

Engr. Spec. #	Importance	Source	Specification (description)	Unit of Measure	Current Value	Ideal Value
ES1	1	CN1	Inventory			
ES1-1		CN1	Raw materials	weeks/days		
ES1-2		CN1	Work-in-progress	weeks/days		
ES1-3		CN1	finished goods	weeks/days		
ES2	1	CN2	Process Flow			
ES2-1			Cycle times	minutes		
ES2-2			Change-over times	minutes		
ES2-3			inventory lead time	days		0
ES3	1	CN3	Cell Performance			
ES3-1			Efficiency	estimated/actual hours		
ES3-2			Utilization	active/available hours		
ES3-3			Completed Operations	closed operations/week		
ES4	1	CS3	Forecasting process			
ES4-1			Part lead times	days		
ES4-2			Sales projection	\$/month		
ES4-3			Demand estimates	Units/month		
ES5	2	CS4	Forecast Accuracy			
ES5-1			Actual demand	units/month		
ES5-2			Units build to stock vesus order	ratio	80/20	
ES5-3			Order arrival date (days late)	days		0
ES6	2	CS5	New Building Water Requirements			
ES6-1			Pressure	psi		
ES6-2			Capacity	GPM		
ES6-3			Piping length	Ft		
ES7	2	CS5	New Building Space Requirements			
ES7-1			Inventory space	days of inventory		
ES7-2			Process space	square feet		
ES7-3			Aisle space	square feet		