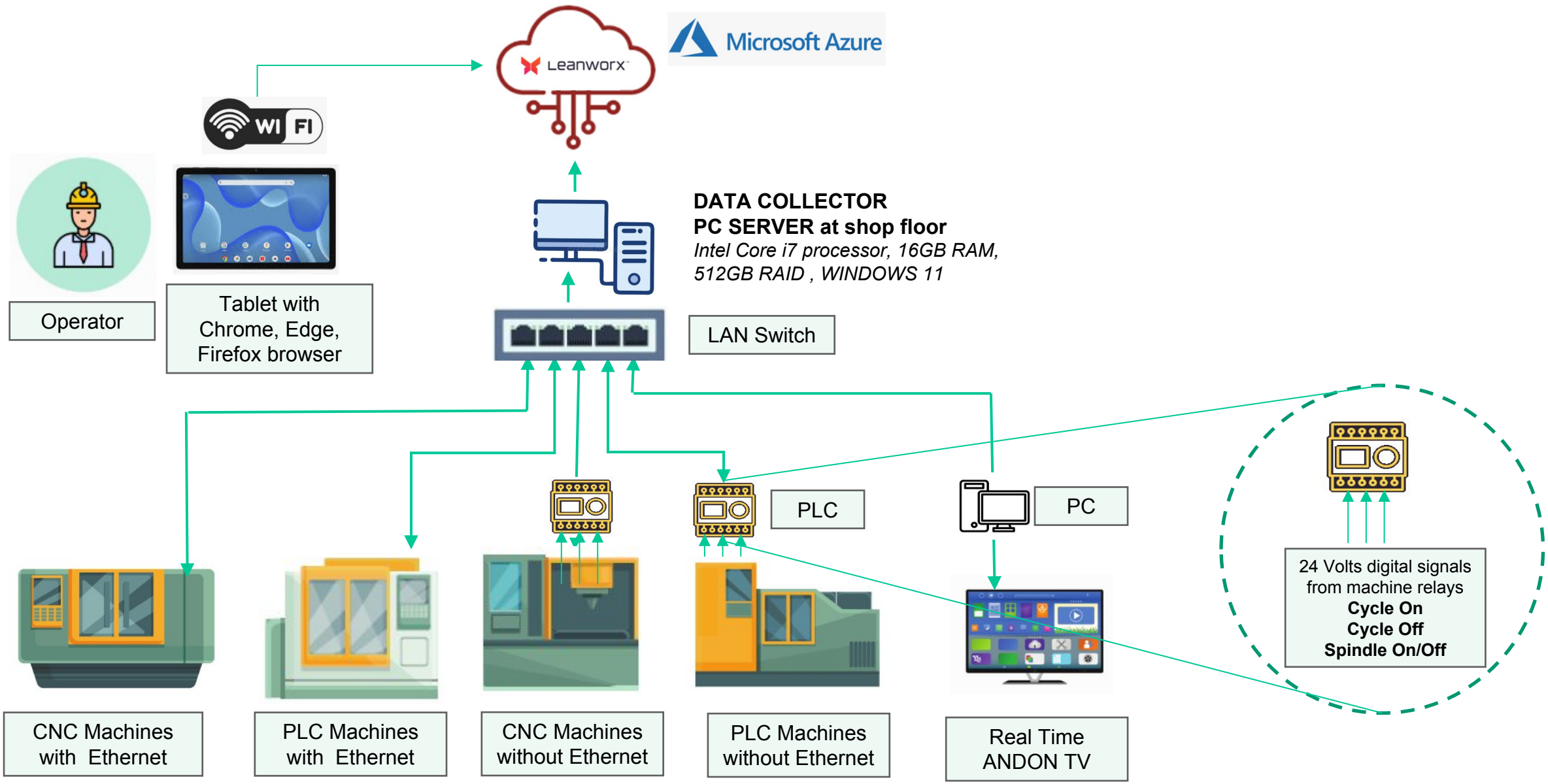
Leanworx™

Works like magic

DISCOVER HIDDEN PROFITS


Leanworx
Microsoft Azure
WI FI
Operator
Tablet with Chrome, Edge, Firefox browser
DATA COLLECTOR
PC SERVER at shop floor
Intel Core i7 processor, 16GB RAM, 512GB RAID , WINDOWS 11
LAN Switch
PLC
PC
24 Volts digital signals from machine relays
Cycle On
Cycle Off
Spindle On/Off
CNC Machines with Ethernet
PLC Machines with Ethernet
CNC Machines without Ethernet
PLC Machines without Ethernet
Real Time ANDON TV

Machine Utilization Reports

Hourly production report

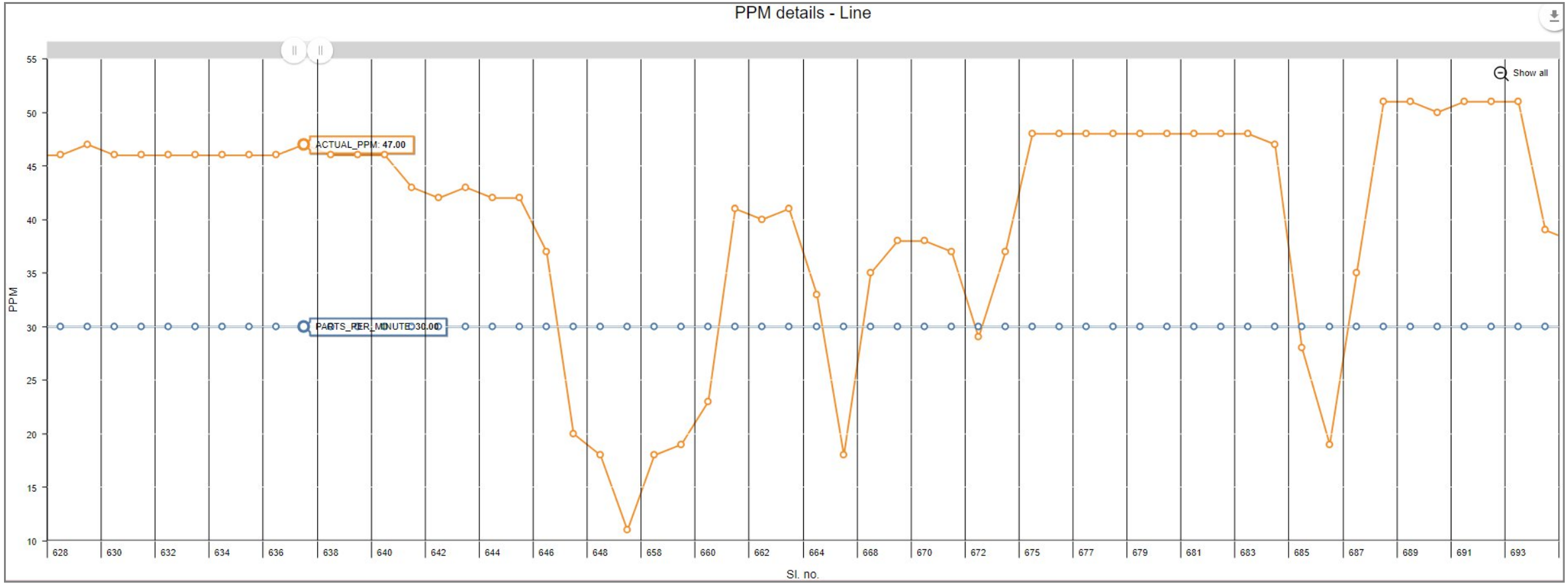
Machine name	Time slice	Part name	Op. no.	Hourly Target	Hour 1	Hour 2	Hour 3	Hour 4	Hour 5	Hour 6	Hour 7	Hour 8	Planned qty	Actual qty.	Utilization %
Machine name=MAZAK T:07															
MAZAK T:07	Shift 1	K0NA GPDN	110	22	21	21	6	21	21	4	10	12	163	116	71
MAZAK T:07	Shift 2	K0NA GPDN	110	22	10	16	15	19	20	10	4	0	163	94	58
MAZAK T:07	Shift 3	K0NA GPDN	110	22	0	0	0	0	0	0	0	12	163	12	7
													489	**222**	**45**
Machine name=MAZAK T:08															
MAZAK T:08	Shift 1	K0NA GPDN	120	29	22	20	6	22	20	4	10	13	213	117	55
MAZAK T:08	Shift 2	K0NA GPDN	120	29	10	16	15	18	20	9	6	0	213	94	44
MAZAK T:08	Shift 3	K0NA GPDN	120	29	0	0	0	0	0	0	0	12	213	12	6
													639	**223**	**35**
Machine name=MAZAK T:15															
MAZAK T:15	Shift 1	K0NA GPDN	120	29	0	0	0	0	0	0	0	6	213	6	3
MAZAK T:15	Shift 2	K0NA GPDN	120	29	22	24	18	24	26	12	5	0	213	131	62
MAZAK T:15	Shift 3	K0NA GPDN	120	29	0	0	0	0	0	0	0	4	213	4	2
													639	**141**	**22**
Machine name=MAZAK T:16															
MAZAK T:16	Shift 1	K0NA GPDN	110	22	0	0	0	0	0	0	0	8	163	8	5
MAZAK T:16	Shift 2	K0NA GPDN	110	22	22	24	18	24	25	13	2	0	163	128	79
MAZAK T:16	Shift 3	K0NA GPDN	110	22	0	0	0	0	0	0	0	4	163	4	2
													489	**140**	**29**

