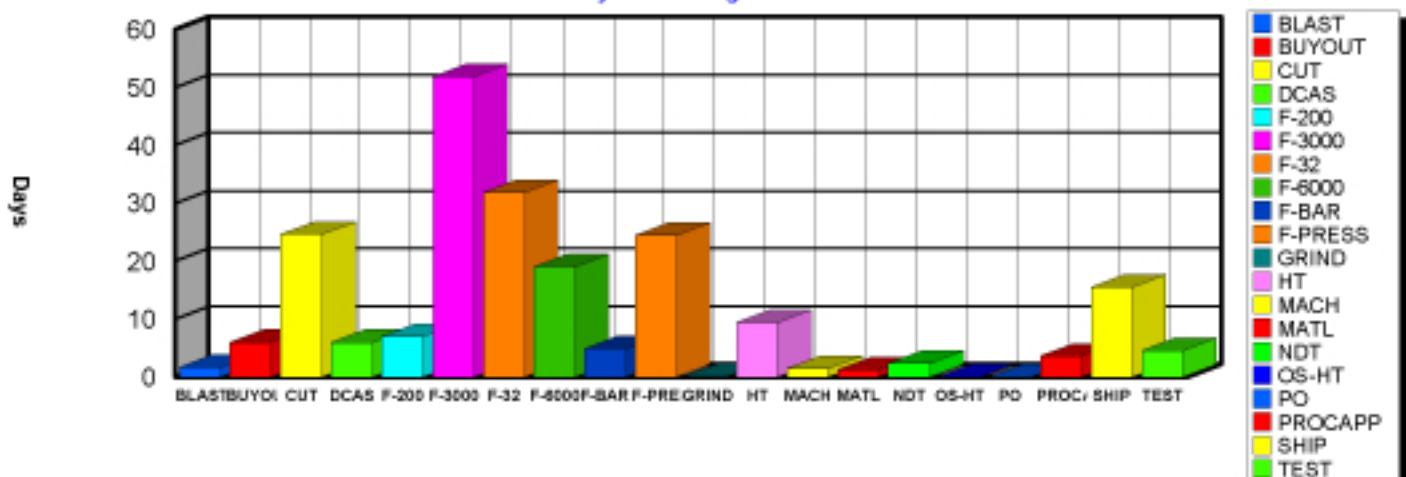


## Work Center Bottleneck Analysis

Days of Backlog Per Work Center



3/31/00

<u>Work Center</u>	<u>Description</u>	<u>Stations</u>	<u>Backlog Hrs</u>	<u>Capacity/Day</u>	<u>Backlog Days</u>
BLAST	BLAST CLEANING	1	12.00	7.00	1.70
BUYOUT	BUYOUT MATL	1	6.00	1.00	6.00
CUT	CUTTING	5	1,108.40	45.00	24.60
DCAS	DCAS	1	6.00	1.00	6.00
F-200	200 TON RING MILL	1	56.30	8.00	7.00
F-3000	3000 LB HAMMER	1	414.80	8.00	51.90
F-32	32 TON RING MILL	1	254.00	8.00	31.80
F-6000	6000 LB HAMMER	1	151.90	8.00	19.00
F-BAR	BARMILL	1	39.00	8.00	4.90
F-PRESS	1500 TON PRESS	1	195.40	8.00	24.40
GRIND	GRINDING	1	1.00	7.00	0.10
HT	HEAT TREATING	8	1,808.10	192.00	9.40
MACH	MACHINING	50	483.50	350.00	1.40
MATL	MATL IN INVENTORY	20	188.00	160.00	1.20
NDT	NON DEST TEST	30	69.00	30.00	2.30
OS-HT	OUTSIDE HEAT TREAT	1	0.00	7.00	0.00
PO	PURCHASE ORDERS	10	1.00	80.00	0.00
PROCAPP	PROCEDURE APPROVAL	50	180.00	50.00	3.60
SHIP	SHIPPING	1	186.10	12.00	15.50
TEST	DEST TEST	30	133.50	30.00	4.50