



***factoryInsite*[®] Software**

Order Schedule Performance

Sample Reports

Analysis Reports

Analysis reports give summary and trend information over time as well as allowing you to drill down into the report to see detail. These reports can help you see what is changing before it affects your profitability. Analysis reports that are included with the *factoryInsite*[®] Order Schedule Performance application are:

- Direct Labor Hours By Job – This report shows you the difference between the standard and actual time for each work order. This can indicate areas for potential productivity improvement
- Employee Efficiency Chart – This charts efficiency by weeks for multiple departments. It can give you a quick check of productivity improvements after you implement a process change.
- Setup Breakdown by Order – This compares measured setup/breakdown times to the standard times. This can indicate rate differences in work areas or between standards and actual times.
- Shop Efficiency – Comparison between actual times and standard times are presented across departments. This can be used to compare process changes implemented or point to departments that are performing at a higher than average efficiency.
- Work Order Summary – A subset of orders can be viewed to check on progress by time and by quantity.
- Workcenter Rate Performance – Workcenters performing above or below standards can be quickly spotted.



Direct Labor Hours By Order

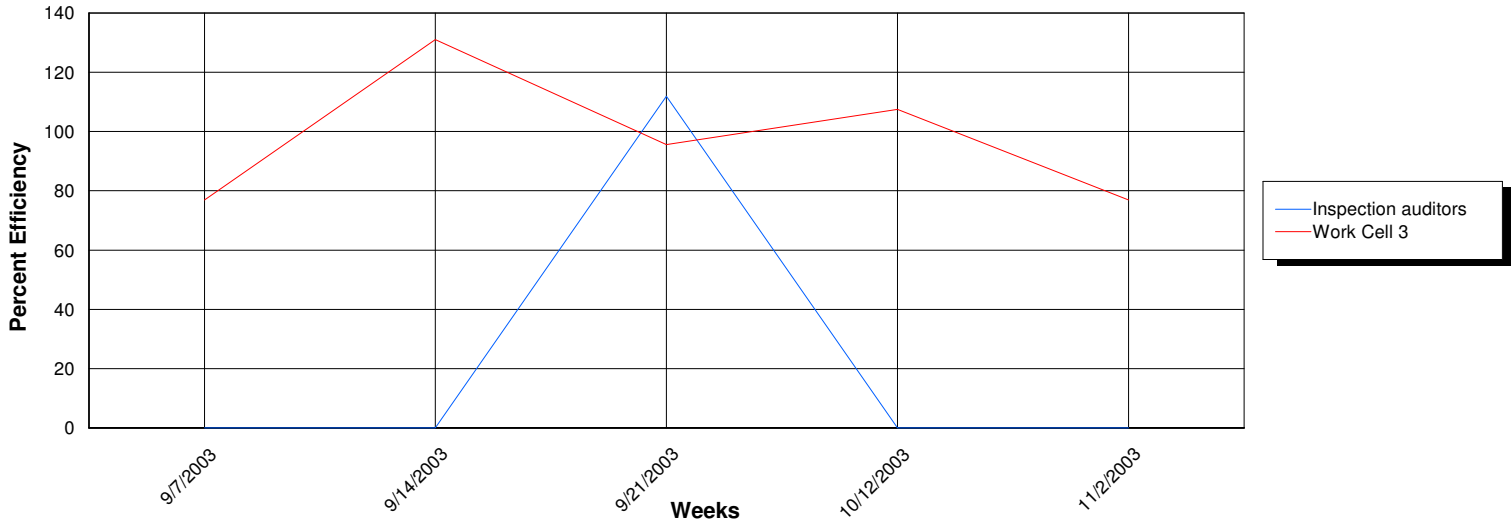
1-Jan-2003 to 30-Sep-2003

1
07-Dec-2004
9:45:52

<u>Work Order</u>	<u>Estimated Time</u>	<u>Actual Time</u>	<u>Hours Difference</u>	<u>% Deviation</u>
1426781344	19.02	20.10	-1.08	5.69
1426781345	6.30	6.17	0.13	-2.00
2345	3.50	3.30	0.20	-5.63
6789	2.90	3.92	-1.02	35.10

Employee Efficiency Trends

1-Aug-2003 to 1-Dec-2003



		7-Sep-2003	14-Sep-2003	21-Sep-2003	12-Oct-2003	2-Nov-2003	Total
Inspection auditors	Hoffman Timothy	0.00%	0.00%	111.92%	0.00%	0.00%	111.92%
	Total	0.00%	0.00%	111.92%	0.00%	0.00%	111.92%
Work Cell 3	Amy K Johnson	76.96%	131.05%	95.64%	107.53%	76.96%	104.53%
	Total	76.96%	131.05%	95.64%	107.53%	76.96%	104.53%
Total		76.96%	131.05%	96.73%	107.53%	76.96%	104.68%



