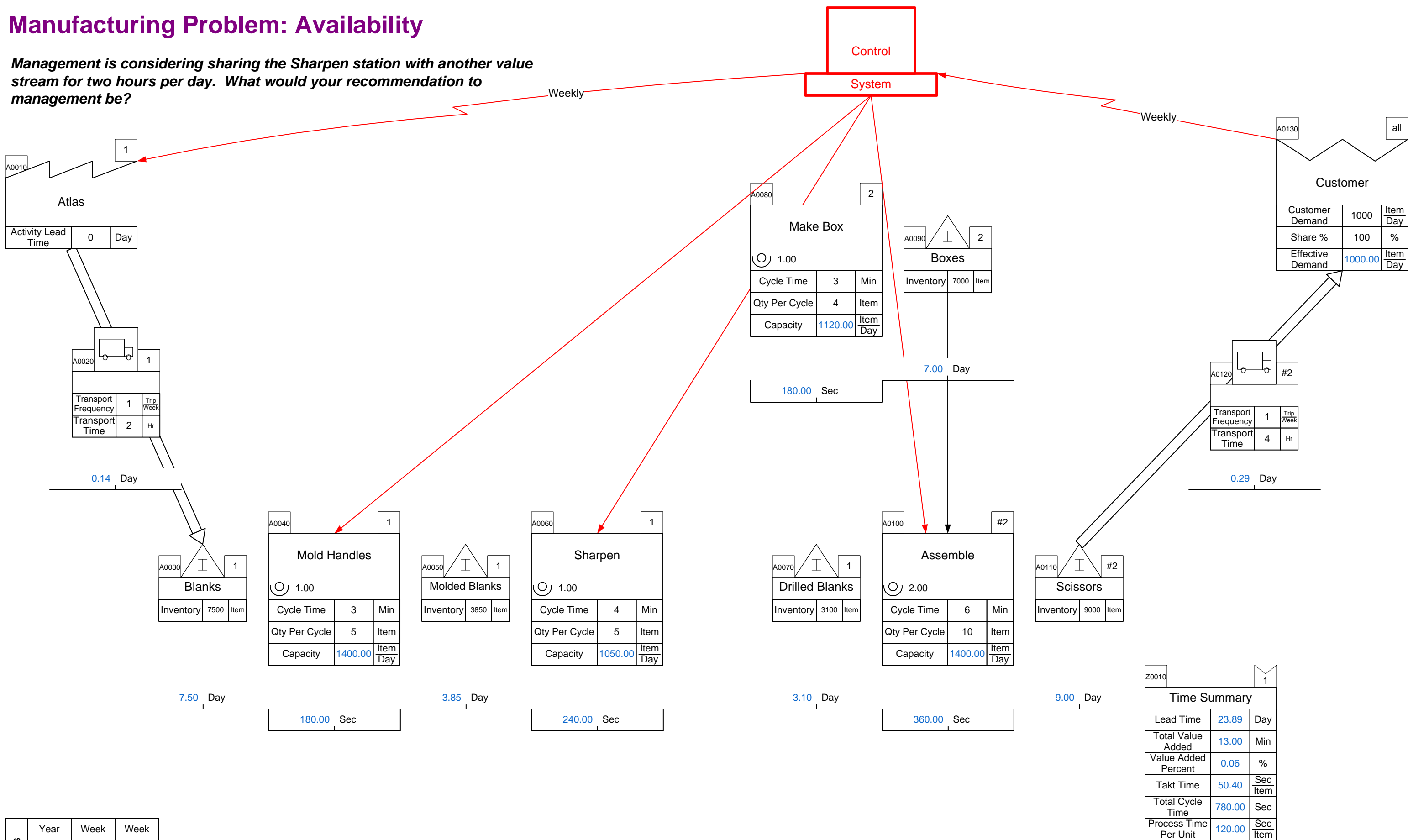


Manufacturing Problem: Availability

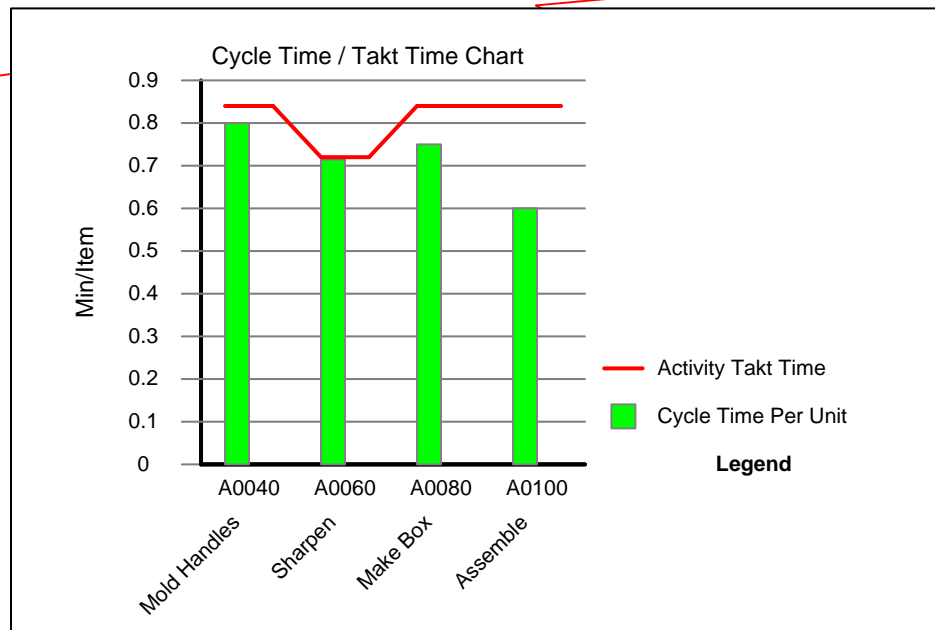
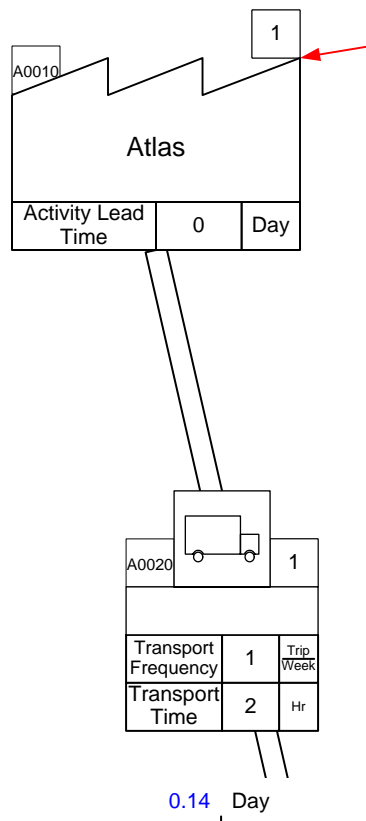
Management is considering sharing the Sharpen station with another value stream for two hours per day. What would your recommendation to management be?



