

Eagle Reporting System

Owner's Report



Company: Eagle

Machine	Laser power	Machine type	Machine acronym	Automation
iNspire1530	20 kW	iNspire	iNspire1530	Crane Master Store

Report dates:

01.03.2021 - 30.03.2021

Report created:

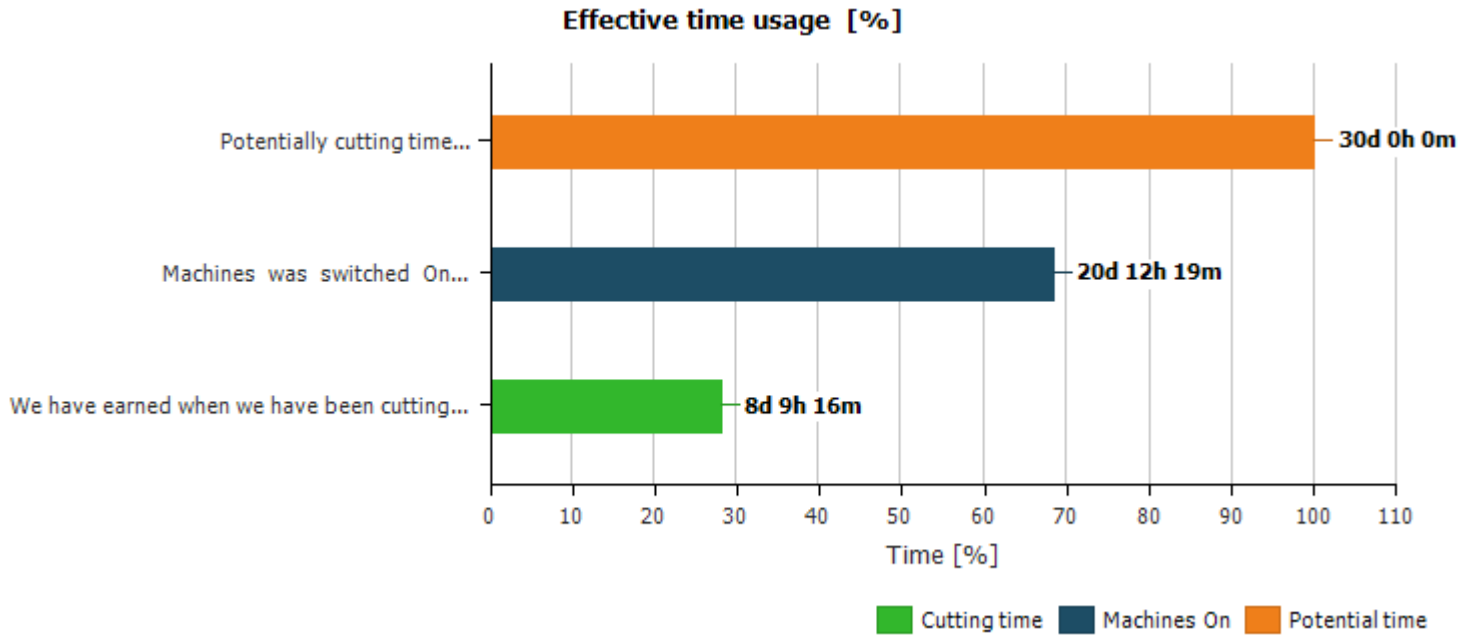
30.03.2021 08:25

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1. Time usage analysis.

Time usage analysis shows in general how efficient was our work during the reported time period. Reference : 100% = Summary for all machines.



DEFINITION

EXPLANATION

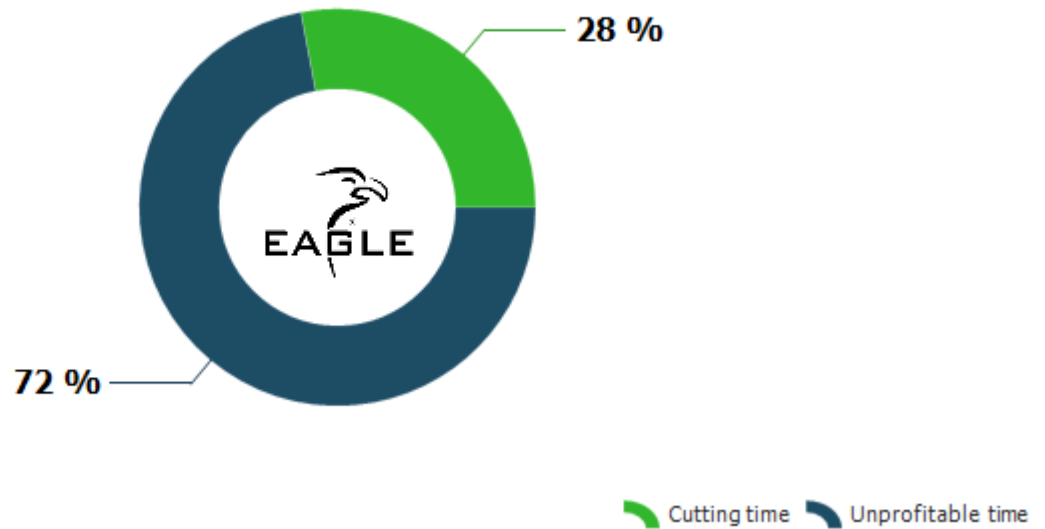
Cutting time	Time used for cutting on the machines in the reported time period – we have been earning while we have been cutting.
Machines On	Time, when the machines were switched On in the reported time period – we have been working on the machines.
Potential time	The whole time period – we could have been working. All machines summary.

