

Tecnomatix Plant Simulation 16 Statistics

Created on	martes, 11 de mayo de 2021 3:27 a. m.
Model name	C:\Users\leo7s\Documents\Universidad\01 APM\02 Proyecto Final\Proyecto_APM\SimulacionProceso\Simulación completa sin automatizar.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	16.88%	57.38%	20.52%	0.86%	0.00%	4.37%	0.00%	0.00%	0.00%	
St4a_Roscado	9.84%	0.52%	89.64%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4b_BocaDePescado	10.12%	42.74%	47.14%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4c_Perforado	40.50%	11.25%	48.25%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St2_Doblado	69.75%	11.25%	13.12%	0.00%	0.00%	5.88%	0.00%	0.00%	0.00%	
St3_Conformado	6.75%	16.88%	76.38%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St6_Estampado	1.12%	0.05%	98.83%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St8_Secado	19.97%	0.01%	75.33%	0.00%	0.00%	4.69%	0.00%	0.00%	0.00%	
St9_Pintura	75.94%	0.25%	23.81%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St18_CentradoRuedas	43.31%	0.04%	56.65%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St22_LimpiezaDesengrase	9.00%	0.01%	90.99%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St5_Soldado	33.75%	49.54%	16.71%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St11_InsercionCubetas	5.62%	2.85%	91.53%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St13_ColCubreCadena	22.50%	1.99%	75.51%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St14_CBA	16.88%	1.71%	81.20%	0.22%	0.00%	0.00%	0.00%	0.00%	0.00%	
St15_Horquilla	78.47%	4.27%	17.26%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St16_SFP	79.03%	4.27%	16.70%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St20_ColRuedaTrasYCadena	64.69%	2.85%	32.47%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St19_EngomadoColPiñon	79.59%	1.42%	8.43%	10.55%	0.00%	0.00%	0.00%	0.00%	0.00%	
St12_ArmadoCajaPedalera	28.12%	10.25%	61.62%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St17_ArmRuedasRayos	29.25%	41.00%	29.75%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St21_ColRuedaDelantera	19.12%	1.14%	79.74%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St7_PretSuperficial	58.22%	0.85%	40.93%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St10_Curado	19.97%	0.57%	79.46%	0.00%	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	972	972	0	1	21.46%	-	78.54%	79.48%
St4a_Roscado	81	81	0	1	89.64%	-	10.36%	10.36%
St4b_BocaDePescado	729	729	0	1	47.14%	-	52.86%	52.86%
St4c_Perforado	324	324	0	1	48.25%	-	51.75%	51.75%
St2_Doblado	648	648	0	1	13.94%	-	86.06%	86.88%
St3_Conformado	486	486	0	1	76.38%	-	23.63%	23.63%
St6_Estampado	81	81	0	1	98.83%	-	1.17%	1.17%
St8_Secado	81	81	0	1	79.04%	-	20.96%	21.28%
St9_Pintura	81	81	0	1	23.81%	-	76.19%	76.19%
St18_CentradoRuedas	81	81	0	1	56.65%	-	43.35%	43.35%
St22_LimpiezaDesengrase	81	81	0	1	90.99%	-	9.01%	9.01%
St5_Soldado	81	81	0	1	12.10%	-	87.90%	87.90%
St11_InsercionCubetas	81	81	0	1	94.34%	-	5.66%	5.66%
St13_ColCubreCadena	81	81	0	1	77.48%	-	22.52%	22.52%
St14_CBA	81	81	0	1	82.31%	-	17.69%	17.69%
St15_Horquilla	81	81	0	1	17.62%	-	82.38%	82.38%
St16_SFP	81	81	0	1	17.55%	-	82.45%	82.45%
St20_ColRuedaTrasYCadena	81	81	0	1	35.28%	-	64.72%	64.72%
St19_EngomadoColPiñon	81	81	0	1	8.43%	-	91.57%	91.57%
St12_ArmadoCajaPedalera	81	81	0	1	71.75%	-	28.25%	28.25%
St17_ArmRuedasRayos	81	81	0	1	30.25%	-	69.75%	69.75%
St21_ColRuedaDelantera	81	81	0	1	80.86%	-	19.14%	19.14%
St7_PretSuperficial	81	81	0	1	41.77%	-	58.23%	58.23%
St10_Curado	81	162	0	2	80.02%	-	19.98%	19.98%

