

## Tecnomatix Plant Simulation 16 Statistics

Created on	martes, 17 de agosto de 2021 3:40 a. m.
Model name	C:\Users\leo7s\Documents\Universidad\01 APM\02 Proyecto Final\Proyecto_APM\SimulacionProceso\Simulación Playera 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	13.64%	9.10%	72.90%	0.00%	0.00%	4.37%	0.00%	0.00%	0.00%	
St4a_Roscado	13.25%	0.52%	86.24%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4b_BocaDePescado	13.61%	6.78%	79.61%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St4c_Perforado	54.53%	15.17%	30.30%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St2_Doblado	54.50%	15.14%	24.48%	0.00%	0.00%	5.88%	0.00%	0.00%	0.00%	
St3_Conformado	9.08%	18.17%	72.75%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St6_Estampado	8.46%	0.05%	0.00%	91.50%	0.00%	0.00%	0.00%	0.00%	0.00%	
St8_Secado	25.88%	0.01%	30.26%	39.16%	0.00%	4.69%	0.00%	0.00%	0.00%	
St9_Pintura	94.93%	0.25%	4.82%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St18_CentradoRuedas	41.45%	0.04%	19.39%	39.12%	0.00%	0.00%	0.00%	0.00%	0.00%	
St22_LimpiezaDesengrase	10.44%	0.01%	89.55%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
Producto_terminado	0.00%	0.00%	100.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St5_Soldado	30.00%	0.00%	70.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St11_InsercionCubetas	6.94%	3.51%	89.55%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St13_ColCubreCadena	27.78%	2.45%	69.77%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St14_CBA	20.83%	2.10%	77.06%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St15_Horquilla	34.03%	5.21%	55.32%	5.44%	0.00%	0.00%	0.00%	0.00%	0.00%	
St16_SFP	20.21%	5.10%	39.15%	35.54%	0.00%	0.00%	0.00%	0.00%	0.00%	
St20_ColRuedaTrasY Cadena	75.59%	3.30%	21.11%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St19_EngomadoColPiñon	93.86%	1.67%	0.97%	3.50%	0.00%	0.00%	0.00%	0.00%	0.00%	
St12_ArmadoCajaPedalera	34.72%	12.62%	52.65%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St17_ArmRuedasRayos	46.58%	31.52%	0.00%	21.90%	0.00%	0.00%	0.00%	0.00%	0.00%	
St21_ColRuedaDelantera	22.19%	1.32%	76.49%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	
St7_PretSuperficial	77.15%	1.12%	19.72%	2.01%	0.00%	0.00%	0.00%	0.00%	0.00%	
St10_Curado	24.89%	0.70%	74.41%	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	1310	1309	0	1	76.23%	-	23.77%	24.02%
St4a_Roscado	109	109	0	1	86.24%	-	13.76%	13.76%
St4b_BocaDePescado	981	980	0	1	79.61%	-	20.39%	20.39%
St4c_Perforado	437	436	0	1	30.30%	-	69.70%	69.70%
St2_Doblado	872	872	0	1	26.01%	-	73.99%	75.52%
St3_Conformado	654	654	0	1	72.75%	-	27.25%	27.25%
St6_Estampado	609	608	0	1	0.00%	-	100.00%	100.00%
St8_Secado	105	104	0	1	31.75%	-	68.25%	68.43%
St9_Pintura	102	101	0	1	4.82%	-	95.18%	95.18%
St18_CentradoRuedas	127	126	0	1	19.39%	-	80.61%	80.61%
St22_LimpiezaDesengrase	94	94	0	1	89.55%	-	10.45%	10.45%
Producto_terminado	94	94	0	1	100.00%	-	0.00%	0.00%
St5_Soldado	109	108	0	1	0.00%	-	100.00%	100.00%
St11_InsercionCubetas	100	100	0	1	93.02%	-	6.98%	6.98%
St13_ColCubreCadena	100	100	0	1	72.20%	-	27.80%	27.80%
St14_CBA	100	100	0	1	79.15%	-	20.85%	20.85%
St15_Horquilla	99	98	0	1	59.58%	-	40.42%	40.42%
St16_SFP	97	96	0	1	41.27%	-	58.73%	58.73%
St20_ColRuedaTrasY Cadena	95	94	0	1	9.79%	-	90.21%	90.21%
St19_EngomadoColPiñon	96	95	0	1	0.97%	-	99.03%	99.03%
St12_ArmadoCajaPedalera	100	100	0	1	65.15%	-	34.85%	34.85%
St17_ArmRuedasRayos	129	128	0	1	0.00%	-	100.00%	100.00%
St21_ColRuedaDelantera	94	94	0	1	77.79%	-	22.21%	22.21%
St7_PretSuperficial	108	107	0	1	20.22%	-	79.78%	79.78%
St10_Curado	101	200	0	2	75.10%	-	24.90%	24.90%