	Cutting	Machines On	Potential time
Time	8d 9h 16m	20d 12h 19m	30d 0h 0m
Percent [%]	28	68.38	100.00

1.1 Time usage analysis – cutting time.

Time usage analysis – cutting time. Shows how much time we used for cutting during the whole time period of the report. Reference : 100% = Summary for all machines.

Effectiveness time usage [%]



DEFINITION

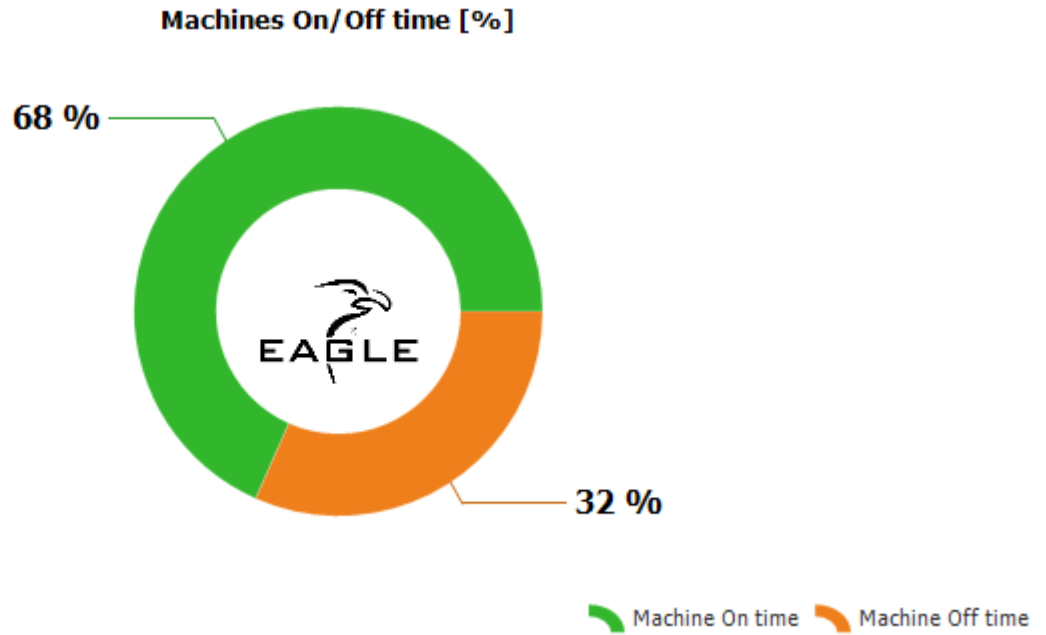
EXPLANATION

Cutting time	Time used for cutting on the machines in the reported time period – we have been earning while we have been cutting.
Unprofitable time	Time in the whole reported time period when the machines were not cutting.

	Cutting	Unprofitable time
Time	8d 9h 16m	21d 14h 43m
Percent [%]	27.96	72.04

1.2 Time usage analysis – machines time.

Time usage analysis – machines time. Shows for how long the machines were switched On during the whole time period of the report. Reference : 100% = Summary for all machines.



