

**Exemplo Fabrica de Autopecas**

Replications: 1 Time Units: Minutes

**Key Performance Indicators**

<b>System</b>	Average
Number Out	91

**Exemplo Fabrica de Autopecas**

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**Entity****Time**

VA Time	Average	Half Width	Minimum Value	Maximum Value
Peca	532.27	(Insufficient)	435.02	634.35
NVA Time	Average	Half Width	Minimum Value	Maximum Value
Peca	0.00	(Insufficient)	0.00	0.00
Wait Time	Average	Half Width	Minimum Value	Maximum Value
Peca	1056.68	(Insufficient)	484.12	2002.97
Transfer Time	Average	Half Width	Minimum Value	Maximum Value
Peca	0.00	(Insufficient)	0.00	0.00
Other Time	Average	Half Width	Minimum Value	Maximum Value
Peca	0.00	(Insufficient)	0.00	0.00
Total Time	Average	Half Width	Minimum Value	Maximum Value
Peca	119.46	(Insufficient)	74.7460	187.09

**Other**

Number In	Value			
Peca	1664.00			
Number Out	Value			
Peca	1595.00			
WIP	Average	Half Width	Minimum Value	Maximum Value
Peca	54.9141	(Correlated)	0.00	109.00

## Exemplo Fabrica de Autopecas

Replications: 1 Time Units: Minutes

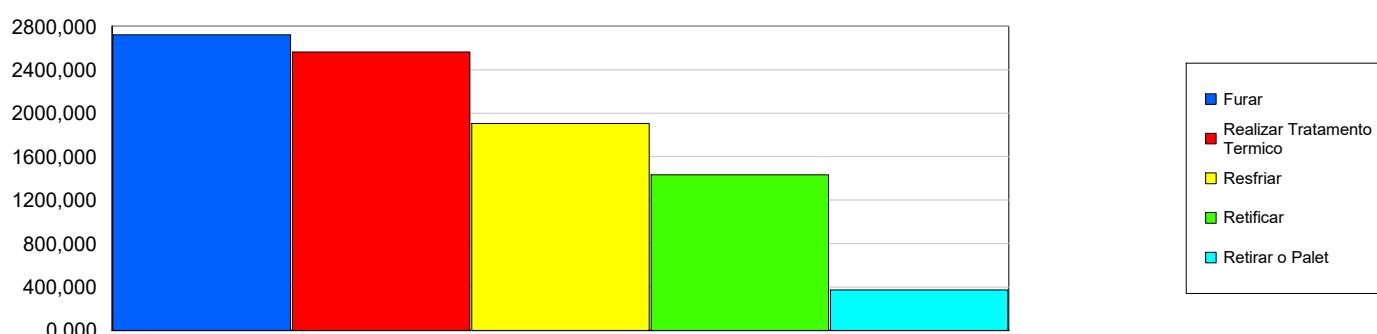
### Process

#### Time per Entity

VA Time Per Entity	Average	Half Width	Minimum Value	Maximum Value
Furar	1.9813	0,028903477	0.8059	3.1463
Realizar Tratamento Termico	18.4494	(Insufficient)	13.0314	24.6507
Resfriar	13.7140	(Insufficient)	5.5961	19.3529
Retificar	1.0007	0,031217972	0.00	2.4912
Retirar o Palet	4.0745	(Insufficient)	1.6771	6.4424
Wait Time Per Entity	Average	Half Width	Minimum Value	Maximum Value
Furar	20.4735	(Correlated)	0.00	62.3798
Realizar Tratamento Termico	22.3087	(Insufficient)	0.00	75.0350
Resfriar	9.0154	2,05203	0.00	43.4943
Retirar o Palet	0.00	(Insufficient)	0.00	0.00
Total Time Per Entity	Average	Half Width	Minimum Value	Maximum Value
Furar	22.4549	(Correlated)	1.4916	64.0801
Realizar Tratamento Termico	40.7581	(Insufficient)	13.9202	90.8297
Resfriar	13.7140	(Insufficient)	5.5961	19.3529
Retificar	10.0162	2,06526	0.04619169	45.3019
Retirar o Palet	4.0745	(Insufficient)	1.6771	6.4424

#### Accumulated Time

Accum VA Time	Value
Furar	2720.39
Realizar Tratamento Termico	2564.46
Resfriar	1906.25
Retificar	1431.07
Retirar o Palet	370.78



