|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **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. |