|  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | | |
| c1 | C2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF ASSEMBLY |
| Part ID | Alpha & Bêta symmetry | # the operation is carried out consecutively | Manual handling code | Manual handling time per part | Manual insertion code | Manual insertion time per part | Insertion direction time | Montage process time | Operation time  C3 (c5+c7+c8+c9) | Operation costs  0,4 X c10 |  |
| 1 | 720 | 2 | 3.3 | 2.5 | 0.8 | 6.5 | 0.4 | 5.0 | 28.8 | 11.52 | 1 Buiten gedeelte BBQ L+R |
| 2 | 540 | 1 | 2.3 | 2.4 | 0.6 | 5.5 | 0.0 | 4.0 | 11.9 | 4.76 | 2 Bakje voor de kolen op te vangen |
| 3 | 540 | 1 | 2.3 | 2.4 | 0.2 | 2.5 | 0.0 | 4.0 | 8.9 | 3.56 | 3 Plaat waar kolen op komen |
| 4 | 540 | 1 | 2.3 | 2.4 | 0.0 | 1.5 | 0.0 | 4.0 | 7.9 | 3.16 | 4 Rooster |
| 5 | 360 | 2 | 1.3 | 2.1 | 1.6 | 8.0 | 0.4 | 5.0 | 31.0 | 12.4 | 5 Plaatje voor aan de zijkant |
| 6 | 720 | 2 | 3.3 | 2.5 | 1.0 | 4.0 | 0.0 | 4.0 | 21 | 8.4 | 6 Zuurstofregelaar |
| ~~7~~ | ~~720~~ | ~~2~~ | ~~3.3~~ | ~~2.5~~ | ~~-~~ | ~~-~~ | ~~-~~ | ~~-~~ | ~~-~~ | ~~-~~ | ~~7 Handvat~~ |
| 8 |  |  |  |  |  |  |  |  |  |  |  |
| 9 |  |  |  |  |  |  |  |  |  |  |  |
| 10 |  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
| **Total:** | | | | | | |  |  | 109.5  00:01:49:50 | 43.8 |  |

* DFA tabel in de volgorde van de werktekening
* Handvat is onneembaar en is los van de BBQ