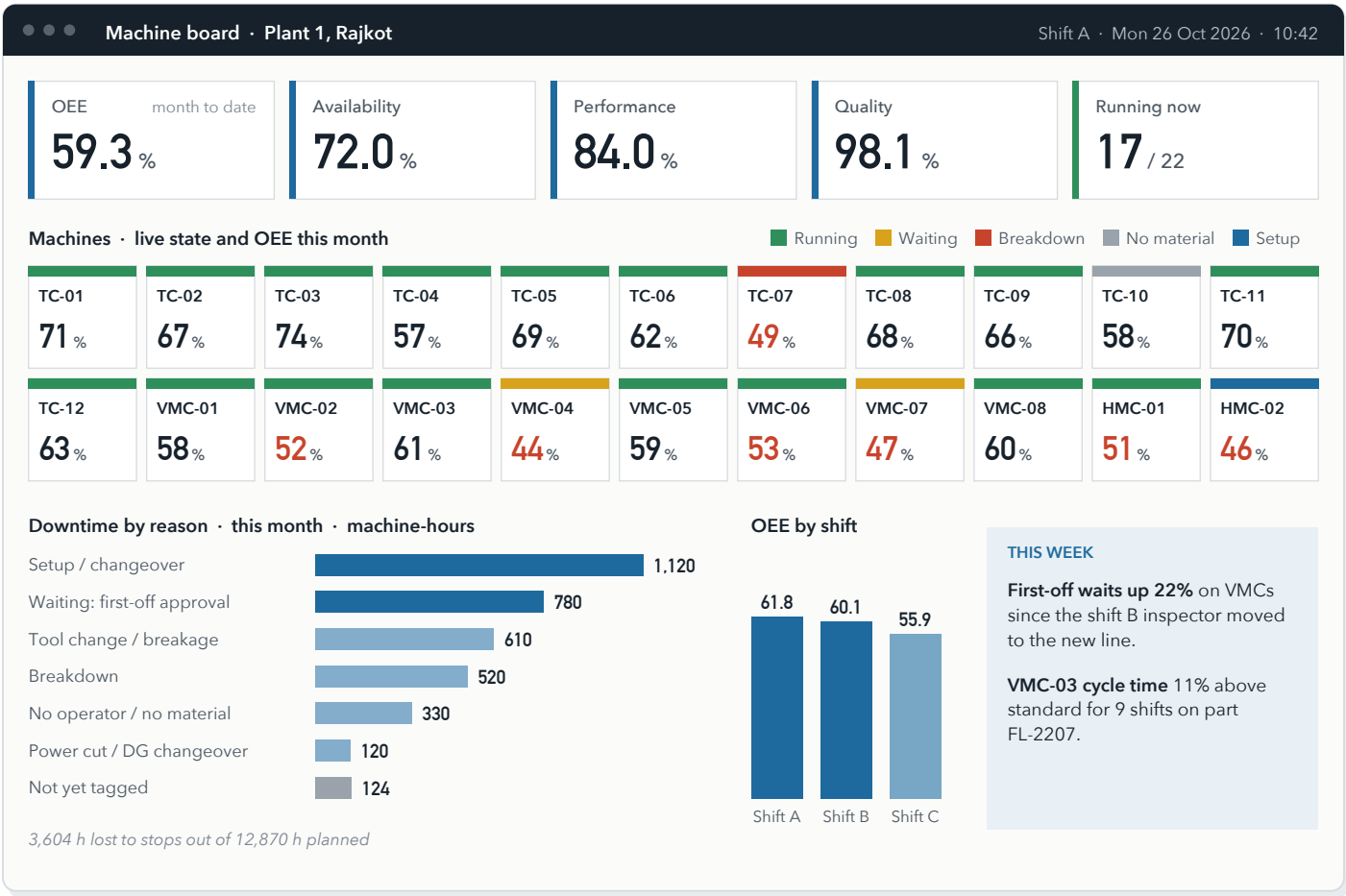


DOWNTIME · CYCLE TIME · OEE · PRODUCTION PLANNING

See where every machine hour goes.

Downtime, cycle time and OEE for every machine and every shift, captured from the machine itself. Then a production plan built on what your machines really deliver, not on quoted cycle times.



Every stop

Detected by the machine, explained by the operator in one tap. Short stops of a few minutes count too, because together they are often the biggest loss.

Every cycle

Measured against its standard, per part, machine and shift. Slow drift is flagged before it quietly becomes the new normal.

Every order

Checked against what your machines actually deliver, with changeovers, maintenance and holidays in the calendar, before you promise a date.

Works with the machines you already have

Fanuc and Siemens controls connect directly (FOCAS over Ethernet, OPC UA). Older machines without a data port get a clamp-on current sensor and a part counter. No change to your CNC programs, and the platform never writes to a machine.

