



TIME SAVER SYSTEMS

IMPAX TSS-NETVIEWING SAMPLES

Microsoft Excel - IMPAX TSS Viewer.xls

IMPAX TSS Viewing System

Intro Summary Detail View

Summary View OEE View Reporting Setup

Print this Page

Shop Floor Summary

Machine Name	Machine Status	Current PPM	Current Efficiency	Current Production	Today's OEE	View OEE Details	View Machine Details
Header 1	UP	95	95.0%	92%	33.00%	View Details	View Details
Header 2	UP	97	97.0%	95%	30.15%	View Details	View Details
Header 3	DOWN	0	0.0%	12%	11.43%	View Details	View Details
Header 4	UP	102	102.0%	99%	92.66%	View Details	View Details
Header 5	UP	82	82.0%	90%	89.75%	View Details	View Details
Roller 1	UP	54	54.0%	62%	68.52%	View Details	View Details
Roller 2	DOWN	0	0.0%	56%	55.55%	View Details	View Details
Roller 3	DOWN	0	0.0%	1%	1.23%	View Details	View Details
Roller 4	UP	87	87.0%	90%	89.54%	View Details	View Details
Roller 5	UP	90	90.0%	86%	87.78%	View Details	View Details

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Detail View OEE View Reporting Setup

Detail View for machine: Header 1

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Current Status

Machine Status: UP Current Part: ABC 123
 Current RPM: 95 Current Operator: 112
 Current PPM: 94 Current Job: 0
 Current Scrap: 0 Current Message: Send maint. help

Efficiencies

Instant Efficiencies: Current Shift Efficiencies: Daily Efficiencies:

	Actual	Ideal	Effic	Time	Actual	Planned	Effic	Time	Shift 1	Shift 2	Shift 3	Total
RPM	95	100	95%	422	400	88%	88%	88%	88%	0%	0%	88%
Feed	94	100	94%	4100	4100	100%	100%	100%	100%	0%	0%	100%
PPM	94	95	99%	4100	4800	85%	85%	85%	85%	0%	0%	85%
Parts	94	95	99%	4100	4800	85%	85%	85%	85%	0%	0%	85%

Up/Down Times

Daily Minutes Weekly Minutes Monthly Minutes Yearly Minutes

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Up/Down Times

Shift	Daily Minutes			Weekly Minutes			Monthly Minutes			Yearly Minutes		
	Up	Down	Resp	Up	Down	Resp	Up	Down	Resp	Up	Down	Resp
Shift 1	422	21	6	422	21	6	2550	52	23	1524	512	201
Shift 2	0	0	0	0	0	0	2375	48	15	1624	842	395
Shift 3	0	0	0	0	0	0	7851	84	31	14255	351	186
Total:	422	21	6	422	21	6	7876	164	69	45743	1705	782

Production Counts

Order Counters:	Daily	Weekly	Monthly	Yearly
Order Quantity:	10000	77	248632	1458623
Parts Made:	2485	7535	232171	1423965
Percent Made:	24	76	41000	41000

Tool Counters

Tool	Expected Life	Life Used	Life Remaining
DRILL	10000	10000	0
CHISEL	10000	7800	2200
TOOL 3	0	0	0
TOOL 4	0	0	0
TOOL 5	0	0	0
TOOL 6	0	0	0
TOOL 7	0	0	0
TOOL 8	0	0	0
TOOL 9	0	0	0

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Tool Counters

(change color to yellow at 75 percent, and to red at 100 percent)

Tool	Expected Life	Life Used	Life Remaining
OIL	10000	10000	0
LUBE	10000	100	9900
MAINT 3	0	0	0
MAINT 4	0	0	0
MAINT 5	0	0	0
MAINT 6	0	0	0
MAINT 7	0	0	0
MAINT 8	0	0	0
MAINT 9	0	0	0

Maintenance Counters

(change color to yellow at 75 percent, and to red at 100 percent)

