

ANEXO 2. EJEMPLO DE HOJA DE SALIDA

MAQUINA M6 (minutos)

| ORDEN | CAMBIO DE SABOR | | PROCESO | | TIEMPO DE PROCESO | TIEMPO DE CAMBIO |
|-------|-----------------|--------|---------|--------|-------------------|------------------|
| | INICIO | FIN | INICIO | FIN | | |
| 1 | 0.0 | 0.0 | 0.0 | 24.2 | 24.2 | 0.00 |
| 1 | 24.2 | 24.2 | 24.2 | 46.8 | 22.6 | 0.00 |
| 1 | 46.8 | 46.8 | 46.8 | 75.1 | 28.3 | 0.00 |
| 1 | 75.1 | 75.1 | 75.1 | 102.4 | 27.3 | 0.00 |
| 1 | 102.4 | 102.4 | 102.4 | 129.4 | 27.0 | 0.00 |
| 1 | 129.4 | 129.4 | 129.4 | 157.9 | 28.5 | 0.00 |
| 1 | 157.9 | 157.9 | 157.9 | 182.7 | 24.8 | 0.00 |
| 1 | 182.7 | 182.7 | 182.7 | 205.8 | 23.1 | 0.00 |
| 1 | 205.8 | 205.8 | 205.8 | 234.7 | 28.9 | 0.00 |
| 1 | 234.7 | 234.7 | 234.7 | 262.3 | 27.6 | 0.00 |
| 1 | 262.3 | 262.3 | 262.3 | 289.5 | 27.2 | 0.00 |
| 2 | 289.5 | 349.5 | 349.5 | 375.9 | 26.4 | 60.00 |
| 2 | 375.9 | 375.9 | 375.9 | 399.3 | 23.4 | 0.00 |
| 2 | 399.3 | 399.3 | 399.3 | 425.9 | 26.6 | 0.00 |
| 2 | 425.9 | 425.9 | 425.9 | 451.8 | 25.9 | 0.00 |
| 2 | 451.8 | 451.8 | 451.8 | 474.4 | 22.6 | 0.00 |
| 2 | 474.4 | 474.4 | 474.4 | 501.2 | 26.8 | 0.00 |
| 2 | 501.2 | 501.2 | 501.2 | 525.9 | 24.7 | 0.00 |
| 2 | 525.9 | 525.9 | 525.9 | 554.4 | 28.5 | 0.00 |
| 2 | 554.4 | 554.4 | 554.4 | 578.3 | 23.9 | 0.00 |
| 2 | 578.3 | 578.3 | 578.3 | 606.1 | 27.8 | 0.00 |
| 2 | 606.1 | 606.1 | 606.1 | 634.3 | 28.3 | 0.00 |
| 2 | 634.3 | 634.3 | 634.3 | 659.6 | 25.3 | 0.00 |
| 2 | 659.6 | 659.6 | 659.6 | 685.4 | 25.8 | 0.00 |
| 3 | 685.4 | 745.4 | 745.4 | 771.1 | 25.7 | 60.00 |
| 3 | 771.1 | 771.1 | 771.1 | 791.9 | 20.8 | 0.00 |
| 3 | 791.9 | 791.9 | 791.9 | 816.7 | 24.8 | 0.00 |
| 3 | 816.7 | 816.7 | 816.7 | 842.2 | 25.5 | 0.00 |
| 3 | 842.2 | 842.2 | 842.2 | 866.2 | 23.9 | 0.00 |
| 3 | 866.2 | 866.2 | 866.2 | 890.5 | 24.3 | 0.00 |
| 3 | 890.5 | 890.5 | 890.5 | 918.7 | 28.2 | 0.00 |
| 3 | 918.7 | 918.7 | 918.7 | 941.5 | 22.8 | 0.00 |
