



Sample Reports

Shift Log

Machine: 500 Harris Marconi Stitcher

Period: 02/10/2003

Date	Time	Elapsed	Event	Oper/Reason	Speed	Gross	Net	C
02/10	00:45:46	00:00:01	Makeready II	Stitcher M.R.	1,600	3,932	3,931	
02/10	00:45:47	00:11:45	Running	Stitcher Run	1,600	3,934	3,932	
02/10	00:57:32	00:05:21	Machine Stopped	Mechanical Problem	0	5,536	5,528	
02/10	01:02:53	00:23:20	Restart Running	Stitcher Run	1,900	5,538	5,531	
02/10	01:26:13	00:15:32	Machine Stopped	Mechanical Problem	0	8,584	8,542	
02/10	01:41:45	01:47:17	Restart Running	Stitcher Run	8,800	8,664	8,542	
02/10	03:29:02	00:32:25	Machine Stopped	Lunch	0	21,019	20,767	
02/10	04:01:27	01:33:44	Restart Running	Stitcher Run	8,900	21,098	20,767	
02/10	05:35:11	00:06:36	Machine Stopped	Mechanical Problem	0	34,600	34,230	
02/10	05:41:47	00:07:11	Restart Running	Stitcher Run	2,100	34,612	34,230	
02/10	05:48:58	00:01:59	Machine Stopped	Stitcher M.R.	0	35,511	35,056	
02/10	05:50:57	00:00:00	Version Started	Ver: 0209041 AB-1	0	0	0	
02/10	05:50:57	00:35:57	Makeready I	Stitcher M.R.	0	0	0	
02/10	06:26:54	00:00:00	Makeready II	Stitcher M.R.	3,200	3	2	
02/10	06:26:54	00:26:39	Running	Stitcher Run	3,200	4	4	
02/10	06:53:33	00:06:11	* Sign-on Shift 1 *	Employee # 4225	8,800	2,726	2,707	
02/10	06:59:44	00:00:16	Machine Stopped	Mechanical Problem	0	3,556	3,536	
02/10	07:00:00	00:01:18	*** Shift Change ***	Employee # 3460	0	3,557	3,537	
02/10	07:01:18	00:02:55	Restart Running	Stitcher Run	2,000	3,562	3,541	
02/10	07:04:13	00:09:22	* Sign-off *	Employee # 3460	8,800	3,987	3,963	
02/10	07:13:35	00:05:51	Machine Stopped	Mechanical Problem	0	4,560	4,532	
02/10	07:19:26	01:20:37	Restart Running	Stitcher Run	2,400	4,569	4,540	
02/10	08:40:03	00:05:33	Machine Stopped	Mechanical Problem	0	14,695	14,576	
02/10	08:45:36	00:43:04	Restart Running	Stitcher Run	2,100	14,704	14,585	
02/10	09:28:40	00:13:39	Machine Stopped	Break	0	19,610	19,404	
02/10	09:42:19	01:53:33	Restart Running	Stitcher Run	8,900	19,691	19,404	
02/10	11:35:52	00:12:53	Machine Stopped	Stitcher M.R.	0	35,199	34,829	
02/10	11:48:45	00:00:00	Version Started	Ver: 0209041 AA-1	0	0	0	
02/10	11:48:45	02:03:42	Makeready I	Stitcher M.R.	0	0	0	
02/10	13:52:27	00:02:54	Makeready II	Stitcher M.R.	2,100	8	0	
02/10	13:55:21	00:56:30	Running	Stitcher Run	8,900	147	0	
02/10	14:51:51	00:08:09	* Sign-on Shift 2 *	Employee # 3507	8,900	7,983	7,752	
02/10	15:00:00	00:00:36	*** Shift Change ***	Employee # 4225	8,900	9,193	8,954	
02/10	15:00:36	01:13:00	* Sign-off *	Employee # 4225	8,900	9,283	9,043	
02/10	16:13:36	00:06:35	Machine Stopped	Mechanical Problem	0	19,231	18,943	
02/10	16:20:11	00:00:52	Restart Running	Stitcher Run	2,100	19,249	18,958	
02/10	16:21:03	00:07:17	Machine Stopped	Mechanical Problem	0	19,335	19,030	
02/10	16:28:20	01:02:19	Restart Running	Stitcher Run	6,400	19,414	19,030	
02/10	17:30:39	00:11:59	Machine Stopped	Break	0	28,233	27,729	
02/10	17:42:38	00:06:33	Restart Running	Stitcher Run	2,100	28,243	27,740	
02/10	17:49:11	00:07:35	Machine Stopped	Mechanical Problem	0	29,177	28,673	
02/10	17:56:46	00:12:31	Restart Running	Stitcher Run	8,400	29,203	28,689	
02/10	18:09:17	00:06:14	Machine Stopped	Mechanical Problem	0	30,933	30,414	
02/10	18:15:31	00:13:23	Restart Running	Stitcher Run	2,100	30,946	30,426	
02/10	18:28:54	00:08:00	Machine Stopped	Mechanical Problem	0	32,446	31,906	
02/10	18:36:54	00:51:29	Restart Running	Stitcher Run	2,100	32,525	31,906	
02/10	19:28:23	00:36:46	Machine Stopped	Lunch	0	39,411	38,734	
02/10	20:05:09	00:00:00	Version Started	Ver: 0209041 BA-1	0	0	0	
02/10	20:05:09	01:13:02	Makeready I	Stitcher M.R.	0	0	0	
02/10	21:18:11	00:00:01	Makeready II	Stitcher M.R.	3,500	3	3	
02/10	21:18:12	00:15:00	Running	Stitcher Run	3,500	4	4	
02/10	21:33:12	00:05:26	Machine Stopped	Mechanical Problem	0	2,035	2,031	
02/10	21:38:38	00:54:22	Restart Running	Stitcher Run	2,000	2,050	2,045	
02/10	22:33:00	00:27:00	* Sign-on Shift 3 *	Employee # 3460	9,200	8,148	8,061	
02/10	23:00:00	00:06:05	*** Shift Change ***	Employee # 3507	9,200	11,605	11,482	

Machine Speed Log

Machine: 500 Harris Marconi Stitcher

Period: 07/22/2002 thru 07/23/2003

Date	Time	Elapsed	Event	Speed	Gross	Net
06/17/03	21:43:05	00:00:36	Machine Speed Change	0	478	479
06/17/03	21:43:41	00:02:14	Machine Speed Change	0	493	492
06/17/03	21:45:55	00:05:06	Machine Speed Change	0	569	567
06/17/03	21:51:01	00:02:32	Machine Speed Change	0	597	594
06/17/03	21:53:33	00:03:11	Machine Speed Change	0	842	839
06/17/03	21:56:44	00:01:57	Machine Speed Change	0	1,123	1,118
06/17/03	21:58:41	00:00:37	Machine Speed Change	0	1,136	1,131
06/17/03	21:59:18	00:00:42	Machine Speed Change	0	1,149	1,144
06/17/03	22:00:00	00:00:27	Machine Speed Status	0	1,151	1,146
06/17/03	22:00:27	00:01:09	Machine Speed Change	0	1,175	1,170
06/17/03	22:01:36	00:05:08	Machine Speed Change	0	1,236	1,231
06/17/03	22:06:44	00:01:33	Machine Speed Change	0	1,252	1,247
06/17/03	22:08:17	00:01:49	Machine Speed Change	0	1,271	1,265
06/17/03	22:10:06	00:03:40	Machine Speed Change	0	1,286	1,278
06/17/03	22:13:46	00:04:15	Machine Speed Change	0	1,431	1,415
06/17/03	22:18:01	00:01:01	Machine Speed Change	0	1,498	1,480
06/17/03	22:19:02	00:02:01	Machine Speed Change	0	1,508	1,488
06/17/03	22:21:03	00:01:17	Machine Speed Change	0	1,526	1,505
06/17/03	22:22:20	00:01:46	Machine Speed Change	0	1,566	1,544
06/17/03	22:24:06	00:00:49	Machine Speed Change	0	1,620	1,597
06/17/03	22:24:55	00:01:13	Machine Speed Change	0	1,639	1,616
06/17/03	22:26:08	00:02:01	Machine Speed Change	0	1,733	1,708
06/17/03	22:28:09	00:04:27	Machine Speed Change	0	1,770	1,746
06/17/03	22:32:36	00:00:17	Machine Speed Change	0	1,779	1,754
06/17/03	22:32:53	00:00:21	Machine Speed Change	0	1,782	1,754
06/17/03	22:33:14	00:07:13	Machine Speed Change	0	1,788	1,761
06/17/03	22:40:27	00:06:22	Machine Speed Change	0	2,290	2,261
06/17/03	22:46:49	00:11:00	Machine Speed Change	0	2,379	2,346
06/17/03	22:57:49	00:02:11	Machine Speed Change	0	3,397	3,362
06/17/03	23:00:00	00:12:01	Machine Speed Status	0	3,397	3,362
06/17/03	23:12:01	00:03:30	Machine Speed Change	0	4,395	4,357
06/17/03	23:15:31	00:38:10	Machine Speed Change	0	4,595	4,557
06/17/03	23:53:41	00:06:19	Machine Speed Change	0	8,276	8,236
06/18/03	00:00:00	00:02:45	Machine Speed Status	6,200	8,726	8,686
06/18/03	00:02:45	00:03:22	Machine Speed Change	0	8,988	8,948
06/18/03	00:06:07	00:01:50	Machine Speed Change	0	9,016	8,976
06/18/03	00:07:57	00:03:46	Machine Speed Change	0	9,028	8,989
06/18/03	00:11:43	00:06:13	Machine Speed Change	0	9,267	9,228
06/18/03	00:17:56	00:19:44	Machine Speed Change	0	9,641	9,602
06/18/03	00:37:40	00:05:40	Machine Speed Change	0	11,534	11,494
06/18/03	00:43:20	00:01:46	Machine Speed Change	0	11,974	11,933
06/18/03	00:45:06	00:01:25	Machine Speed Change	0	12,008	11,967
06/18/03	00:46:31	00:03:34	Machine Speed Change	0	12,093	12,052
06/18/03	00:50:05	00:01:14	Machine Speed Change	0	12,242	12,202
06/18/03	00:51:19	00:00:32	Machine Speed Change	0	12,328	12,287
06/18/03	00:51:51	00:02:34	Machine Speed Change	0	12,339	12,298
06/18/03	00:54:25	00:05:35	Machine Speed Change	0	12,537	12,491
06/18/03	01:00:00	00:01:39	Machine Speed Status	6,300	12,748	12,699
06/18/03	01:01:39	00:02:55	Machine Speed Change	0	12,901	12,853
06/18/03	01:04:34	00:06:04	Machine Speed Change	0	12,944	12,895
06/18/03	01:10:38	00:17:42	Machine Speed Change	0	13,540	13,491
06/18/03	01:28:20	00:16:49	Machine Speed Change	0	15,078	15,017
06/18/03	01:45:09	00:12:34	Machine Speed Change	0	15,371	15,232
06/18/03	01:57:43	00:02:17	Machine Speed Change	0	16,602	16,462
06/18/03	02:00:00	00:05:41	Machine Speed Status	6,300	16,811	16,671

