## What is the timeline of the process to achieve the desired goal?

No.   Work Step										
Work Step	ne:						Product-No.:			
Work Step	rocess:				No. of Operators		Customer Takt:	Min/ Pc.	Cycle Time:	Min, Pc
	lo.	Work Step	Time Processing Machine Time Time	Routes						
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)										
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)										
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Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)										
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	2									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	3									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	1									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	5									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	5									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	7									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	3									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	)									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)	)									
Manual Labour Time Machine Time Routes Waiting Time Takt Time Net Time (red)		Total Time			Comment:					
(red)	ate:						Sigr	nature:		
		Manual Labour Time	Machine Tin	Machine Time			Waiting Time	Takt Time	Net Time	
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Product: