

Tecnomatix Plant Simulation 16 Statistics

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|-----------------|--|
| Created on | viernes, 16 de julio de 2021 3:55 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 | 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% | |
| Producto_terminado | 0.00% | 0.00% | 100.00% | 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% |
| Producto_terminado | 81 | 81 | 0 | 1 | 100.00% | - | 0.00% | 0.00% |
| 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 |
| Producto_terminado | 0.00% | 81 | 0.0000 | 0.0000 | 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 |
| Producto_terminado | 0.00% | 0 | 0.0000 | 0.0000 | 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 |
| Producto_terminado | 100.00% | 82 | 8:00:00.0000 | 5:51.2195 | 4:31.3551 |
| 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 |
| 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 | 0.22% | 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 |
| 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 | 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 |
| Producto_terminado | 100.00% | 82 | 8:00:00.0000 | 5:51.2195 | 4:31.3551 |
| 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

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 | 71.08% | 7.60% | 21.15% | 0.00% | 0.17% | 0.00% | 44:17.5636 | 5:12.8584 | 81 | 10.125 | 243 |

Cumulated Statistics of the Parts which the Drain Deleted

| Object | All Types | Platina_Ref |
|--------------------|-----------|-------------|
| Producto_terminado | 81 | 81 |

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 | 71.08% | 7.60% | 12.43% | 0.00% | 0.17% | 0.00% | 91.28% | 0.00% | 0.00% | 0.00% | 0.00% | 0.00% | 0.00% | 0.00% | 0.00% | 0.00% | 8.72% | 0.00% | 0.00% | 0.00% | 8.72% |

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 | 44:17.5636 | 2:45.7962 | 39:21.0000 | 54:52.8526 | 5:12.8584 | 1:19.6039 | 4:56.0000 | 13:50.5358 | 81 | 10.125 | 243 |

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