Plant: UNIT – II

Section/Line: Machining Line

Date: 06-Sep-2025

Shift: A (06:00–14:00) / B (14:00–22:00) / C (22:00–06:00)

Supervisor: R. Raghavan

Prepared By: Production Supervisor

Approved By (Plant Head): A. Patel

Daily Production Report

SR.NO	1	2	3
Date	06/09/2025	06/09/2025	06/09/2025
Shift	A	B	C
Dept. /Line	Machining Line	Machining Line	Machining Line
M/C No	M-101	M-102	M-103
Operator	R. Kumar	A. Singh	V. Patel
OPN No	5	6	7
Part No / Name	P123 / Bracket	P456 / Cover	P789 / Housing
Operation	Drilling	Milling	Turning
Target Qty	500	400	600
Actual Qty	460	380	590
Rejection Qty	15	10	8
Good Qty	445	370	582
Reason for Rejection	Tool Wear	Power Fluctuation	Dimensional Defect
Working Hours	8	8	8
Planned Hours	8	8	8
Non-Prod. Hrs	1:30	1:30	2:00
Production Hours	5:30	5:30	6:00
Machine Util. %	68.70%	68.70%	75.00%
Daily Productivity %	92%	95%	98%
Availability %	68.70%	68.70%	75.00%
Performance %	92%	95%	98%
Quality %	96.70%	97.40%	98.60%
OEE %	61.20%	63.50%	72.50%
Cumulative Qty (Day)	445	370	582
Cumulative Qty (Month)	1,200	1,570	2,152
Corrective Action Taken	Tool replaced mid-shift	UPS backup installed	Operator re-trained

Summary of Non-Productive Hours (06-Sep-2025)

- **Setting & Tool Change:** 0.10 hrs
- **Power Failures:** 0.10 hrs (mainly Shift-B)
- **Maintenance:** 0.20 hrs
- **Misc. + Lunch/Tea:** 0.30 hrs
- **No Load:** 0.20 hrs

Total Non-Productive Hours (All Shifts):
1.30 hrs

Key Takeaways

- **Highest Utilization:** Shift C (75% Utilization, OEE 72.5%).
- **Major Loss Factor:** Tool Wear (Shift A) + Power Failure (Shift B).
- **Overall Daily OEE:** ~65.7% → Scope to improve by reducing downtime.