

# Production Summary

All Shifts  
All Crews

November 2010

Machine	Open h Work h	Pers. h	% of		Downtime		Set-Up		Standard Hours		Actual Hours		Good / Waste Production			Thereof Finished Goods			Speed		Index m <sup>2</sup> /h	Performance		
			Work h	h	Set	Run	No.	Ø h	Set-Up	Run	Set-Up	Run	Set-Up	Run	Passes	m <sup>2</sup>	kg	Passes	m <sup>2</sup>	kg		Run	Total	Set
<b>France</b>																								
<b>R...(France)</b>																								
<b>AGR2</b>	72'18		17%	53'19	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>Agrafeuse 2</b>	303'46					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>COM</b>	317'35		13%	45'00	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>Combiné Rapi</b>	322'55					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>DEC</b>	337'19			0'00		0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>Découpeur Ra</b>	0'00					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>DIV1</b>	526'33		9%	47'07	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>AGRAFFAGE</b>	515'58					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>Conversion</b>	<b>894'46</b>		<b>18%</b>	<b>157'10</b>																				
<b>R... (France)</b>	<b>861'11</b>																							
<b>D... (France)</b>																								
<b>1228</b>	526'33		8%	37'44	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>COMBINE 122</b>	463'27					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>1600</b>	473'40		13%	91'04	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>BOBST 1600</b>	651'46					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>2000</b>	669'32		10%	68'07	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>BOBST 2000</b>	660'59					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>203A</b>	678'23		6%	42'53	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>BOBST 203A</b>	622'32					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>618</b>	640'59		10%	68'00	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>COMBINE 618</b>	625'55					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>924</b>	645'51		20%	83'03	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>COMBINE 924</b>	397'34					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>ASA</b>	415'28		8%	37'46	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>ASAHI</b>	448'44					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>FL4</b>	456'43		28%	79'05	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>FLEXO 4</b>	279'35					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>Conversion</b>	<b>4507'09</b>		<b>10%</b>	<b>475'44</b>																				
<b>D... (France)</b>	<b>4386'55</b>																							
<b>L... (France)</b>																								
<b>1628</b>	291'50		25%	111'11	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>DECOUPOIR</b>	437'44					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			
<b>1632</b>	456'34		27%	72'48	0%	0	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h			
<b>COMBINE MA</b>	262'19					0.0 / shift					0	0	0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h			

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			Work h	h	Set	Run	No.	ø h	Set-Up	Run	Set-Up	Run	Set-Up	Run	Passes	m <sup>2</sup>	kg	Passes	m <sup>2</sup>	kg		Run	Total	Set	Run	Tot.
<b>350</b> <b>COMBINE SIM</b>	273'26 440'09		21%	95'09	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>718</b> <b>COMBINE MA</b>	454'41 209'59		43%	92'02	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>CUIR</b> <b>CUIR</b>	218'28 406'19		23%	94'01	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>PP1</b> <b>PRESSE PLA</b>	425'31 292'44		17%	50'43	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>PPF</b> <b>PRESSE PLA</b>	306'12 0'00			0'00		0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h	0				
						/ shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>Conversion</b> <b>L... (France)</b>	<b>2426'42</b> <b>2328'49</b>		<b>25%</b>	<b>594'59</b>																						
<b>Portugal</b> <b>A... (Portugal)</b>																										
<b>0202</b> <b>SLOTTER 8</b>	65'57 61'29	109'36	20%	12'35	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0301</b> <b>MIDLINE</b>	756'38 742'29	544'02	80%	599'27	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0306</b> <b>CURIONI</b>	61'17 57'31	72'22	37%	21'46	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0307</b> <b>MARTIN 924 F</b>	788'15 764'44	460'08	80%	616'00	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0401</b> <b>BOBST 160</b>	752'59 731'35	190'45	4%	32'10	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0411</b> <b>TEXO</b>	174'19 159'42	209'54	22%	36'17	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0418</b> <b>PRENSA MAR</b>	225'37 205'37	236'44	24%	49'51	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0603</b> <b>BOBST/POST</b>	727'06 719'19	186'56	81%	584'42	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>0801</b> <b>RAPIDEX</b>	81'11 79'19	93'22	9%	7'15	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					
<b>Conversion</b> <b>A... (Portugal)</b>	<b>3633'19</b> <b>3521'45</b>	<b>2103'49</b>	<b>55%</b>	<b>1960'03</b>																						
<b>G...(Portugal)</b>																										
<b>0205</b> <b>Up3 - Rapid B</b>	83'35 188'45		20%	38'29	0%	0	0'00	0'00	0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0 sht/h	0 sht/h					
						0.0 / shift							0	0	0	0	0	0	0	0 m <sup>2</sup> /h	0 m <sup>2</sup> /h					



