

R@R-Date: 29/ Mrz/ 20

Template Version: V1.5

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Project: Flange nut
 Part Name: Flange Nut
 Part Number: A3C0715510000
 Supplier: EASYLINK INDUSTRIAL CO.,LTD.
 Location: KAOHSIUNG,TAIWAN

Pre - Production Run -- Capacity Evaluation -- Flange Nut A3C0715510000

Green fields - data Input by CA representative

Yellow fields - Columns -- Data input by Supplier required

RED Indication - Critical Process Step based on Run @ Rate

Purple Indication -- Bottle Neck (w/o) considering FTYs of following process steps

			Supplier Planned Capacity/ week							Results Pre-production Run/ Run at Rate							
No.	Process Steps	Process Description	Shifts/ week	Hours / shift	Planned Capacity Per Hour	Planned FTY	Machine availability consid. multiple mach. usage in %	OEE please refer to sheet 2a) consid. DOWNTIME in %	Net Planned Output Per Week	Effective production Duration of Run at Rate in hours (without downtime)	Produced parts	Capacity/ hour	Acceptable Parts Produced	Machine availa- bility consid. multiple mach. usage in %	OEE per sheet 2a) consid. DOWNTIME in %	FTY	Real Output Per Week
1	Forming	Forming	10	8	3000	95%	70%	95%	151620	1	3000	3000	3000	100%	89.6%	100%	214960
2	Tapping Thread	Tapping Thread	10	8	1200	95%	70%	95%	60648	1	1200	1300	1200	108%	90.7%	100%	102143
3	Plating	Plating	15	8	8000	95%	30%	95%	259920	1	8000	8000	8000	100%	94.8%	100%	910187
4	Optical Sorting	Optical Sorting	10	8	7200	99%	70%	90%	359251	1	7200	7200	7200	100%	90.7%	100%	522504
5	Msnual Sorting	Msnual Sorting	5	8	3600	95%	70%	95%	90972	1	3600	3600	3600	100%	79.7%	100%	114708
6																	
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Supplier Planned Bottle Neck

Calculated/ Planned Capacity per hour	
Max. Capacity per hour	1200
Calculated Output Bottle Neck/week	60648
Planned FPY (complete Process)	81%
Planned FTY	95%
Planned OEE (Machine Availability)	95%
Planned Bottle Neck	Tapping Thread

Shifts/ week	10
Hours/ shift	8
Total planned Capacity/ week	60648

Bottle Neck Evaluation		Critical Process Evaluation	
Bottle Neck	Achieved Output per hour during Run @ Rate	Critical Process	Achieved Output per hour during Run @ Rate
No. of parts produced/ hour	1200	No. of parts produced/ hour	1200
Achieved Output Bottle Neck/week	102143	Ach. Output 'Critical process'/week	102143
Required Output	96000	Required Output	96000
Achieved FTY	100%	Achieved FTY	100%
Machine availability*OEE	98%	Machine availability*OEE	98%
Actual Bottle Neck/ Name	Tapping Thread	Actual Critical Process/ Name	Tapping Thread

Shifts/ week	10	Shifts/ week	10
Hours/ shift	8	Hours/ shift	8
Total achieved Capacity/ week	102143	Total achieved Capacity/ week	102143

Bottle Neck evaluation (w/o) FTY		Most Critical Process Step	
Bottle Neck/ lowest output		under consideration of FTYs	
Required Output Bottle Neck/ week	96000	Required Output Critical step/ week	96000
Achieved Output Bottle Neck/week	102143	Ach. Output 'Critical process'/week	102143
Capacity >= 130%	Green	Capacity >= 130%	Green
Capacity < 130% but >= 100%	Yellow	Capacity < 130% but >= 100%	Yellow
Capacity < 100%	Red	Capacity < 100%	Red
Bottle Neck: Tapping Thread		Critical Process: Tapping Thread	
Required capacity/ week	96000	Required capacity/ week	96000
Fulfillment CA Requirement	106%	Fulfillment CA Requirement	106%
FPY for processes following 'Bottle Neck' Tapping Thread	100%	FPY following Tapping Thread	100%
Achieved FPY complete process	100%	Buffer critical process Tapping Thread	-6%