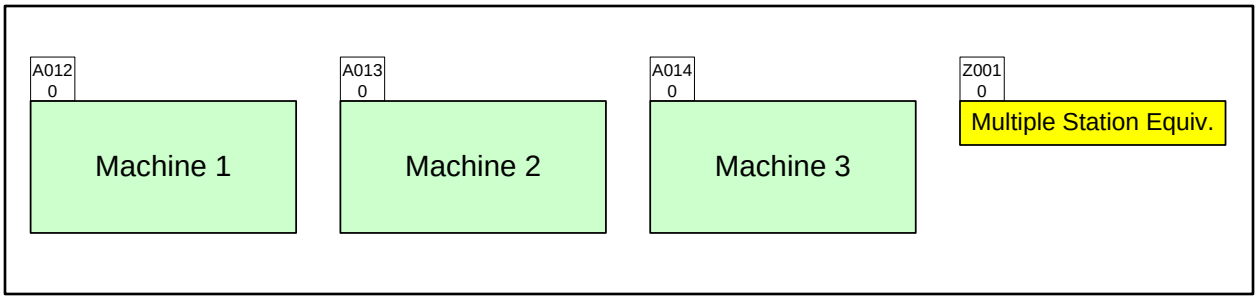
Manufacturing Multi Station Wizard Tutorial

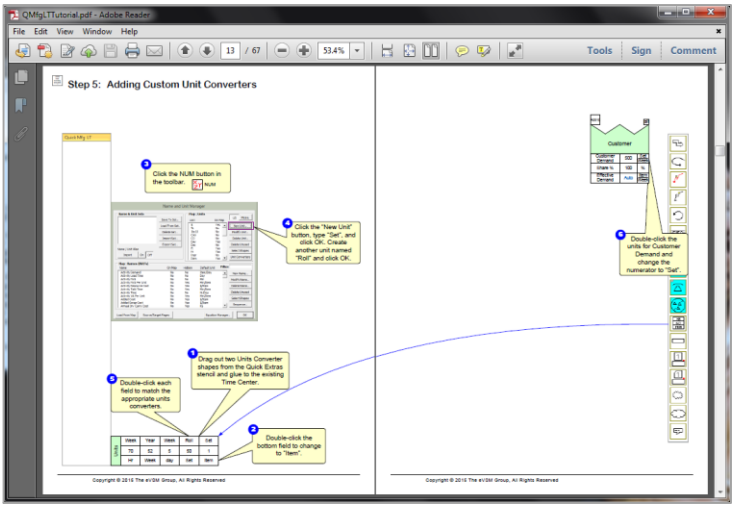
This tutorial will guide you through the steps to draw a simple map and perform common calculations using the Manufacturing Multi Station Wizard.



