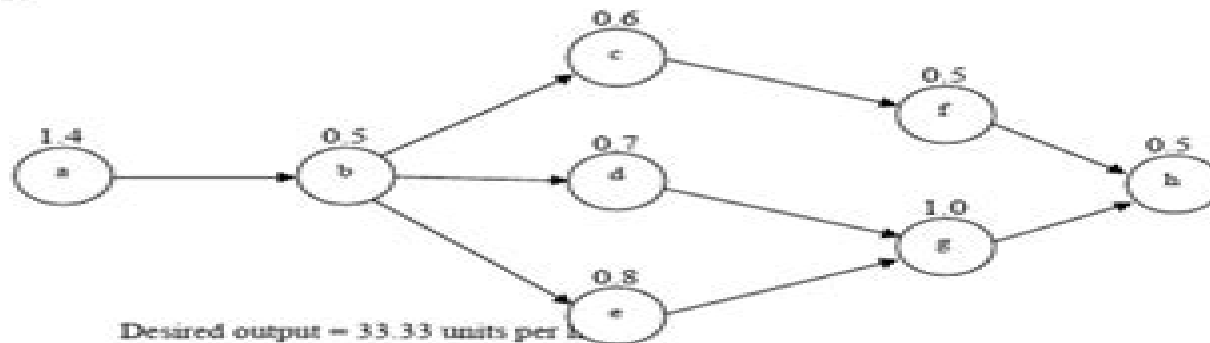


Chapter 6 Solutions

1. OT = 450 minutes
 - a. Minimum cycle time = length of longest task, which is 2.4 minutes.
Maximum cycle time = Σ task times = 18 minutes.
 - b. Range of output:
 @ 2.4 min.: $\frac{450}{2.4} = 187.5$ units
 @ 18 min.: $\frac{450}{18} = 25$ units
 - c. $N = \frac{D \times \Sigma t}{OT} = \frac{187.5(18)}{450} = 7.5$, which rounds to 8
 - d. Output = $\frac{OT}{CT}$ Solving for CT, $CT = \frac{450}{125} = 3.6$ minutes per cycle
 - e. Potential output:
 (1) CT = 9 min.: $\frac{OT}{CT} = \frac{450}{9} = 50$ units
 (2) CT = 15 min.: $\frac{450}{15} = 30$ units

2.



Desired output = 33.33 units per hour

Operating time = 60 minutes per hour

$$CT = \frac{\text{Operating time}}{\text{Desired output}} = \frac{60 \text{ minutes per hour}}{33.33 \text{ units per hour}} = 1.80 \text{ minutes per unit}$$

Solutions (continued)

a.

Task	Number of following tasks	Positional Weight
A	7	6
B	6	4.6

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