### Material Flow Properties

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	13.64%	1309	1:05:27.0000	3.0000	0.0000
St4a_Roscado	13.25%	109	1:03:35.0000	35.0000	0.0000
St4b_BocaDePescado	13.61%	981	1:05:21.0000	3.9969	0.0958
St4c_Perforado	54.53%	437	4:21:45.0000	35.9382	1.2916
St2_Doblado	54.50%	872	4:21:36.0000	18.0000	0.0000
St3_Conformado	9.08%	654	43:36.0000	4.0000	0.0000
St6_Estampado	8.46%	609	40:36.0000	4.0000	0.0000
St8_Secado	25.88%	105	2:04:13.1474	1:10.9824	0.1808
St9_Pintura	94.93%	102	7:35:39.1474	4:28.0309	19.8874
St18_CentradoRuedas	41.45%	127	3:18:58.0000	1:34.0000	0.0000
St22_LimpiezaDesengrase	10.44%	94	50:08.0000	32.0000	0.0000
Producto_terminado	0.00%	94	0.0000	0.0000	0.0000
St5_Soldado	30.00%	108	2:24:00.0000	1:20.0000	0.0000
St11_InsercionCubetas	6.94%	100	33:20.0000	20.0000	0.0000
St13_ColCubreCadena	27.78%	100	2:13:20.0000	1:20.0000	0.0000
St14_CBA	20.83%	100	1:40:00.0000	1:00.0000	0.0000
St15_Horquilla	34.03%	99	2:43:21.0000	1:39.0000	0.0000
St16_SFP	20.21%	97	1:37:00.0000	1:00.0000	0.0000
St20_ColRuedaTrasYCadena	75.59%	95	6:02:50.9269	3:49.1677	8.1127
St19_EngomadoColPiñon	93.86%	96	7:30:30.9269	4:41.5722	13.9900
St12_ArmadoCajaPedalera	34.72%	100	2:46:40.0000	1:40.0000	0.0000
St17_ArmRuedasRayos	46.58%	129	3:43:36.0000	1:44.0000	0.0000
St21_ColRuedaDelantera	22.19%	94	1:46:32.0000	1:08.0000	0.0000
St7_PretSuperficial	77.15%	108	6:10:18.1474	3:25.7236	13.2649
St10_Curado	24.89%	101	1:59:29.1474	1:10.9817	0.1843

## Working Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	9.10%	1310	43:40.0000	2.0000	0.0000
St4a_Roscado	0.52%	1	2:29.0000	2:29.0000	0.0000
St4b_BocaDePescado	6.78%	976	32:32.0000	2.0000	0.0000
St4c_Perforado	15.17%	437	1:12:50.0000	10.0000	0.0000
St2_Doblado	15.14%	872	1:12:40.0000	5.0000	0.0000
St3_Conformado	18.17%	654	1:27:12.0000	8.0000	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
Producto_terminado	0.00%	0	0.0000	0.0000	0.0000
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	3.51%	101	16:50.0000	10.0000	0.0000
St13_ColCubreCadena	2.45%	101	11:47.0000	7.0000	0.0000
St14_CBA	2.10%	101	10:06.0000	6.0000	0.0000
St15_Horquilla	5.21%	100	25:00.0000	15.0000	0.0000
St16_SFP	5.10%	98	24:30.0000	15.0000	0.0000
St20_ColRuedaTrasYCadena	3.30%	95	15:50.0000	10.0000	0.0000
St19_EngomadoColPiñon	1.67%	96	8:00.0000	5.0000	0.0000
St12_ArmadoCajaPedalera	12.62%	101	1:00:36.0000	36.0000	0.0000
St17_ArmRuedasRayos	31.52%	130	2:31:16.9269	1:09.8225	2.0236
St21_ColRuedaDelantera	1.32%	95	6:20.0000	4.0000	0.0000
St7_PretSuperficial	1.12%	108	5:24.0000	3.0000	0.0000
St10_Curado	0.70%	101	3:22.0000	2.0000	0.0000

