



Manufacturing

Summary for 10/11/20 - 10/17/20

Sample Weekly Report

Hours	Hours	Hours	Change	Change	Cycle	Cycle
Hours	Hours	Hours	Change	Change	Cycle	Cycle
Hours	Hours	Hours	Change	Change	Cycle	Cycle
Change	Change	Change	Change	Change	Cycle	Cycle
Change	Change	Change	Change	Change	Cycle	Cycle
Cycle	Cycle	Cycle	Cycle	Cycle	Cycle	Cycle
Cycle	Cycle	Cycle	Cycle	Cycle	Cycle	Cycle

<=33% utilized
 34-66% utilized
 >=67% utilized
 Incr from prev week
 Decr from prev week
 Hasn't cycled in 2 days
 Hasn't cycled in 3 days

Overall Utilization

54.74%

	Hours	Change(h)	Last Cycle
Manufacturing	3461/6323	▼27	
Watch Facility	780/2073	▼133	
Machine Shop	780/2073	▼133	
CNC Lathe	0/120	0	
⚙ Lathe	0/120	0	-
Horizontal Machines	780/1832	▼133	
⚙ CNC #23 (SSR Swivel)	0/33	0	10/5/20
⚙ Machine #10 (Parker Overflow)	4/157	▼30	10/17/20
⚙ Machine #11 (Parker Endblocks)	94/131	▲33	10/18/20
⚙ Machine #12 (BRP 062 / 21&22)	2/0	0	10/17/20
⚙ Machine #14 (Snowhead)	68/161	▲9	10/18/20
⚙ Machine #16 (Mori Pallet Pool)	75/145	▲3	10/16/20
⚙ Machine #22 (Swingarm&JDRotor)	16/118	▼36	10/18/20
⚙ Machine #24 (Upper, Stern, 207255 Pallet Pool)	2/0	▲2	10/15/20
⚙ Machine #25 (Ross)	58/145	▲23	10/16/20
⚙ Machine #27 (Mori 800 / Frames)	7/77	▼41	10/16/20
⚙ Machine #28 (Volvo Manifolds)	49/163	▼31	10/18/20
⚙ Machine #29 (Doosan 800 bathtubs)	58/103	▲30	10/17/20
⚙ Machine #30 Okuma (Pallet Pool)	56/108	▼2	10/15/20
⚙ Machine #31 Okuma (Meritor Case)	146/163	▲11	10/18/20
⚙ Machine #32 Okuma (Bufflehead)	0/0	0	9/16/20
⚙ Machine #33 Okuma (Meritor Cover)	34/134	▼86	10/18/20
⚙ Machine #34 Seastar	54/122	▼26	10/18/20
⚙ Machine #8 (Midcast)	56/72	▲7	10/17/20
Vertical Machines	0/121	0	
⚙ Haas 3rd OP. SSR	0/121	0	1/28/20
Pattern Shop	0/0	0	
Foundry	2681/4250	▲106	
Air Compressors	150/316	▲34	
⚙ Air Compressor #1	0/98	0	-
⚙ Air Compressor #2	150/120	▲34	10/18/20

⚙️ Air Compressor #3	0/98	0	9/2/20
Blasting	234/478	▼3	
Spinner Blaster	135/285	▼8	
⚙️ Spin Blaster #1	0/95	0	12/27/19
⚙️ Spin Blaster #2	90/95	▼4	10/17/20
⚙️ Spin Blaster #3	44/95	▼4	10/17/20
Tumbler Blaster	99/192	▲5	
⚙️ Tumble Blaster #1	67/95	▼1	10/17/20
⚙️ Tumble Blaster #2	32/97	▲6	10/17/20
Core	410/660	▲24	
BP	0/209	0	
⚙️ BP#1	0/108	0	9/24/20
⚙️ BP#2	0/101	0	9/16/20
Gaylord	69/89	▲22	
⚙️ Large Gaylord	69/89	▲22	10/17/20
Laempe	341/363	▲2	
⚙️ Laempe 1	0/53	0	9/26/20
⚙️ Laempe 2	32/53	▲22	10/17/20
⚙️ Laempe 3	32/53	▲9	10/15/20
⚙️ Large Laempe 1	49/102	▼21	10/17/20
⚙️ Large Laempe 2	228/102	▼8	10/17/20
Finishing	0/0	0	
Fork Truck Fleet	0/98	0	
Test Unit 1	0/98	0	
⚙️ Test Unit aac (not used)	0/98	0	-
Furnaces	0/98	0	
⚙️ Furnace 1	0/98	0	-
Permanent Molding	902/1437	▲1	
Cell #1	31/166	▼41	
⚙️ Perm Mold #1	0/83	0	9/26/20
⚙️ Perm Mold #2	31/83	▼41	10/17/20
Cell #2	73/166	▲6	
⚙️ Perm Mold #3	22/83	▼5	10/17/20
⚙️ Perm Mold #4	51/83	▲11	10/17/20
Cell #3	77/249	▼12	
⚙️ Perm Mold #5	10/83	▼12	10/14/20
⚙️ Perm Mold #6(new)	30/83	▼12	10/15/20
⚙️ Perm Mold #7(new)	37/83	▲12	10/17/20
Cell #4	88/166	▲24	
⚙️ Perm Mold #8(new)	59/83	▲18	10/17/20
⚙️ Perm Mold #9(new)	29/83	▲6	10/17/20
Cell #5	189/166	▲3	
⚙️ Perm Mold #10(new)	21/83	▲1	10/15/20
⚙️ Perm Mold #11(new)	168/83	▲2	9/2/20
Cell #6	139/195	▲4	
⚙️ Perm Mold #12(new) parker	70/97	▲5	10/17/20
⚙️ Perm Mold #13(new) parker	69/97	▼1	10/17/20

