

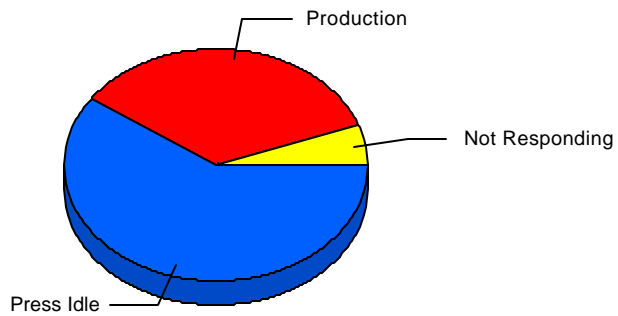
Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Machine Number 1234

Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Press Idle	12	08:42:16	00:43:31	59.6%
Production	91	05:05:14	00:03:21	34.8%
Not Responding	28	00:48:27	00:01:43	5.5%
High Limit Alarm	1			
Job Change	1			
Low Limits Turned ON	9			
Prog Mode Entered	7			
Reverse Limits Turned ON	8			
Run Mode Entered	7			

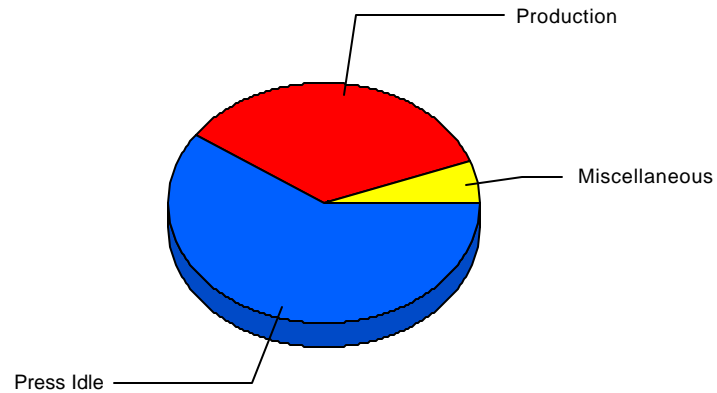


Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Press Idle	3	08:42:16	02:54:05	59.6%
Production	3	05:05:14	01:41:44	34.8%
Miscellaneous	3	00:48:27	00:16:09	5.5%



Standard Rates/Utilization

<u>Die Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
2	7:45:18	60.0	0.7	27918	322	1.2%
123456	6:15:07	60.0	0.6	22507	231	1.0%
All Dies	14:00:25	60.0	0.7	50425	553	1.1%

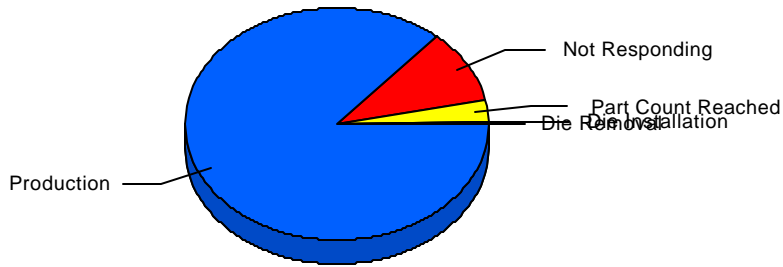
Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Machine Number 4321

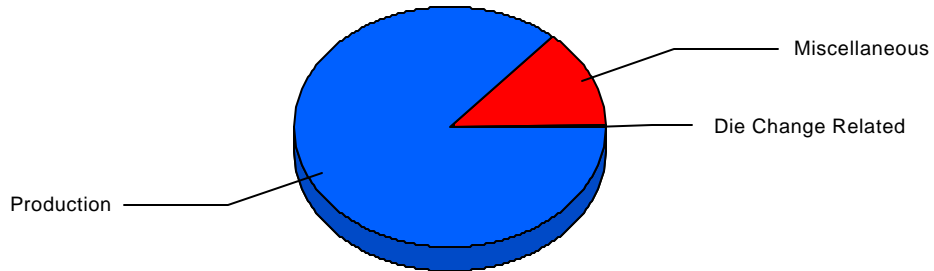
Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	110	12:18:59	00:06:43	86.4%
Not Responding	98	01:27:55	00:00:53	10.3%
Part Count Reached	6	00:25:28	00:04:14	3.0%
Die Installation	2	00:01:30	00:00:45	0.2%
Die Removal	1	00:01:17	00:01:17	0.2%



Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	5	12:18:59	02:27:47	86.4%
Miscellaneous	9	01:53:23	00:12:35	13.3%
Die Change Related	2	00:02:47	00:01:23	0.3%



Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Standard Rates/Utilization

<u>Die Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
0	1:36:11	0.0	0.0	0	0	N/A
1	0:42:15	50.0	0.0	2113	0	0.0%
2	2:30:25	11.9	2.4	1790	368	20.6%
3	0:39:25	60.0	3.0	2365	120	5.1%
4	0:01:59	0.0	0.0	0	0	N/A
All Dies	5:30:15	19.0	1.5	6268	488	7.8%

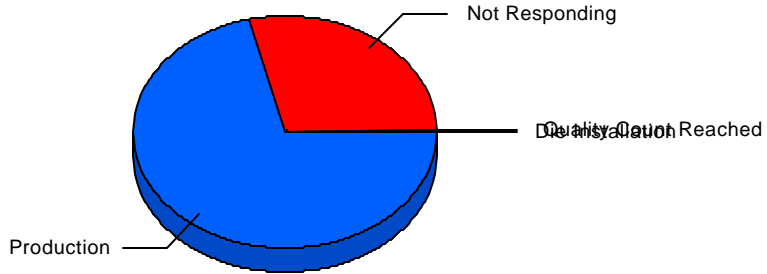
Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Machine Number 4322

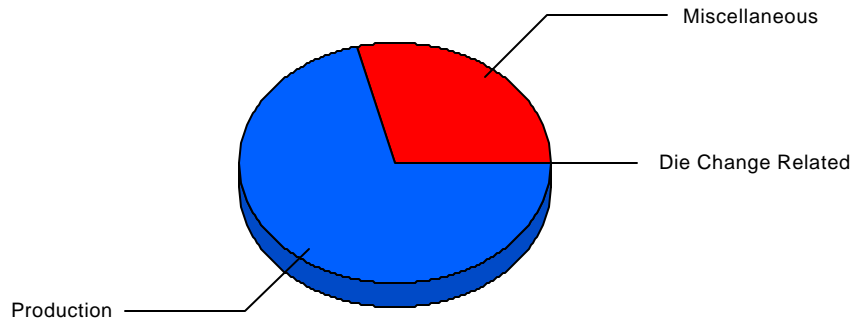
Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	13	02:19:03	00:10:41	71.2%
Not Responding	6	00:55:38	00:09:16	28.5%
Quality Count Reached	2	00:00:41	00:00:20	0.3%
Die Installation	2	00:00:03	00:00:01	0.0%



Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	2	02:19:03	01:09:31	71.2%
Miscellaneous	3	00:56:19	00:18:46	28.8%
Die Change Related	1	00:00:03	00:00:03	0.0%



Summary (By Press) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:48:49PM

Standard Rates/Utilization

<u>Die Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
0	3:20:55	0.0	0.2	0	32	N/A
All Dies	3:20:55	0.0	0.2	0	32	N/A

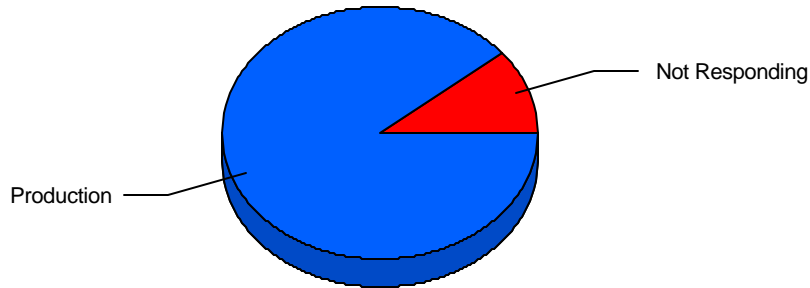
Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Die Number 1

