



DFC-LT-06 · Manual, machine and walk time for one operator through one cycle, against takt.

Time the job at the process, ten cycles, and use the lowest repeatable time — not the average and not the best ever. If total cycle time exceeds takt, the job cannot be done by one operator at this demand.

PART / PROCESS	OPERATOR	DATE
CELL / LINE	OBSERVER	REV

TAKT INPUTS

Available time per shift (min)	450
Shifts per day	1
Customer demand per day (pcs)	0
TAKT TIME (sec / pc)	

Takt = available work time ÷ customer demand. It is the drumbeat, not a target you can beat.

WORK ELEMENTS

#	Work element	Manual (s)	Auto (s)	Walk (s)	Element total	Cumulative	% of takt	Notes / waste observed
1								
2								
3								
4								
5								
6								
7								
8								
9								
10								
11								
12								
13								
14								

15								
16								
17								
18								
	CYCLE TOTAL (operator work content)	0.0	0.0	0.0	0.0			Enter demand to compare with takt

Manual = operator hands-on time. Auto = machine runs unattended (does not add to the operator's cycle). Walk = steps between elements — count it, then design it out.