**DFA CAD-project boormachine**

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **DFA tabel** | | | | | | | | | | | |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF ASSEMBLY |
| Part ID | Alpha & Bêta symmetry | # the operation is carried out consecutively | Manual handling code | Manual handling time per part | Manual insertion code | Manual insertion time per part | Insertion direction time | Montage process time | Operation time  C3 (c5+c7+c8+c9) | Operation costs  0,4 X c10 | Boormachine |
| Part 1.1 | 720 | 1 | 0/3 | 1,9 | 3/1 | 6,0 | 0,0 | 0,0 | 7,9 | 3,16 | Boormachine behuizing links |
| Part 1.2 | 720 | 1 | 0/3 | 1,9 | 3/1 | 6,0 | 0,0 | 0,0 | 7,9 | 3,16 | Boormachine behuizing rechts |
| Part  2.1 | 720 | 1 | 0/3 | 1,9 | 3/0 | 3,5 | 0,0 | 0,0 | 5,4 | 2,16 | Schuifknop richting |
| Part 2.2 | 720 | 1 | 0/3 | 1,9 | 3/0 | 3,5 | 0,0 | 0,0 | 5,4 | 2,16 | Schuifknop stand |
| Part 2.3 | 720 | 1 | 0/3 | 1,9 | 2/1 | 5,0 | 0,4 | 0,0 | 7,3 | 2,92 | Knop |
| Part  3.1 | 720 | 1 | 0/3 | 1,9 | 8/0 | 6,5 | 0,0 | 0,0 | 8,4 | 3,36 | Boorkop |
| Part 3.2 | 720 | 1 | 0/3 | 1,9 | 2/0 | 2,5 | 0,0 | 0,0 | 4,4 | 1,76 | Blokje knop |
| Part 3.3 | 360 | 1 | 0/0 | 1,1 | 2/0 | 2,5 | 0,0 | 0,0 | 3,6 | 1,44 | Boormotor |
| Part 4.1 | 720 | 1 | 0/3 | 1,9 | 3/1 | 6,0 | 0,0 | 0,0 | 7,9 | 3,16 | Oplaadblokje |
| Part 4.2 | 720 | 1 | 0/3 | 1,9 | 7/1 | 9,0 | 0,4 | 0,0 | 11,3 | 4,52 | Accu |
| Part 5.1 | 720 | 1 | 0/3 | 1,9 | 2/0 | 2,5 | 0,0 | 0,0 | 4,4 | 1,76 | Schuifhulp |
| Part 6.1 | 360 | 8 | 8,5 | 8,0 | 9/4 | 10,5 | 0,0 | 5,0 | 188 | 75,2 | Schroefjes |
| **Total:** | | | | | | |  |  | **271,9** | **1149,1** |  |