

ABSTRACTClosed LoopOne Piece Flow System

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A processing line for use in assembly or inspection line comprising a plurality of tasks with different task time arranged along the processing line in a closed loop
10 vertical formation, wherein each task with a corresponding task time T in the processing line with a throughput of T_p per piece is divided into a number of sub-tasks n , wherein n is T / T_p , such that each sub-task is executed at T_p or less. More particularly, the
15 processing line is used in a dye penetrant inspection line for marking surface crack of components under test.

Figure 1