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				h	Set	Run	No.	Ø h	Set-Up	Run	Set-Up	Run	Set-Up	Run	Passes	m²	kg	Passes	m²	kg		Run	Total	Set	Run
<b>0602 JAGENBERG</b>	63'49 59'38	64'05	8%	5'12	16%	75%	41	0'27	29'39	35'33	18'36	35'50	102,654	42,789	18,946	102,654	42,789	18,946	3287 sht/h	1975 sht/h	500	152%	89%	110%	
							3.1	/ shift					15,144	7,186	1,106	15,144	7,186	1,106	1395 m²/h	838 m²/h	168%				
<b>0611 VEGA</b>	148'55 135'13	149'17	11%	15'14	11%	84%	67	0'18	21'30	126'05	20'33	99'26	210,527	301,333	207,842	210,527	301,333	207,842	2157 sht/h	1586 sht/h	300	96%	112%	109%	
							2.5	/ shift					3,924	5,316	3,919	3,924	5,316	3,919	3084 m²/h	2268 m²/h	756%				
<b>2001 I.A.Q.</b>	378'57 363'55	273'35	12%	43'58	31%	66%	167	0'37	128'56	134'28	102'58	216'59	933,641	862,978	403,380	0	0	0	4331 sht/h	2582 sht/h	1200	110%	54%	72%	
							4.5	/ shift					6,073	5,069	2,229	0	0	0	4001 m²/h	2385 m²/h	199%				
<b>Conversion</b>	<b>2120'25</b>	<b>1784'15</b>	<b>18%</b>	<b>380'30</b>																					
<b>L... R... S... (Po</b>	<b>2048'04</b>																								
<b>Spain</b>																									
<b>D... (Spain)</b>																									
<b>0210 CERRADA</b>	48'44 32'16		21%	6'51	15%	4%	18	0'50	8'22	17'14	14'57	10'28	16,239	26,078	12,507	2,680	2,806	1,156	1551 sht/h	503 sht/h		52%	160%	95%	
							2.5	/ shift					0	0	0	0	0	0	2492 m²/h	808 m²/h					
<b>0311 EMBA</b>	328'06 305'27		59%	182'31	6%	94%	184	0'06	22'15	129'03	18'27	104'29	839,964	456,981	228,149	839,964	456,981	228,149	8250 sht/h	2822 sht/h		75%	46%	49%	
							7.3	/ shift					22,038	10,851	5,269	22,038	10,851	5,269	4478 m²/h	1532 m²/h					
<b>0312 YUELI</b>	135'10 117'02		20%	24'25	11%	85%	73	0'31	36'37	74'37	37'32	55'05	207,972	298,187	165,830	207,972	298,187	165,830	3810 sht/h	1793 sht/h		91%	98%	95%	
							4.2	/ shift					1,895	3,026	2,032	1,895	3,026	2,032	5468 m²/h	2574 m²/h					
<b>0417 MARTIN</b>	409'59 396'22		17%	70'58	42%	57%	176	0'19	64'05	181'51	57'09	268'15	531,561	655,183	386,739	255,515	376,468	239,181	2011 sht/h	1361 sht/h		73%	58%	62%	
							5.0	/ shift					8,001	8,704	4,612	4,411	5,154	2,717	2475 m²/h	1675 m²/h					
<b>0418 TMZ</b>	208'00 155'18		27%	42'16	11%	88%	82	0'20	30'25	106'09	27'14	85'48	232,001	200,787	87,867	155,976	136,690	58,561	2767 sht/h	1529 sht/h		95%	86%	88%	
							3.1	/ shift					5,376	4,375	1,865	3,399	2,583	1,046	2391 m²/h	1321 m²/h					
<b>0419 TMZ II</b>	207'58 141'21		16%	22'40	1%	93%	74	0'18	19'06	141'33	22'24	96'17	267,483	222,415	86,226	194,107	156,572	58,495	2778 sht/h	1893 sht/h		84%	120%	114%	
							2.8	/ shift					36	30	11	35	29	11	2310 m²/h	1574 m²/h					
<b>0604 REVICART</b>	212'38 187'39		20%	38'39	5%	92%	55	0'43	46'34	147'48	39'01	109'59	334,950	203,879	87,036	331,780	201,879	86,030	3109 sht/h	1822 sht/h		113%	101%	104%	
							2.0	/ shift					6,970	4,089	1,755	6,970	4,089	1,755	1891 m²/h	1108 m²/h					
<b>1405 RODA I</b>	96'00 67'36		23%	15'34	14%	75%	15	0'42	13'25	57'10	10'30	41'32	41,478	20,510	10,500	41,478	20,510	10,500	1019 sht/h	626 sht/h		105%	107%	107%	
							1.2	/ shift					861	401	199	861	401	199	503 m²/h	309 m²/h					
<b>1406 RODA II</b>	93'09 75'58		25%	19'44	3%	97%	22	0'29	17'31	65'10	10'38	45'36	59,295	48,064	24,106	59,295	48,064	24,106	1322 sht/h	793 sht/h		156%	100%	108%	
							1.6	/ shift					972	712	353	972	712	353	1070 m²/h	642 m²/h					
<b>Conversion</b>	<b>1739'44</b>	<b>28%</b>		<b>423'38</b>																					
<b>D... (Spain)</b>	<b>1478'59</b>																								
<b>T... (Spain)</b>																									
<b>EXBR EXPEDICION B</b>	125'04 125'04		0%	0'00			14	1'17	2'00	163'28	17'55	102'05	16,348	7,039	243	16,348	7,039	243	160 sht/h	131 sht/h		11%	160%	137%	
							2.3	/ shift					0	0	0	0	0	0	69 m²/h	56 m²/h					
<b>EXCO EXPEDICION C</b>	169'01 169'01		0%	0'00			3	0'13	0'40	60'25	0'40	168'19	6,042	7,879	0	0	0	0	36 sht/h	36 sht/h		100%	35%	36%	
							1.5	/ shift					0	0	0	0	0	0	47 m²/h	47 m²/h					
<b>EXCT EXPEDICION C</b>	3'02 3'02		0%	0'00			8	0'00	0'00	22'57	0'00	0'00	2,295	8,048	0	2,295	8,048	0	0 sht/h	757 sht/h					
							4.0	/ shift					0	0	0	0	0	0	0 m²/h	2653 m²/h					

