|  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | c9 | | NAME OF ASSEMBLY |  |
| Part ID | # the operation is carriedout consecutively | Manual handling code | Manual handling time per part | Manual insertion code | Manual insertion time per part | Insertion direction | Operation time  c2 (c4+c6+c7) | Operation costs  0,4 X c8 | | . . . . . . . . . . . . . . . . . . . . . .    . . . . . . . . . . . . . . . . . . . . . .    . . . . . . . . . . . . . . . . . . . . . .    . . . . . . . . . . . . . . . . . . . . . .    . . . . . . . . . . . . . . . . . . . . . . |  |
| 1 | 1 | 1.3 | 2,2 | 0,3 | 2,0 | 0 | 4,2 | 0,0 | | opvangbak | 360/360720 |
| 2 | 1 | 3.3 | 2,5 | 0,3 | 2,0 | 0 | 4,5 | 0,0 | | Bak | 360/360720 |
| 3 | 1 | 0.3 | 1.9 | 0,4 | 4,5 | 4 | 6,5 | 0,4 | | Rooster kolen | 360/360  720 |
| 4 | 1 | 0.2 | 1.8 | 0,0 | 1,5 | 0 | 3,3 | 0,0 | | Rooster eten | 360/180  540 |
| 5 | 1 | 1.1 | 1.6 | 0,0 | 1,5 | 1 | 3,1 | 5,0 | | Karabijnhaak | 180/180360 |
| 6 | 1 | 3.2 | 2.4 | 8,3 | 6,0 | 1 | 8,4 | 5,0 | | Luchtregeling | 180/360540 |
| 7 | 2 | 3.3 | 2.5 | 8,4 | 8,5 | 1 | 11 | 5,0 | | Handvaten | 360/360720 |
| 8 | 1 | 3.3 | 2,5 | 0,3 | 2,0 | 0 | 4,5 | 0,0 | | Rand van Bak | 360/360  720 |
|  |  |  |  |  |  |  |  |  | |  |  |
|  |  |  |  |  |  |  |  |  | |  |  |
|  |  |  |  |  |  |  |  |  | |  |  |
| **Total:** | | | | | | | 45,5 minuten | 15,4 | |  |  |
|  | |