



\* Every 6<sup>th</sup> SKIN

| #             | WORK STEP                       | MACH TIME | WORK TIME | WAIT TIME | WALK TIME |
|---------------|---------------------------------|-----------|-----------|-----------|-----------|
| 1             | Pick UP I/P INSERT              |           | 2         |           | 2         |
| 2             | FOLD FILM BACK Set Entire JUSCO |           | 14        |           |           |
| 3             | UNDO ALL Tachis                 |           | 11        |           |           |
| 4             | OPEN MOLD & Demold R. Side      |           | 4         |           |           |
| 5             | Close MOLD / Quality Check      |           | 5         |           | 3         |
| 6             | REMOVE SKIN FROM OVEN           |           | 4         |           | 3         |
| 7             | SET ENTIRE SKIN                 |           | 50        |           |           |
| 8             | Q.C. SKIN Set                   |           | 3         |           | 2         |
| 9             | DEFLASH & INSTALL GARNISH HANG  |           | 37        |           |           |
| 10            | ON CAROUSEL                     |           | 2         |           |           |
| 11            | LOAD OVEN & MOVE Jigs           |           | 8         |           |           |
| 12            | Return to Start                 |           |           |           | 3         |
| COLLUM TOTALS |                                 |           | 140       | 15"       | 13"       |
| CYCLE TIME    |                                 |           | 168"      |           |           |
|               |                                 |           | 91%       |           |           |