Tecnomatix Plant Simulation 16 Statistics

Created on	lunes, 16 de agosto de 2021 9:17 p. m.
Model name	E:\Documentos\Documentos\Michael_Rodriguez\Universidad_Nacional\Doceaba_matricula\Automatizacion\Proyecto\Proyecto_APM\SimulacionProceso\Simulación Ruta completa automatizada.spp
Simulation time	8:00:00.0000

Resource Statistics - Resource Statistics

Object	Working	Set-up	Waiting	Blocked	Powering up/down	Failed	Stopped	Paused	Unplanned	Portion
St1_Corte	17.03%	12.77%	59.43%	6.40%	0.00%	4.37%	0.00%	0.00%	0.00%	
St4a_Roscado	12.40%	0.52%	87.09%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4b_BocaDePescado	12.21%	6.10%	71.39%	10.30%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4c_Perforado	50.62%	14.06%	35.31%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St2_Doblado	38.25%	10.62%	45.25%	0.00%	0.00%	5.88%	0.00%	0.00%	0.00%	
St3_Conformado	8.50%	21.25%	70.25%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St8_Secado	22.19%	0.01%	26.39%	46.72%	0.00%	4.69%	0.00%	0.00%	0.00%	
St9_Pintura	84.38%	0.25%	9.42%	5.95%	0.00%	0.00%	0.00%	0.00%	0.00%	
St18_CentradoRuedas	48.12%	0.04%	51.83%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St22_LimpiezaDesengrase	9.44%	0.01%	90.55%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St5_Soldado	25.00%	0.00%	75.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St11_InsercionCubetas	6.25%	3.16%	61.37%	29.22%	0.00%	0.00%	0.00%	0.00%	0.00%	
St14_CBA	18.54%	1.88%	26.49%	53.09%	0.00%	0.00%	0.00%	0.00%	0.00%	
St15_Horquilla	84.10%	4.53%	11.37%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St16_SFPF	17.92%	10.27%	71.81%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St20_ColRuedaTrasYCadena	68.51%	2.99%	28.50%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St19_EngomadoColPiñon	86.34%	1.53%	1.44%	10.69%	0.00%	0.00%	0.00%	0.00%	0.00%	
St12_ArmadoCajaPedalera	31.25%	11.38%	28.12%	29.25%	0.00%	0.00%	0.00%	0.00%	0.00%	
St17_ArmRuedasRayos	32.50%	45.50%	22.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St21_ColRuedaDelanteraAj	33.94%	2.99%	63.07%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St10_Curado	22.19%	0.01%	69.39%	0.00%	0.00%	8.41%	0.00%	0.00%	0.00%	
St7_PretSuperficial	64.69%	0.01%	18.23%	17.07%	0.00%	0.00%	0.00%	0.00%	0.00%	

Portions of the States

Object	Number of Entries	Number of Exits	Minimum Contents	Maximum Contents	Relative Empty	Relative Full	Relative Occupation without Interruptions	Relative Occupation with Interruptions
St1_Corte	1226	1225	0	1	62.15%	-	37.85%	37.49%
St4a_Roscado	102	102	0	1	87.09%	-	12.91%	12.91%
St4b_BocaDePescado	879	878	0	1	71.39%	-	28.61%	28.61%
St4c_Perforado	405	405	0	1	35.31%	-	64.69%	64.69%
St2_Doblado	612	612	0	1	48.07%	-	51.93%	50.16%
St3_Conformado	612	612	0	1	70.25%	-	29.75%	29.75%
St8_Secado	90	90	0	1	27.69%	-	72.31%	72.79%
St9_Pintura	90	90	0	1	9.42%	-	90.58%	90.58%
St18_CentradoRuedas	90	90	0	1	51.83%	-	48.17%	48.17%
St22_LimpiezaDesengrase	85	85	0	1	90.55%	-	9.45%	9.45%
St5_Soldado	90	90	0	1	17.11%	-	82.89%	82.89%
St11_InsercionCubetas	90	90	0	1	63.19%	-	36.81%	36.81%
St14_CBA	89	88	0	1	26.86%	-	73.14%	73.14%
St15_Horquilla	87	86	0	1	11.53%	-	88.47%	88.47%
St16_SFPF	86	86	0	1	81.97%	-	18.03%	18.03%
St20_ColRuedaTrasYCadena	86	85	0	1	31.45%	-	68.55%	68.55%
St19_EngomadoColPiñon	88	87	0	1	1.44%	-	98.56%	98.56%
St12_ArmadoCajaPedalera	90	90	0	1	31.81%	-	68.19%	68.19%
St17_ArmRuedasRayos	90	90	0	1	22.50%	-	77.50%	77.50%
St21_ColRuedaDelanteraAj	85	85	0	1	66.02%	-	33.98%	33.98%
St10_Curado	90	90	0	1	75.77%	-	24.23%	22.19%
St7_PretSuperficial	90	90	0	1	18.23%	-	81.77%	81.77%

Material Flow Properties

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	17.03%	1226	1:21:44.0000	4.0000	0.0000
St4a_Roscado	12.40%	102	59:30.0000	35.0000	0.0000
St4b_BocaDePescado	12.21%	879	58:36.0000	4.0000	0.0000
St4c_Perforado	50.62%	405	4:03:00.0000	36.0000	0.0000
St2_Doblado	38.25%	612	3:03:36.0000	18.0000	0.0000
St3_Conformado	8.50%	612	40:48.0000	4.0000	0.0000
St8_Secado	22.19%	90	1:46:30.0000	1:11.0000	0.0000
St9_Pintura	84.38%	90	6:45:00.0000	4:30.0000	0.0000
St18_CentradoRuedas	48.12%	90	3:51:00.0000	2:34.0000	0.0000
St22_LimpiezaDesengrase	9.44%	85	45:20.0000	32.0000	0.0000
St5_Soldado	25.00%	90	2:00:00.0000	1:20.0000	0.0000
St11_InsercionCubetas	6.25%	90	30:00.0000	20.0000	0.0000
St14_CBA	18.54%	89	1:29:00.0000	1:00.0000	0.0000
St15_Horquilla	84.10%	87	6:43:40.1748	4:38.3928	5.6635
St16_SFPF	17.92%	86	1:26:00.0000	1:00.0000	0.0000
St20_ColRuedaTrasYCadena	68.51%	86	5:28:51.1748	3:49.4323	5.2650
St19_EngomadoColPiñon	86.34%	88	6:54:26.1748	4:42.5702	4.0322
St12_ArmadoCajaPedalera	31.25%	90	2:30:00.0000	1:40.0000	0.0000
St17_ArmRuedasRayos	32.50%	90	2:36:00.0000	1:44.0000	0.0000
St21_ColRuedaDelanteraAj	33.94%	85	2:42:55.0000	1:55.0000	0.0000
St10_Curado	22.19%	90	1:46:30.0000	1:11.0000	0.0000
St7_PretSuperficial	64.69%	90	5:10:30.0000	3:27.0000	0.0000

Working Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	12.77%	1226	1:01:18.0000	3.0000	0.0000
St4a_Roscado	0.52%	1	2:29.0000	2:29.0000	0.0000
St4b_BocaDePescado	6.10%	879	29:18.0000	2.0000	0.0000
St4c_Perforado	14.06%	405	1:07:30.0000	10.0000	0.0000
St2_Doblado	10.62%	612	51:00.0000	5.0000	0.0000
St3_Conformado	21.25%	612	1:42:00.0000	10.0000	0.0000
St8_Secado	0.01%	1	2.0000	2.0000	0.0000
St9_Pintura	0.25%	1	1:12.0000	1:12.0000	0.0000
St18_CentradoRuedas	0.04%	1	12.0000	12.0000	0.0000
St22_LimpiezaDesengrase	0.01%	1	2.0000	2.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	3.16%	91	15:10.0000	10.0000	0.0000
St14_CBA	1.88%	90	9:00.0000	6.0000	0.0000
St15_Horquilla	4.53%	87	21:45.0000	15.0000	0.0000
St16_SFPF	10.27%	87	49:18.0000	34.0000	0.0000
St20_ColRuedaTrasYCadena	2.99%	86	14:20.0000	10.0000	0.0000
St19_EngomadoColPiñon	1.53%	88	7:20.0000	5.0000	0.0000
St12_ArmadoCajaPedalera	11.38%	91	54:36.0000	36.0000	0.0000
St17_ArmRuedasRayos	45.50%	91	3:38:24.0000	2:24.0000	0.0000
St21_ColRuedaDelanteraAj	2.99%	86	14:20.0000	10.0000	0.0000
St10_Curado	0.01%	1	2.0000	2.0000	0.0000
St7_PretSuperficial	0.01%	1	3.0000	3.0000	0.0000

Set-up Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	59.43%	1143	4:45:16.7797	14.9753	0.4989
St4a_Roscado	87.09%	103	6:58:01.0000	4:03.5049	3:10.3250
St4b_BocaDePescado	71.39%	775	5:42:40.0000	26.5290	43.2949
St4c_Perforado	35.31%	183	2:49:30.0000	55.5738	2:28.9230
St2_Doblado	45.25%	163	3:37:10.8723	1:19.9440	2:37.1850
St3_Conformado	70.25%	613	5:37:12.0000	33.0049	1:43.4286
St8_Secado	26.39%	26	2:06:41.3768	4:52.3606	8:13.0291
St9_Pintura	9.42%	4	45:13.7868	11:18.4467	13:24.9927
St18_CentradoRuedas	51.83%	91	4:08:48.0000	2:44.0440	10:53.3267
St22_LimpiezaDesengrase	90.55%	86	7:14:38.0000	5:03.2326	4:38.5659
St5_Soldado	75.00%	91	6:00:00.0000	3:57.3626	8:34.3208
St11_InsercionCubetas	61.37%	65	4:54:35.0000	4:31.9231	5:16.9943
St14_CBA	26.49%	23	2:07:09.8252	5:31.7315	8:23.9819
St15_Horquilla	11.37%	4	54:34.8252	13:38.7063	15:11.7189
St16_SFPF	71.81%	87	5:44:42.0000	3:57.7241	4:08.4626
St20_ColRuedaTrasYCadena	28.50%	86	2:16:48.8252	1:35.4515	4:26.1619
St19_EngomadoColPiñon	1.44%	1	6:54.0000	6:54.0000	0.0000
St12_ArmadoCajaPedalera	28.12%	37	2:14:59.0000	3:38.8919	6:43.3796
St17_ArmRuedasRayos	22.00%	1	1:45:36.0000	1:45:36.0000	0.0000
St21_ColRuedaDelanteraAj	63.07%	86	5:02:45.0000	3:31.2209	4:35.4474
St10_Curado	69.39%	89	5:33:05.6087	3:44.5574	3:07.1599
St7_PretSuperficial	18.23%	20	1:27:31.3850	4:22.5693	12:13.2205

Waiting Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	6.40%	1	30:43.0000	30:43.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	10.30%	1	49:26.0000	49:26.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	46.72%	62	3:44:15.8017	3:37.0291	3:02.7633
St9_Pintura	5.95%	1	28:34.2132	28:34.2132	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	29.22%	37	2:20:15.0000	3:47.4324	1:10.7702
St14_CBA	53.09%	71	4:14:50.1748	3:35.3546	46.1900
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	10.69%	85	51:19.8252	36.2332	3:32.0279
St12_ArmadoCajaPedalera	29.25%	57	2:20:25.0000	2:27.8070	32.3013
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	17.07%	50	1:21:55.6150	1:38.3123	3:05.7238

Blocked Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.00%	0	0.0000	0.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	0.00%	0	0.0000	0.0000	0.0000
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.00%	0	0.0000	0.0000	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Powering up/down Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.00%	0	0.0000	0.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	0.00%	0	0.0000	0.0000	0.0000
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.00%	0	0.0000	0.0000	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Stopped Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	4.37%	2	20:58.2203	10:29.1102	6:04.0526
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	5.88%	2	28:13.1277	14:06.5638	11:14.9882
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	4.69%	4	22:30.8215	5:37.7054	1:17.3345
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.00%	0	0.0000	0.0000	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	8.41%	1	40:22.3913	40:22.3913	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Failed Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.00%	0	0.0000	0.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	0.00%	0	0.0000	0.0000	0.0000
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.00%	0	0.0000	0.0000	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Paused Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	59.43%	1143	4:45:16.7797	14.9753	0.4989
St4a_Roscado	87.09%	103	6:58:01.0000	4:03.5049	3:10.3250
St4b_BocaDePescado	71.39%	775	5:42:40.0000	26.5290	43.2949
St4c_Perforado	35.31%	183	2:49:30.0000	55.5738	2:28.9230
St2_Doblado	45.25%	163	3:37:10.8723	1:19.9440	2:37.1850
St3_Conformado	70.25%	613	5:37:12.0000	33.0049	1:43.4286
St8_Secado	26.39%	26	2:06:41.3768	4:52.3606	8:13.0291
St9_Pintura	9.42%	4	45:13.7868	11:18.4467	13:24.9927
St18_CentradoRuedas	51.83%	91	4:08:48.0000	2:44.0440	10:53.3267
St22_LimpiezaDesengrase	90.55%	86	7:14:38.0000	5:03.2326	4:38.5659
St5_Soldado	17.11%	1	1:22:09.0000	1:22:09.0000	0.0000
St11_InsercionCubetas	63.19%	65	5:03:18.0000	4:39.9692	5:17.1428
St14_CBA	26.86%	23	2:08:54.8252	5:36.2967	8:22.7211
St15_Horquilla	11.53%	4	55:19.8252	13:49.9563	15:08.9580
St16_SFPF	81.97%	87	6:33:26.0000	4:31.3333	4:06.2787
St20_ColRuedaTrasYCadena	31.45%	86	2:30:58.8252	1:45.3352	4:25.4472
St19_EngomadoColPiñon	1.44%	1	6:54.0000	6:54.0000	0.0000
St12_ArmadoCajaPedalera	31.81%	38	2:32:40.0000	4:01.0526	6:39.6732
St17_ArmRuedasRayos	22.50%	1	1:48:00.0000	1:48:00.0000	0.0000
St21_ColRuedaDelanteraAj	66.02%	86	5:16:55.0000	3:41.1047	4:34.7037
St10_Curado	69.39%	89	5:33:05.6087	3:44.5574	3:07.1599
St7_PretSuperficial	18.23%	20	1:27:31.3850	4:22.5693	12:13.2205