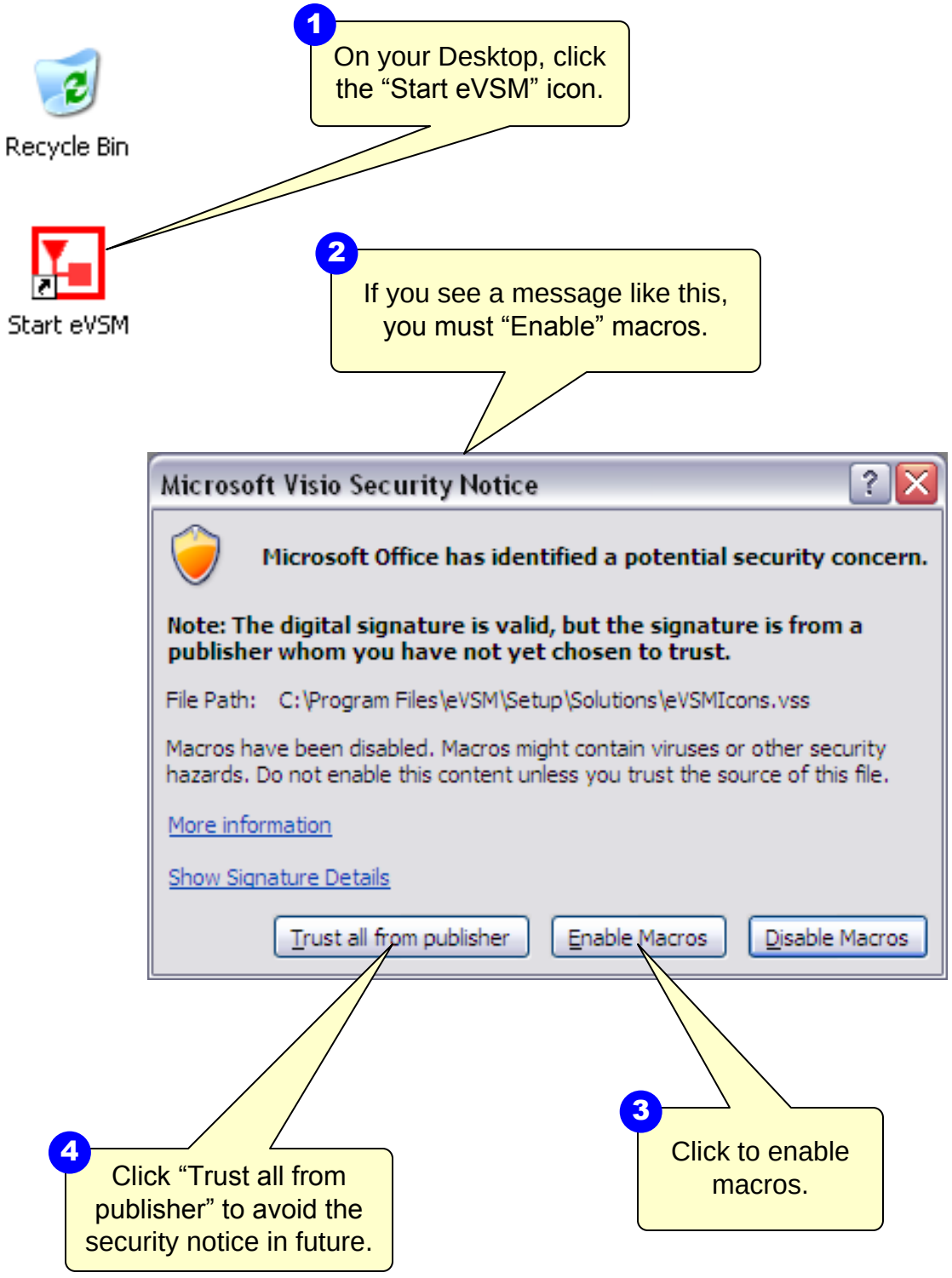
Viewing/printing eVSM Tutorial:

This tutorial is designed for two page layout. If printing, you will need double-sided print.

