



Policy for measure points in typical flows

Symbols

Symbol

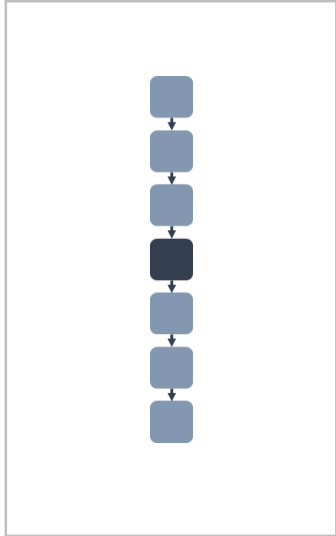
Meaning



Station in sub flow



Cycle time bottle neck station in sub flow

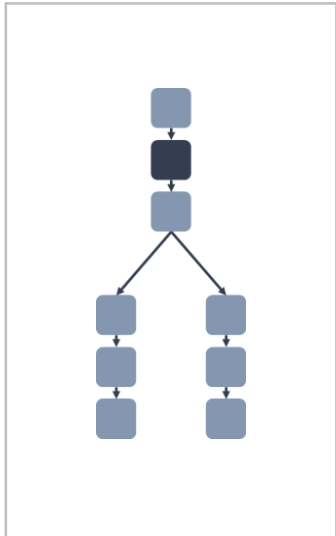


Straight sub flow

In a straight flow without splits, mergers or crosses there is only one measure point.

Number of measure points

1

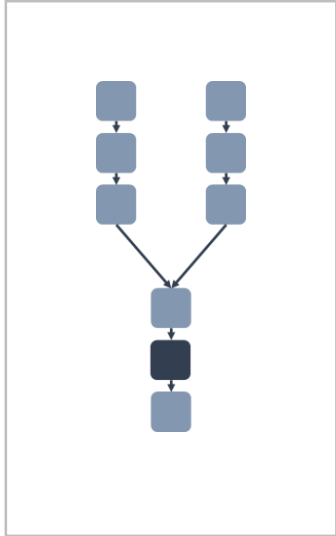


Split 1

When the cycle time bottleneck station is before the split there is enough with one measure point in the sub flow.

Number of measure points

1

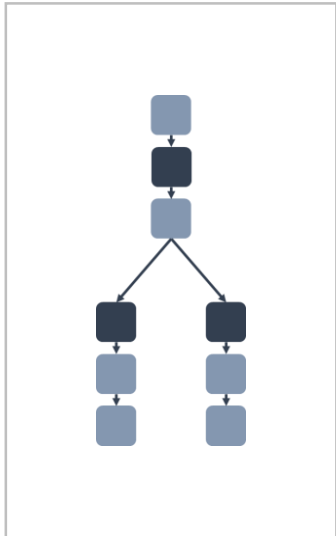


Merger 1

When the cycle time bottleneck is after the merger it is enough with one measure point.

Number of measure points

1

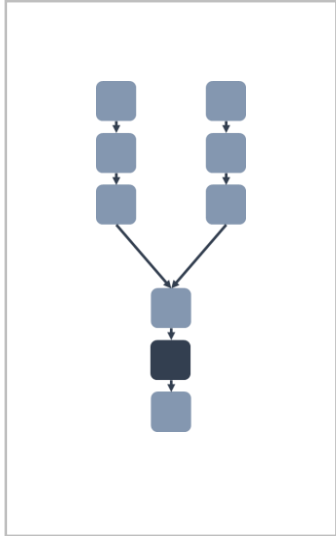


Merger 2

When the cycle time bottleneck is before the merger you'll need one measure point per leg.

Number of measure points

One per leg

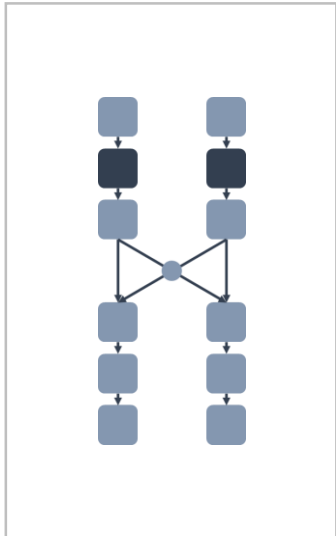


Merger 3

If the cycle time bottleneck moves depending on what article you run and can be both before and after the split you'll need to have one measure point on each leg plus one after the split.

Number of measure points

1 + one per leg

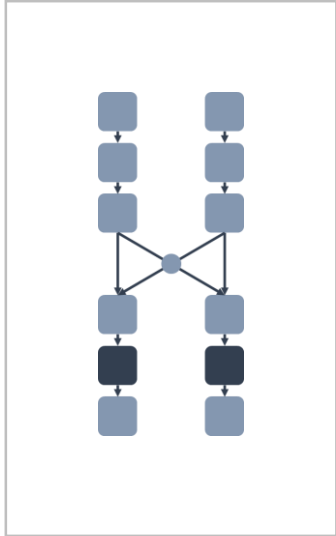


Crossing 1

If the cycle time bottleneck is before the crossing you'll need one measure point per leg before the crossing.

Number of measure points

One per leg before the crossing

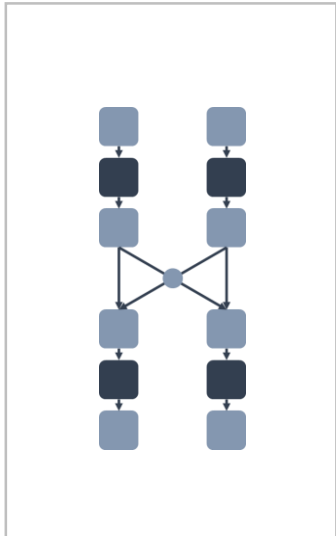


Crossing 2

If the cycle time bottleneck is after the crossing you'll need one measure point per leg after the crossing.

Number of measure points

One per leg after the crossing



Crossing 3

If the cycle time bottleneck moves depending on what article you run and can be both before and after the crossing you can see each leg as a separate sub flow and place one measure point on each leg.

Number of measure points

One per leg