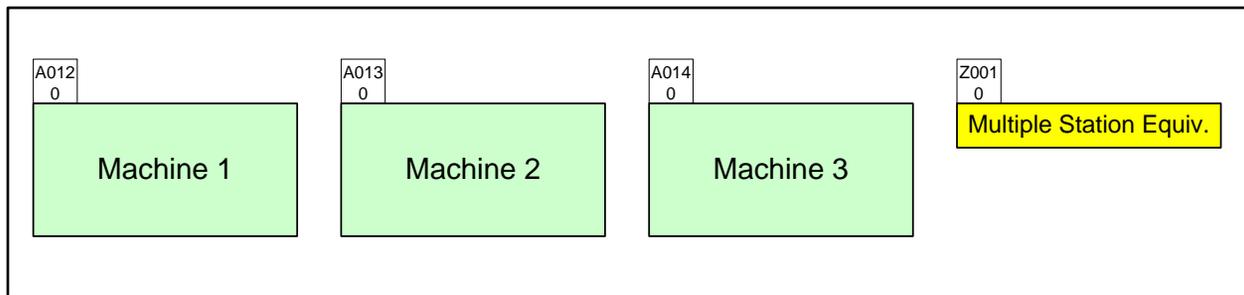


Manufacturing Multi Station Wizard Tutorial

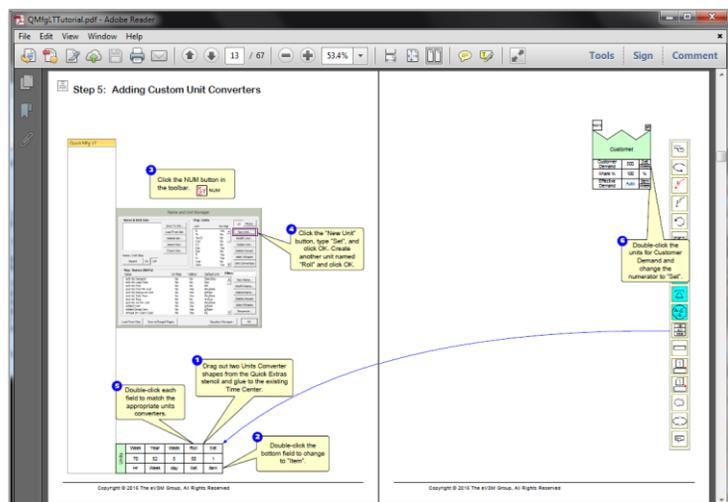
This tutorial will guide you through the steps to draw a simple map and perform common calculations using the Manufacturing Multi Station Wizard.



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

1 On your Desktop, click the "Start eVSM" icon.

2 If you see a message like this, you must "Enable" macros.

3 Click to enable macros.

4 Click "Trust all from publisher" to avoid the security notice in future.

Recycle Bin

Start eVSM

Microsoft Visio Security Notice

Microsoft Office has identified a potential security concern.

Note: The digital signature is valid, but the signature is from a publisher whom you have not yet chosen to trust.

File Path: C:\Program Files\evsm\Setup\Solutions\evsmIcons.vss

Macros have been disabled. Macros might contain viruses or other security hazards. Do not enable this content unless you trust the source of this file.

[More information](#)

[Show Signature Details](#)

Trust all from publisher Enable Macros Disable Macros

Step 2: Learn eVSM Basics

Wiz Manufacturing MultiStation

2

Avoid re-sizing eVSM shapes. Instead grow the drawing page when needed. To resize the page, hold down the "Ctrl" key, and then drag any page edge to the required size. This method works on all four edges of the page.



5

Save your Visio file and then insert a new page via the right-mouse menus on the page-tabs.

VSM

Quick_eVSM

1

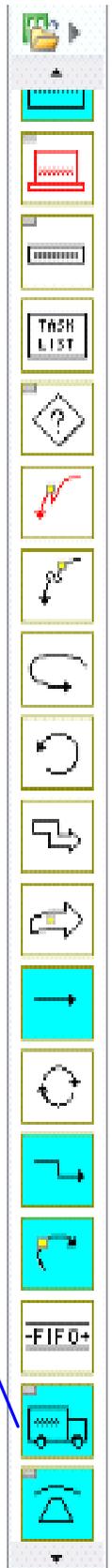
eVSM Help resources are available in the Learn module of the toolbar. Hover over each one to see what they do.

3

Blue icons in the main stencil represent families of shapes. Drag out the Transport icon.

