



THE SEQUENCE OF EVENTS

Product Part Number				SEQUENCE OF EVENTS														Process Identification Connector Ass'y	
Operation	# Sequence	Overlapping	Tasks	Value Added	Setup					Required		Move						Quality Criteria / Safety	
					Machine	Labor	D/S	Quantity	I/E	Machine	Labor	Machine	Labor	D/S	Quantity	I/E	Distance (m)	TQC	Description
	10		Install Fixture			1.07	S	100	E										Fixture T
	20		Adjust Sheet Metal to Plate			0.46	D		E									X	Guide Pin installed
	30		Set Plasma Welding Machine		0.26	0.26	S	20	I										Nozzle : 1.2 I : 15 à 17 A Noxa13 : 8 l/mn
	40		Weld Sheet Metal to Plate	X						0.56	0.56								Wire : 316l
	100		Press Start – Welding Connector	X						0.90	0.05							X	Cycle Reference
	110	100	Sand Probes A & B								0.50								Safety glass
	120	100	Transfer Straight Probes										0.10	D			E	2.0	

Task – The smallest element of work that can be done by Person or Resource.

Value Added – Work that adds value in the "Eyes of the Customer".

Overlapping – Task that are performed concurrently with each other.

Setup – Non-Value Added Task, performed prior to other Required Work. Dynamic or Static. Internal or External.

Required Work – Work that required by Product Definition, Specific Customer Requirement..

Move – Non-Value Added Task, performed after Required Work. Dynamic or Static. Internal or External.

Quality Criteria / Safety – When there are multiple ways to perform a Task, and only One Way is Correct, Quality Criteria defines the One Correct Way.

TQC – Signals need for successive Check. Task which will require a Supplementary Control in the next Operation.

Dynamic : Performed every cycle.

Static : Performed for a group, or **Quantity** of Products.

Internal : Machine cannot perform other required work during this time.

External : Machine can perform other required work during this time.