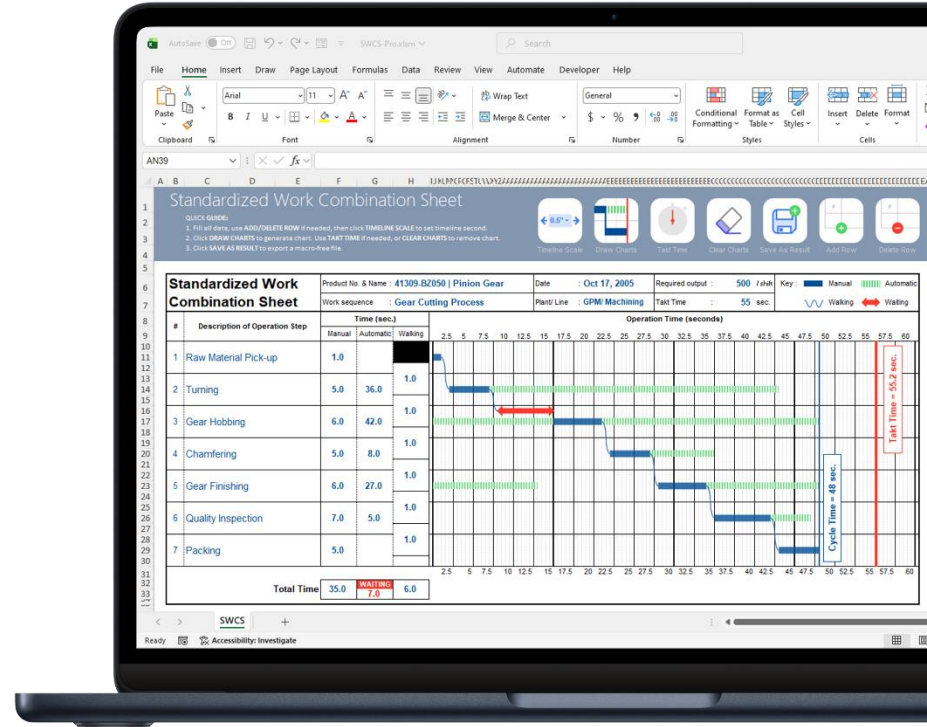


# Standardized Work Combination Sheet Template

PRO

Quick Start Guide



# Standardized Work Combination Sheet

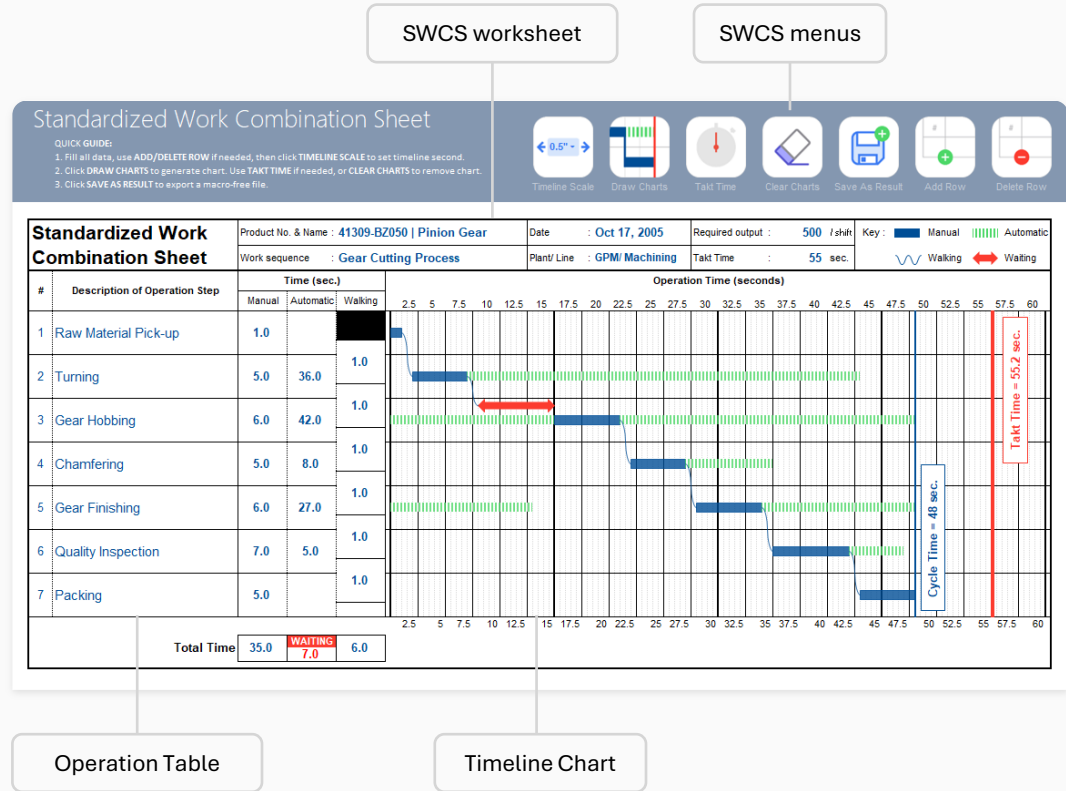
This template helps create standardized work with automated charts and calculations.