DEFINITION

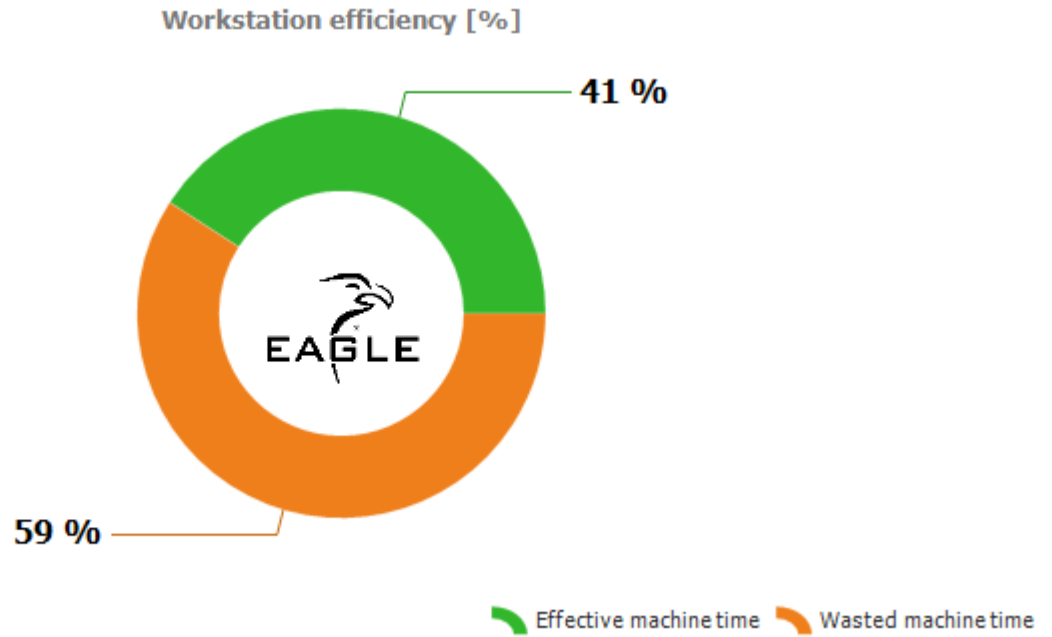
EXPLANATION

Machines On	Time when the machines were switched On during the whole reported time period.
Machines Off time	Time when the machines were switched Off during the reported time period.

	Machines On	Machines Off time
Time	20d 12h 19m	9d 11h 40m
Percent [%]	68.38	31.62

2. Workstation efficiency.

Workstation efficiency – shows how much time was used for cutting while the Machines were switched On during the whole reported time period. Reference time: 100% = Machines On summary.



DEFINITION

EXPLANATION

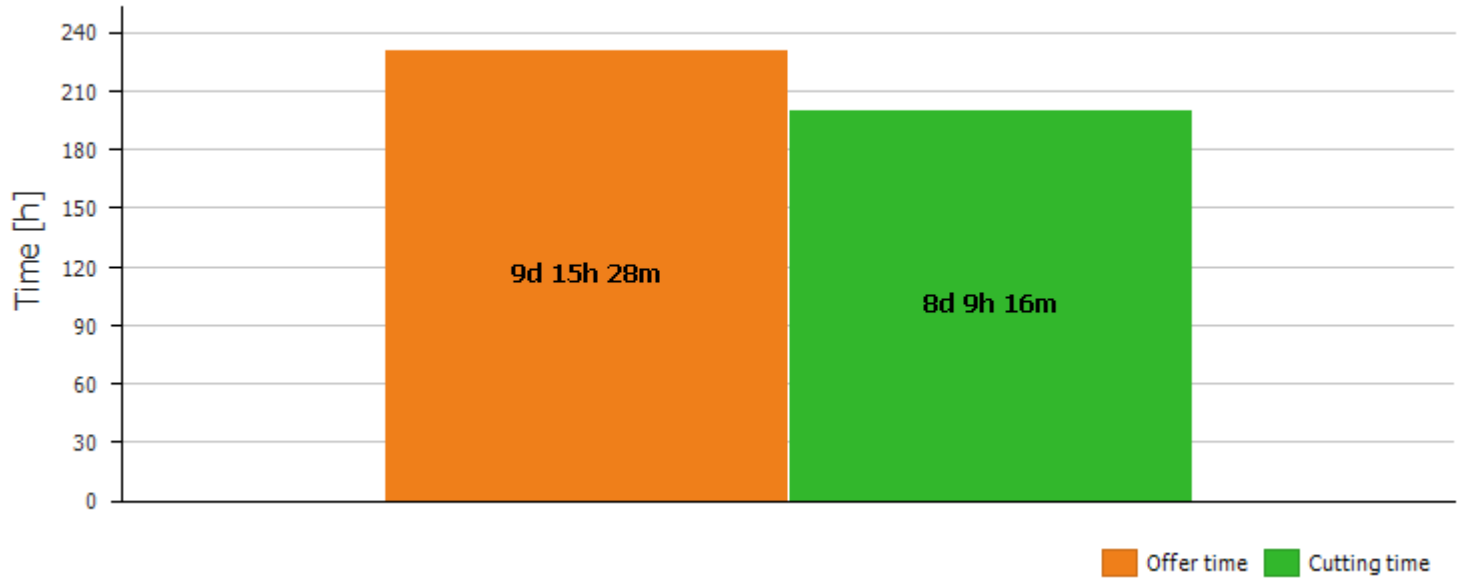
Effective machines time	Time used for cutting when machines were switched On.
Wasted Machine Time	Time of unjustified idleness of the machine when the machines were switched On.

	Effective machines time	Wasted Machine Time
Time	8d 9h 16m	20d 12h 19m
Percent [%]	40.88	59.12

3. Offer time.

Offer Time – shows the difference between the estimated time and the real cutting time of all programs executed during the whole reported time period.

