

crewed hrs	overtime hrs	total hrs	make ready hrs	no. make readies	run hrs	lost time hrs	no. good sheets	av. make ready (min)	av. run speed	% lost time	av. lot size	sheets per manned hour
4302	0	4302	2,444.80	1,276.00	1,076.30	780.60	10,816,550	114.96	10,050	18%	8,477	2514
3930	0	3930	2,270.50	1,295.00	858.60	800.90	8,518,020	105.20	9,921	20%	6,578	2167
4342	0	4342	2,409.10	1,501.00	1,085.70	847.50	10,593,195	96.30	9,757	20%	7,057	2440
4479	0	4479	2,774.50	1,767.00	807.70	897.00	7,692,195	94.21	9,524	20%	4,353	1717
4407	0	4407	2,945.10	2,053.00	724.70	737.40	7,319,290	86.07	10,100	17%	3,565	1661
2722	0	2722	1,892.50	1,048.00	345.50	484.00	2,327,476	108.35	6,737	18%	2,221	855
<b>24182</b>	<b>0</b>	<b>24182</b>	<b>14,736.50</b>	<b>8,940.00</b>	<b>4,898.50</b>	<b>4,547.40</b>	<b>47,266,726</b>	<b>98.90</b>	<b>9,649</b>	<b>19%</b>	<b>5,287</b>	<b>1955</b>
	<b>0%</b>		<b>0.6</b>		<b>20%</b>							

crewed hrs	overtime hrs	total hrs	make ready hrs	no. make readies	run hrs	lost time hrs	no. good sheets	av. make ready (min)	av. run speed	% lost time	av. lot size	sheets per manned hour
784	0	2899	1174	1,792	1,154	442	7,116,944	39.31	6,167	15%	3,972	2455
856	0	3018	1214	1,862	1,179	624	6,967,254	39.12	5,909	21%	3,742	2309
898	0	3414	1437	2,035	1,481	496	8,539,228	42.37	5,766	15%	4,196	2501
880	0	2847	1244	1,082	1,065	539	5,562,340	68.98	5,223	19%	5,141	1954
602	0	1948	769	721	816	363	4,329,169	63.99	5,305	19%	6,004	2222
1005	0	3763	982	1,356	1,959	732	10,859,334	43.45	5,543	19%	8,008	2886
<b>5025</b>	<b>0</b>	<b>17889</b>	<b>6820</b>	<b>8,848</b>	<b>7,654</b>	<b>3,196</b>	<b>43,374,269</b>	<b>46.25</b>	<b>5,667</b>	<b>18%</b>	<b>4,902</b>	<b>2437</b>
	<b>0%</b>		<b>38%</b>		<b>43%</b>							