Units	Year	Week	Week
	52	70	5
	Week	Hr	day

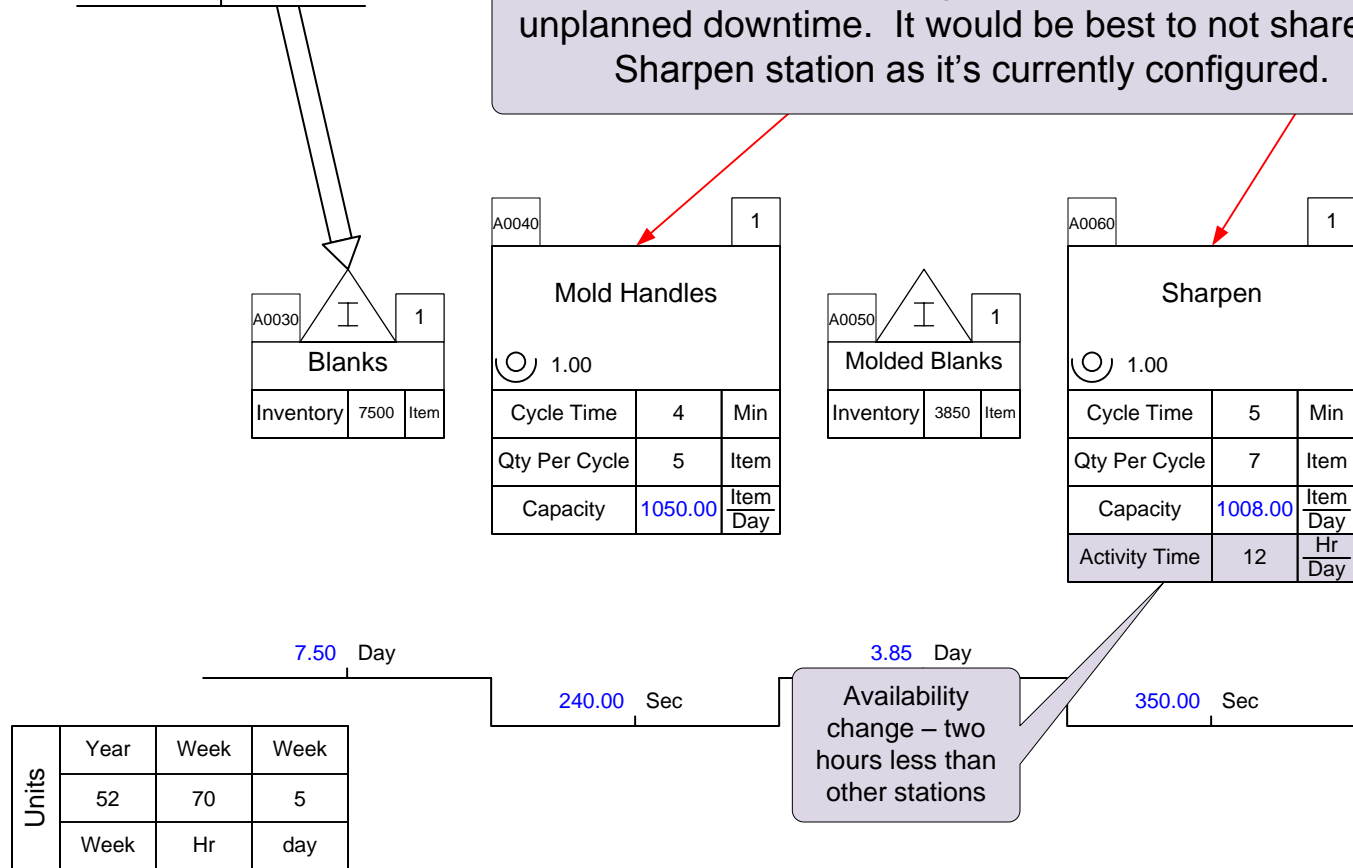
Manufacturing Solution: Availability

Management is considering sharing the Sharpen station with another value stream for two hours per day. What would your recommendation to management be?



