**DFA, BBQ project**

|  |
| --- |
| **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 |  |
| Onderste bak | 720 | 1 | 3 | 2 | 2 | 2 | 1 | 2 | 5 | 2 |  |
| rails | 270 | 1 | 2 | 2 | 2 | 5 | 1 | 6 | 15 | 6 |  |
| opberglade | 720 | 1 | 1 | 2 | 2 | 2 | 1 | 8 | 11 | 5 |  |
| kolenplaat | 720 | 2 | 2 | 3 | 2 | 2 | 1 | 0 | 10 | 3 |  |
| grill | 360 | 4 | 3 | 6 | 9 | 8 | 1 | 5 | 84 | 25 |  |
| Bovenste bak  | 720 | 1 | 2 | 4 | 6 | 3 | 6 | 2 | 23 | 50 |  |
| **Total:** | 11 | 128 | 148 | 91 |  |