


Capacity Verification

	Part Number			Run@Rate Date:			
	Part Description			Supplier Name:			
	1 Annual Capacity Planning Volume	piece/year		Supplier Location:			

Capacity Planning

2	Process Step								
3	Process Description								
<i>Units</i>									
I - Supplier Planned Working Standards	4	Shiftlength	hours						
	5	time planned for breaks (lunch etc.)	minutes / shift						
	6	planned downtime for maintenance/repairs/cleaning etc.	minutes / shift						
	7	planned downtime per changover	minutes						
	8	planned changeovers per shift							
	9	Working hours/shift (4-(7*8)-5-6)	hours	0,0	0,0	0,0	0,0		
	10	Shifts/ day	shifts						
	11	shifts/ week	shifts						
	12	Weeks/ year	weeks						
	13	Total hours/year (9*11*12)	hours	0	0	0	0		
II - Supplier Planned Capacity Data	14	% of line for this part (Allocation %) - See Example	%						
	15	Planned Production Rate (part # item 1)	pcs/hour						
		Cycle time (sec/pcs)	sec/pcs	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!		
	16	Planned % scrap	%						
	17	Planned % line efficiency	%						
	18	Adjusted production rate (15*(1-16)*17)	pcs/hour						
	19	Available yearly capacity (18*14*(1-16)*17)*13	pcs/year						
	20	Utilization % (1/19)	%						
21	Bottleneck operation								

Supplier Capacity Planning result	0,00%	Acceptable
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Capacity Verification

	Run @ Rate	
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III - RUN@RATE Results	22	Trial run duration (total time, incl. downtime, setup, setdown)	minutes						
	23	Total parts produced	pcs						
	24	Number of bad parts (first pass failures)	pcs						
	25	downtime/stand-still (see process sheets)	minutes						
	26	netto production time (22-25)	minutes	0,00	0,00	0,00	0,00	0,00	0,00
	27	First pass yield % ((23-24)/23)*100	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
	28	Number of good parts (23-24)	pcs	0	0	0	0	0	0
	29	Net production rate (28/22)	pcs/ hour	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
	30	minimum required production rate (.....)	pcs/ hour	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
		cycle time ((22*60)/28)	sec/ pcs	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
		netto cycle time ((26*60)/28)	sec/ pcs	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
	31	Performance % (29/30)	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!
32	Bottleneck operation		#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	
IV - Overall Equipment Efficiency	33	Equipment Availability: (9/4)	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	
	34	Performance Efficiency	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	
	35	Quality Rate: ((23-24)/23)	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	
	36	OEE: (37*38*39)	%	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	
		OEE level		#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	#DIV/0!	

SHADED CELLS ARE CALCULATED and protected

37	The RUN@RATE results are acceptable and meet melecs capacity planning volume requirements:	Run@Rate Performance	#DIV/0!		Auditor Information	
	The attached capability study results meet melecs requirements	Status	#DIV/0!		Name:	
	Corrective actions are required:	Date:			Company:	
	New production readiness trial run is required:	Date:			Location:	

Supplier representative signature: _____ Auditor signature: _____