**DFA koptelefoon Julian**

Total Operation time all subassembly’s + assembly: **747.60**
Total operation costs all subassembly’s + assembly: **299.04**

|  |
| --- |
| **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) Linker oordop |
| 3.1 | 720 | 1 | 3,0 | 1,9 | 3,0 | 2,0 | 0.4 | 5.0 | 9.3 | 3.72 | OorstukO |
| 2.2 | 720 | 1 | 3.3 | 1.8 | 3,0 | 2,0 | 0.4 | 5,0 | 9,2 | 3,68 | OorstukLB |
| 4.1 | 540 | 1 | 2,5 | 2.4 | 4,0 | 4,5 | 0.0 | 5,0 | 11,9 | 4,76 | Schuifknop |
| 5.3 | 360 | 6 | 6,2 | 5,5 | 1,2 | 5.0 | 0.4 | 12.0 | 137.4 | 54,96 | Verende kogel |
| 2.1 | 540 | 1 | 2,0 | 1,8 | 4,0 | 4,5 | 0.4 | 5,0 | 11,7 | 4,68 | OorstukLM |
| 5.1 | 360 | 2 | 0.5 | 1.8 | 3,2 | 4.0 | 1,0 | 5.0 | 23,6 | 9,44 | Schroef M5x80mm |
| 2.4 | 720 | 1 | 3,0 | 1.9 | 4,0 | 4,5 | 0.4 | 5.0 | 11,8 | 4,72 | Oorstuk B |
| 5.2 | 360 | 4 | 0,6 | 2.2 | 3,2 | 2,0 | 0.4 | 5,0 | 117,6 | 47,04 | Schroef M5x10mm |
| 3.2 | 540 | 1 | 2,0 | 1,8 | 0,0 | 1,5 | 0,4 | 12,0 | 15,7 | 6,28 | Oorstuk S |
| 4.2 | 360 | 1 | 0,0 | 1,1 | 1,5 | 2,0 | 0,4 | 12,0 | 15,5 | 6,20 | Vacuümgevormde oorklep |
| **Total:** |  |  | 399.7 | 159.88 |  |

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) Rechter oordop |
| 3.1 | 720 | 1 | 3,0 | 1,9 | 3,0 | 2,0 | 0.4 | 5.0 | 9.3 | 3.72 | OorstukO |
| 2.3 | 720 | 1 | 3.3 | 1.8 | 3,0 | 2,0 | 0.4 | 5,0 | 9,2 | 3,68 | OorstukRB |
| 2.4 | 720 | 1 | 3,0 | 1.9 | 4,0 | 4,5 | 0.4 | 5.0 | 11,8 | 4,72 | Oorstuk B |
| 5.3 | 360 | 1 | 6,2 | 5,5 | 1,2 | 5.0 | 0.4 | 12.0 | 22.9 | 9.16 | Verende kogel |
| 5.1 | 360 | 2 | 0.5 | 1.8 | 3,2 | 4.0 | 1,0 | 5.0 | 23,6 | 9,44 | Schroef M5x80mm |
| 5.2 | 360 | 4 | 0,6 | 2.2 | 3,2 | 2,0 | 0.4 | 5,0 | 117,6 | 47,04 | Schroef M5x10mm |
| 3.2 | 540 | 1 | 2,0 | 1,8 | 0,0 | 1,5 | 0,4 | 12,0 | 15,7 | 6,28 | OorstukS |
| 4.2 | 360 | 1 | 0,0 | 1,1 | 1,5 | 2,0 | 0,4 | 12,0 | 15,5 | 6,20 | Vacuümgevormde oorklep |
| **Total:** |  |  | 225,6 | 90,24 |  |

Sub-Assembly 2

|  |
| --- |
| **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 | 3) hele Hoofdband |
| 1.2 | 540 | 1 | 2,0 | 1,8 | 0,8 | 6,5 | 0,4 | 5,0 | 13,7 | 5,48 | Hoofdband |
| 1.1 | 720 | 2 | 2,0 | 1,8 | 0,8 | 6,5 | 0,4 | 5,0 | 27,4 | 10,96 | Halve hoofdband |
| 5.3 | 360 | 2 | 6,2 | 5,5 | 1,2 | 5.0 | 0,0 | 12,0 | 45 | 18 | Verende kogel |
| **Total:** |  |  | 86.1 | 34,44 |  |

Sub-Assembly 3

|  |
| --- |
| **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 | 4) Koptelefoon |
| 1 | 720 | 1 | 3,0 | 1,9 | 0,3 | 3,5 | 0,0 | 5,0 | 10,4 | 4,16 | Linker oordop |
| 2 | 720 | 1 | 3,0 | 1,9 | 0,9 | 7,5 | 0,0 | 5,0 | 14,4 | 5,76 | Hele hoofdband |
| 3 | 720 | 1 | 3,0 | 1,9 | 0,3 | 3,5 | 1,0 | 5,0 | 11,4 | 4,56 | Rechter oordop |
| **Total:** |  |  | 36,2 | 14.48 |  |

Assembly Koptelefoon