Process Observation

Measuring the Process

CannaV Inc

PathStone Group

CannaV Inc.

The CBD Vapes are packed in Tubes:

3 units per tube
Tube is labelled
24 Tubes in a case
10-hour shift

Machine can label at 35 units per minute.
The operator load and unload labelling machine manually.

The intention is to standardize the work and set up a productivity target for this operation.

We are going to measure with the best (fastest) operator. It takes about 1 min to reload the Kanban bin.

Use the template to record data, rate the factors, and calculate a potential target for this operation.

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Process Observation Worksheet

									Ave Obs Time (sec)	Ave Obs Time (min)	Normal Time (min)	Standard Time (min)	Target Tubes/hr
							UOM						**Tubes**
Operator ID	Task / Operation	Type of Operation	Cycle Time (seconds)								
			1	2	3	4	5						
	Load the tube with 3 vapes cartages	Manual	45	55	54	44	49		49.40	0.82	0.91	0.018	33,125
	Load machine, label and unload	Process	76	77	79	67	68		73.40	1.22	1.35	0.027	22,294
	Place 24 tubes in the box	Manual	77	89	88	78	75		81.40	1.36	1.49	0.030	20,103

Sample Size

Preliminary mean of observation time	
Standard deviation of observed time	
Confidence level required (z Value)	
Maximum acceptable error	

	Performance Rating Factor	Allowance Factor
Manual Operation	110%	2%
Machine Operation	100%	2%
Process (Manual+Machine)	110%	2%

Working Hours	10.00

Total Cycle Time	204.2	sec
	3.40	min
Total Normal Cylce Time	3.74	min
Total Standard Cylce Time	0.07	min
Expected Target	25,174	Tubes/hr

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