Cycle details report

Compare
Std cycle Vs Actual

Sl. no.	Machine	Part no.	Cycle started at	Cycle ended at	Cycle time	Std. cycle time	Standard load/unload	Downtime between cycles	Spindle ON time	Cycle time more	Cycle time less	Cycle time less%
1	CNC-6 TF2	63_alu_flange	21-11-2023 08:59:44 AM	21-11-2023 09:01:06 AM	00:01:22	00:01:50	00:00:10	00:01:26	00:01:22	0	1	25.00
2	CNC-6 TF2	63_alu_flange	21-11-2023 09:02:32 AM	21-11-2023 09:03:56 AM	00:01:24	00:01:50	00:00:10	00:00:38	00:01:24	0	1	24.00
3	CNC-6 TF2	63_alu_flange	21-11-2023 09:04:34 AM	21-11-2023 09:05:49 AM	00:01:15	00:01:50	00:00:10	00:00:17	00:01:15	0	1	32.00
4	CNC-6 TF2	63_alu_flange	21-11-2023 09:06:06 AM	21-11-2023 09:07:21 AM	00:01:15	00:01:50	00:00:10	00:00:41	00:01:15	0	1	32.00
5	CNC-6 TF2	63_alu_flange	21-11-2023 09:08:02 AM	21-11-2023 09:09:17 AM	00:01:15	00:01:50	00:00:10	00:00:29	00:01:15	0	1	32.00
6	CNC-6 TF2	63_alu_flange	21-11-2023 09:09:46 AM	21-11-2023 09:10:56 AM	00:01:10	00:01:50	00:00:10	00:00:12	00:01:10	0	1	36.00
7	CNC-6 TF2	63_alu_flange	21-11-2023 09:11:08 AM	21-11-2023 09:12:16 AM	00:01:08	00:01:50	00:00:10	00:00:17	00:01:08	0	1	38.00
8	CNC-6 TF2	63_alu_flange	21-11-2023 09:12:33 AM	21-11-2023 09:13:41 AM	00:01:08	00:01:50	00:00:10	00:00:38	00:01:08	0	1	38.00
9	CNC-6 TF2	63_alu_flange	21-11-2023 09:14:19 AM	21-11-2023 09:15:27 AM	00:01:08	00:01:50	00:00:10	00:00:16	00:01:08	0	1	38.00
10	CNC-6 TF2	63_alu_flange	21-11-2023 09:15:43 AM	21-11-2023 09:16:51 AM	00:01:08	00:01:50	00:00:10	00:00:25	00:01:08	0	1	38.00
11	CNC-6 TF2	63_alu_flange	21-11-2023 09:17:16 AM	21-11-2023 09:18:25 AM	00:01:09	00:01:50	00:00:10	00:02:21	00:01:09	0	1	37.00
12	CNC-6 TF2	63_alu_flange	21-11-2023 09:20:46 AM	21-11-2023 09:21:54 AM	00:01:08	00:01:50	00:00:10	00:00:48	00:01:08	0	1	38.00
13	CNC-6 TF2	63_alu_flange	21-11-2023 09:22:42 AM	21-11-2023 09:23:50 AM	00:01:08	00:01:50	00:00:10	00:00:09	00:01:08	0	1	38.00
14	CNC-6 TF2	63_alu_flange	21-11-2023 09:23:59 AM	21-11-2023 09:25:07 AM	00:01:08	00:01:50	00:00:10	00:00:25	00:01:08	0	1	38.00
15	CNC-6 TF2	63_alu_flange	21-11-2023 09:25:32 AM	21-11-2023 09:26:41 AM	00:01:09	00:01:50	00:00:10	00:00:10	00:01:09	0	1	37.00

PPM trend - (Parts per minute)

