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DWG. NO. HC2648

SH. 1 REV. 1

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| REVISION HISTORY | | | | |
|------------------|------|-----------------------|----------|----------|
| ZONE | REV. | DESCRIPTION | DATE | APPROVED |
| ALL | 1 | ENGINEERING PROTOTYPE | 08/01/06 | ISD |

D

160'

D

C

**OPEN WALL PANEL FRAMING FACTORY
 2 STATION LAYOUT
 19,200 SQUARE FEET**

C

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120'

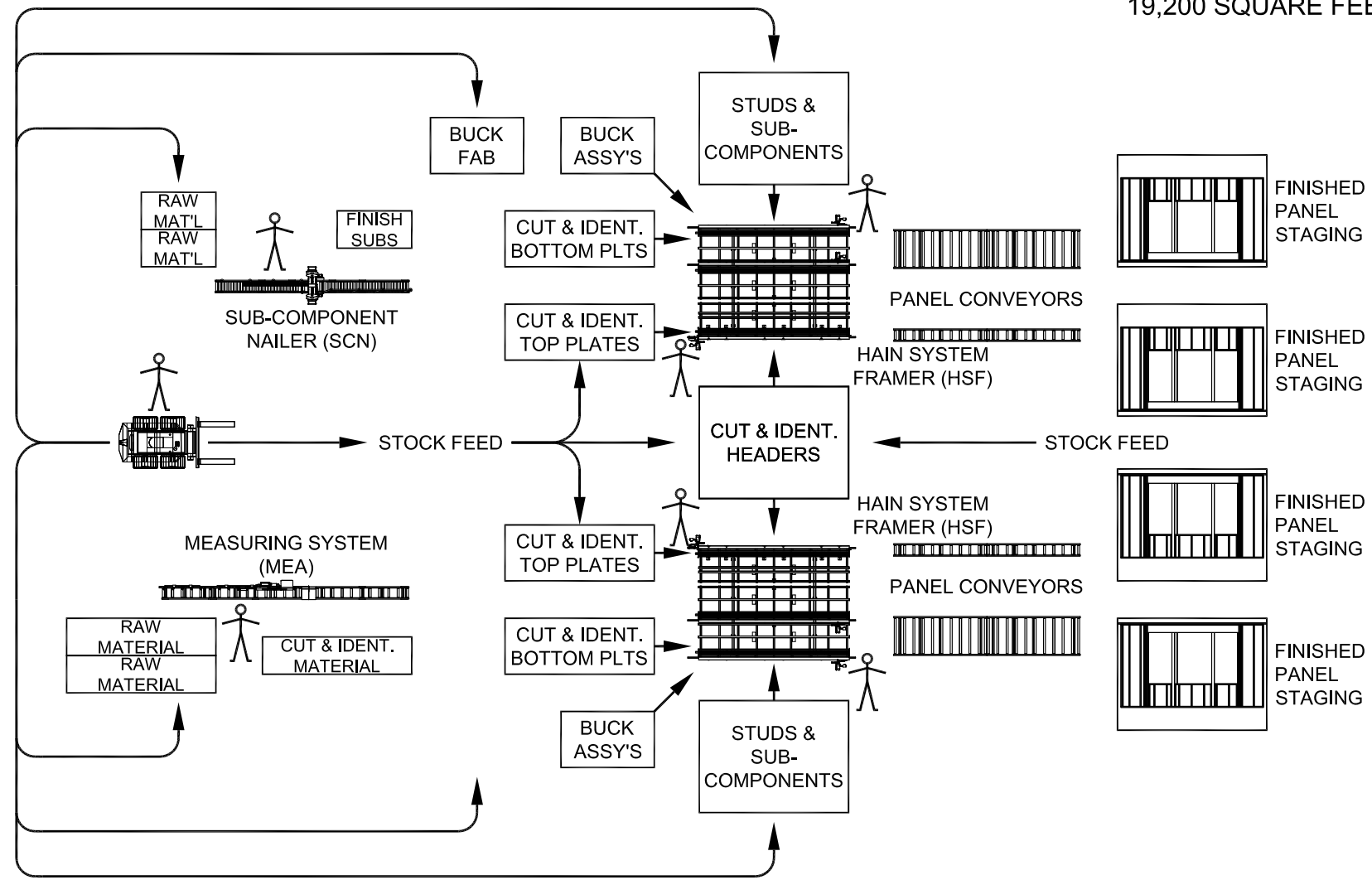
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STANDARD HSF OUTPUT = 800 LINEAR FEET OF OPEN WALL PANELS PER 8 HOUR SHIFT

PLANT LAYOUT SHOWN (SINGLE):
 2X HSF + 1X MEA + 1X SCN + 7 MAN CREW = 1,600 LINEAR FEET PER 8 HOUR SHIFT

THEREFORE:
 1,600 LINEAR FEET ÷ 7 MEN = 229 LINEAR FEET PER MAN PER 8 HOUR SHIFT
 229 ÷ 8 HOUR SHIFT = 29 LINEAR FEET OF OPEN WALL PANELS PER MAN-HOUR

PLANT LAYOUT (DOUBLE):
 4X HSF + 2X MEA + 1X SCN + 12 MAN CREW = 3,200 LINEAR FEET PER 8 HOUR SHIFT

THEREFORE:
 3,200 LINEAR FEET ÷ 12 MEN = 267 LINEAR FEET PER MAN PER 8 HOUR SHIFT
 267 ÷ 8 HOUR SHIFT = 33 LINEAR FEET OF OPEN WALL PANELS PER MAN-HOUR

PLANT LAYOUT (TRIPLE):
 6X HSF + 3X MEA + 1X SCN + 17 MAN CREW = 4,800 LINEAR FT PER 8 HOUR SHIFT

THEREFORE:
 4,800 LINEAR FEET ÷ 17 MEN = 282 LINEAR FEET PER MAN PER 8 HOUR SHIFT
 282 ÷ 8 HOUR SHIFT = 35 LINEAR FEET OF OPEN WALL PANELS PER MAN-HOUR

| | | | | | |
|---------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------|------------------|----------|--------------------------------------------------------|------------------|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994 STANDARD TOLERANCES: | | CONTRACT NO. N/A | | THE HAIN COMPANY Rescue, California | |
| DECIMALS XX ± .02 XXX ± .005 | SURFACE FINISH 125/ ANGLES ± 1° FRACTIONS ± 1/16 | APPROVALS | DATE | TITLE OPEN WALL PANEL FRAMING TABLE PLANT LAYOUT | |
| MATERIAL | SEE NOTES | DRAWN | 08/01/06 | SIZE D | CAGE CODE N/A |
| FINISH | SEE NOTES | CHECKED | | DWG. NO. HC2648 | REV. 1 |
| DO NOT SCALE DRAWING | DESIGN | ISD | 08/01/06 | SCALE 1:1 | SHEET 1 OF 1 |

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