Supplementary Material

for

Proposal to change the Layout in a Job Shop Environment in a Beverage Filling Machinery Industry

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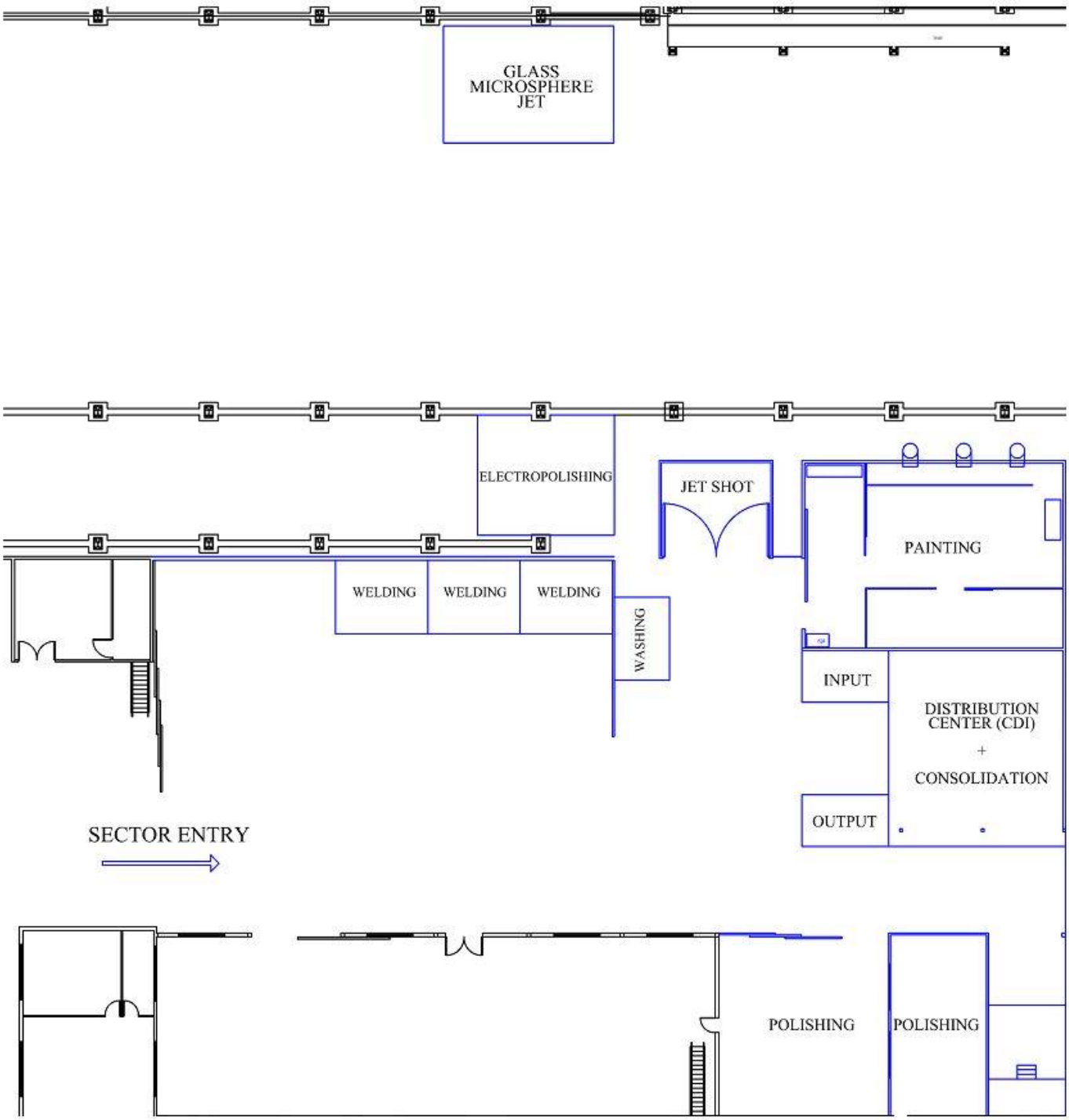


Figure S1. Current layout.

