



DFC-LT-11 · Set the drumbeat, then load the line against it.

Takt comes from the customer, not from the equipment. Balance to takt minus a small buffer, never to the fastest operator. If required operators comes out at 4.3, you have a 4.3-operator problem — solve it with work content, not by rounding.

LINE / CELL	PRODUCT FAMILY	DATE

1. AVAILABLE TIME

Shift length (min)	480
Breaks and lunch (min)	30
Planned meetings / 5S (min)	10
Shifts per day	1
Customer demand per day (pcs)	0
Available time per day (min)	440
TAKT TIME (sec / pc)	
Planning takt (95% of takt)	

Balance to this, not to raw takt. The 5% absorbs normal variation.

2. STATION LOADING

#	Station / operator	Work content (s)	% of takt	Over / under takt (s)	Operators assigned	Load per operator (s)	Balance action
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							
11							

12							
	TOTAL WORK CONTENT	0.0			0		

3. BALANCE RESULTS

Bottleneck station time (s)	0.0
Required operators (work content ÷ takt)	
Operators assigned	0
Line balance efficiency	
Balance loss (s per cycle)	
Daily output at bottleneck (pcs)	

Read it in this order. If required operators is well below operators assigned, the line is overstaffed for this demand. If balance efficiency is under 85%, the work is stacked unevenly and the fix is to move elements, not people. If the bottleneck exceeds takt, no amount of balancing will make the day — take work out of that station first.

