**A03 – Individual activity**

In a given continuous production flow of a 2-step process, workstation B assembles parts which has its components produced at station A. The demand, properly stabilized, is 5 units/minute. Determine the number of Kanbans for this component between these two workstations, knowing that there is no safety stock and that the parts are transported in containers, with a capacity for 150 units. The times, in minutes, to determine the production cycle, are given below:

|  |  |  |
| --- | --- | --- |
| Process | Time (min) | |
| Workstation A | Workstation B |
| Setup | 6 | 6 |
| Unitary Production Cycle Time | 0.2 | 0.6 |
| Motion | 10 | 7 |
| Waiting | 10 | 20 |