01 Compliance

Energy, carbon and export passports

02 Quality

Process fingerprint and golden window

03 Safety

Thermal watch and early fire alarms

04 Process

Downtime, cycle time, OEE, planning

ILLUSTRATIVE PLANT

22 CNC machines, Rajkot, Gujarat

Parts for two-wheeler and tractor OEMs · 3 shifts · ~1,100 changeovers a month

12

Turning centres
9 FOCAS · 3 sensor

8

VMCs
6 FOCAS · 2 OPC UA

2

HMCs
2 FOCAS

THREE THINGS THE PLANT FOUND IN ITS FIRST MONTH

01 780 hours lost waiting for first-off approval

All 22 machines · this month

After each changeover the first part goes to the QC room. Operators tagged the wait with one tap, and it added up to 780 machine-hours: the second-biggest loss after setup itself. Two inspectors cover 22 machines on shift A, one on shifts B and C.

Action: inspector call button on the board and gauges at the machine for repeat parts. Halving the wait frees about 390 hours a month, two-thirds of a machine.

02 VMC-03 slowed down by 27 seconds a part

Flange FL-2207 · last 3 weeks

Standard cycle 4 min 12 s. The median crept up to 4 min 39 s over three weeks, and no shift report showed it. Cycle data pointed to shifts B and C, where operators had cut the feed to stop chatter on worn inserts.

Alert after 3 shifts above the 5% drift limit. At 230 parts a day, the drift was costing about 1 h 45 min of VMC-03 every day.

03 Can we ship 18,000 shafts by 20 November?

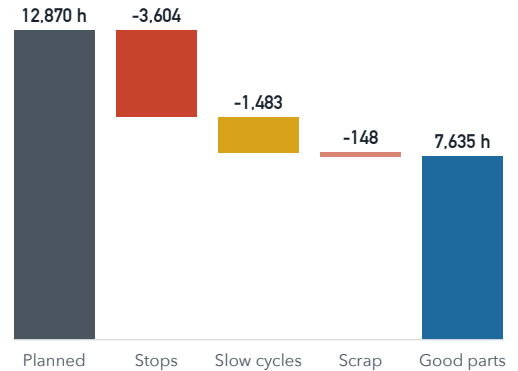
New order · 4 turning centres qualified

The plan uses each machine's demonstrated rate, not the quoted cycle time: 440 shafts per machine per day including real losses. 17 working days are left after the Diwali shutdown, which is already in the calendar.

Two machines: about 4 days late. **Three machines:** done with 3 days to spare, and the bracket order on TC-06 moves by 2 days. The planner decides before quoting.

OEE in hours, not just a percentage

All 22 machines · this month

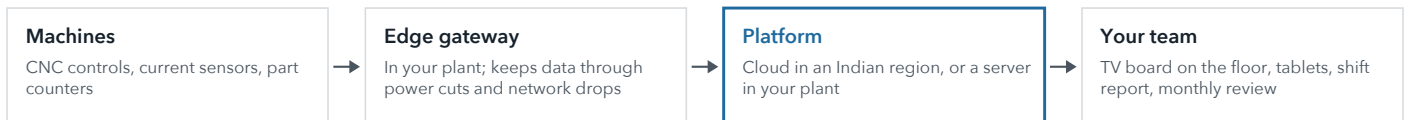


7,635 productive hours out of 12,870 planned = **59.3% OEE**. Formula to ISO 22400; every hour traces back to a logged machine signal or operator tag.

CHOOSE YOUR FEATURES

☒	Machine connection FOCAS, OPC UA, MTConnect, current sensors	CORE
☒	Live machine board TV, tablet or phone; operator call	CORE
☒	Downtime reasons One tap, in Gujarati, Hindi or English	CORE
☒	OEE and loss hours Per machine, part and shift (ISO 22400)	CORE
☒	Cycle-time analysis Standards, drift alerts	CORE
☐	Capacity planning Load chart, promise-date check	OPTION
☐	Shift reports WhatsApp or SMS headline at shift end	OPTION
☐	ERP orders Tally, SAP Business One or Excel	OPTION
☐	Energy per part Shared meters from the Compliance module	OPTION

HOW IT FITS TOGETHER



START WITH WHAT YOU HAVE

TIER 0 Tablets only Operators log stops and counts on a tablet. Downtime by reason from week one.	TIER 1 Gateway + sensors Automatic run/stop and part counts on your bottleneck machines.	TIER 2 All controls connected Every CNC connected: cycle times, alarms, programs, OEE per part.
--	---	--

01 Compliance

Energy, carbon and export passports

02 Quality

Process fingerprint and golden window

03 Safety

Thermal watch and early fire alarms

04 Process

Downtime, cycle time, OEE, planning