

CPMS Newsletter

“As the Wrench Turns”

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PM Scheduling

After adding all of your plant equipment to CPMS then it is only a matter of identifying what needs to be done, and how often, to keep each machine running properly. What could be easier!

The challenge at almost every plant is to get your mechanics to “buy in” to more accountability. And, they must always turn in their PM work card at the end of the week, even if they haven’t completed all of their PM assignments.

The CPMS scheduling philosophy is to give the mechanics PM assignments which should rarely be more than 50% of their work week. Work Orders, Breakdown repair, Projects, etc., should make up the rest of their hands on tasks. CPMS will automatically reschedule PM tasks which were not completed (except for Weekly).

PM should primarily be inspection and lubrication. Problems found when performing PM should result in repairs (Work Orders). Some plants include Predictive Maintenance as some of their PM activity. A part may be replaced even though it appears to be OK, based upon its projected life and how critical it is to your operation.



All work falls into one of three major categories:

- Preventive Maintenance
- Work Orders (planned repair)
- Breakdown Repair (unplanned repair)

If you spent half an hour performing PM tasks on a piece of equipment and then spent an hour making a necessary repair, those two activities should be entered separately. Thirty minutes for PM and sixty minutes for the associated Work Order.

Mechanics know that they will see any PMs they missed on their PM Work Card next week. And, when processing work cards, you can give the mechanic credit for the individual PM tasks which were completed and only the residual tasks will be printed on his PM work card for next week.

The goal is that once your Master Schedule is complete, then generating, printing and processing your PM work cards is virtually automatic... provided that most of the PMs are being done. A reasonable goal is 80% completion.

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The PM Work Week

One of your early PM decisions is to determine what is the “First Day of Work Card Week”. If you go to Supervisor, System Configuration, and under “Scheduling Options” you will see where you set the first day of the week. This day should correspond to the best day for the PM Planner to process the week which just ended yesterday at midnight, generate the PMs for the week beginning today, and then print out the Detail Preventive Maintenance Work Card for this week.

Scheduling Options-

Last Date Schedule or Actual Schedule

Maximum PM Work Scheduled 50 %

Overtime Calculation 1.5

Reschedule Incomplete Tasks Yes

PM's Assumed Completed Yes

Work Card Report Options WCEdit

First Day of Work Card Week 5 Friday

Default Description Ident for:

Equipment Downtime DT DOWN TIME

Work Orders WO WORK ORDER

Residual PM Tasks PM RESIDUAL PM TASKS

Equipment Failure Notes BEFORE THE

Equipment Failure Signature Lines Mechanic: _____

Here are some considerations:

- Choose the best day of the week where the Planner has an hour or so to perform this important task. The amount of time depends on how many PM's were missed last week and how many Work Orders (as a result of PMs) need to be entered.
- Make any necessary corrections to the Master Schedule before generating this week's PMs. For example, any changes to Equipment Numbering, PM frequency, or the assigned mechanic.
- In order to avoid a situation where the PM Planner is not available to generate next week's PMs, you can generate the PM schedule for two weeks but you still generate weekly. And, you still Process and Print every week.

- By design, you cannot generate a PM schedule in the past. If you showed an auditor how to generate and process PMs for a week that was missed, the integrity of your PM program would be in question. But, if important PMs were not scheduled we can show you how to schedule them the following week.

Changing the First Day of the Work Card Week

As you have seen when using CPMS, the default date which pops up when generating, processing, and printing your PMs, always correspond to your “First Day of Work Card Week”. If you are in the middle of your work week and go to generate PMs, you will see the first day of the next work week.

When processing PM's you will see the oldest work week which has not been processed. You should not generate PMs for next week before processing the week which just completed. In order to have good PM history and accurate reports, always keep your PM schedule current.

Although you can change the start of the work week day it is something that should seldom occur. Remember, it is the date that works best for the Planner but it is also good for the mechanics and the maintenance department work flow. If you move the date forward you must make sure you don't leave “holes” in your calendar. If you move the date back, you don't want to overlap processing or generating days.



In this example we will change the First Day of the Work Card from Monday to Wednesday. Your work week use to end at midnight on Sunday and so on Monday you still want to process the week which just finished and generate the new week beginning on Monday. But, only print out PM work cards for Monday and Tuesday. On Wednesday you can change the System Configuration to your new First Day of the Work Card from Monday to Wednesday.

It is best to have a two day work card in order to begin your new schedule. So, on Wednesday process “last week” which is just Monday and Tuesday. You may see a warning message since you are overlapping into dates which have already been process. Now generate for the new week beginning on Wednesday. Remember that it is OK to generate a PM schedule more than once since it will replace the existing schedule. The old schedule will be deleted and replaced by the new schedule, except for any PMs which were missed from the prior week which are automatically rescheduled with a priority of “1”.

And the Winner is...

We had two winners in the last CPMS Newsletter contest who answered the Quiz “half right”. Pam Coleman from Lewis Bakeries, Evansville, IN and Ken Redden from Klosterman Bakery, Morristown, IN.

The question was: You have equipment B100 and B101 in the Master Schedule which both have their own PM duties. One day you realize that they are virtually identical because any time you change the PM duties for B100 you are entering the same changes for B101. List the steps you would take so that they share the same PM duties and any change made to either are automatically used by the other machine.

We were hoping that someone would remember that before you change the procedure number to a different equipment number, make sure and delete the PM duties for the second (or subsequent) equipment numbers which will be

using the “master number” In the example, you would first delete the PM Duties for B101 and then change the procedure number to B100.

CPMS Quiz

For \$100

If you have equipment numbers which have the following format:

LLN-EEE-DD

Where

LL = Line

N = Line number

EEE = Equipment number

DD = Department

How would you print the Equipment (Standard) report for all the “MU1” line but only for the “PR” department using only one selection condition? For example, Equipment Number CONTAINS “MU1” AND Equipment Number CONTAINS “PR” would be incorrect.

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