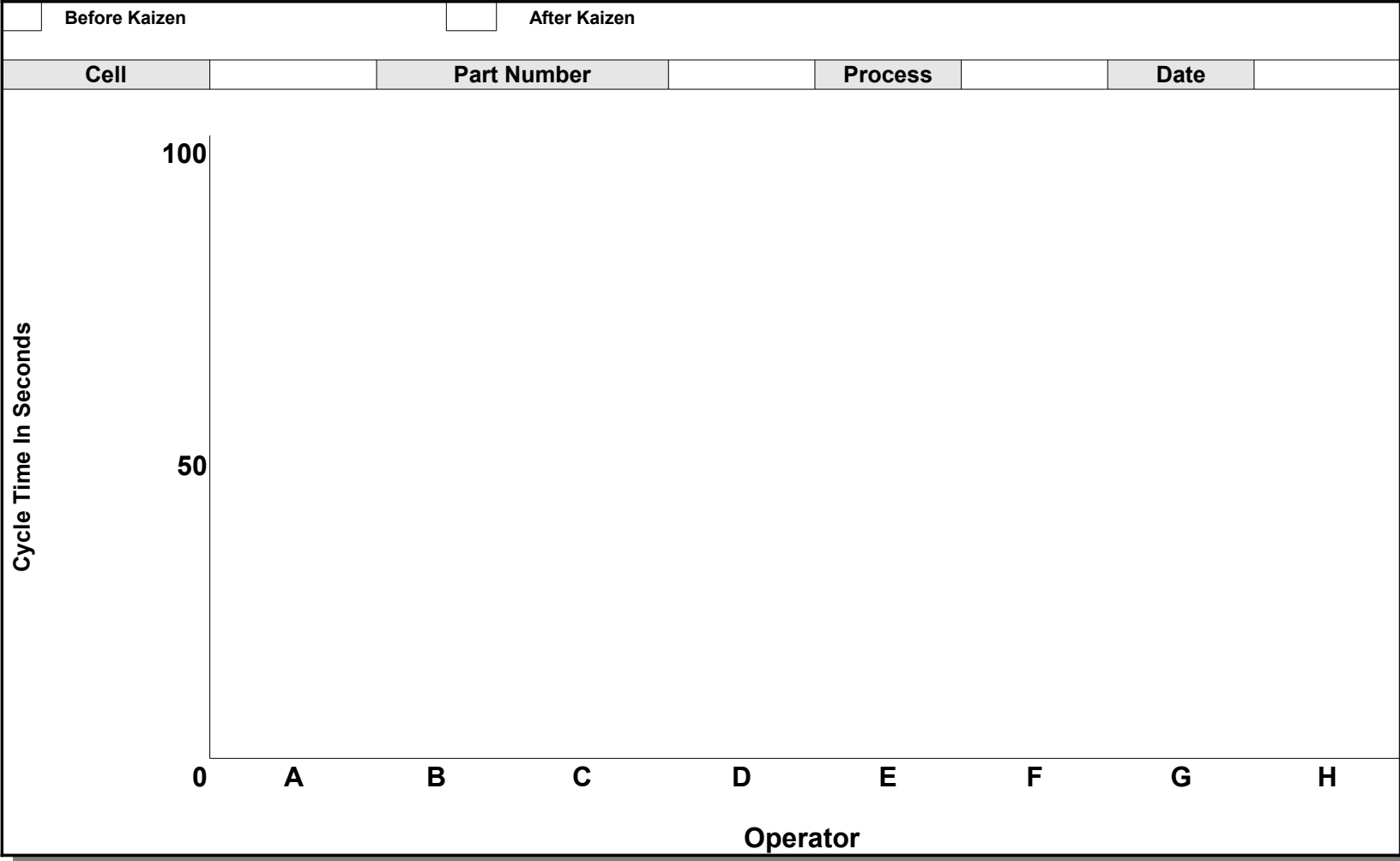


Cycle Time vs Takt Time Chart



- Note:
1. On the operator side (a through h) make a bar chart with the time for each operation
 2. Once you have that information, draw a horizontal line from the left side across with the takt time
 3. This will show you where you have operators fully loaded, and where the line needs to be balanced