

The background of the slide is a light blue isometric illustration of a factory floor. It features various industrial equipment, including robotic arms, conveyor belts, and large cylindrical tanks, all rendered in a simplified, geometric style. The perspective is from a high angle, looking down at the machinery.

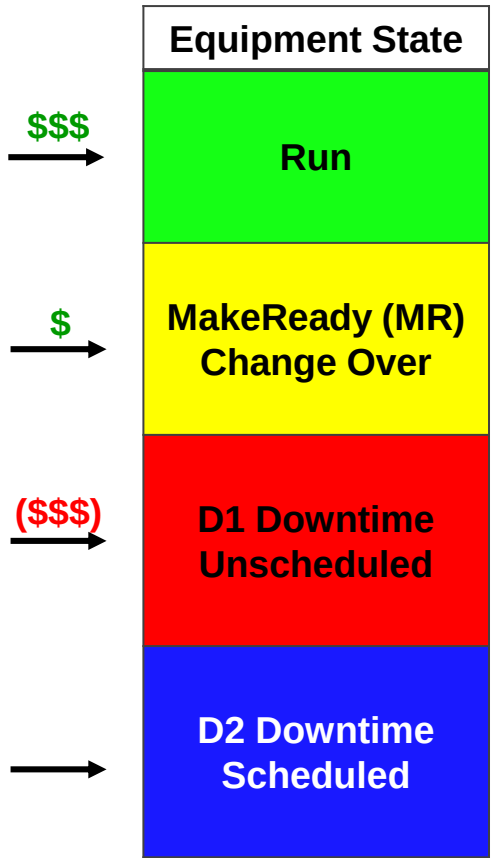
flexMetrics

Flex Introduction

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Flex Equipment States

Flex provides a simple framework to identify the impact of Work mix on Contribution per Hour (Throughput)



Configure the Flex-Rules to define the Machine Status

Direct Machine Speed > minimum RUN threshold for XX seconds
Customer Job = Have work to run
Current Job Count < Target Good

Direct Machine Speed < threshold
Customer Job = Have work to run
Current Job Count = Target Good

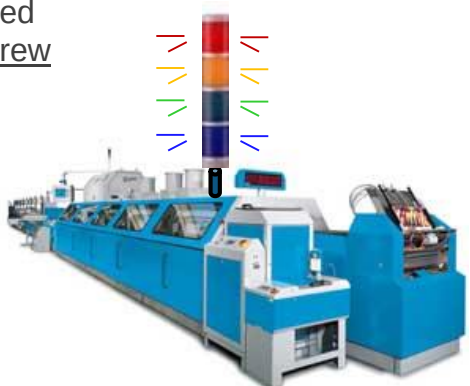
Direct Machine Speed = Stopped
Customer Job = Have work to run
Current Job Count <= Target Good

Direct Machine Speed = Stopped
Customer Job = No work, No Crew
Current Job Count = N/A