Comparison of actual time and offer time



DEFINITION

EXPLANATION

Offer time	Estimated cutting time for all programs executed during the reported time period.
Cutting time	Actual cutting time of all programs executed on the machines.

	Offer time	Cutting	Difference
Time	9d 15h 28m	8d 9h 16m	-1d -6h -11m
Percent [%]	100	87	13

Note: Programs without time estimation are not included in this report.

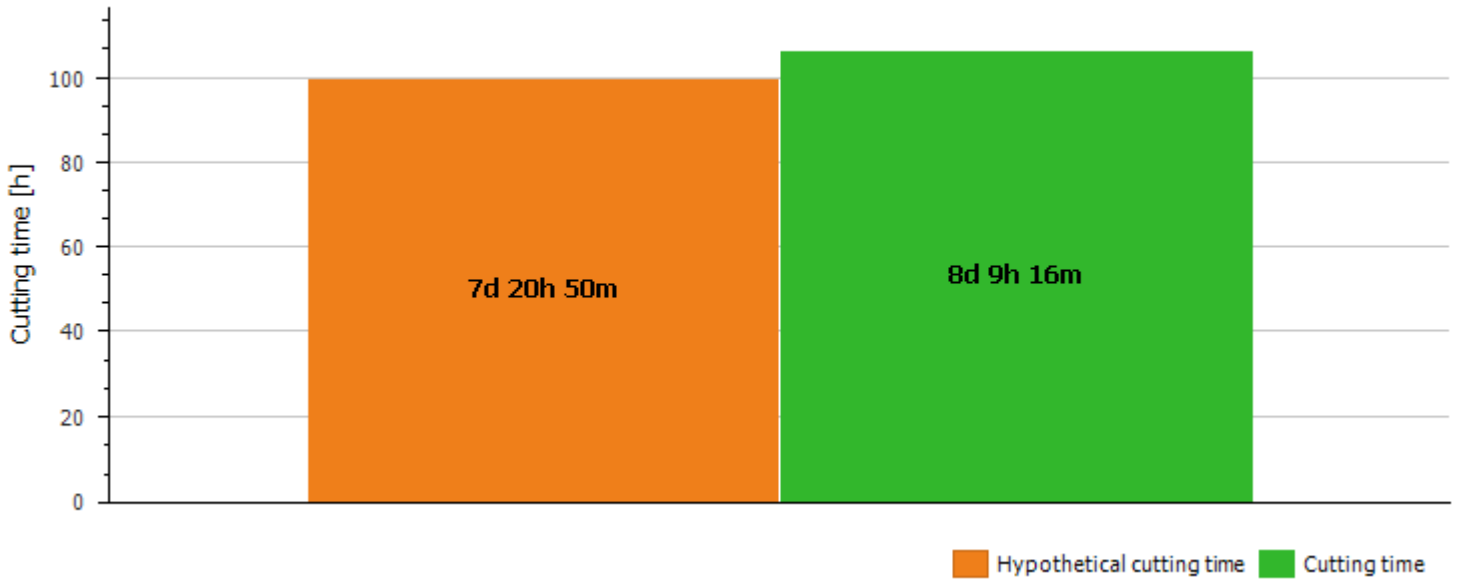
4. Override inspection.

Override inspection – shows how much actual cutting time was changed relatively to hypothetical cutting time because of change of override value and other cutting parameters on the machine during the reported time period.

Reference time: 100% = Hypothetical cutting time.