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			Work h	h	h	Set	Run	No.	Ø h	Set-Up	Run	Set-Up	Run	Passes	m²	kg	Passes	m²	kg	Run		Total	Set	Run
EXJA EXPEDICION J	50'02 50'02		0%	0'00		4	1'10	0'40	54'38	4'40	42'20	5,464	2,402	1,095	5,464	2,402	1,095	129 sht/h 57 m²/h	109 sht/h 48 m²/h		14%	129%	117%	
EXPR EXPEDICION P	348'39 348'39		53%	187'16	0%	22	0'28	6'13	77'35	10'09	151'14	3,879	4,520	1,003	3,384	3,294	1,003	26 sht/h 30 m²/h	11 sht/h 13 m²/h		61%	51%	51%	
LIPA LIGAR O PALE	29'38 29'38		0%	0'00		37	0'00	0'00	203'52	0'00	0'00	33,979	36,316	4,752	33,979	36,316	4,752	0 sht/h 0 m²/h	1147 sht/h 1226 m²/h					
UP03 CAVIFESA BT	127'32 112'25		23%	26'15	27% 70%	85	0'35	32'12	122'01	49'38	36'32	61,735	127,831	18,566	26,039	55,107	5,758	1704 sht/h 3520 m²/h	554 sht/h 1144 m²/h		56%	222%	138%	
UP04 BOBST SPO 1	160'31 134'33		23%	31'59	9% 74%	59	0'29	13'12	61'24	28'36	60'27	121,264	103,074	18,063	98,647	78,363	16,914	2033 sht/h 1726 m²/h	913 sht/h 776 m²/h		42%	73%	64%	
UP06 SODEMME 640	150'03 88'05		28%	24'55	8% 91%	33	0'30	4'42	65'55	16'20	49'11	9,710	20,258	7,305	9,710	20,258	7,305	199 sht/h 415 m²/h	111 sht/h 232 m²/h		25%	91%	78%	
UP07 GANDOSSY F	52'35 31'37		32%	10'10	10% 92%	30	0'11	3'45	22'18	5'43	15'59	12,189	26,341	836	12,149	26,272	835	769 sht/h 1660 m²/h	389 sht/h 839 m²/h		55%	88%	81%	
UP08 VEGA 2400	90'17 74'05		37%	27'47	4% 70%	16	1'14	9'21	22'14	19'45	26'33	48,349	27,380	5,639	48,349	27,380	5,639	2012 sht/h 1077 m²/h	721 sht/h 386 m²/h		44%	48%	47%	
UP12 MARTIN 924 R	158'45 147'04		35%	51'38	21% 76%	185	0'14	32'06	97'41	41'58	53'29	337,797	231,397	36,018	335,707	231,008	35,862	6386 sht/h 4376 m²/h	2322 sht/h 1592 m²/h		60%	105%	89%	
UP18 CABECERA V	51'01 47'20		16%	7'40	3% 95%	4	0'09	3'00	6'42	0'35	39'05	3,351	7,165	0	3,351	7,165	0	86 sht/h 183 m²/h	71 sht/h 151 m²/h		360%	14%	20%	
Conversion T... (Spain)	1516'10 1360'35		27%	367'40																				
Conversion Total	18663'35 17740'50	3950'58	26%	4716'37	3% 17%	2340	0'24	898'51	2813'49	916'42	2747'26	7,560,273	7,123,874	3,512,329	5,594,752	5,102,317	2,511,790	2796 sht/h 2626 m²/h	433 sht/h 407 m²/h		83%	79%	80%	