



# EDGE Sample Reports

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# Machine – Downtime Faults

## Machine Faults

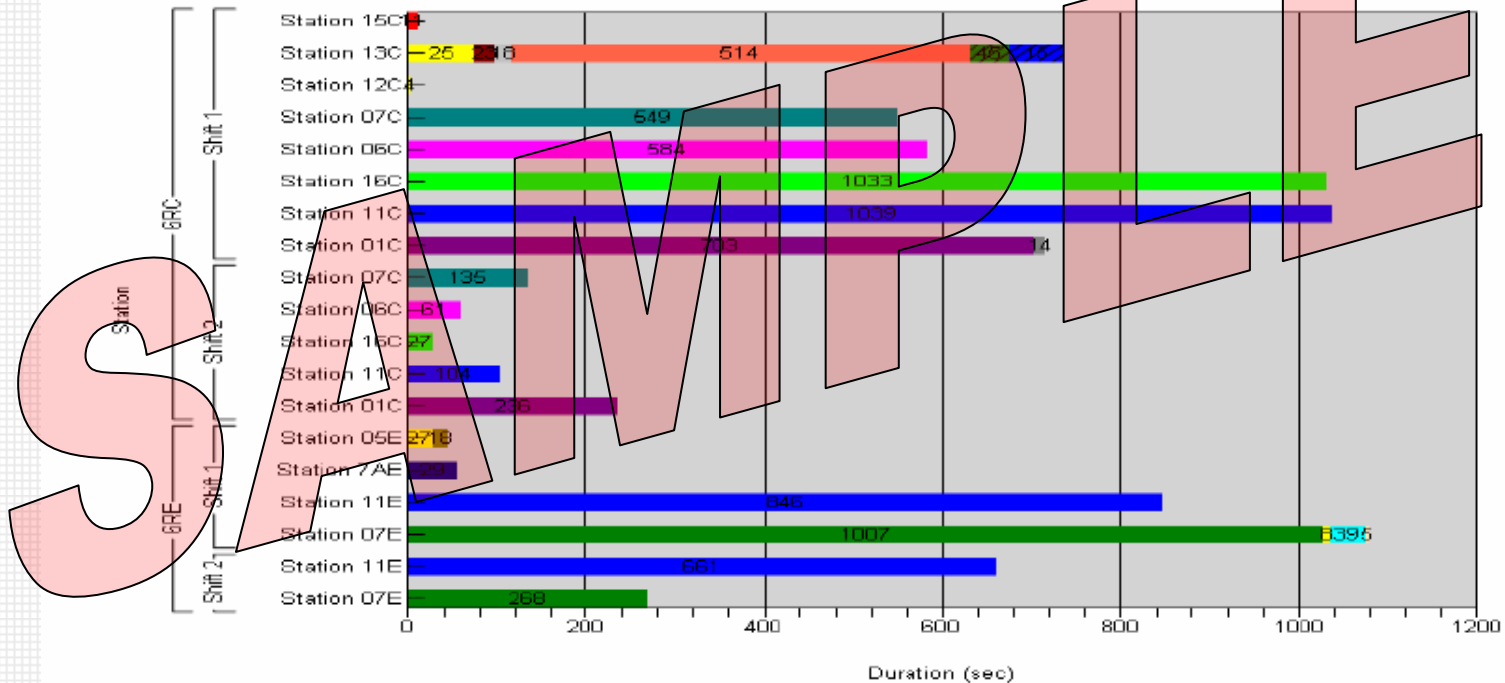
Data Query Criteria  
Machine: ALL

Start Date : 2/26/2007 0:00  
Stations: ALL

End Date : 2/30/2007 0:00  
Fault Events : ALL

Shifts : ALL

- |   |                                      |
|---|--------------------------------------|
| SHUTTLE STRIPPER LOWERED FAULT                | PICK AND PLACE HEAD NOT LOWERED      |
| Series 2                                      | GUARD DOOR #2 OPEN                   |
| PALLET MISSING AT STATION STOP                | PALLET MISSING AT LTU3 PRESTOP FAULT |
| LASER SYSTEM IS NOT READY FOR OPERATION       | GUARD DOOR #1 OPEN                   |
| STOP 1 PALLET MISSING FAULT                   | INCORRECT SNAP RING PRESENT          |
| PALLET MISSING FAULT                          | GAGE HEAD PRESSURIZED FAULT          |
| STATION POWER OFF!                            | MOVE SHUTTLE TO PALLET FAULT         |
| 2D DOT MATRIX VISION DECODE FAILED            | LONG PUSHER RETURNED FAULT           |
| FRICITION PLATE LIFTER SERVO OVERTORQUE FAULT | RING PUSHER PIVOT LOWERED FAULT      |



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# Machine – All Events Spreadsheet Listing

## Event Detail - All Events

Date Query Criteria      Start Date : 2/26/2007 0:00      End Date : 2/30/2007 0:00  
 Machine: 6RC              Stations: ALL                      Events: ALL