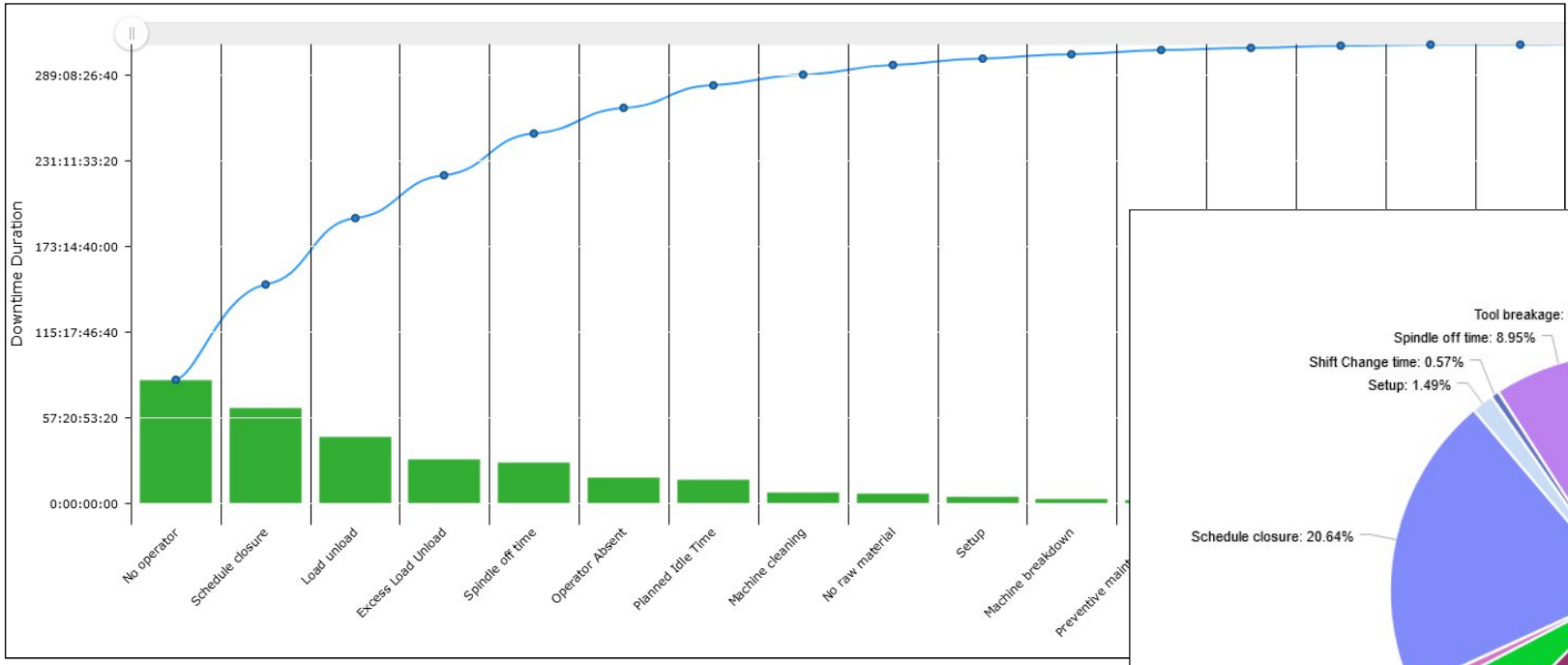


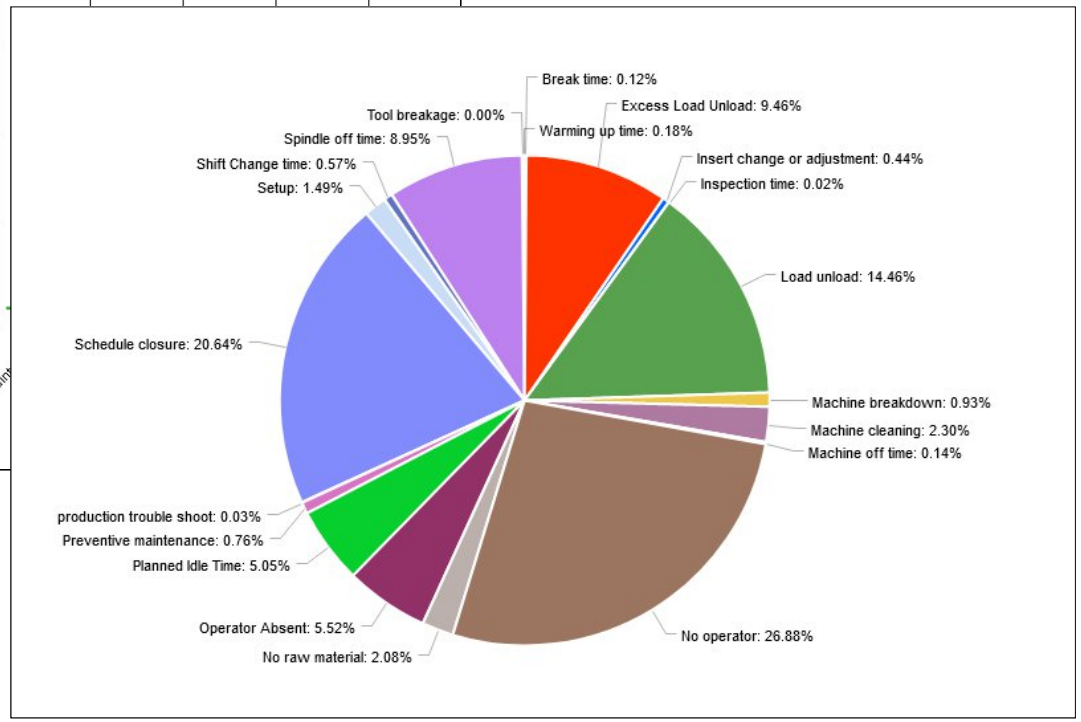
Leanworx

Downtime loss with reasons

Machine name	Start date	End date	Downtime type	Downtime reason name	Downtime Duration
Machine name=TC 120					
TC 120	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	No raw material	01:07:45
TC 120	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Insert change or adjustment	00:30:49
TC 120	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Inspection time	00:56:08
TC 120	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Downtime	Load unload	03:28:15
TC 120	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Machine breakdown	00:20:37
					06:23:34
Machine name=TC 130					
TC 130	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	No raw material	01:06:32
TC 130	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Insert change or adjustment	00:31:10
TC 130	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Inspection time	00:57:10
TC 130	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Downtime	Load unload	03:28:29
TC 130	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Machine breakdown	00:23:02
					06:26:23
Machine name=VMC 20					
VMC 20	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Unscheduled management loss	Inspection time	08:31:00
VMC 20	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Downtime	Load unload	01:14:45
VMC 20	05-08-2020 06:00:00 AM	06-08-2020 06:00:00 AM	Downtime	Spindle off time	04:24:00
					14:09:45