Features:

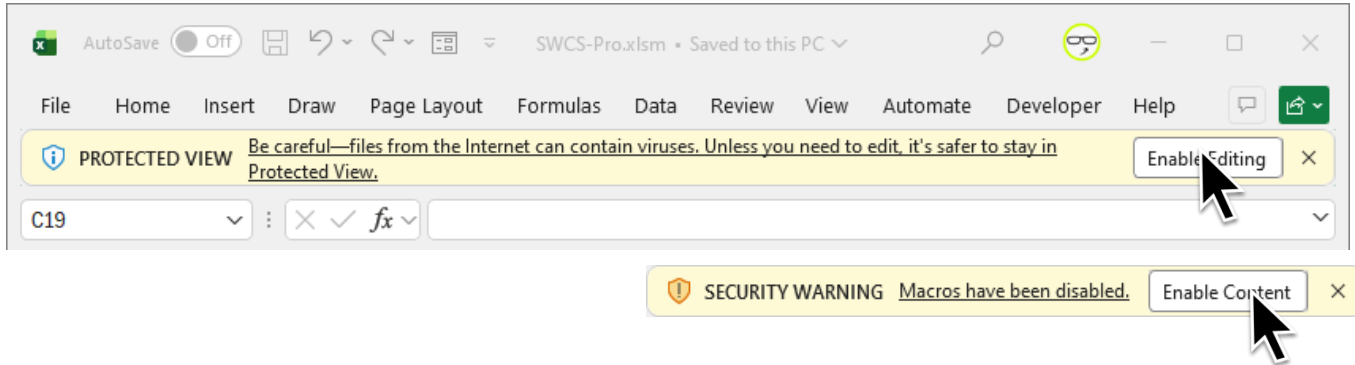
- ✓ Adjust operation timeline scale instantly
- ✓ One-click SWCS chart generation
- ✓ Auto detect and visualize waiting time
- ✓ Takt time calculator & drawer
- ✓ Add or remove rows with one click
- ✓ Save results as a macro-free workbook
- ✓ Built-in VBA automation tools
- ✓ No activation. No subscription

Requirements:

- Microsoft Excel for Windows
- Macros enabled



1










# 5

## Standardized Work Combination Sheet

**QUICK GUIDE:**

1. Fill all data, use ADD/DELETE ROW if needed, then click TIMELINE SCALE to set timeline second.
2. Click DRAW CHARTS to generate chart. Use TAKT TIME if needed, or CLEAR CHARTS to remove chart.
3. Click SAVE AS RESULT to export a macro-free file.

← 1" →



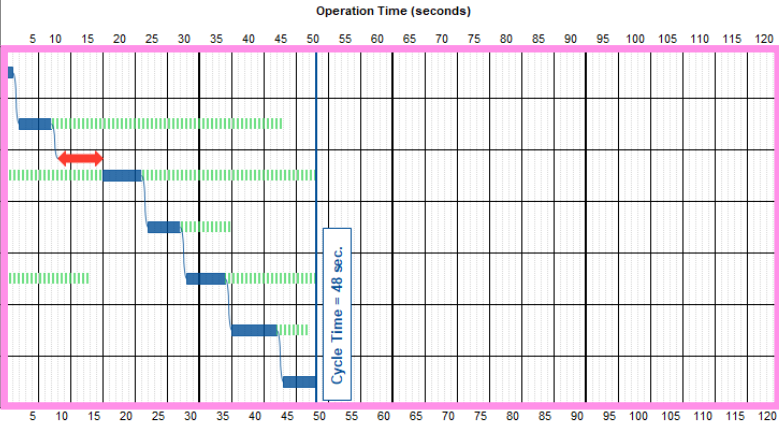
Takt Time

Clear Charts

Save As Result

Add Row

Delete Row

Standardized Work Combination Sheet		Product No. & Name : 41309-BZ050   Pinion Gear			Date : Oct 17, 2023	Required output : / shift	Key : <span style="color: blue;">■</span> Manual <span style="color: green;">▤</span> Automatic					
		Work sequence : Gear Cutting Process			Plant/ Line : GPM/ Machining	Takt Time : sec.	<span style="color: blue;">~</span> Walking <span style="color: red;">↔</span> Waiting					
#	Description of Operation Step	Time (sec.)			Operation Time (seconds)							
		Manual	Automatic	Walking	5	10	15	20	25	30	35	40
1	Raw Material Pick-up	1.0										
2	Turning	5.0	36.0	1.0								
3	Gear Hobbing	6.0	42.0	1.0								
4	Chamfering	5.0	8.0	1.0								
5	Gear Finishing	6.0	27.0	1.0								
6	Quality Inspection	7.0	5.0	1.0								
7	Packing	5.0		1.0								
<b>Total Time</b>		35.0	WAITING 7.0	6.0								