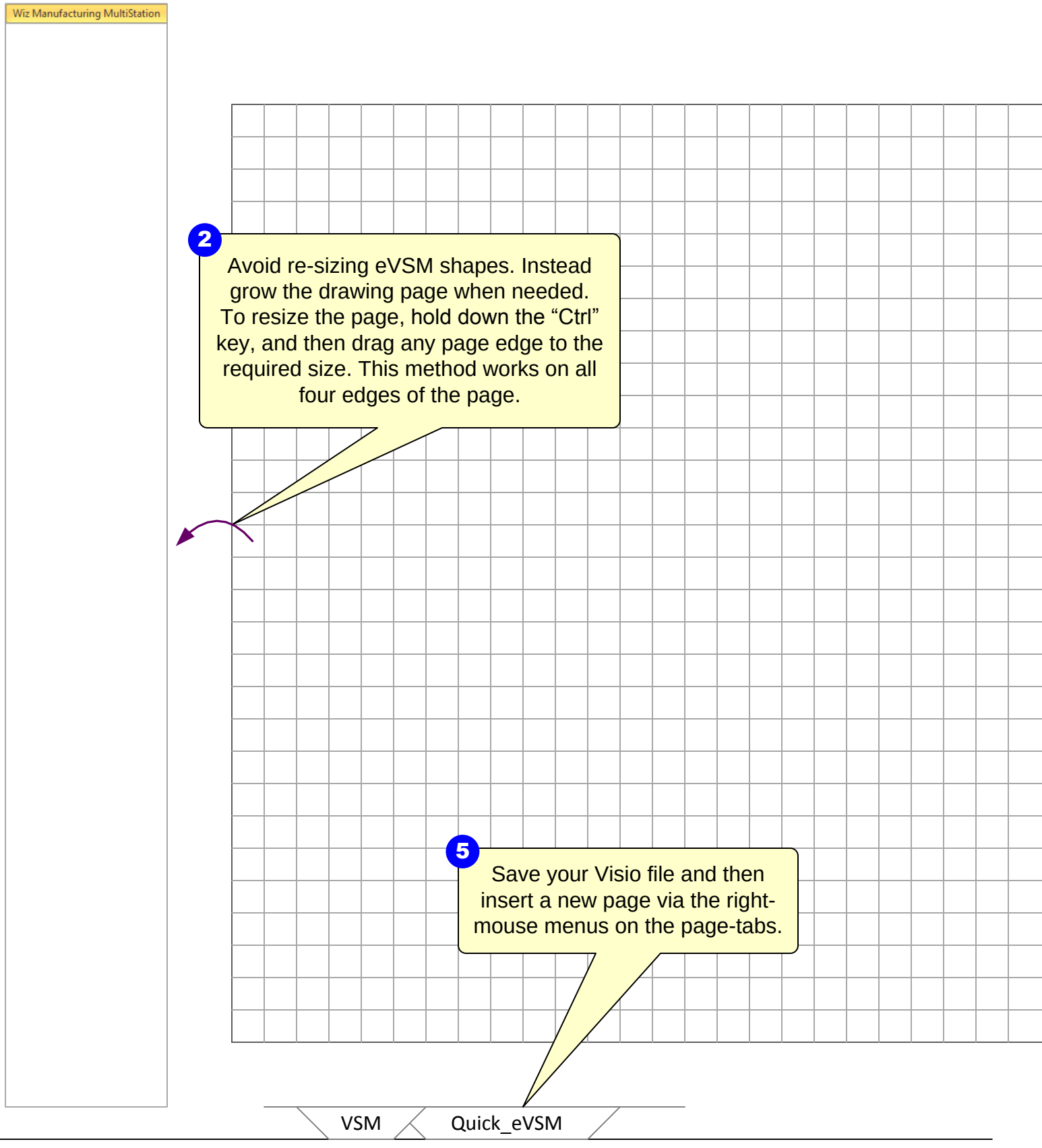
For on-screen viewing, save the PDF file to your PC and then open it in Acrobat Reader (not in a web browser). In the Acrobat menus, click “View>Page Display", make sure “Show Cover Page in Two Page View” is checked and then select "Two Page View”.

