XL Asset Optimization Program

The XL Asset Optimization program is a 2½ days onsite service with a series of remote follow-up calls with an experienced XL Deployment Expert. The purpose of this program is to ensure that your Vorne XL appliances are capturing accurate information, your teams are trained on how to use the appliances and you have a real and solid action plan for how to use Vorne XL to drive improvement.

Agenda

Day 1 –

- Introductions and plant tour
- Understanding Vorne Terminology
    - Production Events - Run, Down, Setup & Standby
    - Shifts, Jobs, Parts
    - Time Schedules
    - Cycle Thresholds
- Day in the Life of Vorne – Operator interaction and processes – use template and update
- Determine what success is from this program.
    - XL Champion is trained and confident to configure and maintain the XL appliances.
    - 'Pilot' Line is operational and being monitored

Day 2 –

- Select one line as the 'pilot' line to establish the standard configuration and processes.
- Based on the Assessment, determine approach to configure Vorne XL to be the standard configuration.
- Train the XL Champion on how to configure and run the XL appliances.
- Update bar codes and train operators.
- Review processes and configuration and document.
- Develop a project plan for implementing the standard configuration and processes to the rest of the plant.

Day 3 – (half day)

- Management Team Review – (scheduled in advance to onsite) Present findings and solutions to the team.
- Train the Management Team on the XL interface to assist them in verifying and using their good data.
- Schedule a series of follow-up calls to ensure sustainability

Program Details

Make an assessment of each Vorne XL board

- Inventory of all devices – name, IP address, current firmware version and location (plant)
- Any special programs – calculations
- Special messages formatted such as the Run, Setup and Standby Messages
- Cycle Thresholds – based on Slow Cycles, Ideal Cycle or Takt Time Cycle.
- Determine Full Stop threshold. Is it enough time for the operator to scan the reason?
- Inputs – how many and are there any special programs that are executed.
- How are parts programmed – Is Ideal Cycle Time and Takt Time correct?
- Time Schedules – are shift names consistent
- Loss Reasons – are they consistent
- Document anything that needs to be kept or needed in case of reprogramming the unit
- Setup one line as a "pilot" line – this will be used to test all programs and processes
- Do floor training with operators on this line

Understanding Vorne XL programming

- Make a backup!
- Upgrade to the latest firmware
- Re-program the device following your new process below.

Consistent setup of Vorne XL units across the plant

- Make tactical plan to reduce "NONE" for downtime reasons
  - Categorize (and update) setup, downtime and standby reason codes.
  - Identify if Ideal Cycle Time and Takt time are correct for each SKU
  - Identify if Slow Cycles, Small Stops and Full Stop Thresholds are programmed correctly.
- Time Schedules and Shift naming consistency
  - All shift names are the same – First Shift or 1st Shift, etc.
  - Time Schedules, make all lines consistent - 8hr shifts vs 12hr shifts, breaks and lunches, weekends and not scheduled.
  - Discuss how to manage the time schedule when your shifts start at different times. The recommendation is that you schedule each shift to start at the same time in the time schedule, and create a "Standby until run" program so that at the start of the shift the unit stays in Standby mode. The unit automatically enters run time once the first part is made.
  - Discuss Breaks and Lunches
  - Simplify process for easy update and maintenance

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- All SKUs need to be updated
    - Need to simplify process within Vorne XL for easy update
    - What happens at a Job Reset? Do you automatically go into setup?
    - Need consistent Shift Resets and Job Resets

Understand how to use XL Interface

- Understand the capabilities of the software
    - Reports that can be run
    - Importance of scanning downtime reasons to eliminate downtime paperwork

Recommendations

- Start with one line – test everything to make sure it is working as expected.
- Print barcodes on colored paper to match the production state – Down (pink), Setup (blue), Standby (yellow), Parts (green). Don't forget the Split Down Reason barcode.
- Pilot this line for a minimum of one week and train the operators/line leads/supervisors, etc. on all shifts.
- Do the same for the remaining lines in your plant. This whole process should take about 4 weeks for a 5-6-line plant.
- Plan for the rest of the enterprise

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