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| DFA Tabel | | | | | | | | | | | |
| C1 | C2 | C3 | C4 | C5 | C6 | C7 | C8 | C9 | C10 | C11 |  |
| Part ID | ALPHA EN BETA 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 |  |  |
| Poot | 270 | 4 | 9.0 | 2.0 | 3.7 | 9.0 | 1.0 | 12 | 60 |  |  |
| rooster | 540 | 1 | 1 | 1.5 | 3.7 | 9.0 | 0 | 1 | 10.5 |  |  |
| Schroeven | 450 | 4 | 1.0 | 1.5 | 8.3 | 6.0 | 0.0 | 5.0 | 31.8 |  |  |
| BBQ Bak | 540 | 2 | 2.0 | 2.4 | 3.4 | 7.5 | 0.0 | 4.0 | 13.3 |  |  |
| Handvat | 540 | 1 | 3.2 | 2.4 | 3.4 | 7.5 | 0.4 | 5.0 | 15.3 |  |  |
| Lucht toevoer | 380 | 1 | 3.2 | 2.4 | 2.4 | 7.5 | 0.5 | 5.0 | 15.3 |  |  |
| Deksel | 720 | 1 | 0.3 | 1.9 | 3.4 | 7.5 | 0.0 | 4.0 | 13.4 |  |  |
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| totaal | | | | | | | 1.6 | 36 | 159.6 |  |  |