

↑
 TERRITORIES
 ↓
 UNEQUAL
 WORKLOAD

① MINIMUM THROUGHPUT TIME

3,2 HR



$\Delta = ??$
5,5d

WHY?
WHERE IS TIME LOST?

① PRIORITY RULES

② BOTTLENECK

ACTUAL THROUGHPUT TIME 6d

CALCULATED TAT (EX(3)) = 8.2d
EXPLAIN?

② HOW ARE PRIORITIES SET?
DO YOU AGREE?

* RELEASE RESULTS

$$CAP = 7.5 \text{ lanes} \times 4 \times 60$$

WORKLOAD
CAPACITY

DISTRIBUTION =

$$= \frac{33 \text{ requests} \times 41'}{450' \times 4} = 89\%$$

$$= \frac{14.6 \text{ requests} \times 28.4'}{450' \times 1} = 92\% \text{ } 97\%$$

$$= \frac{13.2 \text{ requests} \times 28.4'}{450' \times 1} = 83\% \text{ } 78\%$$

$$= \frac{11.2 \text{ requests} \times 28.4'}{450' \times 1} = 71\% \text{ } 70\%$$

$$= \frac{33 \text{ requests} \times 70.4'}{450' \times 8} = 76\%$$

$$= \frac{26.3 \text{ req} \times 54.8'}{450' \times 5} = 64\%$$

POLICY WRITING =

RIMS x Time for Run

+ # REIMS x Time Rev

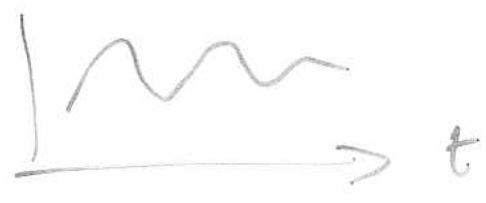
+ # RAP ---

+ # RAIMS ---

450' x 1

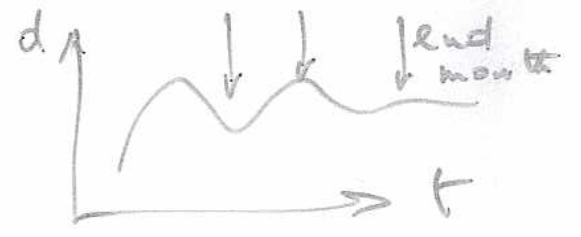
FLUCTUATION.

Split Territories → Unl. res



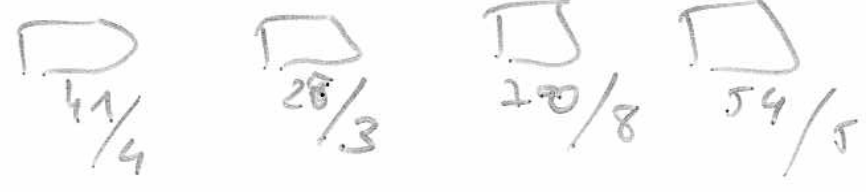
PROCESSING TIMES: HIGH $\frac{STDEV}{MEAN}$

RUMS + RERUMS



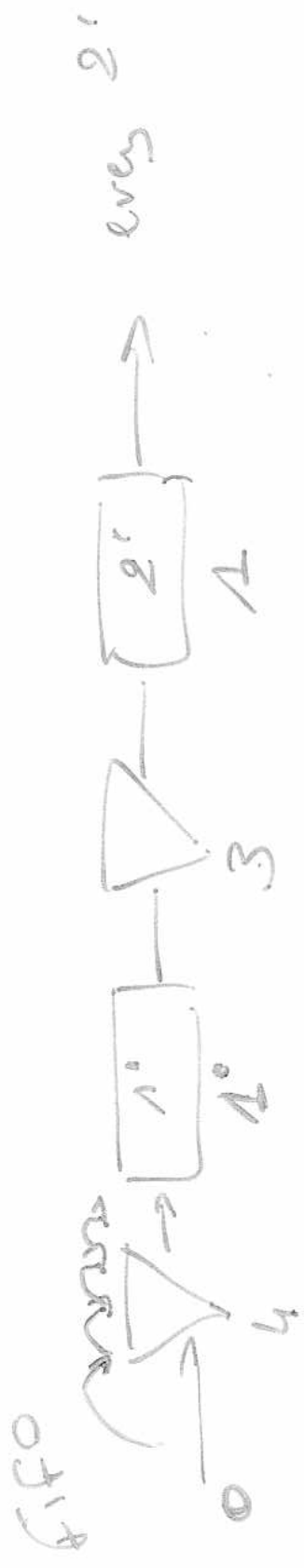
Mix RUM / RERUM DIFFERS PER TEAM
DIFFERS OVER TIME

