

12 USEFUL PERFORMANCE MEASURING FORMULA

- #1. Daily Line Target =
$$\frac{\text{Total working minutes in a day} \times \text{No. of operators} \times \text{line efficiency \%}}{\text{Garment SAM}}$$
- #2. Individual Operator Target =
$$\frac{\text{Total working minutes in a day} \times \text{line efficiency \%}}{\text{Operation SAM}}$$
- #3. Operator Efficiency %(Individual) =
$$\frac{\text{Total pieces produced} \times \text{Operation SAM} \times 100}{\text{Total Minutes worked}}$$
- #4. Line Efficiency % =
$$\frac{\text{Line Output} \times \text{Garment SAM} \times 100}{\text{Total no. of operators} * \text{Minutes worked}}$$
- #5. Machine Productivity =
$$\frac{\text{Line Output (in pieces)}}{\text{Number of Machine used}}$$
- #6. Labor Productivity =
$$\frac{\text{Line Output (in pieces)}}{\text{Number of workers (including operators + helpers)}}$$
- #7. Line Work in Process (WIP) = (Total piece loaded – Total output) Or Total pieces lie on the line
- #8. Standard Time = (Observed Time X Observed Rating) + Allowances**
- #9. Machine Utilization% =
$$\frac{\text{Actual Machine running Time in a working day} \times 100}{\text{Total Time available in a working Day}}$$
- #10. Cost per Minute =
$$\frac{\text{Total cost incurred in Labor}}{\text{Total available working minutes in a Day} \times \text{No. of Labors}}$$
- #11. Production Cost per unit =
$$\frac{\text{Total Production cost incurred in a Day}}{\text{Total Garments produced in a Day}}$$
- #12. Man to Machine Ratio =
$$\frac{\text{Total workforce in a factory}}{\text{Number of utilized machines}}$$

* Add helpers doing manual operations in case manual operation's SAM is included in OB
 ** Allowances – Relaxation and Contingency allowances