Average override [%] **94**

Decrease of efficiency



DEFINITION

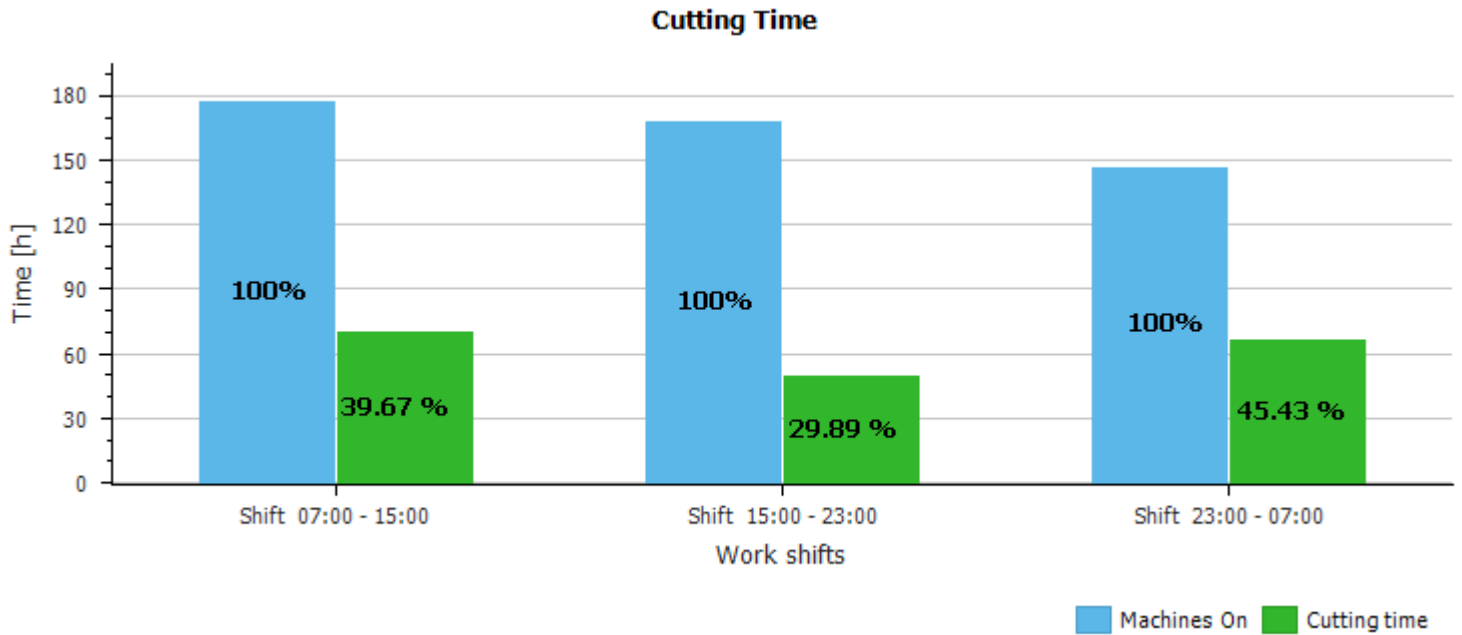
EXPLANATION

Hypothetical cutting time	Presumed cutting time if the cutting parameters had not been modified.
Cutting time	Actual time used on the machine for executing all programs with changed cutting parameters.

	Hypothetical cutting time	Cutting	Difference
Time	7d 20h 50m	8d 9h 16m	0d 12h 26m
Percent [%]	100	106	6

5. Work shift information - cutting.

Work shift information shows the relation between the cutting time and machines On time on each shift.