Reported Setup/Breakdown For Orders

1
7-Dec-2004
11:08:38

<u>Work Order</u>	<u>Equipment</u>	<u>Setup/Breakdown Hours</u>	<u>Estimated Setup</u>
<u>1426781344</u>	<u>LH1</u>		
		S	2.00
	Total Time for LH1		2.00
			2.00
<u>1426781344</u>	<u>PB2</u>		
		B	0.02
		S	1.82
	Total Time for PB2		1.84
	Total Time for 1426781344		3.90
			3.90
<u>1426781345</u>	<u>LH1</u>		
		S	0.15
	Total Time for LH1		0.15
			0.10
<u>1426781345</u>	<u>PB2</u>		
		S	0.06
	Total Time for PB2		0.06
	Total Time for 1426781345		0.16
			0.16
<u>6789</u>	<u>PB2</u>		
		S	2.02
	Total Time for PB2		2.02
	Total Time for 6789		2.00
			2.00



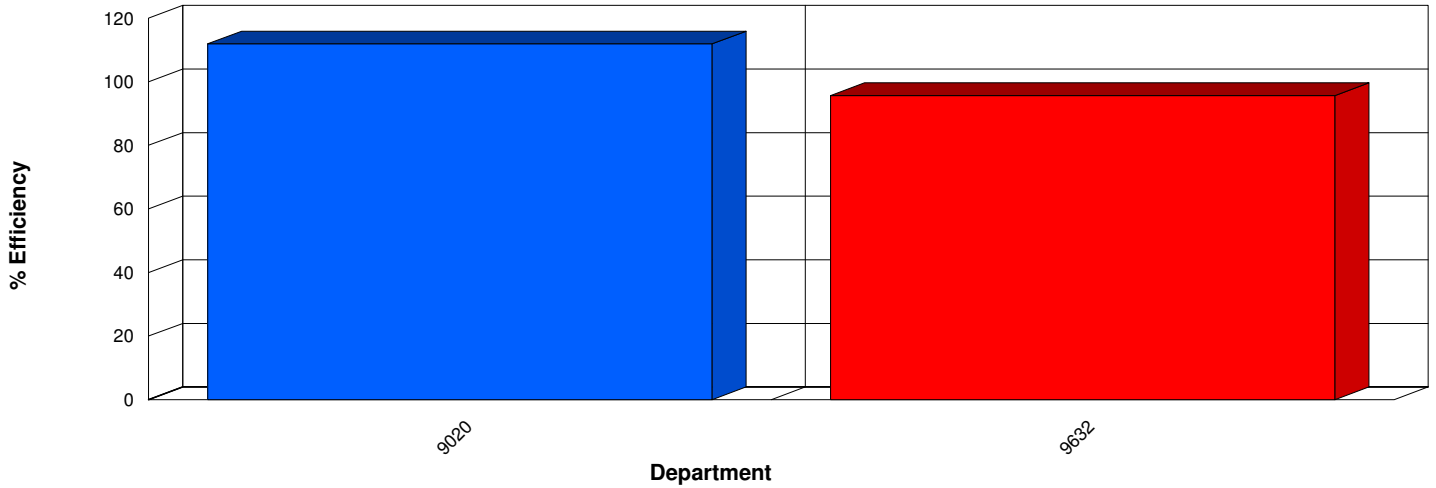
Shop Efficiency

1-Jan-2003 to 30-Sep-2003

1
07-Dec-2004
11:10:45

		<u>Scheduled</u>	<u>Actual</u>	<u>Efficiency</u>
<i>Department</i>	<i>9632 Work Cell 3</i>	21.62	22.61	95.62%
<i>Department</i>	<i>9020 Inspection auditors</i>	0.14	0.13	111.92%
<u>Total Shop:</u>		<u>21.76</u>	<u>22.73</u>	<u>95.71%</u>

