

## Measurements

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- Pallets that are left behind for a long time.
- The loaders looking for a pallets.
- The loaders waiting for a pallets.
- Wrap Machine breaks down
- Small pallets.

## Waiting time

- 40 minutes to 1 hr.
- 5 min. to 1 hr.
- 40 min. to 1 hr.
- 5 sec. to 10 min.
- 1 hr. to 2hr.

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## Calculations

# Total loss of left wrap machine

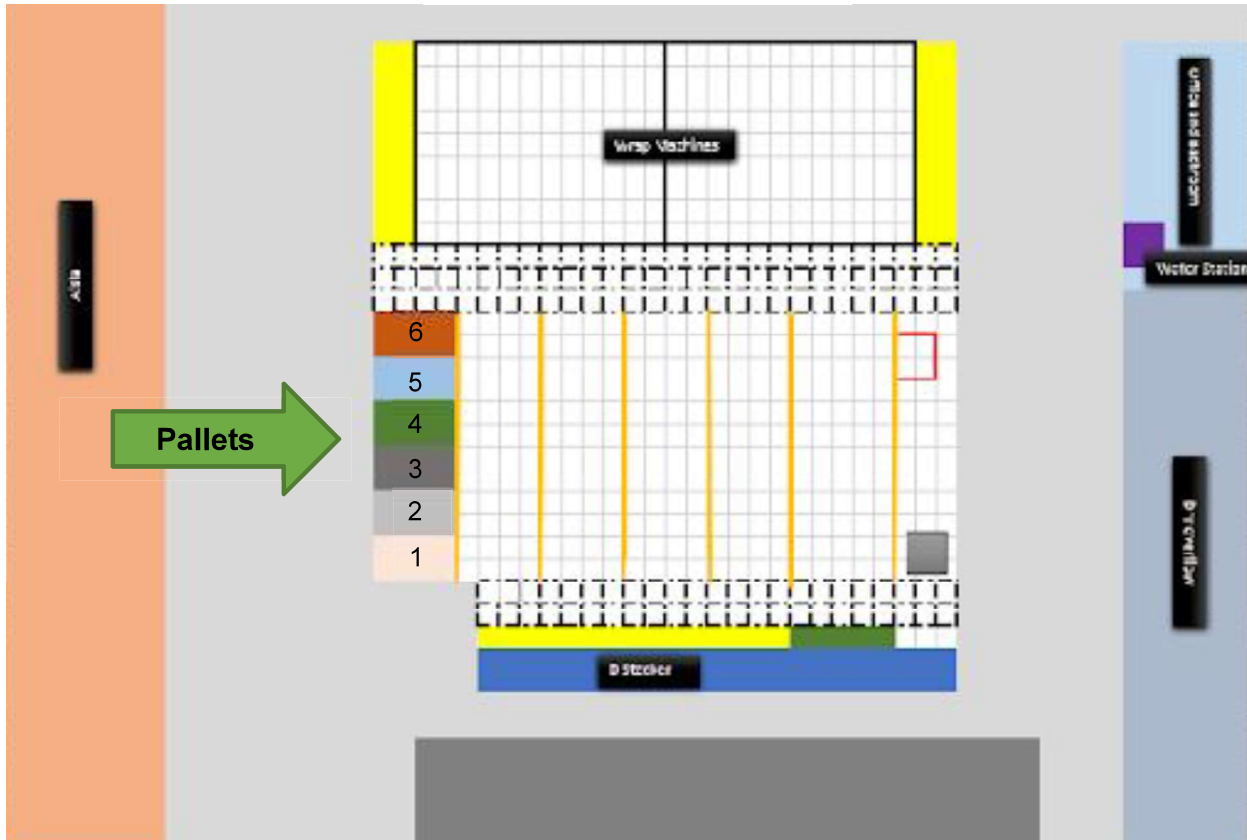
Without waiting time from the staging area to the wrap machine		With waiting time from the staging area to the wrap machine									
	00:43.9		02:00.0								
	00:55.8		30:00.0								
	01:13.0		27:00.0								
	00:34.2		03:09.0								
	00:59.8		02:14.0								
	00:39.5		01:15.0								
	00:30.1		01:13.0								
	00:49.0		00:35.9								
	00:34.3		01:18.0								
	01:04.0		02:00.0								
	00:20.0		03:40.0								
	00:52.3		01:48.0								
	01:12.0		03:52.0								
	00:45.6		04:53.0								
	00:53.2		04:04.0								
	01:17.0		01:32.0								
	00:57.1		02:25.0								
	01:10.0		02:56.0								
	00:35.8		01:00.0								
	01:12.0		01:57.0								
			01:58.0								
			01:23.0								
			02:05.0								
			01:40.0								
Average Time:		Average Time:							Total Loss Calculation		
	00:51.9		11:54.9						814	8994.7	149.9116667
											3935.18125
Difference			11:03.0	11.05							\$1,432,405.98

