## What if products have different routings but also some shared resources? PRODUCTION Forecasts Forecast CONTROL State Street Assembly Michigan Daily Steel Co. weekly MRP Order 18,400 pos/mo fдx -12,000 "L" 500 ft colla -6,400 °R" Weekly Schedule Tray = 20 pieces 2 Shifts Tues. + Daily Ship Schedule Thurs. Daily. eft Bracket Parts ASSEMBLY #2 SHIPPING S. WELD #2 ASSEMBLY #1 S. WELD #1 STAMPING Staging 200 T 2700 L Colls 1200 L 1600 L 850 R 4600 L 1100 L 1440 R 640 R 5 days 600 R 2400 R C/T = 62 seconds C/T = 40 seconds C/T = 46 seconds C/T = 1 second C/T = 39 seconds C/O = 18 C/0 = Ø C/O = 10 minutes C/O = 10 minutes C/O = 1 hourUptime = 100% Uptime = 100% Uptime = 80% Uptime = 85% Uptime = 100% 2 Shifts 2 Shifts 2 Shifts 2 Shifts 27,600 sec. avail. EPE = 2 weeks Production = 23.6 days 1 Shift 1 Shift 1 Shift 4.5 days 2 days 5 days 7.6 days 1.8 days 40 seconds 62 seconds 39 seconds Processing 1 second = 188 sec. Time Right Bracket Parts PART II. THE CURRENT STATE MAP