Standard work combination table

Common practice, not a standard: FactoKit's own layout. Times in seconds. Draw manual time as a solid line, machine time dashed, walk wavy, and the takt as a line across the time column.

Process

Part	Process / operator	Takt (s)	Operator cycle (s)	Date	Prepared by

Work elements

No.	Work element	Manual	Machine	Walk	Time line (draw here): from 0 s to the takt