| 3 | 941.5 | 941.5 | 941.5 | 970.0 | 28.5 | 0.00 |
| 3 | 970.0 | 970.0 | 970.0 | 994.4 | 24.4 | 0.00 |
| 3 | 994.4 | 994.4 | 994.4 | 1022.1 | 27.7 | 0.00 |
| 3 | 1022.1 | 1022.1 | 1022.1 | 1048.4 | 26.3 | 0.00 |
| 3 | 1048.4 | 1048.4 | 1048.4 | 1074.0 | 25.6 | 0.00 |
| 3 | 1074.0 | 1074.0 | 1074.0 | 1094.7 | 20.7 | 0.00 |
| 4 | 1094.7 | 1154.7 | 1154.7 | 1178.4 | 23.7 | 60.00 |
| 4 | 1178.4 | 1178.4 | 1178.4 | 1202.8 | 24.3 | 0.00 |
| 4 | 1202.8 | 1202.8 | 1202.8 | 1231.0 | 28.3 | 0.00 |
| 4 | 1231.0 | 1231.0 | 1231.0 | 1255.7 | 24.7 | 0.00 |
| 4 | 1255.7 | 1255.7 | 1255.7 | 1280.6 | 24.9 | 0.00 |
| 4 | 1280.6 | 1280.6 | 1280.6 | 1309.9 | 29.3 | 0.00 |
| 4 | 1309.9 | 1309.9 | 1309.9 | 1335.7 | 25.8 | 0.00 |
| 4 | 1335.7 | 1335.7 | 1335.7 | 1362.8 | 27.1 | 0.00 |
| 4 | 1362.8 | 1362.8 | 1362.8 | 1385.9 | 23.2 | 0.00 |
| 4 | 1385.9 | 1385.9 | 1385.9 | 1409.2 | 23.3 | 0.00 |
| 4 | 1409.2 | 1409.2 | 1409.2 | 1437.3 | 28.0 | 0.00 |
| 4 | 1437.3 | 1437.3 | 1437.3 | 1465.5 | 28.3 | 0.00 |
| 4 | 1465.5 | 1465.5 | 1465.5 | 1491.8 | 26.3 | 0.00 |
| 4 | 1491.8 | 1491.8 | 1491.8 | 1517.5 | 25.7 | 0.00 |
| 4 | 1517.5 | 1517.5 | 1517.5 | 1539.9 | 22.4 | 0.00 |
| 4 | 1539.9 | 1539.9 | 1539.9 | 1566.4 | 26.5 | 0.00 |
| 4 | 1566.4 | 1566.4 | 1566.4 | 1590.6 | 24.2 | 0.00 |
| 4 | 1590.6 | 1590.6 | 1590.6 | 1612.9 | 22.3 | 0.00 |
| 4 | 1612.9 | 1612.9 | 1612.9 | 1636.7 | 23.8 | 0.00 |
| 4 | 1636.7 | 1636.7 | 1636.7 | 1661.7 | 25.0 | 0.00 |
| 4 | 1661.7 | 1661.7 | 1661.7 | 1688.6 | 26.9 | 0.00 |
| 4 | 1688.6 | 1688.6 | 1688.6 | 1715.9 | 27.3 | 0.00 |
| 4 | 1715.9 | 1715.9 | 1715.9 | 1745.6 | 29.7 | 0.00 |
| 4 | 1745.6 | 1745.6 | 1745.6 | 1770.7 | 25.2 | 0.00 |
| 4 | 1770.7 | 1770.7 | 1770.7 | 1792.9 | 22.2 | 0.00 |
| 4 | 1792.9 | 1792.9 | 1792.9 | 1819.3 | 26.4 | 0.00 |
| 4 | 1819.3 | 1819.3 | 1819.3 | 1847.5 | 28.2 | 0.00 |
| 4 | 1847.5 | 1847.5 | 1847.5 | 1873.1 | 25.5 | 0.00 |