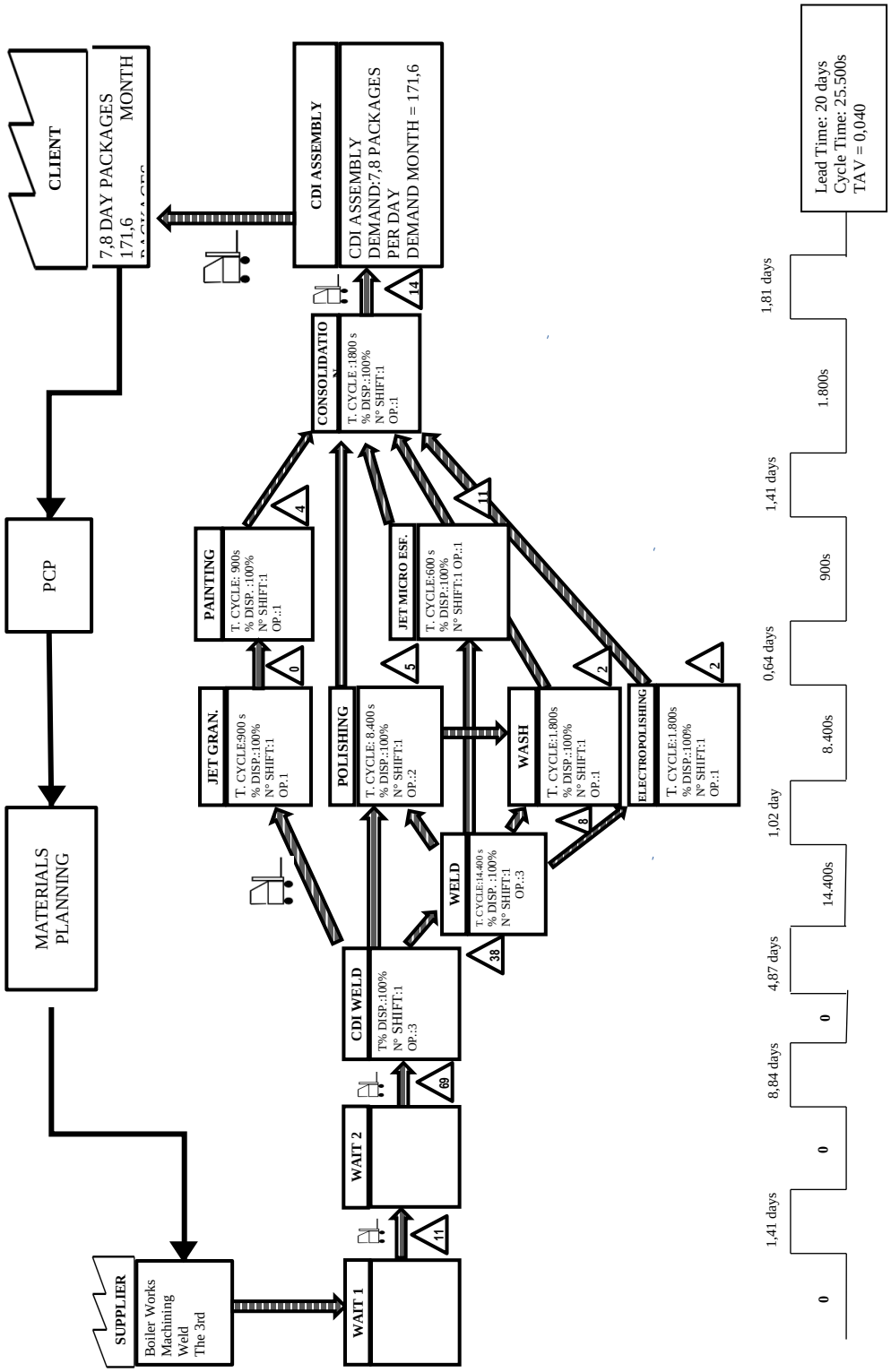
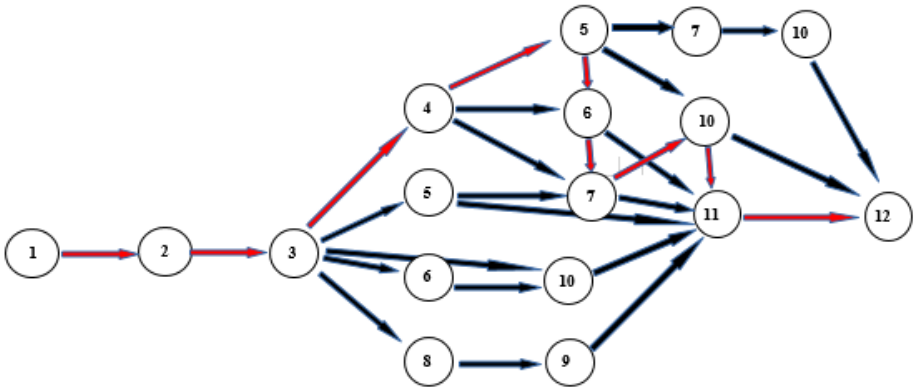


