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| **DFA tabel** |
| c1 | c2 | c3\* | c4\* | c5\* | c6\* | c7\* | c8 | C9 | C10 | c11\*\* | NAME OF ASSEMBLY |
| Part ID | Alpha & Bêta symmetry  | # the operation is carried out consecutively | Manual handling code | Manual handling time per part | Manual insertion code | Manual insertion time per part | Insertion direction time | Montage process time | Operation time C3 (c5+c7+c8+c9) | Estimation for theoretical minimum parts |  |
| knopjes | 540 | 6 | 5/2 | 2.6 | 3/5 | 7.0 | 0.4 | 7.0 | 21 | 6 |  |
| Hoofdband | 540 | 4 | 5/2 | 2.6 | 3/5 | 7.0 | 0.4 | 7.0 | 21 | 1 |  |
| Lere kapje | 180 | 1 | 0/9 | 3.0 | 3/5 | 7.0 | 0 | 7.0 | 18 | 2 |  |
| Connectie punt | 540 | 1 | 0/9 | 3.0 | 3/5 | 7.0 | 0 | 7.0 | 18 | 2 |  |
| spiekertjes | 180 | 1 | 0/9 | 3.0 | 3/5 | 7.0 | 0 | 7.0 | 18 | 2 |  |
| spiekerhouder | 180 | 1 | 0/9 | 3.0 | 3/5 | 7.0 | 0 | 7.0 | 18 | 2 |  |
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| **Total:** |  |  |  |  |  |