

# TIME STUDY

## Using EXCEL 2016

Time Study Sheet (Polo Shirt)

Standard Minute Value (SMV)

Operation Name	Machine [M/C]	Cycle Time (Second)					Average [second]	Average [Minute]	SMV with Allowance
		1	2	3	4	5			
Back & Front Part Arrange	Manual	11	9	9	10	11	10	0.17	0.38
Shoulder Join	OL-4TH	9	9	11	9	10	9.6	0.16	0.39
Side Label Attach	SM	13	14	13	12	13	13	0.22	0.45
Body Mark	Manual	15	14	22	13	16	16	0.27	0.48
Sleeve Hem	FL-FB	8	8	7	8	9	8	0.13	0.37
Body Arrange & Sleeve Hem Cut	Manual	10	10	7	12	9	9.6	0.16	0.38
Sleeve Shearing	SM	10	8	10	10	10	9.6	0.16	0.39
Sleeve Join	OL-4TH	49	47	45	46	45	46.4	0.77	1.01
Placket Rolling	SM	11	9	9	9	9	9.4	0.16	0.39
Placket Mark	Manual	9	9	12	11	10	10.2	0.17	0.39
Placket Join	SM	26	26	24	25	24	25	0.42	0.65
Placket Scissoring	Manual	11	10	15	10	12	11.6	0.19	0.41

SMV	8.89	Minute for Making a Polo Shirt
SMV with Allowances	15.71	

Expected Allowances

Personal Allowance	5	Second
Machine Allowance	6	
Process Allowance	8	

**Note:**

- Personal Allowance is with Manual Operation
- Machine Allowance is with Machine Operation
- Process Allowance is with both Manual & Machine

# Industrial Engineering Time Motion Study Formula

**George Hugh Shepard**



**Industrial Engineering Time Motion Study Formula:**

## Adopting the Beat of Term: An Psychological Symphony within **Industrial Engineering Time Motion Study Formula**

In some sort of used by screens and the ceaseless chatter of instant connection, the melodic splendor and emotional symphony created by the published term frequently fade into the back ground, eclipsed by the constant noise and interruptions that permeate our lives. However, nestled within the pages of **Industrial Engineering Time Motion Study Formula** a charming fictional value filled with fresh emotions, lies an immersive symphony waiting to be embraced. Crafted by a wonderful composer of language, that fascinating masterpiece conducts viewers on an emotional trip, well unraveling the hidden tunes and profound influence resonating within each cautiously crafted phrase. Within the depths with this touching assessment, we shall investigate the book is key harmonies, analyze its enthralling publishing fashion, and submit ourselves to the profound resonance that echoes in the depths of readers souls.

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