## Exemplo Fabrica de Autopecas

Replications: 1 Time Units: Minutes

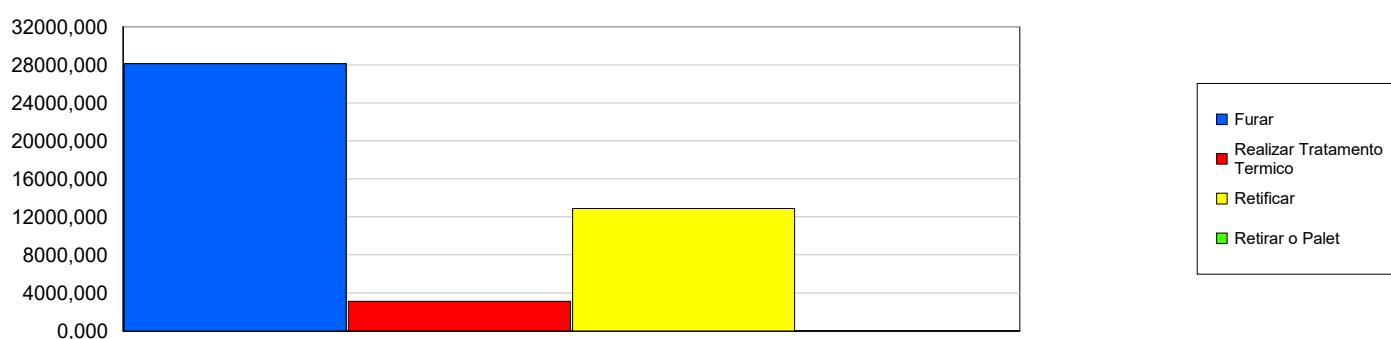
### Process

#### Accumulated Time

Accum Wait Time

Value

Furar	28110.13
Realizar Tratamento Termico	3100.92
Retificar	12892.05
Retirar o Palet	0.00

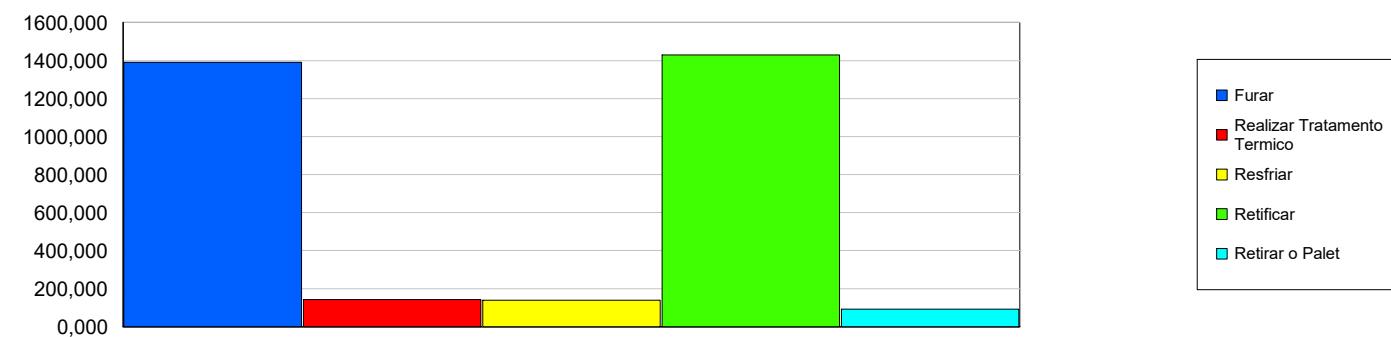


#### Other

Number In

Value

Furar	1390.00
Realizar Tratamento Termico	143.00
Resfriar	139.00
Retificar	1430.00
Retirar o Palet	91.0000



## Exemplo Fabrica de Autopecas

Replications: 1 Time Units: Minutes

## Process

### Other

Number Out	Value
Furar	1373.00
Realizar Tratamento Termico	139.00
Resfriar	139.00
Retificar	1430.00
Retirar o Palet	91.0000

## Queue

### Time

Waiting Time	Average	Half Width	Minimum Value	Maximum Value
Criar o Lote de 10 pecas.Queue	4.4900	0,185525173	0.00	13.2061
Furar.Queue	20.4767	(Correlated)	0.00	62.3798
Montar Palet.Queue	14.8753	1,27402	0.00	96.9816
Realizar Tratamento Termico.Queue	22.6941	(Insufficient)	0.00	76.2649
Retificar.Queue	9.0154	2,05203	0.00	43.4943
Retirar o Palet.Queue	0.00	(Insufficient)	0.00	0.00