DEFINITION

EXPLANATION

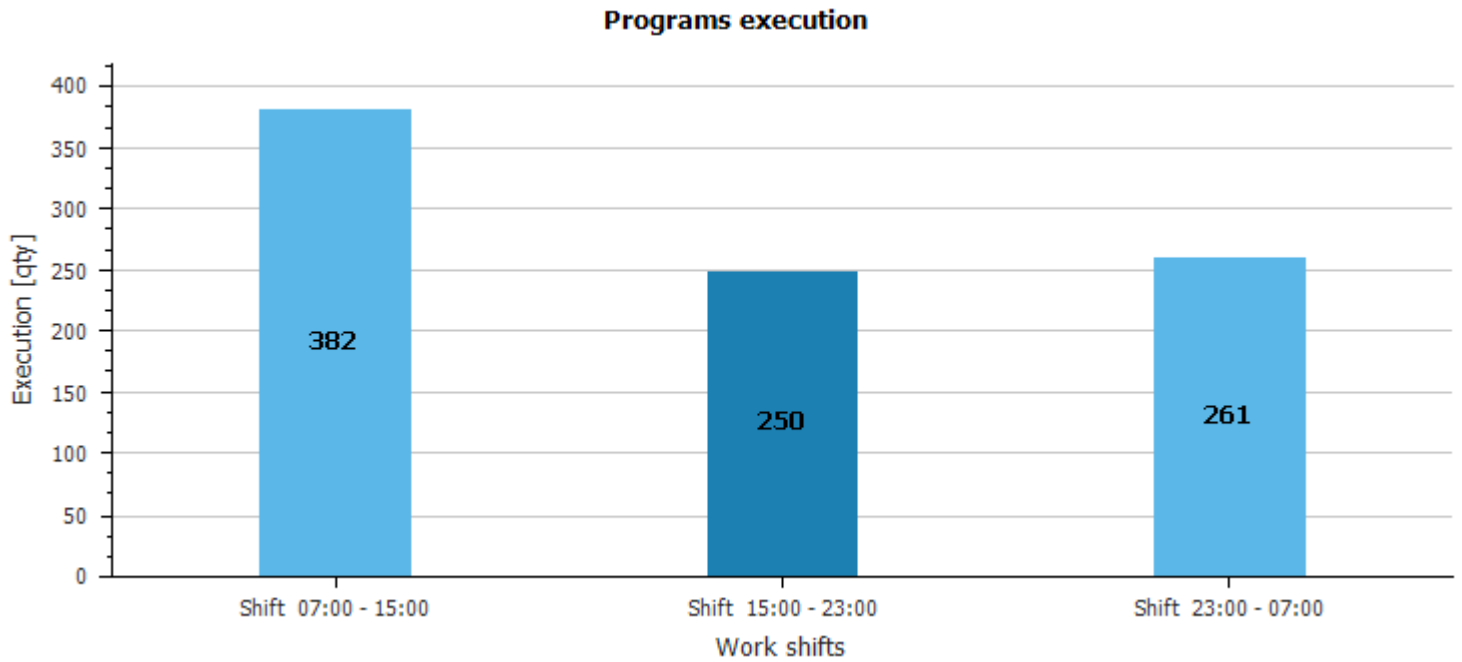
Cutting time / Machines On time

The time used for cutting during the shift, and the time when machines were switched On during the work shift.

Shift	Machines On	Cutting	Cutting [%]
07:00 - 15:00	7d 10h 11m	2d 22h 41m	39.67
15:00 - 23:00	7d 1h 20m	2d 2h 37m	29.89
23:00 - 07:00	6d 3h 28m	2d 18h 59m	45.43

6. Work shift information - programs.

Work shift information shows the number of executed programs on each shift.



DEFINITION

EXPLANATION

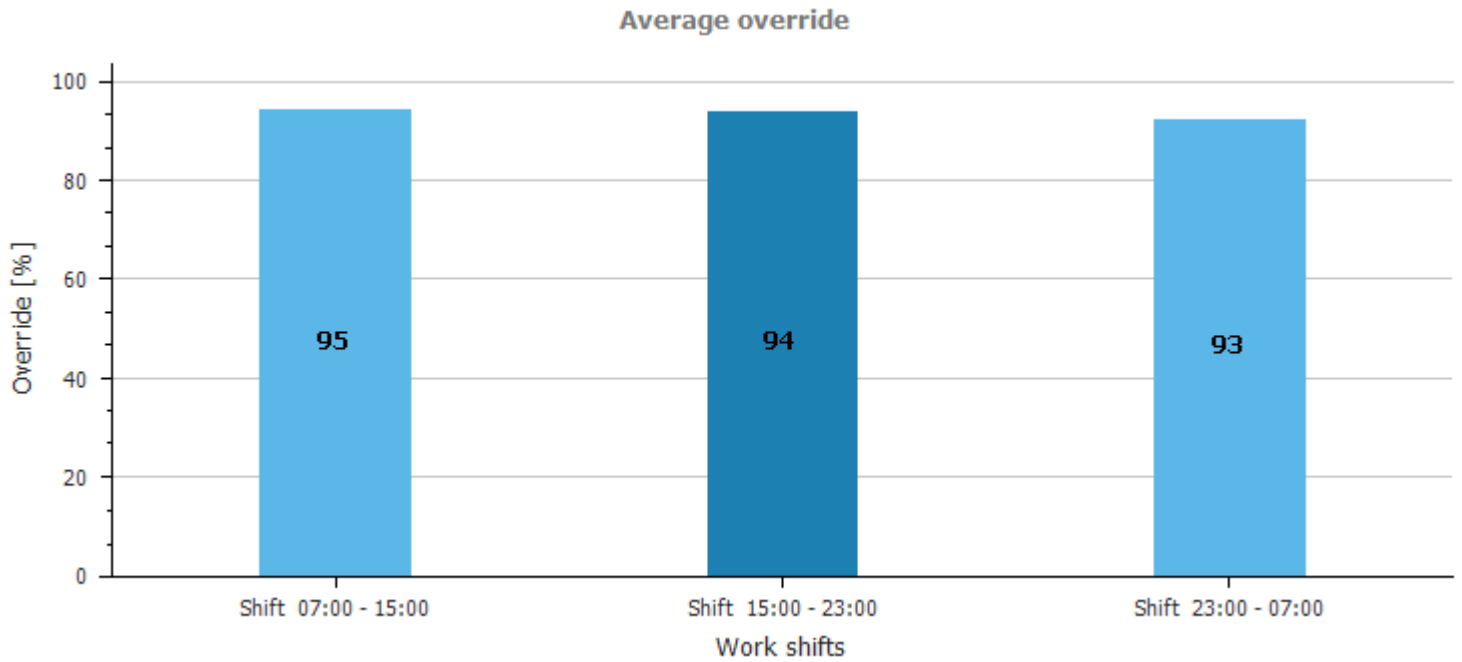
Programs number

Amount of the programs executed on the work shift.

Shift	Program exec [qty] Total
07:00 - 15:00	382
15:00 - 23:00	250
23:00 - 07:00	261

7. Work shift information - override.

Work shift information shows which work shift changes mostly the cutting parameters.



