

Daily production board — Assembly line 2, early shift

All records

CAPSULEM8

CM8-247 · Daily Production Board

August 9, 2026

ATTAINMENT, LATEST DAY
83.5 %
2026-08-08 · 8 periods

UNITS BEHIND
-145
735 made against a plan of 880

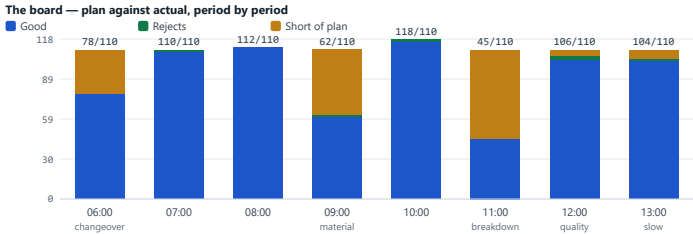
BIGGEST LOSS, LATEST DAY
Breakdown
35 min in 1 period

DOWNTIME, LATEST DAY
100 min
across 8 periods

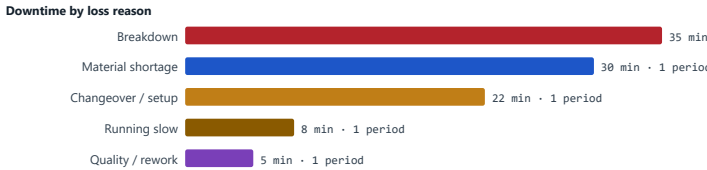
FIRST-PASS QUALITY
98.8 %
9 rejects of 735 made, whole filter

PERIODS ESCALATED
1
4 met the trigger and were not escalated

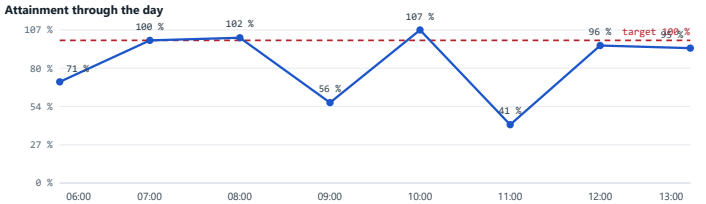
8 of 8 record(s) included. All records. Amounts in USD.



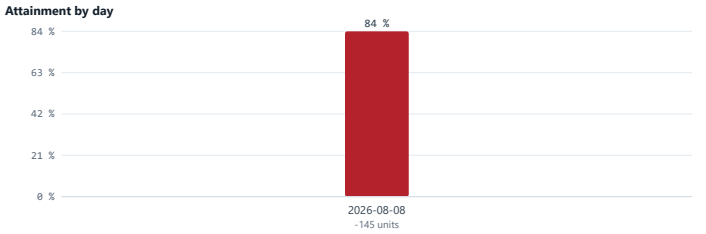
Each bar is one period. Good units sit at the bottom, rejects above them, and the gap to plan on top — so a bar taller than its good block is a period that did not deliver. Read the shortfall blocks left to right and you can see exactly where the day was lost. Each bar is one period. Good units sit at the bottom, rejects above them, and the gap to plan on top — so a bar taller than its good block is a period that did not deliver. Read the shortfall blocks left to right and you can see exactly where the day was lost.



This is the improvement backlog, in order. Filter to a single date and it becomes that day's Pareto; leave the filter open and it is the list worth spending money on. The units-below-plan figure for each reason is in the loss analysis table. This is the improvement backlog, in order. Filter to a single date and it becomes that day's Pareto; leave the filter open and it is the list worth spending money on. The units-below-plan figure for each reason is in the loss analysis table.



The shape matters more than any single point. A line that dips and recovers is a line being managed; a line that drops and stays down is a problem nobody escalated. The shape matters more than any single point. A line that dips and recovers is a line being managed; a line that drops and stays down is a problem nobody escalated.



One bar per day, built from every period on that day. A single day means little; the run of days tells you whether the plan is achievable at all. This chart fills out as days accumulate. One bar per day, built from every period on that day. A single day means little; the run of days tells you whether the plan is achievable at all. This chart fills out as days accumulate.

