



Tomorrows Office COGEN/MTM System

MTM = Methods time measurement.

MTM is a procedure which analyses any manual operation or method into the basic motions required to perform it and assigns to each motion a predetermined time standard which is determined by the nature of the motion and the conditions under which it is made.

The company is a leading manufacturer and distributor of scrub suits, patient gowns, nightwear, patient handling aids and healthcare textiles.

As an approved long standing supplier to the UK NHS Healthcare Service the company has gained an unrivalled reputation for its quality and service. All products are covered by ISO9001 quality standards.

The company uses a high speed video camera to film a machinist making a garment. The video is analyzed frame by frame to isolate all the basic motions. Each motion is assign a TMU (Time measurement unit).

Product Record

Product Record |

Product Code MZ228-0008 **Description** COBSEA HARNESS CLUBMAN GRY 4 POINT OWN

Sketch number 1 **Last Amended**

Ticket Instructions
 3 PLY LEFT & RIGHT OUTER LAPS, AUTO PATTS X 2 SHOULDERS
 AUTO PATT X 1 LOWER LEFT/RIGHT SHOULDERS, FLAT STITCH ATTACH LOGO X 2
 FLAT STITCH STOPPERS X 6, FLAT STITCH LAP PADS X 2

Operation List

Line	Operation Number	Description	BHT	SMV	GMT
1	1800043	1P 3 PLY LEFT OUT LAP SNAP H CLUB	0.000	0.5421	0.54
2	1800044	1P 3 PLY RIGHT OUT LAP SNAP H CLUB	0.000	0.8531	0.85
3	1800041	2 PATTS /SHOULDERS BUD/CLUB4 PT	0.000	0.8112	0.81
4	1800037	1PATT R LOWER SHOULDER BUDGET	0.000	1.3763	1.38
5	1800038	1PATT L LOWER SHOULDER BUDGET	0.000	1.0961	1.10
6	1800040	FLAT STITCH ATT LOGO X 2 BUD 3PT	0.000	1.6000	1.60
7	1800046	SEW STOPPERS X 6 4PT CLUBMAN	0.000	4.4500	4.45
8	1800047	ATT LAP PADS X 2 & TRIM ENDS	0.000	2.4800	2.48
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					

No. Of elements 8

Total SMV 13.2088

Total Tickets 13.2100

Save Discard Close

Operation Record

Operation Record |

Operation Number 1800043 **Description** 1P 3 PLY LEFT OUT LAP SNAP H CLUB **COGEN Code**

Machine Harness Misc Operation **Guiding And Tensioning Factor** 1.00 **Contingency allowance** 5.0

Department Industrial **Start/Stop factor** 0.009 **Relaxation allowance** 13.0

Machine Group Misc **Linear stop addition** 0.000 **Machine allowance** 7.0

Number Of Patterns 0 **Process time** 0.220 **Quality allowance** 0.0

Number Of fittings 0 **BHT** 0.000

Standard time 0.0000 **Elements** 16 **Basic minute** 0.4270 **Total time** 0.5421

Line	Code	Description	Number	Distance	Frequency	Time
1	A2	Pick up web		> 30	0.1	0.0026
2	A2	Pick up snap hook		> 30	0.1	0.0026
3	B3	Regrasp web		> 50	0.2	0.0030
4	D2	Thread web through snap hook		> 20	0.1	0.0032
5	B3	Regrasp web		< 20	0.1	0.0006
6	A1	Aside completed piece from under foot		> 30	1	0.0200
7	D2	Position web under foot		> 20	1	0.0320
8	M13	Close clamp			1	0.0090
9	B6	Pull web		< 20	1	0.0100
10	A2	Pick up adjuster		> 30	1	0.0260
11	D2	Thread adjuster		< 20	1	0.0270
12	B3	Regrasp web		> 50	1	0.0150
13	M13	Lift clamp			1	0.0090
14	D2	Position web under foot		> 20	1	0.0320
15	B1	Manipulate web into exact position		< 20	1	0.0060
16	M13	Close clamp / start machine			1	0.0090

Save Discard Close

Operation Record

Operation Record |

Operation Number 1800044 **Description** 1P 3 PLY RIGHT OUT LAP SNAP H CLUB **COGEN Code**

Machine Harness Misc Operation **Guiding And Tensioning Factor** 1.00 **Contingency allowance** 5.0

Department Industrial **Start/Stop factor** 0.009 **Relaxation allowance** 13.0

Machine Group Misc **Linear stop addition** 0.000 **Machine allowance** 7.0

Number Of Patterns 0 **Process time** 0.220 **Quality allowance** 0.0

Number Of fittings 0 **BHT** 0.000

Standard time 0.0000 **Elements** 24 **Basic minute** 0.6720 **Total time** 0.8531

Line	Code	Description	Number	Distance	Frequency	Time
1	A2	Pick up web		> 30	0.1	0.0026
2	A2	Pick up snap hook		> 30	0.1	0.0026
3	B3	Regrasp web		> 50	0.2	0.0030
4	D2	Thread web through snap hook		> 20	0.1	0.0032
5	B3	Regrasp web		< 20	0.1	0.0006
6	A1	Aside completed piece from under foot		> 30	1	0.0200
7	D2	Position web under foot		> 20	1	0.0320
8	M13	Close clamp			1	0.0090
9	B6	Pull web		< 20	1	0.0100
10	A2	Pick up adjuster		> 30	1	0.0260
11	D2	Thread adjuster		< 20	1	0.0270
12	B3	Regrasp web		> 50	1	0.0150
13	M13	Lift clamp			1	0.0090
14	D2	Position web under foot		> 20	1	0.0320
15	B1	Manipulate web into exact position		< 20	1	0.0060
16	M13	Close clamp			1	0.0090
17	A2	Pick up labels		> 30	2	0.0520
18	E3	Fold labels			1	0.0270
19	B3	Regrasp labels		< 50	2	0.0200
20	D2	Align folded label to orange label		< 20	2	0.0540
21	B3	Regrasp		< 50	2	0.0200
22	M13	Lift clamp			1	0.0090
23	D2	Insert labels		< 20	2	0.0540
24	M13	Close clamp and start machine			1	0.0090

Save Discard Close