

All Down Reasons Report Yearly

Report Date From : 1/1/2003 12:00:00AM TO 11/30/2003 11:59:59PM

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Department Slitting

Shift No. **1**

<u>01 #540 Slitter</u>	<u>Down Hrs</u>	<u>Down Reason</u>	<u>Count</u>	<u>Avg Down. Hrs</u>	<u>Down %</u>
	218.79 Hrs	N/C- Break Time	205	1.07 Hrs	8.98%
	91.40 Hrs	Change Job	212	0.43 Hrs	3.75%
	148.68 Hrs	Coil Change	495	0.30 Hrs	6.10%
	9.02 Hrs	N/C- Company Meeting	7	1.29 Hrs	0.37%
	30.28 Hrs	Knife Change	55	0.55 Hrs	1.24%
	201.80 Hrs	N/C- Lunch	208	0.97 Hrs	8.28%
	13.09 Hrs	N/C- Missing Personel	13	1.01 Hrs	0.54%
	159.70 Hrs	N/C- No Operator	72	2.22 Hrs	6.55%
	2.92 Hrs	N/C- No Work	6	0.49 Hrs	0.12%
	2.89 Hrs	N/C- Non-Conforming	5	0.58 Hrs	0.12%
	544.11 Hrs	N/C- Not Scheduled	340	1.60 Hrs	22.32%
	440.82 Hrs	Packaging	717	0.61 Hrs	18.08%
	0.17 Hrs	PM Gage Calib	4	0.04 Hrs	0.01%
	8.66 Hrs	Quality Check	10	0.87 Hrs	0.36%
	0.92 Hrs	Reset Arbors	1	0.92 Hrs	0.04%
	20.22 Hrs	Reset Machine	139	0.15 Hrs	0.83%
	8.00 Hrs	Scrap Winder	52	0.15 Hrs	0.33%
	397.64 Hrs	Set-Up	777	0.51 Hrs	16.31%
	19.47 Hrs	N/C- Sweep & Clean	61	0.32 Hrs	0.80%
	38.46 Hrs	Tie-Up	37	1.04 Hrs	1.58%
	2.22 Hrs	N/C- Training	1	2.22 Hrs	0.09%
	0.41 Hrs	N/C- Union Business	1	0.41 Hrs	0.02%
	25.37 Hrs	N/C- Unpl Elec Brkdn	47	0.54 Hrs	1.04%
	2.44 Hrs	N/C- Unpl Hydr Brkdn	1	2.44 Hrs	0.10%
	10.86 Hrs	N/C- Unpl Mach Brkdn	12	0.90 Hrs	0.45%
	0.15 Hrs	N/C- Unscheduled Rewind	1	0.15 Hrs	0.01%
	10.84 Hrs	N/C- Wait for OK	22	0.49 Hrs	0.44%
	11.15 Hrs	N/C- Wait For Work	37	0.30 Hrs	0.46%
	17.20 Hrs	N/C- Wait Information	154	0.11 Hrs	0.71%
2,437.68 Hrs			3,692		

Notes: **N/C** = No Charge Down: Total No-Charge Hrs: 1,252.44 Total Charge Hrs: 1,185.24

This Report can be run by Day, Week, Month or Yearly showing each shift allowing you to see trends that are developing. You are then able to see where your problems are. Less down time increases Run Time. It will also be helpful to show you your average down times so you can improve you estimating. If you don't know why your machine is stopping you can't fix your problems. \$\$\$