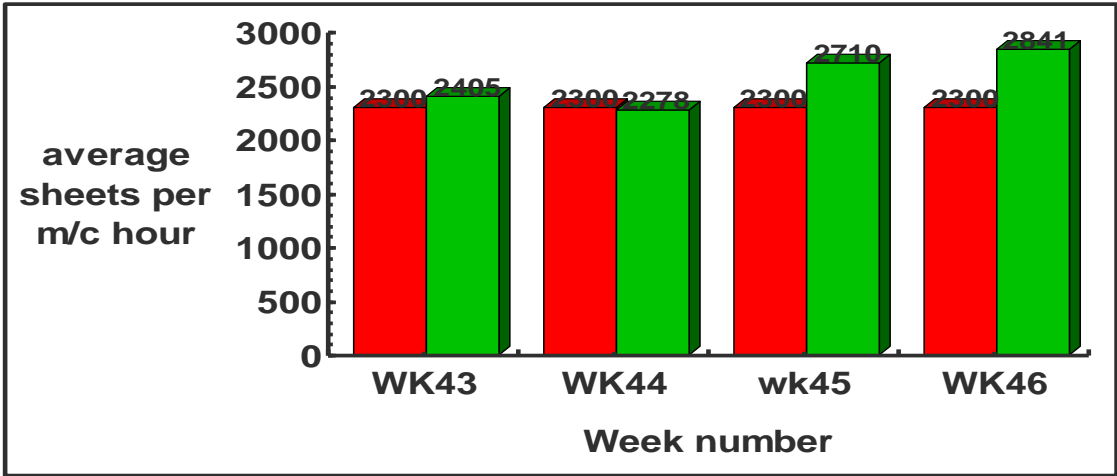
  

crewed hrs	overtime hrs	total hrs	make ready hrs	no. make readies	run hrs	lost time hrs	no. good cartons	av. make ready (min)	av. run speed	% lost time	av. lot size	cartons per manned hour
621	0	2608	738	1,521	1,595	226	38,319,552	29.11	24,025	9%	25,194	14693
550	0	2220	660	1,323	1,205	355	33,494,313	29.93	27,796	16%	25,324	15088
551	0	2154	719	1,511	1,169	265	43,375,005	28.55	37,104	12%	28,706	20137
552	0	1540	461	735	759	260	18,945,932	37.63	24,962	17%	25,777	12303
553	0	2744	709	650	1,817	219	14,293,112	65.45	7,866	8%	21,989	5209
522	0	2203	653	1,409	1,177	374	31,757,755	27.81	26,982	17%	22,539	14416
617	0	2837	256	232	2,181	401	35,419,915	66.21	16,240	14%	152,672	12485
701	0	2567	342	755	1,753	472	116,383,850	27.18	66,391	18%	152,151	45338
652	0	2603	524	925	1,636	443	100,011,258	33.99	61,132	17%	108,120	38422
<b>5319</b>	<b>0</b>	<b>21476</b>	<b>5062</b>	<b>9,061</b>	<b>13,292</b>	<b>3,015</b>	<b>432,000,692</b>	<b>33.52</b>	<b>32,505</b>	<b>15%</b>	<b>47,679</b>	<b>20117</b>
	<b>0%</b>		<b>24%</b>		<b>62%</b>							

Av. 60,000; Total no. of Av. batch size; No of good sheets; No. of job; No. cartons; No. of jobs; Having a *job* average; Productivity per manned hour; Overall index.