Code	Expected Life	Life Used	Life Remaining
1 MACHINE SETUP	1	45	13

Downtime Reasons

Code	Description	Daily Codes Occur	Weekly Codes Occur	Monthly Codes Occur	Yearly Codes Occur
1	MACHINE SETUP	45	13	747	13
2	MAINTENANCE	22	10	91	10
3	PART CHANGE	0	7	15	7
4	ORDER COMPLETE	0	9	225	9
5	SMASHUP	0	1	102	102
6	BREAKDOWN	2	65	8	1182
7	TOOL ADJUST	0	0	4	160
8	TOOL CHANGE	0	0	0	0
9	SAMPLES	0	0	1	5
10	FEED PROBLEMS	0	0	0	0
11	MATERIAL QUALITY	0	0	0	0
12	WAITING FOR MATERIAL	0	0	0	0
13	MEETING/TRAINING	0	0	0	0
14	WAITING FOR OPERATOR	0	0	0	0
15	WORKING ON OTHER MA	0	0	0	0
16	SCHEDULED SHUTDOWN	0	0	0	0

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5	SMASHUP	0	1	102	102
6	BREAKDOWN	2	65	8	1182
7	TOOL ADJUST	0	0	4	160
8	TOOL CHANGE	0	0	0	0
9	SAMPLES	0	0	1	5
10	FEED PROBLEMS	0	0	0	0
11	MATERIAL QUALITY	0	0	0	0
12	WAITING FOR MATERIAL	0	0	0	0
13	MEETING/TRAINING	0	0	0	0
14	WAITING FOR OPERATOR	0	0	0	0
15	WORKING ON OTHER MA	0	0	0	0
16	SCHEDULED SHUTDOWN	0	0	0	0

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Downtime Occurrences

Occurrence	Start Time	End Time	Resp Time	Down Time	Downtime Code	Downtime Reason
1	1536	1544	2	8	2	MAINTENANCE
2	1501	1530	0	29	1	MACHINE SETUP
3	1258	1305	5	7	2	MAINTENANCE
4	1102	1147	7	45	6	BREAKDOWN
5	0	0	0	0	0	
6	0	0	0	0	0	
7	0	0	0	0	0	
8	0	0	0	0	0	



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OEE View

Overall Equipment Effectiveness (OEE) Summary

Machine Name	A Today's Scheduled Time	B Today's Downtime	C Today's Available Time (A-B)	D Availability Percent (C/A)	E Today's Parts Made	F Ideal PFM	G Today's Available Time (E/F * G)	H Performance Percent (E/(F * G))	I Today's Parts Made	J Today's Scrap Parts	K Quality Percent ((I-J)/J)	OEE Percent (D * H * K)
Header 1	1440	22	1418	98.47%	41253	100	1418	29.09%	41253	0	100.00%	28.85%
Header 2	1440	45	1395	96.88%	40253	100	1395	28.86%	40253	0	100.00%	27.95%
Header 3	1440	206	1234	85.69%	32563	100	1234	26.39%	32563	0	100.00%	22.61%
Header 4	1440	2	1438	99.86%	42581	100	1438	29.61%	42581	0	100.00%	29.57%
Header 5	1440	60	1380	95.83%	40128	100	1380	29.06%	40128	0	100.00%	27.87%
Roller 1	1440	16	1424	98.89%	41856	100	1424	29.39%	41856	0	100.00%	29.07%
Roller 2	1440	381	1059	73.54%	38542	100	1059	36.39%	38542	0	100.00%	26.77%
Roller 3	1440	420	1020	70.83%	32684	100	1020	32.04%	32684	0	100.00%	22.70%
Roller 4	1440	43	1397	97.01%	39885	100	1397	28.62%	39885	0	100.00%	27.72%
Roller 5	1440	29	1411	97.99%	40854	100	1411	28.95%	40854	0	100.00%	28.37%

OEE REPORT

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IMPAX TSS Viewing System

System Setup

Machine Setup

Machine Scheduling

Link Status

Data Collection

SETUP SCREEN

Generate New Report

To generate a report, fill in the options below, and click on "Generate Report."

Report Data

1. Choose which data to report on:

Date Filter

2. Choose dates to be included in report:

Start Date: Stop Date:

Machine Filter

3. Choose machines to be included in report:

Current filter: all machines included.

