

Machine Status & Production

TSS Viewing System

Intro
Summary
OEE View

Detail View
Reporting
Setup

Shop Floor Summary

Print this Page

	Machine Name	Machine Status	Current Status		Daily Status			View OEE Details	View Machine Details
			Current PPM	Ideal PPM	Today's Performance	Today's OEE			
9	Header 1	Up: 22:49	95	100	89.1%	89.1%	View Details		
11	Header 2	Up: 3:19	97	100	75.5%	71.7%	View Details		
13	Header 3	Down: 3:45	0	100	62.1%	42.8%	View Details		
15	Header 4	Up: 6:40	102	100	79.4%	59.6%	View Details		
17	Header 5	Up: 1d 2:53	82	100	96.7%	96.7%	View Details		
19	Roller 1	Up: 7:24	54	100	82.5%	72.6%	View Details		
21	Roller 2	Down: 0:15	0	100	87.4%	85.7%	View Details		
23	Roller 3	Down: 12:55	0	100	22.6%	9.0%	View Details		
25	Roller 4	Up: 9:27	87	100	68.3%	51.2%	View Details		
27	Roller 5	Up: 21:40	90	100	71.5%	57.2%	View Details		

Intro
Summary View
OEE View
Detail View
Reporting
Downtime Report
Times Report
Setup

Tool Usage Counts & Maintenance Task Counts

IMPAX TSS Viewing System

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Detail View for machine: Header 1 **Print this Page**

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

	DRILL	CHISEL	PUNCH	TOOL 4	TOOL 5	TOOL 6	TOOL 7	TOOL 8	TOOL 9
Expected Life:	700000	22000000	5500000	0	0	0	0	0	0
Life Used:	559558	1013488	1013455	0	0	0	0	0	0
Life Remaining:	140442	20986512	4486545	0	0	0	0	0	0

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

	OIL	LUBE	FILTER	CONVEYC	MAINT. 5	MAINT. 6	MAINT. 7	MAINT. 8	MAINT. 9
Expected Life:	7777777	6000000	1000000	0	0	0	0	0	0
Life Used:	1186285	1186271	1186257	0	0	0	0	0	0
Life Remaining:	6591492	4813729	1313743	0	0	0	0	0	0

Downtime Reasons
Show Codes: 1 - 16 (Times are hh:mm)

Code	Description	Daily Codes		Weekly Codes		Monthly Codes		Yearly Codes	
		Occur.	Time	Occur.	Time	Occur.	Time	Occur.	Times
1	MACHINE SETUP	1	0:45	5	6:53	13	12:14	20	20:20
2	MAINTENANCE	2	0:22	10	3:05	18	5:42	26	8:35

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Uptime and Downtime Minutes and Percentage

Microsoft Excel - IMPAX TSS Viewer.xls

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Type a question for help

IMPAX TSS Viewing System

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Up/Down Times

(Times are hh:mm)

	Daily Minutes			Weekly Minutes			Monthly Minutes			Yearly Minutes		
	Up	Down	Resp.	Up	Down	Resp.	Up	Down	Resp.	Up	Down	Resp.
Shift 1:	7:02	0:21	0:06	7:02	0:21	0:06	1d 18:32	0:52	0:23	11 days	8:32	3:21
Shift 2:	0:00	0:00	0:00	0:00	0:00	0:00	1d 15:35	0:48	0:15	11 days	14:02	6:35
Shift 3:	0:00	0:00	0:00	0:00	0:00	0:00	1d 20:51	1:04	0:31	9d 21:33	5:51	3:06
Total:	7:02	0:21	0:06	7:02	0:21	0:06	5d 6:58	2:44	1:09	32 days	1d 4:25	13:02

Production Counts

	Order Counters:	Order Quantity:	Minutes Left:	Parts Made:	Parts To Go:	Percent Made:	Percent To Go:	Daily		Weekly	Monthly	Yearly
								Count	Scrap	Count	Count	Count
Shift 1:		10000	77	2465	7535	24	76	41000	0	41000	246851	1485245
Shift 2:								0	0	0	248742	1478523
Shift 3:								0	0	0	232315	1418740
Total:								41000	0	41000	727908	4382508

