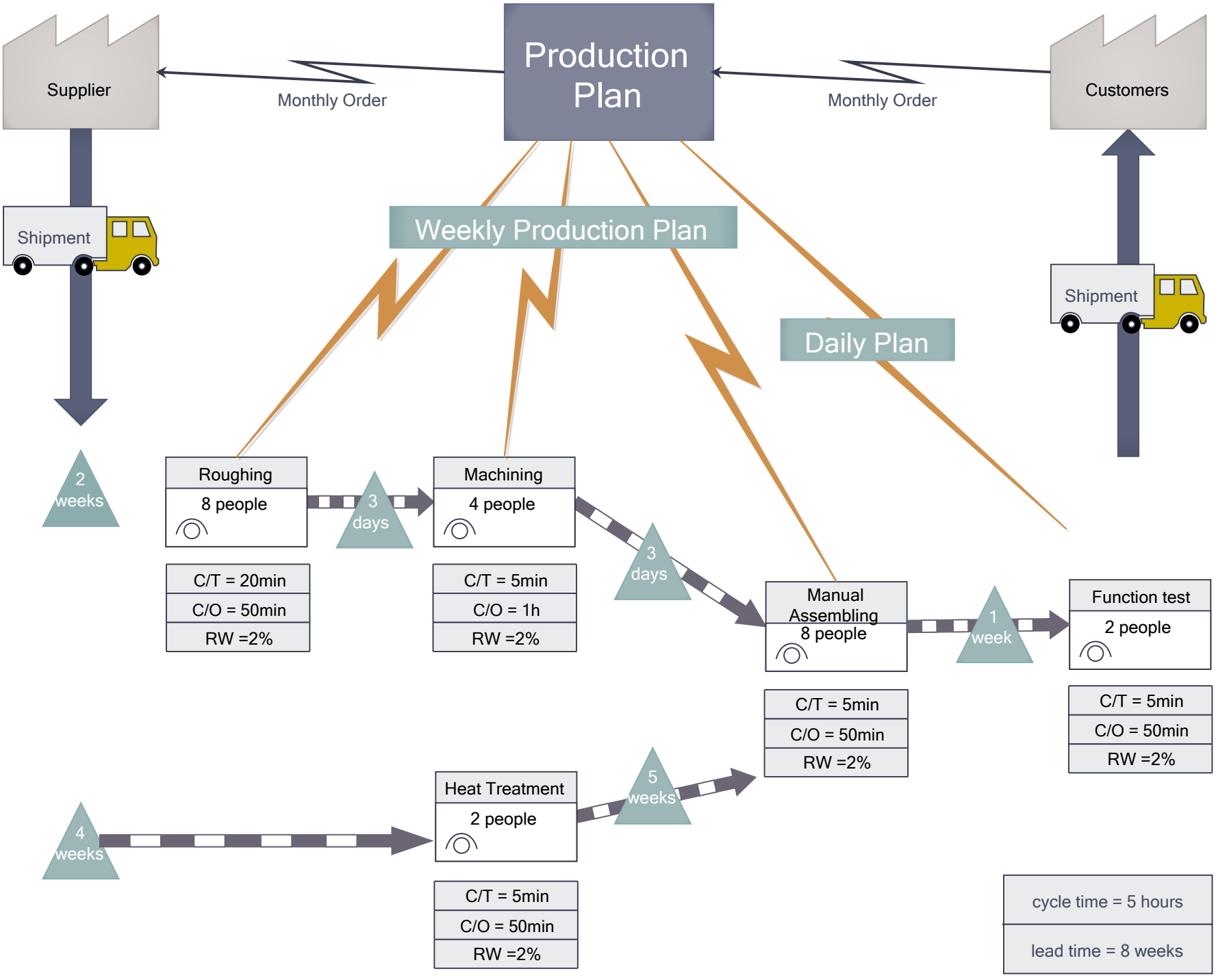
Supplier
Monthly Order
Production Plan
Monthly Order
Customers
Shipment
Weekly Production Plan
Daily Plan
Shipment
2 weeks
Roughing
8 people
3 days
Machining
4 people
3 days
Manual Assembling
8 people
1 week
Function test
2 people
C/T = 20min
C/O = 50min
RW =2%
C/T = 5min
C/O = 1h
RW =2%
C/T = 5min
C/O = 50min
RW =2%
C/T = 5min
C/O = 50min
RW =2%
4 weeks
Heat Treatment
2 people
5 weeks
C/T = 5min
C/O = 50min
RW =2%
cycle time = 5 hours
lead time = 8 weeks