## Set-up Time

Object	Portion	Count	Sum	Mean Value	Standard Deviation
St1_Corte	72.90%	1237	5:49:54.7797	16.9723	0.5941
St4a_Roscado	86.24%	110	6:53:56.0000	3:45.7818	1:24.6014
St4b_BocaDePescado	79.61%	962	6:22:07.0000	23.8326	40.4944
St4c_Perforado	30.30%	193	2:25:25.0000	45.2073	1:08.7445
St2_Doblado	24.48%	150	1:57:30.8723	47.0058	1:18.7227
St3_Conformado	72.75%	655	5:49:12.0000	31.9878	1:11.8774
St6_Estampado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	30.26%	55	2:25:15.4213	2:38.4622	2:56.4754
St9_Pintura	4.82%	4	23:08.8526	5:47.2131	4:30.4355
St18_CentradoRuedas	19.39%	69	1:33:02.9269	1:20.9120	11.6861
St22_LimpiezaDesengrase	89.55%	95	7:09:50.0000	4:31.4737	2:54.0487
Producto_terminado	100.00%	95	8:00:00.0000	5:03.1579	2:54.5975
St5_Soldado	70.00%	109	5:36:00.0000	3:04.9541	2:41.6419
St11_InsercionCubetas	89.55%	101	7:09:50.0000	4:15.3465	1:36.7188
St13_ColCubreCadena	69.77%	101	5:34:53.0000	3:18.9406	1:55.9296
St14_CBA	77.06%	101	6:09:54.0000	3:39.7426	2:02.9775
St15_Horquilla	55.32%	95	4:25:33.0871	2:47.7167	2:18.8278
St16_SFP	39.15%	56	3:07:54.9483	3:21.3384	3:13.0756
St20_ColRuedaTrasYCadena	21.11%	95	1:41:19.0731	1:03.9902	2:42.8957
St19_EngomadoColPiñon	0.97%	1	4:40.0000	4:40.0000	0.0000
St12_ArmadoCajaPedalera	52.65%	101	4:12:44.0000	2:30.1386	1:47.4562
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelantera	76.49%	95	6:07:08.0000	3:51.8737	2:50.3311
St7_PretSuperficial	19.72%	49	1:34:39.8526	1:55.9154	3:48.8275
St10_Curado	74.41%	101	5:57:08.8526	3:32.1669	1:34.5677

## Waiting 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	91.50%	102	7:19:11.0000	4:18.3431	2:42.8800
St8_Secado	39.16%	71	3:07:58.6098	2:38.8537	59.3425
St9_Pintura	0.00%	0	0.0000	0.0000	0.0000
St18_CentradoRuedas	39.12%	60	3:07:47.0731	3:07.7846	29.3381
St22_LimpiezaDesengrase	0.00%	0	0.0000	0.0000	0.0000
Producto_terminado	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	5.44%	16	26:05.9129	1:37.8696	1:01.0833
St16_SFP	35.54%	56	2:50:35.0517	3:02.7688	56.5884
St20_ColRuedaTrasYCadena	0.00%	0	0.0000	0.0000	0.0000
St19_EngomadoColPiñon	3.50%	2	16:49.0731	8:24.5365	4:25.1134
St12_ArmadoCajaPedalera	0.00%	0	0.0000	0.0000	0.0000
St17_ArmRuedasRayos	21.90%	56	1:45:07.0731	1:52.6263	10.2798
St21_ColRuedaDelantera	0.00%	0	0.0000	0.0000	0.0000
St7_PretSuperficial	2.01%	10	9:38.0000	57.8000	6.9570
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
Producto_terminado	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
Producto_terminado	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	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
Producto_terminado	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	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
Producto_terminado	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	72.90%	1237	5:49:54.7797	16.9723	0.5941
St4a_Roscado	86.24%	110	6:53:56.0000	3:45.7818	1:24.6014
St4b_BocaDePescado	79.61%	962	6:22:07.0000	23.8326	40.4944
St4c_Perforado	30.30%	193	2:25:25.0000	45.2073	1:08.7445
St2_Doblado	24.48%	150	1:57:30.8723	47.0058	1:18.7227
St3_Conformado	72.75%	655	5:49:12.0000	31.9878	1:11.8774
St6_Estampado	0.00%	0	0.0000	0.0000	0.0000
St8_Secado	30.26%	55	2:25:15.4213	2:38.4622	2:56.4754
St9_Pintura	4.82%	4	23:08.8526	5:47.2131	4:30.4355
St18_CentradoRuedas	19.39%	69	1:33:02.9269	1:20.9120	11.6861
St22_LimpiezaDesengrase	89.55%	95	7:09:50.0000	4:31.4737	2:54.0487
Producto_terminado	100.00%	95	8:00:00.0000	5:03.1579	2:54.5975
St5_Soldado	0.00%	0	0.0000	0.0000	0.0000
St11_InsercionCubetas	93.02%	101	7:26:30.0000	4:25.2475	1:35.8540
St13_ColCubreCadena	72.20%	101	5:46:33.0000	3:25.8713	1:55.2898
St14_CBA	79.15%	101	6:19:54.0000	3:45.6832	2:02.4283
St15_Horquilla	59.58%	95	4:46:00.4760	3:00.6366	2:18.2944
St16_SFP	41.27%	56	3:18:04.9483	3:32.2312	3:13.3144
St20_ColRuedaTrasYCadena	9.79%	24	47:00.0731	1:57.5030	5:23.4087
St19_EngomadoColPiñon	0.97%	1	4:40.0000	4:40.0000	0.0000
St12_ArmadoCajaPedalera	65.15%	101	5:12:44.0000	3:05.7822	1:44.2075
St17_ArmRuedasRayos	0.00%	0	0.0000	0.0000	0.0000
St21_ColRuedaDelantera	77.79%	95	6:13:24.0000	3:55.8316	2:49.9291
St7_PretSuperficial	20.22%	49	1:37:03.8526	1:58.8541	3:48.7517
St10_Curado	75.10%	101	6:00:28.8526	3:34.1471	1:34.3969