Material Flow Properties

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	16.88%	972	1:21:00.0000	5.0000	0.0000
St4a_Roscado	9.84%	81	47:15.0000	35.0000	0.0000
St4b_BocaDePescado	10.12%	729	48:36.0000	4.0000	0.0000
St4c_Perforado	40.50%	324	3:14:24.0000	36.0000	0.0000
St2_Doblado	69.75%	648	5:34:48.0000	31.0000	0.0000
St3_Conformado	6.75%	486	32:24.0000	4.0000	0.0000
St6_Estampado	1.12%	81	5:24.0000	4.0000	0.0000
St8_Secado	19.97%	81	1:35:51.0000	1:11.0000	0.0000
St9_Pintura	75.94%	81	6:04:30.0000	4:30.0000	0.0000
St18_CentradoRuedas	43.31%	81	3:27:54.0000	2:34.0000	0.0000
St22_LimpiezaDesengrase	9.00%	81	43:12.0000	32.0000	0.0000
St5_Soldado	33.75%	81	2:42:00.0000	2:00.0000	0.0000
St11_InsercionCubetas	5.62%	81	27:00.0000	20.0000	0.0000
St13_ColCubreCadena	22.50%	81	1:48:00.0000	1:20.0000	0.0000
St14_CBA	16.88%	81	1:21:00.0000	1:00.0000	0.0000
St15_Horquilla	78.47%	81	6:16:39.0000	4:39.0000	0.0000
St16_SFP	79.03%	81	6:19:21.0000	4:41.0000	0.0000
St20_ColRuedaTrasYCADena	64.69%	81	5:10:30.0000	3:50.0000	0.0000
St19_EngomadoColPiñon	79.59%	81	6:22:03.0000	4:43.0000	0.0000
St12_ArmadoCajaPedalera	28.12%	81	2:15:00.0000	1:40.0000	0.0000
St17_ArmRuedasRayos	29.25%	81	2:20:24.0000	1:44.0000	0.0000
St21_ColRuedaDelantera	19.12%	81	1:31:48.0000	1:08.0000	0.0000
St7_PretSuperficial	58.22%	81	4:39:27.0000	3:27.0000	0.0000
St10_Curado	19.97%	81	1:35:51.0000	1:11.0000	0.0000

Working Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	57.38%	972	4:35:24.0000	17.0000	0.0000
St4a_Roscado	0.52%	1	2:29.0000	2:29.0000	0.0000
St4b_BocaDePescado	42.74%	724	3:25:08.0000	17.0000	0.0000
St4c_Perforado	11.25%	324	54:00.0000	10.0000	0.0000
St2_Doblado	11.25%	648	54:00.0000	5.0000	0.0000
St3_Conformado	16.88%	486	1:21:00.0000	10.0000	0.0000
St6_Estampado	0.05%	1	13.0000	13.0000	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	49.54%	82	3:57:48.0000	2:54.0000	0.0000
St11_InsercionCubetas	2.85%	82	13:40.0000	10.0000	0.0000
St13_ColCubreCadena	1.99%	82	9:34.0000	7.0000	0.0000
St14_CBA	1.71%	82	8:12.0000	6.0000	0.0000
St15_Horquilla	4.27%	82	20:30.0000	15.0000	0.0000
St16_SFP	4.27%	82	20:30.0000	15.0000	0.0000
St20_ColRuedaTrasYCADena	2.85%	82	13:40.0000	10.0000	0.0000
St19_EngomadoColPiñon	1.42%	82	6:50.0000	5.0000	0.0000
St12_ArmadoCajaPedalera	10.25%	82	49:12.0000	36.0000	0.0000
St17_ArmRuedasRayos	41.00%	82	3:16:48.0000	2:24.0000	0.0000
St21_ColRuedaDelantera	1.14%	82	5:28.0000	4.0000	0.0000
St7_PretSuperficial	0.85%	82	4:06.0000	3.0000	0.0000
St10_Curado	0.57%	82	2:44.0000	2.0000	0.0000

