



Mountain Skies Business Consulting

Totals		CURRENT STATE	Cycle Time total Minutes/Hours	Changeover Time Minutes/Hours	Reliability % Average	First Pass Yield % Average	# of Operators	Distance Traveled Total Feet
Project: Test			135	100	68%	77%		1000
Department: Project			2.25	1.67				
Date: 1/1/01								
Step #	Step Description	Cycle Time (in minutes)	Changeover Time (in minutes)	Reliability %	First Pass Yield %	# of Operators	Distance Traveled (in feet)	
1	Initiate Paperwork	120	30	15%	95%	5	300	
2	Build Box	5	60	95%	85%	2	600	
3	Pack Box	10	10	95%	50%	1	100	
4								
5								
6								
7								
8								
9								
10								
11								
12								
13								
14								
15								
16								
17								
18								
19								
20								



Project: Test	
Department: Project	
Date: 1/1/01	
Number of Repetitions per Year	500
Average Hourly Employee Rate	\$16.00

Current/Future State Totals	Current State	Future State	Change	
			Minutes	Hours
Cycle Time	135	65	70	1.17
Changeover Time	100	55	45	0.75
Reliability	68%	75%	6.67%	
First Pass Yield	77%	97%	20.00%	
Distance Traveled	1000	500	500	
Total Cost to Implement		\$1,200.00		

Annual Cost Break Down			Annual Improvements
Cycle Time	\$18,000.00	\$8,666.67	\$9,333.33
Changeover Time	\$13,333.33	\$7,333.33	\$6,000.00
Total Dollar Improvement			\$15,333.33
Reliability Improvement			6.67%
First Pass Yield Improvement			20.00%
Distance Traveled Improvement			500
Break Even Repetitions			39.13