Empty Time

Service Statistics - Importer Statistics

Object	Total Delay	Reason for the Delay		
		Waiting for Services and Parts	Waiting for Parts	Waiting for Set-up Exporters
St1_Corte	0.00%	0.00%	0.00%	0.00%
St4a_Roscado	0.00%	0.00%	0.00%	0.00%
St4b_BocaDePescado	0.00%	0.00%	0.00%	0.00%
St4c_Perforado	0.00%	0.00%	0.00%	0.00%
St2_Doblado	0.00%	0.00%	0.00%	0.00%
St3_Conformado	0.00%	0.00%	0.00%	0.00%
St8_Secado	0.00%	0.00%	0.00%	0.00%
St9_Pintura	0.00%	0.00%	0.00%	0.00%
St18_CentradoRuedas	0.00%	0.00%	0.00%	0.00%
St22_LimpiezaDesengrase	0.00%	0.00%	0.00%	0.00%
St5_Soldado	75.00%	75.00%	57.89%	0.00%
St11_InsercionCubetas	86.79%	86.79%	0.00%	0.00%
St14_CBA	75.20%	75.20%	0.00%	0.00%
St15_Horquilla	6.76%	6.76%	0.00%	0.00%
St16_SFPF	66.18%	66.18%	0.00%	0.00%
St20_ColRuedaTrasYCadena	22.55%	22.55%	0.00%	0.00%
St19_EngomadoColPiñon	10.69%	10.69%	0.00%	0.00%
St12_ArmadoCajaPedalera	53.47%	53.47%	0.00%	0.00%
St17_ArmRuedasRayos	22.00%	22.00%	0.00%	0.00%
St21_ColRuedaDelanteraAj	56.28%	56.28%	0.00%	0.00%
St10_Curado	0.00%	0.00%	0.00%	0.00%
St7_PretSuperficial	0.00%	0.00%	0.00%	0.00%

Importers Waiting for Services and Parts

Object	Waiting for Services and Parts	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.00%	0	0.0000	0.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	0.00%	0	0.0000	0.0000	0.0000
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	75.00%	91	6:00:00.0000	3:57.3626	8:34.3208
St11_InsercionCubetas	86.79%	90	6:56:35.0000	4:37.7222	4:15.7190
St14_CBA	75.20%	89	6:00:59.0000	4:03.3596	3:59.6010
St15_Horquilla	6.76%	3	32:27.8252	10:49.2751	17:16.6317
St16_SFPF	66.18%	86	5:17:41.0000	3:41.6395	3:19.2159
St20_ColRuedaTrasYCadena	22.55%	85	1:48:13.8252	1:16.3979	3:20.2316
St19_EngomadoColPiñon	10.69%	85	51:19.8252	36.2332	3:32.0279
St12_ArmadoCajaPedalera	53.47%	86	4:16:39.0000	2:59.0581	4:03.0453
St17_ArmRuedasRayos	22.00%	1	1:45:36.0000	1:45:36.0000	0.0000
St21_ColRuedaDelanteraAj	56.28%	85	4:30:10.0000	3:10.7059	3:20.3723
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Waiting Times for Services and Parts

Object	Waiting for Parts	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.00%	0	0.0000	0.0000	0.0000
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	0.00%	0	0.0000	0.0000	0.0000
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	57.89%	90	4:37:51.0000	3:05.2333	2:12.0238
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.00%	0	0.0000	0.0000	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000

Waiting Times for Parts

Object	Waiting for Set-up Exporters	Count	Sum	Mean Value	Standard Deviation	Waiting Time while the Resource Waited	Waiting Time while the Resource Worked	Waiting Time while the Resource was Blocked
St1_Corte	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St4a_Roscado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St4b_BocaDePescado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St4c_Perforado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St2_Doblado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St3_Conformado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St8_Secado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St18_CentradoRuedas	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St14_CBA	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St16_SFPF	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St19_EngomadoColPiñon	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St21_ColRuedaDelanteraAj	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St10_Curado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%

Waiting Times for Set-up Exporters