

**PRE-MANUFACTURING TIME**

| <b>Time Element</b>                           | <b>Time</b> |
|---|-------------|
| Backlog Queue                                 |             |
| Master Scheduling                             |             |
| Material Acquisition (Administration)         |             |
| Material Acquisition Lead Time                |             |
| <i>(Longest Gating Lead Time Part #_____)</i> |             |
| Receiving                                     |             |
| Incoming Inspection                           |             |
| Delivery to Stock Room                        |             |
| Kit Material                                  |             |
| Deliver Material to Process Operation #1      |             |
| <b>Total Pre-Manufacturing Time</b>           |             |

*Use the unit of time (minute, hour, day, week) which most accurately represents the elapsed time. Be sure to identify the number of hours in the supplier's workday (8 hours, 16 hours, etc.), and the number of days in the supplier's work week (i.e.; 5, 6 or 7)*

## ESTIMATING MANUFACTURING TIME

This analysis must be completed for each operation.

|                  |  |
|------------------|--|
| Part Number      |  |
| Current Lot Size |  |
| Operation #      |  |
| Description      |  |

| <b>Sub-Element</b> | <b>Time</b> |
|--------------------|-------------|
| Setup Time         |             |
| Mfg. Process Time  |             |
| Queue Time         |             |
| Move Time          |             |
| <b>TOTAL</b>       |             |

**MANUFACTURING TIME SUMMARY**

|  | <b>Critical Path (Y/N)</b> | <b>Elapsed Time</b> |
|--|----------------------------|---------------------|
| <b>Operation #</b>   |                            |                     |
| <b>Operation #</b>   |                            |                     |
| <b>Operation #</b>   |                            |                     |
| <b>Operation #</b>   |                            |                     |
| <b>Manufacturing Critical Path Operation Time</b><br><i>(Sum of elapsed time for all "Y" critical operations)</i>                  |                            |                     |
| <b>Total Supplier Lead Time</b><br><i>(Sum of total pre-manufacturing time and the manufacturing critical path operation time)</i> |                            |                     |