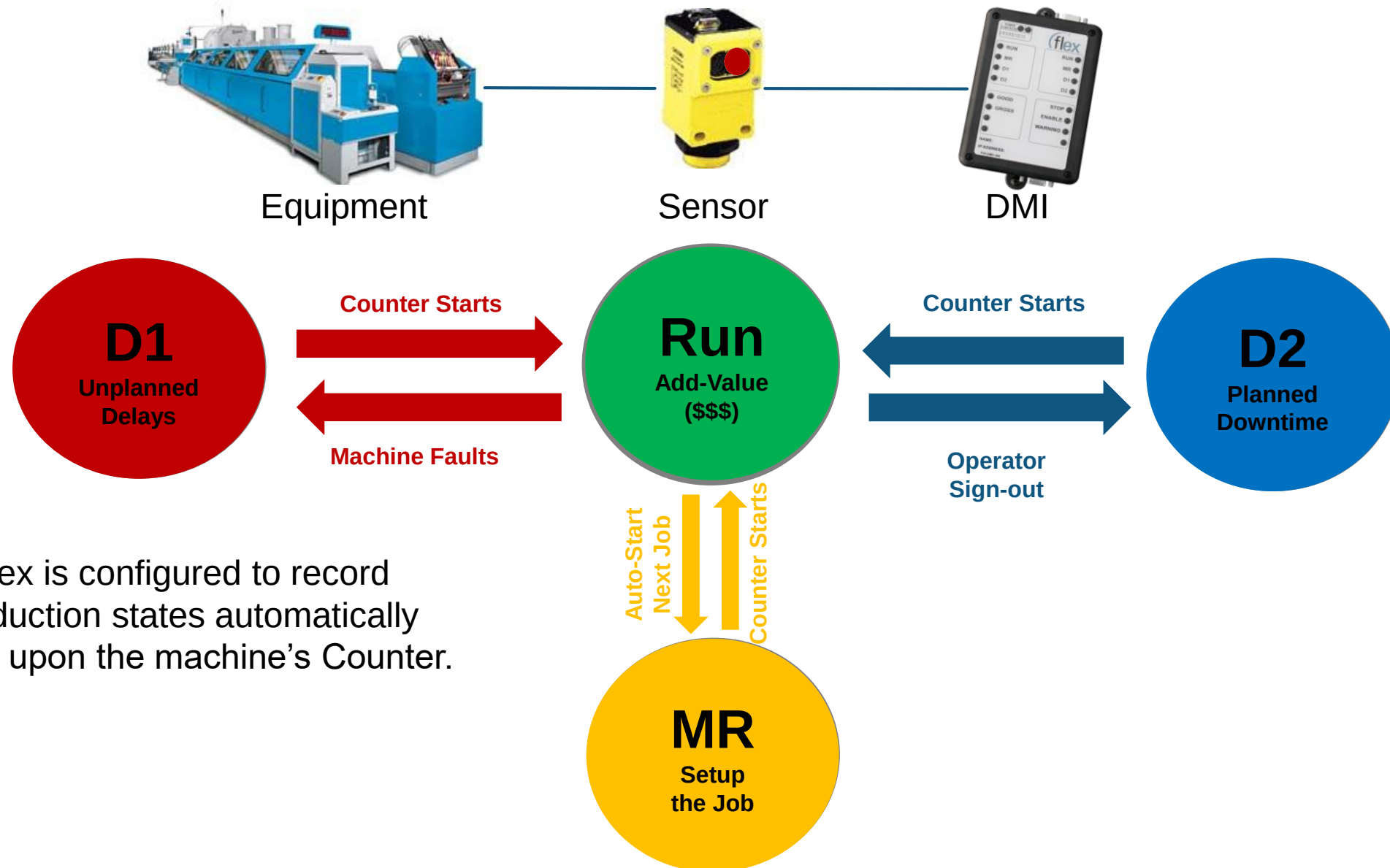
Flex-DMI

Flex is configured to determine the state *automatically*.

D2 is Scheduled Downtime or Planned Downtime (No Crew)
D2 represents available Capacity that could be sold
TPut is the 'Pace' of \$\$\$/Hr that can be expected when Crewed



Typical Production Workflow



Flex Cycle for OEE and Throughput:

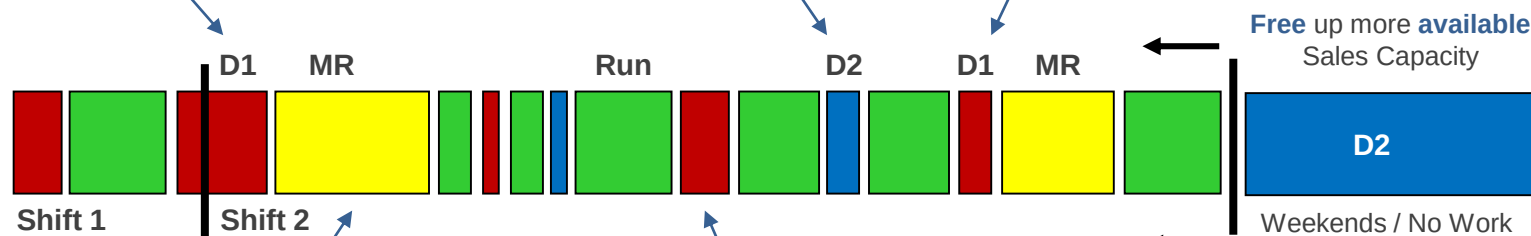
Reduce avoidable losses to increase \$\$\$/Hr contribution



Shift Change D1 – how will we get our equipment running within 10 minutes of a shift change?