Downtime analysis Pareto and Pie

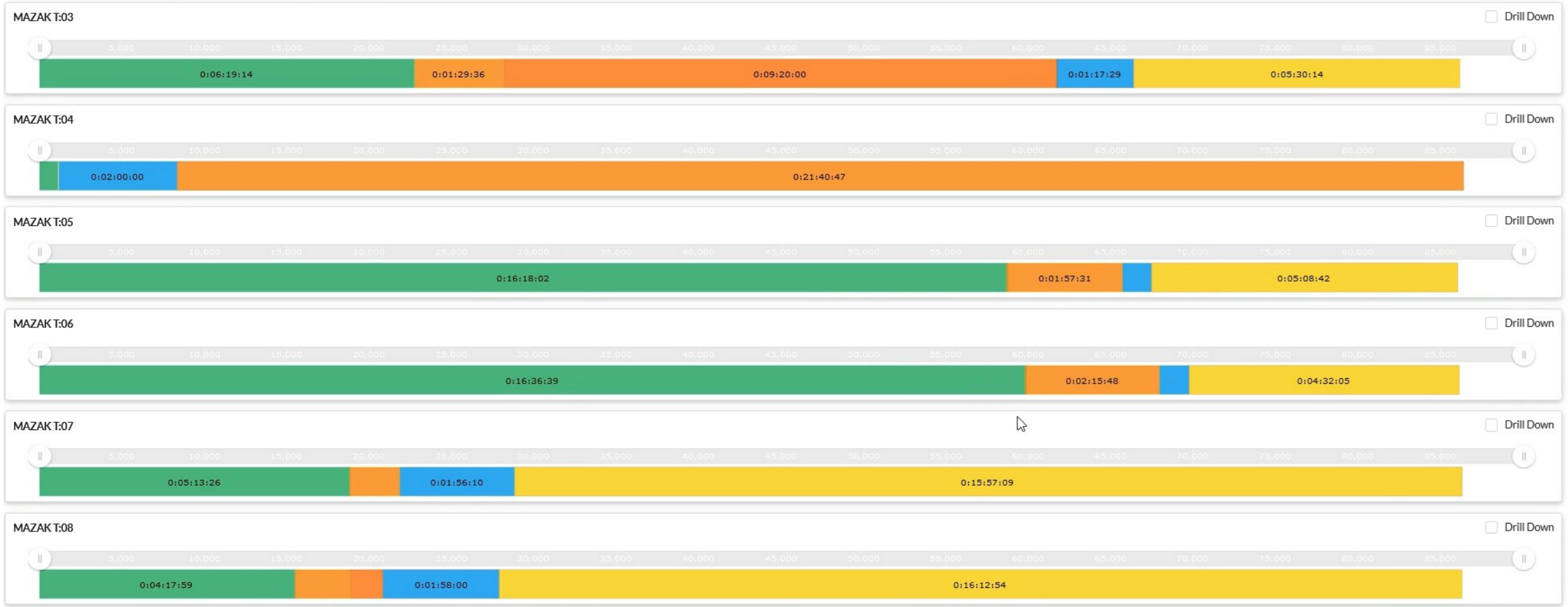


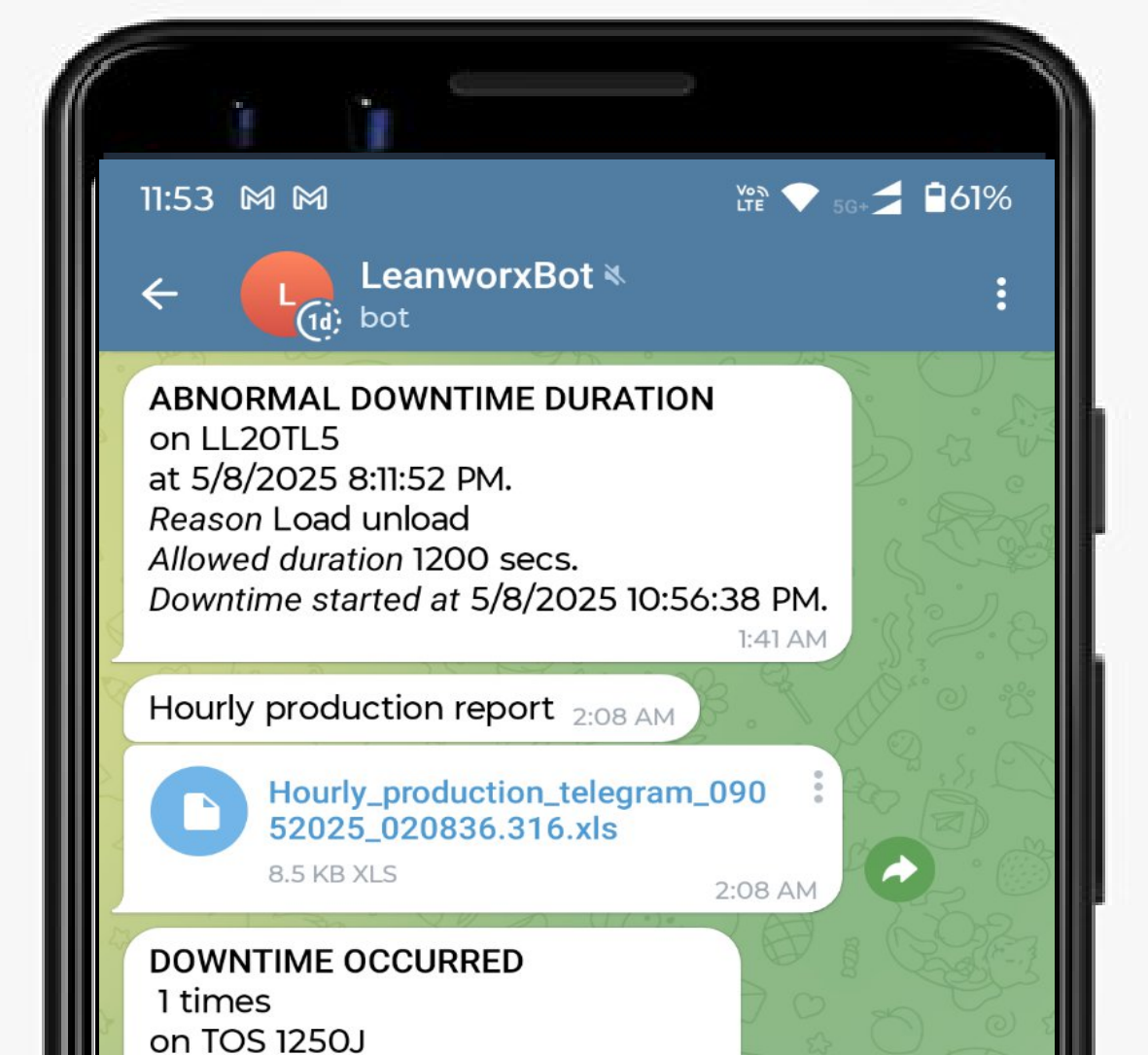


Downtime at shift change

Machine name	Shift	Cell name	Operator name	Shift start	Shift end	Downtime at start	Downtime at end
Machine name=HMC 14							
HMC 14	Shift 1	HMC	Rahul	28-07-2020 06:00:00 AM	28-07-2020 02:00:00 PM	04:57:40	00:00:00
HMC 14	Shift 3	HMC	Rahul	28-07-2020 10:00:00 PM	29-07-2020 06:00:00 AM	00:00:09	00:05:41
HMC 14	Shift 1	HMC	Rahul	30-07-2020 06:00:00 AM	30-07-2020 02:00:00 PM	00:00:26	00:00:00
HMC 14	Shift 3	HMC	Rahul	30-07-2020 10:00:00 PM	31-07-2020 06:00:00 AM	00:00:48	00:00:00
HMC 14	Shift 2	HMC	Rahul	31-07-2020 02:00:00 PM	31-07-2020 10:00:00 PM	00:00:51	00:00:00
HMC 14	Shift 1	HMC	Rahul	02-08-2020 06:00:00 AM	02-08-2020 02:00:00 PM	00:00:30	00:00:00
HMC 14	Shift 3	HMC	Rahul	02-08-2020 10:00:00 PM	03-08-2020 06:00:00 AM	00:00:52	00:00:00
						05:01:16	**00:05:41**
Machine name=TC 120							
TC 120	Shift 3	CNC	Rahul	28-07-2020 10:00:00 PM	29-07-2020 06:00:00 AM	00:00:08	00:04:04
TC 120	Shift 1	CNC	Rahul	29-07-2020 06:00:00 AM	29-07-2020 02:00:00 PM	00:02:06	00:00:00
TC 120	Shift 1	CNC	Rahul	31-07-2020 06:00:00 AM	31-07-2020 02:00:00 PM	00:00:00	00:11:41
TC 120	Shift 2	CNC	Rahul	31-07-2020 02:00:00 PM	31-07-2020 10:00:00 PM	00:38:20	00:00:00
						00:40:34	**00:15:45**
Machine name=TC 130							
TC 130	Shift 1	HMC	Rahul	28-07-2020 06:00:00 AM	28-07-2020 02:00:00 PM	04:48:53	00:00:00
TC 130	Shift 1	HMC	Rahul	30-07-2020 06:00:00 AM	30-07-2020 02:00:00 PM	00:00:00	00:00:34
TC 130	Shift 2	HMC	Rahul	30-07-2020 02:00:00 PM	30-07-2020 10:00:00 PM	00:01:52	00:00:00
TC 130	Shift 1	HMC	Rahul	31-07-2020 06:00:00 AM	31-07-2020 02:00:00 PM	00:00:00	00:17:34
TC 130	Shift 2	HMC	Rahul	31-07-2020 02:00:00 PM	31-07-2020 10:00:00 PM	00:35:31	00:00:00
TC 130	Shift 2	HMC	Rahul	02-08-2020 02:00:00 PM	02-08-2020 10:00:00 PM	00:05:47	00:00:12

Live run status





Get emergency alerts on mobile app

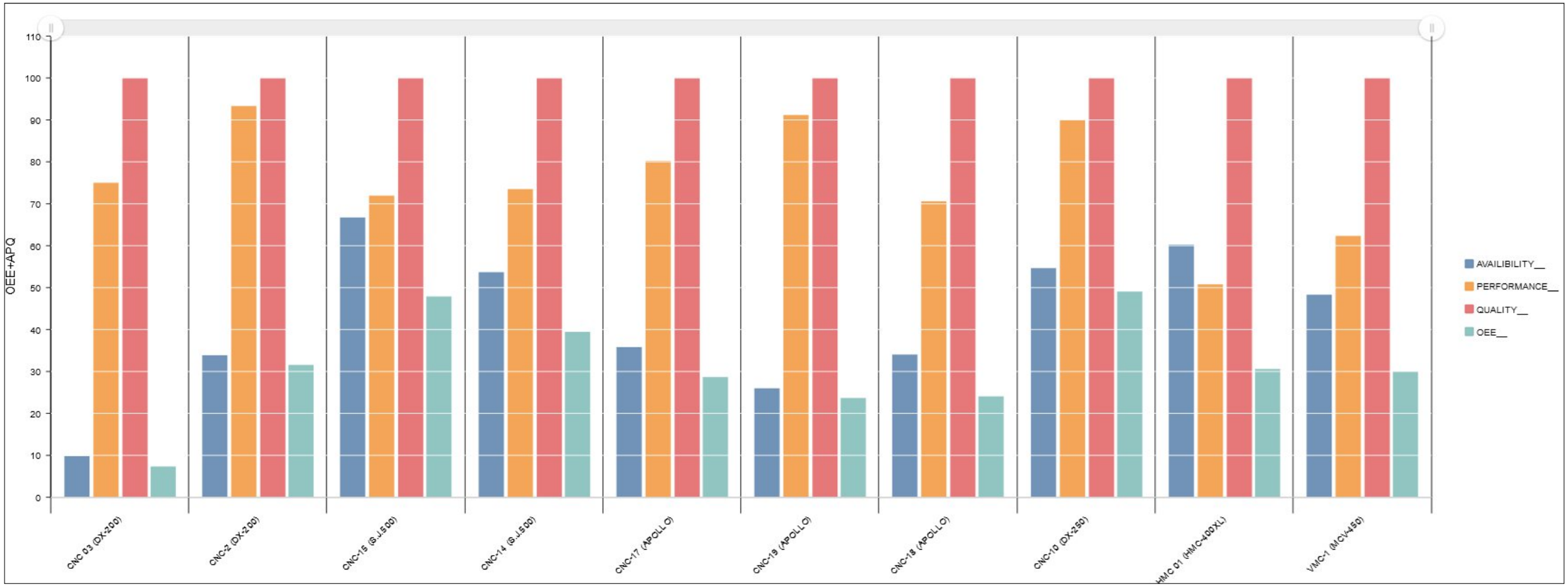
- Machine breakdown HELP request
- Machine idle time exceeds limit
- Cycle times exceeds set limits
- Rejections exceeds acceptable limits

Machine Productivity Reports

OEE-A,P,Q report

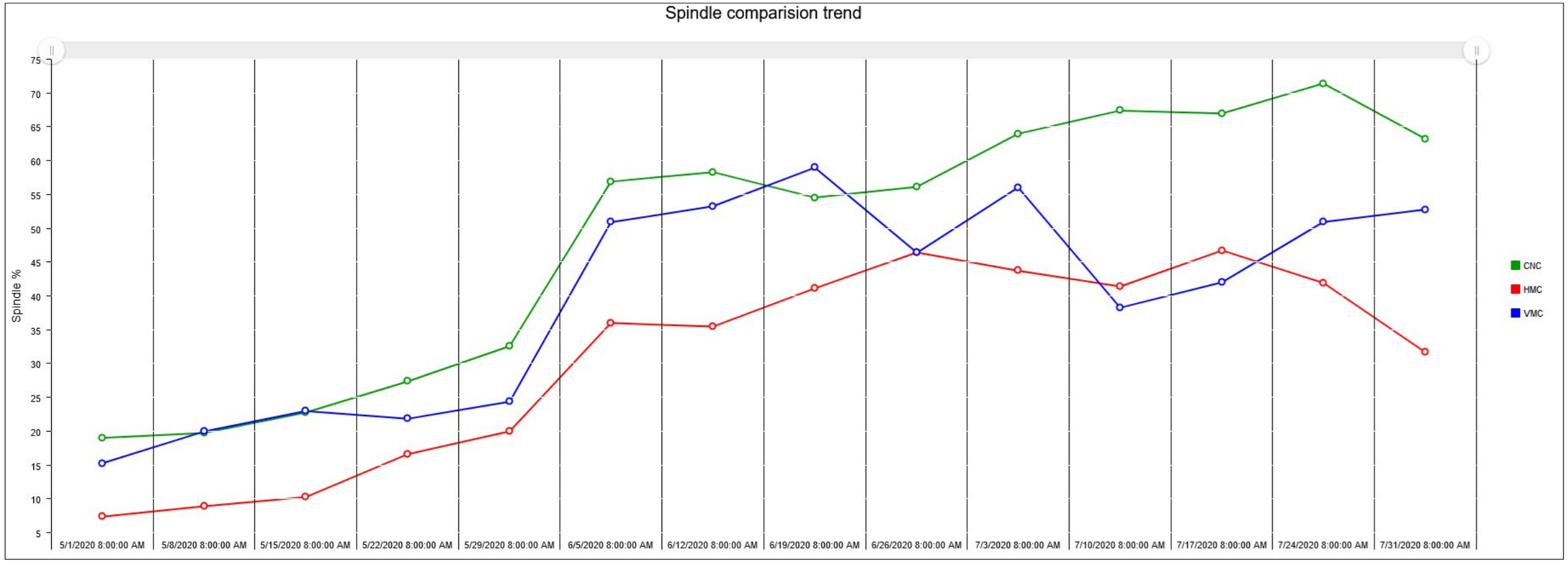
Machine name	Cell name	Start date	Total hr.	Available hr.	Downtime	Operating hr.	Cycle time theoretical	Produced qty.	Rejected qty.	Availibility %	Performance %	Quality %	OEE %
HMC 01 (HMC-400XL)	HMC 2 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	238:10:25	359:49:35	182:54:00	708	0	60.17	50.83	100.00	30.59
CNC 03 (DX-200)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	539:43:42	58:16:18	43:45:12	1536	0	09.74	75.09	100.00	07.32
CNC-2 (DX-200)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	395:40:23	202:19:37	188:41:49	3250	0	33.83	93.26	100.00	31.55
CNC-15 (S.J.500)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	199:12:27	398:47:33	286:51:40	2807	0	66.69	71.93	100.00	47.97
VMC-1 (MCV-450)	VMC 1 Machine	01-04-2021 08:30:00 AM	720:00:00	598:00:00	309:53:03	288:06:57	179:32:16	1307	0	48.18	62.31	100.00	30.02
CNC-14 (S.J.500)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	276:49:22	321:10:38	236:07:29	3821	3	53.71	73.52	99.92	39.45
CNC-17 (APOLLO)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	384:14:27	213:45:33	171:21:43	12061	0	35.75	80.17	100.00	28.66
CNC-19 (APOLLO)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	442:25:20	155:34:40	141:50:27	10960	0	26.02	91.17	100.00	23.72
CNC-18 (APOLLO)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	394:02:49	203:57:11	143:52:16	15129	1	34.11	70.54	99.99	24.06
CNC-10 (DX-250)	CNC 10 Machines	01-04-2021 08:30:00 AM	720:00:00	598:00:00	271:30:25	326:29:35	293:41:13	807	0	54.60	89.95	100.00	49.11
			7200:00:00	**5980:00:00**	**3451:42:23**	**2528:17:37**	**1868:38:05**	**52386**	**4**	**42.28**	**73.91**	**99.99**	**31.25**

