

**WWP Supplier Quality  
GP-9 Build at Rate Attachment S-2  
Sequencer Build at Rate Worksheet (estimate)**

SECTION 1 - BASIC INFORMATION		
1.1 SEQUENCER NAME:		
1.2 SEQUENCER ADDRESS:		
1.3 PART/SUB-ASSEMBLY NAME:		
1.4 Supplier Duns Number:		
1.5 Supplier Quality Engineer:		
1.6 Build at Rate Date:		
	<b>UNITS</b>	<b>DATA</b>
SECTION 2 - SEQUENCER INPUT DATA (to be provided by Sequencer)		
2.1 Broadcast Batch Size	# of broadcasts	
2.2 Number of Parts per Rack	# of parts	
2.3 Number of Racks per Shipment	# of racks	
2.4 Number of Shipments per hour	# of shipments	
2.5 Sequencer Pick/Build Rate (capability in terms of number of pieces picked/built per hour)	JPH	
2.6 TIME to <b>MOVE ONE RACK</b> from Picking area to Staging Area or Shipping Dock (if no staging is done)	minutes	
2.7 Sequencer Staging Rate (capability in terms of number of pieces staged per hour)	JPH	
2.8 Time to <b>LOAD ONE RACK</b> to Truck	minutes	
SECTION 3 - TRANSPORT INPUT DATA (to be provided by Transporter)		
3.1 WORST CASE Time required to transport one shipment from Sequencer to GM Plant (non-catastrophic)	minutes	
3.2 SAFETY FACTOR to cover traffic/weather related delays (non-catastrophic)	minutes	
SECTION 4 - GM PLANT INPUT DATA (to be provided by GM Plant)		
4.1 GM PLANT HOURLY PRODUCTION RATE	JPH	
4.2 JOB OFFSET (from job 1 of General Assembly to point of use of sequenced incoming part/sub-assembly)	# of jobs	
4.3 PLANNED MINIMUM SIZE OF BUFFER (number of <b>sequenced jobs</b> between Paint Shop and General Assembly)	# of jobs	
4.4 Percentage Variation expected in PLANNED MINIMUM SIZE OF BUFFER	%	
4.5 Time required to <b>UNLOAD one shipment</b> at the receiving dock of the GM plant (include waiting time)	minutes	
4.6 Time required to <b>MOVE one shipment</b> from dock to the point of use in General Assembly (include all staging)	minutes	
4.7 SAFETY FACTOR to cover unexpected unloading/moving delays (non-catastrophic)	minutes	
SECTION 5 - WORKSHEET CALCULATIONS		
5.1 <b>TIME AVAILABLE</b>	minutes	0.00
5.2 <b>TIME REQUIRED</b> (time between receipt of broadcast at Sequencer to delivery at point of use in General Assembly)	minutes	#DIV/0!
SECTION 6 - SEQUENCER BUILD AT RATE RESULT		status
		<b>FAIL</b>

**PLEASE FILL IN ALL CELLS HIGHLIGHTED IN YELLOW**  
CELLS IN GREEN ARE CALCULATED BY THE WORKSHEET