Can we find any way to team together & run through **Lunch** or **Breaks**?

End of Job D1 – how will we get our end-of-job cleanup completed within 5 minutes of our final good count?



MR / Setup Reduction – once we enter a new MR on a Job, we can score **significant** Flex Points if we beat the Count Down Clock for the MR Standard of the Job Sequence we are running.

Repairs D1 – how do we quickly assess if we need to call Maintenance or if we can get this delay closed as quickly as possible for ourselves?

Park it in D2! – as Process Capability increases (*Flex Scores go up*), there will be more D2 time each week. This becomes **sellable** capacity for your sales team to aggressively price / pursue!

40,000 Net Good per 8 Hours = 5,000/Hr

Key Concept: Predictability is critical in order to grow sales without overtime & outsourcing. If Sales demand drops, a Flex-based management system will see **true D2 available capacity** increase. (without a Direct Machine Interface – the work tends to fill the time available)

Flex Cycle for OEE and Throughput:

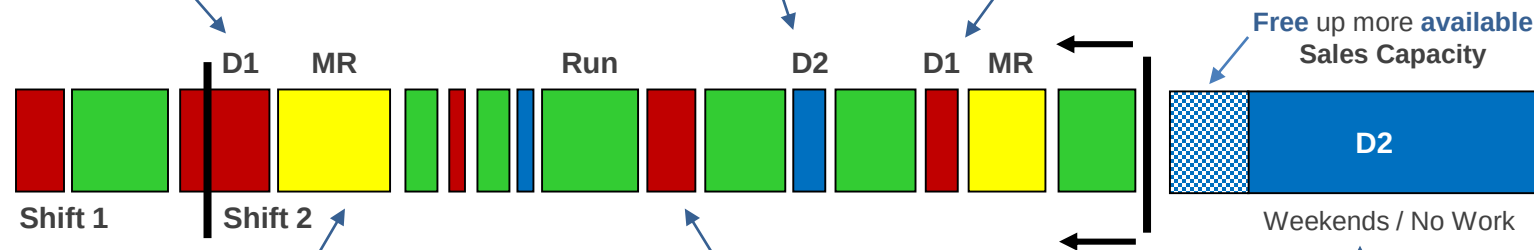
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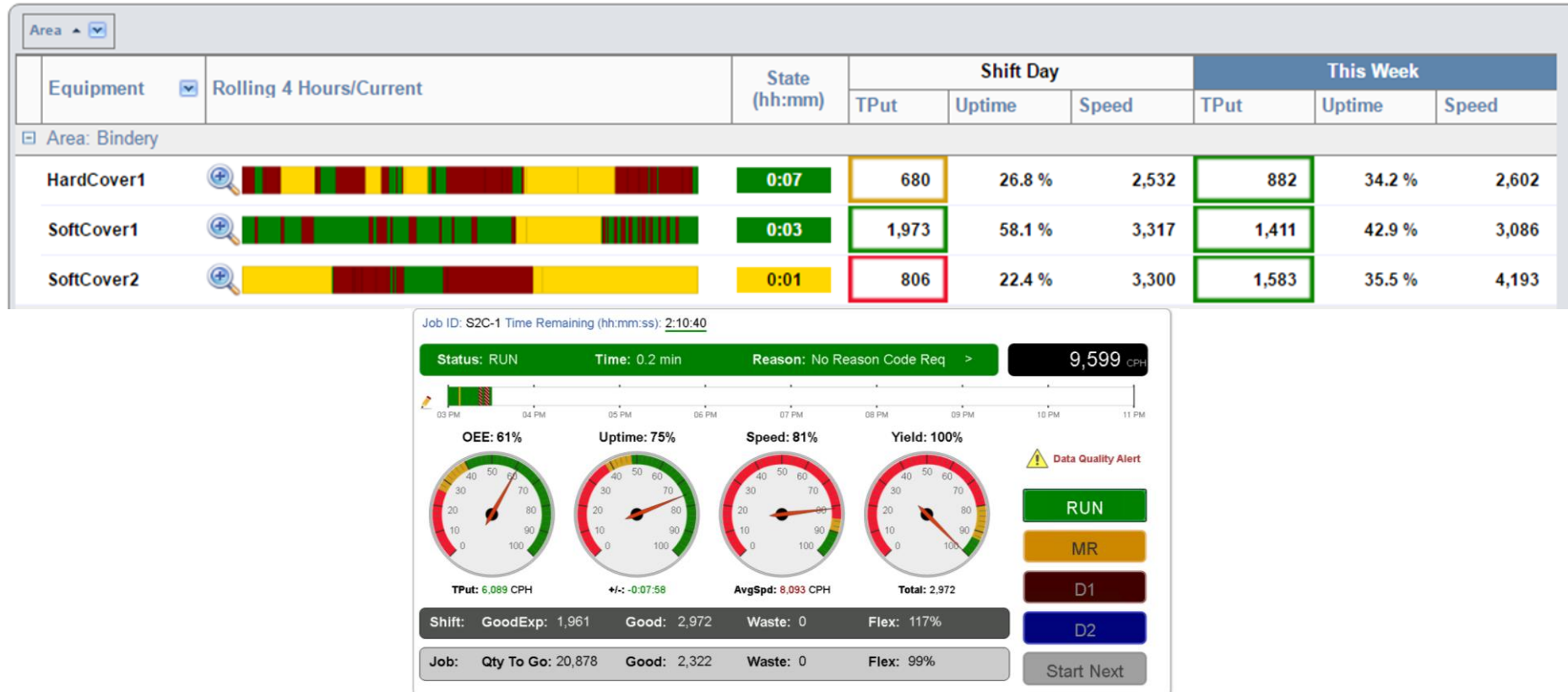
40,000 Net Good per 7 Hours = 5,714/Hr

