

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

R Barnett



Industrial Engineering Time Motion Study Formula:

Enjoying the Beat of Appearance: An Mental Symphony within **Industrial Engineering Time Motion Study Formula**

In some sort of taken by monitors and the ceaseless chatter of instantaneous connection, the melodic beauty and psychological symphony developed by the prepared word often fade into the backdrop, eclipsed by the relentless noise and distractions that permeate our lives. Nevertheless, located within the pages of **Industrial Engineering Time Motion Study Formula** a marvelous literary value filled with raw feelings, lies an immersive symphony waiting to be embraced. Constructed by an outstanding musician of language, that interesting masterpiece conducts visitors on a mental trip, well unraveling the hidden tunes and profound impact resonating within each cautiously constructed phrase. Within the depths with this emotional evaluation, we shall explore the book is central harmonies, analyze its enthralling writing type, and surrender ourselves to the profound resonance that echoes in the depths of readers souls.

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