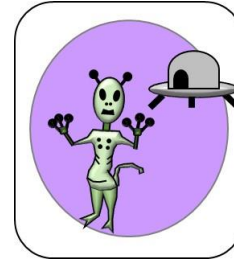
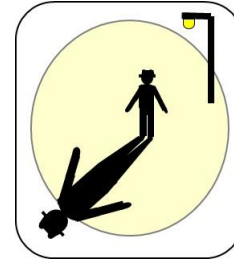
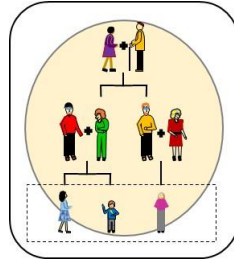
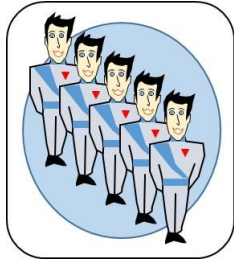




Figure 3-1

Figure 3-2

Task Familiarity



EMA	Clones	Blood Relatives	Close Cousins	Near Neighbours	Strangers	Aliens
9	✓	✓				
8	✓	✓				
7		✓	✓			
6			✓	✓		
5			✓	✓		
4			✓	✓		
3				✓	✓	
2					✓	✓
1					✓	✓

	A	B	C	D	E	F
1	Work Centre	Parts Count	Average Standard Time (Hours) per Part	Estimated Total Standard Time (Hours)	First Article Hours	
2	Total			69.79	169.07	
3	Machining	15	2.75	41.25	61.05	
4	Fabrication	24	0.67	16.08	35.20	
5	Electrics	4	0.75	3.00	10.64	
6	Assembly	43	0.22	9.46	62.18	
7						
8	Work Centre	Learning Rate	Learning Exponent	Baseline Unit	Current Average % Performance to Standard @ Baseline	First Article Factor
9	Machining	95%	-0.0740	100	95%	1.4801
10	Fabrication	90%	-0.1520	100	92%	2.1889
11	Electrics	85%	-0.2345	100	83%	3.5469
12	Assembly	80%	-0.3219	100	67%	6.5733

Figure 3-11

	A	B	C	D	E	F	G	H	I	J
1	Work Centre	Parts Count	Average Standard Time (Hours) per Part	Estimated Total Standard Time (Hours)	Learning Rate	Baseline Unit	Learning Exponent	Current Average % Performance to Standard @ Baseline	First Article Factor	First Article Hours
2	Machining	15	2.75	41.25	95%	100	-0.0740	95%	1.4801	61.05
3	Fabrication	24	0.67	16.08	90%	100	-0.1520	92%	2.1889	35.20
4	Electrics	4	0.75	3.00	85%	100	-0.2345	83%	3.5469	10.64
5	Assembly	43	0.22	9.46	80%	100	-0.3219	67%	6.5733	62.18
6	Total			69.79						169.07

Figure 3-12

	A	B	C	D	E	F	G	H	I	J
1	Work Centre	Learning Rate	Baseline Unit	Current Average % Performance to Standard @ Baseline	Parts Count	Average Standard Time (Hours) per Part	Estimated Total Standard Time (Hours)	Learning Exponent	First Article Factor	First Article Hours
2	Machining	95%	100	95%	15	2.75	41.25	-0.0740	1.4801	61.05
3	Fabrication	90%	100	92%	24	0.67	16.08	-0.1520	2.1889	35.20
4	Electrics	85%	100	83%	4	0.75	3.00	-0.2345	3.5469	10.64
5	Assembly	80%	100	67%	43	0.22	9.46	-0.3219	6.5733	62.18
6	Total						69.79			169.07

Figure 3-13