Eclipse Production Management Software Training

Eclipse & Pathfinder Training Schedule

Tuesday

8:30am	Introduction
9:00am	Training begins
10:20am - 10:30am	Break
11:45am - 12:30pm	Lunch
2:20pm - 2:30pm	Break
4:30pm	Training ends, shuttle to Demolition Ball
5:00pm – 7:30pm	Demolition Ball 1875 S. Old Highway 94 St. Charles, MO 63303

Wednesday

8:30am	Training begins
10:20am - 10:30am	Break
10:30am - 11:00am	Tour
11:45am - 12:30pm	Lunch
12:45pm	Eclipse Discussion & Feedback
2:00pm	Pathfinder Training begins
3:30pm	Pathfinder Training ends

Contact AMS Controls

www.amscontrols.com

Sales

sales@amscontrols.com
800.334.5213 or 314.344.3144

Support

support@amscontrols.com
800.334.5213 or 314.344.3144
Press “2” for Support

Training

training@amscontrols.com

Mission Statement

AMS Controls provides world-class engineered solutions – including production management software and integrated machine controls – that optimize the operations of manufacturers in the metal profiling industry and provide a fair return on investment.

38 - 70 - 11,000

- AMS Controls has been in business for 38 years
- A Global Company – our products are in 70 countries!
- 11,000+ Machine Controllers sold

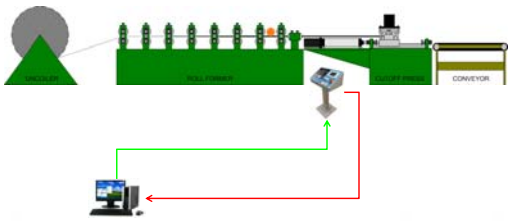
A Case for Eclipse

Why Computer Integrated Manufacturing is Critical for your Operations

Topics

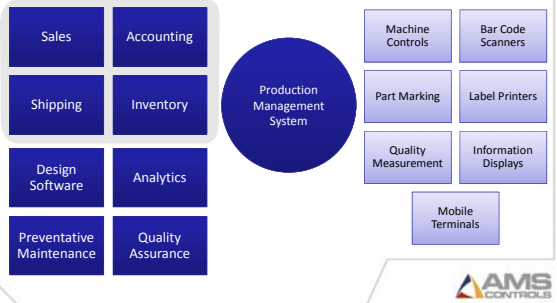
- Why Is Eclipse Valuable
- Eclipse Data Flow
- Mistake-Proofing Tools
- Productivity/Profitability Tools
- Operational Tools

What is Eclipse?



Software Integrated Manufacturing

What is Eclipse?



What is Eclipse good for?

- Mistake-proofing
- On-time deliveries
- Perfect accounting & inventory control
- Eliminating waste/growing capacity
- Flexibility
- Management focus and capital spending
- Continuous improvement

Eclipse Data Flow

Data Flow & Processing from ERP to XL200 and back to Eclipse

Eclipse Data Flow

Order Import File

Order

Order/Invoice

PERFECT BUILDING SYSTEMS
9020 MT. VERNON ROAD
ST. LOUISVILLE, MAINE 43071

PHONE: 940-345-2998 FAX: 940-345-2903

SOLD TO: JIM MCLAUGHLIN
398-2959
1384 BILLMAN RD NE
ST LOUISVILLE, ME 53071

SHIP TO: ROBERT AND SUSIE WILLIAMS
5370 JOHNSTOWN ALEXANDRIA ROAD
JOHNSTOWN, MAINE 53031
940-522-3675
PH#940-398-2959

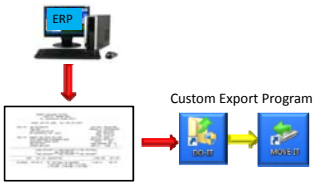
ACCT-PRJ: JMCLAN-000
INVOICE #: 150950914638
PO#: WILLIAMS
DATE: 09/10/15
TIME: 17:11:52
SALES ID: ADAM T
DELIVERY: 09/18/15
ROUTE: DEL
"ORD #031498 REV 2"
1000-27 PAGE 1

ORD #031498***ORD #031498*****ORD #031498**
** ORD #031498 REV 2 **
ORD #031498***ORD #031498*****ORD #031498**

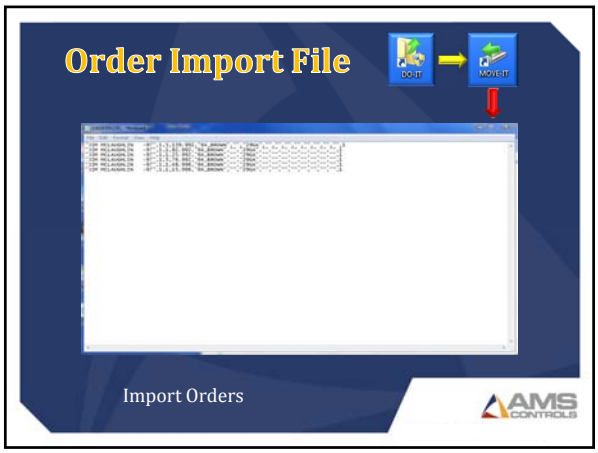
ITEM	QTY U/M	DESCRIPTION	U-PRC PER	NET AMT
64_BROWN	104.00 LF	36" (40 YEAR LTD PAINTED) 5-139.992",1-82.992",1-25.992", 1-76.992", 1-48.996", 1-15.996'	1.940 LF	201.76

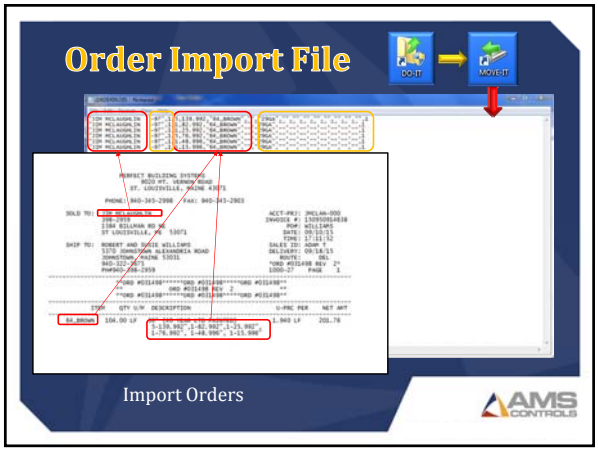
Import Orders

Custom Cut-List Program



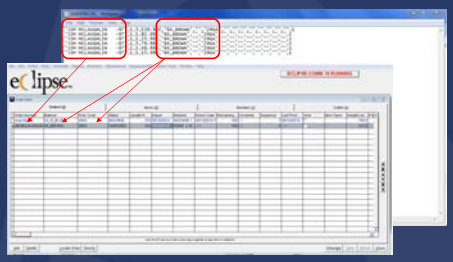
Order


Order Import File
DO-IT
MOVE-IT
Import Orders
AMS CONTROLS


Order Import File
DO-IT
MOVE-IT
Import Orders
AMS CONTROLS

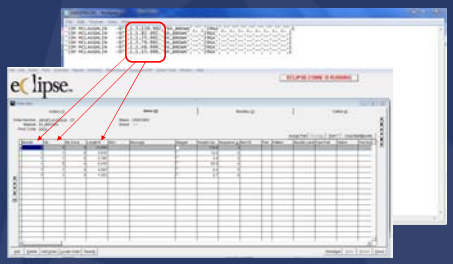

Order Import –Orderin.del File
ERP
Custom Export Program
DO-IT
MOVE-IT
Order
Eclipse
AMS CONTROLS

Order Import File



Import Orders

Order Import File



Import Orders

XL200 Controller

XL200-Controller

6 Important Functions of XL Series

- Machine Controller Basics
- Scrap Handling
- Downtime Handling
- Coil Changes
- The Part Queue
- Calibration

XL200-Controller Basics

Current Order Status
Order Information
Remaining Footage

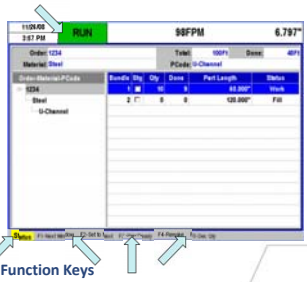
Order List
Order Number
Raw Material
Tooling

Cutlist
Bundle
Quantity
Length
Status

Navigation
Similar to "Windows Start" button.
Duplicates hotkey functions.

XL200-Controller Basics

Status – Current Date/Time, Machine Status, Line Speed, Length Past Shear



Menu-based Function Keys
Functions change based on current menu selection.

XL200-Controller Basics

Production *Flows*

XL200-Part Queue

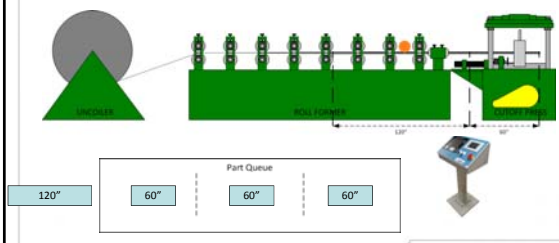
Shear-only Part Queue

Two versions of the Part Queue: Shear-only and Punching

The Part Queue is "dumped" when the line is halted

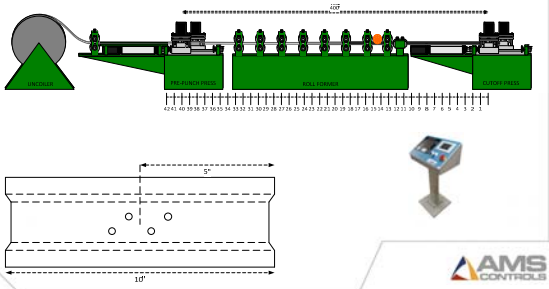
XL200-Part Queue

Shear-only Part Queue



XL200-Part Queue

Punching Part Queue

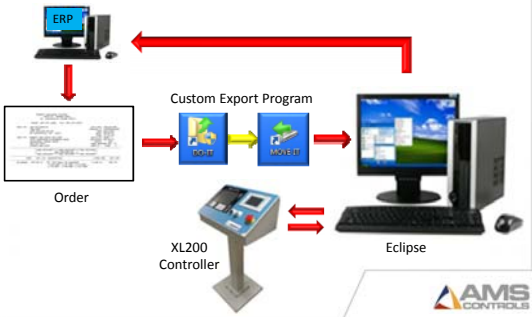


XL200-Length Calibration

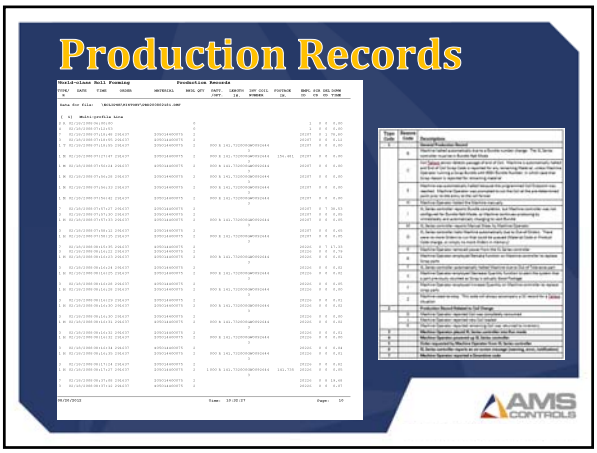
On-board Length Calibration

- Calibration corrects consistent error, *not* variance.
- Calibration is required due to encoder wheel measuring error.
- Operators enter length measured.
- Mind the queue!

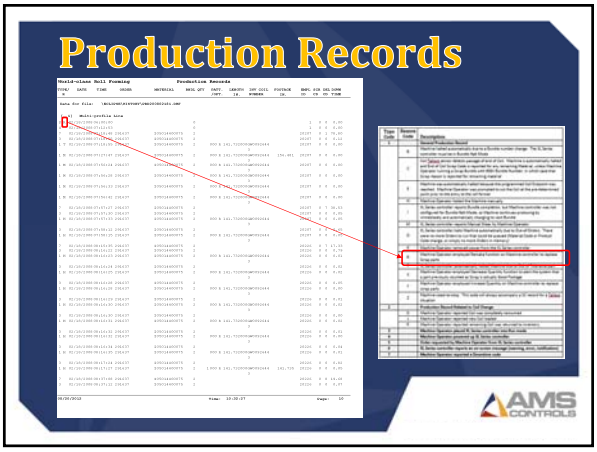
Production Records



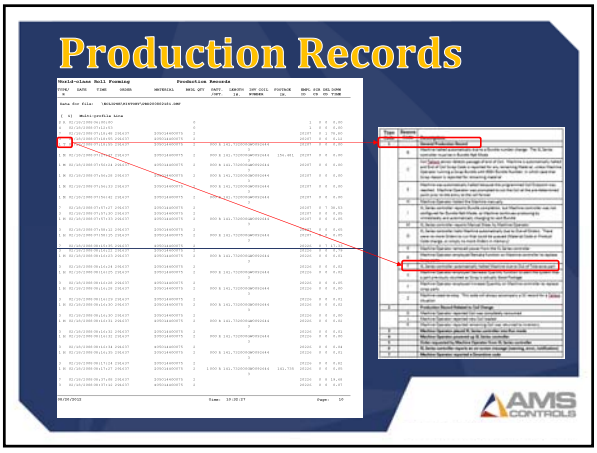
Production Records



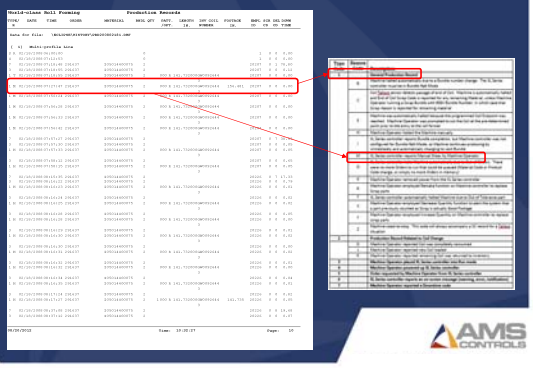
Production Records



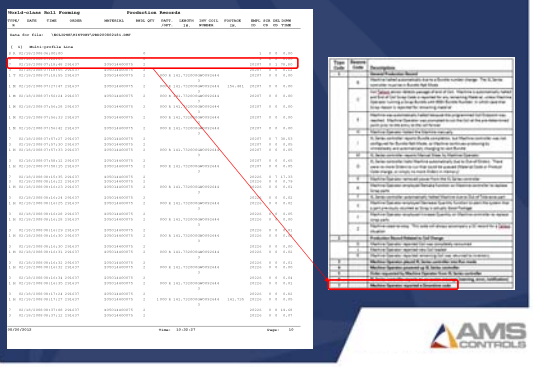
Production Records



Production Records



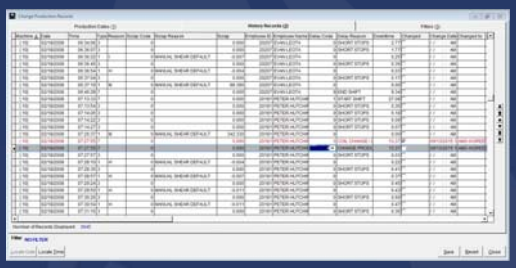
Production Records



Changed Production Records

Changed Production Records

Changed Production Records



Changed Production Records

Changed Production Records

Company Name goes here Changed Production Records

Changed Production Records Report

Mistake-Proofing Tools

Mistake-Proofing Tools

- Order & Part Data
- Coil Selection
- Machine Setup
- Data Collection

How Does Eclipse Help?

