



BlueCherry® Shop Floor Control (formerly Leadtec®) Real Time Operator Feedback

Description of Motivational Functions

When an operator begins work on a bundle, the bundle number is scanned (or keyed) at the terminal. If the bundle is rejected for any reason, an explanation is displayed at the terminal. If the bundle is accepted, the terminal displays information and some motivational values. These values are described below.

Standard Value: The amount that is paid appears at the top left of the screen. The format in which the amount is presented is controlled by the customer: SAM, SAH, or Dollars can be used. It can reflect payment for one unit, a dozen units or any other multiple. It may reflect the calculated value of the entire bundle and it may or may not include the bundle handling rate.

Bundle Quantity: The bundle quantity is displayed at the top center of the screen.

All-Day Performance: The operator's performance for the day, so far, is displayed at the top right of the screen. This is a percent of standard and can range from 0% to 999%.

Target Time*: The target time for the bundle is displayed at the bottom left of the screen. This is shown in hours, minutes, and seconds. It is based on the allowed time and the operator's target performance level. The target performance level is set by the system, based on the operator's past performance. It can be changed by the operator to achieve self-pacing. The suggested time counts down on the screen so that it constantly shows remaining time. When the time reaches zero, it begins counting up to indicate excess time, or lost time incurred.

Target Quantity*: The number of units in the bundle that the operator should have completed at any moment is displayed at the bottom center of the screen. This starts at zero and counts up each time a piece should be completed, until a new bundle is scanned. When the entire bundle should be finished, the display shows target units that are equal to the bundle quantity. If the operator continues work on the bundle, the target units will continue to climb. This provides another visual indication that the operator has taken too much time and indicates how many units of time have been lost.

Bundle Performance*: The operator's performance on the current bundle is displayed on the bottom right of the screen. The system does not know how many units the operator has actually done, so this value assumes that the operator is just finishing the bundle. It therefore represents the operator's performance if the bundle is finished "now".

Customer Testimonial

"BlueCherry® Shop Floor Control had been on my radar for many years due to its proven track record. Having purchased ACS years back, I have always had great respect for CGS and the quality of their solutions and Services and BlueCherry Shop Floor Control is no different."

– Jeff Rosenstock
Vice President, General Sportwear

* These functions can be disabled by management.

To learn more about **BlueCherry®**, contact your **BlueCherry®** sales representative at 212-408-3809 or email us at applications@cgsinc.com. You can also visit us at www.cgsinc.com.

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Example

Assume that the plant displays piecerates in SAH. An operator starts a bundle of 30 unites that has a piecerate of 0.010830 SAH per unit. Bundle handling is included in the rate. The operator has a target performance level of 120%. Prior to starting the bundle, the operator has been performing at 123%.

The allowed time for the bundle is then 0.32490 SAH (0.01183×30). The operator's target time is 0.27075 hours ($0.32490/120\%$). The target time per unit is 0.00903 hours.

Standard Value	Bundle Quantity	All-Day Performance
0.01083	30	123%
Target Time	Target Quantity	Bundle Performance
0:16:15	0	999%

After 12 minutes, the operator should have completed 22 units. If the operator were to finish the bundle at that time, the performance would have been 135%, and would have bettered the target by 4 minutes and 15 seconds.

Standard Value	Bundle Quantity	All-Day Performance
0.01083	30	123%
Target Time	Target Quantity	Bundle Performance
0:04:15	22	135%

The operator actually finished the bundle after 17 minutes and 20 seconds. The operator has missed the target by 1 minute and 5 seconds. 30 units have been completed in the time it should have taken to complete 32. Even though the target was missed, the operator has still performed at 112%.

Standard Value	Bundle Quantity	All-Day Performance
0.01083	30	123%
Target Time	Target Quantity	Bundle Performance
0:01:05	32	112%