Station	Event Category	Shift	Part	Start Time	Duration	Event Detail
Station 01C						
Station 02C						
	<input type="checkbox"/> BLOCKED				119 sec	
	<input type="checkbox"/> STARVED				3510 sec	
Station 03C						
Station 04C						
Station 05C						
Station 06C						
	<input type="checkbox"/> BLOCKED				771 sec	
	<input type="checkbox"/> FAULT				645 sec	
		2	1	2/27/2007 8:19:00 PM	00:01:01	STOP 1 PALLET MISSING FAULT
		1	1	2/26/2007 7:00:00 AM	00:09:44	STOP 1 PALLET MISSING FAULT
	<input type="checkbox"/> IDLE				1 sec	
	<input type="checkbox"/> MANUAL				2 sec	
	<input type="checkbox"/> STARVED				1922 sec	
Station 07C						
Station 08C						
Station 09C						
Station 10C						
Station 11C						
Station 12C						
Station 13C						
	<input type="checkbox"/> BLOCKED				2503 sec	
	<input type="checkbox"/> FAULT				736 sec	
		1	1	2/26/2007 8:13:14 AM	00:00:23	GUARD DOOR #2 OPEN
		1	1	2/26/2007 8:13:48 AM	00:00:25	STATION POWER OFF!
		1	1	2/26/2007 8:22:30 AM	00:00:18	INCORRECT SNAP RING PRESENT
		1	1	2/26/2007 8:22:59 AM	00:00:50	STATION POWER OFF!
		1	1	2/26/2007 8:23:58 AM	00:08:34	GAGE HEAD PRESURIZED FAULT
		1	1	2/26/2007 8:32:40 AM	00:00:45	LONG PUSHER RETURNED FAULT
		1	1	2/26/2007 8:33:29 AM	00:00:15	RING PUSHER PIVOT LOWERED FAULT
		1	1	2/26/2007 8:33:50 AM	00:00:46	RING PUSHER PIVOT LOWERED FAULT
	<input type="checkbox"/> IDLE				1 sec	
	<input type="checkbox"/> MANUAL				52 sec	
	<input type="checkbox"/> STARVED				20 sec	
Station 14C						
Station 15C						
Station 16C						

SAMPLE

MS Reporting Services

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# Machine – All Events Spreadsheet Listing

Microsoft Excel - Event Detail Spreadsheet - All Events

File Edit View Insert Format Tools Data Window Help Adobe PDF

J1683

Event Detail - All Events

Data Query Criteria Start Date : 2/26/2007 0:00 Emd Date : 2/30/2007 0:00  
 Machine: 6RC Stations: ALL Events: ALL

Station	Event Category	Shift	Part	Start Time	Duration	Event Detail
758	BLOCKED				771 sec	
772	FAULT				645 sec	
773		2	1	2/27/2007 08:19:00 PM	00:01:01	STOP 1 PALLET MISSING FAULT
774		1	1	2/26/2007 07:00:00 AM	00:09:44	STOP 1 PALLET MISSING FAULT
775	IDLE				1 sec	
777	MANUAL				2 sec	
779	STARVED				1922 sec	
1078	Station 07C					
1175	Station 08C					
1231	Station 09C					
1409	Station 10C					
1467	Station 11C					
1478	Station 12C					
1500	Station 13C					
1561	BLOCKED				2503 sec	
1559	FAULT				736 sec	
1660		1	1	2/26/2007 08:13:14 AM	00:00:23	GUARD DOOR #2 OPEN
1661		1	1	2/26/2007 08:13:48 AM	00:00:25	STATION POWER OFF!
1662		1	1	2/26/2007 08:22:30 AM	00:00:18	INCORRECT SNAP RING PRESENT
1663		1	1	2/26/2007 08:22:50 AM	00:00:50	STATION POWER OFF!
1664		1	1	2/26/2007 08:23:58 AM	00:08:34	GAGE HEAD PRESSURIZED FAULT
1665		1	1	2/26/2007 08:32:40 AM	00:00:45	LONG PUSHER RETURNED FAULT
1666		1	1	2/26/2007 08:33:29 AM	00:00:15	RING PUSHER PIVOT LOWERED FAULT
1667		1	1	2/26/2007 08:33:50 AM	00:00:46	RING PUSHER PIVOT LOWERED FAULT
1668	IDLE				1 sec	
1674	MANUAL				52 sec	
1675		1	1	2/26/2007 08:13:36 AM	00:00:12	
1676		1	1	2/26/2007 08:14:12 AM	00:00:02	
1677		1	1	2/26/2007 08:22:48 AM	00:00:11	
1678		1	1	2/26/2007 08:23:48 AM	00:00:02	
1679		1	1	2/26/2007 08:24:13 AM	00:00:08	
1680		1	1	2/26/2007 08:32:31 AM	00:00:01	
1681		1	1	2/26/2007 08:32:49 AM	00:00:07	
1682		1	1	2/26/2007 08:33:25 AM	00:00:01	
1683		1	1	2/26/2007 08:33:43 AM	00:00:04	
1684		1	1	2/26/2007 08:34:35 AM	00:00:04	
1685	STARVED				20 sec	
1692	Station 14C					
1693	BLOCKED				2717 sec	
1810	Station 15C					
1830	Station 16C					
1964						

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# Machine – All Events Spreadsheet Listing