Pallet Log

Period: 07/23/2003

Date	Time	Event	Seq	Pallet #	Quantity	Job #	Ver	Description	Type
04/14	00:26:43	Load Complet	40	B0456087	6,063	020908	4	ADV	NORMA
04/14	01:07:42	Load Complet	41	B0456095	5,052	020908	4	ADV	NORMA
04/14	01:48:03	Load Complet	42	B0456103	5,326	020908	4	ADV	NORMA
04/14	02:28:23	Load Complet	43	B0456111	5,360	020908	4	ADV	NORMA
04/14	03:10:08	Load Complet	44	B0456129	5,248	020908	4	ADV	NORMA
04/14	03:48:32	Load Complet	45	B0456137	5,043	020908	4	ADV	NORMA
04/14	05:42:19	Load Complet	46	B0456145	5,136	020908	4	ADV	NORMA
04/14	06:23:10	Load Complet	47	B0456152	5,367	020908	4	ADV	NORMA
04/14	07:03:20	Load Complet	48	B0456160	4,948	020908	4	ADV	NORMA
04/14	07:44:33	Load Complet	49	B0456178	5,607	020908	4	ADV	NORMA
04/14	09:30:10	Load Complet	50	B0456186	7,534	020908	4	ADV	NORMA
04/14	10:10:23	Load Complet	51	B0456194	5,772	020908	4	ADV	NORMA
04/14	10:51:46	Load Complet	52	B0456202	5,968	020908	4	ADV	NORMA
04/14	12:09:30	Load Complet	53	B0456210	5,130	020908	4	ADV	NORMA

Job Statistics

Job Number 020906
Customer AD, INC.;
AD, INC.;

Ver-Run	Description	Mach	Start Date	Start Time	MIR Hours	Run Hours	Down Hours	MIR Qty	Gross Qty	Order Qty	Net Qty	%Run Waste
A-1	AD, INC.;	***	06/26/03	00:53	25.0	44.0	9.0	5,425	348,837	342,000	343,626	-0.1
B-1	AD, INC.;	517	07/01/03	04:51	0.1	20.6	3.4	68	176,179	166,001	174,632	0.8
C-1	AD, INC.;	529	06/30/03	17:22	0.5	16.7	2.4	5	129,874	77,008	126,390	2.8
C-1	AD, INC.;	528	07/03/03	07:05	0.0	0.9	0.1	0	7,209	77,008	7,226	-0.2
C-1	AD, INC.;	***	06/30/03	23:00	0.1	4.5	1.7	69	38,774	77,008	37,178	4.1
C-1	AD, INC.;	528	07/03/03	01:14	0.5	4.3	1.2	74	25,174	77,008	24,911	0.8
D-1	BULK	517	07/01/03	03:09	0.3	5.6	0.5	77	47,551	45,004	48,670	-2.5
E-1	AD, INC.;	***	06/26/03	12:49	11.3	82.4	24.3	281	596,821	6,025	592,499	0.7
F-1	AD, INC.;	***	07/01/03	04:30	2.4	5.7	3.0	152	34,825	20,099	33,833	2.5
G-1	AD, INC.;	***	07/01/03	04:40	5.7	1.1	3.0	3,038	13,083	8,881	15,449	-35.0
I-1	AD, INC.;	529	07/01/03	18:40	1.9	72.5	10.9	0	693,175	684,486	687,791	0.8
I-STOR-1	AD, INC.;	529	07/07/03	11:51	0.0	1.6	0.0	7	18,168	15,750	15,848	14.6
J-1	AD, INC.;	***	07/03/03	13:18	6.0	54.0	9.4	197	467,740	229,042	471,305	-0.8
K-1	VIPS	***	07/06/03	01:20	0.9	19.0	3.0	176	170,761	523	172,771	-1.3
L-1	AD, INC.;	***	07/06/03	13:27	1.6	51.2	9.6	196	463,095	243,000	463,422	-0.1
Job Totals									3,231,266	2,068,843	3,215,551	0.2

*** Run on multiple machines.

Production Detail - By Version

Machine: 517,529

Period: 07/06/2003 thru 07/07/2003

Job Number 020906 ADV
 Version ALL A
 Customer ADV

Shift	Gross	Net Books	Waste	%Waste/Net	Print Time
1	103,146	100,944	2,202	2.2	13.92
2	127,027	125,329	1,698	1.4	15.33
3	118,664	117,353	1,311	1.1	14.76

	Gross	Net Books	Waste	Hours	Pct	Num
MAKEREADY I + D/T				25.00	19.8	2
MAKEREADY II + D/T	5,425		5,425	0.00	0.0	
PRODUCTION + D/T	343,412	343,626	-214	53.00	42.0	
CLEAN-UP				0.00	0.0	
NON/CHARGE				48.16	38.2	
TOTALS	348,837	343,626	5,211	126.16	100.0	

SPEED	GROSS	7,805 Imp/Hr	YIELD	GROSS	6,479 Imp/Hr
	NET	7,810 Imp/Hr		NET	6,484 Imp/Hr

STOPS:	Code	Description	Waste	Hours	Pct	Num
	7000	Stitcher M.R.	0	16.63	13.2	3
	7010	Stitcher Run	5,207	44.00	34.9	1
D	7030-1	Supervisor/Job Ok	4	0.10	0.1	1
D	7030-2	Wait for Crew	10	0.32	0.3	2
D	7030-3	Wait for Inside Stock	4	2.14	1.7	3
D	7031-7A	Pocket	358	1.00	0.8	9
D	7031-7C	Trimmer	141	0.70	0.6	5
D	7031-7F	Stacker	9	0.12	0.1	1
I	7090	Stitcher Idle	148	56.53	44.8	1
D	X001	Lunch	359	3.25	2.6	6
D	X002	Break	466	1.36	1.1	6
D	X007	T7	68	0.01	0.0	1
		TOTALS	6,774	126.20	100.0	39
		DOWNTIME	1,419	9.00	7.1	34
		IDLE ENTRIES	148	56.53	44.8	1

Production Detail by Machine

Machine: 520 Harris 330 Stitcher

Period: 01/04/2003 thru 03/28/2003

Shift	Gross	Net Books	Waste	%Waste/Net	Run Time
1	3,354,399	3,343,887	10,512	0.3	315.14
2	3,060,177	3,040,852	19,325	0.6	319.33
3	3,178,870	3,161,461	17,409	0.6	326.90

	Gross	Net Books	Waste	Hours	Pct	Num
MAKEREADY I				311.64	15.5	54
MAKEREADY II	1,405		1,405	0.31	0.0	
MAKEREADY D/T				0.00	0.0	
PRODUCTION + D/T	9,592,041	9,546,200	45,841	1,152.08	57.1	
CLEAN-UP				11.04	0.5	
NON/CHARGE				540.93	26.8	
TOTALS	9,593,446	9,546,200	47,246	2,016.00	100.0	

