

Source: TIME STUDY
PLAN: CEP #1 Production
AREA: ENGINE ASSEMBLY

OPERATION UTILIZATION
CLEVELAND ENGINE PLANT #1
BY ZONE

Uncontrolled Document
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Dept	Zone	Team	Line	Sta.	Nbr	Operation	Time Study					Work Class (Min/Hr)			
							Name				Min/Hr	Util%	VA	NVABN	NVA
EA	A	00	BF	280N	0280	INSTALL MOG PLUG	INSTL MOG, 2 DOWELS, DIVERTER				39.16	65.27	5.30	33.86	0.00
EA	A	00	BF	310N	0310	DOWELS,DIVERTER, O/P SWITCH	INSTALL 2 DOWELS, DIVERTER, O/P SWITCH				32.99	54.98	3.86	29.12	0.00
EA	A	00								Team Total	72.15	60.13	9.16	62.99	0.00