

ELEMENT DETAIL

NO.	ELEMENT DESCRIPTION	CYCLE TIME												TOTAL TIME	NO. CYCLES	AVG.	RATING FACTOR	NORMAL TIME	
		1	2	3	4	5	6	7	8	9	10	11	12						
DETAIL OF DELAYS, METHODS VARIATIONS, FOREIGN ELEMENTS																			
A		L																	
B		M																	
C		N																	
D		O																	
E		Q																	
G		R																	
H		S																	
J		T																	
K		U																	
												NET CYCLE TIME =		ALLOWED NON-CYCLIC TIMES		MIN/PC.			
												TOTAL MIN/PC.							

**TIME STUDY OBSERVATION SHEET**

SHEET \_\_\_\_\_ OF \_\_\_\_\_  
AM/PM

OPERATOR'S NAME \_\_\_\_\_  
EMPLOYEE NO. \_\_\_\_\_

PRODUCTION TECHNOLOGY

DATE OF STUDY \_\_\_\_\_  
SHIFT \_\_\_\_\_

DEPT. NO. \_\_\_\_\_ DEPT. NAME \_\_\_\_\_  
PART NO. \_\_\_\_\_ OP NO. \_\_\_\_\_

STUDIED BY \_\_\_\_\_

VIDEO REF \_\_\_\_\_

PART NAME \_\_\_\_\_

EQUIPMENT SUMMARY \_\_\_\_\_

OPERATION DESCRIPTION \_\_\_\_\_

WORKPLACE SKETCH

**TOOLING DETAILS**

ALLOWANCES	MIN/SHIFT	MIN/JOB
1 PERSONAL		
2 FATIGUE		
3 DELAY		
4 SHIFT CLEANUP		
5 LUNCH CLEANUP		
6 CLOTHING		
7 EQUIPMENT		
8		
9		
10		
TOTAL		

**STUDY RECAP**

TOOL SKETCH

MIN/SHIFT - \_\_\_\_\_ ALLOWANCE  
 = NET AVAIL MINUTES/SHIFT \_\_\_\_\_  
 / TOTAL MINUTES PER PIECE \_\_\_\_\_  
 = NET SHIFT PROD \_\_\_\_\_ PCS.  
 NET SHIFT PROD / 8 = NET PCS/HOUR \_\_\_\_\_

1 / PCS./HR = \_\_\_\_\_ HRS./PC.  
 X 100 = \_\_\_\_\_ HRS./C PCS.  
 X 1000 = \_\_\_\_\_ HRS./M PCS.

NOTES:

**STUDY NO.**