SPEED	GROSS NET	9,981 Bks/Hr	9,933 Bks/Hr	YIELD	GROSS NET	8,247 Bks/Hr	8,207 Bks/Hr
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STOPS:	Code	Description	Waste	Hours	Pct	Num
	7000	Stitcher M.R.	768	109.46	5.4	72
S	7000	Stitcher M.R.	2,045	7.89	0.4	18
	7010	Stitcher Run	46,302	971.07	48.2	144
	7020	Maintenance	0	0.00	0.0	
S	7020	Maintenance	12	0.50	0.0	5
	7030-1	Supervisor/Job Ok	21	4.42	0.2	
S	7030-1	Supervisor/Job Ok	381	3.19	0.2	14
	7030-2	Wait for Crew	4	5.21	0.3	
S	7030-2	Wait for Crew	1,209	6.34	0.3	37
	7030-3	Wait for Inside Stock	1	14.68	0.7	
S	7030-3	Wait for Inside Stock	729	4.27	0.2	13
	7030-4	Wait for Outside Stock/Inserts	-1	14.11	0.7	
S	7030-4	Wait for Outside Stock/Inserts	195	0.33	0.0	3
	7030-5A	Information - Mail Related	3	0.72	0.0	
	7030-5B	Information - Job Related	0	3.23	0.2	
S	7030-5B	Information - Job Related	35	1.82	0.1	5
	7030-6A	Wait for Tapes	1	16.92	0.8	
S	7030-6D	Tapes / Files Defective	6	0.12	0.0	1
S	7031-7A	Pocket	3,146	13.42	0.7	62
S	7031-7B	Stitcher	903	6.19	0.3	40
	7031-7C	Trimmer	0	0.00	0.0	
S	7031-7C	Trimmer	894	9.06	0.4	43
S	7031-7D	Shrink Tunnel	288	2.73	0.1	19
S	7031-7E	Ink-Jet	2,392	9.66	0.5	53
S	7031-7F	Stacker	194	0.69	0.0	6
S	7031-7G	Strapper	10	0.10	0.0	1
S	7031-7I	Label Aire	422	4.24	0.2	23
	7031-7J	Card Shooter	0	1.35	0.1	
S	7031-7J	Card Shooter	1,211	13.59	0.7	48
S	7031-7K	Bailer	42	1.31	0.1	6
	7040	Major Breakdown	0	2.02	0.1	
S	7040	Major Breakdown	566	3.96	0.2	7
S	7090-7C	7090-7C	49	0.56	0.0	1

Production Detail by Machine

Machine: 520 Harris 330 Stitcher

Period: 01/04/2003 thru 03/28/2003

STOPS:	Code	Description	Waste	Hours	Pct	Num
I	7090	Stitcher Idle	8,810	672.46	33.4	32
S	X001-7A	X001-7A	65	0.56	0.0	1
S	X001-7B	X001-7B	55	0.57	0.0	1
S	X001-7D	X001-7D	95	1.08	0.1	2
S	X001-7E	X001-7E	111	1.13	0.1	2
S	X001-7I	X001-7I	178	1.16	0.1	2
S	X001-7K	X001-7K	47	0.53	0.0	1
	X001	Lunch	1	5.48	0.3	
S	X001	Lunch	6,855	62.16	3.1	126
S	X002-7A	X002-7A	106	0.38	0.0	2
S	X002-7B	X002-7B	56	0.24	0.0	1
S	X002-7D	X002-7D	85	0.39	0.0	2
S	X002-7E	X002-7E	109	0.48	0.0	2
S	X002-7I	X002-7I	85	0.22	0.0	1
	X002	Break	0	2.27	0.1	
S	X002	Break	7,640	27.83	1.4	129
S	X003-7B	X003-7B	69	0.17	0.0	1
	X003	Start Vip	52	0.31	0.0	
S	X003	Start Vip	925	3.13	0.2	11
S	X004	End Vip	128	0.32	0.0	4
	X007	T7	89	0.71	0.0	
S	X007	T7	396	0.95	0.0	6
S	X008	T8	145	0.35	0.0	4
TOTALS			87,930	2,016.00	100.0	951
MANUAL ENTRIES			0	0.00	0.0	0
SYSTEM ENTRIES			31,879	191.62	9.5	703
IDLE ENTRIES			8,810	672.46	33.4	32

Production Analysis Report

Machine: 520 Harris 330 Stitcher

Period: 01/04/2003 thru 03/28/2003

Shift: 1,2,3

Counts

Gross : 9,593,446 Books
 Net : 9,546,200 Books

Makeready

Number : 54
 Time : 311.64 Hours

Stops

Number : 730
 Time : 191.03 Hours

Productivity

Run Time : 961.36 Hours 65.2 %
 Sched : 1,475.07 Hours
 Un-Sched : 540.93 Hours
 Total : 2,016.00 Hours

Period Ending	Shift	Gross Books	Net Books	M/R Count	M/R Hours	Stop Count	Down Hours
01/10/03	1	499,821	497,824	3	9.75	16	2.73
	2	220,616	216,777	1	2.77	29	8.15
	3	230,982	230,300	1	4.36	32	6.88
		951,419	944,901	5	16.88	77	17.76
01/17/03	1	272,762	271,748	0	3.84	28	8.32
	2	324,460	323,237	0	0.00	29	8.20
	3	218,865	218,343	2	12.43	21	5.81
		816,087	813,328	2	16.27	78	22.33
01/24/03	1	316,291	314,675	1	6.15	10	2.77
	2	178,373	176,001	4	17.31	16	3.33
	3	325,371	322,876	1	1.44	25	5.97
		820,035	813,552	6	24.90	51	12.07
01/31/03	1	208,052	206,054	0	0.00	20	8.50
	2	219,284	218,360	1	1.76	23	6.49
	3	215,173	213,050	1	2.93	38	10.43
		642,509	637,464	2	4.69	81	25.42
02/07/03	1	58,749	58,379	0	0.00	5	1.21
	2	68,353	67,935	1	6.05	8	2.36
	3	63,625	63,218	0	0.00	8	1.68
		190,727	189,532	1	6.05	21	5.25
02/14/03	1	347,492	346,102	4	0.62	18	5.25
	2	290,696	289,635	2	9.48	14	3.24
	3	241,661	240,913	0	8.00	10	2.71
		879,849	876,650	6	18.10	42	11.20

Production Analysis Report

Machine: 520 Harris 330 Stitcher

Period: 01/04/2003 thru 03/28/2003

Period Ending	Shift	Gross Books	Net Books	M/R Count	M/R Hours	Stop Count	Down Hours
02/21/03	1	258,002	256,897	1	26.86	13	2.78
	2	318,360	316,723	0	18.01	20	5.44
	3	245,848	244,146	1	15.20	15	8.08
		822,210	817,766	2	60.07	48	16.30
02/28/03	1	289,110	287,424	1	6.15	18	4.26
	2	333,838	331,878	1	0.47	25	5.09
	3	443,732	441,731	3	0.51	31	6.20
		1,066,680	1,061,033	5	7.13	74	15.55
03/07/03	1	172,460	171,280	2	25.00	10	4.80
	2	162,890	161,830	2	26.89	14	3.21
	3	160,237	159,000	4	16.81	19	5.17
		495,587	492,110	8	68.70	43	13.18
03/14/03	1	260,036	260,476	2	9.96	11	3.28
	2	249,062	247,478	2	7.50	23	4.71
	3	346,298	345,133	2	1.83	29	6.70
		855,396	853,087	6	19.29	63	14.69
03/21/03	1	381,927	379,568	0	8.00	24	6.91
	2	419,845	417,711	1	3.88	28	7.21
	3	389,083	386,794	5	5.67	35	6.35
		1,190,855	1,184,073	6	17.55	87	20.47
03/28/03	1	289,697	293,460	1	19.63	21	4.96
	2	274,400	273,287	2	21.83	18	5.48
	3	297,995	295,957	2	10.88	26	6.37
		862,092	862,704	5	52.34	65	16.81
Grand Totals		9,593,446	9,546,200	54	311.95	730	191.03

