

Process name	Description	Remark	Load/Human/Unload time (s)							Machine Time (s)							Time Line (s)				MAX Human Time	Max Machine Time	Cycle time	Planed Cycle Time
4.10 Panel separation 1	1	Take out the <u>Multiboard</u> from the Magazine									2								4	0	33,5	33,5	16	
	2	Multiboard is placed onto the fixture and fixed										1						2						
	3	DMC reading and MES communication											1,5					1,5						
	4	Start the process												1				1						
	5	Milling												26				13						
	6	Unload the separated PCBs from the nest													2				6					
	7	Remove the waste													2				4					
			0	0	0	0	0	0	0	2	1	1,5	1,0	26,0	2,0	4	2	1,5	1	13	6			

Process name	Description	Remark	Load/Human/Unload time (s)							Machine Time (s)							Time Line (s)				MAX Human Time	Max Machine Time	Cycle time	Planed Cycle Time
4.10 Panel separation 1	1	Take out the <u>Multiboard</u> from the Magazine and insert into the RT lower nest	6															6	10,8	11,5	25	16		
	2	DMC reading and MES communication		1,5														1,5						
	3	Start the process with button			1													1						
	4	Turn the RT operator wait for turning				1					1							1						
	5	Milling										22	6	1,5	4,5	5	5							
	6	Unload the separated PCBs from the nest					6										6							
	7	Remove the waste						6									6							
	8	Visual check																						
			6	1,5	1	1	6	6	0	0	0	1	22	0	6	1,5	4,5	6	6	1				

Projektphasen