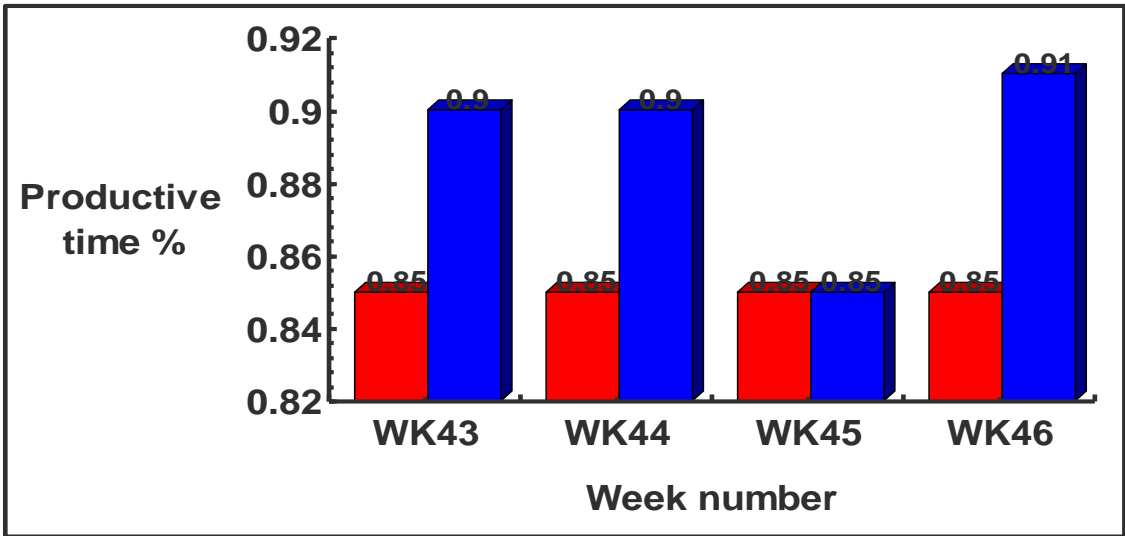
Figure 1: Spreadsheet of process data

### AVERAGE SPEED



Target Actual

### Productive Time



Target Actual

Figure 2: Bar charts derived from process data

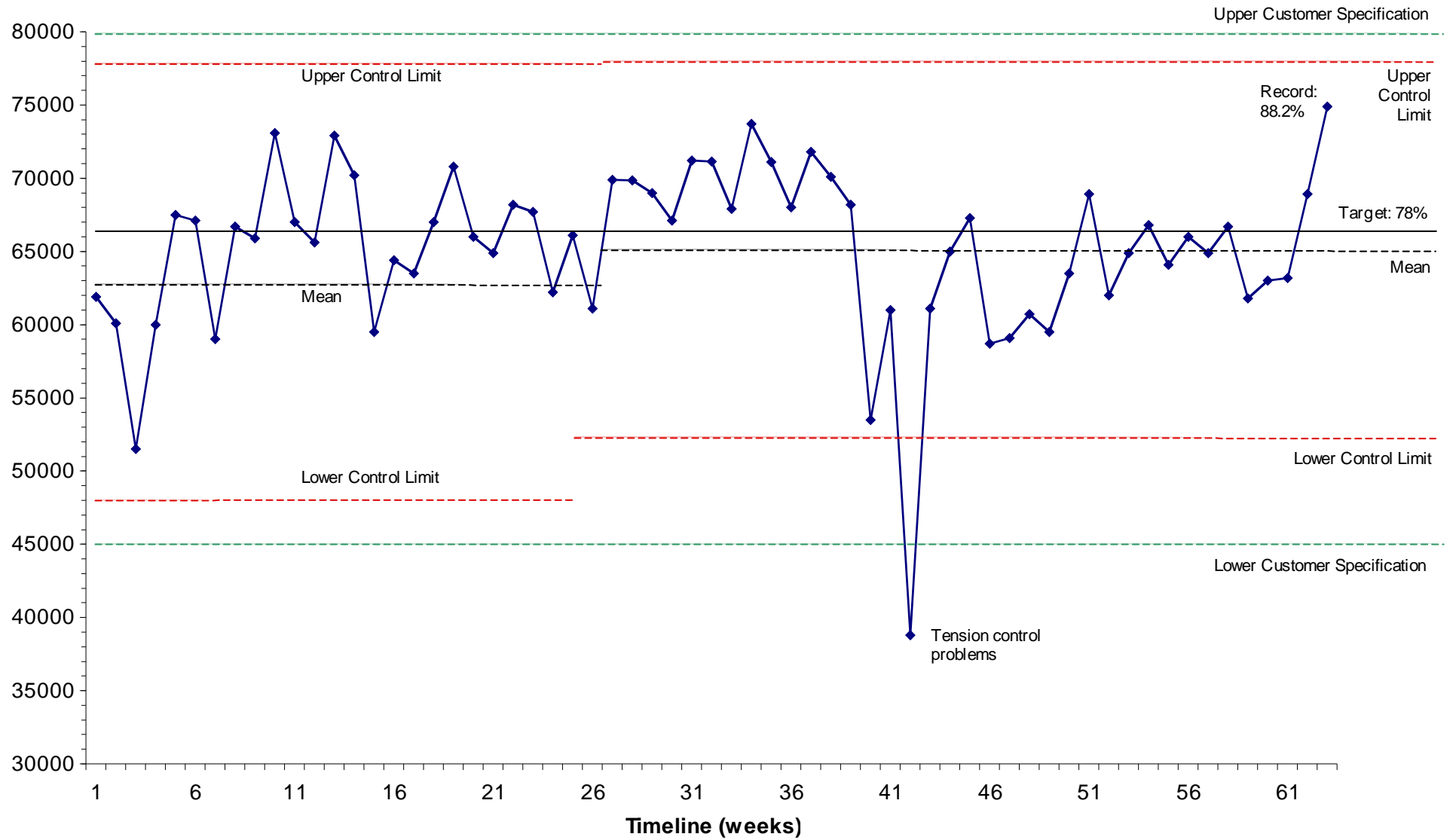


Fig 3: Illustrative SPC Chart



PRODUCTION PERFORMANCE										
Process	S	M	T	W	T	F	S	Target	Previous Week	Comments
DM1 wt	107	108	108	108	108	108	108	108	108	108
DM2 wt	107	108	108	108	108	108	108	108	108	108
DM3 wt	107	108	108	108	108	108	108	108	108	108
DM4 wt	107	108	108	108	108	108	108	108	108	108
DM5 wt	107	108	108	108	108	108	108	108	108	108
DM6 wt	107	108	108	108	108	108	108	108	108	108
DM7 wt	107	108	108	108	108	108	108	108	108	108
DM8 wt	107	108	108	108	108	108	108	108	108	108