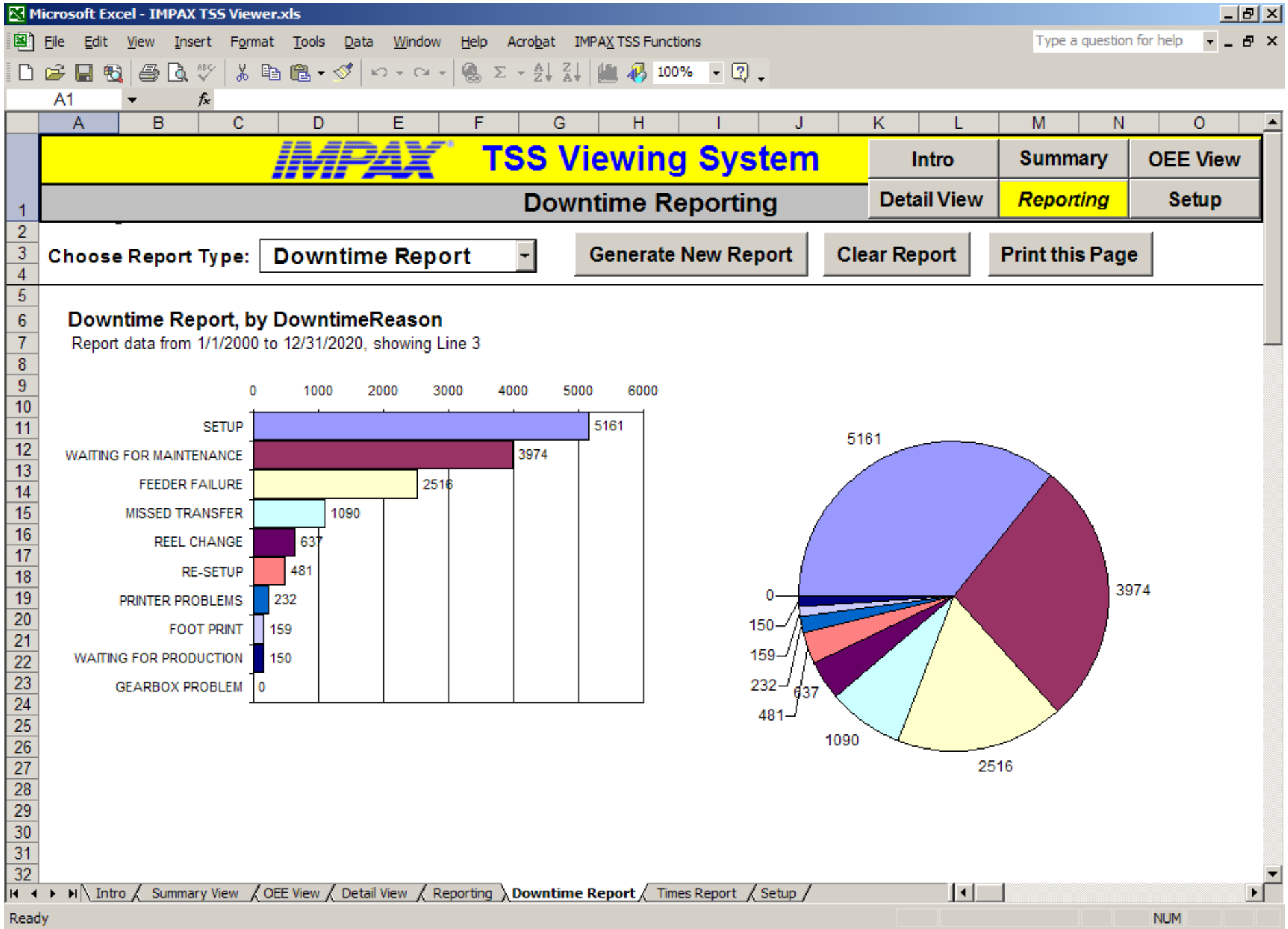
Tool Counters

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

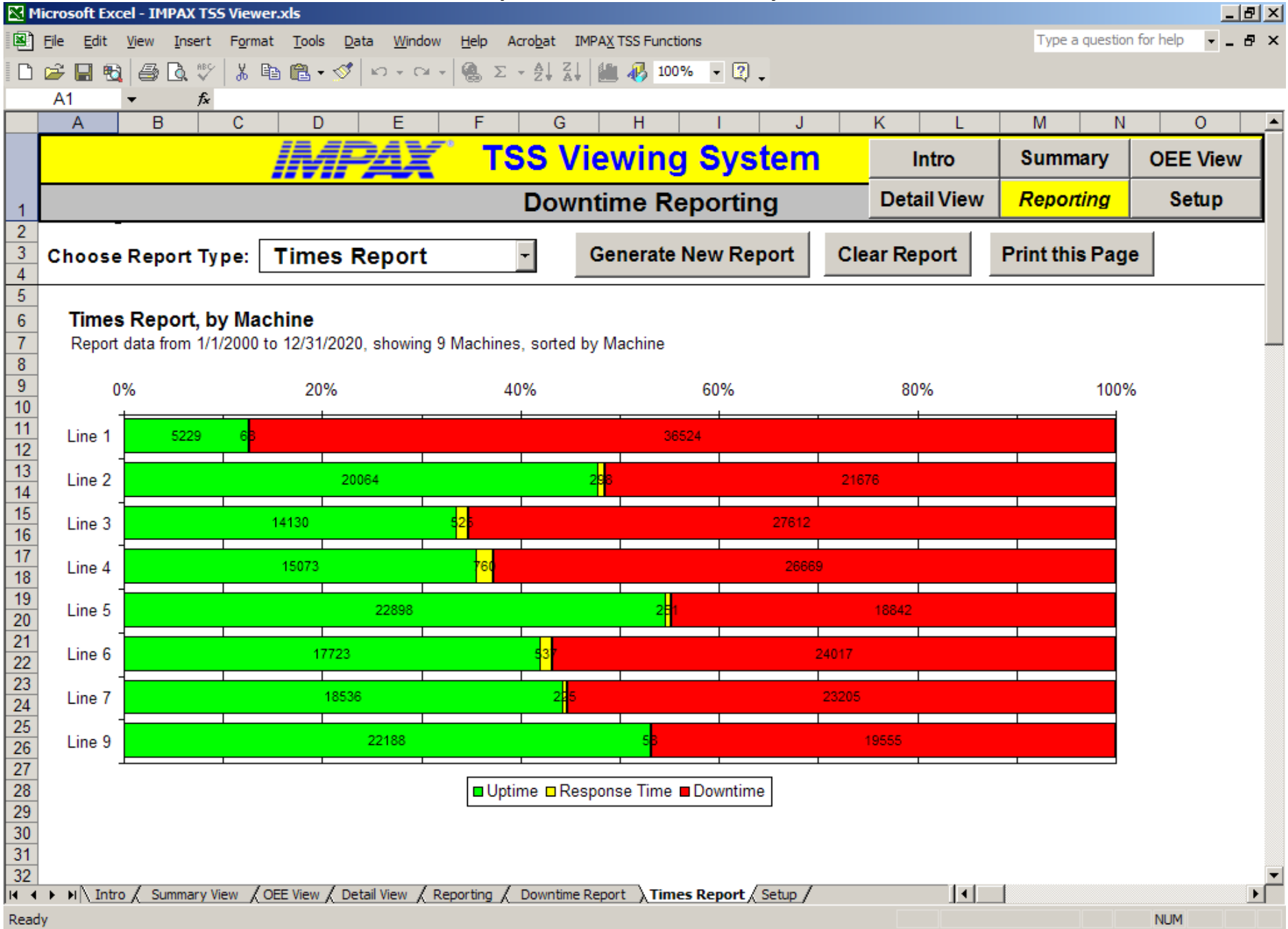
	DRILL	CHISEL	PUNCH	TOOL 4	TOOL 5	TOOL 6	TOOL 7	TOOL 8	TOOL 9
Expected Life:	700000	22000000	5500000	0	0	0	0	0	0