Efficiency By Department





Work Order Summary

1
7-Dec-2004
10:06:02

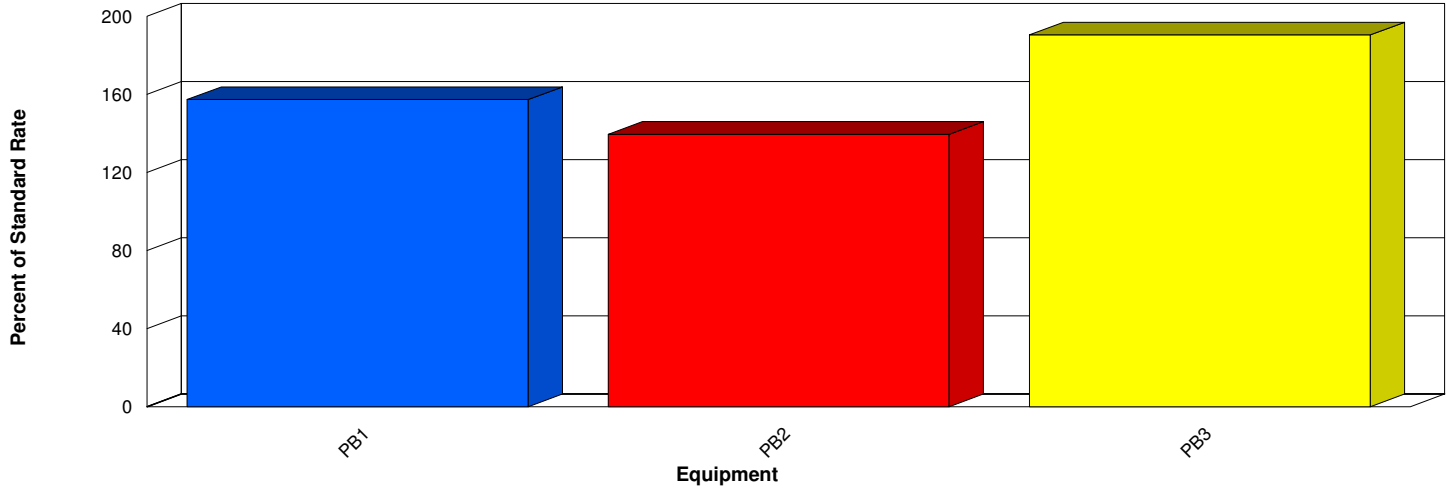
<u>Work Order Sequence</u>	<u>Workcenter</u>	<u>Sequence Completion Date</u>	<u>Completed Quantity</u>	<u>Initial Scrap</u>	<u>Recovered Scrap</u>
1426781344					
01	1 Center Cell	12-Mar-2004 12:00	326	30	6
02	2 Volvo Pre-fabrication	13-Feb-2004 14:59	326	5	5
04	2 Volvo Pre-fabrication	In Progress	6	2	1
05	2 Volvo Pre-fabrication	Not Started			
06	3 Workcenter 3	Not Started			
			6 / 350		Scheduled
1426781345					
COMPLETED					
01	1 Center Cell	2-Jul-2003 20:42	272	69	41
02	Grinder Metal Grinders	2-Jul-2003 21:09	271	20	19
			271 / 300		Scheduled
2345					
010	1 Center Cell	19-Sep-2003 16:10	9	4	3
020	1 Center Cell	26-Sep-2003 13:32	9	0	
030	1 Center Cell	Not Started			
			9 / 10		Scheduled
6789					
ON HOLD					
010	1 Center Cell	26-Sep-2003 10:47	8	4	2
020	1 Center Cell	26-Sep-2003 11:26	8	1	
030	1 Center Cell	26-Sep-2003 11:27	7	1	0
040	1 Center Cell	In Progress			
			7 / 10		Scheduled
9999999999					
010	1 Center Cell	Not Started			
020	2 Volvo Pre-fabrication	Not Started			
030	3 Workcenter 3	Not Started			
			/ 100		Scheduled