Mistake-proofing

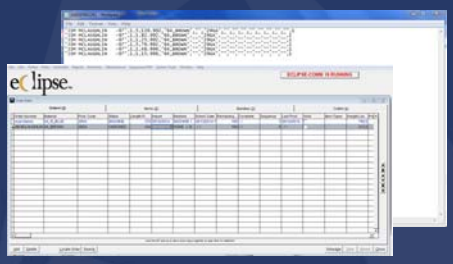
- No more data entry errors
- Automation can be used to ensure correct tooling is loaded
- Coil validation prevents incorrect material usage
- Bar codes prevent data entry mistakes throughout the process

Mistakes Happen!

- Wrong Order (Data entry)
  - 20 orders, 10 items each per day = 400 entries/day.
  - At 0.01% error rate, average 1 error every 25 days.
  - Trained data entry staff have 0.2-0.8% error rates (errors every 1.25 days or worse)
- Wrong punch pattern or profile
- Wrong coil
- Wrong machine

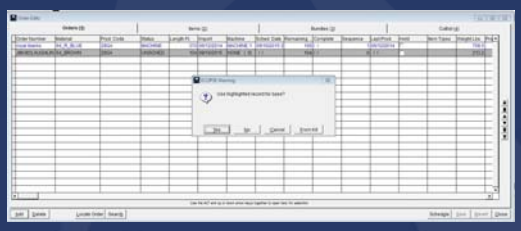
Wrong Orders & The Eclipse Solution

Order Data



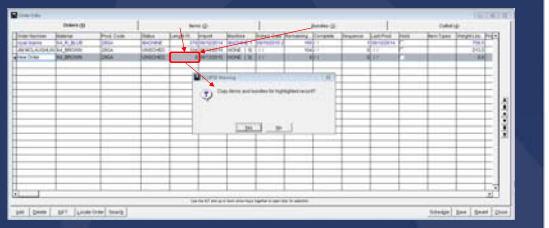
Import Orders

Order Data



Hand Keyed Orders

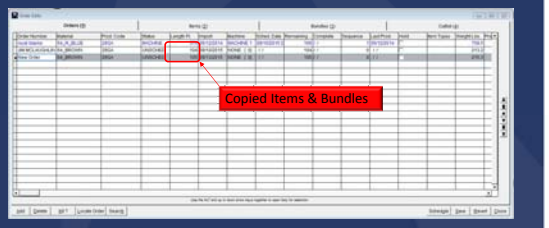
Order Data



Hand Keyed Orders

AMS CONTROLS

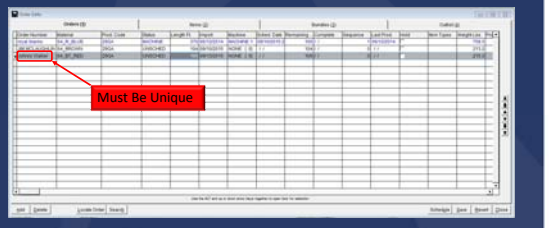
Order Data



Hand Keyed Orders

AMS CONTROLS

Order Data



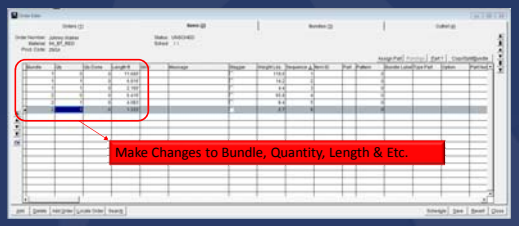
Hand Keyed Orders

AMS CONTROLS

Order Data

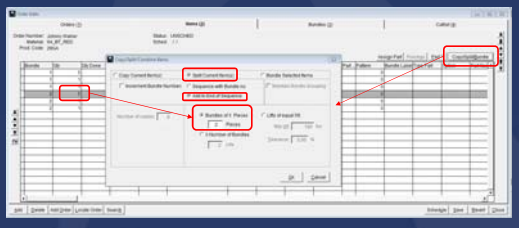
Hand Keyed Orders

Order Data



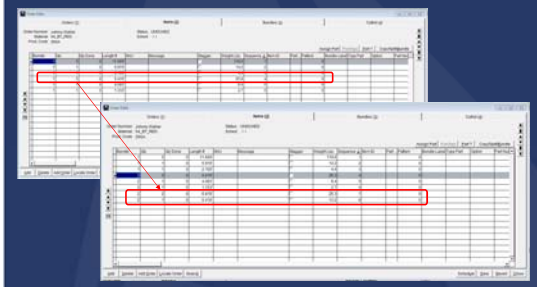
Hand Keyed Orders

Order Data



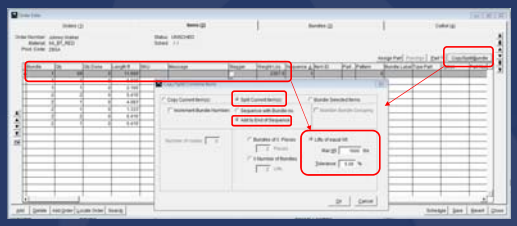
Copy Bundle Split Orders

Order Data



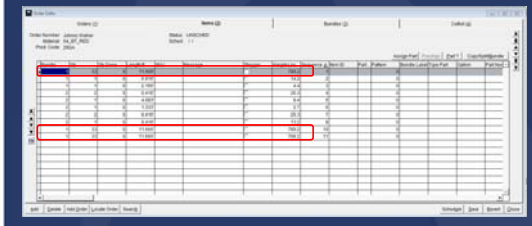
Copy Bundle Split Orders

Order Data



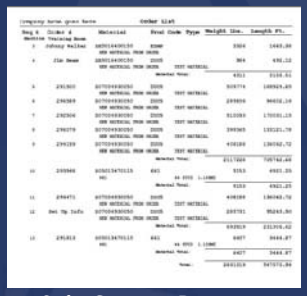
Copy Bundle Split Orders

Order Data



Copy Bundle Split Orders

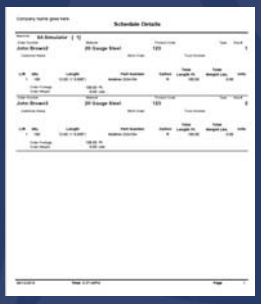
Order Data-Reports



Order Sequence Report

Forward Looking

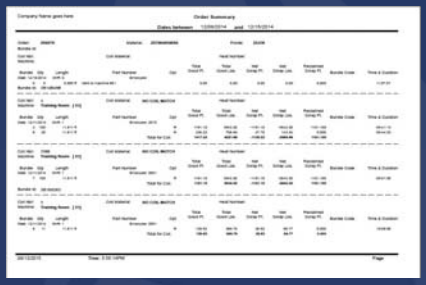
Order Data-Reports



Order Schedule Report

Forward Looking

Order Data-Reports

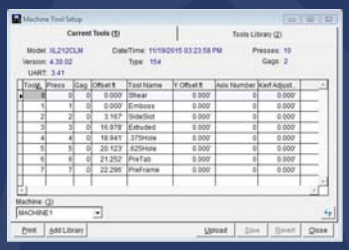


Order Summary Report

Looking in Past

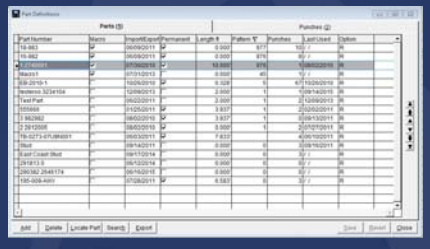
Wrong Part/Patterns & The Eclipse Solution

Part Data



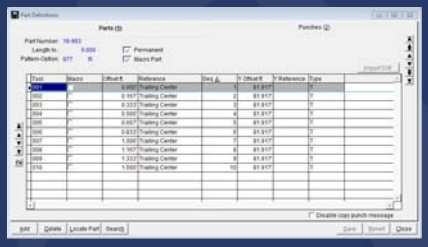
Tool Setup

Part Data



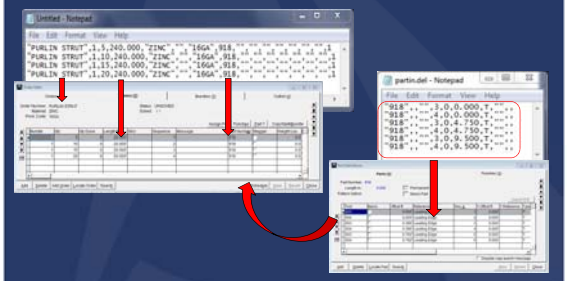
Part Definitions

Part Data



Part Definitions-Punches

Part Data-Import



Part Data-Import

Part Data-Eclipse

- Eclipse Manages the Pattern at the Controller
- Eclipse assigns the pattern #'s automatically
- Eclipse adds & deletes patterns (True/False)
- Part #'s up to 30 characters

Wrong Coil
&
The Eclipse Solution

How Does Eclipse Help?

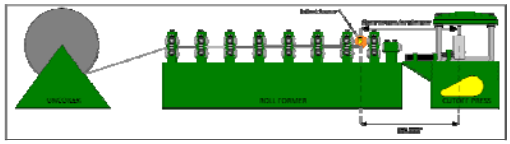
Perfect accounting & inventory control

- Exact coil inventories
  - Usage totals accurate to a fraction of an inch
  - No data logging errors if using bar-codes and coil ID validation
- Exact finished goods tracking
  - Know exactly what was produced in each bundle
  - Great tool for dealing with customer complaints
  - Traceability: what coil was used to produce each part

