**DFA, barbecue project**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF SUB 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) Barbecue bak |
| 1.1 | 720 | 1 | 3/3 | 2,5 | 2/0 | 2,5 | 0,0 | 0,0 | 5 | 2 | Buitenbak |
| 1.3 | 450 | 1 | 3/2 | 2,1 | 2/1 | 5,0 | 1,0 | 7,0 | 15,1 | 6,04 | Bodembak |
| 2.4 | 720 | 1 | 0/3 | 1,9 | 2/0 | 2,5 | 0,0 | 7,0 | 11,4 | 4,56 | Klemmetje |
| 2.3 | 720 | 2 | 3/3 | 2,5 | 2/0 | 2,5 | 0,4 | 0,0 | 10,8 | 4,32 | Handvat |
| 3.1 | 360 | 4 | 8,6 | 8,0 | 9,3 | 8,0 | 0,0 | 5,0 | 84 | 33,6 | Schroeven M6 20mm |
| **Total:** | | | | | | |  |  | 126,3 | 50,52 |  |

(Dit document bevat 3 sub-assemblies en 1 assembly van de hele barbecue)

**Sub-assembly 1**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF SUB 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 | 2) Barbecue Rooster |
| 2.1 | 360 | 1 | 3/1 | 1,7 | 2/0 | 2,5 | 0,0 | 0,0 | 4,2 | 1,68 | Rooster |
| 2.3 | 720 | 2 | 3/3 | 2,5 | 2/0 | 2,5 | 0,5 | 0,0 | 11 | 4,4 | Handvat |
| 3.1 | 360 | 4 | 8,6 | 8,0 | 9,3 | 8,0 | 0,0 | 5,0 | 84 | 33,6 | Schroeven M6 20mm |
| **Total:** | | | | | | |  |  | 99,2 | 39,68 |  |

**Sub-assembly 2**

**Sub-assembly 3**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF SUB 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 | 2) Barbecue Schuif |
| 2.2 | 540 | 1 | 3/2 | 2,4 | 2/1 | 5,0 | 0,4 | 0,0 | 7,8 | 3,12 | Schuif |
| 2.3 | 720 | 1 | 3/3 | 2,5 | 2/0 | 2,5 | 0,4 | 0,0 | 10,8 | 4,32 | Handvat |
| 3.1 | 360 | 2 | 8,6 | 8,0 | 9,3 | 8,0 | 0,0 | 5,0 | 42 | 16,8 | Schroeven M6 20mm |
| **Total:** | | | | | | |  |  | 60,6 | 24,24 |  |

**Barbecue assembly**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF SUB 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 | 2) Barbecue |
| 4.1 | 720 | 1 | 3/3 | 2,5 | 2/0 | 2,5 | 0,0 | 0,0 | 5 | 2 | Barbecue bak |
| 4.2 | 360 | 1 | 3/1 | 2,1 | 2/0 | 2,5 | 0,0 | 0,0 | 4,6 | 1,84 | Barbecue rooster |
| 4.3 | 540 | 1 | 3/2 | 2,4 | 2/2 | 6,5 | 0,0 | 0,0 | 8,9 | 3.56 | Barbecue schuif |
| 1.2 | 540 | 1 | 3/2 | 2,4 | 2/0 | 2,5 | 0,0 | 0,0 | 2,9 | 1.16 | Binnenbak |
| **Total:** | | | | | | |  |  | 20,8 | 8,32 |  |

**Total operation time:** 306,9

**Total operation costs:** 122,76