Report Type

4. Choose report format: List Report: list all matching data sessions Summary Report: combine sessions to produce totals

Sorting

5. Choose order to sort listed records or to group summarized records:

Sort By: Sub-Sort By:

Data Fields to Include

6. Choose data fields to list or summarize:

Downtime Start Total Response Time Downtime Reason Chosen

Downtime End Total Downtime

List Report of Downtime Occurrence Logs

Report date from 6/10/2009 to 12/12/2009

Sorted by Date, Sub-Sorted by Machine

Showing All Machines

Machine	Date	Job Number	Part Number	Operator ID	DT Start	DT End	Resp. Time	Downtime	Downtime Reason
Machine 1	7/9/2009	113094	NIS404	JJM	13:01	13:03	9999	0002	SMASHUP
Machine 1	7/9/2009	113094	NIS404	JJM	13:10	13:21	0	0	TOOL ADJUST
Machine 1	7/9/2009	113094	NIS404	JJM	13:30	13:03	9999	6092	SMASHUP
Machine 1	7/9/2009	113094	NIS404	JJM	13:30	13:29	0	0	TOOL ADJUST
Machine 1	7/9/2009	113094	NIS404	JJM	13:30	13:29	0	0	SMASHUP
Machine 1	7/20/2009	J1	Part 123	JM	22:29	23:00	3	3	TOOL CHANGE
Machine 1	7/21/2009	J1	Part 123	JM	8:26	8:44	1	20	MACHINE SETUP
Machine 1	7/21/2009	J1	Part 123	JM	10:00	10:07	1	0	TOOL ADJUST
Machine 1	7/21/2009	J1	Part 123	JM	10:08	10:09	0	0	TOOL ADJUST
Machine 1	7/21/2009	J1	Part 123	JM	10:09	10:10	1	1	TOOL ADJUST
Machine 1	7/21/2009	J1	Part 123	JM	10:10	10:11	0	0	TOOL ADJUST
Machine 1	7/21/2009	J1	Part 123	JM	10:12	10:12	0	0	SMASHUP
Machine 1	7/21/2009	J1	Part 123	JM	12:09	12:09	1	11	SMASHUP
Machine 1	7/21/2009	J1	Part 123	JM	12:09	14:31	0	150	MACHINE SETUP
Machine 1	7/22/2009	J1	Part 123	JM	13:13	13:18	1	3	TOOL CHANGE
Machine 1	7/22/2009	HARLEY	HOG 1	RUSS	13:56	14:01	1	15	SAVES
Machine 1	8/13/2009	HARLEY	HOG 1	RUSS	13:51	13:52	1	1	TOOL ADJUST
Header 1	8/19/2009	JD1855	260	111	17:50	18:00	0	7	MAINTENANCE
Header 1	8/20/2009	JD1855	260	10ST	8:40	8:54	3	29	MAINTENANCE
Header 1	8/20/2009	JD1855	260	10ST	9:40	10:10	0	28	SET UP
Header 1	8/20/2009	JD1855	260	10ST	10:13	10:17	0	0	SMASHUP
Header 1	8/20/2009	CAND	JLN	BBB	11:10	11:11	0	0	No reason entered
Header 1	8/20/2009	CAND	JLN	BBB	11:26	11:28	4	5	GEAR BOX PROBLEM
Header 1	8/20/2009	CAND	JLN	BBB	11:30	11:31	0	0	TOOL ADJUST
Header 1	8/20/2009	CAND	JLN	BBB	12:22	12:25	0	0	PART QUALITY CHECK
Header 1	8/20/2009	CAND	JLN	BBB	14:30	14:39	0	6	MECHANICAL REPAIR
Header 1	8/20/2009	CAND	JLN	BBB	14:44	14:45	0	0	MATERIAL QUALITY
Header 1	8/20/2009	JD1855	260	10ST	8:23	8:52	3	29	MAINTENANCE
Header 1	8/20/2009	JD1855	260	10ST	9:40	10:10	0	28	SET UP
Header 1	8/20/2009	JD1855	260	10ST	10:13	10:17	0	0	SMASHUP
Header 1	8/20/2009	CAND	JLN	BBB	11:10	11:11	0	0	No reason entered
Header 1	8/20/2009	CAND	JLN	BBB	11:26	11:28	4	5	GEAR BOX PROBLEM

Data Report: 8/23/2009 IMPAX TSS Viewing System Page 1 of 3

REPORT GENERATION