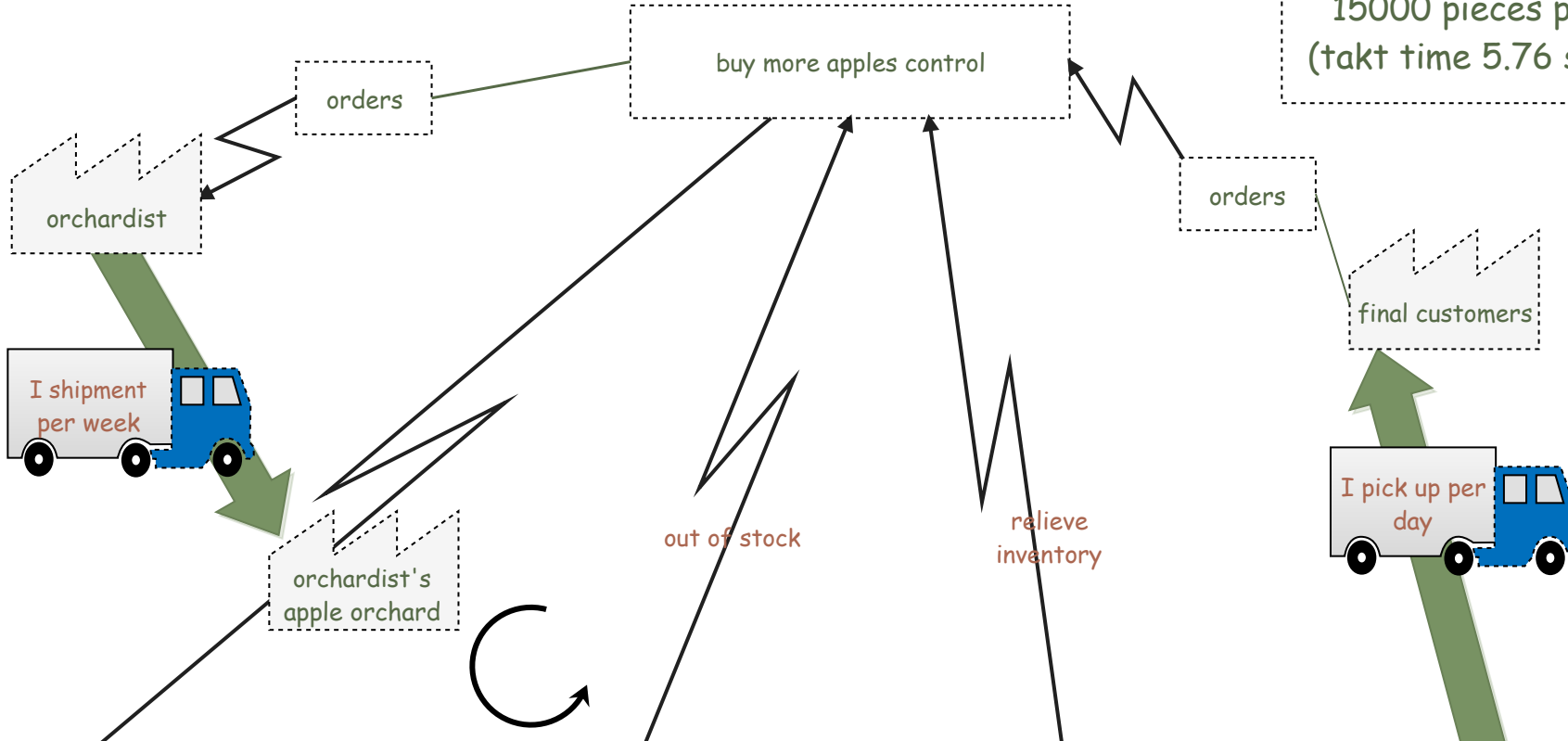


**Customer Demand**  
15000 pieces per day  
(takt time 5.76 seconds)



Inventory	Stage	Inventory	Stage	Inventory	Stage	Inventory
1000	sales process	1000	fulfillment	1000	packing	6480
90 min	cycle time 4 min VA CT 3 min	1000	cycle time: 2 min VA CT 0.5 min NVA CT 1.5 min	1000	cycle time: 3 min VA CT 2.5 min	720 hr

total cycle time = 1.5 hr  
total VA cycle time = 0.1 hr  
total NVA cycle time = 0.05hr  
lead time = 30.203 days  
WIP time = 0.1408 days  
total distance =