Figure S2. Current state value stream mapping.



	CT's	Critical Path	Distance	Days
01	Prohibites	Prohibited	33	1
02	Wait	1 -> 2	8	10
03	CDI Weld	2 -> 3	13	1
04	Weld	3 -> 4	25	1
05	Polishing	4 -> 5	20	1
06	Electropolishing	5 -> 6	20	1
07	Wash	6 ->7	5	1
08	Grit	7 -> 10	175	2
09	Painting	10 -> 11	200	1
10	Glass Microsphere Jet	11 -> 12	33	1
11	CDI Consolidation	**Total**	**532 meters**	**20 days**
12	CDI Assembly			

Figure S3. Critical path of packages – PERT.

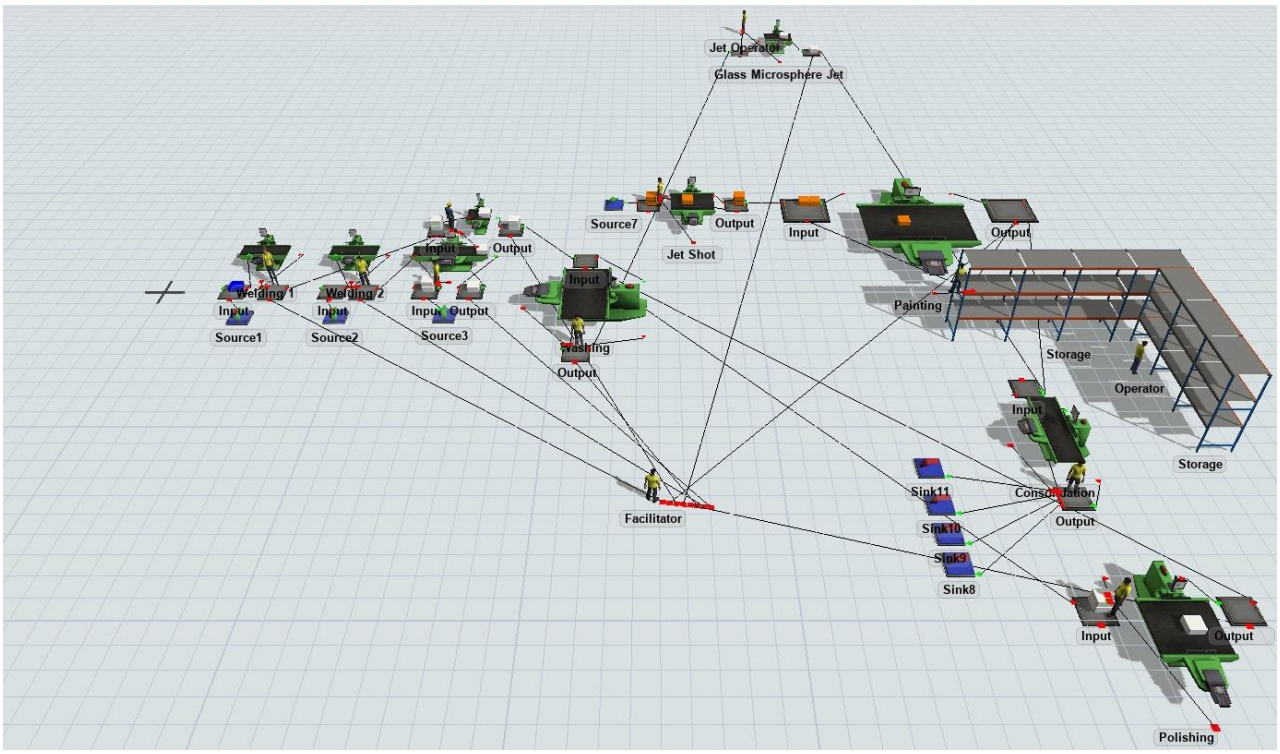


Figure S4. Current layout simulation.