The board

PERIOD	PRODUCT	PLAN	ACTUAL	VARIANCE	REJECTS	DOWNTIME	LOSS REASON	COUNTERMEASURE	ESC.
06:00–07:00	PMP-40 housing	110	78	−32	0	22	Changeover	Changeover ran 22 min against a 12 min standard becau...	
07:00–08:00	PMP-40 housing	110	110	0	1	0	None	—	
08:00–09:00	PMP-40 housing	110	112	+2	0	0	None	Two ahead — kept the pace rather than building float,...	
09:00–10:00	PMP-40 housing	110	62	−48	1	30	Material	No housings at the line from 09:05. Called materials ...	
10:00–11:00	PMP-40 housing	110	118	+8	2	0	None	Ran the recovery rate agreed with the team leader and...	
11:00–12:00	PMP-40 housing	110	45	−65	0	35	Breakdown	Drive belt on the indexer snapped at 11:04. Maintenan...	✓
12:00–13:00	PMP-40 housing	110	106	−4	3	5	Quality	Three units failed the torque check after the belt ch...	
13:00–14:00	PMP-40 housing	110	104	−6	2	8	Running slow	Feeder jammed on the short screws four times and was ...	
Day total · 2026-08-08		8 periods	880	735	−145	9	100	attainment 83.5 %	1 escalated

Loss analysis

LOSS REASON	PERIODS	DOWNTIME (MIN)	UNITS BELOW PLAN	SHARE OF DOWNTIME
Breakdown	1	35	65	35.0 %
Material shortage	1	30	48	30.0 %
Changeover / setup	1	22	32	22.0 %
Running slow	1	8	6	8.0 %
Quality issue / rework	1	5	4	5.0 %
None — hit the plan	3	0	0	0.0 %
All reasons	8	100	155	100.0 %

Hour-by-hour board

DATE	LINE	SHIFT	PERIOD	PRODUCT	PLAN	ACTUAL	REJECTS	DOWNTIME	LOSS REASON	DETAIL	VARIANCE	ATTAINMENT %	GOOD QUANTITY
2026-08-08	Assembly line 2	Early	06:00–07:00	PMP-40 housing	110.0	78.0	0.0	22.0	Changeover	Changeover from PMP-32 to PMP-40	-32.0	70.9	78.0
2026-08-08	Assembly line 2	Early	07:00–08:00	PMP-40 housing	110.0	110.0	1.0	0.0	None	—	0.0	100.0	109.0
2026-08-08	Assembly line 2	Early	08:00–09:00	PMP-40 housing	110.0	112.0	0.0	0.0	None	—	2.0	101.8	112.0
2026-08-08	Assembly line 2	Early	09:00–10:00	PMP-40 housing	110.0	62.0	1.0	30.0	Material	Housings ran out at the line	-48.0	56.4	61.0
2026-08-08	Assembly line 2	Early	10:00–11:00	PMP-40 housing	110.0	118.0	2.0	0.0	None	—	8.0	107.3	116.0
2026-08-08	Assembly line 2	Early	11:00–12:00	PMP-40 housing	110.0	45.0	0.0	35.0	Breakdown	Indexer drive belt failure	-65.0	40.9	45.0
2026-08-08	Assembly line 2	Early	12:00–13:00	PMP-40 housing	110.0	106.0	3.0	5.0	Quality	Torque failures reworked in line	-4.0	96.4	103.0
2026-08-08	Assembly line 2	Early	13:00–14:00	PMP-40 housing	110.0	104.0	2.0	8.0	Running slow	Screw feeder jamming	-6.0	94.5	102.0

Notes

Sample shift — replace every period with your own before relying on it or circulating it. The day finished 145 units behind an 880-unit plan on 100 minutes of downtime; the belt failure at 11:00 took a third of the lost minutes and the largest single bite out of output, and the material call-off at 09:00 took the next. Belt spare now held at the line and the kanban trigger moved to two bins — both to be checked at tomorrow's board.

A board records what was written in the hour. A board filled in at the end of the shift measures memory, not production — the totals will look tidy, the loss reasons will drift towards whatever is easiest to remember, and the Pareto built from them will send improvement effort to the wrong place. Every figure here is arithmetic on what somebody typed: the tool cannot tell whether the plan was honest, whether the count at the end of the hour was accurate, or whether the reason chosen was the real one. Units below plan attributed to a loss reason are an estimate of the shortfall on those rows, not a measured output loss, and downtime minutes are not comparable between periods of different length.