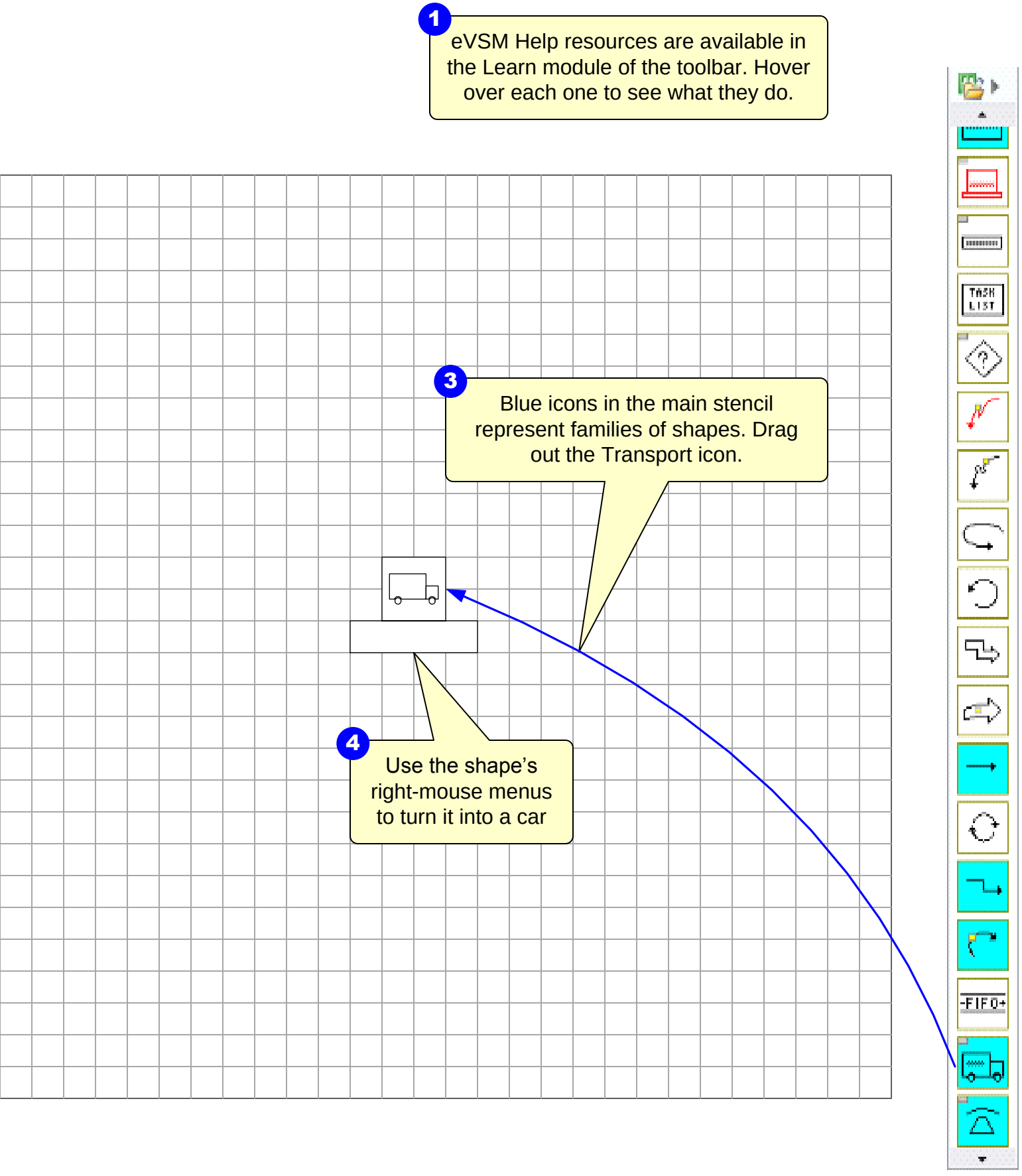


Step 1: Start eVSM

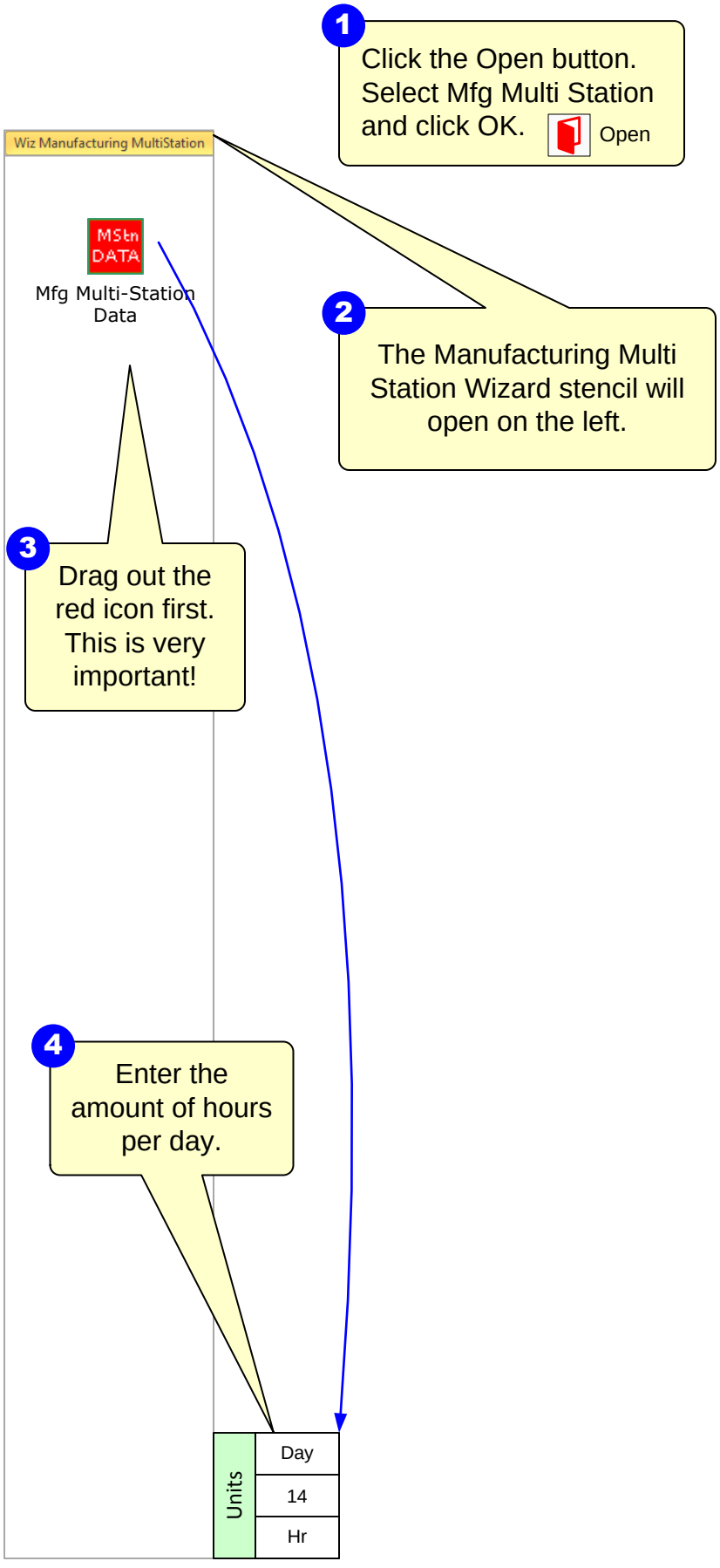


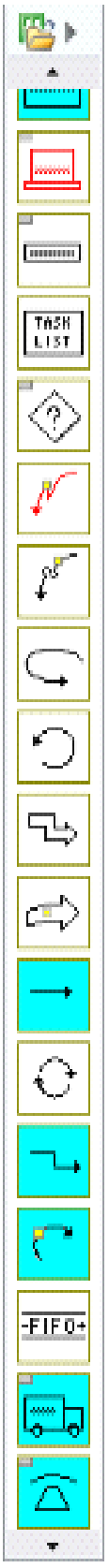
Step 2: Learn eVSM Basics





Step 3: Initiate the map for Manufacturing Multi Station Wizard



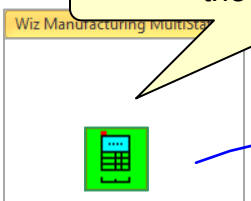


Step 4: Set Up Each Machine

1 The green shapes are called “Centers”. Use the centers to represent the flow.

3 Double-click the unit to change it from Min to Sec.

2 Complete as shown below, including annotation and data values.



A0120

Machine 1		
Cycle Time_M	10	Sec
Qty Per Cycle_M	1	Item
Stations_M	3	Stn
Activity Time_M	12	Hr / Day
OEE Percent_M	98	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

A0130

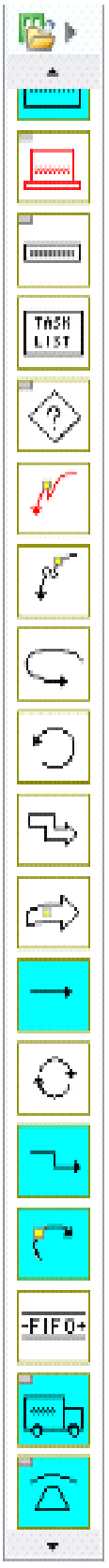
Machine 2		
Cycle Time_M	15	Sec
Qty Per Cycle_M	1	Item
Stations_M	2	Stn
Activity Time_M	10	Hr / Day
OEE Percent_M	98	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

A0140

Machine 3		
Cycle Time_M	1	Min
Qty Per Cycle_M	4	Item
Stations_M	1	Stn
Activity Time_M	14	Hr / Day
OEE Percent_M	95	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