OEE-A,P,Q machine comparison



Leanworx™

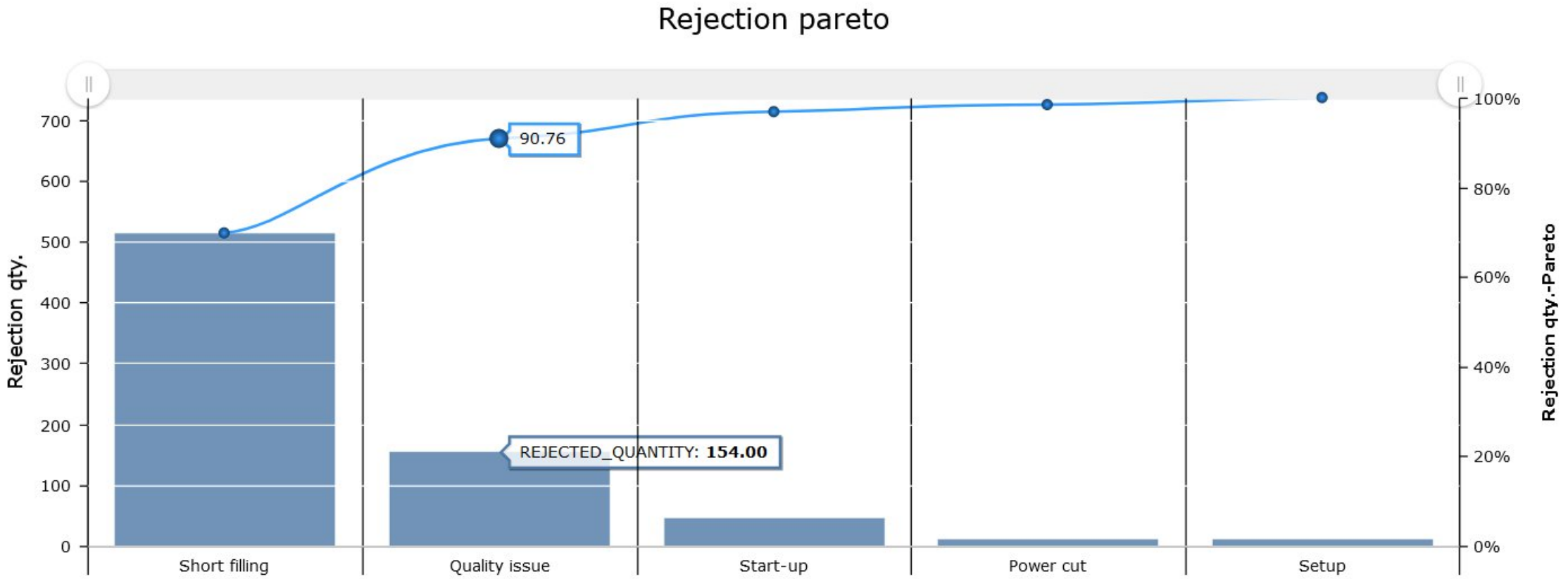
Spindle utilization trend



Revenue loss report

Machine name	Cell name	Start date	End date	Scheduled management loss	Rejected qty	Downtime	Machine hour rate	Downtime revenue loss, Rs.	Rejection revenue loss, Rs.
Cell name=CNC									
CNC 01 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	16	227:57:50	300	68389	247
CNC 02 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	3	185:56:16	300	55781	35
CNC 03 (Supper Jobber)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	3	234:59:28	300	70497	42
CNC 04 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	1	246:44:36	300	74023	16
CNC 05 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	6	222:06:13	300	66631	104
CNC 06 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	5	301:21:28	300	90407	113
CNC 10 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	289:02:59	300	86715	0
CNC 11 (DX 200)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	279:11:29	300	83757	0
CNC 12 (Jobber XL)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	305:23:28	300	91617	0
CNC 13 (Jobber XL)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	4	247:14:38	300	74173	45
CNC 14 (Supper Jobber 500)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	2	293:57:32	300	88188	33
CNC 19 (S.J.500)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	13	194:54:33	300	58473	170
CNC 20 (S.J.500)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	152	170:00:49	300	51004	2635
CNC 21 (Supper Jobber 500)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	230:09:30	300	69048	0
CNC 22 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	3	169:46:45	300	50934	36
CNC 23 (Classic)	CNC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	1	193:20:01	300	58000	13
						3792:07:35		**1137638**	**3487**
Cell name=VMC									
VMC 01 (WINNER)	VMC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	249:51:03	325	81202	0
VMC 02 (WINNER)	VMC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	242:53:16	325	78939	0
VMC 03 (WINNER)	VMC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	207:55:20	325	67575	0
VMC 04 (WINNER)	VMC	01-07-2020 06:00:00 AM	01-08-2020 06:00:00 AM	123:00:00	0	270:27:15	325	87898	0
						971:06:54		**315612**	**0**
						4763:14:29		**1453250**	**3487**