DM9 wt	107	108	108	108	108	108	108	108	108	108
DM10 wt	107	108	108	108	108	108	108	108	108	108
DM11 wt	107	108	108	108	108	108	108	108	108	108
DM12 wt	107	108	108	108	108	108	108	108	108	108
DM13 wt	107	108	108	108	108	108	108	108	108	108
DM14 wt	107	108	108	108	108	108	108	108	108	108
DM15 wt	107	108	108	108	108	108	108	108	108	108
DM16 wt	107	108	108	108	108	108	108	108	108	108
DM17 wt	107	108	108	108	108	108	108	108	108	108
DM18 wt	107	108	108	108	108	108	108	108	108	108
DM19 wt	107	108	108	108	108	108	108	108	108	108
DM20 wt	107	108	108	108	108	108	108	108	108	108

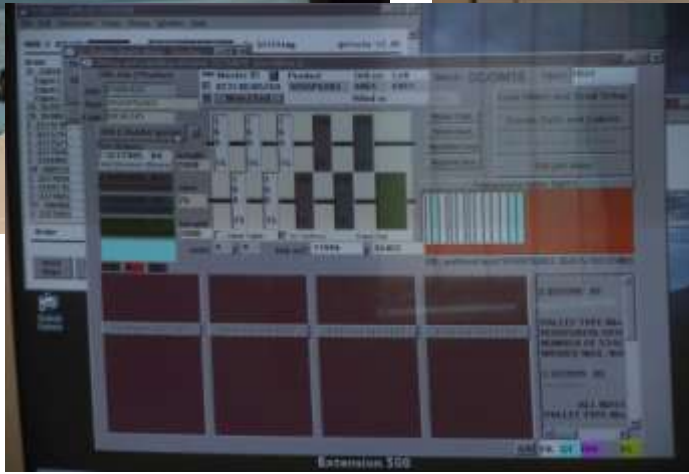
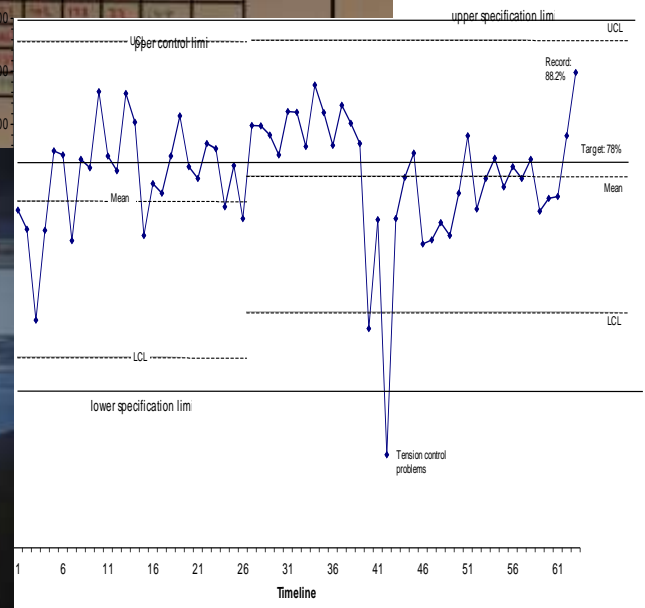


Fig 4: A factory floor with example data displays