

# 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

**Robert Lee Morrow**



## **Industrial Engineering Time Motion Study Formula:**

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*Motion and Time Study* Benjamin W. Niebel,1982 The 10th Edition integrates the traditional elements of motion and time study with current topics in work design and ergonomics This text includes questions problems and sample laboratory exercises to assist the instructor and has gone on line to the internet to provide electronic forms current information and the means for educators students and professionals to interact

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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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