Rejection reasons Pareto



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Leanworx

Operator Productivity Reports

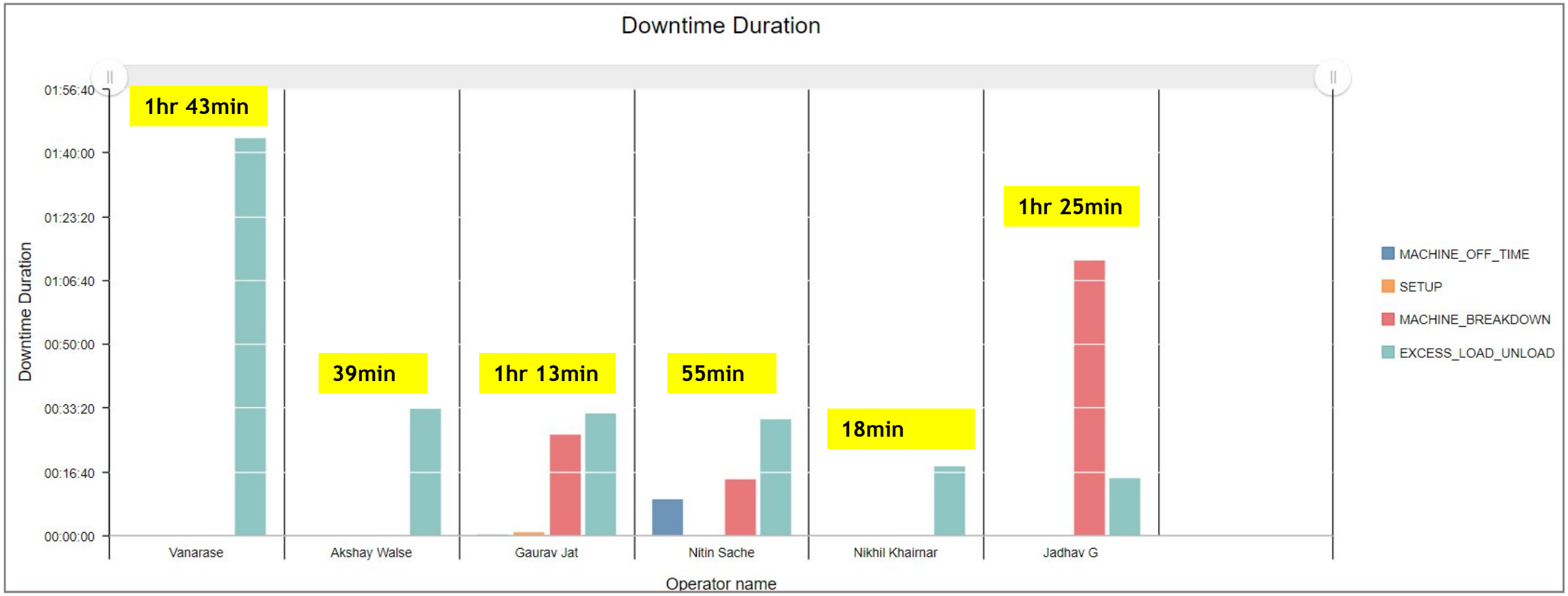
Operator production and efficiency

Operator Name	Login Name	Check In Time	Check Out Time	Machine Name	Part Number	Op. No.	Op. Name	Std Cycle Time	Std Load Unload Time	Planned qty.	Produced Qty.	Rejected Qty.	Efficiency %
Operator Name=ABHISHEK H													
ABHISHEK H	EMP0328	21-08-2023 02:22:45 PM	21-08-2023 10:00:00 PM	VMC 02	IW051	2131	MILLING	2100	1	13	11	0	85
ABHISHEK H	EMP0328	21-08-2023 10:13:06 PM	22-08-2023 06:00:00 AM	VMC 02	IW051	2131	MILLING	2100	1	13	12	0	92
Operator Name=ADITHYA KP													
ADITHYA KP	HSK2294	22-08-2023 06:27:16 AM	22-08-2023 08:00:00 AM	VMC 06	IW005	30	Milling	3240	120	2	2	0	100
Operator Name=AKASH KUMAR PRADHAN													
AKASH KUMAR PRADHAN	CON3344	21-08-2023 02:47:25 PM	21-08-2023 10:00:00 PM	VMC 07	IW005	30	Milling	3240	120	8	7	0	88
Operator Name=ARABINDA KHUNTIA													
ARABINDA KHUNTIA	EMP0329	21-08-2023 08:00:00 AM	21-08-2023 02:00:00 PM	VMC 02	IW051	2131	MILLING	2100	1	10	9	0	90
ARABINDA KHUNTIA	EMP0329	22-08-2023 06:10:21 AM	22-08-2023 08:00:00 AM	VMC 03	IW026	304050	Milling	4320	1	2	1	0	50
Operator Name=ASUTOSH DAS													
ASUTOSH DAS	EMP0317	21-08-2023 08:00:00 AM	21-08-2023 02:00:00 PM	VMC 07	IW005	30	Milling	3240	120	6	6	0	100
Operator Name=BASANT BEHERA													
BASANT BEHERA	CON3328	21-08-2023 08:00:00 AM	21-08-2023 02:00:00 PM	VMC 01	IW058	1020	Milling	2160	60	10	8	0	80
Operator Name=DODDAMANI MURALIDHARA													
DODDAMANI MURALIDHARA	EMP0068	21-08-2023 02:25:41 PM	21-08-2023 10:00:00 PM	VMC 03	IW026	304050	Milling	4320	1	6	6	0	100

Operator downtimes – Jadhav G & Nikhil Khairnar

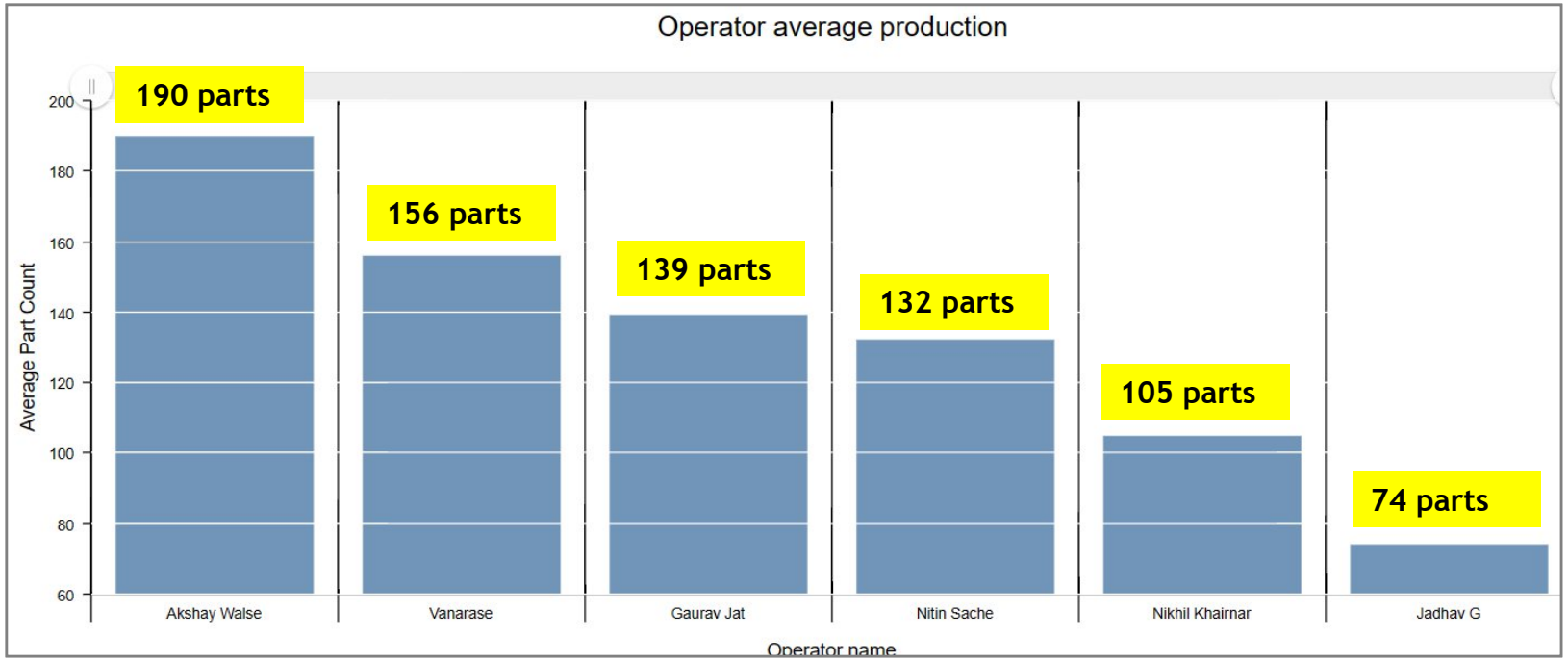
Operator name	Month/Y...	Start date	End date	Product	Planned Qty.	Part Count	Rejection	Std. cycle time	Avg. cycle time	Std. load/unload	Avg. load/unload	Total Downtime	Available Hrs.
Operator name=Jadhav G													
Jadhav G	Shift 3	05-09-2023 11:30:00 PM	06-09-2023 06:30:00 AM	Crank shaft SBD	180	125	0	00:02:00	00:01:57	00:00:20	00:01:23	02:54:53	07:00:00
Jadhav G	Shift 3	06-09-2023 11:30:00 PM	07-09-2023 06:30:00 AM	Crank shaft SBD	159	105	2	00:02:00	00:02:01	00:00:20	00:00:18	00:54:47	06:10:00
Jadhav G	Shift 3	07-09-2023 11:30:00 PM	08-09-2023 06:30:00 AM	Crank shaft SBD	159	98	0	00:02:00	00:01:53	00:00:20	00:00:18	00:22:21	06:10:00
Jadhav G	Shift 3	08-09-2023 11:30:00 PM	09-09-2023 06:30:00 AM	Crank shaft SBD	159	24	1	00:02:00	00:01:50	00:00:20	00:00:17	00:20:05	06:10:00
Jadhav G	Shift 3	09-09-2023 11:30:00 PM	10-09-2023 06:30:00 AM	Crank shaft SBD	159	21	0	00:02:00	00:10:45	00:00:20	00:00:16	00:29:33	06:10:00
						373	**3**					**05:01:39**	**31:40:00**
Operator name=Nikhil Khairnar													
Nikhil Khair...	Shift 2	24-08-2023 03:00:00 PM	24-08-2023 11:30:00 PM	Crank shaft SBD	197	59	0	00:02:00	00:02:31	00:00:20	00:00:20	00:28:59	07:40:00
Nikhil Khair...	Shift 2	26-08-2023 03:00:00 PM	26-08-2023 11:30:00 PM	Crank shaft SBD	195	152	0	00:02:00	00:01:58	00:00:20	00:00:18	00:27:10	07:35:00
						211	**0**					**00:56:09**	**15:15:00**

