

IE

PPT 04

- Stop Watch Study:

Time study equipment: i) Stop watch

ii) The

study board

Time study form.

methods of timing:

There are two principle methods of timing.

i) Cumulative timing

ii) Flyback timing

- Time study rating:

Rating is assessment of the workers rate of working relative to the observers concept of rate corresponding to standard pace.

Normal time=

Average observed actual time*Rating/100

This is the time a normal qualified workman would take.

- How to rate a worker:

$$\text{Performance Rating} = \frac{\text{Observed Performance}}{\text{Normal Performance}} * 100$$

- Techniques of rating:
 - i) Speed rating
 - ii) Westing house system
 - iii) Synthetic rating
 - iv) Objective rating

- Standard Time:

It is the total time in which a Job should be

completed at standard performance

Certain allowances have to be add before

standard time can be derived.

- Allowances:
- These allowances are
 - Personal allowance
 - Fatigue allowance
 - Delay allowance
 - Policy allowance

So, standard time = Basic time + allowances

- Predetermined Motion Time Study(PMTS):
It is a technique for synthesizing operation times from standard time data for basic elementary motions comprising operation.

Technique:

Uses:

Advantages and drawbacks: