Process step	Nbr. Machines		Setup time	Processing time (minutes/part)
			(minutes/job)	
Cutting		1		0.25
Adjusting		2	5	0.8
Inspecting		2	7	0.4
Threat rolling		1		0.9
Heating		1	5	1.1
Bending		1		0.45
Inspecting		1		0.4
Heat treatment		2	30	given in text for batch
Inspecting		1		0.4
Galvanizing		2	15	1.3
Final Inspection		3		0.8,

Data concerning number of machines, number of workers, setup time, and standard processing time is given above. Landmark operates one 8-hours shift a day with an effective production time of 7 hours per shift after adding allowances for morning and afternoon breaks. Also, Landmark works 6 days a week after taking Fridays away.

The plant is currently designed to produce 2 batches per shift and operating a single shift per day. To increase the market share Landmark should produce 17,000 per month. Landmark Auto Parts has hired you to help determine how it can produce 17,000 U-Bolts per month.

- Diagram the process using the process flow chart techniques discussed in class.
- b) Analyze the current capacity of the process.
- c) What is the effect of setup times on the production rate of each process?
- d) Provide two alternative strategies to increase the monthly production capacity to 17,000 U-Bolts.

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