BATCHES



PRIORITY CHANGES

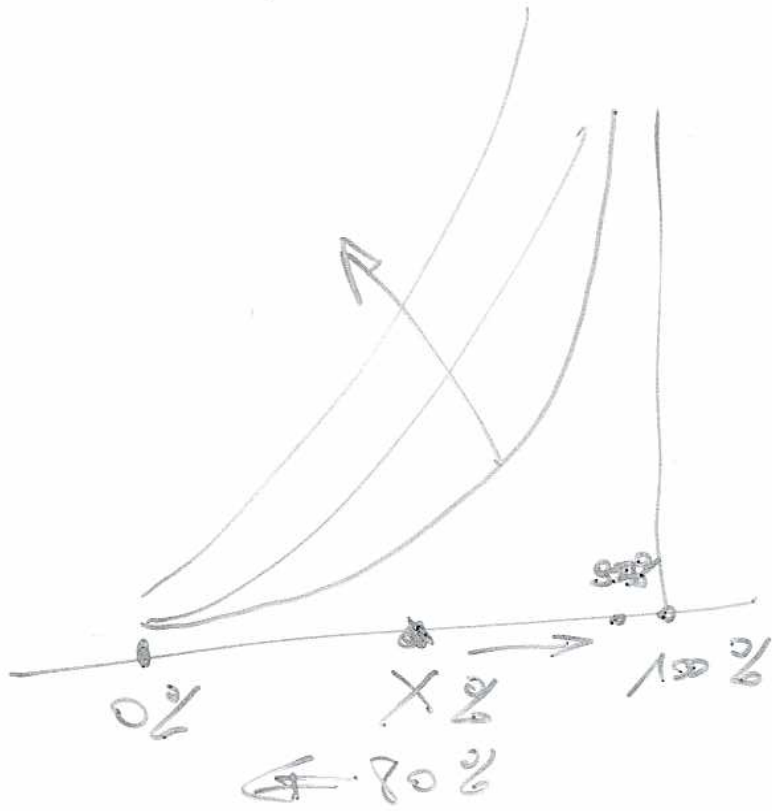
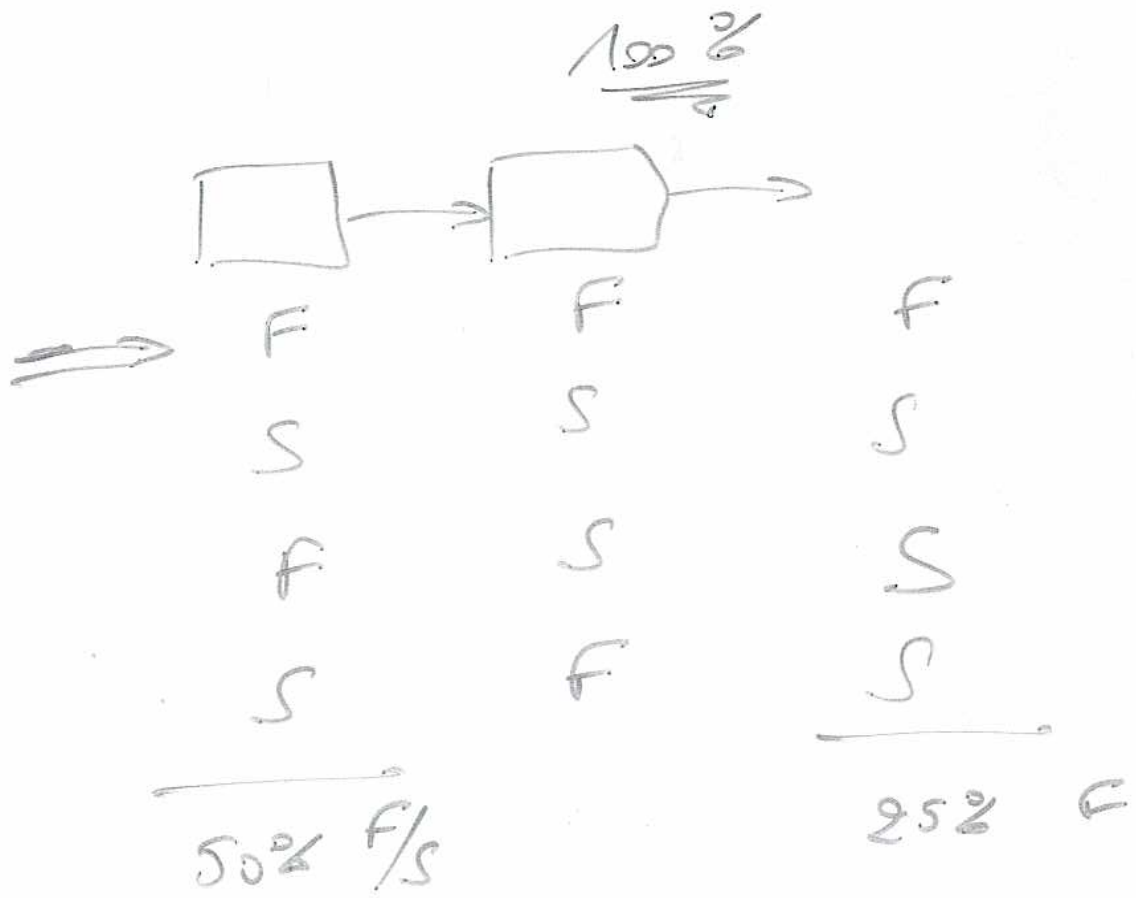
CYCLE TIME = 2'



$$9 \times 2' = 18'$$

~~$$5 \times 1' + 9 \times 2' = 23'$$

$$\frac{5}{5} \quad \frac{18}{18}$$~~



REVENUE	COMMISSION	TNET	LABOR COST	TNET PER HOUR	TIME ON BOTTLE NECK
6724	$0.15 \times 6724 = 1008.6$	5043	4.3 HR	1173	436
6205	$0.07 \times 6205 = 434.35$	5771	2.5 L	2308	187



PRIORITY RULE



DISTR

FIFO

UW

1° RUNS / RANS

2° RERUNS / RAINS



FIFO

RATING

Same

1° RUNS / RANS

POLICY WRITING

: SIMPLE JOBS
FIRST.

* LOWER PRIORITY TO RAPS
(NOT TOO LOW!) } RIMS

* USE RERUNS TO LEVEL OUT
(START EARLIER)

* 1 year of UW

* STANDARDIZE PROCESSING

* RE-ALLOCATE CAPACITY

* SEPARATE TRACK FOR
RERUN
"CELL"