Key Concept: Predictability is critical in order to grow sales without overtime & outsourcing.
If Sales demand drops, a Flex-based management system will see **true D2 available capacity** increase.
(without a Direct Machine Interface – the work tends to fill the time available)

Flex Shift Day Challenge:

Engage Operators & Shift Team Leads

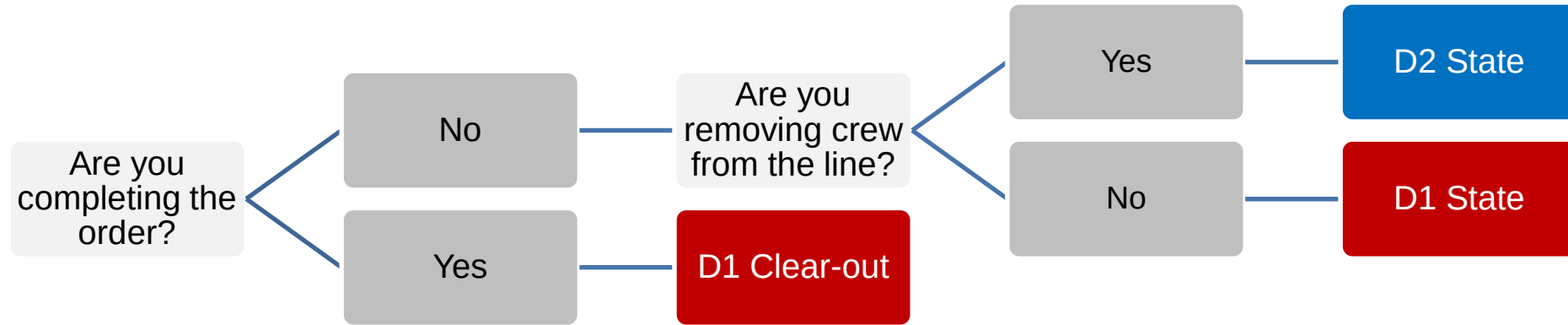
“Keep it Green” - focus on beating the Weekly and Monthly Records



Key Concept of OEE Challenge is to get more predictability each Week:

1. What should I expect for a Great Shift?
2. What should I expect for a Great Shift Day (24 hrs)?
3. Keep it Green every Shift will result in a 'Green Day', 'Green Week' and a **Great Month**

When Line is in a D1 (Red) State:



Line Remains in D1 state until...