## Event Detail - All Events

Data Query Criteria  
Machine: 8RC

Start Date : 2/26/2007 0:00  
Stations: ALL

Emd Date : 2/30/2007 0:00  
Events: ALL

Station	Event Category	Shift	Part	Start Time	Duration	Event Detail
Station 01C						
Station 02C						
Station 03C						
Station 04C						
Station 05C						
Station 06C						
	BLOCKED				771 sec	
	FAULT				645 sec	
		2	1	2/27/2007 08:19:00 PM	00:01:01	STOP 1 PALLET MISSING FAULT
		1	1	2/26/2007 07:00:00 AM	00:09:44	STOP 1 PALLET MISSING FAULT
	IDLE				1 sec	
	MANUAL				2 sec	
	STARVED				922 sec	
Station 07C						
Station 08C						
Station 09C						
Station 10C						
Station 11C						
Station 12C						
Station 13C						
	BLOCKED				2503 sec	
	FAULT				736 sec	
		1	1	2/26/2007 08:13:14 AM	00:00:23	GUARD DOOR #2 OPEN
		1	1	2/26/2007 08:13:48 AM	00:00:25	STATION POWER OFF!
		1	1	2/26/2007 08:12:38 AM	00:00:18	INCORRECT SNAP RING PRESENT
		1	1	2/26/2007 08:22:59 AM	00:00:50	STATION POWER OFF!
		1	1	2/26/2007 08:23:58 AM	00:08:34	GAGE HEAD PRESSURIZED FAULT
		1	1	2/26/2007 08:32:40 AM	00:00:45	LONG PUSHER RETURNED FAULT
		1	1	2/26/2007 08:33:29 AM	00:00:15	RING PUSHER PIVOT LOWERED FAULT
		1	1	2/26/2007 08:33:50 AM	00:00:46	RING PUSHER PIVOT LOWERED FAULT
	IDLE				1 sec	
	MANUAL				52 sec	
		1	1	2/26/2007 08:13:36 AM	00:00:12	
		1	1	2/26/2007 08:14:12 AM	00:00:02	
		1	1	2/26/2007 08:22:48 AM	00:00:11	
		1	1	2/26/2007 08:23:48 AM	00:00:02	
		1	1	2/26/2007 08:24:13 AM	00:00:08	
		1	1	2/26/2007 08:32:31 AM	00:00:01	
		1	1	2/26/2007 08:32:49 AM	00:00:07	
		1	1	2/26/2007 08:33:25 AM	00:00:01	
		1	1	2/26/2007 08:33:43 AM	00:00:04	
		1	1	2/26/2007 08:34:35 AM	00:00:04	
	STARVED				20 sec	
Station 14C						
	BLOCKED				2717 sec	
Station 15C						
Station 16C						

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# A M P L E

Adobe PDF (Export from RS or Excel)

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# Machine – Information

## Current Station Status - Events

Station	Event	Timestamp	Event	Timestamp
Main	Andon Start	3/6/2007 12:52:36 PM		
Station 1	Andon Start	3/6/2007 01:20:39 PM		
Station 2	Andon Start	3/6/2007 01:11:05 PM		
Station 3	Andon Start	3/6/2007 01:19:50 PM		
Station 4	Andon Start	3/6/2007 01:15:49 PM		
Station 5	Andon Start	3/6/2007 01:17:55 PM		
Station 6	Andon Start	3/6/2007 01:08:14 PM		
Station 7	Andon Start	3/6/2007 01:07:56 PM		
Station 8	Andon Start	3/6/2007 01:30:46 PM		
Station 9	Andon Stop	3/6/2007 01:36:12 PM		
Station 10	Andon Start	3/6/2007 01:32:15 PM		
Station 11	Andon Start	3/6/2007 01:12:59 PM		
Station 12	Andon Start	3/6/2007 12:52:36 PM		
Station 13	Andon Start	3/6/2007 12:52:36 PM		
Station 14	Andon Start	3/6/2007 01:35:38 PM		
Station 15	Pokayoke Out of Order	3/6/2007 01:34:42 PM		
Station 16	Andon Start	3/6/2007 12:52:36 PM		
Station 17	Andon Start	3/6/2007 01:30:48 PM		
Station 18	Andon Start	3/6/2007 01:20:02 PM	Andon Parts On	3/6/2007 01:26:02 PM
Station 19	Andon Start	3/6/2007 01:13:48 PM		
Station 20	Andon Start	3/6/2007 12:52:36 PM		
Station 21	Andon Start	3/6/2007 12:52:36 PM		

SAMPLE

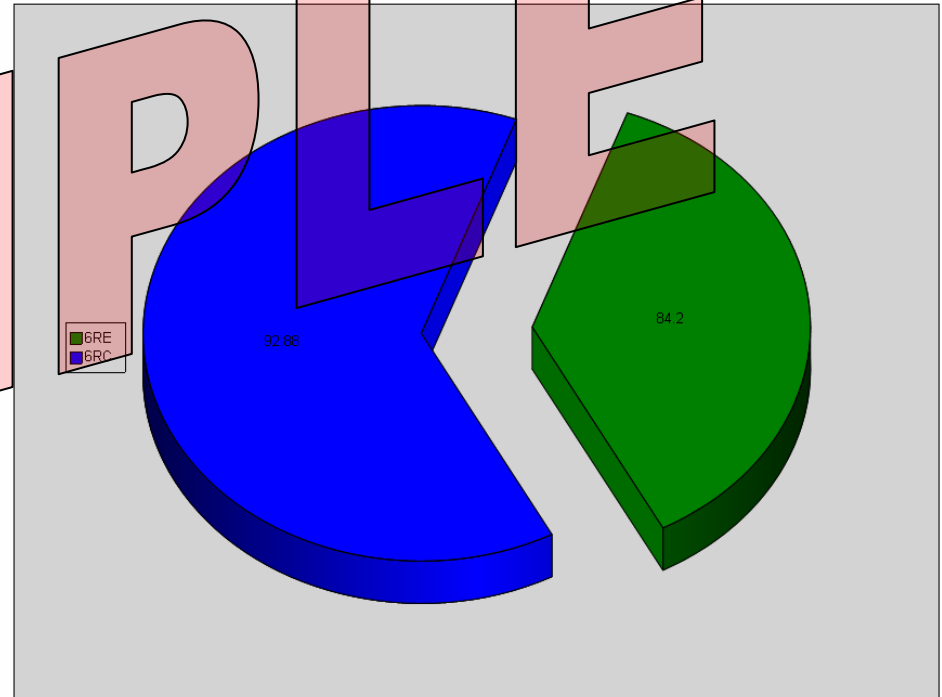
## OEE Calculations

Data Query Criteria

Start Date : 2/26/2007 0:00

End Date : 2/30/2007 0:00

Machine: ALL



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# Machine – Operator Performance

