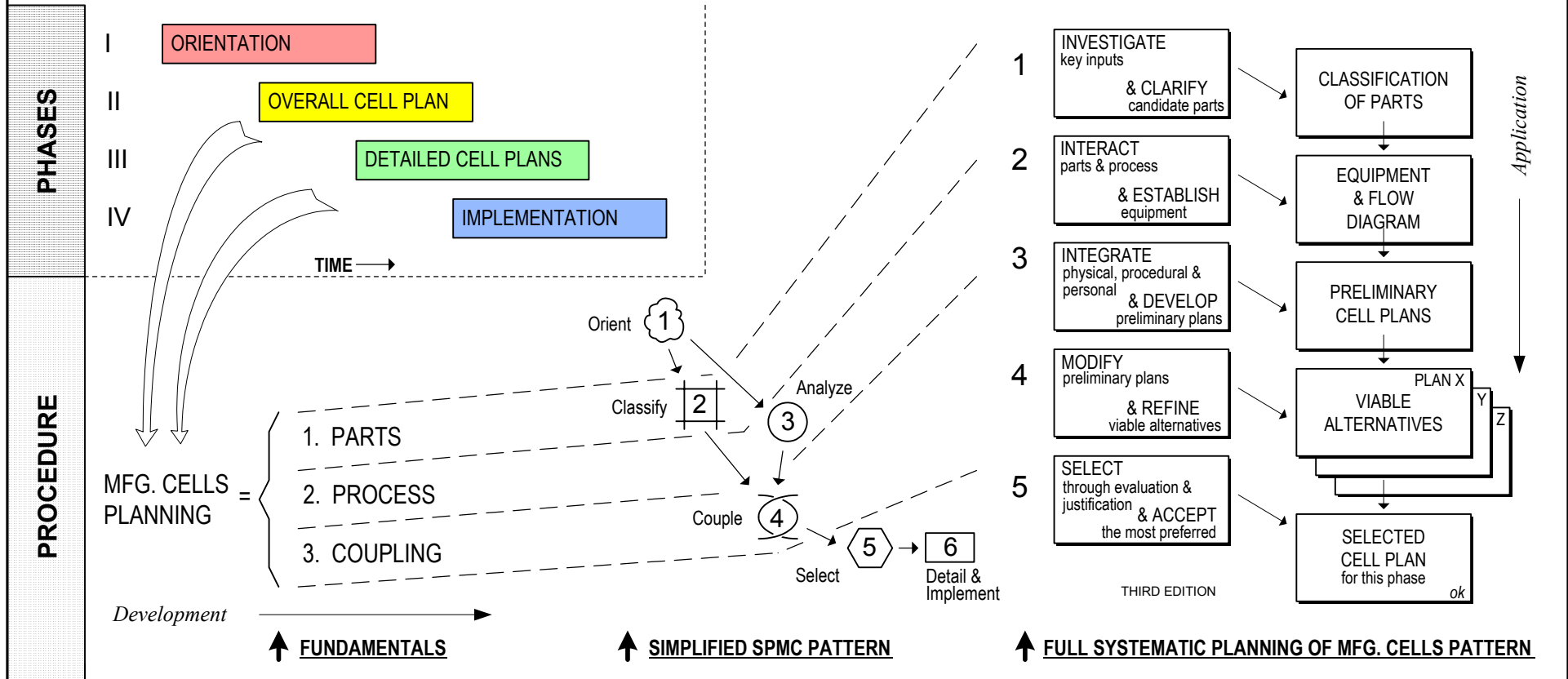


# SYSTEMATIC PLANNING OF MANUFACTURING CELLS -- Capsule Summary



CONVENTIONS	Process Chart Symbols & Action*	Symbols Extended to Identify Equipment & Space	Color Ident.	Black & White**
	* ○ Operation	○	Forming or Treating Equipment & Space	Green**
		○ Assembly, Sub-Assembly, Dis-Assembly	Red**	
* ⇨ Transportation	⇨	⇨ Transport-related Equipment & Space	Orange Yellow**	
* ◇ Handling	◇	◇ Handling Areas -- Pick-up & Set-Down	Orange Yellow**	
* ▽ Storage	▽	▽ Storage Equipment and Space	Orange Yellow**	
* D Delay	D	D Set-down or Hold Areas	Orange Yellow**	
* □ Inspection	□	□ Inspect, Test, Check Equipment & Space	Blue**	
* A.N.S.I. Standard		⌒ Service & Support Equipment & Space	Blue**	
** MHMS (IMMS) Standard		⌒ Office or Planning Areas, or Building Features	Brown** (Gray)	

Vowel Letter	No. Value	No. of Lines	Importance or Intensity Rating	Color Code
A	4		Abnormally High	Red**
E	3		Especially High	Orange Yellow**
I	2		Important	Green**
O	1		Ordinary	Blue**
U	0		Unimportant	Uncolored**
X	Importance only		Not in scope of project	Brown**

Evaluating Description	Letter / Value
Almost Perfect Results (Excellent)	A / 4
Especially Good Results (Very Good)	E / 3
Important Results (Good)	I / 2
Ordinary Results (Fair)	O / 1
Unimportant Results (Poor)	U / 0
Not Acceptable Results (Not Satisfactory)	X / ?