Chapter 4-Production

1. If more flatwork is washed than the full dry can handle, which of the eight Toyota Production System wastes has occurred?
   a. Waiting
   b. Over processing
   c. Overproduction
   d. Excessive Inventory

2. Lowering the standard of quality (allowable stains and tears) will aid in maintaining an adequate par level and will lower costs overall?
   a. True
   b. False

3. Production standards are the same for all textile products you process.
   a. True
   b. False

4. Using the following production data, determine the proper staffing level for a facility:
   Annual Production Task: 3,758,558
   PPOH: 130
   First and Second Break Paid
   Annual Hours Worked: 1950
   a. 12 FTE
   b. 15 FTE
   c. 15.5 FTE
   d. 16 FTE

5. Which of the following is not true about historical data:
   a. It provides required information for setting goals and objectives of the production task.
   b. It is representative of what should occur in a smooth production flow.
   c. It is helpful in analyzing productivity.
   d. A good measure is to analyze data from five years.

6. What are the average pounds per adjusted patient day using the following data?
   Facility size: 350 beds
   Five year average reported pounds per occupied bed: 21.5 pounds
   Adjusted patient Day (APD) factor: 1.44
   Average Occupied bed days: 78%
   a. 14.93
   b. 30.62
   c. 23.8
   d. 11.64

7. Which of the following is not true about production standards?
   a. They should be based on a minimum performance standard and a target standard.
   b. The standard should be developed so it is achievable and maintainable for one hour without a break.
   c. They provide staff with a measurable goal.
   d. They are necessary to establish a successful production flow.
8. Using the following data:

   Facility size: 350 beds
   Five year average reported pounds per occupied bed: 21.5 pounds
   Adjusted patient Day (APD) factor: 1.44
   Average Occupied bed days: 78%

What would 100% of the production requirement be?

   a. 2,746,625
   b. 2,142,367
   c. 3,955,140
   d. 3,085,009

9. Which of the following is true about scheduling staff?

   a. All areas should be fully staffed at the start of every shift.
   b. Since finishing has the highest staffing need, it should be fully staffed during operational hours.
   c. Having all staff start at the same time is the most efficient scheduling plan.
   d. Soil sort staff should be fully staffed for the first hour or more, then some may shift to other locations.

10. Where is the most cost-effective place to reject a sub-quality textile?

    a. When stocking carts
    b. At the point of use
    c. During scheduled quality checks
    d. At the folders

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**Chapter 4 – Production Answers**

1)  C “Overproduction” Page 105
2)  B “False” Page 107
3)  B “False” Page 126
4)  B “15 FTE” Pages 122-123
5)  B “It is representative of what should occur in a smooth production flow” Page 109-110
6)  A “14.93” Pages 111-112
7)  B “The standard should be developed so it is achievable and maintainable for one hour without a break” Page 113
8)  A “2,746,625” Pages 111-112
9)  D “Soil sort staff should be fully staffed for the first hour or more, then some may shift to other locations” Pages 121-122
10) D “At the folders” Page 128