## Pokayoke Error Counts

Report Date 4/11/2007 10:17:40 AM

Start Date : 3/6/2007 7:00

Stop Date : 3/6/2007 15:00

Station : ALL

Model : ALL

Pokayoke : ALL

## Production Counts Data Matrix

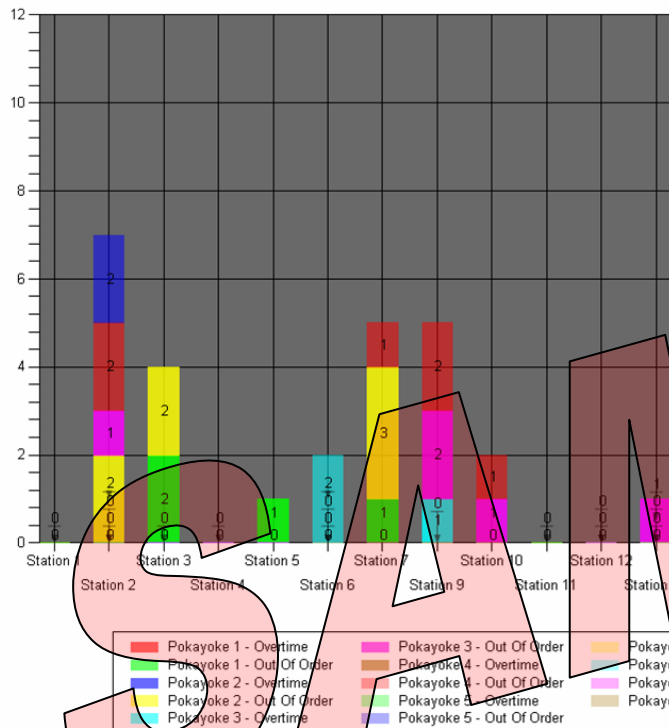
Report Date 4/11/2007 10:37:08 AM

Start Date : 03/6/2007 7:00 Stop Date : 03/6/2007 15:00

Model : ALL

Station : ALL

Stop Date :



	AA443150-5156				AA443150-5176			
	Pass	Repair In Station	Sent to Repair	Scrap	Pass	Repair In Station	Sent to Repair	Scrap
Station 1	181				47			3
Station 2	177			4	44			
Station 3	175				44			
Station 4	174				44			
Station 5	172			2	44			
Station 6	171	1			44			
Station 7	170	1			44			
Station 8	168	1	1		44		1	
Station 9	167		1		44			
Station 10	166		1		44			
Station 11	164			2	44			
Station 12	163	1			44			
Station 13	162				44			
Station 14	162				44			
Station 15	161	1			44	2	1	
Station 17	159			1	41			
Station 18	159		1		41			
Station 19	158				41			
Station 20	158				41			
Station 21	158				40	1		
Station 16 A	51		1		16			
Station 16 B	53				11		1	
Station 16 C	52				13			



# Machine – Setup

## Station Table Setup :

Station : 15

Report Date 4/11/2007 10:24:01 AM

### Current Station Model Running Setup

Station	Timestamp	Part Number	Model
Station 15	2/9/2007 03:11:18 PM	AA443160-0923	D SEG LHD ELE PTC 21

### Current Pokayoke Setup

Station	Timestamp	Pokayoke #	Sequence #
Station 15	2/9/2007 03:11:18 PM	1	0
Station 15	2/9/2007 03:11:18 PM	2	0
Station 15	2/9/2007 03:11:18 PM	3	0
Station 15	2/9/2007 03:11:18 PM	4	0
Station 15	2/9/2007 03:11:18 PM	5	2
Station 15	2/9/2007 03:11:18 PM	6	1
Station 15	2/9/2007 03:11:18 PM	7	3
Station 15	2/9/2007 03:11:18 PM	8	0

### Current Driver Setup

Station	Timestamp	Driver #	Driver Program
Station 15	2/9/2007 03:11:18 PM	1	0
Station 15	2/9/2007 03:11:18 PM	2	0

### Current Takt Time Setup

Station	Timestamp	Takt Time
Station 15	2/9/2007 03:11:18 PM	32.00

## Pokayoke Setup History

Report Date 4/11/2007 10:29:00 AM    Start Date : 1/11/2007    Stop Date : 04/11/2007 10:27:52  
 Station : 15    Model : ALL

Station	Timestamp	Pokayoke #	Sequence #	Status	Model
Station 15	1/25/2007 06:15:12 AM	1	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	2	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	3	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	4	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	5	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	6	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	7	0	Disabled	5153 REWORK
Station 15	1/25/2007 06:15:12 AM	8	0	Disabled	5153 REWORK
Station 15	1/26/2007 04:08:08 PM	1	1	Enabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	2	2	Enabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	3	3	Enabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	4	4	Enabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	5	0	Disabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	6	0	Disabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	7	0	Disabled	JK LHD AC 21
Station 15	1/26/2007 04:08:08 PM	8	0	Disabled	JK LHD AC 21
Station 15	1/27/2007 05:42:42 AM	1	0	Disabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	2	0	Disabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	3	0	Disabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	4	0	Disabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	5	2	Enabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	6	1	Enabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	7	3	Enabled	D SEG LHD ATC-PTC 21
Station 15	1/27/2007 05:42:42 AM	8	0	Disabled	D SEG LHD ATC-PTC 21
Station 15	2/9/2007 03:11:18 PM	1	0	Disabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	2	0	Disabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	3	0	Disabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	4	0	Disabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	5	2	Enabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	6	1	Enabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	7	3	Enabled	D SEG LHD ELE PTC 21
Station 15	2/9/2007 03:11:18 PM	8	0	Disabled	D SEG LHD ELE PTC 21

S.A.P.



