

Andon System

1. Create Downtime

1.1. In case of **any** problem or abnormalities in line need to create downtime through the tabs.

DEPARTMENT ডিপার্টমেন্ট	ERROR CODE ভুল কোড (সংকেত)	MACHINE ID মেশিন আইডি	EPF	DOWN TIME ডাউনটাইম	ACTION একশন
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Downtime Create Screen

1.2. The responsible department need to be selected first.

MAINTENANCE রক্ষণাবেক্ষণ	CUTTING কাটিং	STORES & MARKETING স্টোর	TECHNICAL টেকনিকাল
QUALITY কোয়ালিটি	QUILTING AREA মার্কেটিং	IE IE	QCO কিউসিও

HOME / বাড়ি

1.3. After selecting responsible department need to mention the problem. But in case of Maintenance problem, first need to put machine no and then need to mention the problem.

Machine ID / মেশিন আইডি : 1 Clear / মুছে ফেলুন

1	2	3	4	5
6	7	8	9	0

HOME / বাড়ি BACK / পেছনে OK / ঠিক আছে

Machine ID Input Screen

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Enter CUTTING কাটিং Error Code				
In put delay ইনপুট বিলম্ব	Wrong cut panels ভুল কাট প্যানেল	Wrong Cut mark ভুল কাট মার্ক	Quantities mismatch অসামঞ্জস্য পরিমাণ	Wrong size cut panels ভুল আকারের কাট প্যানেল
Numbering issues নাম্বারিং সমস্যা	Bundle tag issues বান্ডেল ট্যাগ সমস্যা	Fusing Part not received ফিউজিং পার্ট পাওয়া যায় নি	Emb. Cut not recived ই এম বি কাটটি পুনরুদ্ধার করা হয়নি	N
N	N	N	N	N
N	N	N	N	N
HOME / বাড়ি		BACK / পেছনে		

Problem Input Screen

- 1.4. Then need to input ID no of the person giving input. After which the downtime will be started. Once Downtime started it will be notified through Tower lights and Department Display Box.

ID No / আইডি নং :		190502233			Clear / মুছে ফেলুন
1	2	3	4	5	
6	7	8	9	0	
HOME / বাড়ি		BACK / পেছনে		OK / ঠিক আছে	

ID Input Screen

Create Downtime / ডাউনটাইম তৈরি করুন।					
DEPARTMENT ডিপার্টমেন্ট	ERROR CODE ভুল কোড (সংকেত)	MACHINE ID মেশিন আইডি	EPF	DOWN TIME ডাউনটাইম	ACTION একশন
CUTTING কাটিং	In put delay ইনপুট বিলম্ব	NA	190502233	00:00:05	ATTEND উপস্থিত থাকুন

Downtime Calculation Started

Andon System

1.5. Once the Department Display Box Starts to Buzz with lights over the Line number that respective department needed to response to that line as soon as possible.



Andon Tower Light With Buzzer



Department Display Box

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2. Attend Downtime

2.1. When the responsible person of the department notified reaches to the line that asked for solution, they need to input their attendance through the tabs initially.

Create Downtime / ডাউনটাইম তৈরি করুন।					
DEPARTMENT ডিপার্টমেন্ট	ERROR CODE ভুল কোড (সংকেত)	MACHINE ID মেশিন আইডি	EPF	DOWN TIME ডাউনটাইম	ACTION একশন
CUTTING কাটিং	In put delay ইনপুট বিলম্ব	NA	190502233	00:00:05	ATTEND উপস্থিত থাকুন

Attend Screen

2.2. The responsible person from the department need to put his ID no to attend.

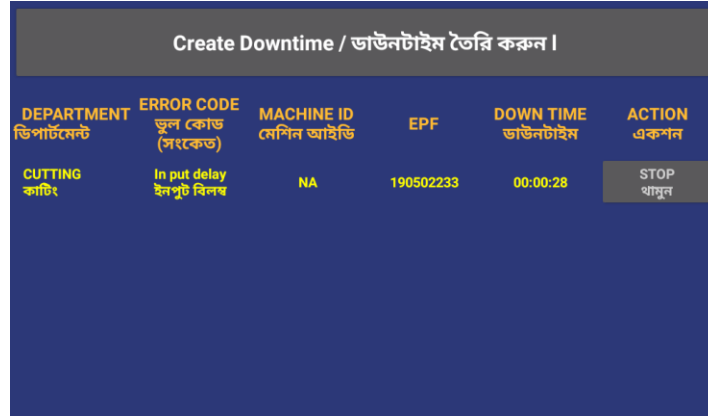
ID No / আইডি নং :		190502222		Clear / মুছে ফেলুন	
1	2	3	4	5	
6	7	8	9	0	
HOME / বাড়ি		BACK / পেছনে		OK / ঠিক আছে	

