40 BACK TRIM TO FOAM	BACK FRAME PREP	RISER PREP/LINE LOAD	RISER TORQUE	BACK MARRIAGE	PLASTIC INSTALL	STEAMING/ARMREST INSTALL	OFFLOAD	HEADREST BUILD/ARMREST BUILD	STEAMING(H61L)								Sum
minimum	157	147	144	126	45	44	42	44	45	25	38	48	26								525
average	171	155	158	140	52	46	46	48	54	37	45	51	32								1035
maximum	183	170	176	163	63	48	50	52	63	57	53	55	38								1153
Takt Time	144	144	144	144	72	72	72	72	72	72	72	72	72								

12.9018713
14.3868414
16.2338

Gap 1

☐ Offline
■ Online