|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel**    |  |  |  |  |  |  |  |  |  |
| **c1**  | **c2**  | **c3\***   | **c4\***  | **c5\***  | **c6\***  | **c7\***  | **c8**  | **C9**  | **C10**  | **c11\*\***  | **NAME OF ASSEMBLY**  |
| Part ID  | Alpha & Bêta symmetry   | # the operation is carried out consecutively | Manual handling code  | Manual handling time per part  | Manual insertion code  | Manual insertion time per part  | Insertion direction time  | Montage process time  | Operation time  C3 (c5+c7+c8+c9)  | Estimation for theoretical minimum parts  | **SAMEN-****STELLINGS TEKENING BBQ** |
| Bak van de barbecue | 540  | 1  | 2,5  | 6,5  | 5,0  | 6,5  | 2,0 | 0,0  | 22,5 sec.  | 0,0  |  |
| Kolenladen van de barbecue  | 360  | 1  | 1,8  | 6,5  | 5,0  | 6,5  | 3,2  | 0,0  | 23 sec.  | 0,0  |  |
| Spatel luchtregeling | 320  | 2 | 1,4  | 6,5  | 5,0  | 6,5  | 4,4  | 0,0  | 47,6 sec.  | 0,0  |  |
| Klem voor hout  | 540  | 2 | 2,1  | 6,5  | 5,0  | 6,5  | 1,8 | 0,0  | 43,8 sec.  | 0,0  |  |
| Plaat voor puntlassen rechthoekig | 540  | 2 | 2,1  | 6,5  | 5,0  | 6,5  | 1,4  | 0,0  | 43 sec.  | 0,0  |  |
| Plaat voor puntlassen 135 graden | 720  | 4  | 2,2  | 6,5  | 5,0  | 6,5  | 2,5 | 0,0  | 90,8 sec.  | 0,0  |  |
| Houten handvaten | 540  | 2 | 2,1  | 6,5  | 5,0  | 6,5  | 1,0  | 0,0  | 42,2 sec.  | 0,0  |  |
| Hout voor balustrade  | 320 | 1 | 2,1 | 6,5 | 5,0  | 6,5  | 1,0 | 0,0  | 21,1 sec. | 0,0  |  |
|  |  |  |  |  |  **Total:**  | 17,3  | 0,0  |   | 0,0  | 334 sec. |