Before
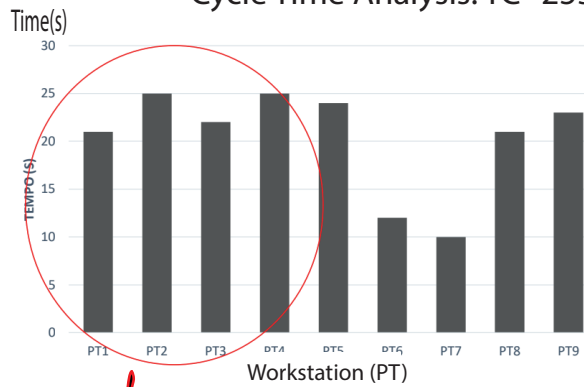
After
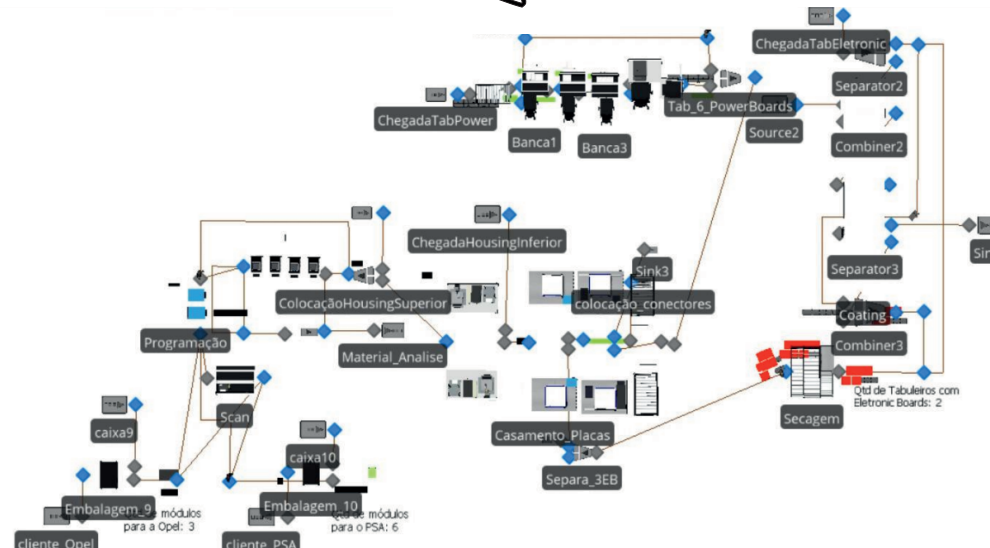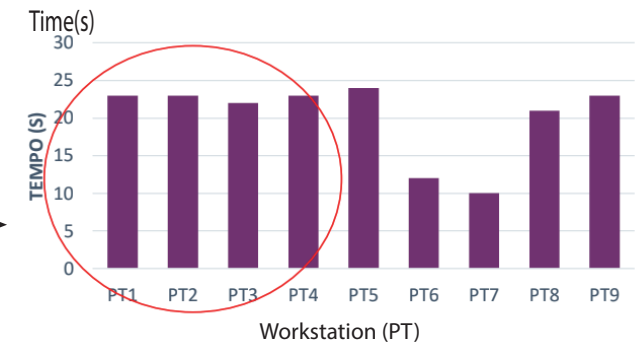
Cycle Time Analysis: TC=25s

reallocate activities in order to reduce cycle time by 1 second (bottlenecks: Workstations 2 and 4)

Cycle Time Analysis: TC=24s

Solution: Line Balancing

Simulation

bottleneck

Simulation to prove the results from the line balancing