



Time Monitoring

- F9 -

Used with Module F4, this module lets you compare planned and real time spent on each work station.

There are two ways to monitor time spent:

- Either via a production terminal, its main function being to provide information to the worker (see Module F4); in a fully automatic and transparent fashion to the worker, time spent is sent to CHACALXXI.
- Or via terminals that are used exclusively for tracking: the worker receives very little information on the screens of these types of terminal. However, he indicates on this terminal on which manufacturing lot and station he is working; this information is sent to CHACALXXI, which can then track production (F4 Module) and also time. These terminals are suitable for factories: ability to use the "touch screen" mode. Multiple workers may use a single terminal simultaneously. Additionally, the workers can (must!) indicate what they are doing during down time (breaks); in the case of a "break" due to a breakdown, they may be asked to define the type of breakdown when they return to work. This informs the production manager of the cause and duration of the breakdown. Time may also be entered after the fact: for example, repair or additional installation time; these times may be entered on a manufacturing station. For example: if the glazing was poorly installed in the factory, it is logical to enter the labor time dedicated to adjusting the glazing on site.

As long as the planned time (calculated on the basis of the parameters) and the time actually spent (entered into the terminals) has been indicated, CHACALXXI can provide various statements and comparisons:

- Statement of services by operator
- Statement of down time by operator
- Statement of all down time (analysis of breakdowns)

Comparisons of planned time and time spent per file, per reference type, per manufacturing lot or per reference type and operator.

Examples of results

Comparative table of time calculated and spent in the factory: example of a manufacturing lot.



Lot	Diffus semaine 20.
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Poste	Calculé	Atelier
Assemblage mécanique	20'00"	18'20"
Vitrage	2h42'00"	2h45'00"
Débit	41'36"	39'32"
Expédition	20'00"	22'00"
Quincaillerie	1h30'29"	1h18'00"
Soudeuse 4 têtes	50'00"	54'50"
Soudeuse 6 têtes	40'00"	35'00"
Soudeuse manuelle		20'24"
Traverse	40'00"	36'00"

Statements of services per operator for a given day.



Période	09/10/2003 - 09/10/2003
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Opérateur	Temps
Alain TERIEUR	
Alex TERIEUR	3h50'40"
André BAUWENS	
David MICHEL	
Fabien RICHE	7h53'20"
Gérard MANFROY	8h08'41"
Guy DE RIDDER	8h03'20"
Jean LEBAILLY	
Jean MICHEL	8h49'10"
Jessica RAMEL	
Jozef DUPONT	
Michel GALLEZ	5h00'20"
Nathalie BAILLE	
Paul LAMBERT	
Simon STURBOIS	
Sonja BAUWENS	

Comparison for one operator over a given period The time is indicated by type of reference and station

HACAL XXI DSI (Documentation) Par type de repère et opérateur

Opérateur	Alex TERIEUR
Période	09/10/2003 - 16/10/2003

Type	Qté	Total	Assemblage mécanique	Vitrage	Débit	Expédition	Quincaillerie
Fixe	5	36'00"	33'20"	36'00"	33'20"		
Frappe	8	1h12'00"	1h15'00"	1h12'00"	1h15'00"		
Frappe + fixe	7	54'00"	56'40"	54'00"	56'40"		
Total	18	2h42'00"	2h45'00"	2h42'00"	2h45'00"		

HACAL XXI DSI (Documentation) Par type de repère et opérateur

Opérateur	Alex TERIEUR
Période	09/10/2003 - 16/10/2003

Type	Qté	Soudeuse 4 têtes	Soudeuse 6 têtes	Soudeuse manuelle	Traverse
Fixe	5				
Frappe	6				
Frappe + fixe	7				
Total	18				

Interventions SAV

Date	Gravité	Section	Description
14/10/2003	3	Vitrage	Reprise vitrage sur 2 Vtx + fixe Opérateur Alex Terieur
14/10/2003	3	Vitrage	Reprise vitrage sur 2 Vtx + fixe Opérateur Alex Terieur
14/10/2003	3	Vitrage	Reprise vitrage sur 2 Vtx + fixe Opérateur Alex Terieur
14/10/2003	3	Vitrage	Reprise vitrage sur 2 Vtx + fixe Opérateur Alex Terieur

At the bottom of the table above, After Sales services appear under the glazing item.

Examples of screens displayed on a tracking terminal (touch screen in the factory).

List of operators for identification at the beginning of the day.

Indiquez votre nom

Guy DE RIDDER	Gérard MANFROY	Fabien RICHE
André BAUWENS	Alex TERIEUR	Michel GALLETZ
Jozef DUPONT	Alain TERIEUR	Nathalie BAILLE
Sonja BAUWENS	Jean MICHEL	David MICHEL
Paul LAMBERT	Simon STURBOIS	Jean LEBAILLY

Autre

Retour

Screen for the selection of a labor item

Alex TERIEUR

Indiquez l'activité que vous allez faire

Soudeuse 4 têtes	Traverse	Cintre
Débit	Assemblage mécanique	Seuil alu
Ferrage	Pose joints	Petit-bois
Battement	Vitrage	Soudeuse 6 têtes
Renforts	Déclignage	Fabrication Coffre

Autre

Retour

Summary screen for six operators (and more - "Other" button). The names, work station occupied, manufacturing lot in process, starting time and work time are indicated. In practice, the logos of a man with a helmet are replaced by photos of the operators.

 <p>Opérateur : Gérard MANFROY</p> <p>🕒 11:35 1h 07'</p> <p>Réglage machine</p> <p>Débit 04001_A</p>	 <p>Opérateur : Fabien RICHE</p> <p>🕒 11:35 1h 07'</p> <p>Assemblage mécanique 04001_A</p>	Commencer
 <p>Opérateur : Jessica RAMEL</p> <p>🕒 11:35 1h 06'</p> <p>Vitrage Diffus S18</p>	 <p>Opérateur : Guy DE RIDDER</p> <p>🕒 11:35 1h 06'</p> <p>Soudeuse 4 têtes 04001_A</p>	Autre
 <p>Opérateur : Nathalie BAILLE</p> <p>🕒 12:15 27'</p> <p>Traverse 04001_A</p>	 <p>Opérateur : Alex TERIEUR</p> <p>🕒 12:32 10'</p> <p>Soudeuse 4 têtes Diffus S18</p>	

Example of a list of planned "breaks": the parameters for these lists may be changed

Indiquez le type d'interruption		
Arrêt pipi	Pause café	
Réglage machine		
Alimentation poste de travail		
Entretien		
Panne		
Retour		

Example of a list which, when the workers return to work, can specify the cause of a breakdown (the list parameters may be changed).

Indiquez l'origine de l'interruption		
panne générale atelier		
panne électrique		
panne mécanique		
panne commande numérique		
autre panne		
Retour		