# Production – Quantities

## Part Production Summary

From: 1/9/2006 To: 4/9/2007 11:59:59 PM

4/9/2007 03:00:31 PM

Models : ALL

Model	Good Parts	Number of Reworks	Scrap Parts
0100550	1086	140	31
0100560	368	2	3

## Hourly Production Data Matrix

From: 1/9/2006 To: 4/9/2007 11:59:59 PM

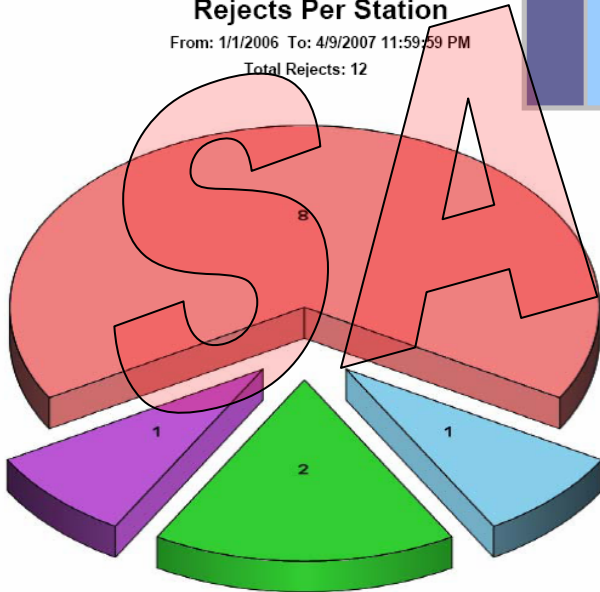
4/9/2007 03:25:53 PM

Year, Month, Day, Hour	Model 0100550				Model 0100560			
	In Process	Good Part	Reworked	Scrap	In Process	Good Part	Reworked	Scrap
2006 11 6 13					1	0	1	2
14					0	0	1	1
18	0	0	8	4				
8	0	0	5	5				
9	0	0	8	8				
11	0	0	2	2				
13	1	13	23	9				
14	1	54	53	2				
15	6	11	21	1				
16	14	0	14	0				

## Rejects Per Station

From: 1/1/2006 To: 4/9/2007 11:59:59 PM

Total Rejects: 12



■ Station 020      ■ Station 060  
■ Station 050 Work Position 2      ■ Station 070 Work Position 2

## Journal Usage Report

4/9/2007 4:04:14 PM

From: 1/1/2000 To: 4/9/2007 11:59:59 PM

Page 1 of 1

Journal Usage.rpt

Journal Category	Description	Flange Count
0	Invalid	2
1	01000553-1	2
2	01000553-2	51
3	01000553-3	68
4	01000553-4	1
5	01000553-5	0

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# Production – Part Traceability

Serial Number

1 of 1

## Part/Lot Numbers for Part Serial Number

**01311060011**

Model	Start Time Stamp	End Time Stamp	Differential SN	No. of Rework	Pallet No.
0100550	11/7/2006 9:35:53 AM	11/7/2006 1:36:20 PM	63-25402	1	43

<b>Side Gear 1</b> 63-25404001	<b>Side Gear 2</b> 63-25404001	Start Date 1/1/2000	<input type="checkbox"/> NULL	End Date 1/1/3000	<input type="checkbox"/> NULL
<b>Pin Shaft</b> 63-25403001	<b>Roll Pin</b>	Unit Serial Number	<input checked="" type="checkbox"/> NULL	Side Gear Lot Number	<input checked="" type="checkbox"/> NULL
		Pin Washer Lot Number	<input checked="" type="checkbox"/> NULL	Pin Gear Lot Number	<input checked="" type="checkbox"/> NULL
		Pin Shaft Lot Number 63-25403001	<input type="checkbox"/> NULL	Roll Pin Lot Number	<input checked="" type="checkbox"/> NULL
		Flange Shim Lot Number	<input checked="" type="checkbox"/> NULL	Journal Shim Lot Number	<input checked="" type="checkbox"/> NULL

