

Exercise 03 – Part X requires machining on a milling machine (operations A and B are required). Find the number of machines required to produce 3,000 parts per week. Assume the company will be operating five days per week, 18 hours per day. The following information is known:

Operation	Standard Time	Efficiency	Reliability	Defect Rate
A	3 min	95%	95%	2%
B	5 min	95%	90%	5%

Note: The milling machine requires tool changes and preventive maintenance after every lot of 500 parts. These changes require 30 minutes.

Answer:

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C Cleary



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