DEFINITION

EXPLANATION

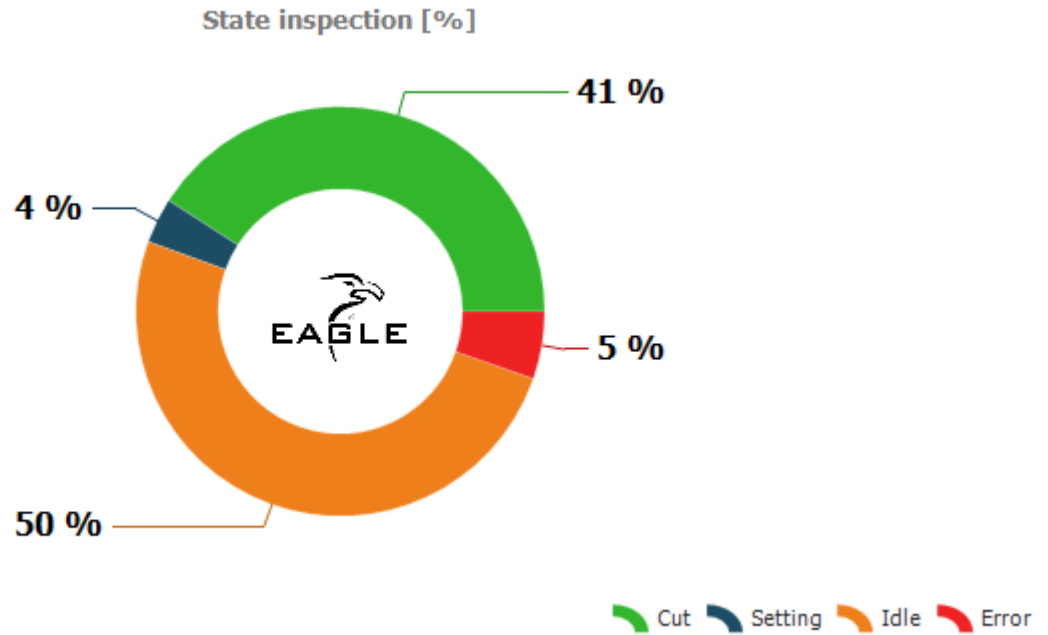
Average override

The average override was made during the work shift.

Shift	Average override Total
07:00 - 15:00	95
15:00 - 23:00	94
23:00 - 07:00	93

8. Machines state inspection.

Machines state inspection shows the total time that machines spent on every state during the reported time period. Reference time: 100 % = Machine On time, summary for all machines.



DEFINITION

EXPLANATION

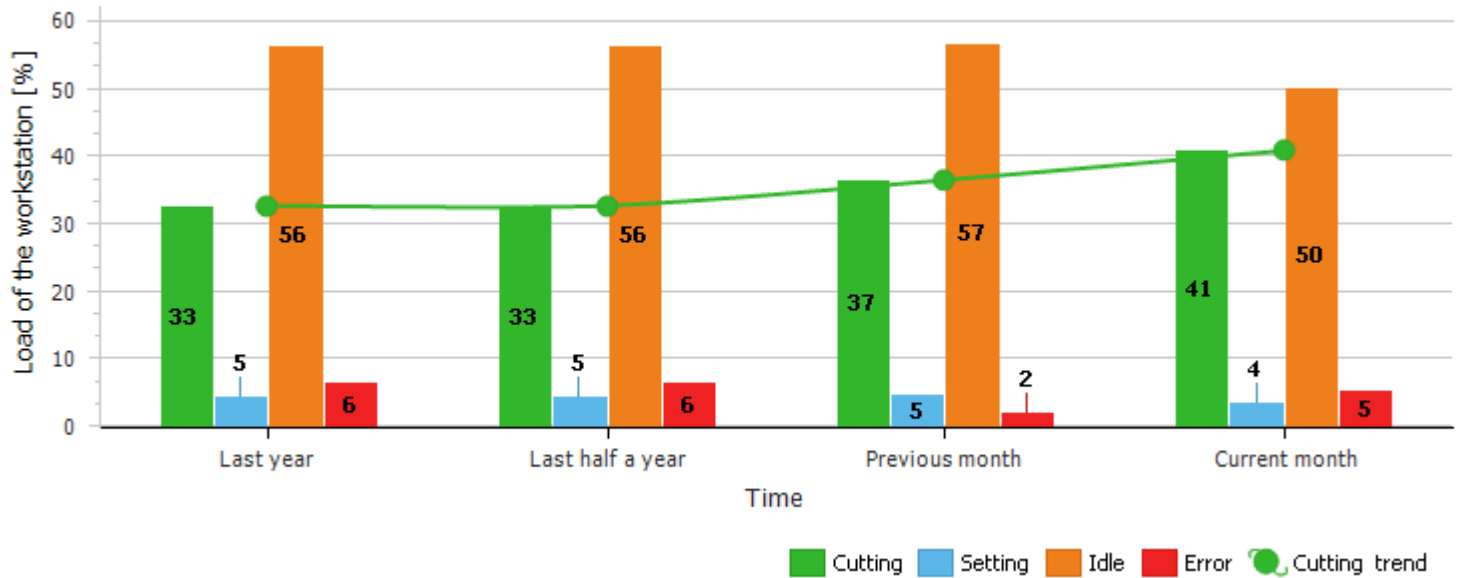
Cutting	Time used for cutting on the machines during the reported time.
Setting	Time used for settings and preparing machines for cutting while machine was switched ON.
Idleness	Time of no activities on the machines.
Error	Machines in error state.

