Gemba Research

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| PART NUMBER AND NAME | **STANDARD WORK COMBINATION SHEET** | DATE PREPARED | | DAILY DEMAND | | ~~~~~ WALKING |
|---|---|---|---|---|---|---|
| | | | | | | _____ MANUAL |
| WORK SEQUENCE | | WORK AREA | | TAKT TIME | | --------- AUTO |
| | | | | | | <===> WAITING |

| STEP | OPERATION | TIME MAN | TIME AUTO | TIME WALK | OPERATION TIME (SECONDS) 5 10 15 20 25 30 35 40 45 50 55 60 65 70 75 80 85 90 95 100 105 110 115 |
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