Production Analysis Report

Machine: 520 Harris 330 Stitcher

Period: 01/04/2003 thru 03/28/2003

Shift: 1,2,3

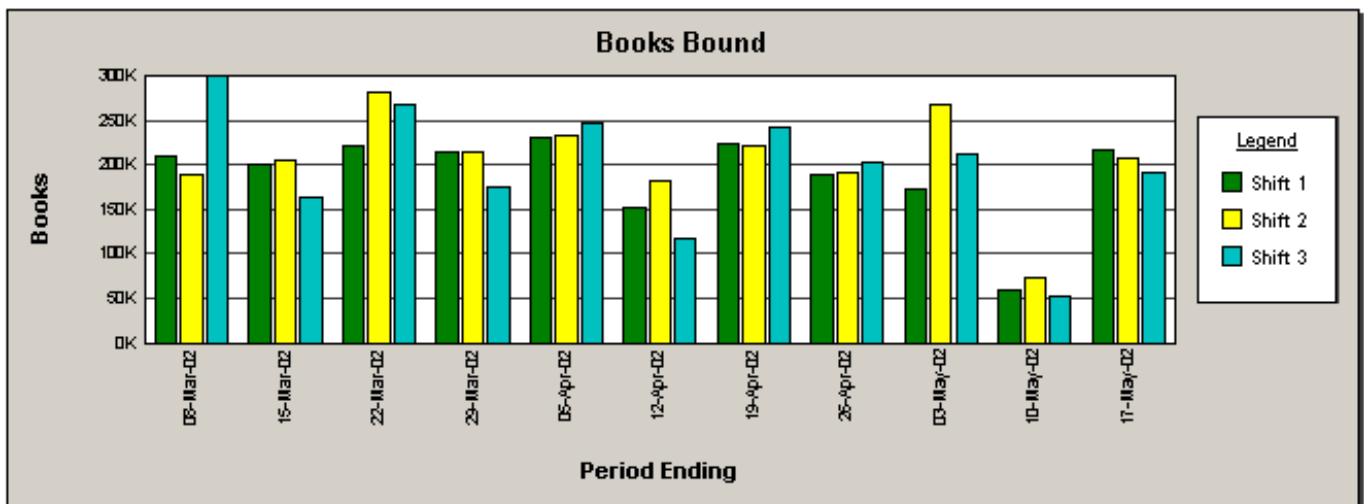
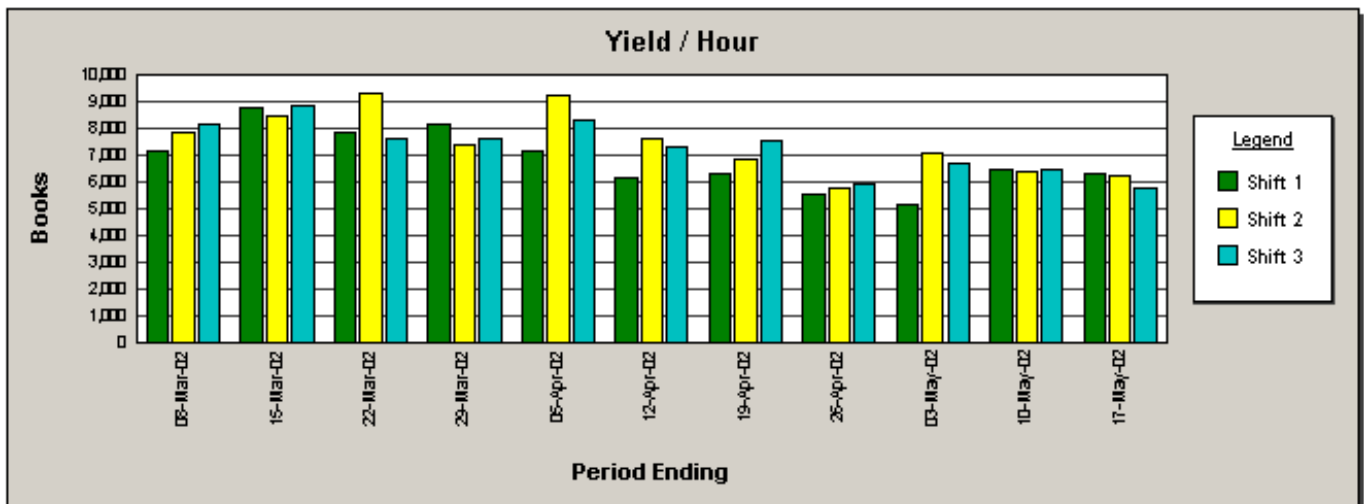
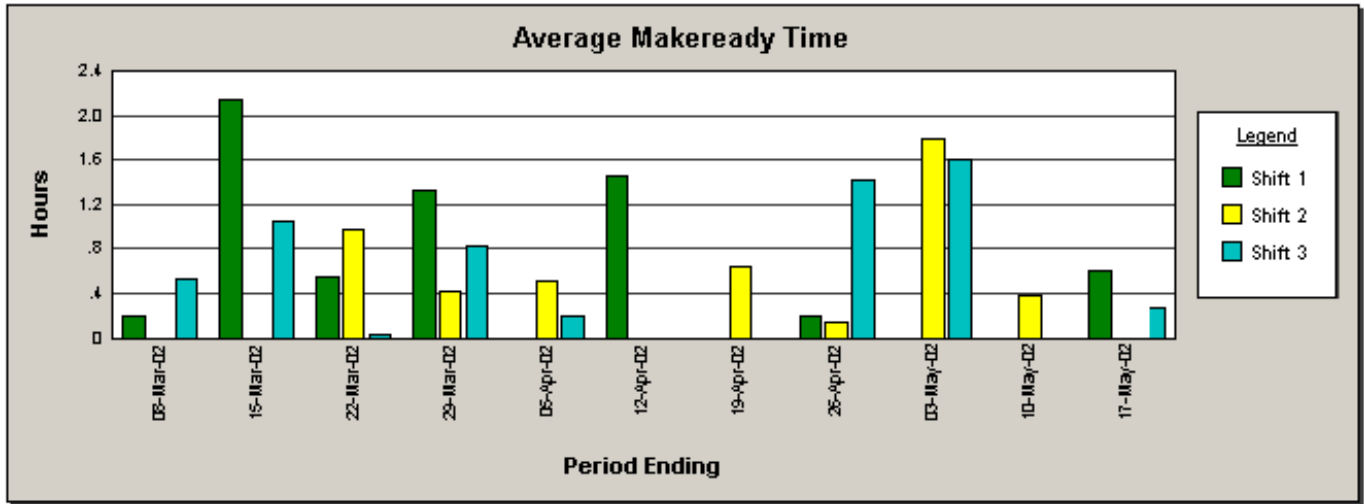
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Gross	: 9,593,446 Books	Number	: 54
Net	: 9,546,200 Books	Time	: 311.64 Hours
<u>Stops</u>		<u>Productivity</u>	
Number	: 730	Run Time	: 961.36 Hours 65.2 %
Time	: 191.03 Hours	Sched	: 1,475.07 Hours
		Un-Sched	: 540.93 Hours
		Total	: 2,016.00 Hours

Period Ending	Shift	Gross Books	Net Books	M/R Count	M/R Hours	Stop Count	Down Hours
01/10/03	1,2,3	951,419	944,901	5	16.88	77	17.76
01/17/03	1,2,3	816,087	813,328	2	16.27	78	22.33
01/24/03	1,2,3	820,035	813,552	6	24.90	51	12.07
01/31/03	1,2,3	642,509	637,464	2	4.69	81	25.42
02/07/03	1,2,3	190,727	189,532	1	6.05	21	5.25
02/14/03	1,2,3	879,849	876,650	6	18.10	42	11.20
02/21/03	1,2,3	822,210	817,766	2	60.07	48	16.30
02/28/03	1,2,3	1,066,680	1,061,033	5	7.13	74	15.55
03/07/03	1,2,3	495,587	492,110	8	68.70	43	13.18
03/14/03	1,2,3	855,396	853,087	6	19.29	63	14.69
03/21/03	1,2,3	1,190,855	1,184,073	6	17.55	87	20.47
03/28/03	1,2,3	862,092	862,704	5	52.34	65	16.81
Grand Totals		9,593,446	9,546,200	54	311.95	730	191.03

Bindery Statistics by Week (Detail)

Machine: 500 Harris Marconi Stitcher

Period: 03/02/2002 thru 05/17/2002



Bindery Statistics by Week (Detail)