Coil-Validation

XL200 Controller Setup Screen

Coil-Validation



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Coil-Validation

AMS CONTROLS

Coil-Validation

AMS CONTROLS

Coil-Validation

Coil-Validation

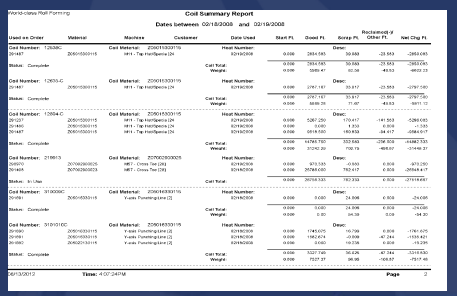
Coil-Validation

Coil-Validation

Coil-Inventory

Coil Inventory Tab

Coil Reports

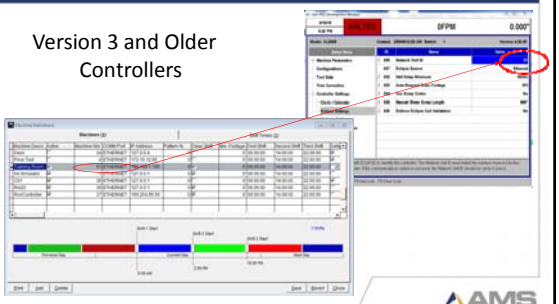


Coil Summary Report

Wrong Machine & The Eclipse Solution

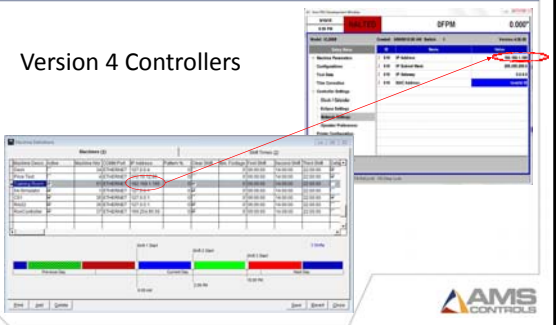
Machine Setup

Version 3 and Older Controllers

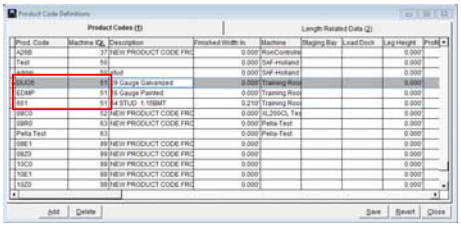


Machine Setup

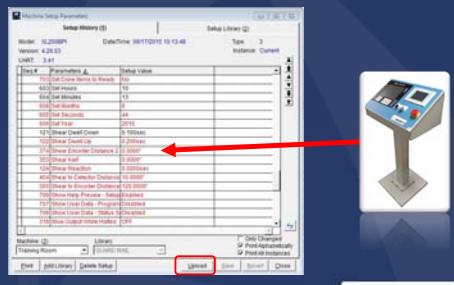
Version 4 Controllers



Machine Setup

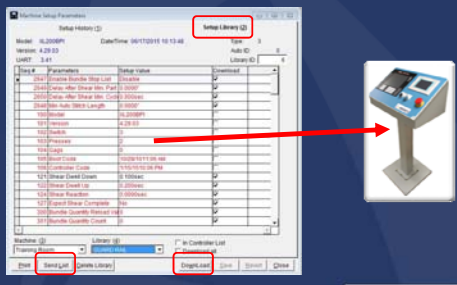


Machine Parameters



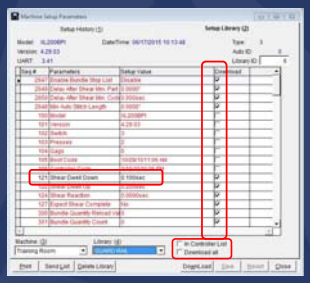
Maintenance Tab

Machine Parameters



Maintenance Tab

Machine Parameters



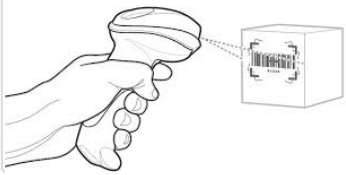
Maintenance Tab

Wrong Production Data & The Eclipse Solution

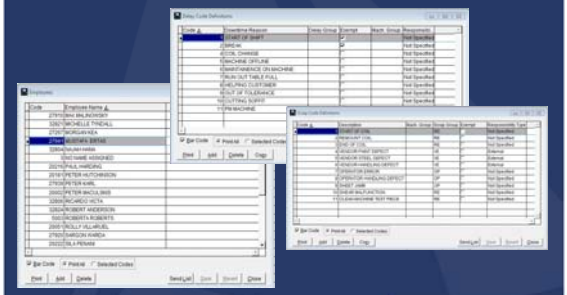
Data Collection

Barcode Scan

- Same effect as Increase Quantity, but includes the Scrap Reason
- Saves Machine Operator steps and avoids on-screen interface
- Reinforces use of barcode scanner for data input



Data Collection-Codes



Maintenance Tab

Data Collection-Codes

Maintanence Tab

Productivity & Profit Tools

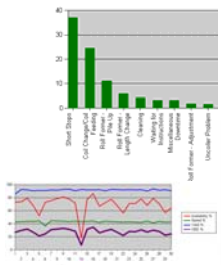
Productivity & Profit Tools

- Real-Time Metrics
- Productivity Tracking
- Scrap Tracking
- Downtime Tracking

How Does Eclipse Help?

Continuous Improvement

- Use Pareto charts to focus attention
- Correlate performance
- Use OEE and other metrics to monitor results & progress



How Does Eclipse Help?

Management focus and capital spending

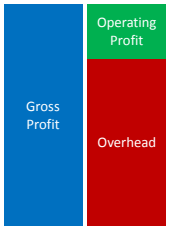
- Operator performance
- Supplier performance
- Equipment performance

Profit!

Goal: profit now and in the future

Simple model:

Gross Profit
- Overhead
Operating Profit



AMS CONTROLS

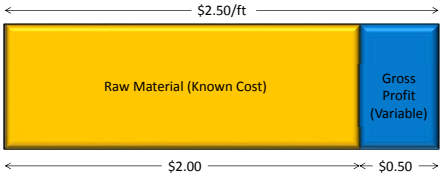
Gross Profit

South Park's-Business Model

AMS CONTROLS

Gross Profit

Gross Profit = Selling Price – Material Cost



AMS CONTROLS

Machine Speed vs. Throughput

Road trip: Chicago to St. Louis = 300 miles

AMS CONTROLS

Machine Speed vs. Throughput

Road trip: Chicago to St. Louis = 300 miles

Good news:
Bugatti Veyron

Speed = 265 mph
Trip time = 67 minutes!
Throughput = 265 mph

Bad news:
Potty-training toddler

Must stop every 45 mi.
Each stop = 20 min.
Trip time = 187 min.
Throughput = 96 mph

More bad news:
Antique-obsessed mother-in-law

Must stop at every flea market
@ 60 min. ea.
Trip time = 307 minutes
Throughput = 58 mph

AMS CONTROLS

Machine Speed vs. Throughput

Back to Roll Forming...

AMS CONTROLS

Machine Speed vs. Throughput

Back to Roll Forming…

Good news:
Flying shear
Speed = 135 fpm
Throughput = 135 fpm

Bad news:
20 Coil changes/shift
12 minutes/change
240 minutes downtime
Throughput = 58 fpm

More bad news:
2 Tooling changes/shift
35 minutes/change
310 minutes downtime
Throughput = 35 fpm

AMS CONTROLS

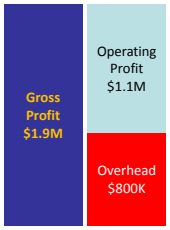
How Roll Formers Make Money

Production / day =
(420-310) * 135 = 14,850'

Gross profit / year =
14,850 * $0.50 * 250 = $1.9M

Overhead / year = $800K

Operating profit = $1.1M*



* Assuming you can sell all production

AMS CONTROLS

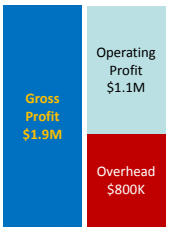
How Roll Formers Make Money

Almost…
Additional downtime from data entry, etc: 35 min.

Production / day =
(420 - 310 - 35) * 135 = 10,125'

Gross profit / year =
10,125 * $0.50 * 250 = $1.3M

Operating profit = $466K*



* Assuming you can sell all production

AMS CONTROLS

How Roll Formers Make Money

Not so fast…

Problems with stacker limit speed to 120 fpm

Production / day =
(420-345) * 120 = 9,000'

Gross profit / year =
9,000 * $0.50 * 250 = $1.1M

Operating profit = $325K*

* Assuming you can sell all production

How Roll Formers Make Money

Oh, Scrap!

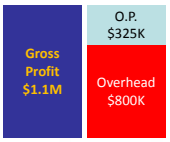
2% of parts have a problem and you scrap 10' per coil change

Production/day = (420-345)*120*98% = 8,820'

Gross profit/year =
8,820 * $0.50 * 250 – (180+200) * $2.00 = $914K

Operating profit = $114K**

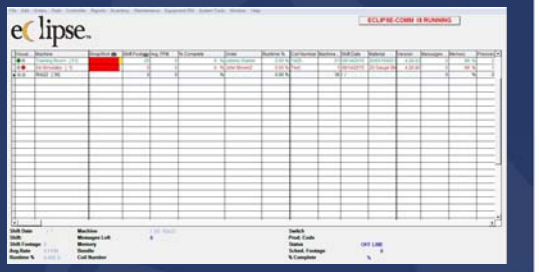
**** Assuming you don't ship any bad product to a customer!***



* Assuming you can sell all production

Real-Time Metrics

Real-Time Metrics



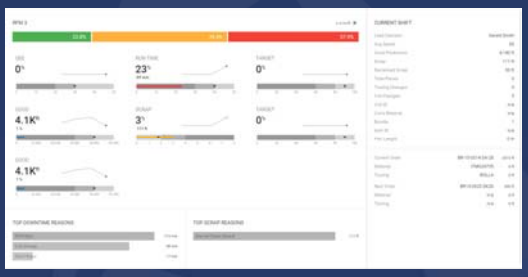
AMS CONTROLS

Real-Time Metrics

Eclipse Pro View with Premium Support

AMS CONTROLS

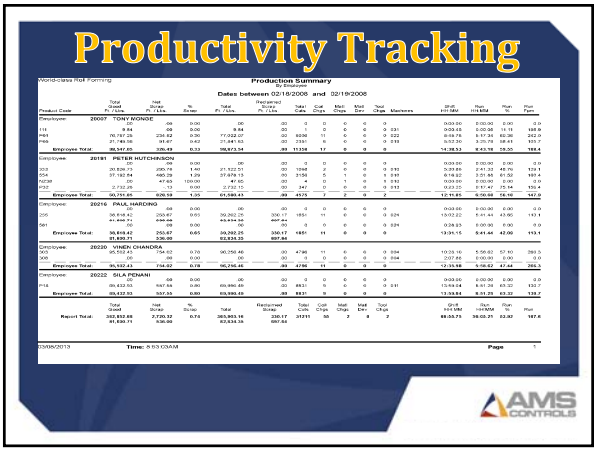
Real-Time Metrics

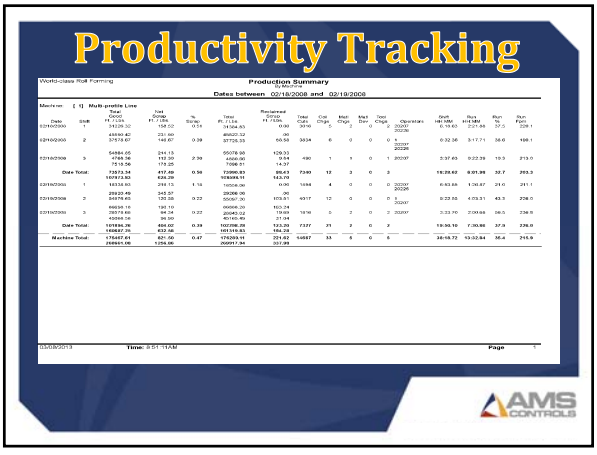


Eclipse Pro View with Premium Support

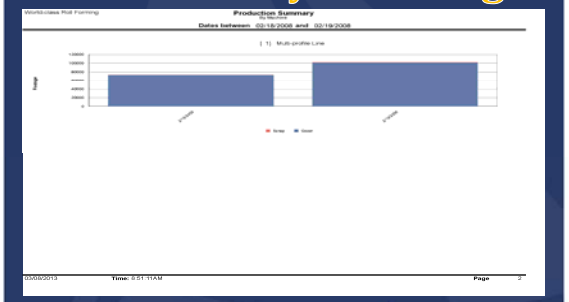
AMS CONTROLS

Productivity Tracking

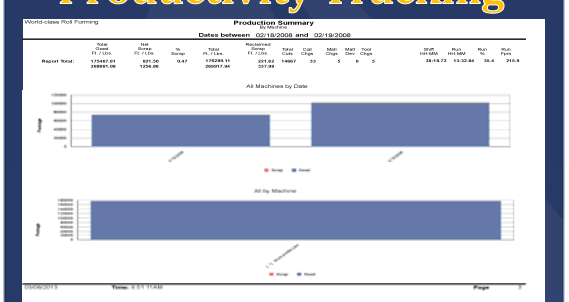




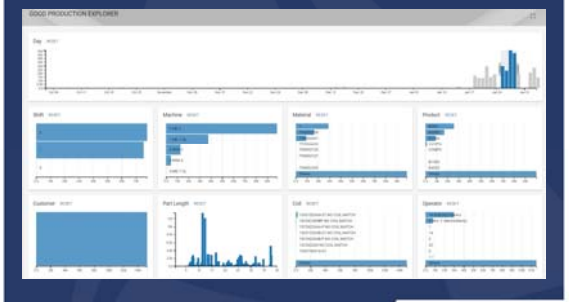
Productivity Tracking



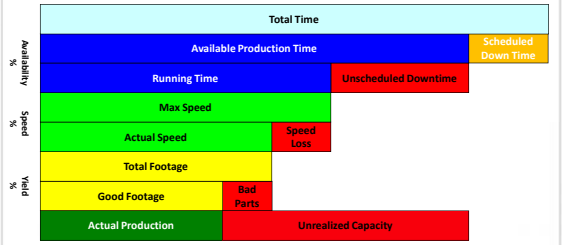
Productivity Tracking



Productivity Tracking



OEE – Overall Equipment Effectiveness



= Good Production / (Available Production Time * Max speed)

OEE = Availability * Speed * Yield

OEE – Overall Equipment Effectiveness

OEE = 18% * 88% * 98% = 15.6%

Scrap Tracking

How Does Eclipse Help?

Less Waste

- Minimize scrap
  - Optimize production schedule
  - Optimize cutting patterns for slitters or shears
  - Mistake-proofing!
  - Knowing causes leads to fixes

Scrap Handling

4 Methods of handling Scrap pieces:

- Increase Quantity
- Remake
- Hand-keyed "900" bundle
- Barcode Scan "on-the-fly"

Scrap Handling

Increase Quantity:

- Used for small quantities (1 – 2 pieces at a time)
- Cutlist item cannot have a status of "DONE"
- Can be used "on-the-fly" in most applications
- Parts produced this way are counted as Scrap
- Operators must be careful around Bundle and Order transitions

Scrap Handling

Remake:

- Used for large quantities or when an item is "DONE"
- Cannot be used "on-the-fly"
- Parts produced this way are always counted as Scrap
- Parts are not counted as Scrap until they are produced

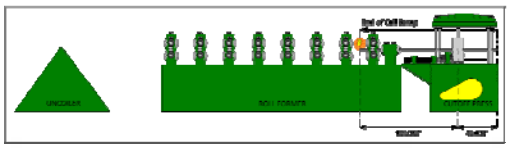
Scrap Handling

900 Bundle Number – For when you KNOW you're making Scrap!

- Any bundle with a 900+ number is automatically counted as Scrap
- The last 2 digits carry the Scrap Code
- Used by Machine Operators to handle large quantities of Scrap
  - The current coil has a large section of defective material
  - The Machine Operator or Setup Man is working on a tooling setup or problem that will clearly generate a lot of Scrap in the process of forming a good part

Scrap Handling

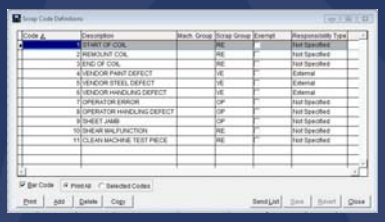
Decrease Quantity is used to recover good product from something previously counted as scrap. It subtracts from the Scrap total and adds length back to the Good total.



