

# 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

**Daniel F McAuley**



**Industrial Engineering Time Motion Study Formula:**

Industrial Engineering Time Motion Study Formula: Bestsellers in 2023 The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous captivating novels captivating the hearts of readers worldwide. Lets delve into the realm of top-selling books, exploring the engaging narratives that have captivated audiences this year. The Must-Read : Colleen Hoover "It Ends with Us" This poignant tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover skillfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can triumph. Industrial Engineering Time Motion Study Formula : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids captivating storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Industrial Engineering Time Motion Study Formula : Delia Owens "Where the Crawdads Sing" This evocative coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens weaves a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These popular novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a exceptional and gripping novel that will keep you guessing until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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## **Table of Contents Industrial Engineering Time Motion Study Formula**

1. Understanding the eBook Industrial Engineering Time Motion Study Formula
  - The Rise of Digital Reading Industrial Engineering Time Motion Study Formula
  - Advantages of eBooks Over Traditional Books
2. Identifying Industrial Engineering Time Motion Study Formula
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Industrial Engineering Time Motion Study Formula
  - User-Friendly Interface
4. Exploring eBook Recommendations from Industrial Engineering Time Motion Study Formula
  - Personalized Recommendations
  - Industrial Engineering Time Motion Study Formula User Reviews and Ratings
  - Industrial Engineering Time Motion Study Formula and Bestseller Lists
5. Accessing Industrial Engineering Time Motion Study Formula Free and Paid eBooks
  - Industrial Engineering Time Motion Study Formula Public Domain eBooks
  - Industrial Engineering Time Motion Study Formula eBook Subscription Services
  - Industrial Engineering Time Motion Study Formula Budget-Friendly Options
6. Navigating Industrial Engineering Time Motion Study Formula eBook Formats
  - ePub, PDF, MOBI, and More
  - Industrial Engineering Time Motion Study Formula Compatibility with Devices
  - Industrial Engineering Time Motion Study Formula Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Industrial Engineering Time Motion Study Formula
  - Highlighting and Note-Taking Industrial Engineering Time Motion Study Formula
  - Interactive Elements Industrial Engineering Time Motion Study Formula
8. Staying Engaged with Industrial Engineering Time Motion Study Formula

- Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Industrial Engineering Time Motion Study Formula
9. Balancing eBooks and Physical Books Industrial Engineering Time Motion Study Formula
- Benefits of a Digital Library
  - Creating a Diverse Reading Collection Industrial Engineering Time Motion Study Formula
10. Overcoming Reading Challenges
- Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Industrial Engineering Time Motion Study Formula
- Setting Reading Goals Industrial Engineering Time Motion Study Formula
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Industrial Engineering Time Motion Study Formula
- Fact-Checking eBook Content of Industrial Engineering Time Motion Study Formula
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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