Cell #7	0/0	0	
⚙️ Perm Mold #14	0/0	0	4/13/20
⚙️ Perm Mold #15	0/0	0	3/25/20
Cell #8	137/166	▲19	
⚙️ Perm Mold #16 6H	65/83	▼6	10/17/20
⚙️ Perm Mold #17 5H	72/83	▲25	10/17/20
Cell #9	169/164	▼2	
⚙️ Perm Mold #18 6H	88/82	▼19	10/17/20
⚙️ Perm Mold #19 6H	80/82	▲16	10/17/20
Robotics	586/893	▲17	
Deburring	9/119	▲3	
⚙️ MidCast Post Machining	9/119	▲3	10/16/20
Dimensional Inspection	0/0	0	
Material Removal	109/197	▼9	
⚙️ MRC #1	17/107	▼13	10/16/20
⚙️ MRC #2	92/90	▲4	10/17/20
Post Machining Cells	242/200	▼11	
⚙️ Parker End Blocks	74/100	▼18	10/18/20
⚙️ Snow Head Cell	168/100	▲7	6/29/20
Pouring Cells	226/378	▲34	
⚙️ Cell #1	28/90	▼3	10/17/20
⚙️ Cell #4	22/90	▲12	10/17/20
⚙️ Cell #8	84/108	▲5	10/17/20
⚙️ Cell #9	91/90	▲20	10/17/20
Sand Molding	401/271	▲33	
CMI Pumps	336/187	▲20	
⚙️ Striko #2 Pump	168/144	▲20	10/7/20
⚙️ Striko 3 Pump	168/43	0	8/10/20
Sinto	65/83	▲14	
⚙️ Sinto 1	31/42	▲4	10/16/20
⚙️ Sinto 2	34/42	▲10	10/16/20

Best Performers

Utilization %

Striko 3 Pump	386.2%
Large Laempe 2	224%
Perm Mold #11(new)	202.4%
Snow Head Cell	168%
Air Compressor #2	124.8%

Worst Performers

Utilization %

Air Compressor #1	0%
Air Compressor #3	0%
BP#1	0%
BP#2	0%
CNC #23 (SSR Swivel)	0%

Most Increased

Hours

Air Compressor #2	▲34
Machine #11 (Parker Endblocks)	▲33
Machine #29 (Doosan 800 bathtubs)	▲30
Perm Mold #17 5H	▲25

Most Decreased

Hours

Machine #33 Okuma (Meritor Cover)	▼86
Machine #27 (Mori 800 / Frames)	▼41
Perm Mold #2	▼41
Machine #22 (Swingarm&JDRotor)	▼36

Machine #25 (Ross)

▲23

Machine #28 (Volvo Manifolds)

▼31

Machine Exceptions

Last Cycle

CNC #23 (SSR Swivel)	13 days ago
Striko #2 Pump	11 days ago
Perm Mold #5	5 days ago
Perm Mold #6(new)	3 days ago
Perm Mold #10(new)	3 days ago
Machine #30 Okuma (Pallet Pool)	3 days ago
Laempe 3	3 days ago
Machine #24 (Upper, Stern, 207255 Pallet Pool)	3 days ago

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