Empty Time

## Resource Statistics - Drain Statistics

Object	Working	Set-up	Waiting	Stopped	Failed	Paused	Mean Life Time	Mean Exit Time	Total Throughput	Throughput per Hour	Throughput per Day
Producto_terminado	47.79%	0.36%	51.51%	0.00%	0.34%	0.00%	50:30.1076	4:47.5707	94	11.75	282

Cumulated Statistics of the Parts which the Drain Deleted

Object	All Types	Platina_Ref
Producto_terminado	94	94

Part Types which the Drains Deleted

Producto_terminado	Production							Transport							Storage						
	Working	Set-up	Waiting	Stopped	Failed	Paused	Sum	Working	Set-up	Waiting	Stopped	Failed	Paused	Sum	Working	Set-up	Waiting	Stopped	Failed	Paused	Sum
Platina_Ref	47.79%	0.36%	23.25%	0.00%	0.34%	0.00%	71.74%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	0.00%	28.26%	0.00%	0.00%	0.00%	28.26%

Detailed Statistics of the Part Types Which the Drain Deleted

Producto_terminado	Life Time				Exit Time				Throughput		
	Mean Value	Standard Deviation	Minimum	Maximum	Mean Value	Standard Deviation	Minimum	Maximum	Total	Per Hour	Per Day
Platina_Ref	50:30.1076	9:04.2493	32:27.0000	1:11:36.0731	4:47.5707	33.4577	4:30.0000	9:59.0731	94	11.75	282

## 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	70.00%	70.00%	70.00%	0.00%
St11_InsercionCubetas	85.75%	85.75%	0.00%	0.00%
St13_ColCubreCadena	65.40%	65.40%	0.00%	0.00%
St14_CBA	72.39%	72.39%	0.00%	0.00%
St15_Horquilla	55.86%	55.86%	0.00%	0.00%
St16_SFP	69.39%	69.39%	0.00%	0.00%
St20_ColRuedaTrasYCadena	15.55%	15.55%	12.11%	0.00%
St19_EngomadoColPiñon	3.50%	3.50%	0.00%	0.00%
St12_ArmadoCajaPedalera	48.75%	48.75%	0.00%	0.00%
St17_ArmRuedasRayos	21.90%	21.90%	0.00%	0.00%
St21_ColRuedaDelantera	70.09%	70.09%	0.00%	0.00%
St7_PretSuperficial	20.36%	20.36%	0.00%	0.00%
St10_Curado	70.86%	70.86%	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	70.00%	109	5:36:00.0000	3:04.9541	2:41.6419
St11_InsercionCubetas	85.75%	100	6:51:37.0000	4:06.9700	47.8606
St13_ColCubreCadena	65.40%	100	5:13:54.0000	3:08.3400	45.9472
St14_CBA	72.39%	100	5:47:28.0000	3:28.4800	48.3263
St15_Horquilla	55.86%	99	4:28:07.0000	2:42.4949	43.1183
St16_SFP	69.39%	97	5:33:04.0000	3:26.0206	36.3702
St20_ColRuedaTrasYCadena	15.55%	94	1:14:38.0731	47.6391	33.8815
St19_EngomadoColPiñon	3.50%	2	16:49.0731	8:24.5365	4:25.1134
St12_ArmadoCajaPedalera	48.75%	100	3:54:01.0000	2:20.4100	44.8071
St17_ArmRuedasRayos	21.90%	56	1:45:07.0731	1:52.6263	10.2798
St21_ColRuedaDelantera	70.09%	94	5:36:27.0000	3:34.7553	34.4478
St7_PretSuperficial	20.36%	58	1:37:42.8526	1:41.0837	3:27.6155
St10_Curado	70.86%	100	5:40:08.8526	3:24.0885	48.7402

### 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	70.00%	109	5:36:00.0000	3:04.9541	2:41.6419
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	12.11%	74	58:09.0000	47.1486	5.1250
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