WORK CENTER	A					B					C					D					E				
%C&A	100%					100%					100%					100%					100%				
TURN	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
ROLL	5	3	6	1	2	3	6	2	6	4	5	6	6	5	5	2	3	2	1	6	3	6	1	5	5
MOVED	5	3	6	1	2	3	5	2	5	2	3	5	2	5	2	2	3	2	1	6	2	3	1	2	5
WIP	0	0	0	0	0	2	0	4	0	0	0	0	0	0	0	1	3	0	8	4	0	0	1	0	1
DEVIATION	+1.5	+1.0	+3.5	+1.0	-0.5	-0.5	+1.0	-0.5	+1.0	-0.5	-0.5	+1.0	-0.5	+1.0	-0.5	-1.5	-2.0	-3.5	-6.0	-3.5	-1.5	-2.0	-4.5	-6.0	-4.5

Moved. This will be the **minimum** of the roll and the sum of the moved items from the previous work center for the current turn and the WIP for the current workstation for the previous turn. For example: Suppose work center 'B' rolls a 5, the items moved from work center 'A' were 2, and work center 'B's WIP is 1. Then work center 'B' may only move 3 items: the two they just received and the 1 they already had.

WIP. This is the amount of WIP left over after a move. For example, if a work center receives 3 items from it's predecessor, but rolls a 2, the remaining 1 item becomes WIP. WIP is cumulative over time.

Deviation. Calculate the deviation for each turn by subtracting 3.5 from each die roll to get the current turn's deviation. Add that deviation to the prior turn's deviation to get the total cumulative deviation and place an 'X' in the appropriate row and column. All work centers begin with 0 deviation at the start. For example: Suppose work center 'A's first roll is a 4. Its total deviation for its first turn would be (4 - 3.5) + 0 = +0.5. If it next rolls a 1, then the total deviation for its second turn would (1 - 3.5) + 0.5 = -2.0.

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+5.0																									
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