

Operators run machines with FRO set to 120% at nights

This need not necessarily happen during night shifts. Whenever there is a need to take an illegal break or make 'gift parts' to gift the night shift operator, it is common for operators to tamper and increase the feed rates with FRO set to 120%. This has an adverse effect on the quality of parts, reduces tool life and machine life.

Solution

Every cycle start and cycle end is captured by SHOPtrack electronically directly from the machine as and when it happens. Assuring us 100% accurate cycle times, however small or big the cycle time may be. Same for part load / unload times. This ensures that cycle time and part load time is captured for every single part made. When this captured data is plotted against the standard times in the database as histograms, the trick gets exposed. 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

- Which machine was misused?
- Which operator is responsible for it?
- Date and time of misuse.
- Duration of the misuse.

