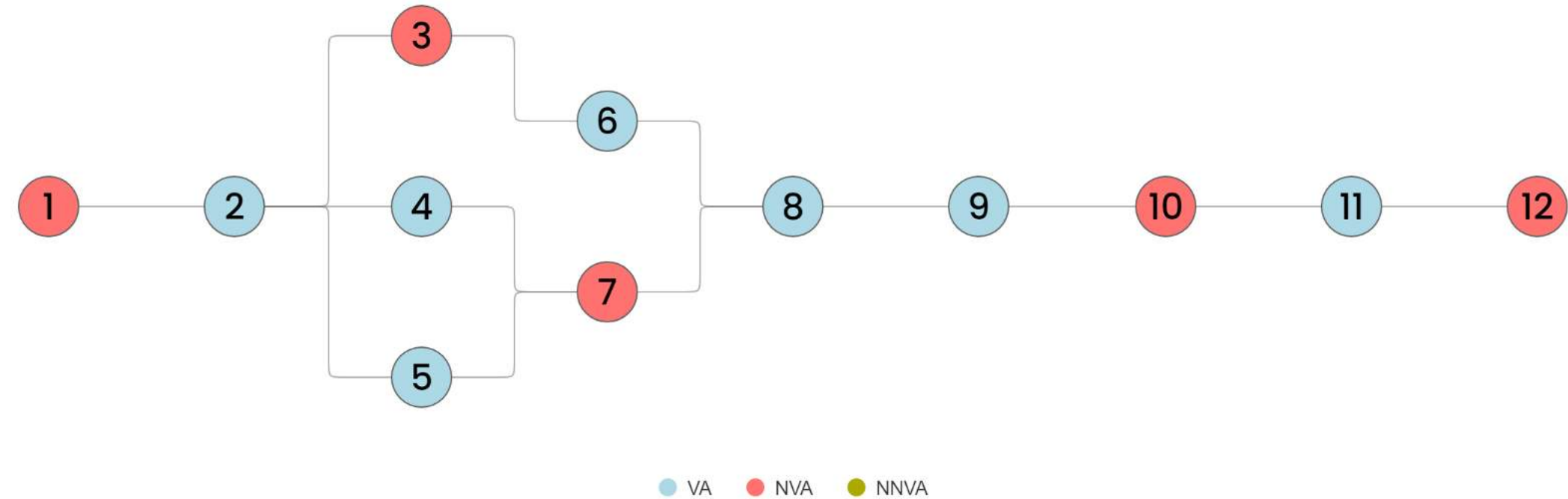
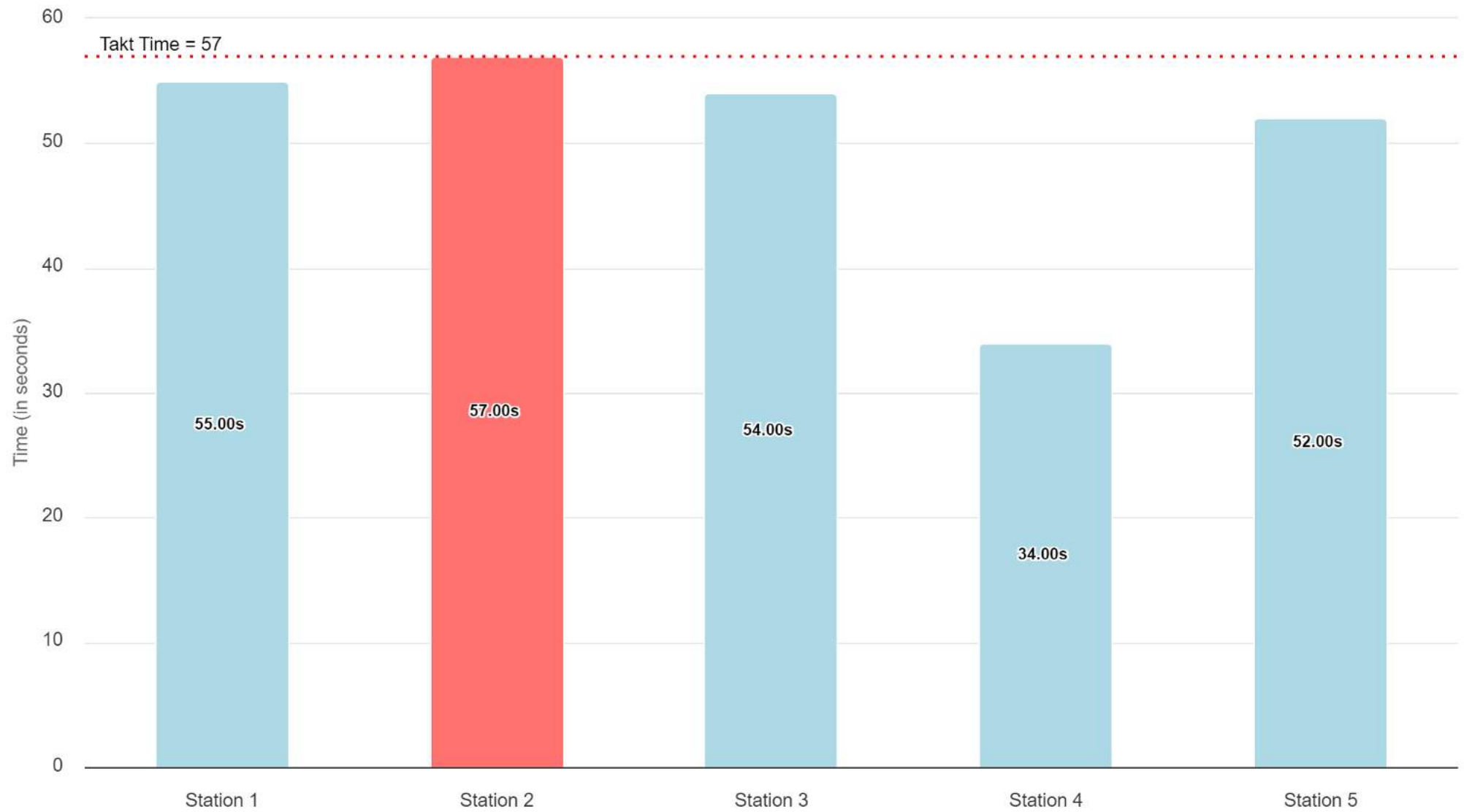
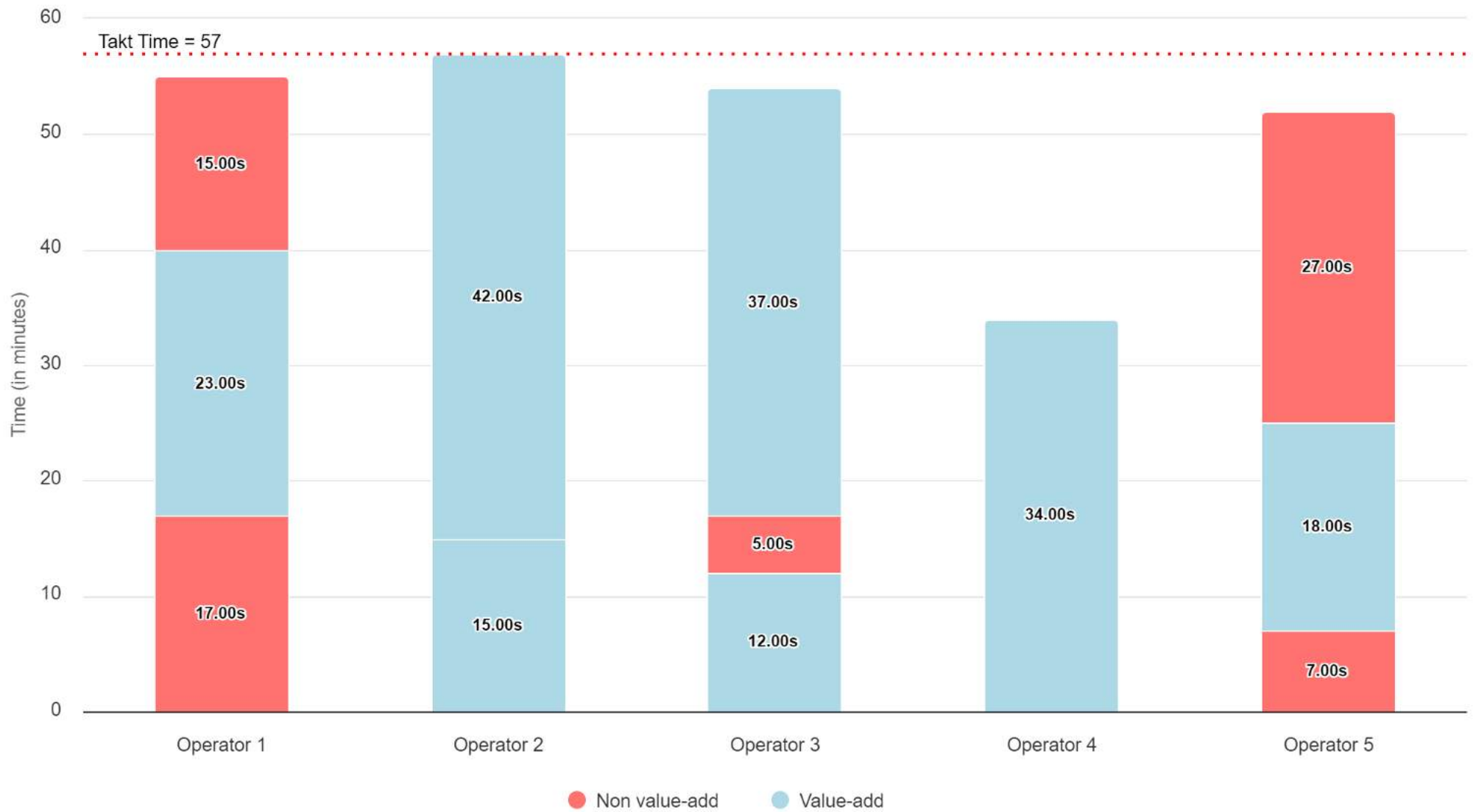


Line Name	Takt time (s)	Operators	LBR (%)	Bottleneck station	Target volume/hr
Sensor Line 1	57	5	88.42 %	Station 1	63 units







Station Name	Operators	Cycle Time (s)	Steps Allocated
Station 1	Operator 1	55	<ul style="list-style-type: none"><li>• Pick &amp; place housing</li><li>• Install sensing element</li><li>• Remove sensor and place it on the crimp m/c.</li></ul>
Station 2	Operator 2	57	<ul style="list-style-type: none"><li>• Perform crimping</li><li>• Install wire harness</li></ul>
Station 3	Operator 3	54	<ul style="list-style-type: none"><li>• Perform pressing</li><li>• Remove sensor and place it on testing m/c</li><li>• Electrical test</li></ul>
Station 4	Operator 4	34	<ul style="list-style-type: none"><li>• Barcode marking</li></ul>
Station 5	Operator 5	52	<ul style="list-style-type: none"><li>• Visual inspection</li><li>• Packing</li><li>• Move sensor to rack</li></ul>