Set-up Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	20.52%	1	1:38:30.8723	1:38:30.8723	0.0000
St4a_Roscado	89.64%	82	7:10:16.0000	5:14.8293	10:40.7247
St4b_BocaDePescado	47.14%	579	3:46:16.0000	23.4473	2:34.7921
St4c_Perforado	48.25%	91	3:51:36.0000	2:32.7033	10:15.6941
St2_Doblado	13.12%	3	1:02:58.8723	20:59.6241	35:35.0353
St3_Conformado	76.38%	487	6:06:36.0000	45.1663	2:59.8505
St6_Estampado	98.83%	1	7:54:23.0000	7:54:23.0000	0.0000
St8_Secado	75.33%	80	6:01:36.1785	4:31.2022	5:55.3126
St9_Pintura	23.81%	56	1:54:18.0000	2:02.4643	6:44.3968
St18_CentradoRuedas	56.65%	82	4:31:54.0000	3:18.9512	15:34.6548
St22_LimpiezaDesengrase	90.99%	82	7:16:46.0000	5:19.5854	4:32.5968
St5_Soldado	16.71%	4	1:20:12.0000	20:03.0000	24:00.4769
St11_InsercionCubetas	91.53%	82	7:19:20.0000	5:21.4634	5:10.1124
St13_ColCubreCadena	75.51%	82	6:02:26.0000	4:25.1951	5:07.2926
St14_CBA	81.20%	82	6:29:45.4481	4:45.1884	5:03.1257
St15_Horquilla	17.26%	6	1:22:51.0000	13:48.5000	11:59.5166
St16_SFP	16.70%	6	1:20:09.0000	13:21.5000	12:04.4029
St20_ColRuedaTrasYCadena	32.47%	82	2:35:50.0000	1:54.0244	4:38.4788
St19_EngomadoColPiñon	8.43%	2	40:27.3279	20:13.6640	18:50.8956
St12_ArmadoCajaPedalera	61.62%	82	4:55:48.0000	3:36.4390	5:12.9118
St17_ArmRuedasRayos	29.75%	1	2:22:48.0000	2:22:48.0000	0.0000
St21_ColRuedaDelantera	79.74%	82	6:22:44.0000	4:40.0488	4:32.7892
St7_PretSuperficial	40.93%	82	3:16:27.0000	2:23.7439	6:09.6480
St10_Curado	79.46%	82	6:21:25.0000	4:39.0854	5:15.9775

Waiting Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	0.86%	14	4:06.9073	17.6362	19.4595
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
St6_Estampado	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
St13_ColCubreCadena	0.00%	0	0.0000	0.0000	0.0000
St14_CBA	0.22%	27	1:02.5519	2.3167	0.0000
St15_Horquilla	0.00%	0	0.0000	0.0000	0.0000
St16_SFP	0.00%	0	0.0000	0.0000	0.0000
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	10.55%	79	50:39.6721	38.4769	2:21.5064
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000

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
St6_Estampado	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
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	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
St6_Estampado	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
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	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
St6_Estampado	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
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	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
St6_Estampado	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
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	0.00%	0	0.0000	0.0000	0.0000