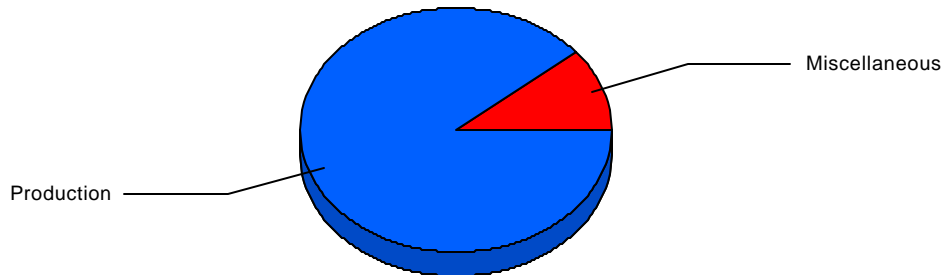
Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	29	01:05:29	00:02:15	88.8%
Not Responding	27	00:08:14	00:00:18	11.2%



Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	1	01:05:29	01:05:29	88.8%
Miscellaneous	1	00:08:14	00:08:14	11.2%



Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Standard Rates/Utilization

<u>Mach Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
4321	0:42:15	50	0	2113	0	0.0%
All Machines	0:42:15	50	0	2113	0	0.0%

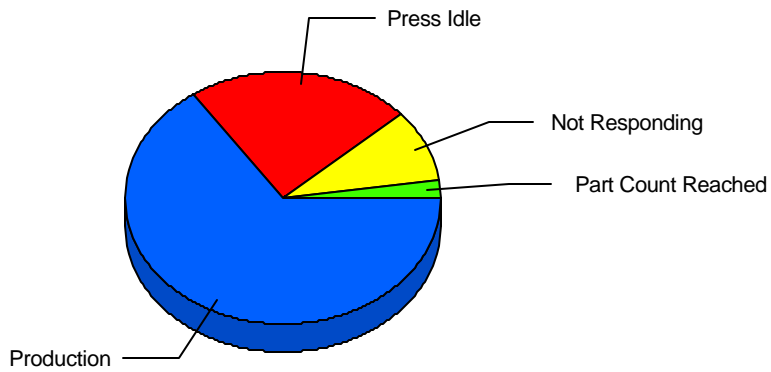
Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Die Number 2

Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	131	12:09:27	00:05:34	65.2%
Press Idle	7	04:19:51	00:37:07	23.2%
Not Responding	74	01:44:07	00:01:24	9.3%
Part Count Reached	6	00:25:28	00:04:14	2.3%
High Limit Alarm	1			
Low Limits Turned ON	3			
Prog Mode Entered	6			
Reverse Limits Turned ON	3			
Run Mode Entered	6			

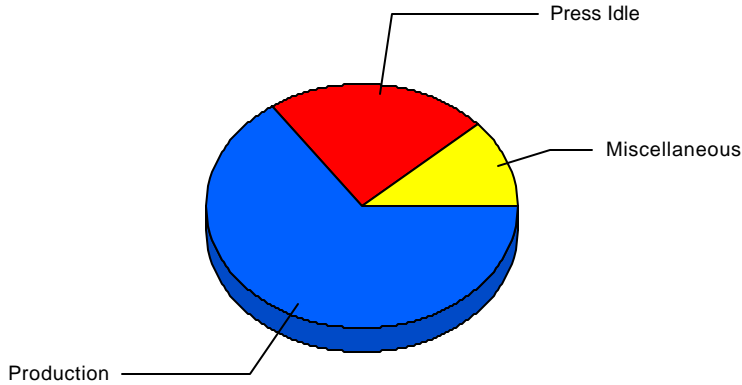


Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	4	12:09:27	03:02:21	65.2%
Press Idle	2	04:19:51	02:09:55	23.2%
Miscellaneous	5	02:09:35	00:25:55	11.6%



Standard Rates/Utilization

<u>Mach Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
1234	7:45:18	60	1	27918	322	1.2%
4321	2:30:25	12	2	1790	368	20.6%
All Machines	10:15:43	48	1	29708	690	2.3%