	Cutting	Setting	Idleness	Error
Time	8d 9h 16m	0d 17h 36m	10d 7h 13m	1d 2h 12m
Percent [%]	40.88	3.58	50.22	5.32

9. Historical information.

Comparison of previous periods of machine state inspection. Reference time: 100% = Machines On time, summary for all machines.

Historical data (state inspection)



DEFINITION

EXPLANATION

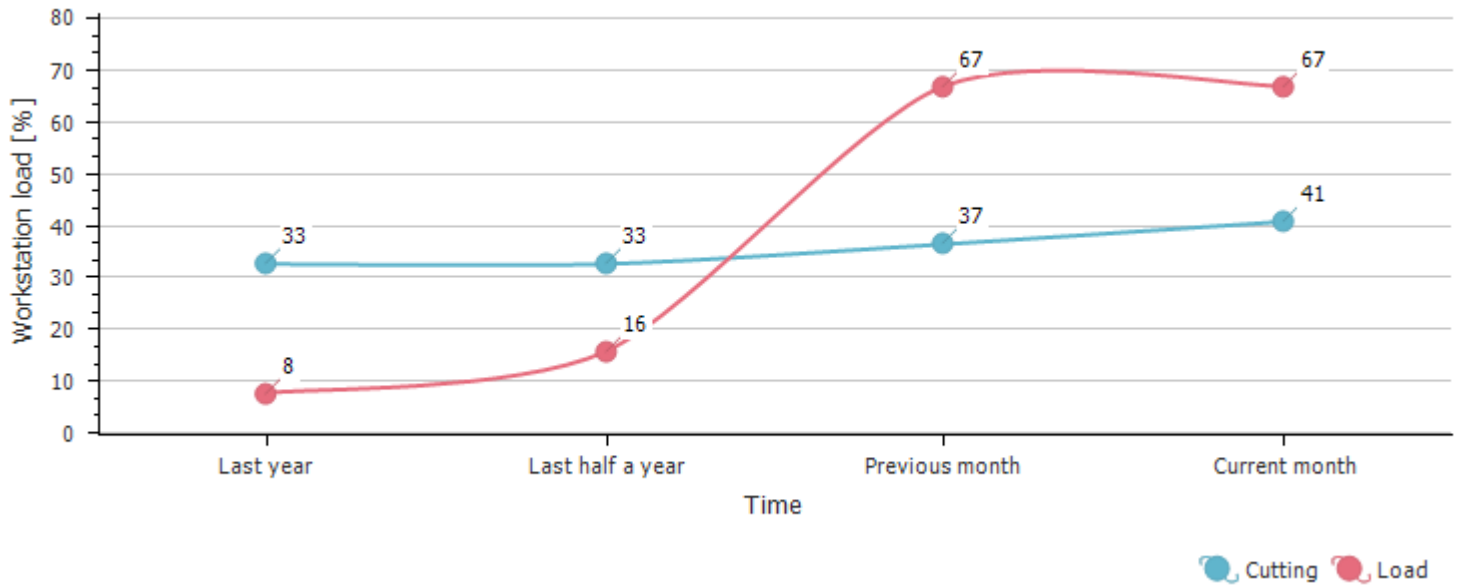
Cutting	Time used for cutting on the machines during the reported time.
Setting	Time used for settings and preparing machines for cutting while machines were switched ON.
Idleness	Time of no activities on the machines.
Error	Machines in error state.

Range	Cutting	Setting	Idleness	Error
Last year	32.73	4.51	56.31	6.45
Last half a year	32.73	4.51	56.31	6.45
Previous month	36.53	4.78	56.69	1.99
Current month	40.88	3.58	50.22	5.32

10. Direct performance information.

Direct performance information shows the relation between the load of the workstation and the cutting time. It shows how the performance changes when the load of the workstation change. Reference time: 100 % = Machine On time, summary for all machines.

Historical data performance information



DEFINITION

EXPLANATION

Cutting time

Time used for cutting on the machines during the reported time period.

Workstation load

The proportion when machines were switched on during the whole reported time period. Error state time is not included in this chart.

Range	Cutting [%]	Workstation load [%]
Current month	41	67
Previous month	37	67
Last half a year	33	16
Last year	33	8