

Production Summary (in Passes and Products)

All Shifts
All Crews

May 1989

Machine	Open h Work h	Pers. h	% of Work h		Downtime h Set Run		Set-Up No. Ø h		Std./Actual Hours Set-Up Run		Good / Waste Production				Thereof Finished Goods				Speed		Index m²/h	Performance		
											Passes	Products	m²	kg	Passes	Products	m²	kg	Run	Total		Set	Run	Tot.
20 Slotter Jurine	11'21 11'11		33%	3'46	77%	3	0'22	1'30	0'00	1'30	0'00	5,624	5,624	2,659	0	5,624	5,624	2,659	0	903 sht/h	512 sht/h		138%	14%
						1.5 / shift		1'05	6'20			98	98	46	0	98	98	46	0	427 m²/h	242 m²/h			
30 Martin 1000	54'06 53'24		23%	12'33	6% 83%	23	0'15	11'24	0'13	11'24	0'13	123,026	123,026	63,950	404	107,197	107,197	51,051	404	3558 sht/h	2342 sht/h		177%	0% 22%
						2.8 / shift		5'42	35'09			2,050	2,050	1,058	17	1,814	1,814	871	17	1849 m²/h	1217 m²/h			
31 Rapidex	46'29 41'37		16%	6'57	0% 99%	24	0'22	10'28	5'47	10'28	5'47	73,212	74,846	66,884	2,550	59,174	59,174	52,335	0	2879 sht/h	1782 sht/h		117%	17% 39%
						3.4 / shift		8'55	25'45			934	950	810	0	817	817	648	0	2629 m²/h	1627 m²/h			
32 Martin 1000	35'21 29'49		22%	6'38	68%	12	0'20	6'00	5'26	6'00	5'26	129,893	134,685	78,896	9,116	114,253	114,253	67,772	9,116	6843 sht/h	4403 sht/h		150%	22% 41%
						2.4 / shift		4'00	19'11			1,378	1,430	856	8	1,218	1,218	742	8	4157 m²/h	2675 m²/h			
51 Bobst	99'21 99'21		0%	0'43	0%	25	0'20	5'00	3'17	5'00	3'17	131,062	424,655	120,937	0	119,910	400,597	110,891	0	1468 sht/h	1333 sht/h		59%	3% 8%
						1.9 / shift		8'26	90'12			1,344	4,085	1,414	0	1,130	3,627	1,226	0	1356 m²/h	1232 m²/h			
58 Ward	27'21 27'21		0%	0'00		6	0'47	2'00	5'12	2'00	5'12	52,072	140,891	54,876	10,898	52,072	140,891	54,876	10,898	2318 sht/h	1921 sht/h		42%	22% 26%
						1.5 / shift		4'41	22'40			460	1,173	511	15	460	1,173	511	15	2444 m²/h	2025 m²/h			
60 Coupeuse de	11'35 11'15		0%	0'00		2	1'48	0'00	0'00	0'00	0'00	1,087	1,087	608	0	1,087	1,087	608	0	143 sht/h	98 sht/h			
						1.0 / shift		3'35	7'40			13	13	7	0	13	13	7	0	80 m²/h	55 m²/h			
65 Piqueuse man	5'45 5'45		0%	0'00		1	0'15	0'00	0'00	0'00	0'00	1,087	1,087	608	0	1,087	1,087	608	0	200 sht/h	191 sht/h			
						1.0 / shift		0'15	5'30			13	13	7	0	13	13	7	0	112 m²/h	107 m²/h			
81 Mitrailleuse	5'00 0'00			0'00		0		0'00	0'00	0'00	0'00	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h	0		
						/ shift		0'00	0'00			0	0	0	0	0	0	0	0	0 m²/h	0 m²/h			
88 Roda 1	18'51 18'51		3%	0'37	0%	2	0'18	1'00	0'00	1'00	0'00	21,108	21,108	12,714	0	21,108	21,108	12,714	0	1218 sht/h	1141 sht/h		171%	5%
						0.6 / shift		0'35	17'39			398	398	222	0	398	398	222	0	733 m²/h	686 m²/h			
89 Roda 2	2'20 2'00		0%	0'00		1	1'15	1'00	0'00	1'00	0'00	0	0	0	0	0	0	0	0	0 sht/h	0 sht/h		80%	50%
						1.0 / shift		1'15	0'45			0	0	0	0	0	0	0	0	0 m²/h	0 m²/h			
Conversion Total	317'30 305'34		11%	36'14	2% 68%	99	0'23	38'22	19'56	38'22	19'56	538,171	927,009	402,131	22,968	481,512	851,018	353,514	20,419	2360 sht/h	1783 sht/h		97%	7% 19%
						2.1 / shift		38'29	230'51			6,688	10,210	4,932	40	5,961	9,171	4,281	40	1763 m²/h	1332 m²/h			