Operator’s average downtimes per shift



Operator’s Average production bar chart – Shiftwise

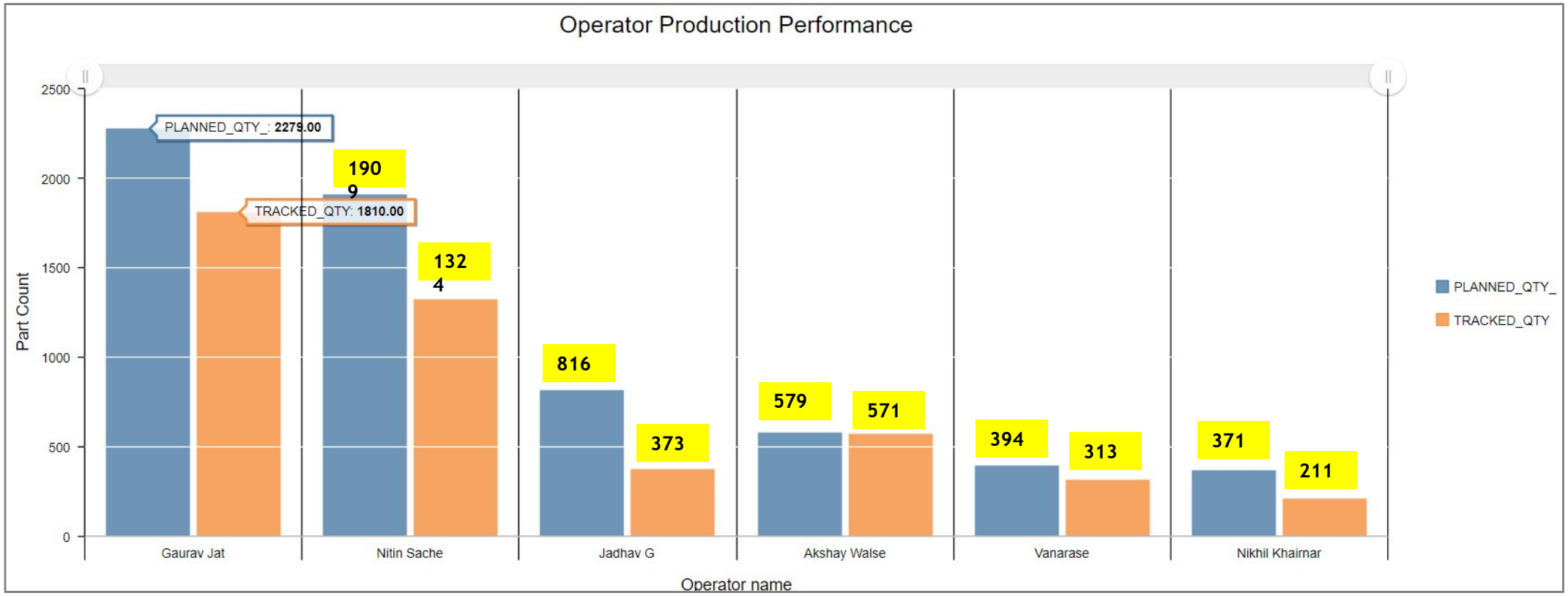
- Part Name: Crankshaft SBD
- Standard Planned Quantity per Shift: 193 units



Machine	Start date	Time period	Operator name	Produced qty.
GES 369	22-08-2023 06:30:00 AM	Shift 1	Gaurav Jat	180
GES 369	22-08-2023 03:00:00 PM	Shift 2	Vanarase	128
GES 369	23-08-2023 06:30:00 AM	Shift 1	Gaurav Jat	160
GES 369	23-08-2023 03:00:00 PM	Shift 2	Vanarase	185
GES 369	24-08-2023 06:30:00 AM	Shift 1	Gaurav Jat	92
GES 369	24-08-2023 03:00:00 PM	Shift 2	Nikhil Khairnar	59
GES 369	25-08-2023 06:30:00 AM	Shift 1	Gaurav Jat	99
GES 369	26-08-2023 06:30:00 AM	Shift 1	Gaurav Jat	106
GES 369	26-08-2023 03:00:00 PM	Shift 2	Nikhil Khairnar	152
GES 369	28-08-2023 06:30:00 AM	Shift 1	Nitin Sache	96
GES 369	28-08-2023 03:00:00 PM	Shift 2	Gaurav Jat	124
GES 369	29-08-2023 06:30:00 AM	Shift 1	Nitin Sache	159
GES 369	29-08-2023 03:00:00 PM	Shift 2	Gaurav Jat	162
GES 369	30-08-2023 06:30:00 AM	Shift 1	Nitin Sache	154
GES 369	30-08-2023 03:00:00 PM	Shift 2	Akshay Walse	193
GES 369	31-08-2023 06:30:00 AM	Shift 1	Nitin Sache	186
GES 369	31-08-2023 03:00:00 PM	Shift 2	Akshay Walse	186
GES 369	02-09-2023 06:30:00 AM	Shift 1	Nitin Sache	133
GES 369	02-09-2023 03:00:00 PM	Shift 2	Akshay Walse	192
GES 369	04-09-2023 06:30:00 AM	Shift 1	Gaurav Jat	176
GES 369	05-09-2023 06:30:00 AM	Shift 1	Gaurav Jat	177
GES 369	05-09-2023 03:00:00 PM	Shift 2	Nitin Sache	167
GES 369	05-09-2023 11:30:00 PM	Shift 3	Jadhav G	125
GES 369	06-09-2023 06:30:00 AM	Shift 1	Gaurav Jat	117
GES 369	06-09-2023 03:00:00 PM	Shift 2	Nitin Sache	121