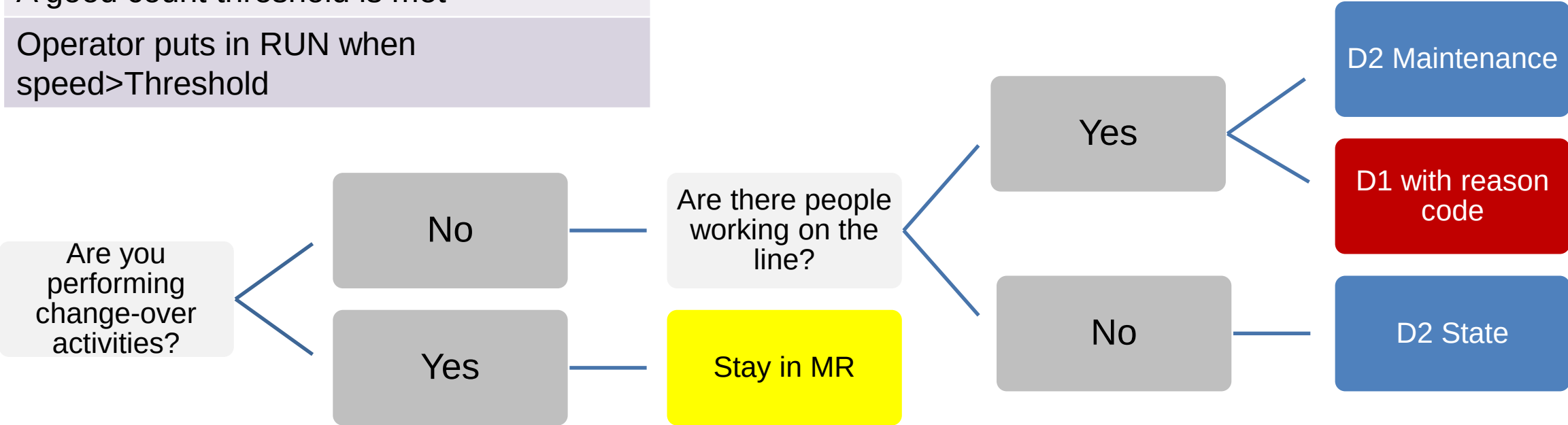
- Machine restarts (RUN)
- Crew removed then select D2 with reason code
- Start Next Job (Change-Over)

Line Remains in D2 state until...

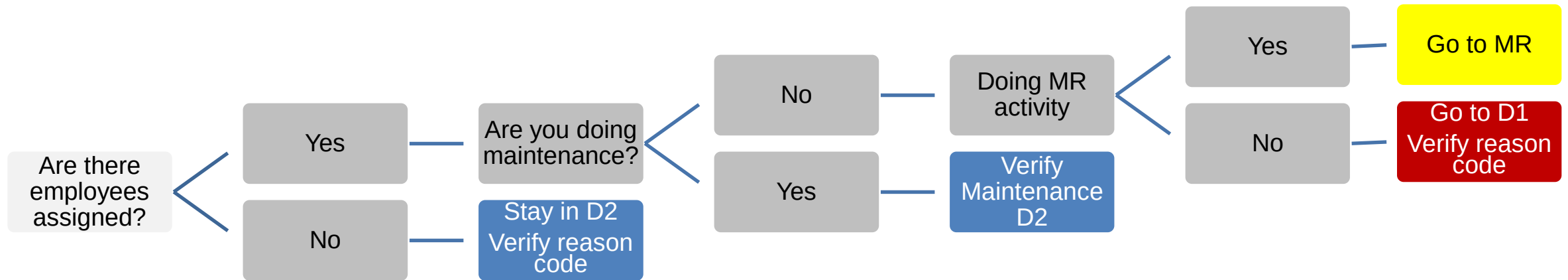
- Machine restarts (RUN)
- Crew returns then select D1 with reason code
- Start Next Job (Change-Over)

When Line is in MR/Change-Over (Yellow) State:

- Line Remains in MR state until...
- Machine stays above speed threshold for specified timeframe
- A good count threshold is met
- Operator puts in RUN when speed>Threshold



When Line is in D2 (Blue) State:



Line Remains in D2 state until...	Line Remains in MR state until...	Line Remains in D1 state until...
Machine restarts (RUN)	Machine stays above speed threshold for specified timeframe	Machine restarts (RUN)
Select D1 with reason code	A good count threshold is met	Crew removed select D2 with reason code
Start Next Job (Change-Over)	Operator puts in RUN	Start Next Job (Change-Over)