

6-1-21

Cycle Times								
Lam#	4 Variant	Loading	Shuttle Cycle	Waiting/Idle	Machine (Laminate)	Remove/Load Part	M2W	Total
Cycle 1	BLTZK	12	14	20	52	5	10	113
Cycle 2	BLTZK	16	25	28	52	7	9	137
Cycle 3	BLTZK	14	14	28	54	10	10	131
Cycle 4	BLTZK	14	18	28	52	8	18	138
Cycle 5	BLTZK	20	14	24	52	5	9	125
Cycle 6	BLTZK	14	21	29	52	4	11	131
Cycle 7	BLTZK	18	15	26	60	4	8	132
Cycle 8	BLTZK	17	17	24	53	5	9	125
Cycle 9	BLTZK	15	16	29	52	5	8	124
Cycle 10	BLTZK	16	16	28	52	5	15	132

6-1-21

Cycle Times								
Lam#	5							
	Variant	Loading	Shuttle Cycle	Waiting/Idle	Machine (Laminate)	Remove/Load Part	M2W	Total
Cycle 1	BEIGE	13	13	12	56	22	11	119
Cycle 2	BEIGE	13	16	15	61	5	27	140
Cycle 3	BEIGE	9	17	12	56	8	35	138
Cycle 4	BEIGE	16	17	7	58	9	42	148
Cycle 5	BEIGE	15	18	10	60	11	33	147
Cycle 6	BEIGE	13	17	8	57	7	28	130
Cycle 7	BEIGE	20	14	7	57	7	26	130
Cycle 8	BEIGE	14	26	12	60	15	50	177
Cycle 9	BEIGE	13	7	19	60	10	42	151
Cycle 10	BEIGE	15	19	6	64	10	47	162

* FINISH

* VARIABILITY

6-1-21

Cycle Times								
Lam#	6 Variant	Loading	Shuttle Cycle	Waiting/Idle	Machine (Laminate)	Remove/Load Part	M2W	Total
Cycle 1	BLTK	23	22	8	62	9	31	155
Cycle 2	BLTK	10	12	14	53	5	34	128
Cycle 3	BLTK	18	24	10	57	9	38	156
Cycle 4	BLTK	20	26	8	53	8	34	150
Cycle 5	BLTK	19	20	8	61	7	38	153
Cycle 6	BLTK	17	19	7	52	8	32	136
Cycle 7	BLTK	15	30	6	51	8	25	184
Cycle 8	BLTK	21	19	9	50	8	28	135
Cycle 9	BLTK	17	15	6	59	13	22	132
Cycle 10	BLTK	17	16	8	64	9	30	144

* Variability