

CONTROL_SHIFT



MEASURE.CONTROL.MAXIMISE.

Printing Press example

Operator Screen

At the start of the print job the operator enters the Work Order Id which is used by the system to load the Work Order Number and Product Description fields. Also loaded are the target Machine speed, Throughput and Setup Time that have been previously entered by the Press manager as shown by the yellow pointers on the bar charts. The operator then enters his four digit logon code which identifies who the operator is for the current job.

When the press is started the system starts recording how many meters have been run and calculates an average Machine speed which gives the operator an indication of how fast they are running against the Standard Machine speed as displayed on The Machine Speed bar chart.

When the Press stops the operator is prompted to select a reason from the available buttons that the press has stopped running. The total meters run is divided by the total time the job has been running to calculate and display the Throughput value which gives a good measurement of the amount of material produced over a complete shift.

The downtime reasons displayed can be set by the Press Manager up to a maximum of twenty reasons. The buttons visibility and text is set when the application starts by reading the information from the database.

The shift Uptime bar chart is updated every 15 minutes to give the operator and manager a clear indication of how long the press has been running.

An additional feature of this system that relates directly to the print industry is that at the start of a print job the press is started and stopped multiple times to check the print quality and colour. To prevent the material being run showing up in the reports as uptime there is a settable delay that requires that a certain amount of meters must be run continuously before it is assumed that the press is running usable material.

Shift Report

At the end of each shift a shift report displays the performance of each separate job and an overall list of the downtime reasons for the shift.

KPI Report

The KPI report can be run across any time period. The example shown below has been run across one month.

CONTROL_Shift

KPI Report

Date range: 01/04/2014 12:59:40 to 30/04/2014 12:59:46

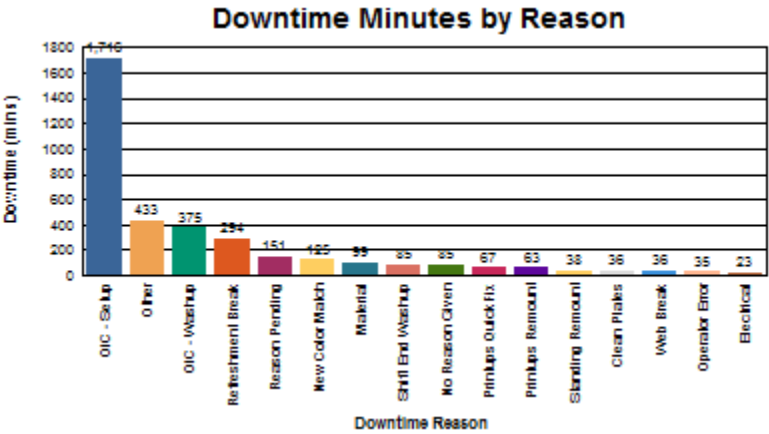
Shift: A

Printing Press

Total Elapsed Time 7,561 min
Machine Utilization: 4,407 min 58%

	min	%
Uptime	744	16.89
Downtime:		
No Reason Given	85	1.93
Reason Pending	151	3.42
Clean Plates	36	0.82
Electrical	23	0.53
Material	99	2.25
New Colour Match	125	2.85
O/C - Setup	1,716	38.94
O/C - Washup	375	8.52
Operator Error	35	0.79
Other	433	9.84
Printups QuickFix	67	1.52
Printups Remount	63	1.43
Refreshment Break	294	6.66
Shift End Washup	85	1.93
Standing Remount	38	0.87
Web Break	36	0.81

Total Setup Time	2,215	min			
Flying Order Changes	0				
Average Setup Time	96.31	min	Standard Setup Time (Average)	121.85	min 79.03 %
Actual Average Linespeed	228.06	mpm	Average Aim Linespeed	241.40	mpm 94.48 %
Throughput	77.43	mpm	Standard Throughput	150.09	mpm 51.59 %



CONTROL_Shift

Shift Report for Timestamp

Selected timestamp: 10/04/2014 12:04

Shift: C Day Shift
Date: 10/04/2014 07:00 to 10/04/2014 19:00
Report Time: 22/07/2014 12:09

Printing Press

Shift Downtime Summary

Machine Utilization:		88%	(minutes)
Downtime:	Uptime	132	20.82%
	No Reason Given	10	1.54%
	Clean Plates	10	1.56%
	New Colour Match	62	9.80%
	O/C - Setup	393	61.89%
	Other	3	0.45%
	Refreshment Break	25	3.94%

Shift Throughput Summary

Average		Standard														
Shift Linespeeds:		121	180	mpm												
Start Time	Finish Time	Order #	ID #	Order Change (min)		Operator	Shift (Lm)	Total Order (Lm)	Uptime (min) (%)		Downtime (min)	Linespeed (mpm)		Throughput (mpm)		Reason for Variance
				Actual	Std							Average	Aim	Average	Standard	
10/04/14 08:19:51	10/04/14 12:56:33	NPDN431	1013403	147	219	John Smith	7,520	7,520	59	21%	71	128	180	58	152	
10/04/14 13:02:56	10/04/14 18:58:38	103328.1	1004603	247	219	John Smith	8,538	18,692	74	20%	39	116	180	76	152	

NCM Machine Roll #'s: _____

Comments: _____

Supervisor Signature