

DFMA FORM 1		RECOGNITION OF CRITICAL COMPONENTS AND SUB-ASSEMBLIES		
Assembly name:		Page: 1/___	Date: _____	
Document number:		Analyzed by: _____ Approved by: _____		
Component	Number of components N	Number of critical components N _{CR}	Assembly time /component T	Summarized assembly time/ component T _{tot} =N×T
Sub-assembly 1 (name: _____)				
1.				
2.				
3.				
4...				
N				
Sub-assembly 2 (name: _____)				
1.				
2.				
3.				
4...				
N				
Sub-assembly N (name: _____)				
1.				
2.				
3.				
4...				
N				
Total number of components:		Σ _N =		
Total number of critical components:			Σ _{NCR} =	
Total assembly time				Σ _{TTOT} =
Total assembly time of critical components	Calculate from above N _{CR} ×T and summarize Σ[N _{CR} ×T]= Σ _{TOTCR}		Σ _{TOTCR} =	
Nominal effectiveness of assembly work	Divide total assembly time by total number of components Σ _{TTOT} /Σ _N		ASEMBLY P _{nom} =	
Practical effectiveness of assembly work	Divide total assembly time by total number of critical components Σ _{TTOT} /Σ _{NKR}		ASEMBLY P _{prac} =	