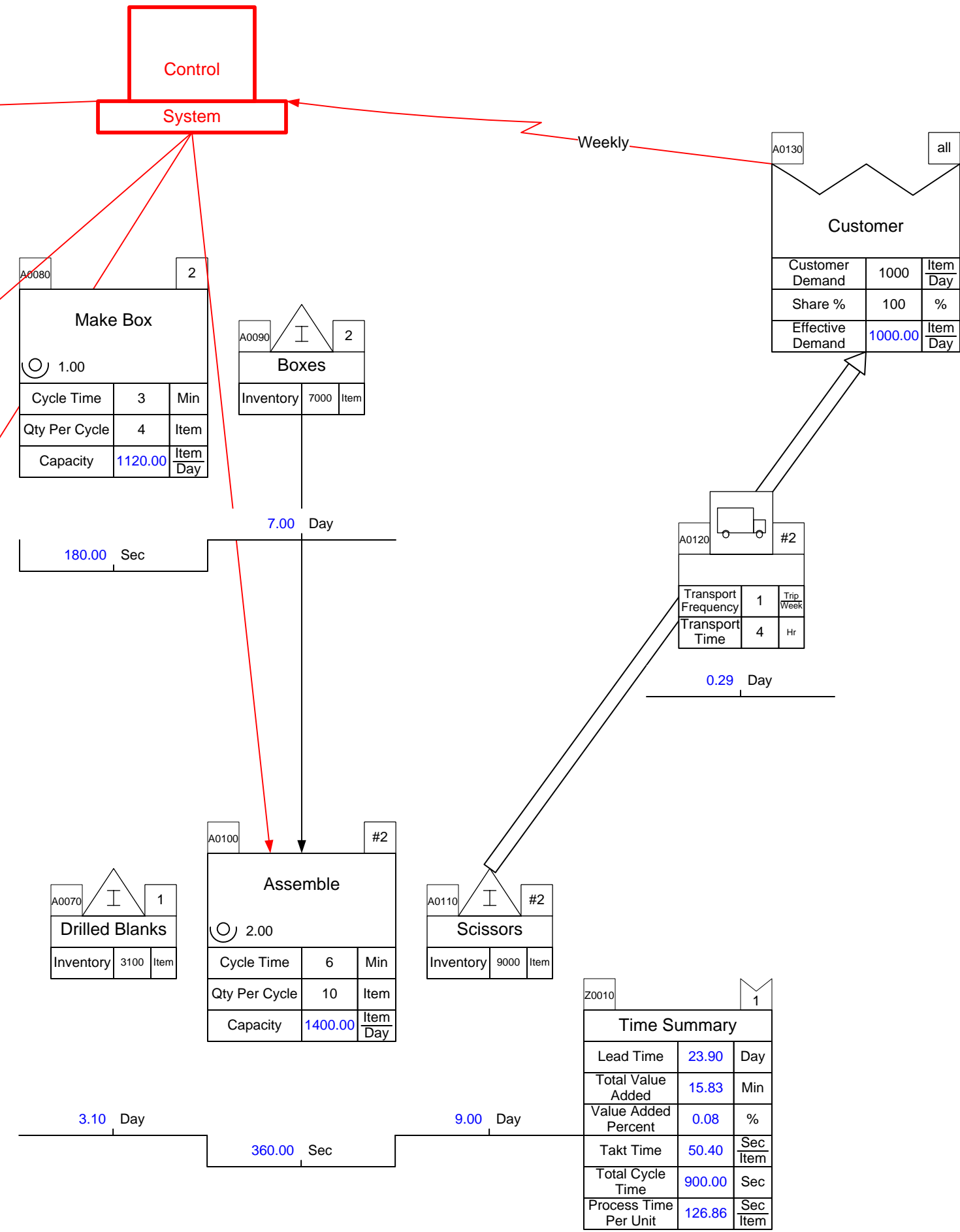
Answer:

Sharing the Sharpen station brings its availability very close to Takt Time, leaving little to no room for planned/unplanned downtime. It would be best to not share the Sharpen station as it's currently configured.



Units	Year	Week	Week
	52	70	5
	Week	Hr	day

Availability change – two hours less than other stations



Time Summary	
Lead Time	23.90 Day
Total Value Added	15.83 Min
Value Added Percent	0.08 %
Takt Time	50.40 Sec/Item
Total Cycle Time	900.00 Sec
Process Time Per Unit	126.86 Sec/Item