# 6

## Standardized Work Combination Sheet

**QUICK GUIDE:**

1. Fill all data, use ADD/DELETE ROW if needed, then click **TIMELINE SCALE** to set timeline second.
2. Click **DRAW CHARTS** to generate chart. Use **TAKT TIME** if needed, or **CLEAR CHARTS** to remove chart.
3. Click **SAVE AS RESULT** to export a macro-free file.

← 1" →

Standardized Work Combination Sheet		Product No. & Name : 41309-BZ050   Pinion Gear			Date : Oct 17, 2005	Required output : 500 / shift	Key : <span style="color: blue;">■</span> Manual <span style="color: green;">▤</span> Automatic										
		Work sequence : Gear Cutting Process			Plant/ Line : GPM/ Machining	Takt Time : 56 sec.	<span style="color: blue;">~</span> Walking <span style="color: red;">↔</span> Waiting										
#	Description of Operation Step	Time (sec.)			Operation Time (seconds)												
		Manual	Automatic	Walking	5	10	15	20	25	30	35	40	45	50	55	60	65
1	Raw Material Pick-up	1.0															
2	Turning	5.0	36.0	1.0													
3	Gear Hobbing	6.0	42.0	1.0													
4	Chamfering	5.0	8.0	1.0													
5	Gear Finishing	6.0	27.0	1.0													
6	Quality Inspection	7.0	5.0	1.0													
7	Packing	5.0		1.0													
<b>Total Time</b>		35.0	WAITING 7.0	6.0													

**Takt Time Calculator**

Working shift / day:  shift(s)

Working hour / shift:  hours

Total downtime / day:  minutes

Customer demand / day:  units

Net Available Time (seconds)

## 28,200

7.8 hours | 470 minutes

Takt Time

56.40

(seconds)

# 7

**Standardized Work Combination Sheet**

1. Click CHART.  
 2. Fill all data, Use ADD/DELETE ROW if needed, then click TIME/LINE SCALE to set timeline second.  
 3. Click DRAW CHARTS to generate chart. Use TACT TIME if needed, or CLEAR CHARTS to remove chart.  
 4. Click SAVE AS EXCEL to export a spreadsheet file.

Time/Chart | Draw Chart | Clear Chart | Add Row | Delete Row | Save Chart

Standardized Work Combination Sheet		Product No. & Name : 41309-BZ050   Pinion Gear	Date : Oct 17, 2005	Required output : 500 /shift	Key : Manual Automatic	
		Work sequence : Gear Cutting Process	Plant/ Line : GPM Machining	Takt Time : 56 sec	Walking Waiting	
#	Description of Operation Step	Time (sec.)			Operation Time (seconds)	
		Manual	Automatic	Walking		
1	Raw Material Pick-up	1.0				
2	Turning	5.0	36.0			
3	Gear Hobbing	6.0	42.0			
4	Chamfering	5.0	8.0			
5	Gear Finishing	6.0	27.0			
6	Quality Inspection	7.0	5.0			
7	Packing	5.0				
Total Time		35.0	WAITING 7.0	6.0		

Standardized Work Combination Sheet		Product No. & Name : 41309-BZ050   Pinion Gear	Date : Oct 17, 2005	Required output : 500 /shift	Key : Manual Automatic	
		Work sequence : Gear Cutting Process	Plant/ Line : GPM Machining	Takt Time : 56 sec	Walking Waiting	
#	Description of Operation Step	Time (sec.)			Operation Time (seconds)	
		Manual	Automatic	Walking		
1	Raw Material Pick-up	1.0				
2	Turning	5.0	36.0	1.0		
3	Gear Hobbing	6.0	42.0	1.0		
4	Chamfering	5.0	8.0	1.0		
5	Gear Finishing	6.0	27.0	1.0		
6	Quality Inspection	7.0	5.0	1.0		
7	Packing	5.0		1.0		
Total Time		35.0	WAITING 7.0	6.0		

Cycle Time = 48 sec.  
 Takt Time = 56.4 sec.





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