9705098-3

PCT WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 6: G06F 17/60, G06G 7/48 — A1

(11) International Publication Number: WO 96/35187

(43) International Publication Date: 7 November 1996 (07.11.96)

(21) International Application Number: PCT/US96/05692

(22) International Filing Date: 24 April 1996 (24.04.96)

(30) Priority Data:
08/431,679 2 May 1995 (02.05.95) US

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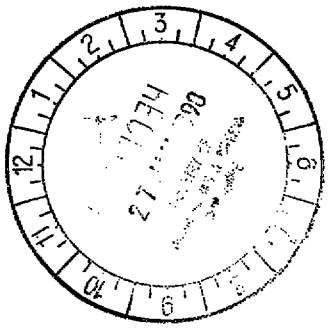
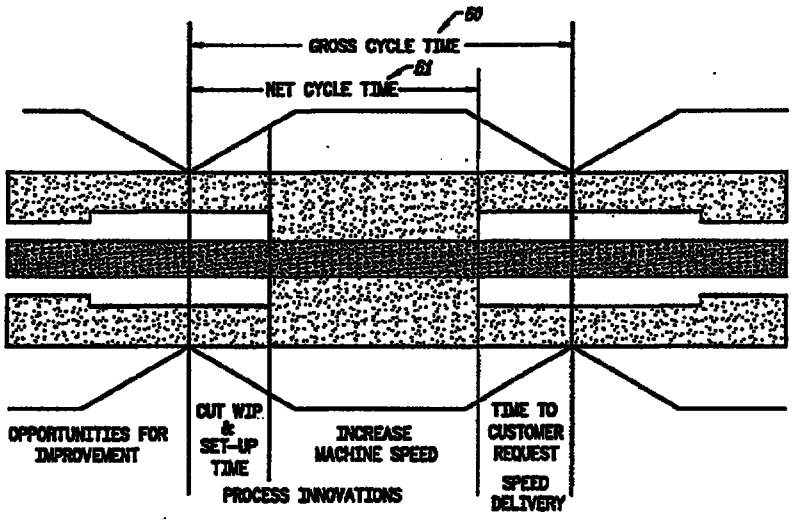
(81) Designated States: AU, BR, CN, JP, MX, SG, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE).

Published
With international search report.



(54) Title: METHOD AND APPARATUS FOR CYCLE TIME COSTING



(57) Abstract

A cycle time costing method and apparatus is provided to obtain cost, efficiency, bottleneck and value creation information in a manufacturing facility. The facility has a plurality of production lines each having a plurality of process steps. A work cell having a plurality of workers is responsible for each process step. Each work cell has a local processor for input of quantity and time information. The local processor communicates to a central processor via a local area network. The central process calculates cycle time costing information regarding each work cell. The cycle time costing information may include, among other information, gross cycle time (60), net cycle time (61), bottleneck costs and scrap information for each process step and/or a product manufactured. The cycle time information is transferred to a printer or display nearby a work cell.