Network PCA Form

PCA Request Details:

Requestor Name: Scott McNulty and James Greszler
Requestors Job Titles: JLL-CSE and Amazon Central Teams AESE
Requestor Site: MCO1 and Automation Engineering
Date: 4/18/2022
Triggering Event WO#: N/A
Brief Description of Root Cause for Triggering Event/Why PCA being requested:
Currently, there is no standard speed configuration from the vendors (Dematic and Intelligrated) to be set for the AFE Mini Sorters 3.0 and 3.5. Each mini sorter is subject to local and subjective speed arrangement which leads to increased jams, tracking errors and total throughput. The current tray rate is 25/minute. Additionally, with the current setup, the start/stop cycle frequency is higher than needs to be, leading to excessive wear and tear on the MDRs in the area.

It has been determined that increasing the max scan rate to 35 trays/minute, will lower start/stop cycle frequency and will allow for trays to move more continuously, increasing scan rate. This change will be achieved by modifying MDR dipswitch settings on AFE 3.0 and 3.5 Mini Sorters.

Impacted Equipment/Sites:

Equipment Model/Models Impacted: AFE 3.0 and 3.5 Mini Sorters
EAM Profile: General Conveyor

Sites Impacted:

ACY1	BFL1	CMH4	DSM5	HOU2	JFK8	LIT1	MKE2	PCW1	STL8
AKC1	BOI2	DAL3	DTW1	HOU6	LAS7	MCO1	MQY1	PDX9	SYR1
AUS2	CLE2	DCA1	EWR9	IGQ1	LGA9	MDW7	MTN1	RDU1	TUL2
AUS3	CLE3	DEN3	FAT1	JAN1	LGB3	MIA1	OKC1	SLC1	TUS2
BDL2	CMH1	DEN4	FTW6	JAX2	LGB7	MKC6	ORF3	SMF1	YYZ4

General Information:

PCA Work Order Description: AFE 3.0/3.5 Mini Sorter Speed Standardization

Is LOTO/MTHA needed: Yes
# of Techs required to perform task: 1
Estimated Time to complete (in hours): 1 hour/mini sorter
PCA Start Date: 04/22/2022
PCA Due Date: 7/1/2022

Enter General Task instructions for WO:
- ☐   - Review procedure and collect all required documentation and tools
- ☐   - Locate the proper standardized speed map for your facility from this document
- ☐   - Set the MDR speeds using a combination of documents and tools and follow all safety protocols
- ☐   - After settings have been adjusted, monitor Mini Sorter operations approximately 30mins

Is there a Network MCM/CR for this PCA request: Yes
        If Yes, provide link:
https://issues.amazon.com/issues/GESChangeRequest-6439
Is a PO required for this PCA (Yes or No?): No
Are the sites responsible for submitting PO (Yes or No or N/A?): N/A

Required Tools
- Small flat blade screw driver to set dip switches.
- Standard Flat Blade and Number 2 or equivalent Phillips to access MDR areas.
- LOTO Supplies
- Tachometer to verify speeds are correct if necessary.

Parts
- Verify site does have a new MDR Card or Controller in stock in case of damage while making these adjustments.
- Verify site does have the correct Power Supply in stock in case of damage while making these adjustments.

Action(s) Required by Impacted Sites:

- **Preparation**
    1. Create a scheduled plan of work. It is recommended that you work with one mini sorter at a time in case you have to roll back.
    2. Hold a pre-meeting with all affected Techs to go over expectations and roll back plan for the job.
    3. Ensure Operations Team is aware of changes being made and of effect on tray movement.
    4. Follow all applicable LOTO and safety procedures before attempting adjustment of any equipment.
    5. Locate the proper standardized speed map for your facility from this document.
    6. Create a spreadsheet on a Laptop or a Kindle. This will be for documenting the original dip switch settings if you need to roll back.

- **Changing Dip Switches**
    7. Locate MDR or DMC location.
    8. Remove protective cover or shielding to access dip switch location.
    9. Record dip switch setting from each MDR (DMC) before modifying. Note: Suggest using a spreadsheet and track as you go.
    10. Using the small flat blade screwdriver, set dip switches on MDR (DMC) to the new appropriate settings as listed in the appropriate table below.
    11. Re install covers or shielding.

- **Start-up**
    12. Verify area is clean, clear and ready for startup.
    13. If used, remove all LOTO and or other safety related items.
    14. Notify affected personal of startup.
    15. Start system.

- **Testing and Validation**
    16. After settings have been adjusted, monitor Mini Sorter operations for:
        - ✓ Tray travel issues
        - ✓ Jamming
        - ✓ Tracking Errors
        - ✓ Consistent flow to Rebin Associates.

- **Return to Operations**
    17. Collect all tools.
    18. Clean up any areas that need to be.
    19. Notify OPS task is complete.

- **Documentation and logging**
    20. Document work to EAM-TT-SIM.

Tables and Settings:

Intelligrated

Intelligrated MDR
Images Speed Table

Dematic

Dematic MDR
Images Speed Table