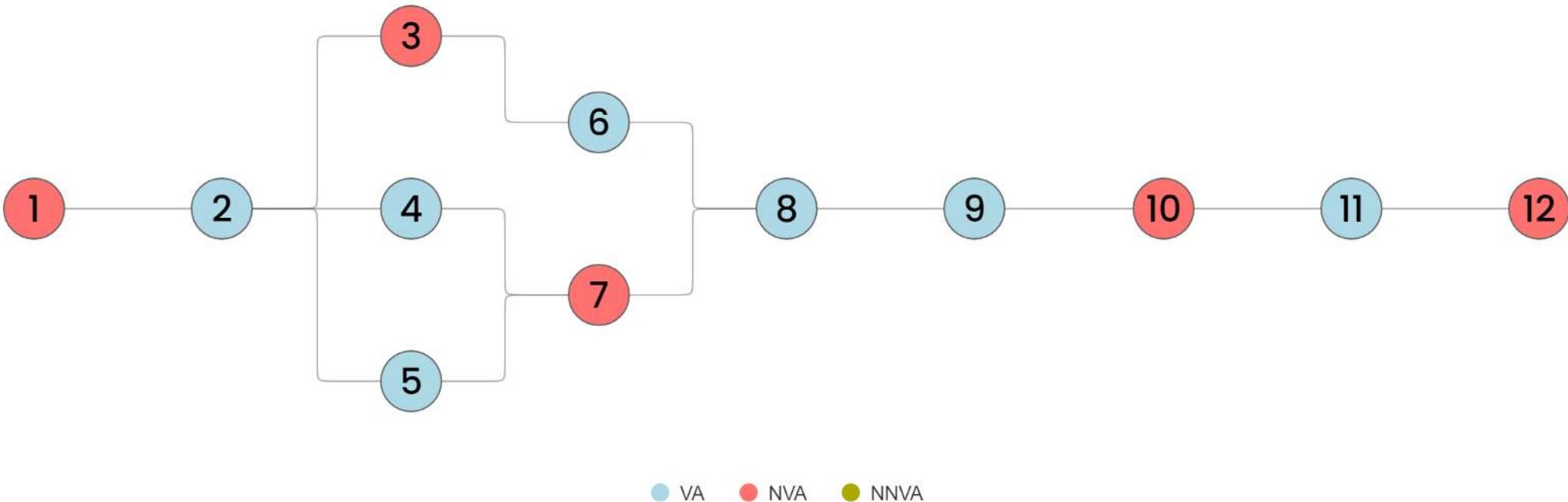
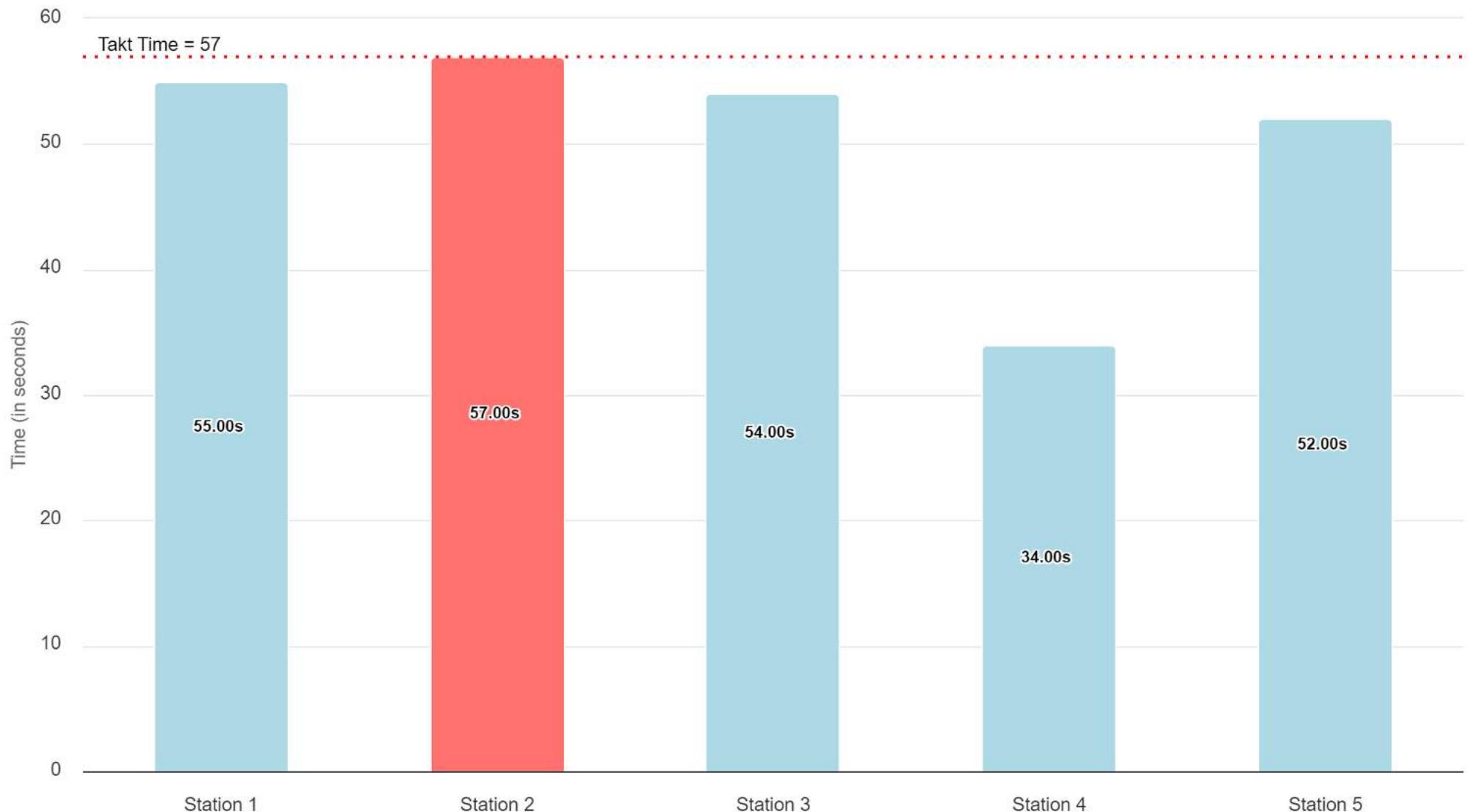
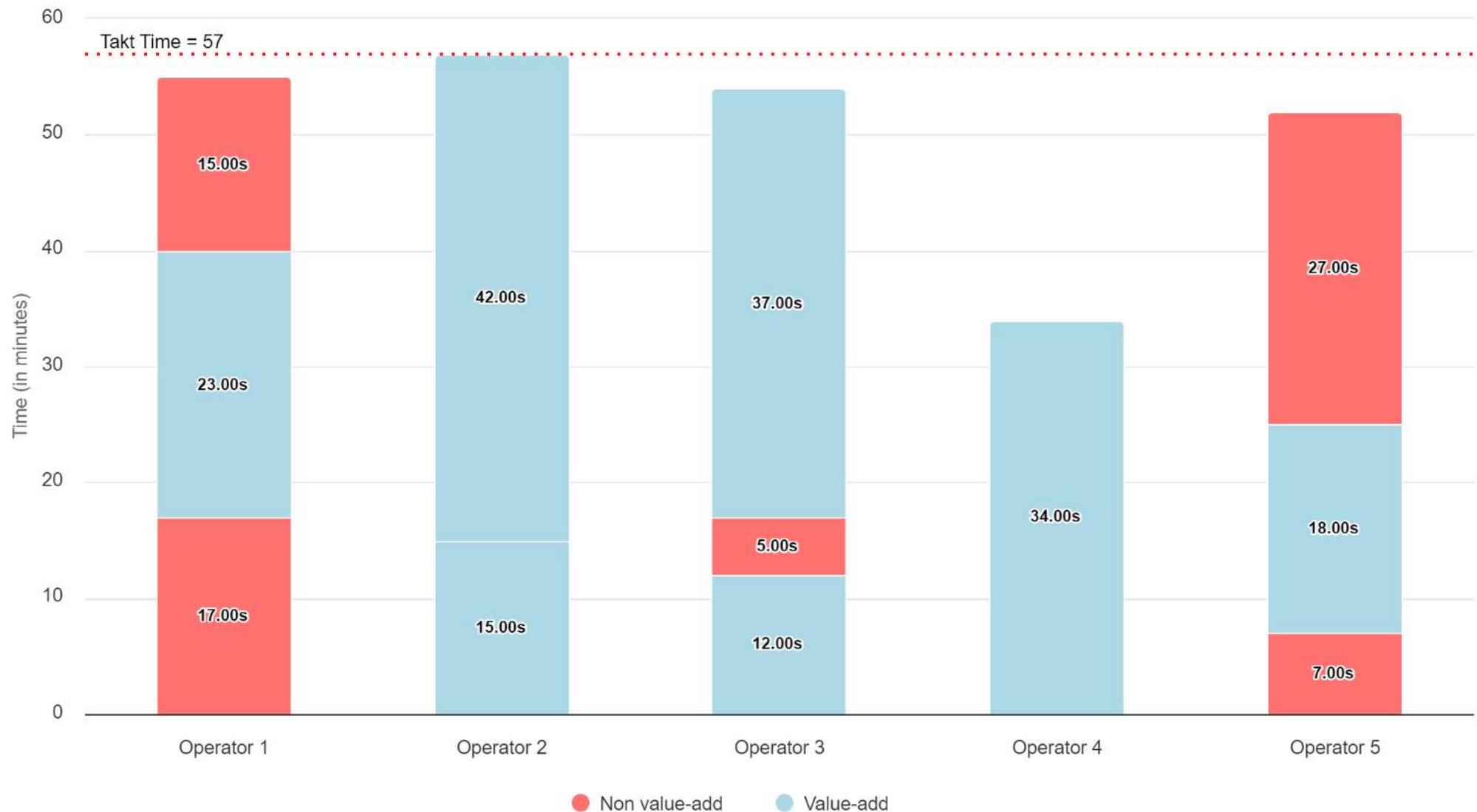


Line Name	Takt time (s)	Operators	LBR (%)	Bottleneck station	Targer volume/hr
Sensor Line 1	57	5	88.42 %	Station 1	63 units







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