

PENNSSTATE



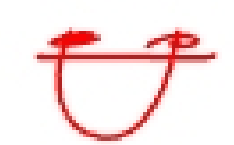
TIME
STUDY

HW#4 DUE TODAY

MTM-2

SPIRAL - 235
LB

U-BOLT



FLASHLIGHT

MUST

CASE STUDY #1

3 - GROUPS

IE 419
Work Design:
Productivity and Safety

Dr. Andris Freivalds

Class #14



Maynard Operation Sequence Technique (MOST, pp. 508-513)

- Developed by Zandin in 1967
- At SAAB-Scania in Sweden 200 PTS
- Published in 1980 through H.B. Maynard
- Basically simplified MTM ^{-V MACHINES} (same TMU)
- Faster than MTM-1 and MTM-2 = MANUAL
- Has many diverse tool applications
- Has computer program!!

MOST – Comparison with MTM

Factor	MTM-1	MTM-2	MOST
Time to analyze	250x	100x	10x
Speed wrt MTM-1	1	2.5	25
Speed wrt MTM-2	-	1	<u>10</u>
Min. cycle time for 5% accuracy (min)	0.36	1.0	2.0