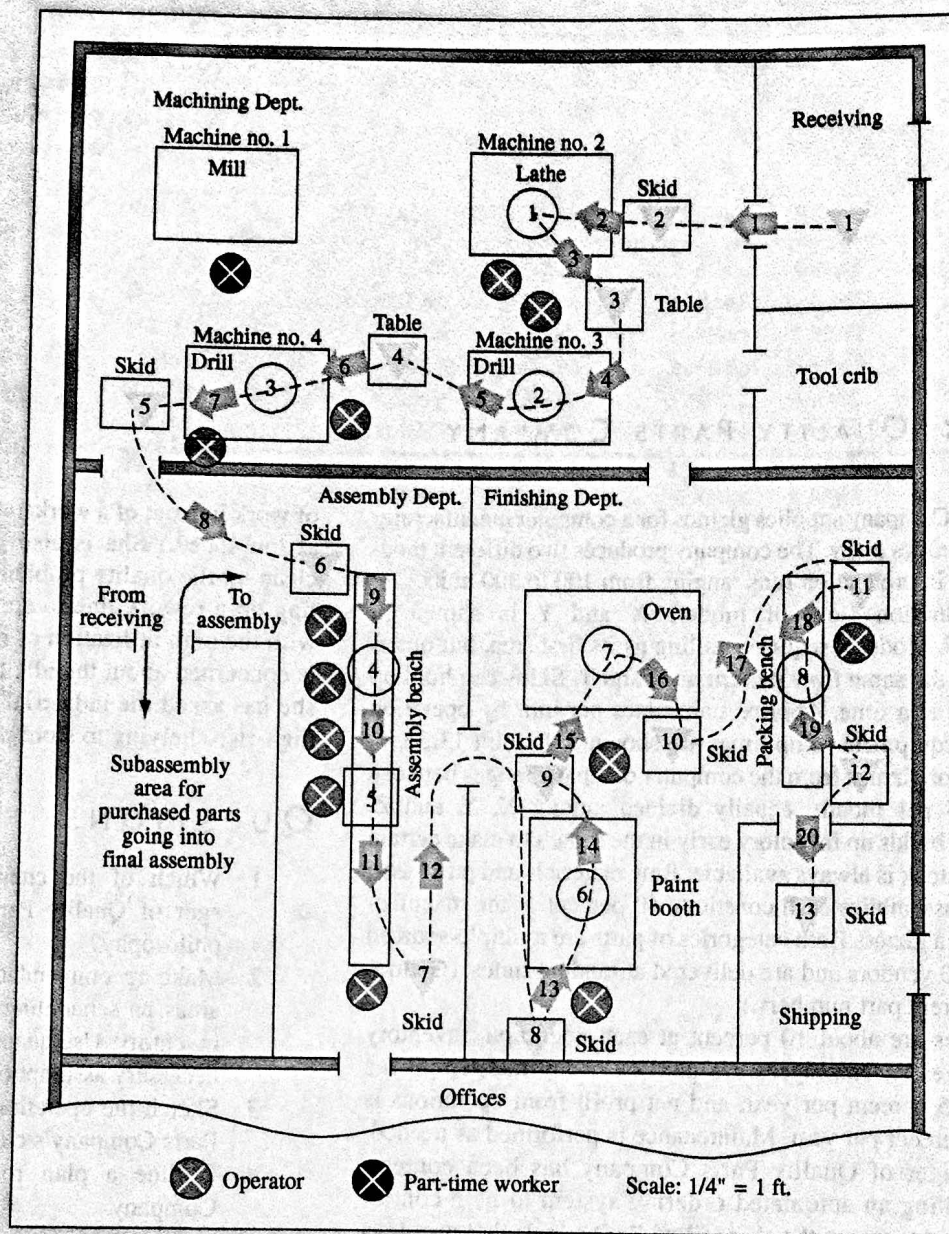




Operations and Setup Time

OPERATION NUMBER AND NAME	OPERATION TIME (MINUTES)	SETUP TIME (MINUTES)
Milling for Model Z	20	60
1 Lathe	50	30
2 Mod. 14 drill	15	5
3 Mod. 14 drill	40	5
4 Assembly step 1	50	
Assembly step 2	45	
Assembly step 3	50	
5 Inspection	30	
6 Paint	30	
7 Oven	50	20
8 Packing	5	