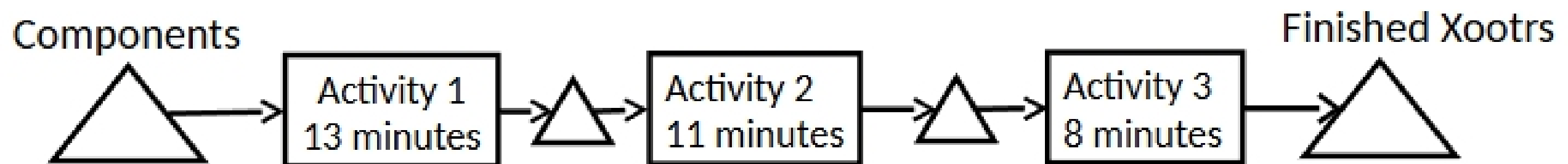


# Chapter 4

## Estimating and Reducing Labor Costs

# A Labor Intense Process (Novacruz Case)



# Xootr Task Durations

<b>Worker 1</b>	<b>Worker 2</b>	<b>Worker 3</b>
Prepare cable 30	Assemble brake lever 110	Inspect & wipe off 95
Move cable 25	Trim and cap cable 59	Apply decal 20
Assemble washer 100	Place first rib 33	Insert in bag 43
Apply fork 66	Insert axles, cleats 96	Assemble carton 114
Assemble socket head 114	Insert rear wheel 135	Insert Xootr & manual 94
Steer pin nut 49	Place 2 <sup>nd</sup> rib 84	Seal carton 84
Brake shoe, spring 66	Apply grip tape 56	
Insert front wheel 100	Insert deck fasteners 75	
Insert axle bolt 30		
Tighten axle bolt 43		
Tighten brake pivot 51		
Assemble handle cap 118		
792 seconds	648 seconds	450 seconds