Figure S5. Proposed layout.

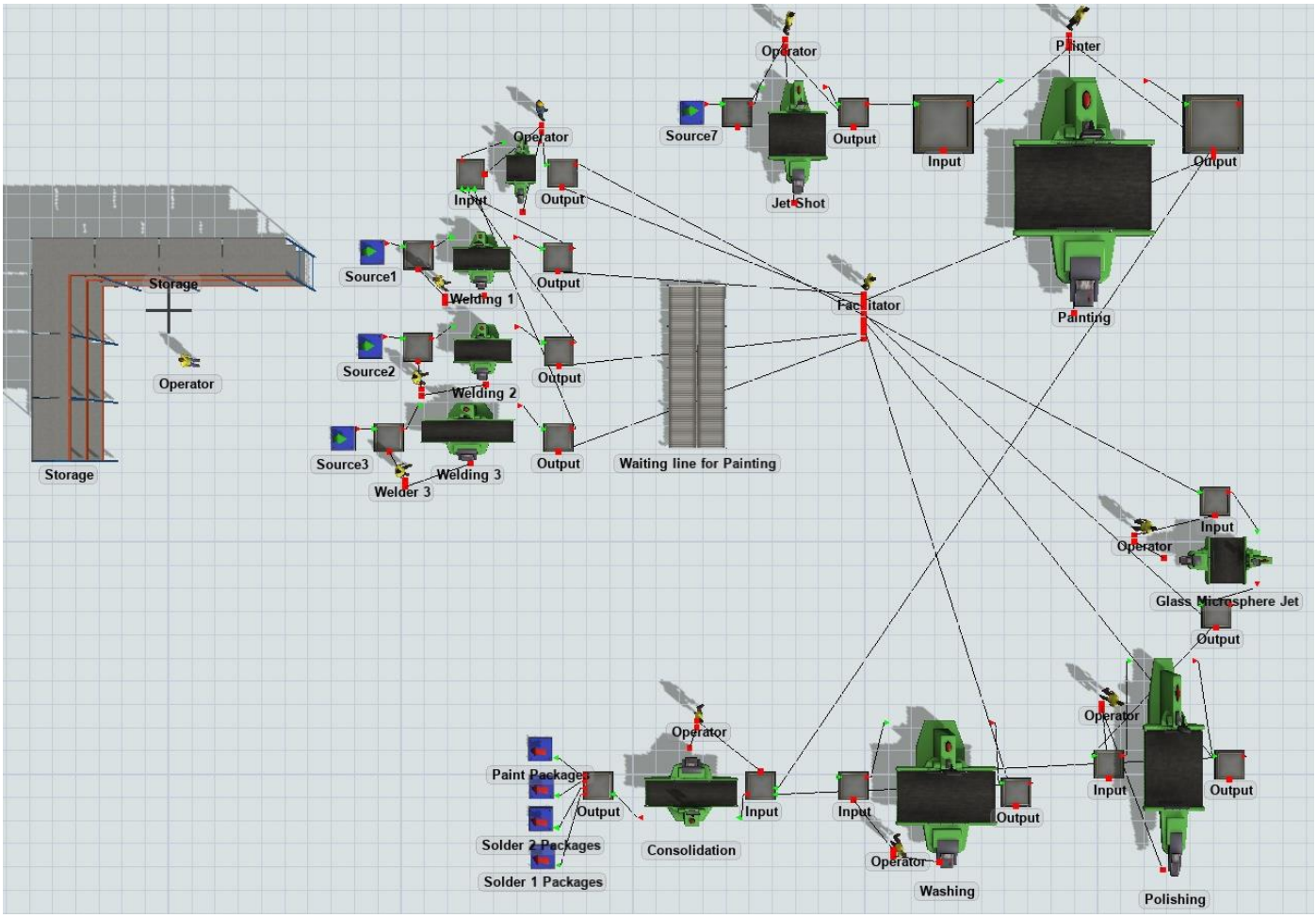


Figure S6. Future state simulation.