

CPMS Newsletter

“As the Wrench Turns”

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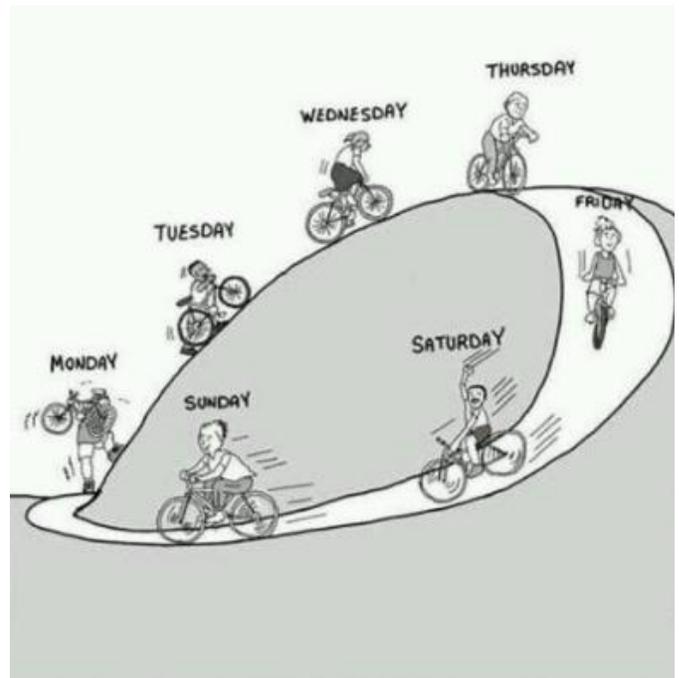
Completing the CPMS cycles

There are numerous cycles within CPMS and when each is completed properly everything falls into place. For example:

- If you use the Work Request cycle which feeds nicely into the Work Order cycle, you will find that adding, assigning, and closing out Work Orders is a lot less work.
- If you use the Purchase Request option you can automatically generate PO's. In addition, part Order and Receipt transactions are automatically created.
- If you use the Part Check Out option, then when you process your Part Transactions (orders, receipts and issues) the Inventory cycle becomes a snap.
- The PM work card cycle consists of processing your PM's at the end of each week, generating PM's for the new week, and then printing out the PM work cards.

If you are not completing these cycles you will need to “band-aid” the portions you are missing. A plant may be using the Purchase Order module which creates order and receipt transactions but

they are manually adjusting part quantities for issues. Consequently, a lot of important part usage history may be lost, such as where and when parts were used.



Check your CPMS work flow cycles to determine if you have any missing links in your “bicycle chain”.

Reviewing your plant's data

We have always offered to review your CPMS data at no charge. Typically we find that there are areas of the program that you are not using or are using improperly. We document our findings and email the customer a Plant Review where we highlight some of the simple things you can do to use CPMS more effectively and take advantage of functions you are not using. Remote or onsite training is a great way to make your maintenance department more productive.

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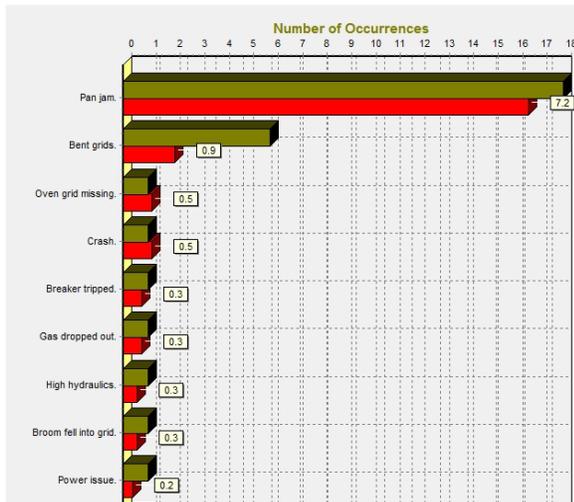
As we go through a plant's data base we make a list of CPMS functions where you "made a wrong turn" or are using the function improperly. We will point out where just a few simple changes in your daily routine will make using CPMS a lot easier and can provide better and more complete reports to your management.

