



Process: B Pillar AC LH (Lamination 6)

Act Process Cycle Time: 65s

Shift: 1st

Start Time: 10:50 A.M

End Time: 12:50 P.M

Date: 6/16/2021

		Hour 1				Hour 2																																																																																																																		
Part / Variant	Beige	Beige	Beige	Beige	Beige	Beige	Beige	Beige	Beige																																																																																																															
Target Cum Good Parts	14	14	14	14	14	14	14	14	14																																																																																																															
Act Good Parts	12	8	12	11	10	1	0	4	4																																																																																																															
Cum Good Parts	12	20	32	35	45	46	46	58	58																																																																																																															
Not Accounted For (Cumulative)	-2	-6	-2	-3	-4	-13	-14	-10	-10																																																																																																															
Time Minutes	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120
Cycle Occurrence	[Color-coded bars representing cycle occurrences]																																																																																																																							
Scrap Losses	[Grid for scrap losses with a central note: No Major Scap Issues During Observation]																																																																																																																							
PROCESS RUNNING	[Green bar indicating process running time]																																																																																																																							
Downtime Losses	[Grid for downtime losses with callouts: 33 Min Break, 5 Min Poor Start Up, 1min, 2min Temporary Color Change, 2min Punch Ring Fault, 3min Early Break, Lunch Break 30min, 5min Nonchalant Start-Up]																																																																																																																							
Late From break																																																																																																																								
Break	33 Min																																																																																																																							
No Order In GRP																																																																																																																								
Tool Down																																																																																																																								
Re-Packing																																																																																																																								
Poor Start Up	5 Min																																																																																																																							
No People																																																																																																																								
Punch Ring	2 Min																																																																																																																							
No Packaging																																																																																																																								
Change over	3 Min																																																																																																																							
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Glue Mc Down																																																																																																																								
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MC Down Maint.																																																																																																																								