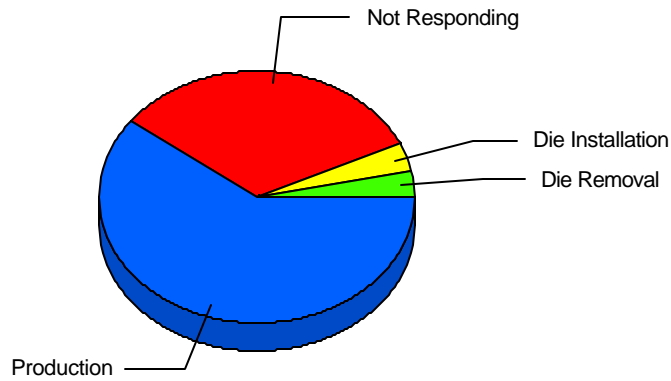
Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Die Number 3

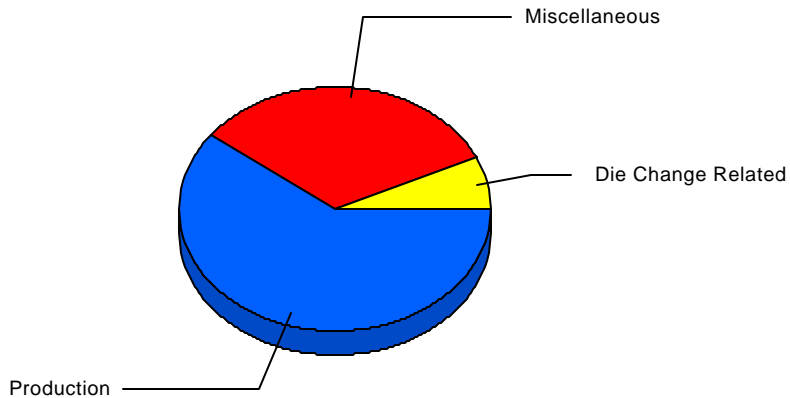
Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	8	00:24:13	00:03:01	60.3%
Not Responding	5	00:13:09	00:02:37	32.8%
Die Installation	2	00:01:30	00:00:45	3.7%
Die Removal	1	00:01:17	00:01:17	3.2%



Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	1	00:24:13	00:24:13	60.3%
Miscellaneous	1	00:13:09	00:13:09	32.8%
Die Change Related	2	00:02:47	00:01:23	6.9%



Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Standard Rates/Utilization

<u>Mach Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
4321	0:39:25	60	3	2365	120	5.1%
All Machines	0:39:25	60	3	2365	120	5.1%

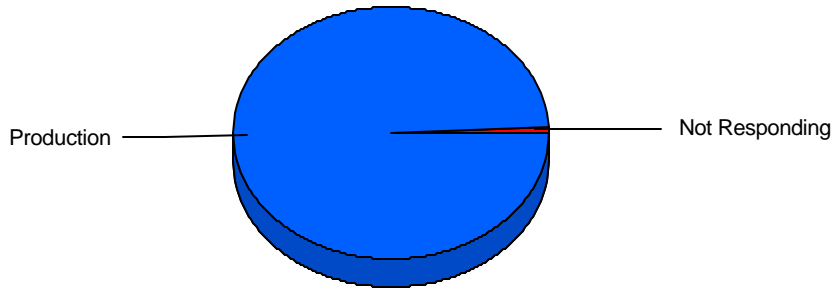
Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Die Number 4

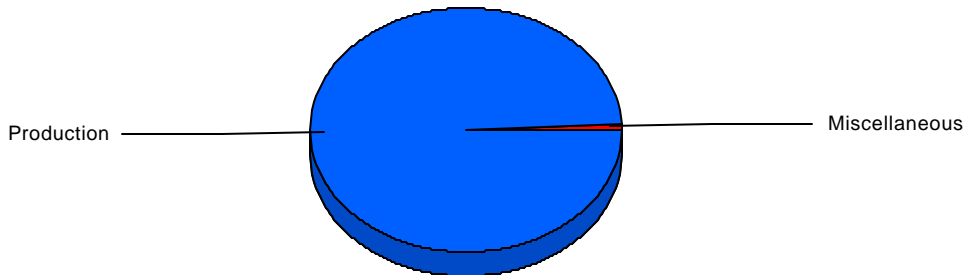
Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	2	01:06:30	00:33:15	99.2%
Not Responding	1	00:00:32	00:00:32	0.8%



Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Production	1	01:06:30	01:06:30	99.2%
Miscellaneous	1	00:00:32	00:00:32	0.8%



Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Standard Rates/Utilization

<u>Mach Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
4321	0:01:59	0	0	0	0	N/A
All Machines	0:01:59	0	0	0	0	N/A

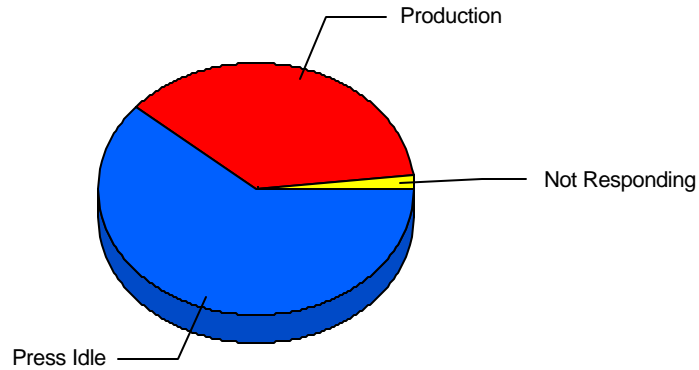
Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Die Number 123456

Down Time Code Analysis (Specific)

<u>Description</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Press Idle	5	04:22:25	00:52:29	61.3%
Production	31	02:38:34	00:05:06	37.1%
Not Responding	13	00:06:47	00:00:31	1.6%
Job Change	1			
Low Limits Turned ON	6			
Prog Mode Entered	1			
Reverse Limits Turned ON	5			
Run Mode Entered	1			

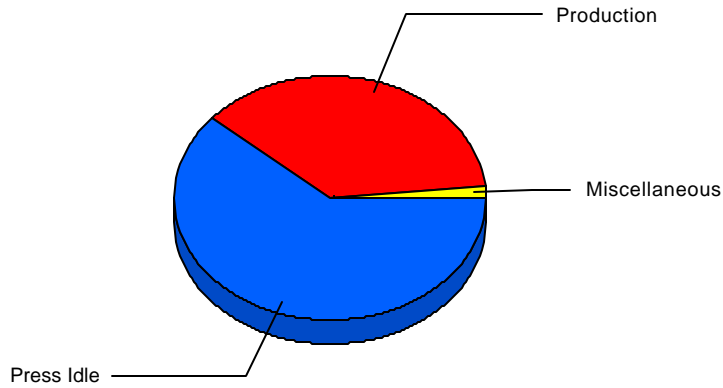


Summary (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:50:53PM

Down Time Code Analysis (By Category)

<u>DTC Category</u>	<u># Occ.</u>	<u>Tot Time</u>	<u>Avg Time</u>	<u>% of Tot</u>
Press Idle	1	04:22:25	04:22:25	61.3%
Production	1	02:38:34	02:38:34	37.1%
Miscellaneous	1	00:06:47	00:06:47	1.6%



Standard Rates/Utilization

<u>Mach Num</u>	<u>Total Time</u>	<u>Standard Rate</u>	<u>Average Rate</u>	<u>Avail Strokes</u>	<u>Actual Strokes</u>	<u>Utilization</u>
1234	6:15:07	60	1	22507	231	1.0%
All Machines	6:15:07	60	1	22507	231	1.0%

Tonnage Alarms (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:51:52PM

Die Number 1							
<u>Mach Num</u>	<u>Run Time</u>	<u>Strokes</u>	<u>High Lim Alarms</u>	<u>Low Lim Alarms</u>	<u>Rev Lim Alarms</u>	<u>First Run (for this period)</u>	<u>Last Run (for this period)</u>
4321	00:42:15	0	0	0	0	6/23/1999 9:57:45AM	6/24/1999 1:50:00PM
All	00:42:15	0	0	0	0	6/23/1999 9:57:45AM	6/24/1999 1:50:00PM