4/9/2007 3:57:26 PM

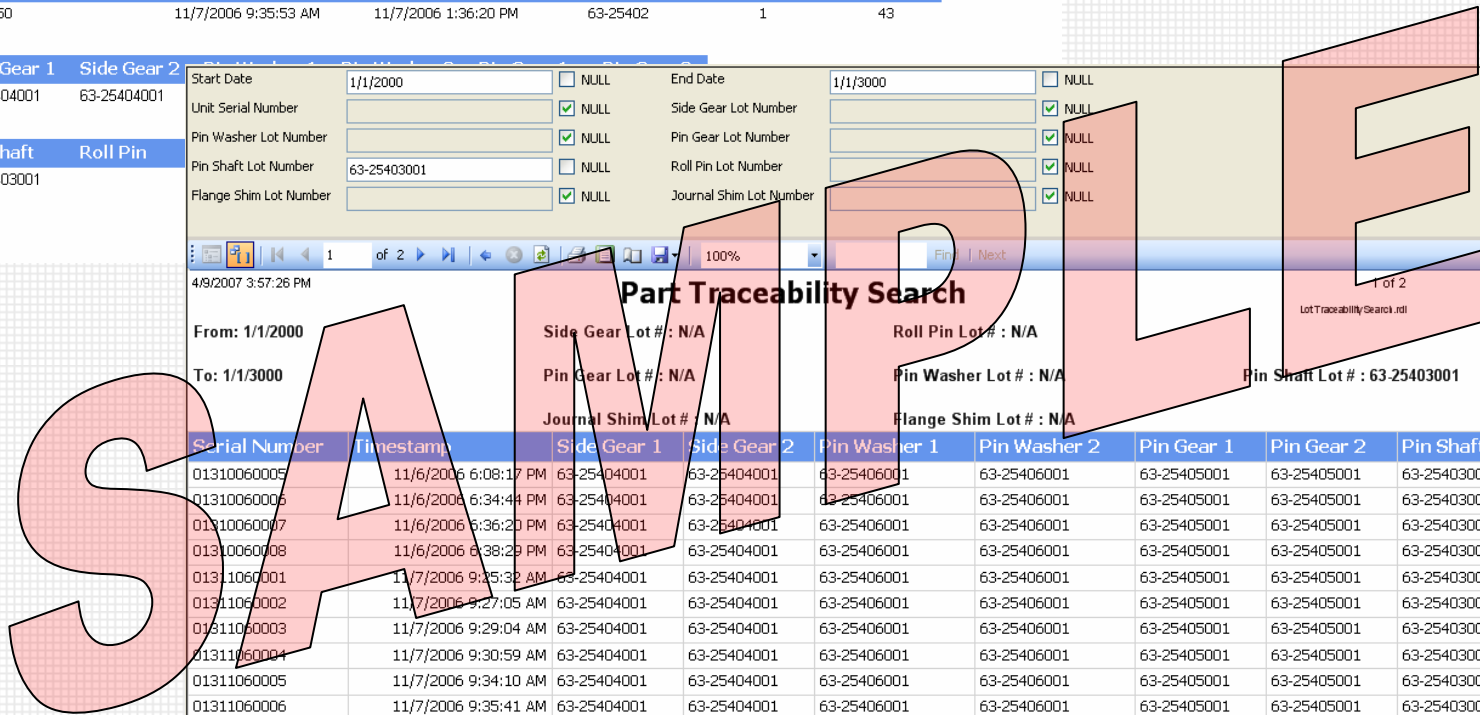
## Part Traceability Search

From: 1/1/2000  
To: 1/1/3000

Side Gear Lot #: N/A  
Pin Gear Lot #: N/A  
Journal Shim Lot #: N/A  
Roll Pin Lot #: N/A  
Pin Washer Lot #: N/A  
Flange Shim Lot #: N/A

Pin Shaft Lot #: 63-25403001

Serial Number	Timestamp	Side Gear 1	Side Gear 2	Pin Washer 1	Pin Washer 2	Pin Gear 1	Pin Gear 2	Pin Shaft	Roll Pin	Flange
0131060005	11/6/2006 6:08:17 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
0131060006	11/6/2006 6:34:44 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
0131060007	11/6/2006 6:36:20 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
0131060008	11/6/2006 6:38:29 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060001	11/7/2006 9:25:32 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060002	11/7/2006 9:27:05 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060003	11/7/2006 9:29:04 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060004	11/7/2006 9:30:59 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060005	11/7/2006 9:34:10 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060006	11/7/2006 9:35:41 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060007	11/7/2006 9:36:59 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060008	11/7/2006 9:38:18 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060009	11/7/2006 9:39:11 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060010	11/7/2006 9:40:45 AM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060011	11/7/2006 12:40:47 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001		0125606
01311060012	11/7/2006 1:04:48 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606
01311060013	11/7/2006 1:33:38 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606
01311060020	11/7/2006 1:35:54 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606
01311060021	11/7/2006 1:37:04 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606
01311060022	11/7/2006 1:38:01 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606
01311060025	11/7/2006 1:39:05 PM	63-25404001	63-25404001	63-25406001	63-25406001	63-25405001	63-25405001	63-25403001	63-	0125606





