

# Standardized Work 1: Process Capacity Sheet

Process Capacity Sheet	Approved by:		Part #	Application		Entered by:		Date
	Step	Step name		Machine #	Number of parts	Line	REMARKS	
				BASIC TIME		TOOL CHANGE		PROCESSING CAPACITY/SHIFT
				MANUAL	AUTO	CHANGE	TIME	
			<b>Total</b>					

## Example of Process Capacity Sheet (工程別能力表の例)

Process Capacity Sheet		Approved by:		Part #	Application	Entered by:	Date
		R. Quan					
Step	Step name	Machine #	Part name		Number of parts	Line	REMARKS
			Base Unit				
			BASIC TIME		TOOL CHANGE		PROCESSING CAPACITY/SHIFT
			MANUAL	AUTO	CHANGE	TIME	
1	Cut	C100	6	32	500	2 min.	720 p
2	Rough Grind	GR100	7	12	1,000	5 min.	1,440 p
3	Fine Grind	GR200	7	30	200	5 min.	724 p
4	Measure Diameter	TS100	8	4	—	—	2,325 p
Total			28				

The Process Capacity Chart is used to calculate the capacity of each machine to confirm true capacity and to identify and eliminate bottlenecks. Processing capacity per shift will be calculated from the available production time, completion time, and tool-change time (and other factors as necessary) for each work piece.

工程別能力表は、生産能力を正しく把握してボトルネックを見つけ、改善するために、個々の設備の能力を計算するために使うものです。加工能力は、稼働時間、部品1個あたりの完成時間と刃具交換時間から計算します（必要に応じて、その他の条件を考慮する場合もあります）。