| 4 | 1873.1 | 1873.1 | 1873.1 | 1896.7 | 23.6 | 0.00 |
| 4 | 1896.7 | 1896.7 | 1896.7 | 1919.7 | 23.0 | 0.00 |
| 4 | 1919.7 | 1919.7 | 1919.7 | 1942.8 | 23.1 | 0.00 |
| 4 | 1942.8 | 1942.8 | 1942.8 | 1967.5 | 24.7 | 0.00 |
| 4 | 1967.5 | 1967.5 | 1967.5 | 1994.7 | 27.2 | 0.00 |
| 4 | 1994.7 | 1994.7 | 1994.7 | 2019.3 | 24.6 | 0.00 |
| 4 | 2019.3 | 2019.3 | 2019.3 | 2045.8 | 26.6 | 0.00 |
| 4 | 2045.8 | 2045.8 | 2045.8 | 2071.3 | 25.5 | 0.00 |
| 4 | 2071.3 | 2071.3 | 2071.3 | 2094.4 | 23.0 | 0.00 |
| 4 | 2094.4 | 2094.4 | 2094.4 | 2118.2 | 23.8 | 0.00 |
| 4 | 2118.2 | 2118.2 | 2118.2 | 2139.5 | 21.2 | 0.00 |
| 4 | 2139.5 | 2139.5 | 2139.5 | 2166.6 | 27.2 | 0.00 |
| 4 | 2166.6 | 2166.6 | 2166.6 | 2187.3 | 20.7 | 0.00 |
| 4 | 2187.3 | 2187.3 | 2187.3 | 2211.8 | 24.5 | 0.00 |
| 4 | 2211.8 | 2211.8 | 2211.8 | 2236.3 | 24.5 | 0.00 |
| 4 | 2236.3 | 2236.3 | 2236.3 | 2263.6 | 27.3 | 0.00 |
| 4 | 2263.6 | 2263.6 | 2263.6 | 2288.3 | 24.8 | 0.00 |
| 4 | 2288.3 | 2288.3 | 2288.3 | 2316.5 | 28.2 | 0.00 |
| 4 | 2316.5 | 2316.5 | 2316.5 | 2339.6 | 23.1 | 0.00 |
| 4 | 2339.6 | 2339.6 | 2339.6 | 2366.5 | 26.9 | 0.00 |
| 4 | 2366.5 | 2366.5 | 2366.5 | 2386.7 | 20.3 | 0.00 |
| 4 | 2386.7 | 2386.7 | 2386.7 | 2411.1 | 24.3 | 0.00 |
| 4 | 2411.1 | 2411.1 | 2411.1 | 2434.7 | 23.6 | 0.00 |
| 4 | 2434.7 | 2434.7 | 2434.7 | 2458.9 | 24.1 | 0.00 |
| 4 | 2458.9 | 2458.9 | 2458.9 | 2484.5 | 25.6 | 0.00 |
| 4 | 2484.5 | 2484.5 | 2484.5 | 2506.2 | 21.7 | 0.00 |
| 4 | 2506.2 | 2506.2 | 2506.2 | 2527.0 | 20.9 | 0.00 |
| 4 | 2527.0 | 2527.0 | 2527.0 | 2552.9 | 25.9 | 0.00 |
| 4 | 2552.9 | 2552.9 | 2552.9 | 2581.0 | 28.1 | 0.00 |

MAQUINA M7 (minutos)

| ORDEN | CAMBIO DE SABOR | | PROCESO | | TIEMPO DE PROCESO | TIEMPO DE CAMBIO |
|-------|-----------------|--------|---------|--------|-------------------|------------------|
| | INICIO | FIN | INICIO | FIN | | |
| 1 | 0.0 | 0.0 | 0.0 | 33.4 | 33.4 | 0.00 |
| 1 | 33.4 | 33.4 | 33.4 | 65.9 | 32.4 | 0.00 |
