

TIME STUDY

Using EXCEL 2016

Time Study Sheet (Polo Shirt)

Standard Minute Value (SMV)

| | | |
|---------------------|-------|--------------------------------|
| SMV | 8.89 | Minute for Making a Polo Shirt |
| SMV with Allowances | 15.71 | |

| Expected Allowances | | |
|---------------------|---|--------|
| Personal Allowance | 5 | Second |
| Machine Allowance | 6 | |
| Process Allowance | 8 | |

Note:

- Personal Allowance is with Manual Operation
- Machine Allowance is with Machine Operation
- Process Allowance is with both Manual & Machine

| Operation Name | Machine [M/C] | Cycle Time (Second) | | | | | Average [second] | Average [Minute] | SMV with Allowance |
|-------------------------------|---------------|---------------------|----|----|----|----|------------------|------------------|--------------------|
| | | 1 | 2 | 3 | 4 | 5 | | | |
| Back & Front Part Arrange | Manual | 11 | 9 | 9 | 10 | 11 | 10 | 0.17 | 0.38 |
| Shoulder Join | OL-4TH | 9 | 9 | 11 | 9 | 10 | 9.6 | 0.16 | 0.39 |
| Side Label Attach | SM | 13 | 14 | 13 | 12 | 13 | 13 | 0.22 | 0.45 |
| Body Mark | Manual | 15 | 14 | 22 | 13 | 16 | 16 | 0.27 | 0.48 |
| Sleeve Hem | FL-FB | 8 | 8 | 7 | 8 | 9 | 8 | 0.13 | 0.37 |
| Body Arrange & Sleeve Hem Cut | Manual | 10 | 10 | 7 | 12 | 9 | 9.6 | 0.16 | 0.38 |
| Sleeve Shearing | SM | 10 | 8 | 10 | 10 | 10 | 9.6 | 0.16 | 0.39 |
| Sleeve Join | OL-4TH | 49 | 47 | 45 | 46 | 45 | 46.4 | 0.77 | 1.01 |
| Placket Rolling | SM | 11 | 9 | 9 | 9 | 9 | 9.4 | 0.16 | 0.39 |
| Placket Mark | Manual | 9 | 9 | 12 | 11 | 10 | 10.2 | 0.17 | 0.39 |
| Placket Join | SM | 26 | 26 | 24 | 25 | 24 | 25 | 0.42 | 0.65 |
| Placket Scissoring | Manual | 11 | 10 | 15 | 10 | 12 | 11.6 | 0.19 | 0.41 |

Industrial Engineering Time Motion Study Formula

Mike Jess



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