1. **F** Production efficiency: OEE >= 90% overall
2. **F** standard working hours 2 shifts/day, 48 weeks/year
3. **F** minimal walking distance < 2 m
4. **F** safety exits at least 0.7 m wide
5. **F** product\_transit\_time/production\_time < layout\_eff % [throughput]
6. **F** regular and reliable raw material order patterns with a < 10% variation
7. **F** Safety Stock: < n %, not more than n % of the ordered raw materials is unused
8. **F** Cost of new machinery required [Initial Investment]
9. **F** Should reach the breakeven point in (x) years
10. **F** minimum working wage
11. **F** Quality: Cpk > 1.5 (the ability of a process to produce output within specification limits)
12. **F** Material Usage Efficiency: less than r% wasted product and material == (shaft less than 600 for agriculture part). Statistical analysis and rework allocation
13. **F** horizontal displacement of boom tip <= 4mm
14. **NF** failure modes are minimized (FMEA analysis) and (QC&RM) == quantify (numbers and units)
15. **NF** ISO standards are met (QC&RM)
16. **NF** Order delivery: specified delivery dates and number of parts are met with minimal variation (ensure by keeping safety stock) == dependability
17. **NF** easy access to safety exits (not blocked by machines/ keep in mind the walking distance)
18. **NF** Flexibility