# Production – Process Trending

## Bolt Process Trending

Report Date 4/12/2007 3:27:06 PM

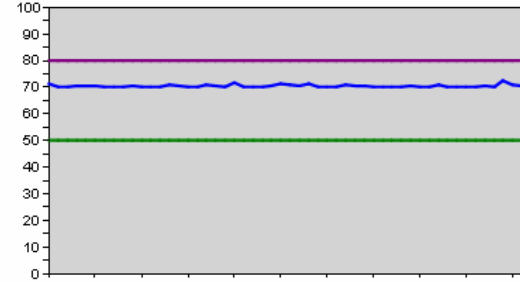
Stations: 70

Start Time : 11/10/2006 1:00 PM

End Time Time : 11/10/2006 2:00 PM

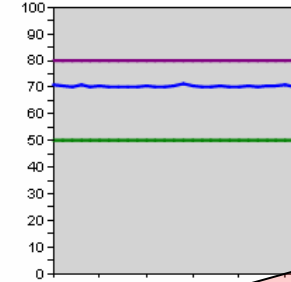
Torque

Min Limit Spindle 1 Pass 1 Max Limit



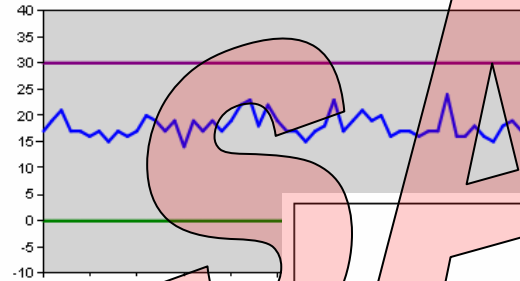
Torque

Min Limit Spindle 1 Pass 1 Max Limit



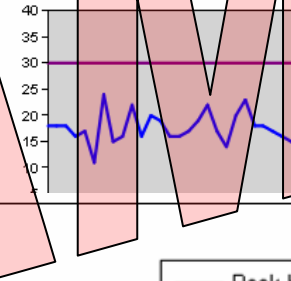
Angle

Min Limit Spindle 1 Pass 1 Max Limit



Angle

Min Limit Spindle 1 Pass 1 Max Limit



## Fan Motor Test Data Trend

Report Date 1/3/2007 8:58:04 AM

Start Date : 10/20/2006 16:00

Stop Date : 10/20/2006 17:00

Model : ALL

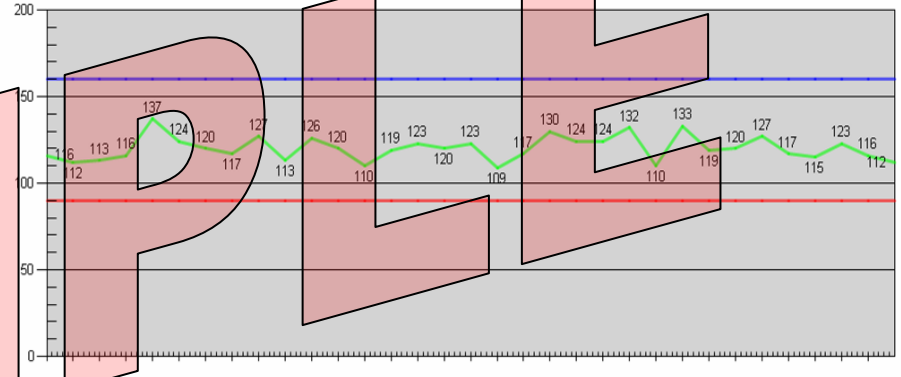
Part Status : ALL

Serial Number : ALL

[\(Hyperlink\) Goto Fan Motor Test Results Spreadsheet View](#)

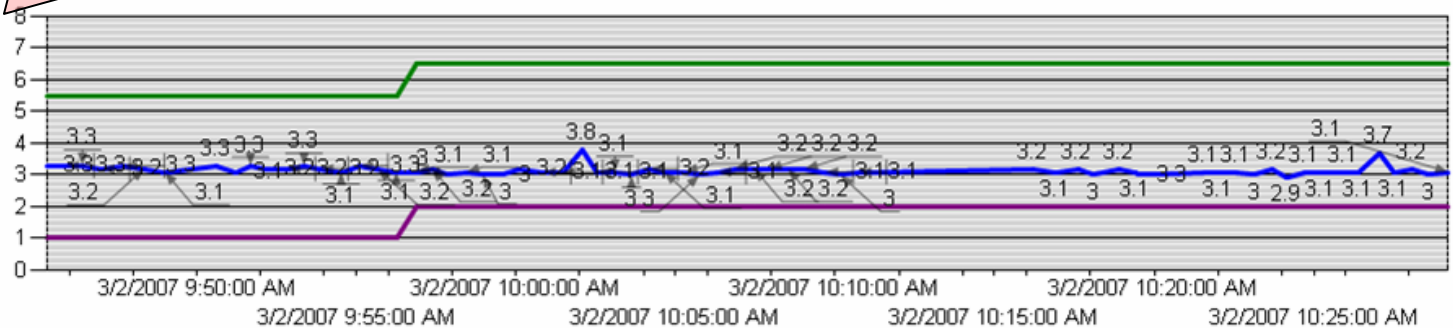
Fin Pitch Test Results

Fin Pitch Low Limit Fin Pitch Actual Fin Pitch High Limit



Blower 1

Peak High Measured Peak Peak Low



S A M P L E



# Production – Process Data

## N2 Part Data Spreadsheet

Report Date 4/9/2007 2:23:13 PM

Start Date : 10/09/2006 13:00

Stop Date : 10/09/2006 13:30

N2 Station : ALL N2

Model : ALL

Part Status : ALL

[\(Hyperlink\) Goto N2 Test Results Graphical View](#)

