

₹1.1 crore

More revenue a month

Month 1 to Month 3. A month, this line.

166 MT

More a month

Month 1 to Month 3. 10.3 to 10.7 MT an hour.

1,399 to 591 min

Unplanned stops

Month 1 to Month 3.

EPOXY-COATED REBAR | ONE LINE

166 more tonnes a month on one epoxy-coated rebar line.

On one coating line, a stopped minute on a heavy bar loses more tonnes than a stopped minute on a light bar. Production and maintenance used that when they cleared stops.

The minute total could not say which stop to clear.

Month 1 lost 1,399 minutes of unplanned stops. A minute on a heavy bar takes more tonnes out of the hour than a minute on a light bar. The total minutes did not show the diameter on the heater.

Neuron showed the diameter, the hour and the stop together.

Production and maintenance could see the tonnes in a stopped minute. They cleared those stops. Manpower delays and gun-powder jams were eliminated. Material not available fell from 128 minutes in Month 1 to 6 minutes in Month 3.

The diameter

The bar on the heater

The coating hour

MT an hour

The stopped minute

Taken out of that hour

Production and maintenance see that hour

Unplanned stops fell from 1,399 minutes in Month 1 to 591 minutes in Month 3.

Month 3 coated more tonnes in the hour.

The comparison is Month 1 with Month 3. Stops are in minutes. The rate is MT an hour.

FINDING

The same minute was not the same tonnes.

Month 1 lost 1,399 minutes.
The tonnes lost depended on the diameter on the heater.

ACTION

Clear the stops on that hour.

The team cleared them.
Manpower delays and gun-powder jams were eliminated.

RESULT

591 minutes, and a faster hour.

Month 1 to Month 3, unplanned stops fell from 1,399 minutes to 591. The coating rate moved from 10.3 to 10.7 MT an hour, about 166 MT more a month.

One coating line, Month 1 and Month 3

	Month 1	Month 3
Unplanned stops	1,399 minutes	591 minutes
Coating rate	10.3 MT an hour	10.7 MT an hour
Material not available	128 minutes	6 minutes
Manpower delays	—	Eliminated
Gun-powder jams	—	Eliminated
Additional revenue	—	₹1.1 crore a month

About 58% fewer unplanned-stop minutes. The rate change is about 166 MT more a month. The comparison is Month 1 to Month 3.

The extra revenue is monthly.

Additional revenue is ₹1.1 crore a month on this line. The comparison is Month 1 to Month 3.

One epoxy-coated rebar line. Unplanned stops and material-not-available are minutes in Month 1 and Month 3. Coating rate is MT an hour. Additional revenue is ₹1.1 crore a month.