**[A blue and white sign

Description automatically generated](https://www.smartsheet.com/try-it?trp=12149&utm_source=template-word&utm_medium=content&utm_campaign=Blank+Takt+Time+VSM-word-12149&lpa=Blank+Takt+Time+VSM+word+12149)Takt Time VSM Template**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 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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