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**Improve**

## LIFO Last In – First Out

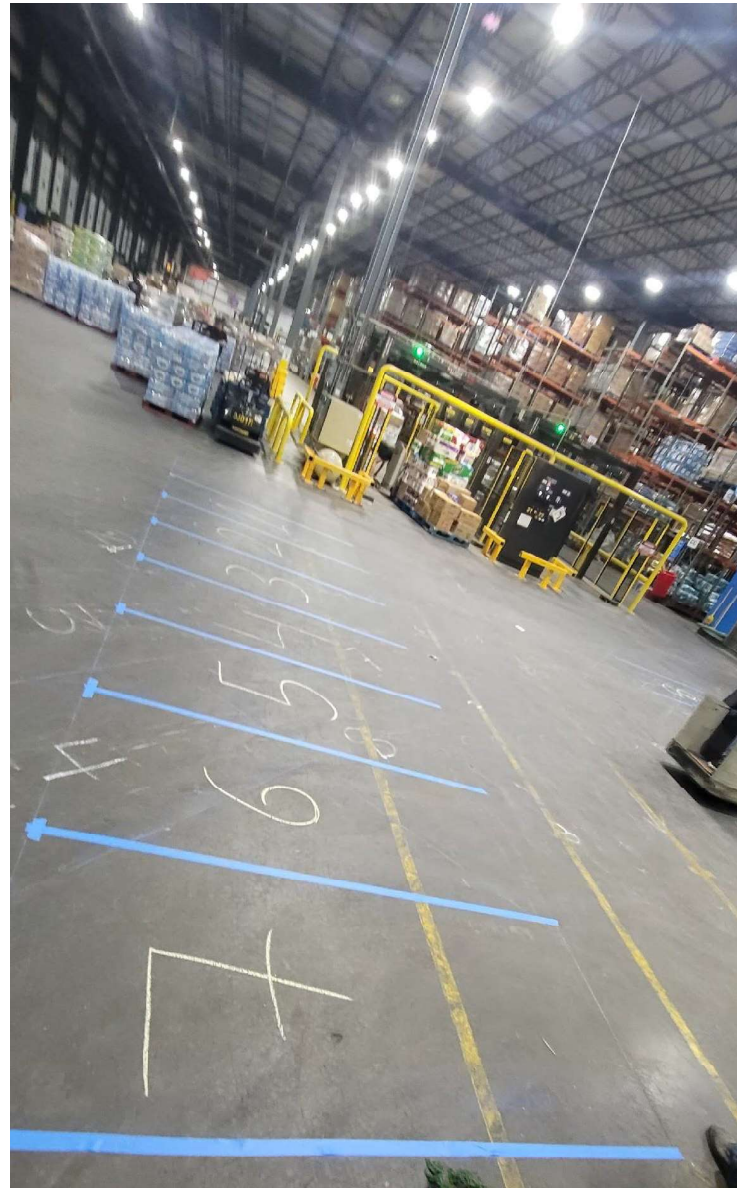


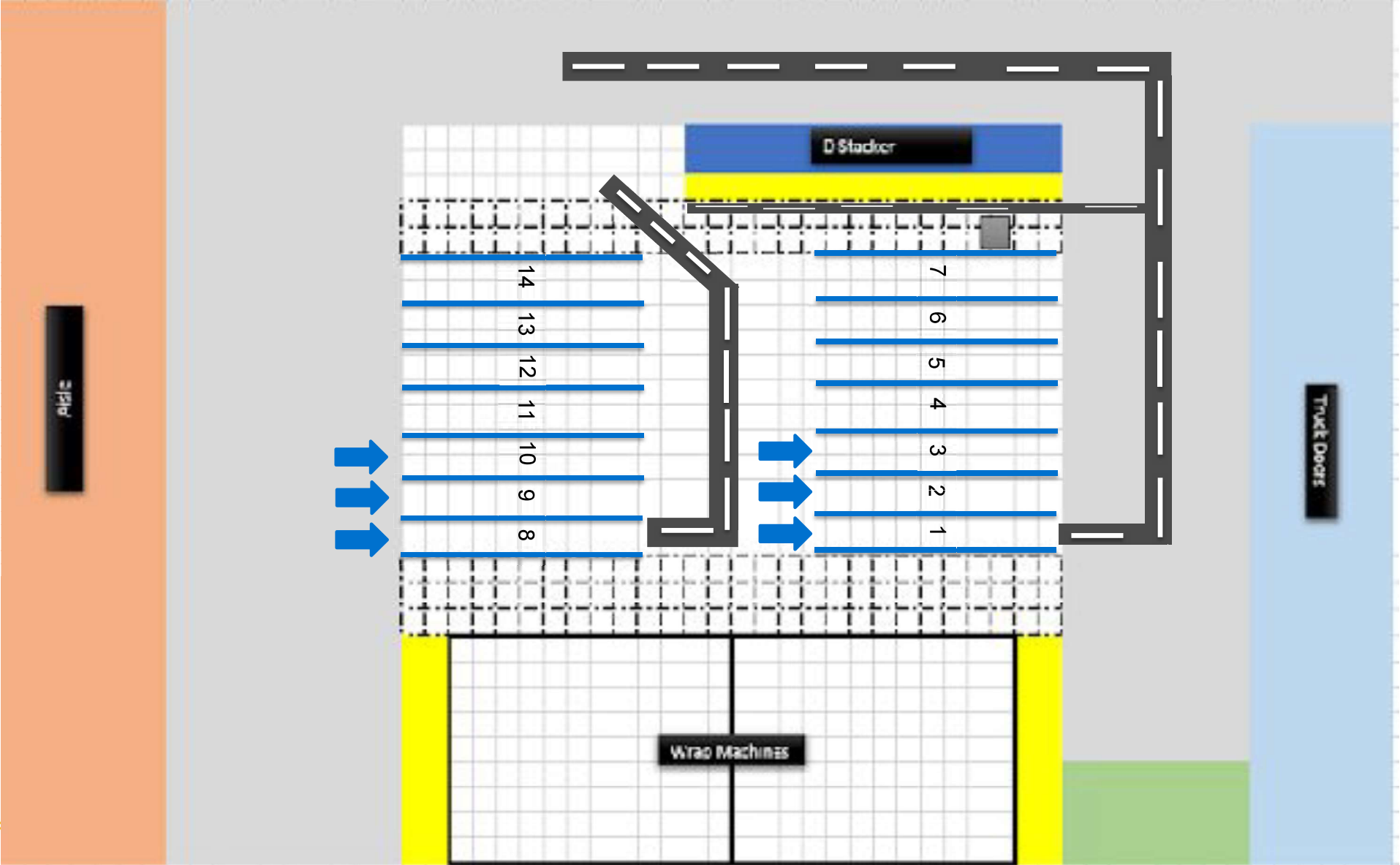


# FIFO

## First In – First Out

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# Short-term solution

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Both/Or

