

Suspect machines do not run full shift hours at nights

During night shifts, it is common for operators to run the machines at higher feed-rates using the FRO and complete the target quantity in a shorter time and idle the rest of the time. This has an adverse effect on the quality of parts, reduces tool life and machine life.

Solution

Since every cycle start / end is automatically captured on the machine when it happens, the hourly parts counts report gives away the operators' trick. Each working hour would show more parts being made than the norm, and idling hours would show zero parts.

Other benefits to you from this feature

- How many parts have been made in each hour?
- Total parts count that shift. Is the parts count consistent with hourly production norms?
- Is there a pattern in the hourly parts count?
- How many hours did machine produce no parts?
- Evidence of any goofing off by the operator

From	11/5/2007 6:00:00AM
Upto	11/5/2007 6:00:00PM
Asset	Machines

Hourly parts count



Inconsistent hourly part count

Machine	Batch no	Part name	Part no.	Setup no.	Hour 1	Hour 2	Hour 3	Hour 4	Hour 5	Hour 6	Hour 7	Hour 8	Hour 9	Hour 10	Hour 11	Hour 12	Total
LT25-MC01	DS7829	PT0301000-T46	1200	1	71	35											106
	DS7834	PT0300800-T42	1187	1		10	56	113	113	129	128	127	121	121	117	134	1169
LT2-MC11	DS7830	RP671PT00	1323	1	83	131	131	108	125	129	131	107	97	111	123	86	1362
LC16-MC12	DS7825	PXZH091448	1290	1	201	358	357	324	229	249	377	326	213	321	375	370	3700
LC16-MC14	ES71195	RR1300950-Z52	1355	1	34	61	39	53									187
	ES71203	RSK300950-T46	1529	1016						11	76						87
	ES71203	RSK300950-T46	1529	1							12	76	60	26	113	117	404
LC16-MC15	ES71180	PG590D007-T05	1085	1	160	186	222	189	213	206	169	175	188	187	215	214	2324
LC16-MC16	ES71204	RS1500400-Z51	1473	1	55	103	62	33									253
	ES71187	PXYS092162T4C	1285	1				2	22	158	152	126	118	145	169	170	1062
LT25-MC17	FS71174	PT0300850-T46	1192	1	107	143	140	134	132	125	123	119	103	111	108	115	1460
OKUMA 48	ES71192	PT0000180-T46	1144	1	170	318	313	244	261	338	343	278	327	337	353	352	3634
MAZAK-MC51	ES71200	PT0401000-T42	1219	1	31												31
	DS7837	PT0301150-T42	1206	1		11	55	74	90	93	87	86	25				521
	DS7835	PGWN000013-T	1856	1									1	41	90	105	237
MAZAK-MC50	ES71202	PQ0301600-T46	1105	1							21	36	17	31	35	28	168
MAZAK-MC49	ES71196	PT0300900-T46	1195	1	56	68	59	67	103	100	79	62	67	77	93	77	908