Operatorwise production - Planned Vs Actual

- **Data for 15 days**

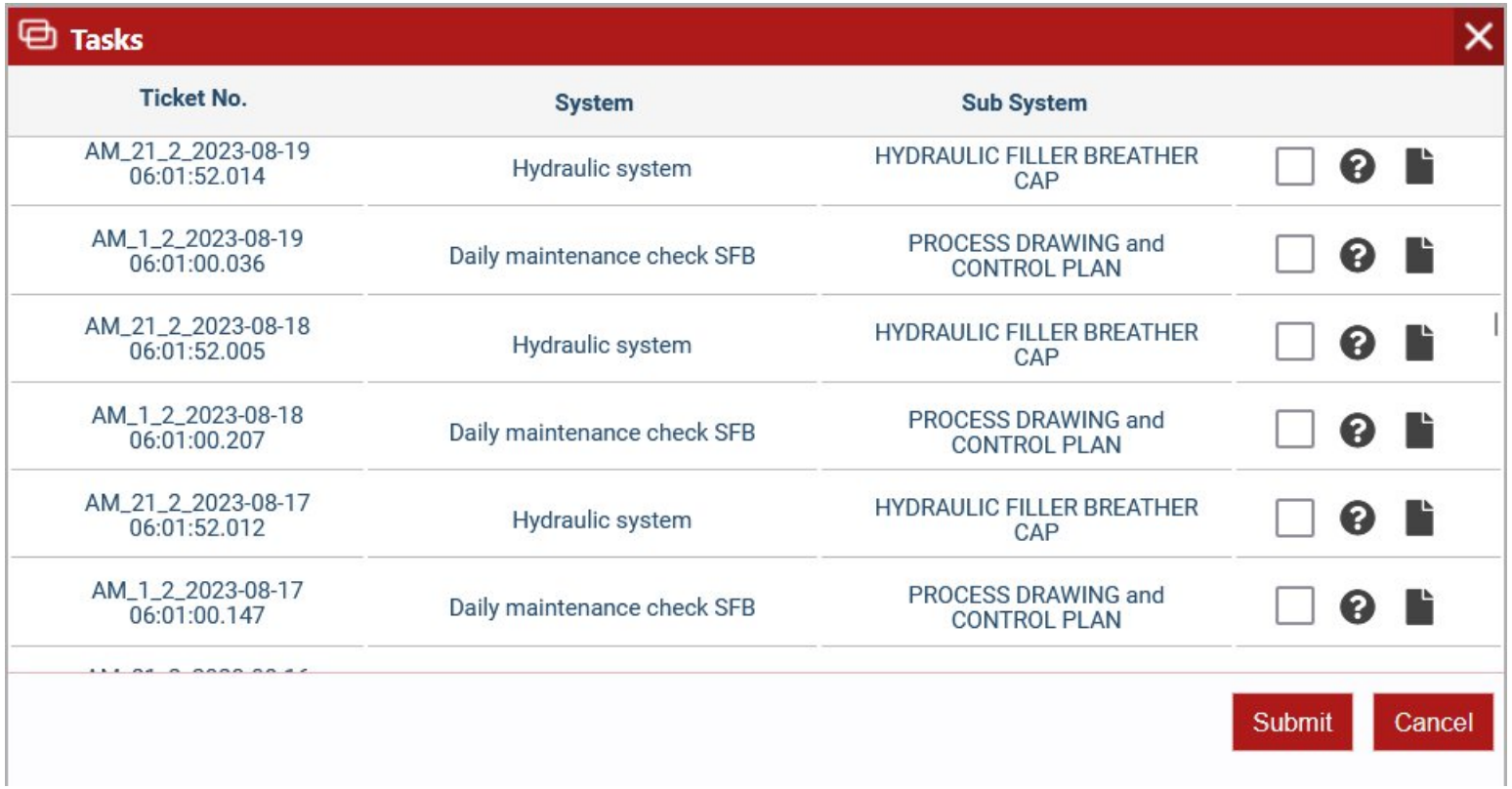


Supervisor efficiency report

Operator Name	Supervisor Name	Check In Time	Check Out Time	Machine Name	Part Number	Op. No.	Op. Name	Part Category	Std Cycle Time	Std Load Unload Time	Planned qty.	Produced Qty.	Rejected Qty.	Supervisor performance %
Supervisor Name=Supervisc														
RANGANATHA	Supervisor	03-10-2023 02:14:06 PM	03-10-2023 10:00:00 PM	VMC 01	IW058	1020	Milling	Production	00:35:00	00:01:00	13	10	0	88
SATISH ARKACHARI	Supervisor	03-10-2023 07:01:27 AM	03-10-2023 02:00:00 PM	VMC 01	IW058	1020	Milling	Production	00:35:00	00:01:00	12	9	0	88
RAMESH	Supervisor	03-10-2023 06:00:00 AM	03-10-2023 06:00:00 AM	VMC 01	IW058	1020	Milling	Production	00:35:00	00:01:00	0	1	0	50
RAMESH	Supervisor	03-10-2023 10:20:33 PM	04-10-2023 06:00:00 AM	VMC 01	IW058	1020	Milling	Production	00:35:00	00:01:00	13	9	0	84
ABHISHEK H	Supervisor	03-10-2023 02:14:08 PM	03-10-2023 10:00:00 PM	VMC 02	IW051	2131	MILLING	Production	00:42:00	00:00:01	11	11	0	100
ARABINDA KHUNTIA	Supervisor	03-10-2023 06:08:29 AM	03-10-2023 02:00:00 PM	VMC 02	IW051	2131	MILLING	Production	00:42:00	00:00:01	11	11	0	100
RAJATH KUMAR K G	Supervisor	03-10-2023 06:00:00 AM	03-10-2023 06:00:00 AM	VMC 02	IW051	2131	MILLING	Production	00:42:00	00:00:01	0	1	0	50
Nagaraja S	Supervisor	03-10-2023 10:11:56 PM	04-10-2023 06:00:00 AM	VMC 02	IW051	2131	MILLING	Production	00:42:00	00:00:01	11	11	0	100
SHARATH S	Supervisor	03-10-2023 02:13:27 PM	03-10-2023 10:00:00 PM	VMC 03	IW031	304050	Milling	Production	01:13:00	00:00:01	6	6	0	100
DODDAMANI MURALIDHA...	Supervisor	03-10-2023 06:12:45 AM	03-10-2023 02:00:00 PM	VMC 03	IW031	304050	Milling	Production	01:13:00	00:00:01	6	6	0	100
RAJATH KUMAR K G	Supervisor	03-10-2023 10:14:03 PM	04-10-2023 06:00:00 AM	VMC 03	IW031	304050	Milling	Production	01:13:00	00:00:01	6	6	0	100
Nagaraja S	Supervisor	03-10-2023 06:00:00 AM	03-10-2023 06:00:00 AM	VMC 03	IW031	304050	Milling	Production	01:13:00	00:00:01	0	1	0	50
PRASAD DS	Supervisor	03-10-2023 02:07:15 PM	03-10-2023 10:00:00 PM	VMC 04	IW397	30	Milling	Development	00:56:00	00:02:00	8	1	0	56

Machine Maintenance Reports

Autonomous maintenance



Breakdown incidences

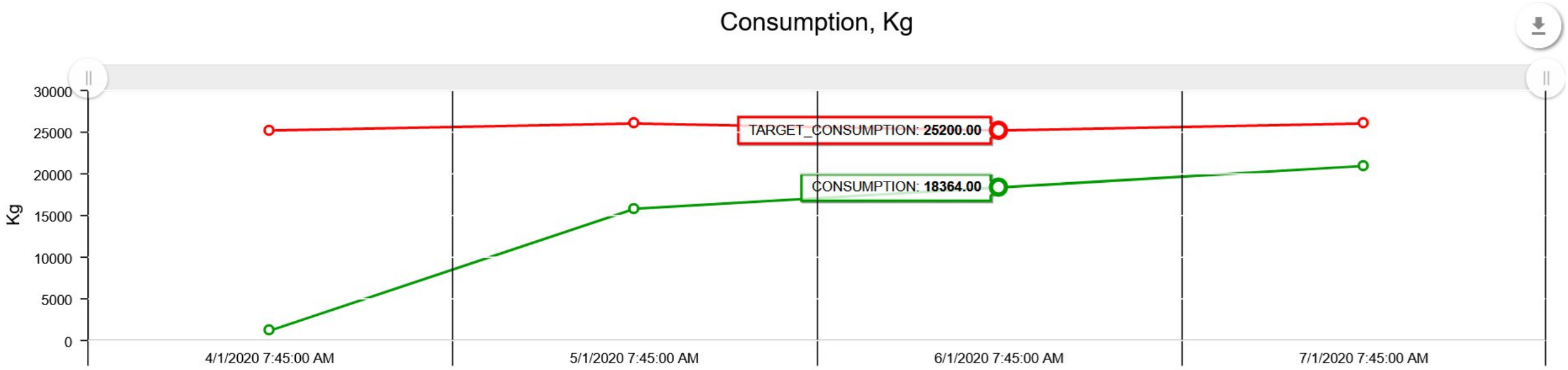
Machine	Ticket number	Maintenance type	Requested at	Requested by	Status	Maintenance started at	Started by	Response time	Maintenance ended at	Maintenance time	Ended by	Approved at	Approved by	Reason	Sub reason
Maintenance type=AM															
CNC 30	AM_1_1_2021-06-05 ...	AM	05-06-2021 01:00:00 PM		Accepted	05-06-2021 01:00:00 PM		00:00:00	07-06-2021 07:51:03 AM	42:51:03	operator	07-06-2021 07:51:03 AM	operator	Complete check CNC l...	All systems CNC lathe
CNC 30	AM_1_1_2021-06-13 ...	AM	13-06-2021 07:55:00 AM		Accepted	13-06-2021 07:55:00 AM		00:00:00	14-06-2021 06:44:19 AM	22:49:19	operator	14-06-2021 06:44:19 AM	operator	Complete check CNC l...	All systems CNC lathe
CNC 30	AM_1_1_2021-06-13 ...	AM	13-06-2021 01:00:00 PM		Accepted	13-06-2021 01:00:00 PM		00:00:00	14-06-2021 06:44:18 AM	17:44:18	operator	14-06-2021 06:44:18 AM	operator	Complete check CNC l...	All systems CNC lathe
CNC 30	AM_1_1_2021-06-22 ...	AM	22-06-2021 04:36:00 PM		Created	22-06-2021 04:36:00 PM		00:00:00						Complete check CNC l...	All systems CNC lathe
CNC 30	AM_2_1_2021-06-13 ...	AM	13-06-2021 03:00:00 PM		Accepted	13-06-2021 03:00:00 PM		00:00:00	14-06-2021 06:44:17 AM	15:44:17	operator	14-06-2021 06:44:17 AM	operator	Coolant system	Coolant pump
CNC 30	AM_2_1_2021-06-22 ...	AM	22-06-2021 04:36:00 PM		Created	22-06-2021 04:36:00 PM		00:00:00						Coolant system	Coolant pump

Tool consumption

Machine name	Consumable name	Consumable group name	Time slice	Start date	Quantity changed	Produced qty.	Parts per edge
Time slice=Month 2							
SFB - 1102	SCMT09T308	Insert for Fine boring	Month 2	01-09-2022 06:00:00 AM	251	17685	70.00
SFB - 1102	CCGT060204	Insert for Fine boring	Month 2	01-09-2022 06:00:00 AM	14	16851	1204.00
SFB - 1102	CSCMT09T308	Insert for Fine boring	Month 2	01-09-2022 06:00:00 AM	10	15061	1506.00
					275		
Time slice=Month 3							
SFB - 1102	SCMT09T308	Insert for Fine boring	Month 3	01-10-2022 06:00:00 AM	174	7972	46.00
SFB - 1102	CCGT060204	Insert for Fine boring	Month 3	01-10-2022 06:00:00 AM	42	3146	75.00
					216		
					491		

Consumable tracking

Machine name	Consumable	Cost per unit	Units	Consumption	Target consumption	Consumption saving	Saving %	Consumption per hour	Cost, Rs.	Target cost, Rs.	Saving, Rs.
CAB furnace	Energy	6.35	kWh	110394	133920	23526	18	148.38	701002	850392	149390
CAB furnace	LPG	52	kg	20947	26040	5093	20	28.15	1089244	1354080	264836
CAB furnace	Nitrogen	9	m3	180571	238080	57509	24	242.70	1625139	2142720	517581
									3415385	**4347192**	**931807**



Inspection details

Sl. no.	Measured by	Measured on	Last Measured on	Part number	Work order number	Operation number	Operation Name	Dimension name	Basic dimension	Measured value	Upper limit	Lower limit
8	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	INNER DIAMETER	219.645	219.65	0.095	0.095
9	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	OUTER DIAMETER	250.745	20.81	0.18	0.18
10	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	SURFACE HARDNESS AT PCD POINT	54.5	56.5	4.5	4.5
11	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CASE DEPTH AT POINT Y1 AND Y2	1.5	1.5	0	0
12	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CASE DEPTH AT POINT Z	1.5	2.1	1	1
13	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	TEETH MELTING	0	1	0	0
14	operator	25-06-2021 10:51:53 AM	25-06-2021 10:45:23 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CRACK	0	1	0	0
15	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	INNER DIAMETER	219.645	219.595	0.095	0.095
16	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	OUTER DIAMETER	250.745	250.8	0.18	0.18
17	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	SURFACE HARDNESS AT PCD POINT	54.5	57	4.5	4.5
18	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CASE DEPTH AT POINT Y1 AND Y2	1.5	1.5	0	0
19	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CASE DEPTH AT POINT Z	1.5	0.9	1	1
20	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	TEETH MELTING	0	1	0	0
21	operator	25-06-2021 10:56:25 AM	25-06-2021 10:51:53 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	CRACK	0	1	0	0
22	operator	25-06-2021 11:16:43 AM	25-06-2021 10:56:25 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	INNER DIAMETER	219.645	219.65	0.095	0.095
23	operator	25-06-2021 11:16:43 AM	25-06-2021 10:56:25 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	OUTER DIAMETER	250.745	250.73	0.18	0.18
24	operator	25-06-2021 11:16:43 AM	25-06-2021 10:56:25 AM	KE02	KE_02_WORK_ORDER_SECON...	100	INDUCTIONHARDENING	SURFACE HARDNESS AT PCD POINT	54.5	53	4.5	4.5