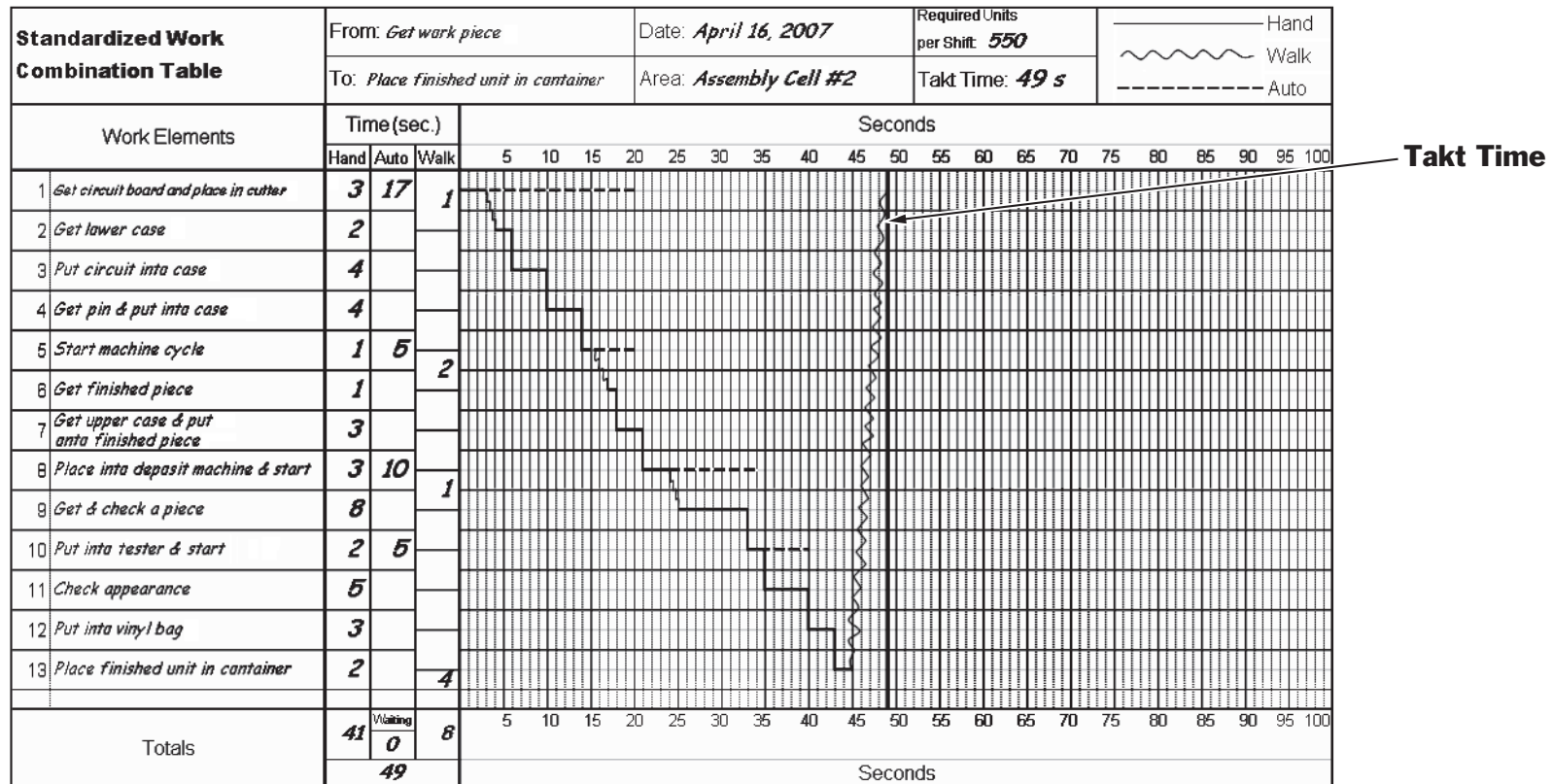


Standardized Work 2: Standardized Work Combination Table

Standardized Work Combination Table		From:		Date:		Required Units per Shift:		Hand Walk Auto																	
		To:		Area:		Takt Time:																			
Work Elements		Time (sec.)			Seconds																				
		Hand	Auto	Walk	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	
1																									
2																									
3																									
4																									
5																									
6																									
7																									
8																									
9																									
10																									
11																									
12																									
13																									
14																									
15																									
Totals			Waiting		5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	
					Seconds																				

Example of Standardized Work Combination Table

(標準作業組み合わせ票の例)



The Standardized Work Combination Table shows the combination of manual work time, walk time, and machine processing time for each operation in a production sequence. This form is a more precise process design tool than the Operator Balance Chart. It can be very helpful to identify the waste of waiting and overburden, and to confirm standard work-in-process.

標準作業組み合わせ票を見れば、ラインの作業者ごとに、作業順序に沿って人と機械の組み合わせがどうなっているのかがよくわかります。これは、先に説明した「作業者バランスチャート」よりも精緻な工程設計ツールと言えるでしょう。手待ちのムダやムリを発見したり、標準手持ちを決めるのにも役立ちます。