NEUGEBAUER Rhapso GmbH

Conversion

Computation Base for PC Topp Plant Performance Reports • 1/4

Category	Unit	Substitute	Formula	Title	Comment
Total Time	**h**	**totaltime**	setuptime + runtime + minidowntime + downtime	**Total Work Time**	Work time excl. breaks, but incl. downtime and mini downtimes
Setup Time h ST	**h**	**setuptime**		**Setup Time**	Time needed for machine setup
% ST	**%**		(runtime / totaltime) * 100	**Percentage of Run Time**	Runtime expressed in percent of work time excl. breaks, but incl. downtime and mini downtimes
	(h)	**(expsetuptime)**		**Expected Setup Time**	Estimated on the basis of normal machine performance; depends on machine parameters
	(h)	**(basicruntime)**		**Basic Run Time**	Work time excl. breaks, downtime and mini downtimes
Run Time h RT	**h**	**runtime**	basicruntime + minidowntime	**Run Time**	Work time incl. mini downtimes, but excl. breaks and downtime
% RT	**%**		(runtime / totaltime) * 100	**Percentage of Run Time**	Runtime expressed in percent of work time excl. breaks, but incl. downtime and mini downtimes
	(h)	**(expruntime)**		**Expected Run Time**	Estimated on the basis of normal machine performance; depends on machine parameters
	(h)	**(minidowntime)**		**Mini Downtime**	Any negligible downtime with a duration less than a pre-defined period of time; length depends on machine parameters
Downtime h DT	**h**	**downtime**		**Downtime**	Downtime excl. breaks and mini downtimes
% DT	**%**		(downtime / totaltime) * 100	**Percentage of Downtime**	Downtime expressed in percent of work time excl. breaks, but incl. downtime and mini downtimes
Perf.	**%**		((expruntime + expsetup time) / totaltime) * 100	**Performance**	Actual machine speed compared to expected speed during work time excl. breaks, but incl. downtime and mini downtimes

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Perf. ST	%		(setuptime / totaltime) * 100	Setup Time Performance	Percentage of setup time in relation to work time excl. breaks, but incl. downtime and mini downtimes
Perf. RT	%		(runtime / totaltime) * 100	Run Time Performance	Percentage of run time in relation to work time excl. breaks, but incl. downtime and mini downtimes
No. of Runs	runs	numberofruns		Number of Runs (or Orders)	Total number of runs (or orders) incl. runs with and without die-cut
with Die-Cut runs	runs	runswithdiecut		Number of Runs (or Orders) With Die-Cut	Number of runs runs (or orders) excl. runs without die-cut
%	%		(runswithdiecut / numberofruns) * 100	Percentage of Runs (or Orders) With Die-Cut	Amount of runs runs (or orders) with die-cut expressed in percent of total number of runs
no Die-Cut runs	runs	runsnodiecut	numberofruns - runswithdiecut	Number of Runs (or Orders) Without Die-Cut	Number of runs runs (or orders) excl. runs with die-cut
%	%		(runsnodiecut / numberofruns) * 100	Percentage of Runs (or Orders) Without Die-Cut	Amount of runs without die-cut expressed in percent of total number of runs
Total Good sht.	sht	goodsheets		Total Good Sheets Produced	
Total m²	m²	totalm2		Total Square Meters Produced	
Ø sht/Order	sht		goodsheets / numberofruns	Average Order Size	Average number of sheets produced per order
Ø m²/Order	m²		totalm2 / numberofruns	Average Order Area	Average square meters produced per order
Ø No. Out	out			Average Number Out	
Ø Sheet Size	m²		totalm2 / goodsheets	Average Sheet Size	
Total sht/h	sht/h		goodsheets / totaltime	Average Speed (Per Hour)	Average speed per hour during work time excluding breaks, but incl. downtime and mini downtimes
sht/h RT	sht/h		goodsheets / runtime	Average Speed (Per Hour) During Run	Average speed per hour during work time incl. mini downtimes, but excl. breaks

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					and downtime
sht./h RT+DT	sht/h		goodsheets / (downtime + runtime)	**Sheets Per Hour**	Total sheets produced per hour of work time incl. mini downtimes and downtime, but excl. breaks
Total m²/h	m²/h		totalm² / totaltime	**Average Area Produced Per Hour**	Average area per minute produced during work time incl. mini downtimes, but excl. breaks and downtime
m²/h (RT)	m²/h		totalm2 / runtime	**Average Area Produced During Run**	Average area produced per minute during work time incl. mini downtimes, but excl. breaks and downtime
m²/h RT+ST	m²/h		totalm2 / (setuptime + runtime)	**Average Area Produced During Setup Plus Run**	Average area produced per minute during work time incl. setup time and mini downtimes, but excl. breaks and downtime
Single Wall	sht			**Single Wall: Total Produced Sheets**	
Double Wall	sht			**Double Wall: Total Produced Sheets**	
Triple Wall	sht			**Triple Wall: Total Produced Sheets**	
No Print	sht			**No Print: Total Produced Sheets**	
1 Color	sht			**1 Color: Total Produced Sheets**	
2 Colors	sht			**2 Colors: Total Produced Sheets**	
3+ Colors	sht			**3 Colors: Total Produced Sheets**	
Staff Time	h	stafftime		**Personnel Time**	Personnel time incl. breaks (all persons present added together)
Ø Staff	h		stafftime / totaltime	**Average Staff**	Average number of persons present during work time excl. breaks, but incl. downtime and mini downtimes
Mach. Perf	m²/h		totalm2 / stafftime	**Machine Performance**	Square meters produced per

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				Per Man Hour	hour of personnel time