

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

Marvin Everett Mundel



Industrial Engineering Time Motion Study Formula:

Motion and Time Study Ralph M. Barnes,1991-01-16 An updated demonstration of the application of motion and time study to the design and measurement of work and industrial problem solving Illustrations and practical examples show how motion and time study can increase productivity improve equipment utilization conserve materials and energy reduce human effort and advance organizational goals Includes discussions on computer aided time study human factors and wage incentives

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

Time Study and Motion Economy Robert Lee Morrow,1946

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Unveiling the Magic of Words: A Report on "**Industrial Engineering Time Motion Study Formula**"

In a world defined by information and interconnectivity, the enchanting power of words has acquired unparalleled significance. Their capability to kindle emotions, provoke contemplation, and ignite transformative change is actually awe-inspiring. Enter the realm of "**Industrial Engineering Time Motion Study Formula**," a mesmerizing literary masterpiece penned by a distinguished author, guiding readers on a profound journey to unravel the secrets and potential hidden within every word. In this critique, we shall delve to the book is central themes, examine its distinctive writing style, and assess its profound effect on the souls of its readers.

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