Machine: 500 Harris Marconi Stitcher

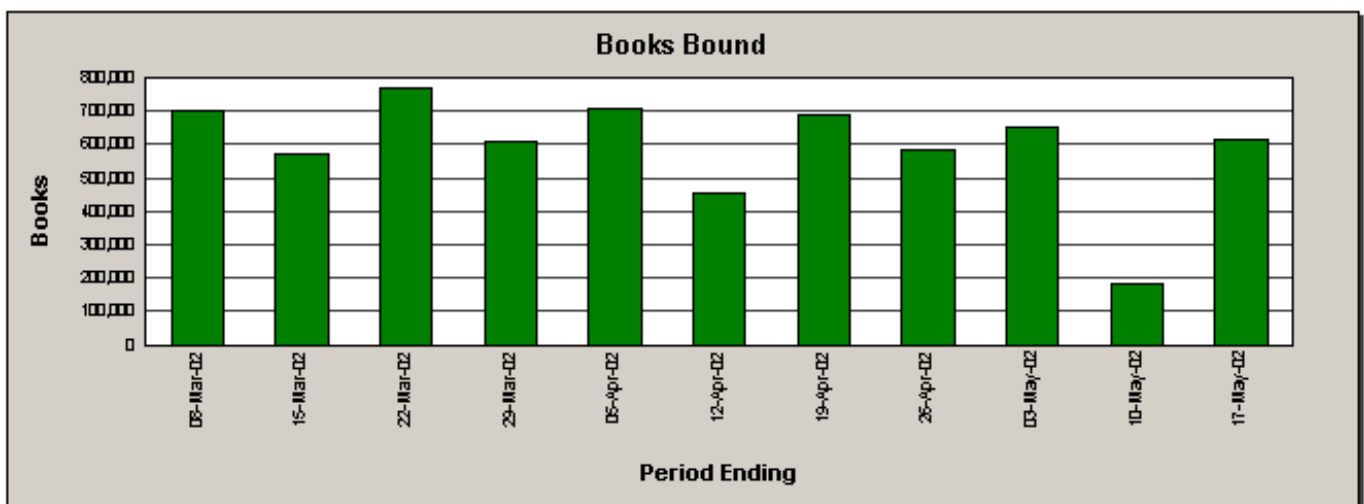
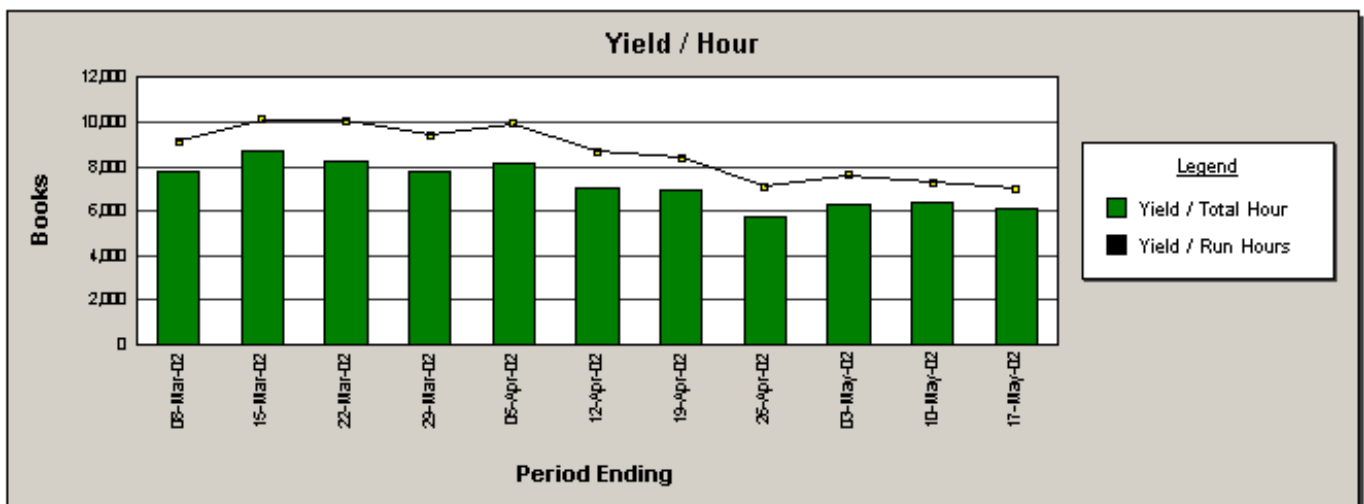
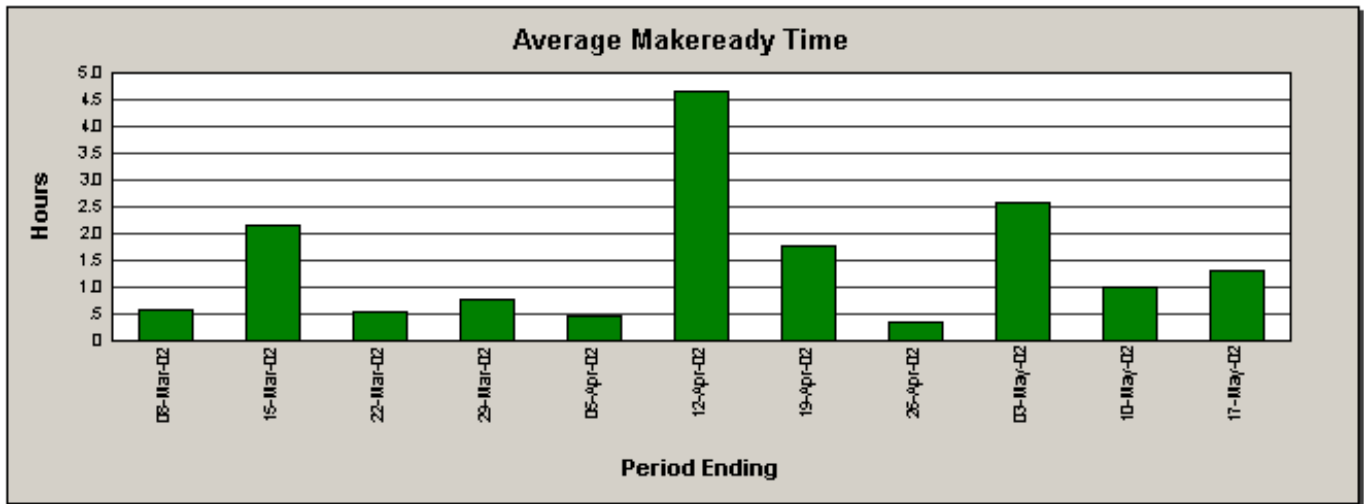
Period: 03/02/2002 thru 05/17/2002

Period Ending	Shift	M/R Count	M/R Hours	Run Hours	Down Hours	Total Hours	Net Yield	Yield / Run Hr.	Yield / Tot Hr.
08-Mar-02	1	2	7.8	23.9	5.5	29.4	210,069	8,789	7,145
	2	0	1.6	21.1	2.9	24.0	188,915	8,953	7,871
	3	3	1.1	31.6	4.9	36.5	299,906	9,491	8,217
15-Mar-02	1	1	2.1	19.5	3.2	22.7	200,620	10,288	8,838
	2	1	2.2	20.3	3.9	24.2	205,182	10,107	8,479
	3	2	2.1	16.4	2.0	18.4	163,929	9,996	8,909
22-Mar-02	1	0	1.1	22.7	5.3	28.0	220,637	9,720	7,880
	2	3	1.0	25.1	5.0	30.1	281,296	11,207	9,345
	3	1	0.0	28.8	6.3	35.1	268,447	9,321	7,648
29-Mar-02	1	4	1.3	22.4	3.8	26.2	215,389	9,616	8,221
	2	1	.8	23.1	5.8	28.9	215,109	9,312	7,443
	3	0	1.6	18.8	4.2	23.0	175,985	9,361	7,652
05-Apr-02	1	2	.8	25.0	7.3	32.3	231,376	9,255	7,163
	2	1	1.0	22.4	2.7	25.1	232,049	10,359	9,245
	3	3	.8	24.2	5.3	29.5	247,066	10,209	8,375
12-Apr-02	1	1	1.5	17.3	7.3	24.6	152,410	8,810	6,196
	2	0	1.6	21.2	2.7	23.9	183,005	8,632	7,657
	3	0	1.6	13.7	2.3	16.0	117,701	8,591	7,356
19-Apr-02	1	1	.3	26.0	9.3	35.3	224,338	8,628	6,355
	2	0	.7	27.7	4.3	32.0	220,937	7,976	6,904
	3	0	.8	27.9	4.0	31.9	241,450	8,654	7,569
26-Apr-02	1	3	.6	25.6	8.2	33.8	188,089	7,347	5,565
	2	4	.6	27.7	5.6	33.3	191,926	6,929	5,764
	3	0	1.4	28.4	5.4	33.8	202,205	7,120	5,982
03-May-02	1	1	1.8	23.4	9.8	33.2	171,710	7,338	5,172
	2	1	1.8	34.0	3.9	37.9	267,951	7,881	7,070
	3	1	1.6	28.1	3.6	31.7	212,892	7,576	6,716
10-May-02	1	1	.4	7.8	1.2	9.0	58,290	7,473	6,477
	2	1	.8	10.0	1.3	11.3	72,385	7,239	6,406
	3	0	.8	7.1	0.8	7.9	51,312	7,227	6,495
17-May-02	1	0	.6	30.0	4.0	34.0	215,767	7,192	6,346
	2	1	.7	28.9	4.2	33.1	206,788	7,155	6,247
	3	0		28.4	5.0	33.4	192,263	6,770	5,756
Totals		39	42.9	758.5	151.0	909.5	6,527,394	8,606	7,177

Bindery Statistics by Week (Summary)

Machine: 500 Harris Marconi Stitcher

Period: 03/02/2002 thru 05/17/2002



Bindery Statistics by Week (Summary)

