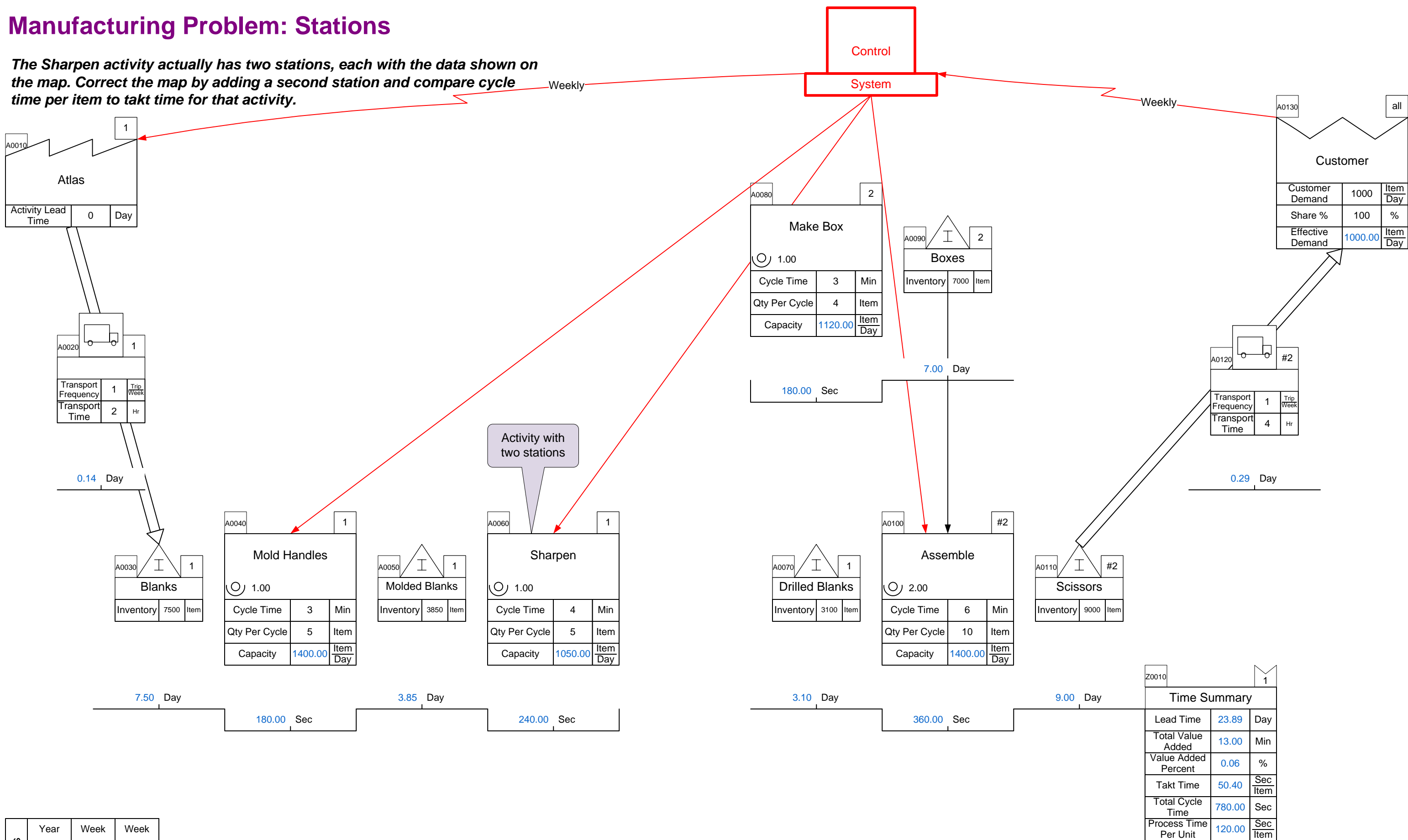


Manufacturing Problem: Stations

The Sharpen activity actually has two stations, each with the data shown on the map. Correct the map by adding a second station and compare cycle time per item to takt time for that activity.



Units	Year	Week	Week
	52	70	5
	Week	Hr	day

Z0010			1
Time Summary			
Lead Time	23.89	Day	
Total Value Added	13.00	Min	
Value Added Percent	0.06	%	
Takt Time	50.40	Sec/Item	
Total Cycle Time	780.00	Sec	
Process Time Per Unit	120.00	Sec/Item	

Manufacturing Solution: Stations

The Sharpen activity actually has two stations, each with the data shown on the map. Correct the map by adding a second station and compare cycle time per item to takt time for that activity.