Scrap Handling

XL200 Controller Setup Screen

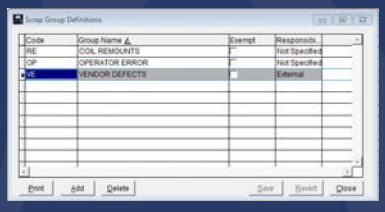
Scrap Codes



If Bundles are set to zero-Scrap is sent to general scrap file

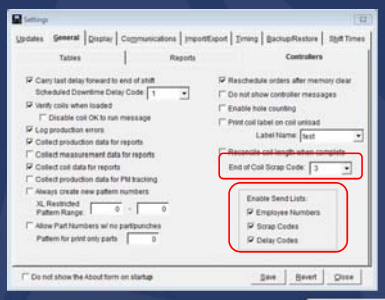
Maintanence Tab

Scrap Codes-Groups



Maintanence Tab

Scrap Codes

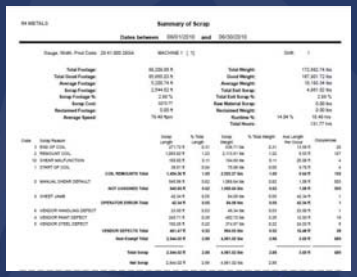


Settings Tab

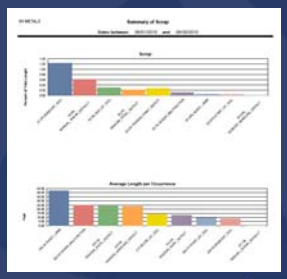
Scrap Codes

Maintanence Tab

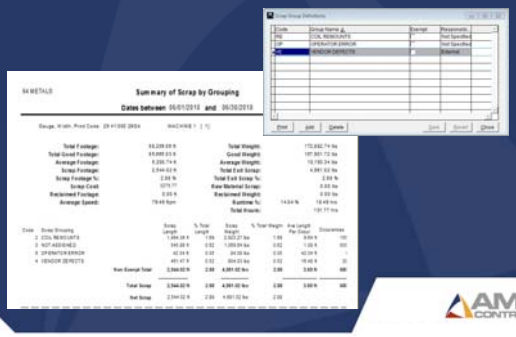
Scrap Reports



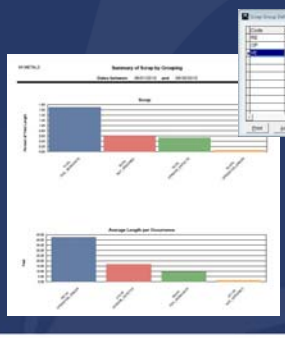
Scrap Reports



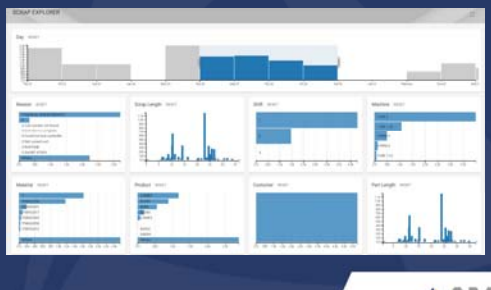
Scrap Groups Report



Scrap Group Report



Scrap Reports



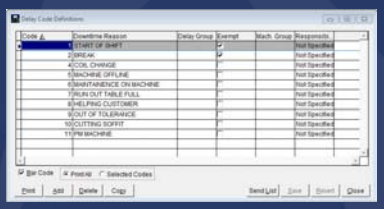
Downtime Tracking

How Does Eclipse Help?

More Capacity

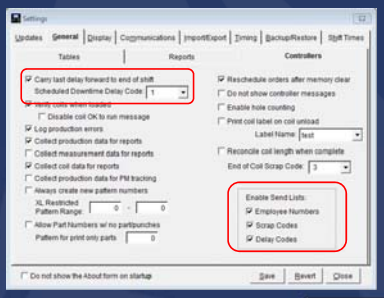
- Eliminate downtime
  - Data entry
  - Coil and production logging
  - Waiting for coils to arrive or finished goods to be removed
  - Coordinate help to minimize changeover time

Downtime Tracking



Maintanence Tab

Downtime Tracking

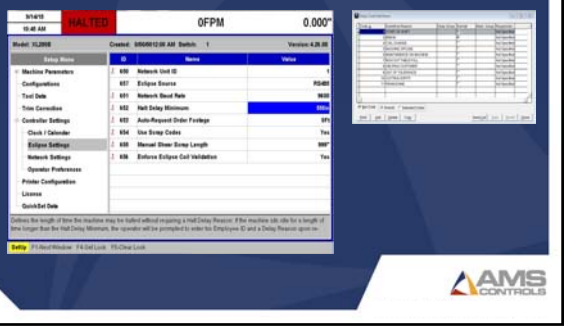


Settings Tab

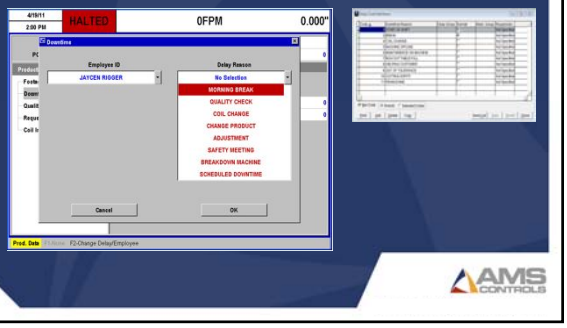
Downtime Tracking

Maintanence Tab

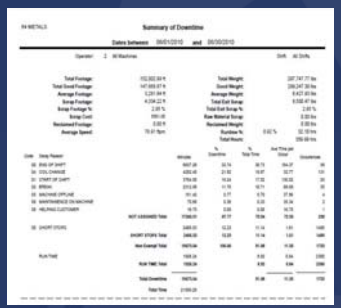
Downtime Tracking



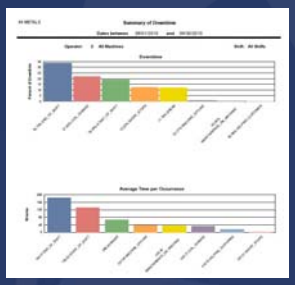
Downtime Tracking

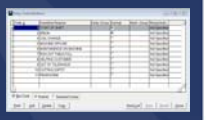


Downtime Report

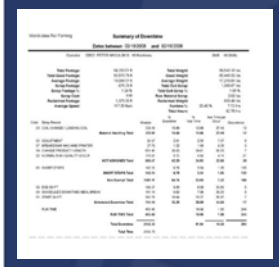


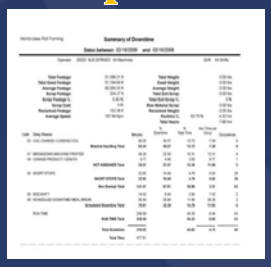
Downtime Report





Downtime Report





Downtime Report

Downtime Report

Operational Tools

Operational Tools

- Production Scheduling
- Order Queries
- Operator Messages
- Bundle & Part Printing

How Does Eclipse Help?

Flexibility

- Schedule
- Bundling
- Custom punching or profiles
- Bundle labeling and part marking

How Does Eclipse Help?

On-time deliveries

- Predict completions
- Smarter scheduling
- No “local optimization” by operator
- Fewer “fires” caused by mistakes
- Instantly detect material shortages

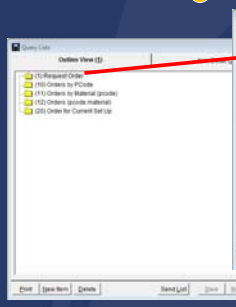
Production Scheduling

Production Scheduling

Orders deleted at the Controller will be set as Unscheduled in Eclipse

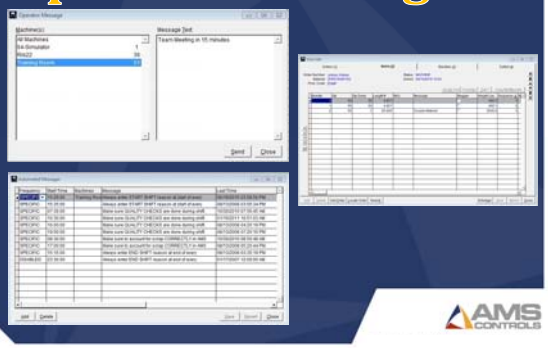
Order Queries

Order Queries



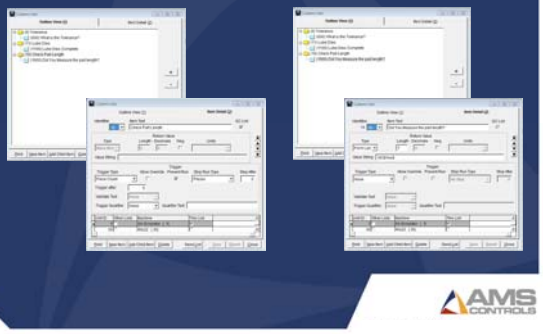
Operator Messages

Operator Messages



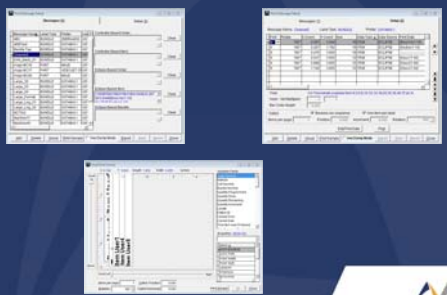
Quality Audits

Quality Audits



Bundle Tag/Part Printing

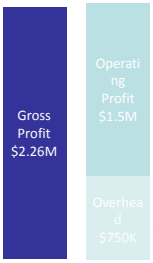
Bundle Tag/Part Printing



Let's Make More Money!

After implementing Eclipse…

1. No more data entry downtime
2. Fewer customer complaints & "yield loss"
3. Dialog with operators gets the stacker fixed
4. Smart capital spending on coil handling
5. OEE improves from 15.6% to 36%
6. Operating profit increase from $114K to $1.5M



AMS CONTROLS

Sample Reports

12180 Prichard Farm Rd., Maryland Heights, MO 63043
800.334.5213 – 314.344.3144
training@amscontrols.com - www.amscontrols.com

Order Summary

Dates between 02/18/2008 and 02/18/2008

Order: **291124** Material: **Z05015400070** Pcode: **506**
Bundle Id:

Coil Nbr: Coil Material: Heat Number:
Machine:

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 0		Employee:									
0	0	0.000 in	Start on machine #31		0.00	0.00	0.00	0.00	0.000		16:30:13	0.00
0	0	0.000 in	DONE machine #31		0.00	0.00	0.00	0.00	0.000		18:04:24	0.00
			Total for Coil:		**0.00**	**0.00**	**0.00**	**0.00**	**0.000**			**0.00**

Coil Nbr: **GW00855061** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 2		Employee: TROY PAGETT									
19	36	144.488 in		R	433.46	0.00	19.66	0.00	0.000		16:29:43	1.94
20	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:36:34	5.19
21	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:44:18	5.13
22	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:49:24	5.10
23	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:54:30	5.10
24	86	144.488 in		R	1035.50	0.00	9.61	0.00	0.000		16:58:55	4.42
			Total for Coil:		**6285.23**	**0.00**	**29.25**	**0.00**	**0.000**			**26.88**

Coil Nbr: **GW00855062** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 2		Employee: TROY PAGETT									
14	57	144.488 in		R	686.32	0.00	0.00	0.00	0.000		15:54:59	3.11
15	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:01:11	5.31
16	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:11:15	5.22
17	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:16:27	5.20
18	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		16:21:38	5.18
19	64	144.488 in		R	770.60	0.00	10.75	0.00	0.000		16:24:59	3.35
			Total for Coil:		**6273.19**	**0.00**	**10.73**	**0.00**	**0.000**			**27.37**

Order Summary

Dates between 02/18/2008 and 02/18/2008

Order: **291124** Material: **Z05015400070** Pcode: **506** *** Continued ***

Coil Nbr: **GW00855065** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 2		Employee: TROY PAGETT									
30	84	144.488 in		R	1011.42	0.00	0.00	0.00	0.000		17:51:28	4.39
			Total for Coil:		**1011.42**	**0.00**	**0.00**	**0.00**	**0.000**			**4.39**

Coil Nbr: **GW00855070** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 2		Employee: TROY PAGETT									
24	14	144.488 in		R	168.57	0.00	0.00	0.00	0.000		17:08:07	0.77
25	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		17:11:44	5.13
26	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		17:20:12	5.15
27	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		17:31:57	5.10
28	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		17:37:04	5.12
29	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		17:42:10	5.10
30	16	144.488 in		R	192.65	0.00	-99.73	0.00	108.366		17:42:34	0.40
			Total for Coil:		**6381.55**	**0.00**	**-99.75**	**0.00**	**108.366**			**26.77**

