

Question 4 - Mention difference between:

- a) Production and Productivity
- b) Performance and efficiency
- c) Lead time and throughput time

Question 5 - Define the following:

- a. On standard time
- b. Performance
- c. Efficiency
- d. Utilization

Question 6- Fill ups:

Suppose average piece rate per operation in a section is 84 cents per dozen and average earning is \$ 6.00 per hour. Based on this average production per operation-----dozen. If two hours of work between each work station is considered healthy amount that you want to keep as a cushion for 30 sewing operator line. Then, total cushion is -----dozen. Furthermore, you have to consider that sewing machine operator is working with one bundle waiting at the machine to start as soon as s/he finishes his/her present bundle. If we assume each bundle has 3 dozen, then there are ----- dozen tops at each station or ----- dozen tops in the section. Total number of dozens of WIP is -----

Why is not enough WIP a problem? Why is excessive WIP a problem?

Question 7- There are two lines on production floor manufacturing shirts separately. Line A has 40 operators and line B has 20 operators.

Let us assume line is perfectly balanced with one operator to every operation and work content to each operation is 1 min in line A and 2 min in line B. If work flows in a UPS and WIP between operations is 15 pcs. In each case. Find out throughput time for a garment and WIP for each line. There is no WIP at feeding points. Explain what is the effect of WIP on throughput time.