Machine: 500 Harris Marconi Stitcher

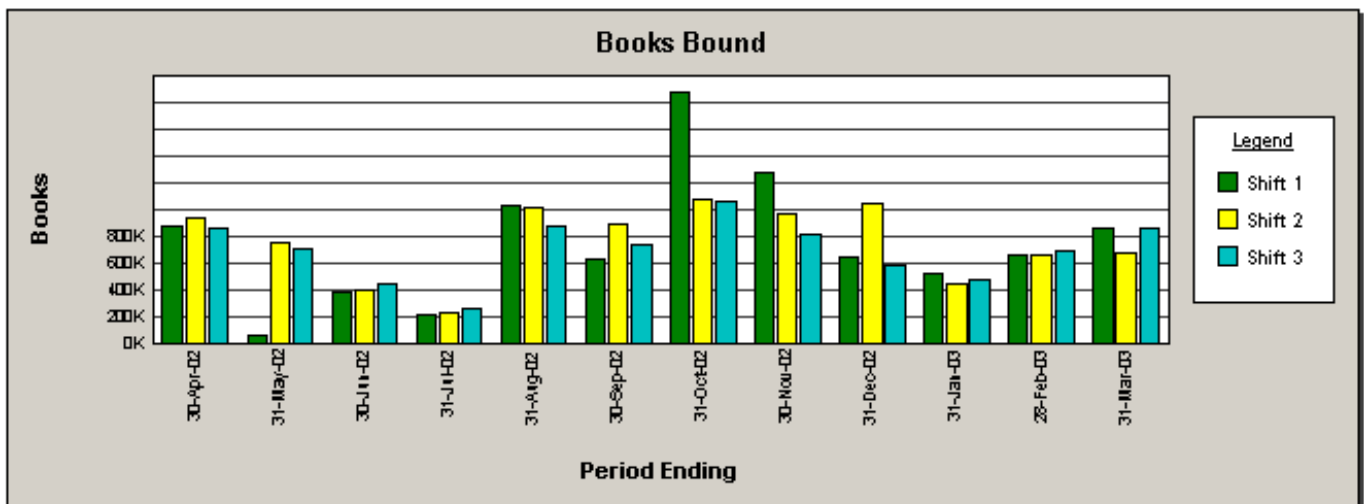
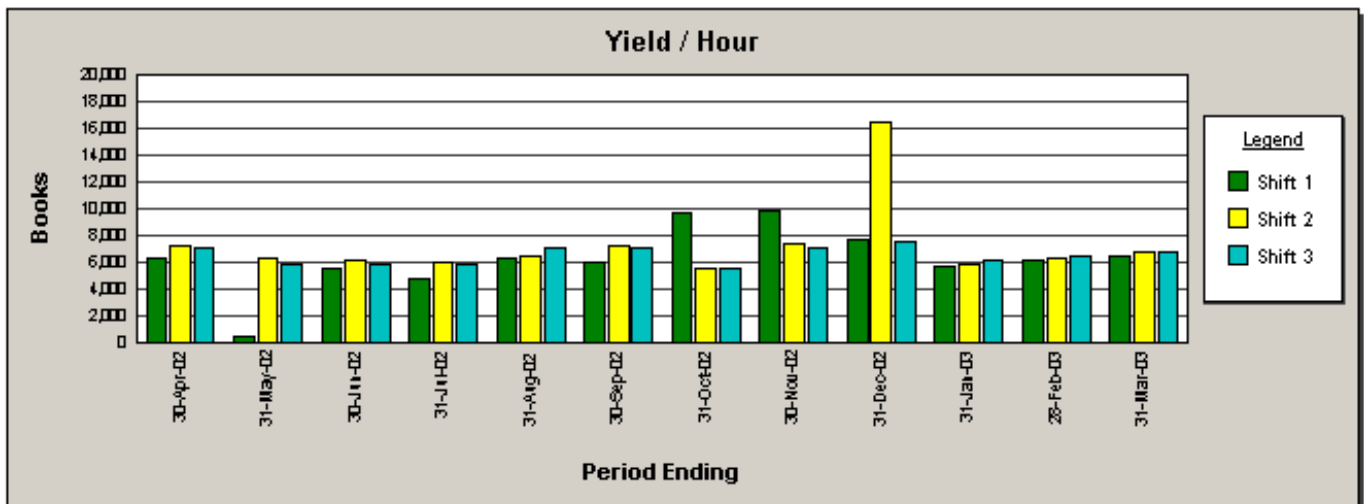
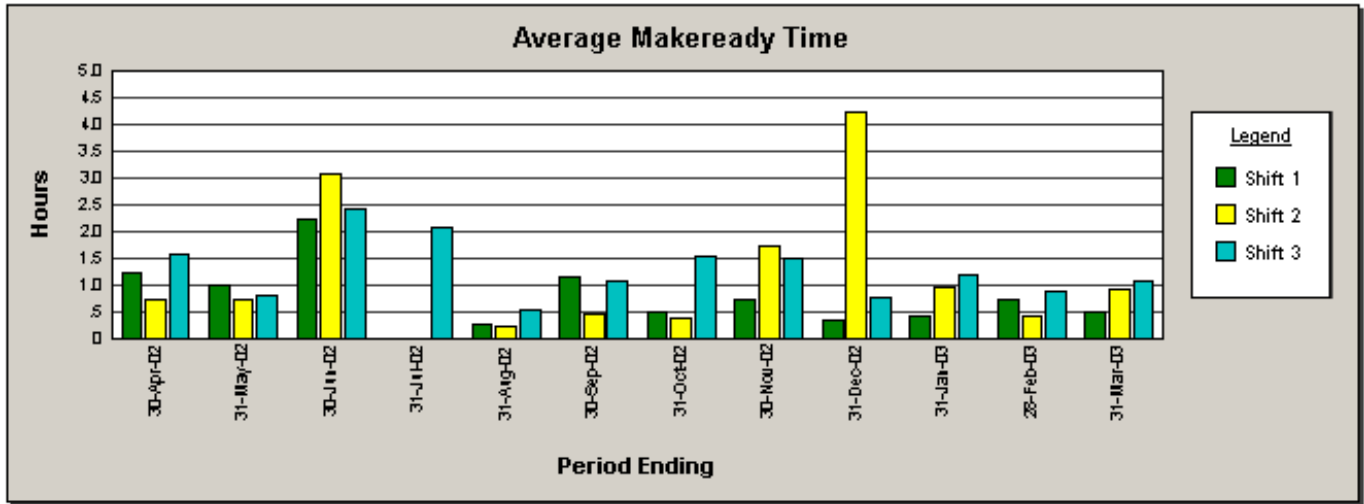
Period: 03/02/2002 thru 05/17/2002

Period Ending	M/R Count	M/R Hours	Run Hours	Down Hours	Total Hours	Net Yield	Yield / Run Hr.	Yield / Tot Hr.
08-Mar-02	5	3.4	76.5	13.4	89.9	698,890	9,136	7,774
15-Mar-02	4	6.4	56.2	9.1	65.3	569,731	10,138	8,725
22-Mar-02	4	2.1	76.6	16.5	93.1	770,380	10,057	8,275
29-Mar-02	5	3.8	64.3	13.9	78.2	606,483	9,432	7,756
05-Apr-02	6	2.6	71.6	15.4	87.0	710,491	9,923	8,167
12-Apr-02	1	4.7	52.2	12.3	64.5	453,116	8,680	7,025
19-Apr-02	1	1.8	81.5	17.5	99.0	686,725	8,426	6,937
26-Apr-02	7	2.5	81.8	19.3	101.1	582,220	7,118	5,759
03-May-02	3	5.7	85.6	17.3	102.9	652,553	7,623	6,342
10-May-02	2	2.0	24.9	3.4	28.3	181,987	7,309	6,431
17-May-02	1	1.3	87.4	13.2	100.6	614,818	7,035	6,112
Totals	39	36.3	758.6	151.3	909.9	6,527,394	8,605	7,174

Bindery Statistics by Month (Detail)

Machine: 500 Harris Marconi Stitcher

Period: 04/01/2002 thru 03/31/2003



Bindery Statistics by Month (Detail)

Machine: 500 Harris Marconi Stitcher

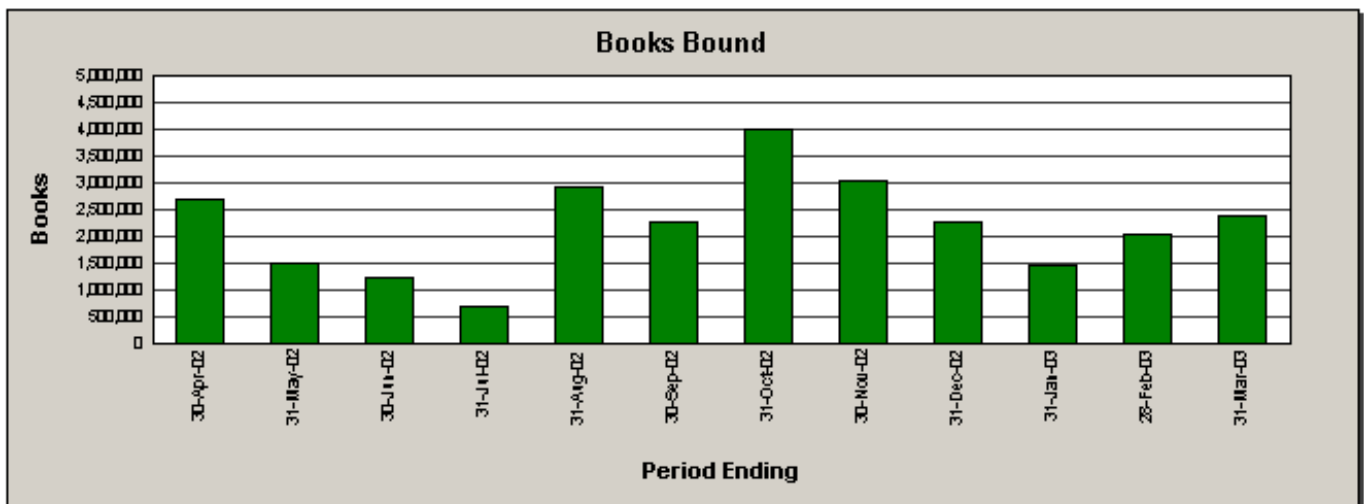
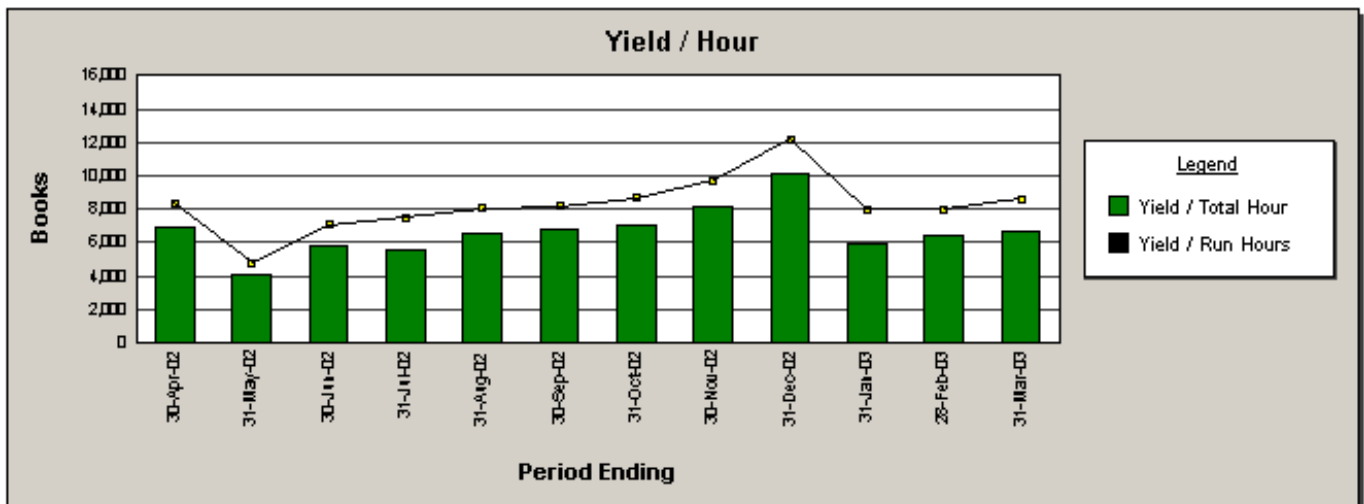
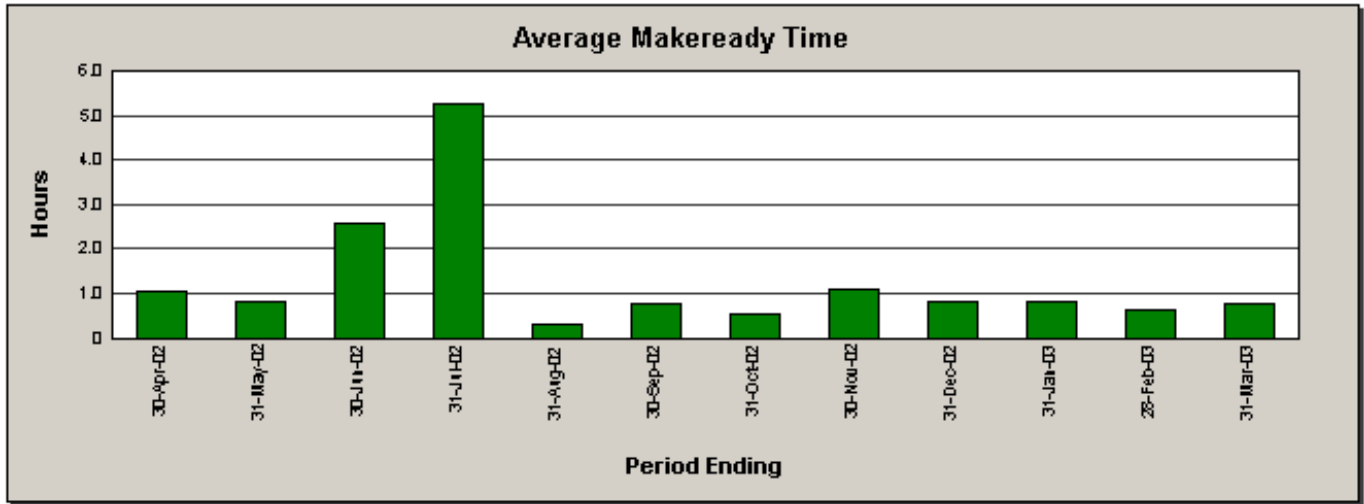
Period: 04/01/2002 thru 03/31/2003

Period Ending	Shift	M/R Count	M/R Hours	Run Hours	Down Hours	Total Hours	Net Yield	Yield / Run Hr.	Yield / Tot Hr.
30-Apr-02	1	8	4.9	105.5	34.3	139.8	880,974	8,350	6,302
	2	6	5.6	111.6	16.8	128.4	935,757	8,385	7,288
	3	3	6.2	101.6	18.4	120.0	851,652	8,382	7,097
31-May-02	1	1	1.0	111.3	22.8	134.1	56,357	506	420
	2	2	1.4	103.4	12.9	116.3	744,499	7,200	6,402
	3	1	.8	98.1	19.6	117.7	696,425	7,099	5,917
30-Jun-02	1	0	2.2	53.0	14.6	67.6	373,329	7,044	5,523
	2	1	3.1	54.7	9.3	64.0	393,917	7,201	6,155
	3	1	2.4	63.3	11.9	75.2	442,181	6,985	5,880
31-Jul-02	1	0	1.6	28.7	15.8	44.5	211,474	7,368	4,752
	2	0	1.6	29.5	8.2	37.7	228,449	7,744	6,060
	3	2	2.1	34.5	9.2	43.7	255,513	7,406	5,847
31-Aug-02	1	5	1.0	126.4	37.8	164.2	1,031,099	8,157	6,280
	2	9	2.5	127.4	28.9	156.3	1,012,931	7,951	6,481
	3	6	2.6	106.9	16.0	122.9	871,444	8,152	7,091
30-Sep-02	1	7	4.5	84.5	18.5	103.0	628,541	7,438	6,102
	2	7	3.6	103.6	20.3	123.9	890,725	8,598	7,189
	3	3	5.3	87.5	16.2	103.7	730,846	8,353	7,048
31-Oct-02	1	4	1.4	153.7	38.9	192.6	1,876,269	12,207	9,742
	2	4	1.9	157.1	33.0	190.1	1,069,778	6,810	5,627
	3	1	1.5	149.8	38.5	188.3	1,058,366	7,065	5,621
30-Nov-02	1	8	4.2	109.0	18.9	127.9	1,270,360	11,655	9,932
	2	1	3.4	111.9	17.8	129.7	971,445	8,681	7,490
	3	2	4.5	91.6	21.5	113.1	804,123	8,779	7,110
31-Dec-02	1	2	2.3	65.9	16.8	82.7	634,832	9,633	7,676
	2	5	4.2	55.7	7.5	63.2	1,041,676	18,702	16,482
	3	4	2.3	63.5	13.3	76.8	578,131	9,104	7,528
31-Jan-03	1	6	1.6	64.0	25.0	89.0	513,697	8,027	5,772
	2	1	2.9	55.4	21.3	76.7	445,247	8,037	5,805
	3	3	3.5	60.8	15.8	76.6	478,602	7,872	6,248
28-Feb-03	1	8	4.2	81.3	24.5	105.8	659,428	8,111	6,233
	2	8	4.6	82.8	20.7	103.5	662,026	7,995	6,396
	3	8	6.2	86.4	18.8	105.2	689,646	7,982	6,556
31-Mar-03	1	9	6.4	96.6	35.3	131.9	856,697	8,868	6,495
	2	11	9.1	80.5	18.9	99.4	673,916	8,372	6,780
	3	9	6.4	101.2	26.3	127.5	861,986	8,518	6,761
Totals		156	123.0	3,198.7	744.3	3,943.0	26,382,338	8,248	6,691

Bindery Statistics by Month (Summary)

Machine: 500 Harris Marconi Stitcher

Period: 04/01/2002 thru 03/31/2003



Bindery Statistics by Month (Summary)