Paused Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	20.52%	1	1:38:30.8723	1:38:30.8723	0.0000
St4a_Roscado	89.64%	82	7:10:16.0000	5:14.8293	10:40.7247
St4b_BocaDePescado	47.14%	579	3:46:16.0000	23.4473	2:34.7921
St4c_Perforado	48.25%	91	3:51:36.0000	2:32.7033	10:15.6941
St2_Doblado	13.12%	3	1:02:58.8723	20:59.6241	35:35.0353
St3_Conformado	76.38%	487	6:06:36.0000	45.1663	2:59.8505
St6_Estampado	98.83%	1	7:54:23.0000	7:54:23.0000	0.0000
St8_Secado	75.33%	80	6:01:36.1785	4:31.2022	5:55.3126
St9_Pintura	23.81%	56	1:54:18.0000	2:02.4643	6:44.3968
St18_CentradoRuedas	56.65%	82	4:31:54.0000	3:18.9512	15:34.6548
St22_LimpiezaDesengrase	90.99%	82	7:16:46.0000	5:19.5854	4:32.5968
St5_Soldado	12.10%	1	58:05.8723	58:05.8723	0.0000
St11_InsercionCubetas	94.34%	82	7:32:50.0000	5:31.3415	5:09.7664
St13_ColCubreCadena	77.48%	82	6:11:53.0000	4:32.1098	5:06.9852
St14_CBA	82.31%	82	6:35:06.4481	4:49.1030	5:03.0270
St15_Horquilla	17.62%	8	1:24:36.0000	10:34.5000	11:56.2957
St16_SFP	17.55%	29	1:24:15.0000	2:54.3103	7:30.7883
St20_ColRuedaTrasYCadena	35.28%	82	2:49:20.0000	2:03.9024	4:37.5973
St19_EngomadoColPiñon	8.43%	2	40:27.3279	20:13.6640	18:50.8956
St12_ArmadoCajaPedalera	71.75%	82	5:44:24.0000	4:12.0000	5:11.5013
St17_ArmRuedasRayos	30.25%	1	2:25:12.0000	2:25:12.0000	0.0000
St21_ColRuedaDelantera	80.86%	82	6:28:08.0000	4:44.0000	4:32.4157
St7_PretSuperficial	41.77%	82	3:20:30.0000	2:26.7073	6:09.6128
St10_Curado	80.02%	82	6:24:07.0000	4:41.0610	5:15.9117

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%
St6_Estampado	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	16.71%	16.71%	5.21%	0.00%
St11_InsercionCubetas	87.38%	87.38%	0.00%	0.00%
St13_ColCubreCadena	70.78%	70.78%	0.00%	0.00%
St14_CBA	76.39%	76.39%	0.00%	0.00%
St15_Horquilla	12.00%	12.00%	0.00%	0.00%
St16_SFP	10.42%	10.42%	0.00%	0.00%
St20_ColRuedaTrasYCadena	25.16%	25.16%	0.00%	0.00%
St19_EngomadoColPiñon	17.55%	17.55%	0.00%	0.00%
St12_ArmadoCajaPedalera	57.37%	57.37%	0.00%	0.00%
St17_ArmRuedasRayos	29.75%	29.75%	0.00%	0.00%
St21_ColRuedaDelantera	71.60%	71.60%	0.00%	0.00%
St7_PretSuperficial	39.20%	39.20%	0.00%	0.00%
St10_Curado	75.57%	75.57%	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
St6_Estampado	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	16.71%	4	1:20:12.0000	20:03.0000	24:00.4769
St11_InsercionCubetas	87.38%	81	6:59:25.0000	5:10.6790	4:56.1684
St13_ColCubreCadena	70.78%	81	5:39:45.0000	4:11.6667	4:43.5735
St14_CBA	76.39%	81	6:06:40.0000	4:31.6049	4:35.5143
St15_Horquilla	12.00%	5	57:37.0000	11:31.4000	11:51.4471
St16_SFP	10.42%	5	50:01.0000	10:00.2000	9:53.3269
St20_ColRuedaTrasYCadena	25.16%	81	2:00:46.0000	1:29.4568	2:48.5486
St19_EngomadoColPiñon	17.55%	79	1:24:13.0000	1:03.9620	4:24.1225
St12_ArmadoCajaPedalera	57.37%	81	4:35:23.0000	3:23.9877	4:53.7104
St17_ArmRuedasRayos	29.75%	1	2:22:48.0000	2:22:48.0000	0.0000
St21_ColRuedaDelantera	71.60%	81	5:43:40.0000	4:14.5679	2:26.4175
St7_PretSuperficial	39.20%	81	3:08:10.0000	2:19.3827	6:09.8223
St10_Curado	75.57%	81	6:02:43.0000	4:28.6790	5:03.4779

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
St6_Estampado	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	5.21%	3	25:00.1277	8:20.0426	6:24.1424
St11_InsercionCubetas	0.00%	0	0.0000	0.0000	0.0000
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	0.00%	0	0.0000	0.0000	0.0000
St10_Curado	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%
St6_Estampado	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%
St13_ColCubreCadena	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_SFP	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_ColRuedaDelantera	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%
St10_Curado	0.00%	0	0.0000	0.0000	0.0000	0.00%	0.00%	0.00%

Waiting Times for Set-up Exporters