| 1 | 65.9 | 65.9 | 65.9 | 101.1 | 35.2 | 0.00 |
| 1 | 101.1 | 101.1 | 101.1 | 133.7 | 32.6 | 0.00 |
| 1 | 133.7 | 133.7 | 133.7 | 166.1 | 32.4 | 0.00 |
| 1 | 166.1 | 166.1 | 166.1 | 201.2 | 35.2 | 0.00 |
| 1 | 201.2 | 201.2 | 201.2 | 234.3 | 33.0 | 0.00 |
| 1 | 234.3 | 234.3 | 234.3 | 271.7 | 37.5 | 0.00 |
| 1 | 271.7 | 271.7 | 271.7 | 308.2 | 36.4 | 0.00 |
| 2 | 308.2 | 398.2 | 398.2 | 431.7 | 33.5 | 90.00 |
| 2 | 431.7 | 431.7 | 431.7 | 466.2 | 34.5 | 0.00 |
| 2 | 466.2 | 466.2 | 466.2 | 499.0 | 32.9 | 0.00 |
| 2 | 499.0 | 499.0 | 499.0 | 537.9 | 38.9 | 0.00 |
| 2 | 537.9 | 537.9 | 537.9 | 572.1 | 34.1 | 0.00 |
| 2 | 572.1 | 572.1 | 572.1 | 609.6 | 37.5 | 0.00 |
| 2 | 609.6 | 609.6 | 609.6 | 644.3 | 34.7 | 0.00 |
| 2 | 644.3 | 644.3 | 644.3 | 679.8 | 35.5 | 0.00 |
| 2 | 679.8 | 679.8 | 679.8 | 713.8 | 34.0 | 0.00 |
| 2 | 713.8 | 713.8 | 713.8 | 752.0 | 38.2 | 0.00 |
| 3 | 752.0 | 842.0 | 842.0 | 875.6 | 33.6 | 90.00 |
| 3 | 875.6 | 875.6 | 875.6 | 910.8 | 35.2 | 0.00 |
| 3 | 910.8 | 910.8 | 910.8 | 941.2 | 30.4 | 0.00 |
| 3 | 941.2 | 941.2 | 941.2 | 973.0 | 31.8 | 0.00 |
| 3 | 973.0 | 973.0 | 973.0 | 1011.6 | 38.5 | 0.00 |
| 3 | 1011.6 | 1011.6 | 1011.6 | 1050.9 | 39.3 | 0.00 |
| 3 | 1050.9 | 1050.9 | 1050.9 | 1086.2 | 35.3 | 0.00 |
| 3 | 1086.2 | 1086.2 | 1086.2 | 1120.0 | 33.8 | 0.00 |
| 3 | 1120.0 | 1120.0 | 1120.0 | 1155.9 | 35.9 | 0.00 |
| 4 | 1155.9 | 1245.9 | 1245.9 | 1278.8 | 32.9 | 90.00 |
| 4 | 1278.8 | 1278.8 | 1278.8 | 1315.3 | 36.5 | 0.00 |
| 4 | 1315.3 | 1315.3 | 1315.3 | 1349.1 | 33.9 | 0.00 |
| 4 | 1349.1 | 1349.1 | 1349.1 | 1383.7 | 34.6 | 0.00 |
| 4 | 1383.7 | 1383.7 | 1383.7 | 1418.2 | 34.4 | 0.00 |
| 4 | 1418.2 | 1418.2 | 1418.2 | 1452.8 | 34.6 | 0.00 |
| 4 | 1452.8 | 1452.8 | 1452.8 | 1487.5 | 34.8 | 0.00 |
| 4 | 1487.5 | 1487.5 | 1487.5 | 1525.7 | 38.2 | 0.00 |
| 4 | 1525.7 | 1525.7 | 1525.7 | 1558.4 | 32.7 | 0.00 |
| 4 | 1558.4 | 1558.4 | 1558.4 | 1593.1 | 34.6 | 0.00 |
