

## Operators do not stick to standard cycle times, part load/unload times

We spend a lot of time and resources in arriving at optimal cycle times and part loading/unloading times to maximize profitability. However, we have very little control over the process when it hits the shop floor, if the operators do not stick or are unable to stick to producing parts within these standard times. We have no trusted method to measure the deviations to take timely corrective action. We can have an inspector to check; even this cannot be a viable solution considering the sheer volume of the task. If these violations are not checked, we are sure to lose revenue on every single part we make.

## Solution

Every cycle start and cycle end is captured by SHOPtrack electronically directly from the machine as and when it happens. Assuring us 100% guaranteed of accurate cycle times, however small or big the cycle time may be. Same for part load and unload times. This ensures that cycle time and part load time is captured for every single part made. This is compared with the standard times in the database, deviations are highlighted and waste is made visible to all. This information not only helps in correcting slow operators but also gives us an excellent tool to verify our set norms and fine tune them by revising the norms upwards or downwards.

### Other benefits to you from this feature

- Our standard cycle times : do they need to be revised?
- Were there any deviations in the standard cycle times and part loading/unloading times?
- Which machine, part, operator are causing the deviations?
- Are deviations happening at a specific time of the day or shift?
- Deviation patterns prompt us to analyse and investigate.

From	6/11/2008 3:15:00PM
Upto	6/11/2008 11:15:00PM
Asset	116 CNC 2

## Cycle and downtime chart



Sl. no.	Batch no.	Part name	Part no.	Setup no.	Operator	Cycle started at	Cycle ended at	Cycle time	Cycle time deviation	Load/unload time	Load/unload time deviation
1	A534	2020-1	2020	1	Vishal	6/11/2008 3:30:25 PM	6/11/2008 3:33:23 PM	00:02:58	- 00:00:32	00:00:27	00:00:22
2	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:33:50 PM	6/11/2008 3:36:47 PM	00:02:57	- 00:00:33	00:00:49	00:00:44
3	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:37:36 PM	6/11/2008 3:40:34 PM	00:02:58	- 00:00:32	00:01:40	00:01:35
4	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:42:14 PM	6/11/2008 3:45:12 PM	00:02:58	- 00:00:32	00:02:06	00:02:01
5	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:47:18 PM	6/11/2008 3:50:16 PM	00:02:58	- 00:00:32	00:01:06	00:01:01
6	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:51:22 PM	6/11/2008 3:55:02 PM	00:03:40	00:00:10	00:00:37	00:00:32
7	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:55:39 PM	6/11/2008 3:59:19 PM	00:03:40	00:00:10	00:00:29	00:00:24
8	BC-100	2020-1	2020	1	Vishal	6/11/2008 3:59:48 PM	6/11/2008 4:03:28 PM	00:03:40	00:00:10	00:01:05	00:01:00
9	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:04:33 PM	6/11/2008 4:08:15 PM	00:03:42	00:00:12	00:01:24	00:01:19
10	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:09:39 PM	6/11/2008 4:12:54 PM	00:03:15	- 00:00:15	00:02:21	00:02:16
11	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:15:15 PM	6/11/2008 4:18:36 PM	00:03:21	- 00:00:09	00:00:52	00:00:47
12	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:19:28 PM	6/11/2008 4:22:58 PM	00:03:30	00:00:00	00:01:04	00:00:59
13	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:24:02 PM	6/11/2008 4:27:32 PM	00:03:30	00:00:00	00:00:14	00:00:09
14	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:27:46 PM	6/11/2008 4:31:17 PM	00:03:31	00:00:01	00:00:17	00:00:12
15	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:31:34 PM	6/11/2008 4:35:03 PM	00:03:29	- 00:00:01	00:00:13	00:00:08
16	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:35:16 PM	6/11/2008 4:38:47 PM	00:03:31	00:00:01	00:00:18	00:00:13
17	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:39:05 PM	6/11/2008 4:42:35 PM	00:03:30	00:00:00	00:00:19	00:00:14
18	BC-100	2020-1	2020	1	Vishal	6/11/2008 4:42:54 PM	6/11/2008 4:46:23 PM	00:03:29	- 00:00:01	00:00:17	00:00:12