Workcenter Rate Performance

1-Jan-2003 to 30-Sep-2003

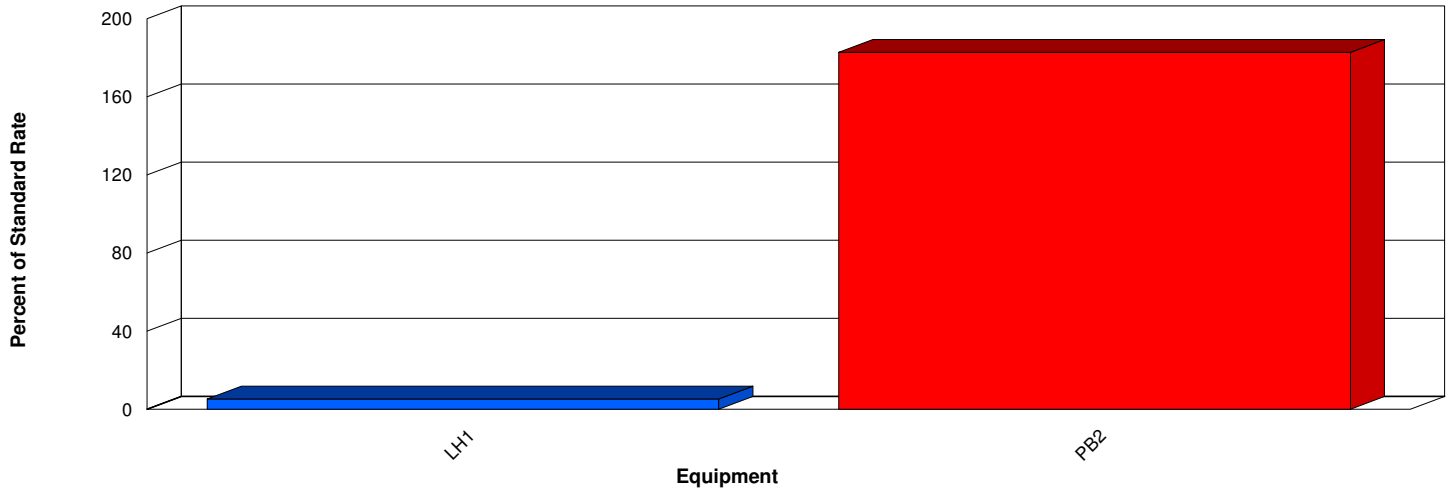
Workcenter *1 Center Cell*

Percent of Standard Rate By Equipment



Workcenter *2 Volvo Pre-fabrication*

Percent of Standard Rate By Equipment



Exception Reports

Exception reports provide information about occurrences that were outside of the management policies defined to the Attendance system. Exception reports that are included with the *factoryInsite*[®] Order Schedule Performance application are:

- **Jobs Closed at Less Than Planned Quantity** – Jobs that were closed with less than the scheduled quantity usually require producing more product if they correspond to customer orders. In a build to stock environment, this may not be a concern.
- **Order Scheduled Time Variances** – Variances from setup standards and operation standards can be spotted in order to improve processes.
- **Orders Finishing Late** – Orders that finish late generally indicate some constraint that has not been taken into account when scheduling.
- **Orders Starting Late** – Orders that could not be started when schedule can indicate some sort of a blocking condition.
- **Work Performed at Alternate Workcenters** – When work is performed at a work center other than the one scheduled it can affect the delivery time of multiple customer orders. This report allows investigation into these occurrences.



Jobs Closed at Less Than Planned Quantity

1-Jan-2003 to 30-Sep-2003

1
7-Dec-2004
10:22:25

<u>Work Order</u>	<u>Scheduled Quantity</u>	<u>Produced Quantity</u>
1426781345	300	271



Order Scheduled Time Variances

Average Order Variances greater than 10.00%

1-Jan-2003 to 30-Sep-2003

1
7-Dec-2004
10:25:48

<u>Work Order</u>	<u>Estimated Setup Hours</u>	<u>Reported Setup Hours</u>	<u>Setup Variance</u>	<u>Estimated Operation Hours</u>	<u>Reported Operation Hours</u>	<u>Operation Variance</u>
<u>1426781345</u>	0.16	0.21	30.73%	6.14	5.96	-2.85%
<u>2345</u>	1.41			2.09	3.30	58.04%
<u>6789</u>	2.20	2.02	-8.28%	0.70	0.80	14.51%



Work Order 1426781345

Orders Completed Later Than Scheduled

Orders Starting Between 1-Jan-2003 and 30-Sep-2003

Order Scheduled Finish Date

16-Jun-2003

Order Completion Date

02-Jul-2003 21:09

1
7-Dec-2004
10:27:03



Work Orders Starting Late

1
7-Dec-2004
10:28:12

	<u>Work Order</u>	<u>Next Sequence</u>	<u>Scheduled Workcenter</u>	<u>Scheduled Start Date</u>
	1426781344	04	2 Volvo Pre-fabrication	16-Oct-2003
	2345	030	1 Center Cell	17-Sep-2003
ON HOLD	6789	040	1 Center Cell	18-Oct-2003
NOT STARTED	9999999999	010	1 Center Cell	20-Oct-2003



