

Standardized Work 1: Process Capacity Sheet

Process Capacity Sheet		Approved by:		Part #		Application		Entered by:	Date
				Part name		Number of parts		Line	
Step	Step name	Machine #	BASIC TIME			TOOL CHANGE		PROCESSING CAPACITY/SHIFT	Remarks
			MANUAL	AUTO	COMPLETION	CHANGE	TIME		
		Total							

Example of Process Capacity Sheet (工程別能力表の例)

Process Capacity Sheet		Approved by: R. Quan		Part # 25-59001			Application JN-01		Entered by: Wayne Xi	Date May 08, 2007
				Part name Base Unit			Number of parts 1		Line Machine Shop #2	
Step	Step name	Machine #	BASIC TIME			TOOL CHANGE		PROCESSING CAPACITY/SHIFT	Remarks	
			MANUAL	AUTO	COMPLETION	CHANGE	TIME			
1	Cut	C100	6	32	38	500	2 min.	720 p		
2	Rough Grind	GR100	7	12	19	1,000	5 min.	1,440 p		
3	Fine Grind	GR200	7	30	37	200	5 min.	724 p		
4	Measure Diameter	TS 100	8	4	12	—	—	2,325 p		
		Total	28							

The Process Capacity Chart is used to calculate the capacity of each machine to confirm true capacity and to identify and eliminate bottlenecks. Processing capacity per shift will be calculated from the available production time, completion time, and tool-change time (and other factors as necessary) for each work piece.

工程別能力表は、生産能力を正しく把握してボトルネックを見つけ、改善するために、個々の設備の能力を計算するために使うものです。加工能力は、稼働時間、部品1個あたりの完成時間と刃具交換時間から計算します（必要に応じて、その他の条件を考慮する場合もあります）。