**Takt Time VSM Template**

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| Takt Time is Total Production Time (minutes) / Average Demand (units). |
| TIME AVAILABLE | TOTAL TIME | BREAKS (min) | CLEANUP (min) | MINUTES AVAILABLE |
| DAYS PER YEAR |  |
| HOURS PER DAY |  |  |  |  |
|  |  |  |  |  |  |  |
| TAKT TIME | PRODUCT 1 | PRODUCT 2 | PRODUCT 3 | PRODUCT 4 | PRODUCT 5 | TOTALS |
| Annual demand |  |  |  |  |  |  |
| Daily demand |  |  |  |  |  |  |
| Percent of total sales |  |  |  |  |  |  |
| Takt Time (minutes per unit) |  |  |  |  |  |  |
| Cycle time per Operator |  |  |  |  |  |  |
| Number of Operators |  |  |  |  |  |  |

DAILY DEMAND Right-Click Chart to Edit Data in Excel

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