

Figure 3-1
Rate Adjusted Unit Learning

Log Hours

Log Unit Sequence Number

1 unit per period Learning
2 units per period Learning
4 units per period Learning
8 units per period Learning

Figure 3-2
Rate Adjusted Secondary Learning

Primary Learning Curve during Rate Build-up

Log Hours

Log Unit Sequence Number

1 unit per period Learning
2 units per period Learning
4 units per period Learning
8 units per period Learning

Figure 3-3
Rate Adjusted Secondary Learning in Relation to Primary Learning

\[ t_a = t_1 a^\varepsilon \]
\[ t_b = t_1 b^\varepsilon \]
\[ t_1 a^\varepsilon \frac{(b/a)^\sigma}{(r_b/r_a)^\theta} = t_1 b^\varepsilon \]

Figure 3-5
Learning Curve Incremental Investment Return

Incremental Saving multiplied by the Number of Units Remaining
20 x 11 = 220 hours
9.79 x 10 = 97.9 hours

Reducing Potential Incremental Savings
477.32 hours saving in total

Assembly Hours

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Figure 3-6
Cost Driver 1, 21%
Cost Driver 2, 31% (Normally, 22%)
Cost Driver 3, 23%
Cost Driver 4, 34%

Cost Drivers 109% of Normal

Figure 3-12