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| Operation | Time | Daily Capacity |
| Step 1: Cutting fabric | 4 min | 420 / 4 = 105 |
| Step 2: Stitching fabric | 7 min | 420 / 7 = 60 |
| Step 3: Adding zippers, toggles, liners | 10 min | 420 / 10 = 42 |
| Step 4: Inspecting, packing, labeling | 5 min | 420 / 5 = 84 |