Die Number 2							
<u>Mach Num</u>	<u>Run Time</u>	<u>Strokes</u>	<u>High Lim Alarms</u>	<u>Low Lim Alarms</u>	<u>Rev Lim Alarms</u>	<u>First Run (for this period)</u>	<u>Last Run (for this period)</u>
1234	07:45:18	322	1	0	0	4/30/1999 11:50:00AM	5/10/1999 7:00:00PM
4321	02:30:25	368	0	0	0	6/24/1999 9:00:31AM	8/4/1999 10:20:00AM
All	10:15:43	690	1	0	0	4/30/1999 11:50:00AM	8/4/1999 10:20:00AM

Die Number 3							
<u>Mach Num</u>	<u>Run Time</u>	<u>Strokes</u>	<u>High Lim Alarms</u>	<u>Low Lim Alarms</u>	<u>Rev Lim Alarms</u>	<u>First Run (for this period)</u>	<u>Last Run (for this period)</u>
4321	00:39:25	120	0	0	0	8/3/1999 7:40:00PM	8/3/1999 8:27:37PM
All	00:39:25	120	0	0	0	8/3/1999 7:40:00PM	8/3/1999 8:27:37PM

Die Number 4							
<u>Mach Num</u>	<u>Run Time</u>	<u>Strokes</u>	<u>High Lim Alarms</u>	<u>Low Lim Alarms</u>	<u>Rev Lim Alarms</u>	<u>First Run (for this period)</u>	<u>Last Run (for this period)</u>
4321	00:01:59	0	0	0	0	8/3/1999 7:38:01PM	8/3/1999 7:40:00PM
All	00:01:59	0	0	0	0	8/3/1999 7:38:01PM	8/3/1999 7:40:00PM

Die Number 123456							
<u>Mach Num</u>	<u>Run Time</u>	<u>Strokes</u>	<u>High Lim Alarms</u>	<u>Low Lim Alarms</u>	<u>Rev Lim Alarms</u>	<u>First Run (for this period)</u>	<u>Last Run (for this period)</u>
1234	06:15:07	231	0	0	0	4/28/1999 5:00:00PM	4/30/1999 11:20:25AM
All	06:15:07	231	0	0	0	4/28/1999 5:00:00PM	4/30/1999 11:20:25AM

High/Low/Avg Tonnage (By Die) Over All Time (Shifts 1 and 2)

Generated 6/21/2000 at 4:53:07PM

Die Number 2												
<u>Mach Num</u>	<u>Window</u>	<u>Ton Type</u>	<u>Tot Fwrd</u>	<u>Ch 1 Fwrd</u>	<u>Ch 2 Fwrd</u>	<u>Ch 3 Fwrd</u>	<u>Ch 4 Fwrd</u>	<u>Tot Rev</u>	<u>Ch 1 Rev</u>	<u>Ch 2 Rev</u>	<u>Ch 3 Rev</u>	<u>Ch 4 Rev</u>
1234	Peak	Highest Good	46.3	16.8	17.2	14.1	16.7	5.1	5.1	4.8	1.8	0.9
		Average	45.7	16.7	17.0	14.0	16.5	4.7	4.7	4.4	1.7	0.8
		Lowest Good	45.1	16.5	16.8	13.9	16.4	4.1	4.0	3.6	1.7	0.7

Die Number 123456												
<u>Mach Num</u>	<u>Window</u>	<u>Ton Type</u>	<u>Tot Fwrd</u>	<u>Ch 1 Fwrd</u>	<u>Ch 2 Fwrd</u>	<u>Ch 3 Fwrd</u>	<u>Ch 4 Fwrd</u>	<u>Tot Rev</u>	<u>Ch 1 Rev</u>	<u>Ch 2 Rev</u>	<u>Ch 3 Rev</u>	<u>Ch 4 Rev</u>
1234	Peak	Highest Good	46.9	17.3	17.2	14.1	17.2	5.2	5.2	4.8	1.8	0.9
		Average	46.4	17.2	17.0	14.0	17.1	4.8	4.8	4.4	1.7	0.9
		Lowest Good	45.8	16.9	16.8	13.9	16.9	4.1	4.0	3.3	1.6	0.7

Link Systems LinkNet Tonnage Waveform

Captured From: OmniLink 5000
Machine: 1234 (OmniLink 5000)
Job: 2 (JOB 2)
Approx SPM: 179 SPM
Die Strokes: 0
Date/Time: 05/10/1999 at 07:04:37 PM

All Channels

