

Example on Man Machine Chart (Improved Method)

TIME (MIN)	MAN		MACHINE	TIME (MIN)
0.2	REMOVED FINISHED CASTING CLEANS WITH COMPRESSED AIR		IDLE	0.2
0.4	CLEAN MACHINE WITH COMPRESSED AIR		IDLE	0.4
0.6	LOCATES A NEW CASTING IN A FIXTURE START MACHINE		IDLE	0.6
0.8	BREAKS SHARP EDGES WITH FILES CLEANS WITH COMPRESSED AIR		CUTTING SLOT 1	0.8
1.0	GAUGE DEPTH OF SLOT ON SURFACE PLATE		CUTTING SLOT 2	1.0
1.2	PLACES CASTING IN A BOX PICKS UP NEW CASTING AND PLATE BY MACHINE		CUTTING SLOT 3	1.2
1.4	IDLE		CUTTING SLOT 4	1.4

Man Machine Chart

Marco Cascella



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