Coil Nbr: **GW00953005** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 1		Employee: DENNIS SANTIAGO									
1	72	144.488 in		R	866.93	0.00	-143.44	0.00	144.488		13:36:22	3.26
			Total for Coil:		**866.93**	**0.00**	**-143.44**	**0.00**	**144.488**			**3.26**

Order Summary

Dates between 02/18/2008 and 02/18/2008

Order: **291124** Material: **Z05015400070** Pcode: **506** *** Continued ***

Coil Nbr: **GW00956535** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 1		Employee: DENNIS SANTIAGO									
5	48	144.488 in		R	577.95	0.00	22.70	0.00	0.000		14:28:39	2.57
6	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:32:48	5.35
7	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:42:50	5.31
8	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:48:08	5.30
9	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:53:26	5.30
10	62	144.488 in		R	746.52	0.00	1.39	0.00	0.000		14:53:53	3.33
			Total for Coil:		**6140.74**	**0.00**	**24.07**	**0.00**	**0.000**			**27.16**

Coil Nbr: **GW00956596** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 1		Employee: DENNIS SANTIAGO									
10	38	144.488 in		R	457.55	0.00	0.00	0.00	0.000		15:11:50	2.05
11	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		15:17:09	5.32
12	72	144.488 in		R	866.93	0.00	0.00	0.00	0.000		15:20:59	3.83
12	28	144.488 in		R	337.14	0.00	0.00	0.00	0.000		15:30:40	1.55
13	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		15:35:37	5.33
14	43	144.488 in		R	517.75	0.00	3.26	0.00	0.000		15:42:38	2.30
			Total for Coil:		**4587.49**	**0.00**	**3.24**	**0.00**	**0.000**			**20.38**

Coil Nbr: **GW00956598** Coil Material: Heat Number:
Machine: **[31] None**

Bundle	Qty	Length	Part Number	Opt	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Bundle Code	Time & Duration	(min.)
Date: 02/18/2008	Shift: 1		Employee: DENNIS SANTIAGO									
1	28	144.488 in		R	337.14	0.00	22.53	0.00	0.000		14:00:53	1.52
2	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:08:03	5.30
3	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:13:22	5.32
4	100	144.488 in		R	1204.07	0.00	0.00	0.00	0.000		14:18:29	5.31
5	52	144.488 in		R	626.11	0.00	2.85	0.00	0.000		14:21:50	2.78
			Total for Coil:		**4575.45**	**0.00**	**25.36**	**0.00**	**0.000**			**20.23**
			Total for Order:		**36122.00**	**0.00**	**-150.54**	**0.00**	**252.854**			**156.44**

Order Summary

Dates between 02/18/2008 and 02/18/2008

	Total Good Ft.	Total Good Lbs.	Net Scrap Ft.	Net Scrap Lbs.	Reclaimed Scrap Ft.	Time (min.)
Report Total:	**36122.00**	**0.00**	**-150.54**	**0.00**	**252.854**	**156.44**

Report Criteria:

Filter: Production Dates = 02/18/2008 1:02/18/2008 2:02/18/2008 3:
Order Number = :291124:

Notes

Coil Summary Report

Dates between 02/18/2008 and 02/19/2008

Used on Order	Material	Machine	Customer	Date Used	Start Ft.	Good Ft.	Scrap Ft.	Reclaimed(-)/ Other Ft.	Net Chg Ft.
Coil Number: 12538C		**Coil Material:** Z05015300115		**Heat Number:**			**Desc:**		
291487	Z05015300115	M11 - Top Hat/Specia [24		02/19/2008	0.000	2834.583	39.083	-23.583	-2850.083
Status: Complete				**Coil Total:**	0.000	2834.583	39.083	-23.583	-2850.083
				Weight:	0.000	5989.47	82.58	-49.83	-6022.23
Coil Number: 12635-C		**Coil Material:** Z05015300115		**Heat Number:**			**Desc:**		
291487	Z05015300115	M11 - Top Hat/Specia [24		02/19/2008	0.000	2787.167	33.917	-23.583	-2797.500
Status: Complete				**Coil Total:**	0.000	2787.167	33.917	-23.583	-2797.500
				Weight:	0.000	5889.28	71.67	-49.83	-5911.12
Coil Number: 12894-C		**Coil Material:** Z05015300115		**Heat Number:**			**Desc:**		
291237	Z05015300115	M11 - Top Hat/Specia [24		02/19/2008	0.000	5267.250	170.417	-141.583	-5296.083
291486	Z05015300115	M11 - Top Hat/Specia [24		02/19/2008	0.000	0.000	1.333	0.000	-1.333
291487	Z05015300115	M11 - Top Hat/Specia [24		02/19/2008	0.000	9518.500	160.833	-94.417	-9584.917
Status: Complete				**Coil Total:**	0.000	14786.750	332.583	-236.000	-14882.333
				Weight:	0.000	31242.29	702.75	-498.67	-31446.37
Coil Number: 219913		**Coil Material:** Z07002900025		**Heat Number:**			**Desc:**		
290970	Z07002900025	M57 - Cross Tee [28]		02/19/2008	0.000	970.333	-0.083	0.000	-970.250
291408	Z07002900023	M57 - Cross Tee [28]		02/18/2008	0.000	25786.000	762.417	0.000	-26548.417
Status: In Use				**Coil Total:**	0.000	26756.333	762.333	0.000	-27518.667
Coil Number: 310009C		**Coil Material:** Z05016330115		**Heat Number:**			**Desc:**		
291691	Z05016330115	Y-axis Punching Line [2]		02/18/2008	0.000	0.000	24.006	0.000	-24.006
Status: Complete				**Coil Total:**	0.000	0.000	24.006	0.000	-24.006
				Weight:	0.000	0.00	54.30	0.00	-54.30
Coil Number: 3101010C		**Coil Material:** Z05016330115		**Heat Number:**			**Desc:**		
291690	Z05016330115	Y-axis Punching Line [2]		02/18/2008	0.000	1745.075	16.799	0.000	-1761.875
291691	Z05016330115	Y-axis Punching Line [2]		02/18/2008	0.000	1582.674	-0.009	-47.244	-1535.421
291692	Z05022130115	Y-axis Punching Line [2]		02/18/2008	0.000	0.000	19.235	0.000	-19.235
Status: Complete				**Coil Total:**	0.000	3327.749	36.025	-47.244	-3316.530
				Weight:	0.000	7527.37	96.95	-106.87	-7517.46

Notes

Production Summary

By Employee

Dates between 02/18/2008 and 02/19/2008

Product Code	Total Good Ft. / Lbs.	Net Scrap Ft. / Lbs.	% Scrap	Total Ft. / Lbs.	Reclaimed Scrap Ft. / Lbs.	Total Cuts	Coil Chgs	Matl Chgs	Matl Dev	Tool Chgs	Machines	Shift HH:MM	Run HH:MM	Run %	Run Fpm
Employee: **20007 TONY MONGE**															
	.00	.00	0.00	.00	.00	0	0	0	0	0		0:00.00	0:00.00	0.00	0.0
111	9.84	.00	0.00	9.84	.00	1	0	0	0	0	031	0:00.45	0:00.05	11.11	196.9
P01	76,787.25	234.82	0.30	77,022.07	.00	9006	11	0	0	0	022	8:45.78	5:17.34	60.36	242.0
P05	21,749.96	91.67	0.42	21,841.63	.00	2351	6	0	0	0	019	5:52.30	3:25.79	58.41	105.7
Employee Total:	**98,547.05**	**326.49**	**0.33**	**98,873.54**	**.00**	**11358**	**17**	**0**	**0**	**0**		**14:38.53**	**8:43.18**	**59.55**	**188.4**
Employee: **20181 PETER HUTCHINSON**															
	.00	.00	0.00	.00	.00	0	0	0	0	0		0:00.00	0:00.00	0.00	0.0
333	20,826.73	295.78	1.40	21,122.51	.00	1068	2	0	0	0	010	5:30.88	2:41.33	48.76	129.1
554	37,192.84	485.29	1.29	37,678.13	.00	3156	5	1	0	1	010	6:16.92	3:51.88	61.52	160.4
NZ38	.00	47.65	100.00	47.65	.00	4	0	1	0	1	010	0:00.00	0:00.00	0.00	0.0
P32	2,732.28	-.13	0.00	2,732.15	.00	347	0	0	0	0	013	0:23.25	0:17.47	75.14	156.4
Employee Total:	**60,751.85**	**828.59**	**1.35**	**61,580.43**	**.00**	**4575**	**7**	**2**	**0**	**2**		**12:11.05**	**6:50.68**	**56.18**	**147.9**
Employee: **20216 PAUL HARDING**															
	.00	.00	0.00	.00	.00	0	0	0	0	0		0:00.00	0:00.00	0.00	0.0
255	38,618.42	253.67	0.65	39,202.25	330.17	1651	11	0	0	0	024	13:02.22	5:41.44	43.65	113.1
	81,600.71	536.00		82,834.35	697.64										
581	.00	.00	0.00	.00	.00	0	0	0	0	0	024	0:28.93	0:00.00	0.00	0.0
Employee Total:	**38,618.42**	**253.67**	**0.65**	**39,202.25**	**330.17**	**1651**	**11**	**0**	**0**	**0**		**13:31.15**	**5:41.44**	**42.09**	**113.1**
	81,600.71	**536.00**		**82,834.35**	**697.64**										
Employee: **20220 VINEN CHANDRA**															
303	95,502.43	754.02	0.78	96,256.46	.00	4796	11	0	0	0	004	10:28.10	5:58.62	57.10	266.3
308	.00	.00	0.00	.00	.00	0	0	0	0	0	004	2:07.88	0:00.00	0.00	0.0
Employee Total:	**95,502.43**	**754.02**	**0.78**	**96,256.46**	**.00**	**4796**	**11**	**0**	**0**	**0**		**12:35.98**	**5:58.62**	**47.44**	**266.3**
Employee: **20222 SILA PENANI**															
	.00	.00	0.00	.00	.00	0	0	0	0	0		0:00.00	0:00.00	0.00	0.0
P18	69,432.93	557.55	0.80	69,990.49	.00	8831	9	0	0	0	011	13:59.04	8:51.29	63.32	130.7
Employee Total:	**69,432.93**	**557.55**	**0.80**	**69,990.49**	**.00**	**8831**	**9**	**0**	**0**	**0**		**13:59.04**	**8:51.29**	**63.32**	**130.7**

	Total Good	Net Scrap	% Scrap	Total	Reclaimed Scrap	Total Cuts	Coil Chgs	Matl Chgs	Matl Dev	Tool Chgs	Shift HH:MM	Run HH:MM	Run %	Run
Report Total:	**362,852.68**	**2,720.32**	**0.74**	**365,903.16**	**330.17**	**31211**	**55**	**2**	**0**	**2**	**66:55.75**	**36:05.21**	**53.92**	**167.6**
	81,600.71	**536.00**		**82,834.35**	**697.64**									

Production Summary

By Employee

Dates between 02/18/2008 and 02/19/2008

Product Code	Total Good Ft. / Lbs.	Net Scrap Ft. / Lbs.	% Scrap	Total Ft. / Lbs.	Reclaimed Scrap Ft. / Lbs.	Total Cuts	Coil Chgs	Matl Chgs	Matl Dev	Tool Chgs	Machines	Shift HH:MM	Run HH:MM	Run %	Run Fpm

Report Criteria:

Filter: Production Dates = 02/18/2008 1:02/18/2008 2:02/18/2008 3:02/19/2008 1:02/19/2008 2:02/19/2008 3:
Employee ID = :0020181:0020007:0020216:0020220:0020222:

