**Production Flow**

Since the production portfolio of the factory includes products of totally different sizes the production flow has been split in two sections. The structural beams of the crane have been assigned both a separated warehouse and a separated production line because these elements are much bigger than the rest of the products produced within the factory.

The production of the crane elements will be produced using a production line. The elements will be transported between machines using conveyor belts.

The production of the rest of the products will be done using both a functional layout and a cell layout. In the figure below it can be seen that the sawing machines and the machine centers are all located together at the front of the production flow. In addition the assembly tables are located together at the end of the flow. These two instances indicate a functional layout. In between the machine centers and the assembly table however, the machines are located in five cells. In the figure the flow of products between the different sections and cells can be found.