

# TIME STUDY

## Using EXCEL 2016

Time Study Sheet (Polo Shirt)

Standard Minute Value (SMV)

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

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

# Industrial Engineering Time Motion Study Formula

**Robert Thurston Kent, Charles  
MacCaughey Sames**



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## **Table of Contents Industrial Engineering Time Motion Study Formula**

1. Understanding the eBook Industrial Engineering Time Motion Study Formula
  - The Rise of Digital Reading Industrial Engineering Time Motion Study Formula
  - Advantages of eBooks Over Traditional Books
2. Identifying Industrial Engineering Time Motion Study Formula
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Industrial Engineering Time Motion Study Formula
  - User-Friendly Interface
4. Exploring eBook Recommendations from Industrial Engineering Time Motion Study Formula
  - Personalized Recommendations
  - Industrial Engineering Time Motion Study Formula User Reviews and Ratings
  - Industrial Engineering Time Motion Study Formula and Bestseller Lists
5. Accessing Industrial Engineering Time Motion Study Formula Free and Paid eBooks
  - Industrial Engineering Time Motion Study Formula Public Domain eBooks
  - Industrial Engineering Time Motion Study Formula eBook Subscription Services

- Industrial Engineering Time Motion Study Formula Budget-Friendly Options
- 6. Navigating Industrial Engineering Time Motion Study Formula eBook Formats
  - ePub, PDF, MOBI, and More
  - Industrial Engineering Time Motion Study Formula Compatibility with Devices
  - Industrial Engineering Time Motion Study Formula Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Industrial Engineering Time Motion Study Formula
  - Highlighting and Note-Taking Industrial Engineering Time Motion Study Formula
  - Interactive Elements Industrial Engineering Time Motion Study Formula
- 8. Staying Engaged with Industrial Engineering Time Motion Study Formula
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Industrial Engineering Time Motion Study Formula
- 9. Balancing eBooks and Physical Books Industrial Engineering Time Motion Study Formula
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Industrial Engineering Time Motion Study Formula
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Industrial Engineering Time Motion Study Formula
  - Setting Reading Goals Industrial Engineering Time Motion Study Formula
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Industrial Engineering Time Motion Study Formula
  - Fact-Checking eBook Content of Industrial Engineering Time Motion Study Formula
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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