Recently we reviewed a plant's CPMS files and as we went from one function to the next it was very hard to find anything they were doing wrong. By way of example, when printing the Equipment Failures reports you can select the Failure Trends as shown below.

July 5, 2017 2:36 PM Selection: L1-D-400, #1 Oven By Occurrences Page 1 of 1 Your Bakery Name

Equipment Failure Trends

From: 01/01/14 To: 06/23/17



Note that "Pan jam" had 18 occurrences and 7.2 hours of downtime, and "Bent grids" had 6 occurrences and .9 hours of downtime.

By using consistent Failure Descriptions the same problem will be totaled correctly. You don't need to remember how you entered the problem the last time since the popup menu will show you. Just enter "pan" or "jam" and matching failure descriptions (only for that equipment number) will popup.

In this example, 70% of all failures on this equipment were either from "pan jams" or "bent grids" and may be a good place to focus your maintenance efforts. But, as with all equipment problems, after determining the "root cause" and recommended solution, replacing the equipment may not be an option. Working around problems and implementing "temporary fixes" may be required and is an important maintenance skill.

Check Quality of Your Data

If you go to Supervisor, Data Base Analyzer, you will see functions which locate errors in your CPMS files. In our last newsletter, we discussed the Self Audit functions which provide reports for missing or inaccurate data in important tables like Equipment and the Master Schedule. The Check Data Base Integrity option will locate possible damage to your data base after loss of power or "PC lockup" while you were running CPMS.

The Check Quality of Your Data option shows data which may be "out of range". This can be used for all column values in a table but is particularly helpful for dates, dollars, and quantities. For example, at one plant the Plant Summary showed there was \$12M in inventory and it should have been about \$2M. Check Quality of Your Data for Parts Inventory showed the Maximum value for unit price (PR_UNITP) was \$54,648 and it was actually \$546.48. And, a quantity on hand should have been 10 and it was 1000. Sort column values in descending order to see where one or more high "out of range" mistakes were made.

Work Load Balancing

In an ideal world all the mechanics have the same amount of PM assignments and they are able to complete them each week. Wouldn't that be nice!

While most of our customers are doing a good job of making sure that all production equipment has PM, and at the proper frequency, the work load is not balanced properly. There are a couple of things you should do in order to complete the PM scheduling process.

- As mechanics turn in PM work cards and enter the total number of minutes for the PM Duties, you need to periodically update the Master Schedule with better time estimates.
- Likewise, those PM's which are done less often than weekly need to be spread across the calendar. Print or view the Master Schedule sorted by employee and then PM frequency (greater than weekly). Use the Last Done date to move PM's as necessary. For example, an employee who has 12 monthly PM's should have 3 of them scheduled each week, not all 12 in the same week.
- Generate a temporary PM schedule which doesn't conflict with your actual schedule. For example, if today were 7/6/17, then generate a PM schedule for three months from 8/1/17 to 10/31/17. Next go to Run Programs, PM and Work Order Utilities, and Work Load Balancing. Run the Weekly PM option beginning on 8/1/17. The spreadsheet and graph can be used to make thoughtful changes to PM employee assignments. When finished, go to Run Programs, Schedule Work, and Delete PM Schedule. In this example, the date range is from 8/1/17 to 10/31/17.



And the Winner is...

Pam Coleman, Lewis Bakeries, Evansville, IN, and Tammie Brown, Schwebels Baking, Hebron, OH.

The question was, "You are adding a Purchase Order and see the following error message:

"Values for rows in PURHDR must be unique"

What does that message mean and what would you do to correct the problem?"

This error indicates that you are trying to add the same PO number again on the Purchase Order Header screen (PURHDR). Whether you are using the next sequential number assigned by CPMS, or entering your own number, the PO number must be unique. Bring up the Purchase Order (Header) on the Query screen and scroll down the PO Numbers to locate your problem.

CPMS Quiz

For \$100

On the PM Work Card there are three places for dates. They are Scheduled, Due Date, and Date Finished. What does each of those mean?

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