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Notes

Production Summary
By Machine

Dates between 02/18/2008 and 02/19/2008

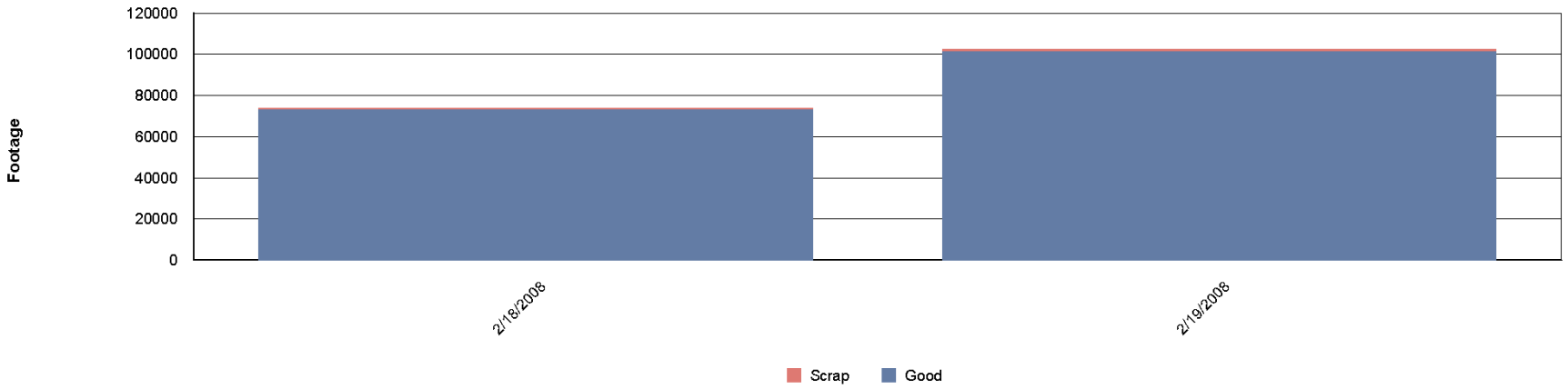
Machine: **[1] Multi-profile Line**

Date	Shift	Total Good Ft. / Lbs.	Net Scrap Ft. / Lbs.	% Scrap	Total Ft. / Lbs.	Reclaimed Scrap Ft. / Lbs.	Total Cuts	Coil Chgs	Matl Chgs	Matl Dev	Tool Chgs	Operators	Shift HH:MM	Run HH:MM	Run %	Run Fpm
02/18/2008	1	31226.32	158.52	0.51	31384.83	0.00	3016	5	2	0	2	20207 20226	6:18.63	2:21.88	37.5	220.1
		45590.42	231.90		45822.32	.00										
02/18/2008	2	37578.67	146.67	0.39	37725.33	88.58	3834	6	0	0	0	1 20207 20226	8:32.36	3:17.71	38.6	190.1
		54864.85	214.13		55078.98	129.33										
02/18/2008	3	4768.36	112.30	2.30	4880.66	9.64	490	1	1	0	1	20207	3:37.63	0:22.39	10.3	213.0
		7518.56	178.25		7696.81	14.37										
Date Total:		**73573.34**	**417.49**	**0.56**	**73990.83**	**98.43**	**7340**	**12**	**3**	**0**	**3**		**18:28.62**	**6:01.98**	**32.7**	**203.3**
		107973.83	**624.29**		**108598.11**	**143.70**										
02/19/2008	1	18338.93	219.13	1.18	18558.06	0.00	1494	4	0	0	0	20207 20226	6:53.85	1:26.87	21.0	211.1
		28920.49	345.57		29266.06	.00										
02/19/2008	2	54976.65	120.55	0.22	55097.20	103.51	4017	12	0	0	0	1 20207	9:22.55	4:03.31	43.3	226.0
		86698.18	190.10		86888.28	163.24										
02/19/2008	3	28578.68	64.34	0.22	28643.02	19.69	1816	5	2	0	2	20207	3:33.70	2:00.68	56.5	236.8
		45068.58	96.90		45165.49	31.04										
Date Total:		**101894.26**	**404.02**	**0.39**	**102298.28**	**123.20**	**7327**	**21**	**2**	**0**	**2**		**19:50.10**	**7:30.86**	**37.9**	**226.0**
		160687.25	**632.58**		**161319.83**	**194.28**										
Machine Total:		**175467.61**	**821.50**	**0.47**	**176289.11**	**221.62**	**14667**	**33**	**5**	**0**	**5**		**38:18.72**	**13:32.84**	**35.4**	**215.9**
		268661.08	**1256.86**		**269917.94**	**337.98**										

Production Summary
By Machine

Dates between 02/18/2008 **and** 02/19/2008

[1] Multi-profile Line



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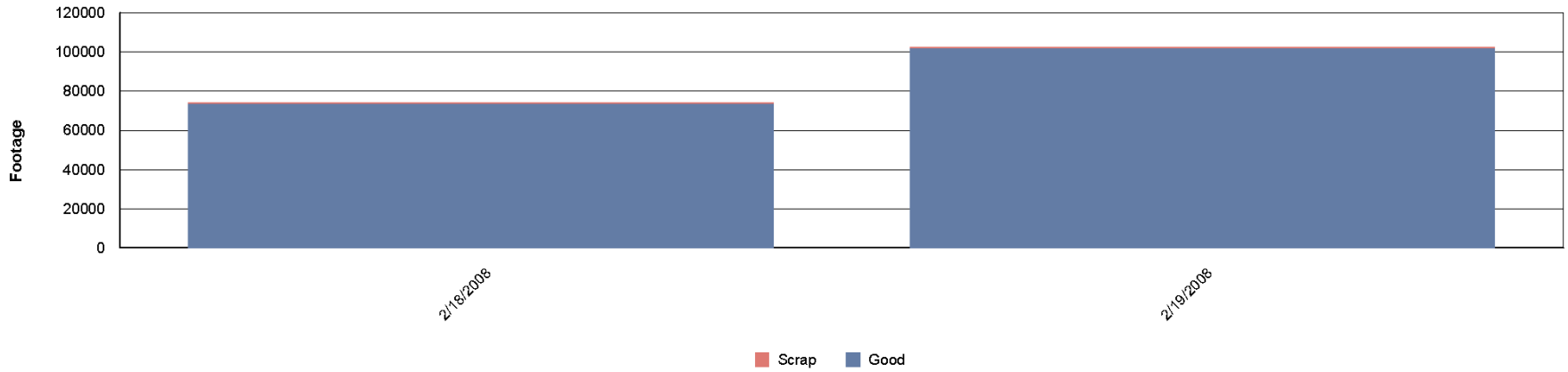
Production Summary
By Machine

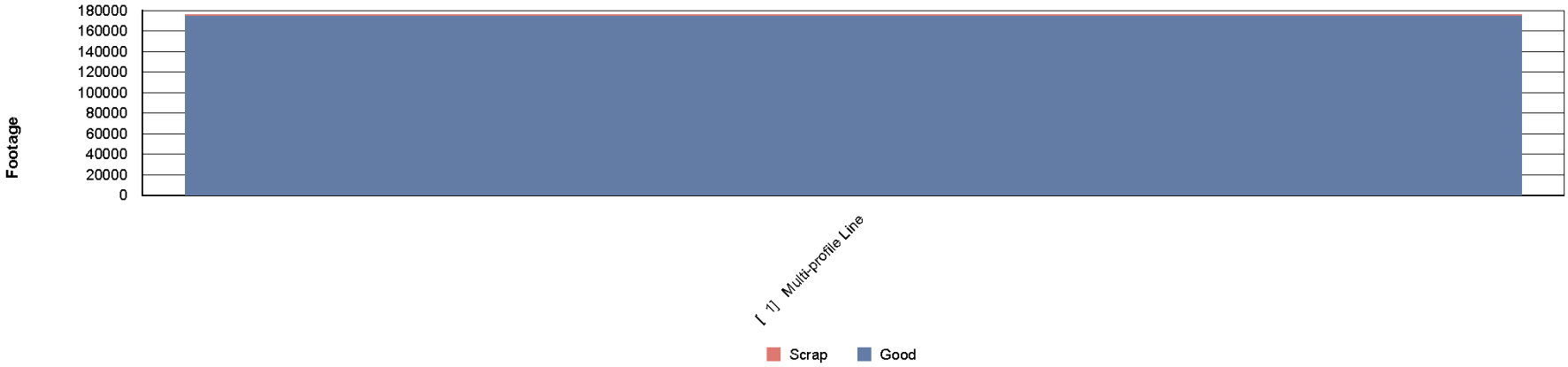
Dates between 02/18/2008 **and** 02/19/2008

	Total Good Ft. / Lbs.	Net Scrap Ft. / Lbs.	% Scrap	Total Ft. / Lbs.	Reclaimed Scrap Ft. / Lbs.	Total Cuts	Coil Chgs	Matl Chgs	Matl Dev	Tool Chgs	Shift HH:MM	Run HH:MM	Run %	Run Fpm
Report Total:	**175467.61**	**821.50**	**0.47**	**176289.11**	**221.62**	**14667**	**33**	**5**	**0**	**5**	**38:18.72**	**13:32.84**	**35.4**	**215.9**
	268661.08	**1256.86**		**269917.94**	**337.98**									

All Machines by Date



All by Machine



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Production Summary
By Machine

Dates between 02/18/2008 **and** 02/19/2008

Report Criteria:

Filter: Production Dates = 02/18/2008 1:02/18/2008 2:02/18/2008 3:02/19/2008 1:02/19/2008 2:02/19/2008 3:
Machine = :[1] Multi-profile Line:

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Notes

64 METALS

Summary of Scrap

Dates between 06/01/2010 **and** 06/30/2010

Gauge, Width, Prod Code: 29 41.000 29GA MACHINE 1 [1] Shift: 1

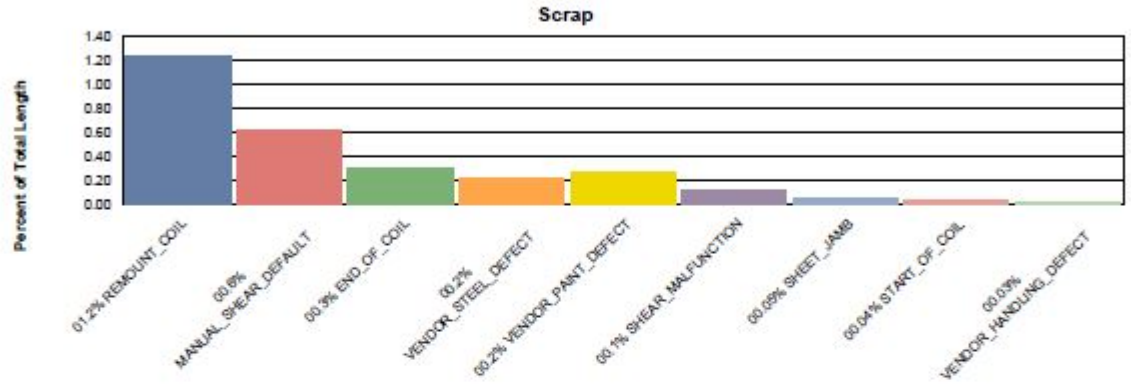
Total Footage:	88,209.06 ft	**Total Weight:**	172,882.74 lbs
Total Good Footage:	85,665.03 ft	**Good Weight:**	167,901.72 lbs
Average Footage:	5,200.74 ft	**Average Weight:**	10,193.34 lbs
Scrap Footage:	2,544.02 ft	**Total Exit Scrap:**	4,981.02 lbs
Scrap Footage %:	2.88 %	**Total Exit Scrap %:**	2.88 %
Scrap Cost:	3275.77	**Raw Material Scrap:**	0.00 lbs
Reclaimed Footage:	0.00 ft	**Reclaimed Weight:**	0.00 lbs
Average Speed:	79.49 ftpm	**Runtime %:** 14.04 %	18.49 hrs
		Total Hours:	131.77 hrs

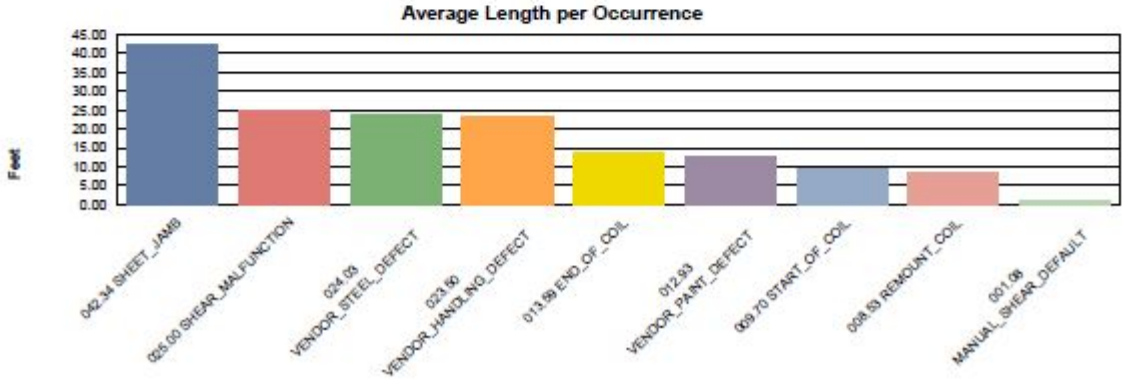
Code	Scrap Reason		Scrap Length	% Total Length	Scrap Weight	% Total Weight	Ave Length Per Occur	Occurences
3	END OF COIL		271.72 ft	0.31	536.71 lbs	0.31	13.59 ft	20
2	REMOUNT COIL		1,083.82 ft	1.23	2,113.81 lbs	1.22	8.53 ft	127
10	SHEAR MALFUNCTION		100.00 ft	0.11	194.69 lbs	0.11	25.00 ft	4
1	START OF COIL		38.81 ft	0.04	78.06 lbs	0.05	9.70 ft	4
		COIL REMOUNTS Total	**1,494.36 ft**	**1.69**	**2,923.27 lbs**	**1.69**	**9.64 ft**	**155**
0	MANUAL SHEAR DEFAULT		545.86 ft	0.62	1,069.64 lbs	0.62	1.08 ft	505
		NOT ASSIGNED Total	**545.86 ft**	**0.62**	**1,069.64 lbs**	**0.62**	**1.08 ft**	**505**
9	SHEET JAMB		42.34 ft	0.05	84.08 lbs	0.05	42.34 ft	1
		OPERATOR ERROR Total	**42.34 ft**	**0.05**	**84.08 lbs**	**0.05**	**42.34 ft**	**1**
6	VENDOR HANDLING DEFECT		23.50 ft	0.03	46.34 lbs	0.03	23.50 ft	1
4	VENDOR PAINT DEFECT		245.71 ft	0.28	482.72 lbs	0.28	12.93 ft	19
5	VENDOR STEEL DEFECT		192.26 ft	0.22	374.97 lbs	0.22	24.03 ft	8
		VENDOR DEFECTS Total	**461.47 ft**	**0.52**	**904.03 lbs**	**0.52**	**16.48 ft**	**28**
		Non-Exempt Total	**2,544.02 ft**	**2.88**	**4,981.02 lbs**	**2.88**	**3.69 ft**	**689**
		Total Scrap	**2,544.02 ft**	**2.88**	**4,981.02 lbs**	**2.88**	**3.69 ft**	**689**
		Net Scrap	2,544.02 ft	2.88	4,981.02 lbs	2.88		