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NUM

Downtime Reason Breakdown



Uptime vs. Downtime Analysis



Downtime Occurrences & Response Times

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Type a question for help

A1

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Detail View for machine:

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Downtime Reasons Show Codes: (Times are hh:mm)

Code	Description	Daily Codes		Weekly Codes		Monthly Codes		Yearly Codes	
		Occur.	Time	Occur.	Time	Occur.	Time	Occur.	Times
1	MACHINE SETUP	1	0:45	5	6:53	13	12:14	20	20:20
2	MAINTENANCE	2	0:22	10	3:05	18	5:42	26	8:35
3	PART CHANGE	0	0:00	0	0:00	0	0:00	0	0:00
4	ORDER COMPLETE	0	0:00	0	0:00	0	0:00	0	0:00
5	SMASHUP	0	0:00	0	0:00	1	7:53	1	7:53
6	BREAKDOWN	2	1:30	8	3:17	8	3:17	12	5:32
7	TOOL ADJUST	0	0:00	4	0:41	9	1:31	9	1:31
8	TOOL CHANGE	0	0:00	0	0:00	2	0:13	2	0:13
9	SAMPLES	0	0:00	0	0:00	4	0:43	4	0:43
10	FEED PROBLEMS	0	0:00	0	0:00	1	0:15	1	0:15
11	MATERIAL QUALITY	0	0:00	0	0:00	5	1:45	5	1:45
12	WAITING FOR MATERIAL	0	0:00	0	0:00	2	0:11	2	0:11
13	MEETING/TRAINING	0	0:00	0	0:00	0	0:00	0	0:00
14	WAITING FOR OPERATOR	0	0:00	0	0:00	1	0:25	1	0:25
15	WORKING ON OTHER MA	0	0:00	0	0:00	0	0:00	0	0:00
16	SCHEDULED SHUTDOWN	0	0:00	0	0:00	0	0:00	0	0:00

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Downtime Occurrences Show Occurrences:

Start	Start	End	Resp.	Down	Downtime	Downtime
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Ready NUM

Overall Equipment Effectiveness (OEE)

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Overall Equipment Effectiveness (OEE) Summary [Print this Page](#)

	A	B	C	D	E	F	G	H	I	J	Today's OEE Percent (D * G * J)
Machine Name	Today's Elapsed Time	Today's Downtime	Today's Uptime	Availability Percent (C / A)	Today's Parts Made	Expected Parts (based on PPM)	Performance Percent (E / F)	Today's Parts Made	Today's Scrap Parts	Quality Percent ((H - I) / H)	
Header 1	12:32	0:00	12:32	100.0%	67003	75200	89.1%	67003.2	0	100.0%	89.1%
Header 2	12:32	0:37	11:54	95.0%	56776	75200	75.5%	56776	0	100.0%	71.7%
Header 3	12:32	3:53	8:38	69.0%	46699	75200	62.1%	46699.2	0	100.0%	42.8%
Header 4	12:32	3:08	9:24	75.0%	59709	75200	79.4%	59708.8	0	100.0%	59.6%
Header 5	12:32	0:00	12:32	100.0%	72718	75200	96.7%	72718.4	0	100.0%	96.7%
Roller 1	12:32	1:30	11:01	88.0%	62040	75200	82.5%	62040	0	100.0%	72.6%
Roller 2	12:32	0:15	12:16	98.0%	65725	75200	87.4%	65724.8	0	100.0%	85.7%
Roller 3	12:32	7:31	5:00	40.0%	16995	75200	22.6%	16995.2	0	100.0%	9.0%
Roller 4	12:32	3:08	9:24	75.0%	51362	75200	68.3%	51361.6	0	100.0%	51.2%
Roller 5	12:32	2:30	10:01	80.0%	53768	75200	71.5%	53768	0	100.0%	57.2%

Intro Summary View **OEE View** Detail View Reporting Downtime Report Times Report Setup

Ready NUM