


# SHIFTS		Quantity	DEMAND		Pcs./Day	PRODUCTION TIME		Min/Day	Click here for the tutorial video! 	EMPLOYEE REQUIREMENTS LEAN - FLOW 11-1
TIME AVAILABLE		Min/Shift	TARGET BALANCING RATE		%	PLANNED CYCLE TIME		Min/Pcs.		
PLANNED DOWNTIME		Min/Shift	TARGET PRODUCTIVITY		%	CUSTOMER TAKT TIME		Min/Pcs.		

NO.	VARIANT	TOTAL TIME (MIN/PCS.)	NUMBER OF OPERATORS					
			1	2	3	4	5	6
1								
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12								
13								
14								
15								

Date:

Creator: