NEUGEBAUER Rhapso GmbH

Corrugator

Computation Base for PC Topp Plant Performance Reports • 1/3

Category	Unit	Substitute	Formula	Title	Comment
Total Time	**h**	**totaltime**	runtime + downtime	**Total Work Time**	Work time excl. breaks, but incl. downtime
Run Time h RT	**h**	**runtime**		**Run Time**	Work time excl. breaks and downtime
% RT	**%**		(runtime / totaltime) * 100	**Percentage of Run Time**	Runtime expressed in percent of work time excl. breaks, but incl. downtime
	(h)	**(expruntime)**		**Expected Run Time**	Estimated on the basis of normal machine performance; depends on machine parameters
Downtime h DT	**h**	**downtime**		**Downtime**	Downtime excl. breaks
% DT	**%**		(downtime / totaltime) * 100	**Percentage of Downtime**	Downtime expressed in percent of work time excl. breaks, but incl. downtime
Perf.	**%**		(expruntime / totaltime) * 100	**Performance**	Actual corrugator speed compared to expected speed during work time excl. breaks, but incl. downtime
No. of Runs	**runs**	**numberofruns**		**Number of Runs**	
Total m	**m**	**totalmeters**		**Total Lineal Meters Produced**	
Total m²	**m²**	**totalm2**	totalmeters * rollsize	**Total Square Meters Produced**	Incl. trim
Ø m/Run	**m**		totalmeters / numberofruns	**Average Run Length**	Average lineal meters produced per run
Ø m²/Run	**m²**		totalm2 / numberofruns	**Average Run Area**	Average square meters produced per run (incl. trim)
Trim	**%**		(trimm2 / totalm2) * 100	**Trim Percentage**	Trim expressed in percent of total square meters produced
Total Trim	**m²**	**trimm2**		**Trim Area**	
Ø Roll Size	**mm**	**rollsize**	(totalm2 / totalmeters) * 1000	**Average Roll Size**	
Total m/h	**m/h**		totalmeters / totaltime	**Average Speed (Per Hour)**	Average speed per hour during work time excluding breaks, but incl. downtime
m/h RT	**m/h**		totalmeters / runtime	**Average Speed (Per**	Average speed per hour

Category	Unit	Substitute	Formula	Title	Comment
				Hour) During Run	during work time excl. breaks and downtime
Total m²/h	**m²/h**		totalm2 / totaltime	**Square Meters Per Hour**	Total square meters produced per hour of work time excl. breaks, but incl. downtime
m²/h RT	**m²/h**		totalm2 / runtime	**Square Meters Per Hour During Run**	Square meters produced per hour of work time excl. breaks and downtime
Total m/min	**m/min**		(totalmeters / totaltime) / 60	**Average Speed**	Average speed per minute during work time excluding breaks, but incl. downtime
m/min (RT)	**m/min**		(totalmeters / runtime) / 60	**Average Speed During Run**	Average speed per minute during work time excl. breaks and downtime
	(m)	**(totalmeterssingle)**		**Single Wall: Total Lineal Meters**	
	(h)	**(runtimesingle)**		**Single Wall: Run Time**	
	(h)	**(downtimesingle)**		**Single Wall: Downtime**	
Single Wall m	**m²**		totalmeterssingle * rollsize	**Single Wall: Total Produced Area**	Incl. trim
m/min	**m/min**		/totalmeterssingle / (runtimesingle + downtimesingle)) / 60	**Single Wall: Average Speed**	Total lineal meters of single wall produced per minute of total time of single wall
	(m)	**(totalmetersdouble)**		**Double Wall: Total Lineal Meters**	
	(h)	**(runtimedouble)**		**Double Wall: Run Time**	
	(h)	**(downtimedouble)**		**Double Wall: Downtime**	
Double Wall m²	**m²**		totalmetersdouble * rollsize	**Double Wall: Total Produced Area**	Incl. trim
m/min	**m/min**		(totalmetersdouble / (runtimedouble + downtimedouble)) / 60	**Double Wall: Average Speed**	Total lineal meters of double wall produced per minute of total time of double wall
	(m)	**(totalmeterstriple)**		**Triple Wall: Total Lineal Meters**	
	(h)	**(runtimetriple)**		**Triple Wall: Run Time**	
	(h)	**(downtimetriple)**		**Triple Wall: Downtime**	

Category	Unit	Substitute	Formula	Title	Comment
Triple Wall m²	**m²**		totalmeterstriple * rollsize	**Triple Wall: Total Produced Area**	Incl. trim
m/min	**m/min**		(totalmeterstriple / (runtimetriple + downtimetriple)) / 60	**Triple Wall: Average Speed**	Total lineal meters of triple wall produced per minute of total time of triple wall
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
Mach. Perf	**m²/h**		totalm2 / stafftime	**Machine Performance Per Man Hour**	Square meters produced per hour of personnel time