Work Performed at Alternate Workcenters

Work Performed from 1-Jan-2003 to 30-Sep-2003

1
7-Dec-2004
11:24:23

<u>Sequence</u>	<u>Started On</u>	<u>Scheduled Workcenter</u>	<u>Actual Workcenter</u>	<u>Employee</u>
1426781344				
02	30-Jun-2003 14:29	2 Volvo Pre-fabrication	1 Center Cell	12345678 Amy K Johnson
1426781345				
02	02-Jul-2003 20:59	Grinder Metal Grinders	2 Volvo Pre-fabrication	12345678 Amy K Johnson
02	02-Jul-2003 21:08	Grinder Metal Grinders	2 Volvo Pre-fabrication	12345678 Amy K Johnson
02	02-Jul-2003 21:09	Grinder Metal Grinders	2 Volvo Pre-fabrication	12345678 Amy K Johnson

Status Reports

Status reports display the real-time status of employees. These reports give a view of what the last reported happenings are on the shop floor. Status reports that are included with the *factoryInsite*[®] Order Schedule Performance application are:

- Work Order Status Report – Selected orders are shown based on the ready time and the downstream workcenter. The time between steps can indicate flow problems between processes.
- Part Quantities in Progress – This report shows all orders for a specified part number that are in process. This can be generated in response to a customer request for a specific part number.
- Order Completion by Scheduled Time – The comparison between reported work hours and standard hours on this report is an indication of completion.



Work Order Status Report

1
7-Dec-2004
10:31:01

	<u>Work Order</u>	<u>Sequence</u>	<u>Workcenter</u>	<u>Ready for Next Step at</u>	<u>Next Workcenter</u>
	1426781344	02	2	13-Feb-2004 14:59:55	2 Volvo Pre-fabrication
ON HOLD	6789	030	1	13-Oct-2003 13:26:26	1 Center Cell
	2345	020	1	26-Sep-2003 13:32:13	1 Center Cell



Part Quantities In Process

1
7-Dec-2004
10:32:21

<u>Part</u>	<u>Work Order</u>	<u>Quantity in Order</u>	<u>Quantity In Process</u>	<u>Cumulative Scrap</u>	<u>Currently at Workcenter</u>
<u>11111111</u>	1426781	350	320	24	2 Volvo Pre-fabrication
		<u>350.00</u>	<u>320.00</u>	<u>24.00</u>	
<u>8393</u>	2345	10	9	1	1 Center Cell
ON HOLD	6789	10	7	3	1 Center Cell
		<u>20.00</u>	<u>16.00</u>	<u>4.00</u>	



Completion of Work Orders In Progress by Estimated Time

1
7-Dec-2004
10:33:45

<u>Work Order In Progress</u>	<u>Estimated Total Hours</u>	<u>Reported Total Hours</u>	<u>Percent of Estimate</u>
1426781344	22.00	20.10	91.38%
2345	11.00	3.30	30.03%
6789	ON HOLD	5.40	72.55%

Informational Reports

Informational reports display the order scheduling information defined. Informational reports that are included with the *factoryInsite*[®] Order Schedule Performance application are:

- Scheduled Work Orders – This is a list of orders that have been received from the scheduling system.



Scheduled Work Orders

1-Jan-2003 to 30-Sep-2003

1
7-Dec-2004
10:38:07

<u>Work Order</u>	<u>Part Number</u>	<u>Quantity</u>	<u>Priority</u>	<u>Scheduled Start</u>	<u>Scheduled Finish</u>
1426781345	11111112	300	50	14-Jun-2003	16-Jun-2003

<u>Sequence</u>	<u>Workcenter</u>	<u>Priority</u>	<u>Setup Hours</u>	<u>Scheduled Hours</u>	<u>Parts Per Hour</u>	<u>Scheduled Start</u>	<u>Scheduled Finish</u>
01	1 Center Cell	60	0.06	6.00	50.00	14-Jun-2003	15-Jun-2003
02	Grin Metal Grinders	30	0.10	0.30	1,000.00	15-Jun-2003	16-Jun-2003
			<u>0.16</u>	<u>6.30</u>			

2345	8393	10	500	14-Sep-2003	17-Sep-2003
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<u>Sequence</u>	<u>Workcenter</u>	<u>Priority</u>	<u>Setup Hours</u>	<u>Scheduled Hours</u>	<u>Parts Per Hour</u>	<u>Scheduled Start</u>	<u>Scheduled Finish</u>
010	1 Center Cell	500	1.00	1.50	6.67	15-Sep-2003	16-Sep-2003
020	1 Center Cell	500	0.41	2.00	5.00	16-Sep-2003	17-Sep-2003
030	1 Center Cell	500	0.50	7.50	1.08	17-Sep-2003	17-Sep-2003
			<u>1.91</u>	<u>11.00</u>			