64 METALS

Summary of Scrap

Dates between 06/01/2010 **and** 06/30/2010





64 METALS

Summary of Downtime

Dates between 06/01/2010 **and** 06/30/2010

Operator: 2 All Machines

Shift: All Shifts

Total Footage:	152,002.89 ft	**Total Weight:**	297,747.77 lbs
Total Good Footage:	147,668.67 ft	**Good Weight:**	289,247.30 lbs
Average Footage:	3,281.64 ft	**Average Weight:**	6,427.93 lbs
Scrap Footage:	4,334.22 ft	**Total Exit Scrap:**	8,500.47 lbs
Scrap Footage %:	2.85 %	**Total Exit Scrap %:**	2.85 %
Scrap Cost:	5581.05	**Raw Material Scrap:**	0.00 lbs
Reclaimed Footage:	0.00 ft	**Reclaimed Weight:**	0.00 lbs
Average Speed:	78.91 ftpm	**Runtime %:** 8.92 %	32.10 hrs
		Total Hours:	359.99 hrs

Code	Delay Reason		Minutes	% Downtime	% Total Time	Ave Time per Occur	Occurences
00	END OF SHIFT		6637.28	33.74	30.73	184.37	36
04	COIL CHANGE		4292.45	21.82	19.87	32.77	131
01	START OF SHIFT		3784.95	19.24	17.52	130.52	29
02	BREAK		2312.98	11.76	10.71	66.09	35
05	MACHINE OFFLINE		151.42	0.77	0.70	37.86	4
06	MAINTAINENCE ON MACHINE		70.68	0.36	0.33	35.34	2
08	HELPING CUSTOMER		16.75	0.09	0.08	16.75	1
		NOT ASSIGNED Total	**17266.51**	**87.77**	**79.94**	**72.55**	**238**
00	SHORT STOPS		2406.53	12.23	11.14	1.61	1495
		SHORT STOPS Total	**2406.53**	**12.23**	**11.14**	**1.61**	**1495**
		Non Exempt Total	**19673.04**	**100.00**	**91.08**	**11.35**	**1733**
	RUN TIME		1926.24		8.92	0.84	2300
		RUN TIME Total	**1926.24**		**8.92**	**0.84**	**2300**
		Total Downtime	**19673.04**		**91.08**	**11.35**	**1733**
		Total Time	21599.28				

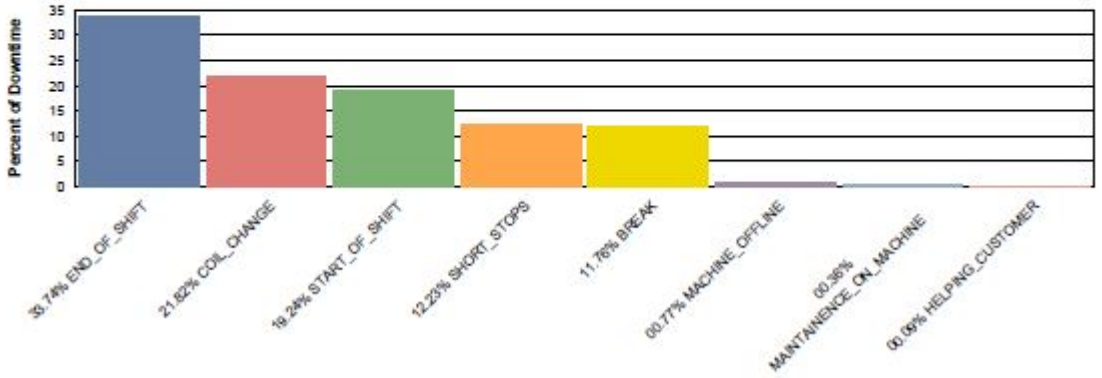
64 METALS

Summary of Downtime

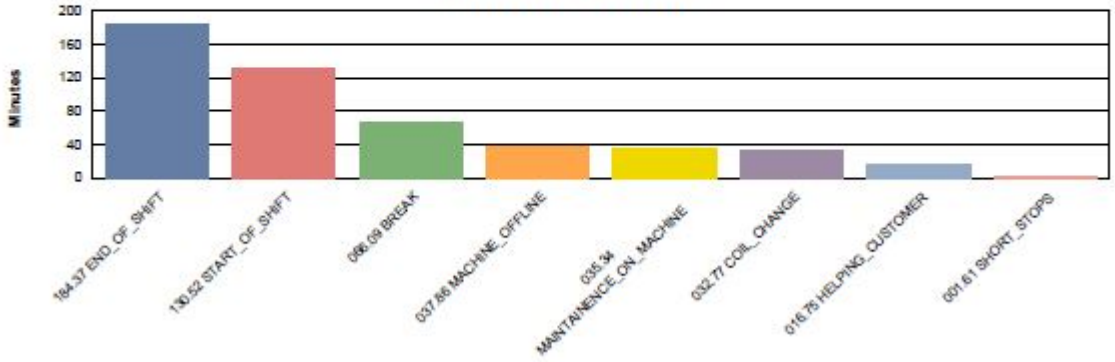
Dates between 06/01/2010 **and** 06/30/2010

Operator: 2 All Machines **Shift:** All Shifts

Downtime



Average Time per Occurrance



Summary of Downtime

Dates between 02/18/2008 **and** 02/19/2008

Operator: 20020 SUE BYRNES All Machines Shift: All Shifts

Total Footage:	51,389.21 ft	**Total Weight:**	0.00 lbs
Total Good Footage:	51,184.94 ft	**Good Weight:**	0.00 lbs
Average Footage:	60,365.53 ft	**Average Weight:**	0.00 lbs
Scrap Footage:	204.27 ft	**Total Exit Scrap:**	0.00 lbs
Scrap Footage %:	0.40 %	**Total Exit Scrap %:**	0 %
Scrap Cost:	0.00	**Raw Material Scrap:**	0.00 lbs
Reclaimed Footage:	102.36 ft	**Reclaimed Weight:**	0.00 lbs
Average Speed:	197.96 ftpm	**Runtime %:** 63.78 %	4.33 hrs
		Total Hours:	7.96 hrs

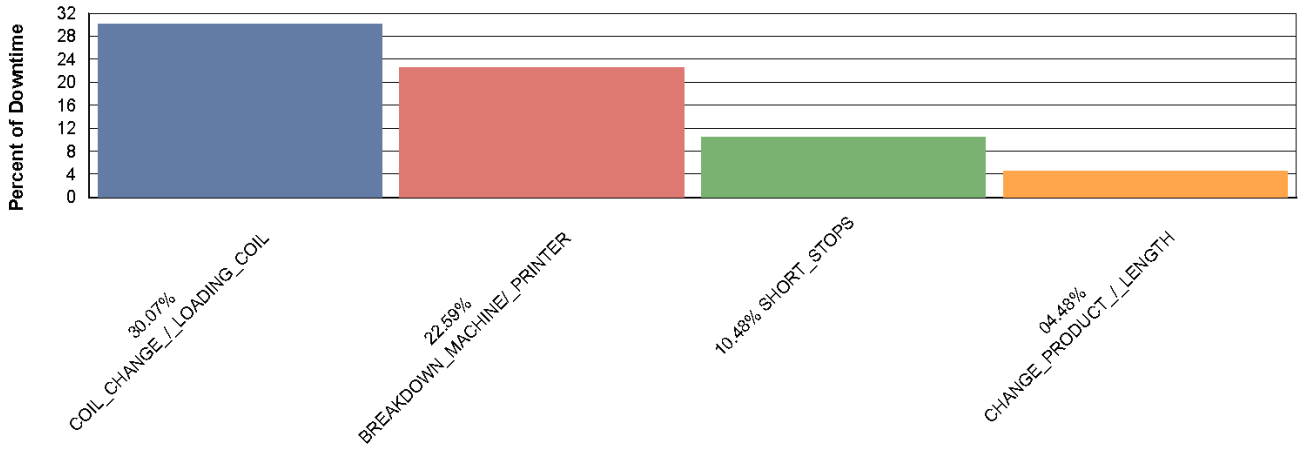
Code	Delay Reason	Minutes	% Downtime	% Total Time	Ave Time per Occur	Occurences
03	COIL CHANGE / LOADING COIL	65.55	30.07	13.72	7.28	9
	Material Handling Total	**65.55**	**30.07**	**13.72**	**7.28**	**9**
07	BREAKDOWN MACHINE/ PRINTER	49.24	22.59	10.31	12.31	4
04	CHANGE PRODUCT / LENGTH	9.77	4.48	2.05	9.77	1
	NOT ASSIGNED Total	**59.01**	**27.07**	**12.36**	**11.80**	**5**
00	SHORT STOPS	22.85	10.48	4.78	0.82	28
	SHORT STOPS Total	**22.85**	**10.48**	**4.78**	**0.82**	**28**
	Non Exempt Total	**147.41**	**67.61**	**30.86**	**3.51**	**42**
09	END SHIFT	14.03	6.44	2.94	7.02	2
08	SCHEDULED DOWNTIME/ MEAL BREAK	56.58	25.95	11.85	28.29	2
	Scheduled Downtime Total	**70.61**	**32.39**	**14.78**	**17.65**	**4**
	RUN TIME	259.59		54.35	6.04	43
	RUN TIME Total	**259.59**		**54.35**	**6.04**	**43**
	Total Downtime	**218.02**		**45.65**	**4.74**	**46**
	Total Time	477.61				

Summary of Downtime

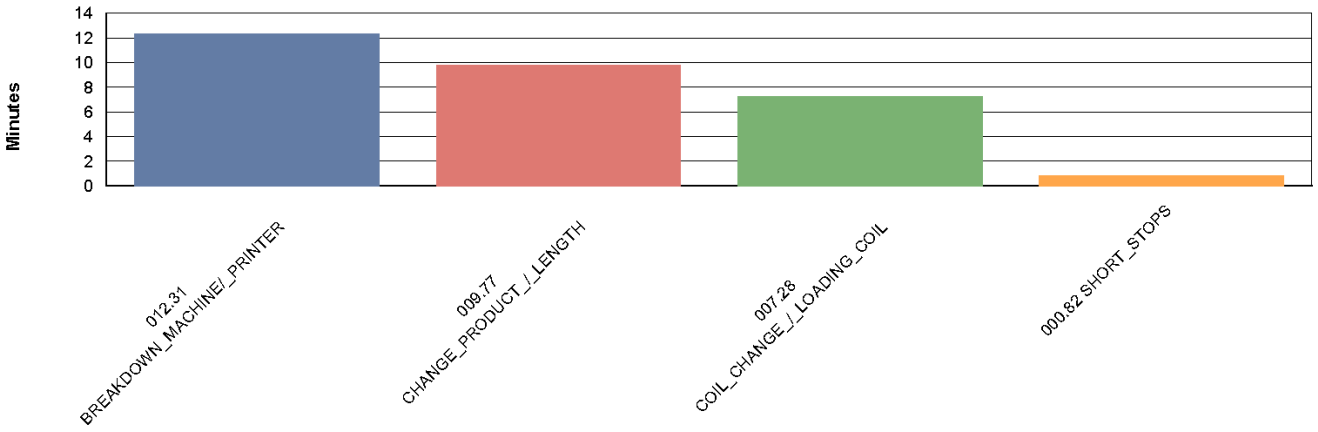
Dates between 02/18/2008 **and** 02/19/2008

Operator: 20020 SUE BYRNES All Machines **Shift: All Shifts**

Downtime



Average Time per Occurrance



Summary of Downtime

Dates between 02/18/2008 **and** 02/19/2008

Operator: 20002 PETER MACULSKIS All Machines Shift: All Shifts

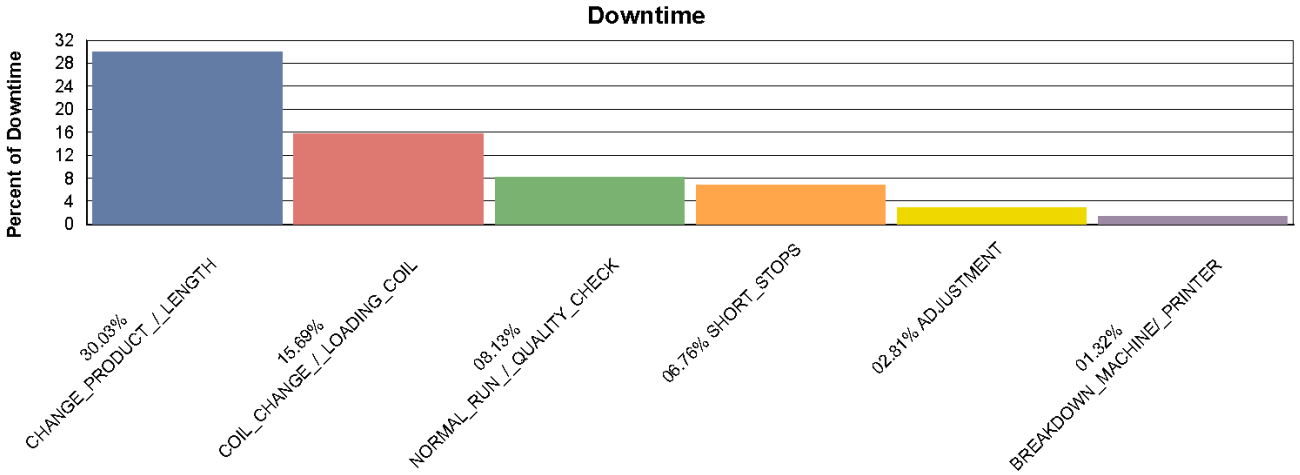
Total Footage:	54,252.01 ft	**Total Weight:**	66,545.19 lbs
Total Good Footage:	53,576.75 ft	**Good Weight:**	65,445.52 lbs
Average Footage:	14,094.51 ft	**Average Weight:**	17,216.84 lbs
Scrap Footage:	675.25 ft	**Total Exit Scrap:**	1,099.67 lbs
Scrap Footage %:	1.24 %	**Total Exit Scrap %:**	1.65 %
Scrap Cost:	0.00	**Raw Material Scrap:**	0.00 lbs
Reclaimed Footage:	1,373.35 ft	**Reclaimed Weight:**	626.48 lbs
Average Speed:	117.05 ftpm	**Runtime %:** 25.40 %	7.72 hrs
		Total Hours:	42.76 hrs

