

CPMS Newsletter

“As the Wrench Turns”

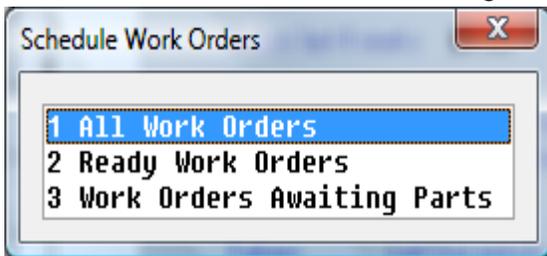
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Are you assigning parts to your Work Orders properly?

Your PM Work Cards should normally only be checks, inspections, and lubrication. Parts should be used in Work Orders and Equipment Failures. The ability to add Required Parts to Work Orders has been available for years but many plants do not use this valuable feature. The difficulty is that in most cases the Work Order planner is not the person who receives parts, and so they don't know when a Work Order which is Awaiting Parts is "Ready".

Recently we were at a plant where they are doing an excellent job in preparing Work Orders for mechanics. And, we saw an opportunity to add a new feature to Work Order Scheduling.



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Counting PM Duties in your Work History Detail report

When evaluating your Master Schedule and how you have spread your PM work across your mechanics, this new report will be very helpful.

WORK HISTORY - Detail & PM Duties

From: 08/03/06 To: 08/09/06

INTER

| <u>Mechanic</u> | <u>Schedule Minutes</u> | <u>Actual Minutes</u> | <u>Actual Overtime</u> | <u>PM Duties</u> |
|-----------------|-------------------------|-----------------------|------------------------|------------------|
| 2 WEEKS | | | | |
| FROEBOL, ISSAC | 31 | 31 | 0 | 3 |
| MONTHLY | | | | |
| FROEBOL, ISSAC | 31 | 31 | 0 | 2 |
| 2 WEEKS | | | | |
| FROEBOL, ISSAC | 3 | 3 | 0 | 4 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 2 | 2 | 0 | 4 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 4 | 4 | 0 | 16 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 2 | 2 | 0 | 16 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 2 | 2 | 0 | 1 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 15 | 15 | 0 | 1 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 15 | 15 | 0 | 1 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 2 | 2 | 0 | 2 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 11 | 0 | 0 | 0 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 31 | 31 | 0 | 2 |
| 2 WEEKS | | | | |
| FROEBOL, ISSAC | 9 | 9 | 0 | 3 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 31 | 31 | 0 | 2 |
| 2 WEEKS | | | | |
| FROEBOL, ISSAC | 11 | 11 | 0 | 4 |
| WEEKLY | | | | |
| FROEBOL, ISSAC | 31 | 31 | 0 | 3 |
| 2 WEEKS | | | | |
| FROEBOL, ISSAC | 3 | 3 | 0 | 3 |
| WEEKLY | | | | |
| SUBTOTAL: | 575 | 564 | 0 | 98 |
| TOTAL: | 2663 | 2594 | 5 | 727 |

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Compare your Work Order process with this one.

- When Work Orders are entered, parts are added using the Required Parts button.
- If all required parts are on hand, the parts are pulled and the Work Order Work Card and necessary parts are issued to the mechanic.
- When complete, the Work Order and part tags used are returned to the Planner.
- The actual parts required are identified when the Work Order is closed.
- A rack of shelves is in the Work Order “staging area” for those Work Orders which are Awaiting Parts.

In CPMS 3.1, when you go to Work Order Scheduling, all of those Work Orders which have parts assigned to them are evaluated. Work Orders where all the Required Parts are less than or equal to the Quantity On Hand are changed to “Ready”, and those with any Required Parts greater than the Quantity On Hand are changed to “Awaiting Parts”.

In the example on the preceding page note the subtotal and total for mechanic Froebol. He completed 98 individual PM duties on this week’s PM Work Card which took him about 10 hours. Note that the PM’s missed have a zero in both the Actual Minutes and PM Duties column.

It is true that we can’t evaluate what we don’t measure. In this example, the mechanic takes about 6 minutes to perform each PM Duty. (600 minutes divided by 100 duties.) The average for all the mechanics is 4 minutes for each PM Duty.

What we found when evaluating the PM schedule at some of our customers was where two mechanic doing PM on virtually the same equipment on different lines had different PM times for the same PM duties. Either one man was doing a more thorough job or possibly taking too long.

In addition to having a valid Work Load Balancing graph, this is another reason to try and have good Schedule Minutes estimates in your Master Schedule.

And the Winner is...

Once again, Renee Gable from Canada Bread, Langley, BC, was our winner. She received half credit for our last newsletter quiz.

You may recall it was a two part question. She answered the second half correctly where we asked how you would combine all the data from two different Vendor Idents when they should have been just one. (Use Supervisor, Change Key Column.)

The other question asked how you would identify the spare parts which are used on a piece of equipment which has been removed from your plant. You can remove parts from your spare parts room if they are only used on this equipment. Some folks answered you just need to print out the Parts/Equipment-Xref report. It’s a little more involved. You need to print out all the parts which are used on the equipment being removed and not used on any other equipment. See Tips and Techniques on the next page.

CPMS Quiz

Anytime stock parts are ordered, received, or issued, a part transaction is added to Part Transactions (Open). When you process Part Transactions, all of the transactions are moved to the Part Transactions (Closed) table, unless there is a quantity error. In addition, every time a Part Number is Issued to an Equipment Number, a new entry is added to the Parts/Equipment-Xref table (unless it has already been added).

Can you think of one or more reasons why you should use the Part/Equipment X-Ref table to determine if parts are no longer needed for an obsolete machine, as opposed to using Part Transactions (Closed)?

Tips and Techniques

1. So, when removing equipment from the plant, what parts can be removed? This was a little more involved than intended. In fact, we will add it to Inventory Utilities as a special report so you don't need to remember the two part condition.

When making any Queries in CPMS, you need to first decide what table(s) you need to use and then what condition is needed. The answer is to Print Standard Reports for Parts Inventory where parts are used on the equipment number being removed, but those same parts are not used on any other equipment.

Try this out at your plant by copying and pasting the condition below into the Condition box on the Power Search screen. (Assume the equipment being removed from your plant is "B100".)

(PR_NBR IN (SEL PR_NBR FROM XREF WHERE EQ_NBR = "B100") AND PR_NBR NOT IN (SEL PR_NBR FROM XREF WHERE EQ_NBR <> "B100"))

2. When using the Change Key column option to combine two Vendor Idents (same company accidentally entered twice) don't forget to review each entry in the Vendor table. Since one Vendor will replace the other, make sure you have saved any important data from the vendor being replaced. For example, contact info, notes and even combine YTD and LTD sales.

3. Sometimes a company file server does not have the correct printer driver for all printers, particularly for older models. This may affect the CPMS graphs. As a "workaround" you can save the graph as a PDF file and then print it.

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