4

Use the shape's right-mouse menus to turn it into a car



Step 3: Initiate the map for Manufacturing Multi Station Wizard

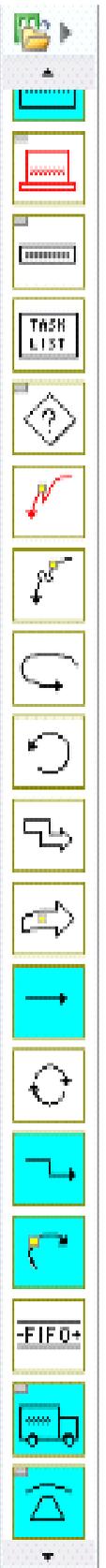
1 Click the Open button. Select Mfg Multi Station and click OK.  Open

2 The Manufacturing Multi Station Wizard stencil will open on the left.

3 Drag out the red icon first. This is very important!

4 Enter the amount of hours per day.

| | |
|-------|-----|
| Units | Day |
| | 14 |
| | Hr |



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.

Wiz Manufacturing Multistage



Activity Center

A012
0

| | | |
|---------------------|------|--------|
| 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 |

A013
0

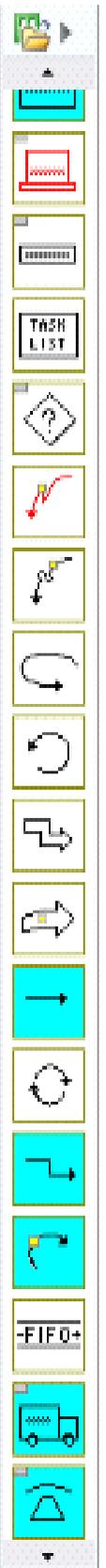
| | | |
|---------------------|------|--------|
| Machine 2 | | |
| Cycle Time_M | 15 | Sec |
| Qty Per Cycle_M | 1 | Item |
| Stations_M | 2 | Stn |
| Activity Time_M | 10 | Hr Day |
| OEE Percent_M | 98 | % |
| Cycle Time Per Item | Auto | Min |
| CT Capacity Per Day | Auto | Item |
| All Stations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

A014
0

| | | |
|---------------------|------|--------|
| 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 be calculated later.

| | |
|-------|-----|
| Units | Day |
| | 14 |
| | Hr |



Step 5: Multi-Station Summary

Wiz Manufacturing MultiStation



Multi-Station Summary

| A012 0 | | |
|---------------------|------|-----------|
| 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 |

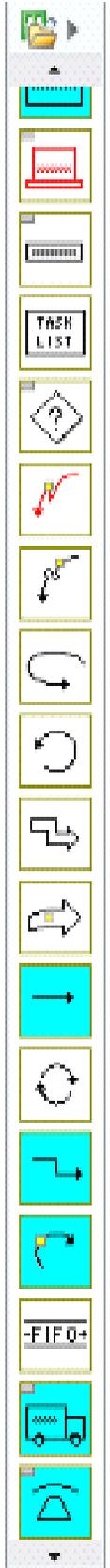
| A013 0 | | |
|---------------------|------|-----------|
| Machine 2 | | |
| Cycle Time_M | 15 | Sec |
| Qty Per Cycle_M | 1 | Item |
| Stations_M | 2 | Stn |
| Activity Time_M | 10 | Hr Day |
| OEE Percent_M | 98 | % |
| Cycle Time Per Item | Auto | Min |
| CT Capacity Per Day | Auto | Item |
| All Stations Time | Auto | Hr Day |
| QPC Contributor | Auto | ItSq |
| Capacity Per Day | Auto | Item |

| A014 0 | | |
|---------------------|------|-----------|
| 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.

| | | |
|---------------------------|--------------------------------|-----------|
| Z001 0 | 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

1 Click the "Check" and button fix any problems flagged  Check

2 Click the "Solve" button to calculate  Solve

Wiz Manufacturing MultiStation

| | | |
|---------------------|--------------|-----------|
| A012 0 | | |
| 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 | 12960.0 0 | Item |
| All Stations Time | 36.00 | Hr Day |
| QPC Contributor | 12960.0 0 | ItSq |
| Capacity Per Day | 12700.8 0 | Item |

| | | |
|---------------------|---------|-----------|
| A013 0 | | |
| 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 |

| | | |
|---------------------|--------------|-----------|
| A014 0 | | |
| 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 | 13440.0 0 | ItSq |
| Capacity Per Day | 3192.00 | Item |

| | |
|-------|-----|
| Units | Day |
| | 14 |
| | Hr |