| 4 | 1593.1 | 1593.1 | 1593.1 | 1630.2 | 37.1 | 0.00 |
| 4 | 1630.2 | 1630.2 | 1630.2 | 1663.3 | 33.2 | 0.00 |
| 4 | 1663.3 | 1663.3 | 1663.3 | 1696.7 | 33.4 | 0.00 |
| 4 | 1696.7 | 1696.7 | 1696.7 | 1729.7 | 33.0 | 0.00 |
| 4 | 1729.7 | 1729.7 | 1729.7 | 1763.4 | 33.7 | 0.00 |
| 4 | 1763.4 | 1763.4 | 1763.4 | 1795.1 | 31.6 | 0.00 |
| 4 | 1795.1 | 1795.1 | 1795.1 | 1833.8 | 38.7 | 0.00 |
| 4 | 1833.8 | 1833.8 | 1833.8 | 1871.1 | 37.2 | 0.00 |
| 4 | 1871.1 | 1871.1 | 1871.1 | 1905.7 | 34.6 | 0.00 |
| 4 | 1905.7 | 1905.7 | 1905.7 | 1940.7 | 35.0 | 0.00 |
| 4 | 1940.7 | 1940.7 | 1940.7 | 1974.1 | 33.4 | 0.00 |
| 4 | 1974.1 | 1974.1 | 1974.1 | 2004.8 | 30.7 | 0.00 |
| 4 | 2004.8 | 2004.8 | 2004.8 | 2042.0 | 37.1 | 0.00 |
| 4 | 2042.0 | 2042.0 | 2042.0 | 2077.7 | 35.8 | 0.00 |
| 4 | 2077.7 | 2077.7 | 2077.7 | 2116.2 | 38.5 | 0.00 |
| 4 | 2116.2 | 2116.2 | 2116.2 | 2153.1 | 36.9 | 0.00 |
| 4 | 2153.1 | 2153.1 | 2153.1 | 2186.8 | 33.8 | 0.00 |
| 4 | 2186.8 | 2186.8 | 2186.8 | 2221.2 | 34.3 | 0.00 |
| 4 | 2221.2 | 2221.2 | 2221.2 | 2256.5 | 35.3 | 0.00 |
| 4 | 2256.5 | 2256.5 | 2256.5 | 2288.8 | 32.3 | 0.00 |
| 4 | 2288.8 | 2288.8 | 2288.8 | 2322.2 | 33.4 | 0.00 |
| 4 | 2322.2 | 2322.2 | 2322.2 | 2357.5 | 35.2 | 0.00 |
| 4 | 2357.5 | 2357.5 | 2357.5 | 2392.5 | 35.0 | 0.00 |
| 4 | 2392.5 | 2392.5 | 2392.5 | 2423.7 | 31.2 | 0.00 |
| 4 | 2423.7 | 2423.7 | 2423.7 | 2457.3 | 33.6 | 0.00 |
| 4 | 2457.3 | 2457.3 | 2457.3 | 2494.7 | 37.4 | 0.00 |
| 4 | 2494.7 | 2494.7 | 2494.7 | 2532.0 | 37.4 | 0.00 |
| 4 | 2532.0 | 2532.0 | 2532.0 | 2567.8 | 35.8 | 0.00 |
| 4 | 2567.8 | 2567.8 | 2567.8 | 2604.7 | 36.9 | 0.00 |
| 4 | 2604.7 | 2604.7 | 2604.7 | 2641.0 | 36.3 | 0.00 |
| 4 | 2641.0 | 2641.0 | 2641.0 | 2676.1 | 35.0 | 0.00 |
| 4 | 2676.1 | 2676.1 | 2676.1 | 2714.2 | 38.2 | 0.00 |
| 4 | 2714.2 | 2714.2 | 2714.2 | 2750.3 | 36.0 | 0.00 |
| 4 | 2750.3 | 2750.3 | 2750.3 | 2788.5 | 38.3 | |