### Other

Number Waiting	Average	Half Width	Minimum Value	Maximum Value
Criar o Lote de 10 pecas.Queue	2.1402	0,338021697	0.00	10.0000
Furar.Queue	9.4629	(Correlated)	0.00	32.0000
Montar Palet.Queue	6.7927	0,359503858	0.00	15.0000
Processo do Torno.Queue	0.00	(Insufficient)	0.00	0.00
Realizar Tratamento Termico.Queue	1.1271	(Insufficient)	0.00	6.0000
Retificar.Queue	4.2974	1,54738	0.00	40.0000
Retirar o Palet.Queue	0.00	(Insufficient)	0.00	0.00

**Exemplo Fabrica de Autopecas**

Replications: 1 Time Units: Minutes

**Resource****Usage**

Instantaneous Utilization	Average	Half Width	Minimum Value	Maximum Value
Empilhadeira1	0.1236	(Insufficient)	0.00	1.0000
Forno	0.8611	(Insufficient)	0.00	1.0000
Furadeira	0.9072	(Insufficient)	0.00	1.0000
Operador	0.9072	(Insufficient)	0.00	1.0000
Retifica	0.4770	(Insufficient)	0.00	1.0000
Torno	0.00	(Insufficient)	0.00	0.00
Number Busy	Average	Half Width	Minimum Value	Maximum Value
Empilhadeira1	0.1236	(Insufficient)	0.00	1.0000
Forno	0.8611	(Insufficient)	0.00	1.0000
Furadeira	0.9072	(Insufficient)	0.00	1.0000
Operador	0.9072	(Insufficient)	0.00	1.0000
Retifica	0.4770	(Insufficient)	0.00	1.0000
Torno	0.00	(Insufficient)	0.00	0.00
Number Scheduled	Average	Half Width	Minimum Value	Maximum Value
Empilhadeira1	1.0000	(Insufficient)	1.0000	1.0000
Forno	1.0000	(Insufficient)	1.0000	1.0000
Furadeira	1.0000	(Insufficient)	1.0000	1.0000
Operador	1.0000	(Insufficient)	1.0000	1.0000
Retifica	1.0000	(Insufficient)	1.0000	1.0000
Torno	1.0000	(Insufficient)	1.0000	1.0000

## Exemplo Fabrica de Autopecas

Replications: 1 Time Units: Minutes

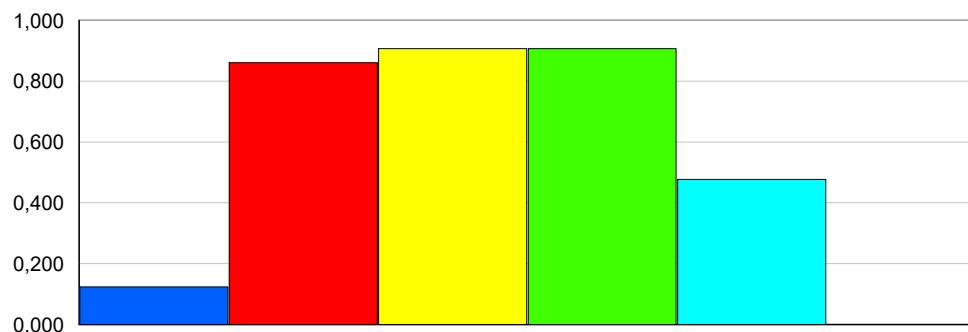
### Resource

#### Usage

##### Scheduled Utilization

###### Value

Empilhadeira1	0.1236
Forno	0.8611
Furadeira	0.9072
Operador	0.9072
Retifica	0.4770
Torno	0.00



##### Total Number Seized

###### Value

Empilhadeira1	91.0000
Forno	140.00
Furadeira	1374.00
Operador	1374.00
Retifica	1430.00
Torno	0.00



**Exemplo Fabrica de Autopecas**

Replications: 1 Time Units: Minutes

**User Specified****Tally**

Between	Average	Half Width	Minimum Value	Maximum Value
gravar tempo entre lotes	21.4232	(Insufficient)	13.0314	109.33
Registro de intervalo de retirada de palet da Empilhadeira	32.3376	(Insufficient)	24.9794	100.95
Interval	Average	Half Width	Minimum Value	Maximum Value
Grava tempo de Processo	119.46	(Insufficient)	74.7460	187.09

**Counter**

Count	Value
Conta acionamento da empilhadeira	91.0000



■ Conta acionamento da empilhadeira