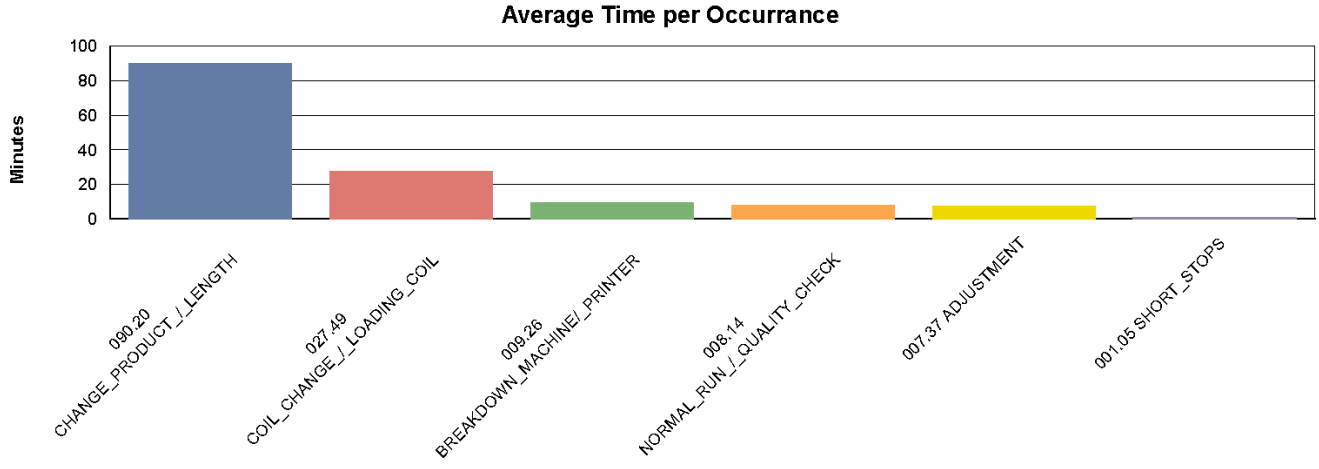
Code	Delay Reason	Minutes	% Downtime	% Total Time	Ave Time per Occur	Occurences
03	COIL CHANGE / LOADING COIL	329.89	15.69	12.86	27.49	12
	Material Handling Total	**329.89**	**15.69**	**12.86**	**27.49**	**12**
05	ADJUSTMENT	58.97	2.81	2.30	7.37	8
07	BREAKDOWN MACHINE/ PRINTER	27.79	1.32	1.08	9.26	3
04	CHANGE PRODUCT / LENGTH	631.40	30.03	24.61	90.20	7
02	NORMAL RUN / QUALITY CHECK	170.91	8.13	6.66	8.14	21
	NOT ASSIGNED Total	**889.07**	**42.29**	**34.65**	**22.80**	**39**
00	SHORT STOPS	142.15	6.76	5.54	1.05	135
	SHORT STOPS Total	**142.15**	**6.76**	**5.54**	**1.05**	**135**
	Non Exempt Total	**1361.11**	**64.74**	**53.05**	**7.32**	**186**
09	END SHIFT	168.27	8.00	6.56	33.65	5
08	SCHEDULED DOWNTIME/ MEAL BREAK	181.14	8.62	7.06	36.23	5
01	START SHIFT	391.78	18.64	15.27	55.97	7
	Scheduled Downtime Total	**741.19**	**35.26**	**28.89**	**43.60**	**17**
	RUN TIME	463.49		18.06	1.90	244
	RUN TIME Total	**463.49**		**18.06**	**1.90**	**244**
	Total Downtime	**2102.30**		**81.94**	**10.36**	**203**
	Total Time	2565.79				

Summary of Downtime

Dates between 02/18/2008 **and** 02/19/2008

Operator: 20002 PETER MACULSKIS All Machines **Shift:** All Shifts





Data for file: \ECLIPSE\HISTORY\PRD200802181.DBF

[1] Multi-profile Line

TYPE/ R	DATE	TIME	ORDER	MATERIAL	BNDL QTY	PATT. /OPT.	LENGTH IN.	INV COIL NUMBER	FOOTAGE IN.	EMPL ID	SCR CD	DEL CD	DOWN TIME
S R	02/18/2008	06:00:00			0					1	0	0	0.00
4	02/18/2008	07:12:53			0					1	0	0	0.00
7	02/18/2008	07:18:48	291637	Z05014400075	2					20207	0	1	78.80
3	02/18/2008	07:18:55	291637	Z05014400075	2					20207	0	0	0.12
1 T	02/18/2008	07:18:55	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.00
1 M	02/18/2008	07:27:47	291637	Z05014400075	2	000 R	141.732000	GW0092644 3	156.481	20207	0	0	0.00
1 M	02/18/2008	07:56:24	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.00
1 M	02/18/2008	07:56:28	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.00
1 M	02/18/2008	07:56:33	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.00
1 M	02/18/2008	07:56:42	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.00
7	02/18/2008	07:57:27	291637	Z05014400075	2					20207	0	7	38.53
3	02/18/2008	07:57:30	291637	Z05014400075	2					20207	0	0	0.05
1 H	02/18/2008	07:57:33	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.05
3	02/18/2008	07:58:12	291637	Z05014400075	2					20207	0	0	0.65
1 H	02/18/2008	07:58:15	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20207	0	0	0.05
7	02/18/2008	08:15:35	291637	Z05014400075	2					20226	0	7	17.33
3	02/18/2008	08:16:22	291637	Z05014400075	2					20226	0	0	0.79
1 H	02/18/2008	08:16:23	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.01
3	02/18/2008	08:16:24	291637	Z05014400075	2					20226	0	0	0.02
1 H	02/18/2008	08:16:25	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.02
3	02/18/2008	08:16:28	291637	Z05014400075	2					20226	0	0	0.05
1 H	02/18/2008	08:16:28	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.00
3	02/18/2008	08:16:29	291637	Z05014400075	2					20226	0	0	0.01
1 H	02/18/2008	08:16:30	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.02
3	02/18/2008	08:16:30	291637	Z05014400075	2					20226	0	0	0.00
1 H	02/18/2008	08:16:31	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.02
3	02/18/2008	08:16:32	291637	Z05014400075	2					20226	0	0	0.01
1 H	02/18/2008	08:16:32	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.00
3	02/18/2008	08:16:34	291637	Z05014400075	2					20226	0	0	0.04
1 H	02/18/2008	08:16:35	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.01
3	02/18/2008	08:17:24	291637	Z05014400075	2					20226	0	0	0.82
1 H	02/18/2008	08:17:27	291637	Z05014400075	2	1000 R	141.732000	GW0092644 3	141.735	20226	0	0	0.05
7	02/18/2008	08:37:08	291637	Z05014400075	2					20226	0	8	19.68
3	02/18/2008	08:37:12	291637	Z05014400075	2					20226	0	0	0.07

Data for file: \ECLIPSE\HISTORY\PRD200802181.DBF

[1] Multi-profile Line

TYPE/ R	DATE	TIME	ORDER	MATERIAL	BNDL QTY	PATT. /OPT.	LENGTH IN.	INV COIL NUMBER	FOOTAGE IN.	EMPL ID	SCR CD	DEL CD	DOWN TIME
1 H	02/18/2008	08:37:12	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.00
3	02/18/2008	08:37:14	291637	Z05014400075	2					20226	0	0	0.03
1 H	02/18/2008	08:37:15	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.02
3	02/18/2008	08:37:18	291637	Z05014400075	2					20226	0	0	0.05
1 H	02/18/2008	08:37:19	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.02
3	02/18/2008	08:37:19	291637	Z05014400075	2					20226	0	0	0.00
1 H	02/18/2008	08:37:22	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.05
3	02/18/2008	08:37:40	291637	Z05014400075	2					20226	0	0	0.30
1 H	02/18/2008	08:37:41	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.01
3	02/18/2008	08:37:43	291637	Z05014400075	2					20226	0	0	0.04
1 H	02/18/2008	08:37:45	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.03
3	02/18/2008	08:38:28	291637	Z05014400075	2					20226	0	0	0.72
1 H	02/18/2008	08:38:36	291637	Z05014400075	2	2 000 R	141.732000	GW0092644 3	283.471	20226	0	0	0.13
3	02/18/2008	08:42:15	291637	Z05014400075	2					20226	0	0	3.65
1 H	02/18/2008	08:42:42	291637	Z05014400075	2	7 000 R	141.732000	GW0092644 3	992.147	20226	0	0	0.45
1 M	02/18/2008	08:51:01	291637	Z05014400075	2	000 R	141.732000	GW0092644 3	110.059	20226	0	0	0.00
1 M	02/18/2008	08:51:39	291637	Z05014400075	2	000 R	141.732000	GW0092644 3	96.259	20226	0	0	0.00
1 M	02/18/2008	08:52:41	291637	Z05014400075	2	000 R	141.732000	GW0092644 3	101.614	20226	0	0	0.00
7	02/18/2008	08:56:57	291637	Z05014400075	2					20226	0	7	14.25
3	02/18/2008	08:57:02	291637	Z05014400075	2					20226	0	0	0.08
1 H	02/18/2008	08:57:08	291637	Z05014400075	2	1 000 R	141.732000	GW0092644 3	141.735	20226	0	0	0.10
3	02/18/2008	08:57:23	291637	Z05014400075	2					20226	0	0	0.25
1 H	02/18/2008	08:57:23	291637	Z05014400075	2	000 R	141.732000	GW0092644 3		20226	0	0	0.00
3	02/18/2008	08:57:38	291637	Z05014400075	2					20226	0	0	0.25
1 I	02/18/2008	08:59:32	291637	Z05014400075	2	32 000 R	141.732000	GW0092644 3	4535.530	20226	0	0	1.90
1 H	02/18/2008	09:00:20	291637	Z05014400075	3	15 000 R	141.732000	GW0092644 3	2126.030	20226	0	0	0.80
3	02/18/2008	09:00:45	291637	Z05014400075	3					20226	0	0	0.42
1 H	02/18/2008	09:00:50	291637	Z05014400075	3	1 000 R	141.732000	GW0092644 3	141.735	20226	0	0	0.08
3	02/18/2008	09:03:54	291637	Z05014400075	3					20226	0	0	3.07
1 H	02/18/2008	09:04:43	291637	Z05014400075	3	15 000 R	141.732000	GW0092644 3	2126.030	20226	0	0	0.82
3	02/18/2008	09:06:20	291637	Z05014400075	3					20226	0	0	1.61
1 H	02/18/2008	09:06:25	291637	Z05014400075	3	1 000 R	141.732000	GW0092644 3	141.735	20226	0	0	0.09

Eclipse Production Records Key

Type Code	Reason Code	Description
1		**General Production Record**
	B	Machine halted automatically due to a Bundle number change. The XL Series controller must be in Bundle Halt Mode
	C	Coil Tailout sensor detects passage of end of Coil. Machine is automatically halted and End of Coil Scrap Code is reported for any remaining Material, unless Machine Operator running a Scrap Bundle with 900+ Bundle Number, in which case that Scrap reason is reported for remaining material
	E	Machine was automatically halted because the programmed Coil Endpoint was reached. Machine Operator was prompted to cut the Coil at the pre-determined point prior to the entry to the roll former
	H	Machine Operator halted the Machine manually
	I	XL Series controller reports Bundle completion, but Machine controller was not configured for Bundle Halt Mode, so Machine continues producing by immediately and automatically changing to next Bundle
	M	XL Series controller reports Manual Shear by Machine Operator
	O	XL Series controller halts Machine automatically due to Out-of-Orders. There were no more Orders to run that could be queued (Material Code or Product Code change, or simply no more Orders in memory)
	P	Machine Operator removed power from the XL Series controller
	R	Machine Operator employed Remake function on Machine controller to replace Scrap parts
	T	XL Series controller automatically halted Machine due to Out of Tolerance part
	X	Machine Operator employed Decrease Quantity function to alert the system that a part previously counted as Scrap is actually Good Footage
	Y	Machine Operator employed Increase Quantity on Machine controller to replace scrap parts
	Z	Machine coast-to-stop. This code will always accompany a 1C record for a Tailout situation
2		**Production Record Related to Coil Change**
	D	Machine Operator reported Coil was completely consumed
	L	Machine Operator reported new Coil loaded
	R	Machine Operator reported remaining Coil was returned to inventory
3		**Machine Operator placed XL Series controller into Run mode**
4		**Machine Operator powered up XL Series controller**
5		**Order requested by Machine Operator from XL Series controller**
6		**XL Series controller reports an on-screen message (warning, error, notification)**
7		**Machine Operator reported a Downtime code**

8		**Custom List request or Query List feedback from Machine Operator**
	C	Custom List feedback from Machine Operator
	Q	Quality Audit feedback from Machine Operator
C		**Query List was triggered at XL Series controller**
E		**End of Shift**
	H	Runtime record
	R	Downtime record
S		**Start of Shift**
	H	Runtime record
	R	Downtime record
G		**General feedback record**
	C	Coil inventory update
	D	Order is Done
	I	Order added to Eclipse via import
	M	Order sent to XL Series controller
	R	Order returned to ERP system
	S	Order started at machine
	U	Order Recalled from controller to Eclipse
	X	Order deleted from Eclipse via import

Notes