Attend ID Screen

Andon System

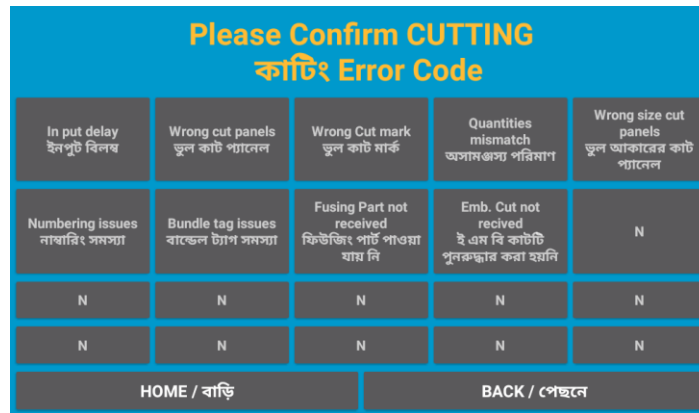
3. Stop Downtime

3.1. After the problems/abnormalities are solved then the responsible person who solved the problem need to stop the downtime



Downtime Stop Screen

3.2. To Stop the problem need to put the actual problem that occur.



Abnormalities/Problems Confirmation Screen

Andon System

4. Verify Downtime

4.1. After checking if the problem is actually solved, then it need to be verified.

Create Downtime / ডাউনটাইম তৈরি করুন।					
DEPARTMENT ডিপার্টমেন্ট	ERROR CODE ভুল কোড (সংকেত)	MACHINE ID মেশিন আইডি	EPF	DOWN TIME ডাউনটাইম	ACTION একশন
CUTTING কাটিং	In put delay ইনপুট বিলম্ব	NA	190502233	00:00:39	VERIFY যাচাই করুন

Verification Screen

4.2. To verify, first need to put the number of machines got effected and after that need to give the ID of the verifier.

Enter Nos Effected Machine / প্রভাবিত মেশিনের সংখ্যা লিখুন ।:					1	Clear / মুছে ফেলুন
1	2	3	4	5		
6	7	8	9	0		
HOME / বাড়ি		BACK / পেছনে		OK / ঠিক আছে		

Effected Number of Machines Screen

ID No / আইডি নং :					190500222	Clear / মুছে ফেলুন
1	2	3	4	5		
6	7	8	9	0		
HOME / বাড়ি		BACK / পেছনে		OK / ঠিক আছে		

ID input Screen

Andon System

- verification all the data will be calculated automatically through the software and will be saved as Excel sheet

ID	Event_Date	Module_Name	Unit_Name	Event_Number	Department	Start_Errorcode	Start_Time	Verify_Time	Stop_Errorcode	MachineID	Create_EPF	Attend_EPF	Verify_EPF	Effected_Machine
7862	2019-11-27	Line 13	Unit 2	9	CUTTING	Wrong cut panels	11:14:07	11:14:28	Quantities mismatch	NA	720503723	730504393	900508400	854
7865	2019-11-27	Line 13	Unit 2	10	CUTTING	Wrong cut panels	11:17:14	11:18:53	Emb. Cut not received	NA	370504837	590509454	890508939	839
7866	2019-11-27	Line 14	Unit 1	13	CUTTING	Bundle tag issues	11:00:30	11:21:04	In put delay	NA	340508333	830504334	190505555	1
7867	2019-11-27	Line 13	Unit 2	11	STORES & MARKETTING	Wrong trims issuing	11:24:38	11:25:56	Packing trims delay	NA	190502222	550505555	550505555	555
7868	2019-11-27	Line 16	Unit 1	2	QCO	Gauge Problem	11:30:01	11:30:14	Gauge Problem	NA	950509595	950509595	950505455	34
7869	2019-11-27	Line 13	Unit 2	12	CUTTING	Wrong cut panels	11:26:43	11:30:52	Wrong size cut panels	NA	190502222	550505555	550505555	555
7870	2019-11-27	Line 02	Unit 1	4	CUTTING	Wrong Cut mark	11:21:52	11:34:06	Emb. Cut not received	NA	340504555	730508237	980509448	424
7871	2019-11-27	Line 21	Unit 2	8	CUTTING	Bundle tag issues	11:38:05	11:38:35	Fusing Part not received	NA	840508480	230504945	840508959	459
7877	2019-11-27	Line 04	Unit 1	12	STORES & MARKETTING	Marketing	10:54:18	11:41:54	Wrong trims issuing	NA	780502383	940509959	840504948	590
7878	2019-11-27	Line 21	Unit 2	9	STORES & MARKETTING	Damage trims	11:03:17	11:42:10	Planning	NA	320503973	830508272	490508989	439
7879	2019-11-27	Line 21	Unit 2	9	STORES & MARKETTING	Damage trims	11:03:17	11:42:10	Planning	NA	320503973	830508272	490508989	439
7886	2019-11-27	Line 13	Unit 2	2	CUTTING	Fusing Part not received	11:40:21	11:43:25	Fusing Part not received	NA	190502222	940509555	940505055	345
7887	2019-11-27	Line 13	Unit 2	3	QCO	Gauge Problem	11:46:33	11:46:45	Gauge Problem	NA	490509900	490509900	840509459	840

- Downtime Monitoring Screen