Machine: 500 Harris Marconi Stitcher

Period: 04/01/2002 thru 03/31/2003

Period Ending	M/R Count	M/R Hours	Run Hours	Down Hours	Total Hours	Net Yield	Yield / Run Hr.	Yield / Tot Hr.
30-Apr-02	17	1.7	318.7	69.5	388.2	2,668,383	8,373	6,874
31-May-02	4	3.2	312.8	55.3	368.1	1,497,281	4,787	4,068
30-Jun-02	2	7.7	171.0	35.8	206.8	1,209,427	7,073	5,848
31-Jul-02	2	5.3	92.6	33.1	125.7	695,436	7,510	5,533
31-Aug-02	20	6.0	360.7	82.7	443.4	2,915,474	8,083	6,575
30-Sep-02	17	13.4	275.7	54.9	330.6	2,250,112	8,161	6,806
31-Oct-02	9	4.9	460.7	110.4	571.1	4,004,413	8,692	7,012
30-Nov-02	11	12.1	312.5	58.2	370.7	3,045,928	9,747	8,217
31-Dec-02	11	8.8	185.1	37.7	222.8	2,254,639	12,181	10,120
31-Jan-03	10	8.0	180.3	62.0	242.3	1,437,546	7,973	5,933
28-Feb-03	24	15.0	250.5	64.0	314.5	2,011,100	8,028	6,395
31-Mar-03	29	21.9	278.2	80.4	358.6	2,392,599	8,600	6,672
Totals	156	108.0	3,198.8	744.0	3,942.8	26,382,338	8,248	6,691

Net Bindery Production Report

Machine: 500 Harris Marconi Stitcher

Period: 02/07/2003 thru 03/14/2003

Job #	Customer	Description	Version	Job-Type	Net Books	Ordered	Last Activity
0209041	PALATE	PALATE	AA		35,229	10,650	02/10/03 05:50
0209041	PALATE	PALATE	AB		34,934	35,000	02/10/03 11:48
0209041	PALATE	PALATE	AA		38,959	10,650	02/10/03 20:05
0209041	PALATE	PALATE	BA		76,029	75,180	02/11/03 09:46
0209041	PALATE	PALATE	BB		23,070	22,800	02/11/03 14:27
0209041	PALATE	PALATE	BC		17,617	17,500	02/11/03 18:08
0209041	PALATE	PALATE	I		6,945	7,600	02/11/03 22:11
0209041	PALATE	PALATE	C		9,459	9,400	02/11/03 23:47
0209041	PALATE	PALATE	W		45,961	45,000	02/12/03 10:54
0209041	PALATE	PALATE	AA1		465,229	480,581	02/17/03 21:15
0209041	PALATE	PALATE	S1		11,353	10,800	02/18/03 05:49
0209041	PALATE	PALATE	VER PA		3,631	4,396	02/18/03 07:58
0209041	PALATE	PALATE	AA		1,101	10,650	02/18/03 10:49
0212072	PSD;2003 CAM	PSD;2003 CAM	A		177,981	393,270	02/20/03 21:05
0212072	PSD;2003 CAM	PSD;2003 CAM	C		15,469	31,000	02/21/03 01:13
0212072	PSD;2003 CAM	PSD;2003 CAM	CA		4,026	8,500	02/21/03 02:42
0211050	PSD;2003 CAM	PSD;2003 CAM	A		513,841	2,950,000	02/26/03 15:08
0212046	LOTA STOM	LOTA STOM	A		1,055,911	2,060,000	03/04/03 13:36
0211001	LOTA STOM	LOTA STOM	A		153,449	153,500	03/05/03 18:27
0301055	DILLMIS	DILLMIS	BA		60,174	58,500	03/07/03 11:45
0301055	DILLMIS	DILLMIS	BB		1,536	1,502	03/07/03 19:57
0301055	DILLMIS	DILLMIS	BD		2,775	650	03/07/03 23:09
0301055	DILLMIS	DILLMIS	C		7,183	7,000	03/08/03 01:58
0301055	DILLMIS	DILLMIS	A		19,002	18,500	03/08/03 09:33
0301055	DILLMIS	DILLMIS	AB		675	585	03/08/03 10:01
0301055	DILLMIS	DILLMIS	AE		25,135	24,416	03/10/03 05:27
0301055	DILLMIS	DILLMIS	BC		24,532	24,353	03/10/03 11:46
0301055	DILLMIS	DILLMIS	CC		148,031	146,155	03/11/03 13:14
0301055	DILLMIS	DILLMIS	CA		4,350	82,000	03/11/03 15:47
0301055	DILLMIS	DILLMIS	AA		148,662	550,000	03/12/03 16:32
0301055	DILLMIS	DILLMIS	ca		0	82,000	03/12/03 23:00
0301055	DILLMIS	DILLMIS	CA		79,420	82,000	03/14/03 14:58
0208006	FABRO	FABRO	C		0	92,000	03/15/03 07:00
TOTALS					3,211,669	7,506,138	

Machine Run Chart

Machine: 534 Harris Marconi Stitcher

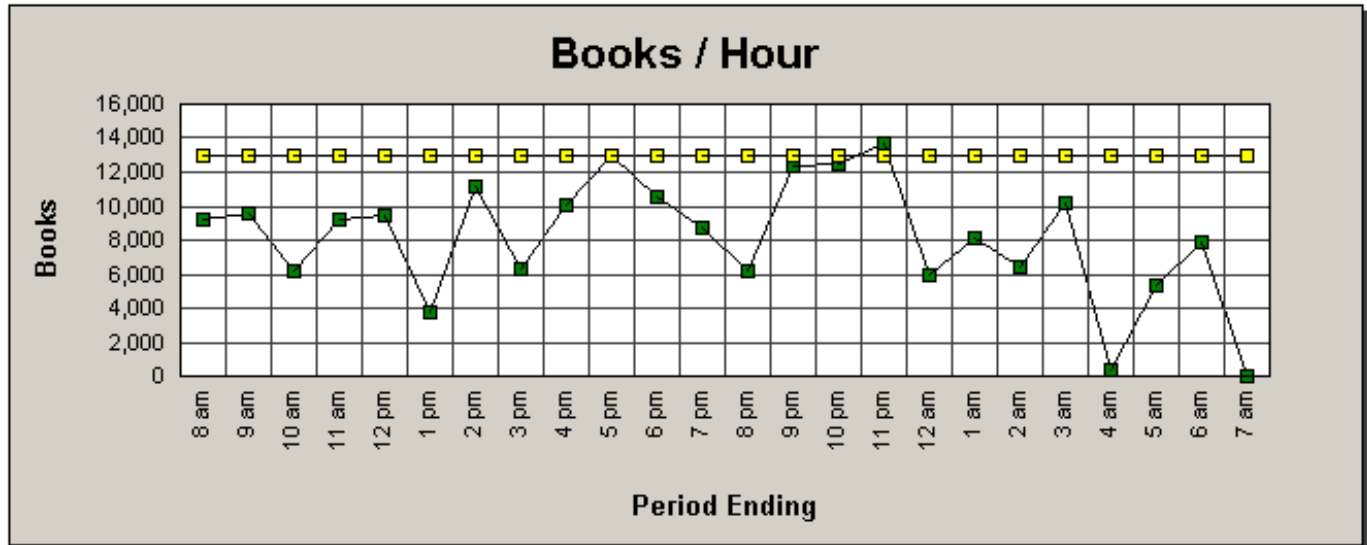
Period: 07/02/2003

Goals

Job Number : 030605
Customer :

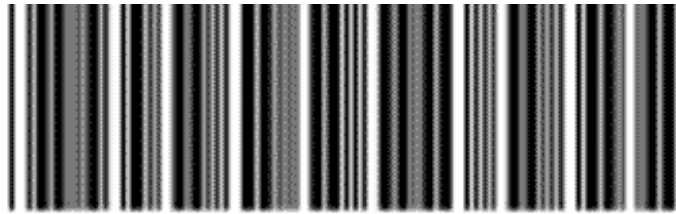
UNWV
UNWV

Gross Cycle Speed Per Minute : 15,000
Net Good Books Per Hour : 8,188



Shift	Operator	Count	Period Ending	Minutes Down	Reason
1	KEITH HOO	65,060	11 am	5	Stitcher
			12 pm	7	Pocket
			1 pm	6	Pocket
2	KEVIN R ANDI	87,041	7 pm	7	Ink-Jet
3	MARTY A	44,431	12 am	9	Pocket
			1 am	5	Pocket
			1 am	11	Maintenance
			2 am	11	Maintenance
			2 am	14	Break
			3 am	9	Ink-Jet
			4 am	57	Ink-Jet
			5 am	15	Pocket
			6 am	9	Pocket
		196,532			165

*** Down-time less than 5 minutes in any period is not reported.



B0000307

LOAD TICKET

Date: 7 / 24 / 03

Operator : JILL SMITH

Skid #

Time : 09:46 AM

Machine #: 520

1

Shift : 1

Checked by :

Job #

9912037

Customer

NAS Tech, Inc.

Job Name

B-DAQ USER GUIDE

Version

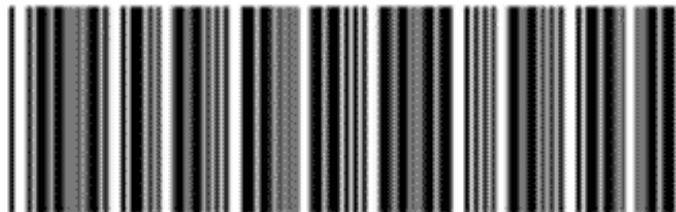
2

Order Quantity

18,000

Skid Count

2,200



B0000307