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| **Filling & Processing** |
| C/T - 5 mins |
| No.of Operator- 1/shift |
| Working time- Continuous |
| L/T- 5-10 mins |

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| **Delivery of Material/ Inventory** |
| C/T – Twice a Week |
| C/O – 30 mins |
| No. of operators :1 |
| 4% Scrap |
| L/T- 5-10 mins |

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| **Manufacturing** |
| C/T cycle time (4 min) |
| C/O changeover time (2 hrs) |
| Number of operators (10 per shift) |
| Working time (7 hrs) |
| Scrap rate |
| L/T- 5-10 mins |

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| **Packaging** |
| C/T cycle time (45 sec) |
| Working time (continuous) |
| Number of operators (3 per shift) |
| VCT (45 sec) |
| Scrap rate |
| L/T- 5-10 mins |

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| **Delivery** |
| C/T- 5-25 hours |
| Shift- Multiple |
| No. of operators: 3-4 (per shift) |
| Working Time: (Continuous) |

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| **Warehouse** |
| C/T – 25-30 mins |
| C/O – 20 mins |
| Uptime: 100% |
| 2 Shifts |
| 2 Operators |
| L/T- 5-10 mins |