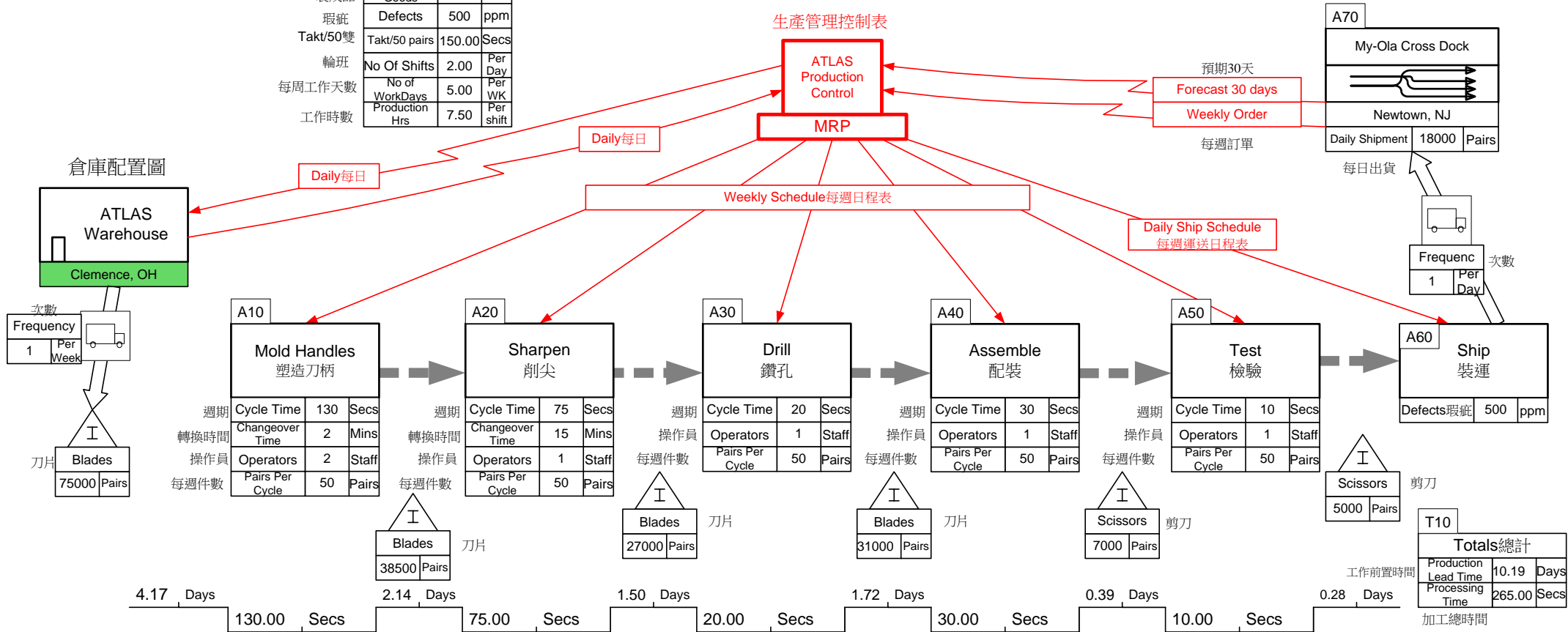


| Wks  | Days   | Shifts | Hrs  | Mins |
|------|--------|--------|------|------|
| 5    | 2      | 7.5    | 60   | 60   |
| Days | Shifts | Hrs    | Mins | Secs |

|          |                  |        |           |  |                   |
|----------|------------------|--------|-----------|--|-------------------|
|          |                  |        |           |  | T20               |
|          |                  |        |           |  | ATLAS             |
|          |                  |        |           |  | Scissors Assembly |
|          |                  |        |           |  | Clemence, OH      |
| 原物料      | Raw Materials    | 62.50  | Hrs       |  |                   |
| 在製品      | Work In Progress | 86.25  | Hrs       |  |                   |
| 製成品      | Finished Goods   | 4.17   | Hrs       |  |                   |
| 瑕疵       | Defects          | 500    | ppm       |  |                   |
| Takt/50雙 | Takt/50 pairs    | 150.00 | Secs      |  |                   |
| 輪班       | No Of Shifts     | 2.00   | Per Day   |  |                   |
| 每周工作天數   | No of WorkDays   | 5.00   | Per WK    |  |                   |
| 工作時數     | Production Hrs   | 7.50   | Per shift |  |                   |

剪刀裝配生管圖



## 剪刀之生產管理控制圖

製作日期：97 年 8/13