Tag	Operation	INV	INV	Text	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data	Data
		blades	scissors	Text01	changeover time	cycle time	defects	defects瑕疵	finished goods	no of shifts	no of workdays	operators	pairs per cycle	processing time	production hrs	production lead time	raw materials	takt/50 pairs	work in progress
		pairs	pairs	Text	mins	secs	ppm	ppm	hrs	per day	per wk	staff	pairs	secs	per shift	days	hrs	secs	hrs
A010	Mold Handles 塑造刀柄	75000.00			2.00	130.00						2.00	50.00						
A020	Sharpen 削尖	38500.00			15.00	75.00						1.00	50.00						
A030	Drill 鑽孔	27000.00				20.00						1.00	50.00						
A040	Assemble 裝配	31000.00				30.00						1.00	50.00						
A050	Test 檢驗		7000.00			10.00						1.00	50.00						
A060	Ship 裝運		5000.00					500.00											
A070	My-Ola Cross Dock																		
T010	Totals總計													265.00		10.19			
T020	ATLAS Scissors Assembly			Clemence, OH			500.00		4.17	2.00	5.00				7.50		62.50	150.00	86.25