Serial Number : ALL

Station	Serial Number	Model	Timestamp	Part Status	Evap. Blocked Core	Evap. Static Vacuum	Evap. Dynamic Vacuum	Evap. Diff. Pressure	Heater Core Diff. Pressure	Evap. Pull Down	Heater Core Dynamic	Heater Core Static
Station 16 A	515412:38:502006100930895	AA443150-5154	10/9/2006 01:00:08 PM	Accept	1	1	1	1	1	1	1	1
	515412:41:302006100930897	AA443150-5154	10/9/2006 01:02:00 PM	Reject	1	1	1	1	Reject	1	1	1
	515412:41:302006100930897	AA443150-5154	10/9/2006 01:03:13 PM	Accept	1	1	1	1	1	1	1	1
	515412:43:202006100930900	AA443150-5154	10/9/2006 01:04:32 PM	Accept	1	1	1	1	1	1	1	1
	515412:45:112006100930903	AA443150-5154	10/9/2006 01:06:27 PM	Accept	1	1	1	1	1	1	1	1
	515412:47:212006100930906	AA443150-5154	10/9/2006 01:08:15 PM	Accept	1	1	1	1	1	1	1	1
	515412:49:312006100930909	AA443150-5154	10/9/2006 01:10:20 PM	Accept	1	1	1	1	1	1	1	1
	515412:51:212006100930912	AA443150-5154	10/9/2006 01:11:57 PM	Accept	1	1	1	1	1	1	1	1
	515412:53:112006100930914	AA443150-5154	10/9/2006 01:13:25 PM	Accept	1	1	1	1	1	1	1	1
	515412:55:112006100930917	AA443150-5154	10/9/2006 01:15:04 PM	Accept	1	1	1	1	1	1	1	1
	515412:56:512006100930920	AA443150-5154	10/9/2006 01:17:03 PM	Accept	1	1	1	1	1	1	1	1
	515412:59:022006100930923	AA443150-5154	10/9/2006 01:19:12 PM	Accept	1	1	1	1	1	1	1	1
	515413:01:222006100930926	AA443150-5154	10/9/2006 01:21:49 PM	Accept	1	1	1	1	1	1	1	1
	515413:03:122006100930929	AA443150-5154	10/9/2006 01:23:12 PM	Accept	1	1	1	1	1	1	1	1
	515413:05:022006100930932	AA443150-5154	10/9/2006 01:24:49 PM	Accept	1	1	1	1	1	1	1	1
	515413:07:122006100930935	AA443150-5154	10/9/2006 01:26:57 PM	Accept	1	1	1	1	1	1	1	1
	515413:08:422006100930938	AA443150-5154	10/9/2006 01:28:47 PM	Accept	1	1	1	1	1	1	1	1
			Total Reject =	1	0	0	0	0	1	0	0	0
			Total Accept =	16	17	17	17	17	16	17	17	17
Station 16 B			Total Reject =	0	0	0	0	0	0	0	0	0
			Total Accept =	16	16	16	16	16	16	16	16	16
Station 16 C			Total Reject =	0	0	0	0	0	0	0	0	0
			Total Accept =	15	15	15	15	15	15	15	15	15

The Future is in  
the Data





# Production – Birth Certificate

## Birth Certificate - Recorded Data for Serial Number :

**515412:41:302006100930897**

Report Date 4/11/2007 9:49:35 AM

### General Information Part Data

Load Timestamp	Serial Number	Model	Rework Count	Unload Timestamp
10/9/2006 12:46:53 PM	AA443150-515412:41:302006100930897	AA443150-5154		10/9/2006 01:09:39 PM

### Pokayoke Data

Timestamp	Station	Pokayoke	Sequence Number	Status
10/9/2006 12:47:01 PM	Station 1	1	1	Triggered
10/9/2006 12:47:43 PM	Station 2	1	1	Triggered
10/9/2006 12:47:58 PM	Station 2	4	2	Triggered
10/9/2006 12:48:01 PM	Station 2	5	3	Triggered
-----				
10/9/2006 12:56:47 PM	Station 12	2	1	Triggered
10/9/2006 12:56:57 PM	Station 12	1	2	Triggered
10/9/2006 12:58:20 PM	Station 13	6	3	Out Of Order
10/9/2006 12:58:01 PM	Station 13	3	1	Triggered
10/9/2006 12:58:09 PM	Station 13	1	2	Triggered
10/9/2006 12:58:20 PM	Station 13	6	3	Triggered
-----				
10/9/2006 01:03:45 PM	Station 17	1	1	Triggered
10/9/2006 01:08:04 PM	Station 20	1	1	Triggered

### Fan Motor Press Test Data

Timestamp	Press Force High Limit	Cap Height	Cap Height Actual Limit	Cap Height High Limit	Go Ho	Go Shaft	Press Height
10/9/2006 12:53:36 PM	2490	52	73	152	Go	Go	3

### N2 Test Data

Timestamp	Evap. Blocked Core	Evap. Dynamic Vacuum	Evap. Diff. Pressure	Heater Core Diff. Pressure	Evap. Pull Down	Heater Core Dynamic	Heater Core Static
10/9/2006 01:02:00 PM	Accept	Accept	Accept	Reject	Accept	Accept	Accept
10/9/2006 01:03:13 PM	Accept	Accept	Accept	Accept	Accept	Accept	Accept

### Functional Test Data

Timestamp	Test Description	Test Status	High Limit	Measured	Low Limit	Target Pos	Final Pos	Peak High	Measured Peak	Peak Low	Measured Lowest	Lowest Low
2/10/2007 07:56:01 PM	1st Blower	Accept	x	x	x	x	x	5.5	3.3	1	x	x
2/10/2007 07:56:02 PM	Thermistor #1	Accept	2500	1719	1000	x	x	x	x	x	x	x
2/10/2007 07:56:04 PM	2nd Blower	Accept	x	x	x	x	x	8.5	5	2.5	x	x
2/10/2007 07:56:05 PM	Servo #4 Test #1	Accept	x	x	x	530	530	0.2	0.023	0.007	0.015	x
2/10/2007 07:56:07 PM	3rd Blower	Accept	x	x	x	x	x	9.5	7.2	5	x	x
2/10/2007 07:56:08 PM	Servo #4 Test #2	Accept	x	x	x	525	525	0.2	0.025	0.007	0.009	x
2/10/2007 07:56:10 PM	4th Blower	Accept	x	x	x	x	x	15	10.6	8	x	x
2/10/2007 07:56:11 PM	Part Status	Accept	x	x	x	x	x	x	x	x	x	x

Notes : x - No Test Performed

SAMPLE



**These were just a  
few samples... please  
feel free to contact  
for more information.**

**[www.EdgeDataGroup.com](http://www.EdgeDataGroup.com)  
[info@EdgeDataGroup.com](mailto:info@EdgeDataGroup.com)  
(269) 465-2295**

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