

## Operators start machines late / stop early at shift changes and breaks

Management considers shift start to shift end as available machine time and makes business calculations based on that. But does that happen in the shopfloor? Operators punch in at the gate in time but do they start the machines on time, similarly do they run the machines till shift end? There is no way to check this wastage of time. This theft of time happens at every shift change, at every tea break and lunch break and goes un-noticed and unaccounted for, overturning all profitability calculations.

### Solution

The operator begins his shift by logging in to the mPOD, the wireless machine tracking unit attached to the machine, using his password and logs off at the end of the shift. This time period reflects his true availability. It enables us capture and map every operator's complete daily activity authentically. Permitting operators to view this report after very shift could become an excellent tool for self improvement for them.

### Other benefits to you from this feature

- When did the operator log in / off on the machine?
- How long was he working on the machine?
- Which part or parts did he make?
- How many good or bad parts did he make?
- How parts many should he be making and how many is he making?
- How many has he made so far?

<b>From</b>	11/5/2007 2:00:00PM
<b>Upto</b>	11/30/2007 6:00:00AM
<b>Asset</b>	Abhilash D

## Activity overview



Late login by 21 minute

Date (yyyy-MM-dd)	Activity	Part no.	Start time	End time	Duration (hrs.)	Target quantity	Quantity produced	Percentage of target	Quantity rejected	Downtime (hrs.)
2007-11-05	Login		14:21:07							
	DS7837	1206	14:21:07	14:30:07	00:09:00	700	0	0.00	0	00:09:00
	DS7835	1856	14:30:07	22:02:46	07:32:39	0	557	99.10	5	03:25:32
	Logout			22:02:46	07:41:39					03:34:32
2007-11-06	Login		14:19:49							
	DS7835	1856	14:19:49	22:02:13	07:42:24	0	664	99.10	6	02:51:59
	Logout			22:02:13	07:42:24					02:51:59
2007-11-07	Login		14:04:42							
	DS7835	1856	14:04:42	06:08:34	16:03:52	0	450	100.00	0	09:42:42
	Logout			06:08:34	16:03:52					09:42:42
2007-11-12	Login		06:13:18							
	DS7835	1856	06:13:18	14:02:07	07:48:49	0	690	99.57	3	02:51:15
	Logout			14:02:07	07:48:49					02:51:15
2007-11-13	Login		06:54:48							
	DS7835	1856	06:54:48	14:02:44	07:07:56	0	764	99.61	3	02:26:22
	Logout			14:02:44	07:07:56					02:26:22