

# 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

**RD Boyd**



**Industrial Engineering Time Motion Study Formula:**

The book delves into Industrial Engineering Time Motion Study Formula. Industrial Engineering Time Motion Study Formula is an essential topic that needs to be grasped by everyone, from students and scholars to the general public. The book will furnish comprehensive and in-depth insights into Industrial Engineering Time Motion Study Formula, encompassing both the fundamentals and more intricate discussions.

1. This book is structured into several chapters, namely:
    - Chapter 1: Introduction to Industrial Engineering Time Motion Study Formula
    - Chapter 2: Essential Elements of Industrial Engineering Time Motion Study Formula
    - Chapter 3: Industrial Engineering Time Motion Study Formula in Everyday Life
    - Chapter 4: Industrial Engineering Time Motion Study Formula in Specific Contexts
    - Chapter 5: Conclusion
  2. In chapter 1, this book will provide an overview of Industrial Engineering Time Motion Study Formula. The first chapter will explore what Industrial Engineering Time Motion Study Formula is, why Industrial Engineering Time Motion Study Formula is vital, and how to effectively learn about Industrial Engineering Time Motion Study Formula.
  3. In chapter 2, the author will delve into the foundational concepts of Industrial Engineering Time Motion Study Formula. This chapter will elucidate the essential principles that need to be understood to grasp Industrial Engineering Time Motion Study Formula in its entirety.
  4. In chapter 3, this book will examine the practical applications of Industrial Engineering Time Motion Study Formula in daily life. This chapter will showcase real-world examples of how Industrial Engineering Time Motion Study Formula can be effectively utilized in everyday scenarios.
  5. In chapter 4, this book will scrutinize the relevance of Industrial Engineering Time Motion Study Formula in specific contexts. This chapter will explore how Industrial Engineering Time Motion Study Formula is applied in specialized fields, such as education, business, and technology.
  6. In chapter 5, this book will draw a conclusion about Industrial Engineering Time Motion Study Formula. The final chapter will summarize the key points that have been discussed throughout the book.
- The book is crafted in an easy-to-understand language and is complemented by engaging illustrations. It is highly recommended for anyone seeking to gain a comprehensive understanding of Industrial Engineering Time Motion Study Formula.

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