4 Do not change any of the “Auto” fields. These will calculated later.

Units	
	Day
	14
	Hr



Step 5: Multi-Station Summary

Wiz Manufacturing MultiStation

Multi-Station Summary

A0120

Machine 1		
Cycle Time_M	10	Sec
Qty Per Cycle_M	1	Item
Stations_M	3	Stn
Activity Time_M	12	Hr / Day
OEE Percent_M	98	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

A0130

Machine 2		
Cycle Time_M	15	Sec
Qty Per Cycle_M	1	Item
Stations_M	2	Stn
Activity Time_M	10	Hr / Day
OEE Percent_M	98	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

A0140

Machine 3		
Cycle Time_M	1	Min
Qty Per Cycle_M	4	Item
Stations_M	1	Stn
Activity Time_M	14	Hr / Day
OEE Percent_M	95	%
Cycle Time Per Item	Auto	Min
CT Capacity Per Day	Auto	Item
All Stations Time	Auto	Hr / Day
QPC Contributor	Auto	ItSq
Capacity Per Day	Auto	Item

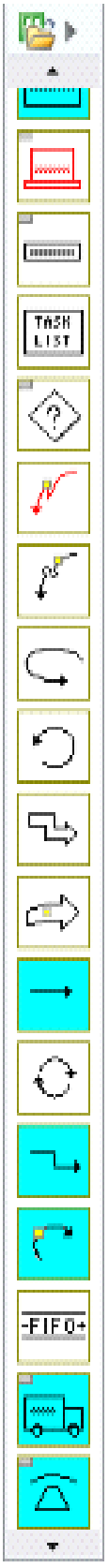
Units	
	Day
	14
	Hr

1

Drag out the Multi-Station Summary Center.

Z0010

Multiple Station Equiv.		
Cycle Time	Auto	Min
Qty Per Cycle	Auto	Item
Stations	Auto	Stn
OEE Percent	Auto	%
Activity Time	Auto	Hr / Day
MS CT Capacity Per Day	Auto	Item
MS Capacity Per Day	Auto	Item
MS Cycle Time Per Item	Auto	Min



Step 6: Perform Calculations

Wiz Manufacturing MultiStation

1. Click the “Check” and button fix any problems flagged  Check

2. Click the “Solve” button to calculate  Solve

A0120

Machine 1		
Cycle Time_M	10	Sec
Qty Per Cycle_M	1	Item
Stations_M	3	Stn
Activity Time_M	12	Hr/Day
OEE Percent_M	98	%
Cycle Time Per Item	0.06	Min
CT Capacity Per Day	12960.00	Item
All Stations Time	36.00	Hr/Day
QPC Contributor	12960.00	ItSq
Capacity Per Day	12700.80	Item

A0130

Machine 2		
Cycle Time_M	15	Sec
Qty Per Cycle_M	1	Item
Stations_M	2	Stn
Activity Time_M	10	Hr/Day
OEE Percent_M	98	%
Cycle Time Per Item	0.13	Min
CT Capacity Per Day	4800.00	Item
All Stations Time	20.00	Hr/Day
QPC Contributor	4800.00	ItSq
Capacity Per Day	4704.00	Item

A0140

Machine 3		
Cycle Time_M	1	Min
Qty Per Cycle_M	4	Item
Stations_M	1	Stn
Activity Time_M	14	Hr/Day
OEE Percent_M	95	%
Cycle Time Per Item	0.25	Min
CT Capacity Per Day	3360.00	Item
All Stations Time	14.00	Hr/Day
QPC Contributor	13440.00	ItSq
Capacity Per Day	3192.00	Item

Units	
	Day
	14
	Hr

3

When complete, note that all blue values show calculated results. The values for the equivalent machine have been calculated from the three individual machines.

Z0010

Multiple Station Equiv.		
Cycle Time	0.29	Min
Qty Per Cycle	1.48	Item
Stations	6.00	Stn
OEE Percent	97.52	%
Activity Time	11.67	Hr / Day
MS CT Capacity Per Day	21120.00	Item
MS Capacity Per Day	20596.80	Item
MS Cycle Time Per Item	0.03	Min