



System Specification

Company:

Contact:

1. Machines

Please list below the machines to be monitored by your Intouch system

XTX Input	Machine name Eg. A26	Process Eg. Injection Moulding	Area/Workgroup Eg. Cell 1
1			
2			
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
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30			
31			
32			

Please also attach a simple plant layout identifying the location of the machines listed above.

2. Shift Pattern

Please specify your shift pattern. Please see example shift patterns in appendix II.

Plant Time Zone:

	Start Time (HH:MM)	End Time (HH:MM)	Worked (Y/N)
1			
2			
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
14			
15			
16			
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18			
19			
20			
21			

3. Downtime Codes

Please list below the downtime codes to be used in your Intouch system. Please also note which downtime codes are to be considered as planned downtime codes for the purposes of calculating OEE (see appendix I for an explanation of OEE):

	Downtime Code	Planned Downtime Code for OEE (Y/N - See appendix I)
1		
2		
3		
4		
5		
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7		
8		
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28		

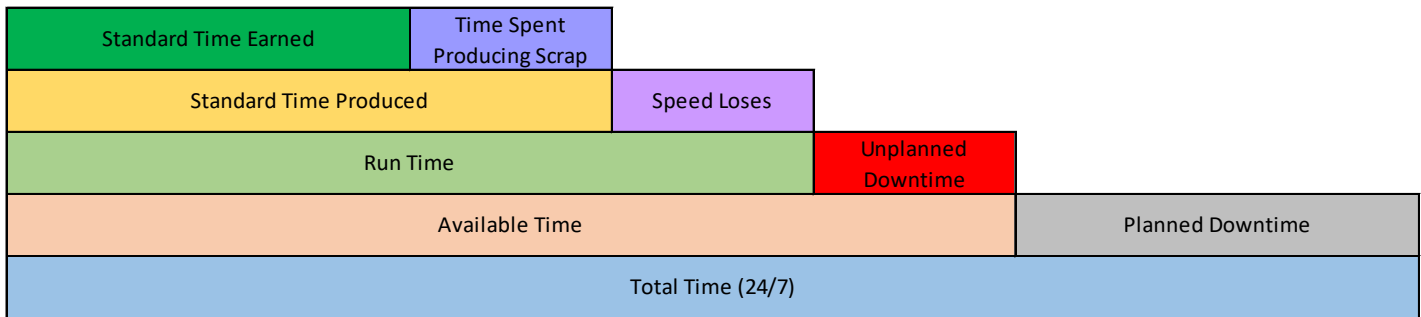
4. Reject Codes

Please list below the reject codes to be used in your Intouch system:

	Reject Code
1	
2	
3	
4	
5	
6	
7	
8	
9	
10	
11	
12	
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14	
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27	
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30	
31	
32	

Appendices

Appendix I – OEE Calculation



Total Time (Elapsed Time) = Potential Machine Time = 24hrs per day

Planned Downtime = Sum of all planned downtime

Available Time = Total Time - Planned Downtime

Unplanned Downtime = Sum of all unplanned downtime

Run Time = Available Time - Unplanned Downtime

Standard Time Earned = Good Parts Made x (Standard Cycle Time / Cavities)

Standard Time Scrapped = Scrap Parts Made x (Standard Cycle Time / Cavities)

Standard Time Produced = (Good Parts Made + Scrap Parts Made) x (Standard Cycle Time / Cavities)
= Standard Time Earned + Standard Time Scrapped

Speed Loses = Run Time - Standard Time Produced

Availability = **Run Time / Available Time**

Performance = **Standard Time Produced / Run Time**

Quality = **Good Parts Made / (Good Parts Made + Scrap Parts Made)**
= **Standard Time Earned / Standard Time Produced**

OEE = **Availability x Performance x Quality**
= **Standard Time Earned / Available Time**

Appendix II – Example Shift Patterns

12 hour shifts. 24 x 5

	Start Time	End Time	Worked (Y/N)
1	Mon 6am	Mon 6pm	Y
2	Mon 6pm	Tue 6am	Y
3	Tue 6am	Tue 6pm	Y
4	Tue 6pm	Wed 6am	Y
5	Wed 6am	Wed 6pm	Y
6	Wed 6pm	Thu 6am	Y
7	Thu 6am	Thu 6pm	Y
8	Thu 6pm	Fri 6am	Y
9	Fri 6am	Fri 6pm	Y
10	Fri 6pm	Sat 6am	Y
11	Sat 6am	Sat 6pm	N
12	Sat 6pm	Sun 6am	N
13	Sun 6am	Sun 6pm	N
14	Sum 6pm	Mon 6am	N

12 hour shifts. 24 x 7

	Start Time	End Time	Worked (Y/N)
1	Mon 6am	Mon 6pm	Y
2	Mon 6pm	Tue 6am	Y
3	Tue 6am	Tue 6pm	Y
4	Tue 6pm	Wed 6am	Y
5	Wed 6am	Wed 6pm	Y
6	Wed 6pm	Thu 6am	Y
7	Thu 6am	Thu 6pm	Y
8	Thu 6pm	Fri 6am	Y
9	Fri 6am	Fri 6pm	Y
10	Fri 6pm	Sat 6am	Y
11	Sat 6am	Sat 6pm	Y
12	Sat 6pm	Sun 6am	Y
13	Sun 6am	Sun 6pm	Y
14	Sum 6pm	Mon 6am	Y

8 hour shifts. 5 day, no night shift

	Start Time	End Time	Worked (Y/N)
1	Mon 6am	Mon 2pm	Y
2	Mon 2pm	Mon 10pm	Y
3	Mon 10pm	Tue 6am	N
4	Tue 6am	Tue 2pm	Y
5	Tue 2pm	Tue 10pm	Y
6	Tue 10pm	Wed 6am	N
7	Wed 6am	Wed 2pm	Y
8	Wed 2pm	Wed 10pm	Y
9	Wed 10pm	Thu 6am	N
10	Thu 6am	Thu 2pm	Y
11	Thu 2pm	Thu 10pm	Y
12	Thu 10pm	Fri 6am	N
13	Fri 6a	Fri 2pm	Y
14	Fri 2pm	Fri 10pm	Y
15	Fri 10pm	Sat 6am	N
16	Sat 6a	Sat 2pm	N
17	Sat 2pm	Sat 10pm	N
18	Sat 10pm	Sun 6am	N
19	Sun 6a	Sun 2pm	N
20	Sun 2pm	Sun 10pm	N
21	Sun 10pm	Mon 6am	N