



The Big 4 Mistakes Manufacturers Make

Are they myths, urban legends, bad habits or judgment errors? Whatever they are, the common mistakes that many manufacturers make add cost, waste resources and labor, and frustrate customers. Take a look at the mistakes below and see if they apply to your business. The good news is that they are avoidable by using **JobPack®'s Productivity Suite** of real-time Scheduling and Manufacturing Execution System software.

Mistake Number 1

Believing that a spreadsheet is an effective way of predicting delivery dates

A spreadsheet of production orders is like a newspaper. By the time you get it, the information is out-of-date. Spreadsheets are a great way to maintain lists of information, but a spreadsheet can't react to changes to the production schedule that occur every day when new orders arrive, orders are cancelled, or when customer-requested delivery dates and quantities change. With the frequent changes that occur in manufacturing businesses today, a spreadsheet can't respond quickly enough.

Spreadsheets also present a "flat" view of the order information, so you can't see the effect that a change to one operation will have on downstream operations. If the machine used for Operation 10 is out of service, how do you immediately know what effect the downtime will have on Operations 20-50? If you increase the machine capacity for one operation, can the spreadsheet move the order forward in subsequent operations?

How much manual effort is used to maintain the spreadsheet? **JobPack Master Scheduler**, a real-time scheduling system, integrated to your ERP system, can receive order information effortlessly, and immediately identify resource constraints caused by overloaded resources. The ability to simulate multiple scenarios to resolve the constraints is impossible for a spreadsheet.

Can a spreadsheet support multiple scheduling methods such as forward scheduling, backward scheduling, and just-in-time scheduling? JobPack has invested more than 100 developer-years to build a real-time, finite capacity scheduling system that incorporates multiple scheduling techniques to support every scheduling challenge. JobPack continues to invest in the development of new scheduling algorithms.



Mistake Number 2

Accepting the times on a job card as accurate

If you are collecting hand-written production job completion cards from your operators at the end of their shift or at mid-shift, you are receiving the information that the operator wants you to receive, not the actual performance. The operator will always meet the standard and always record the information according to the routing. The information will be delayed in updating the scheduling system, making the scheduling system ineffective, as well.

When the operator records the information on the job card, it may be illegible, incomplete or incorrect, making the entry of the information error-prone and late. Time cards are easy to lose, too.

JobPack Shop Floor Data Collection is a real-time data collection system that can immediately capture the correct information from the machine or from the operator. This method gives every employee the most up-to-date and accurate production status. When the operation steps to a terminal and enters the information using a touch screen or a scanner, the information is immediately validated for accuracy. Once accepted, the information is now visible by every authorized employee. There is no redundancy and no delay.

Mistake Number 3

Padding a job with extra hours or giving the customer a padded delivery promise

When you have no faith in the accuracy of your production schedules, the way to cushion the schedule is to deceive yourself by padding the time standards or padding the delivery promise dates. Rather than “just-in-time”, you now have “just-in-case” production management. Anytime you put incorrect information into the system, you make all of your answers incorrect. And, the problem becomes larger because the inflation of rates and dates grows as employees become less confident about the information they receive.

With **JobPack Master Scheduler**, the real-time, finite capacity scheduling system, the accurate time standards and accurate machine/resource capacities deliver a reliable, achievable production schedule with dependable customer delivery dates. As production jobs are



completed and reported on, you capture the actual performance results, so you can use the actual performance to fine-tune the time standards for future production jobs.

Gradually, employees and customers believe the accuracy of the production schedule. This reduces the amount of work-in-process inventory, minimizes expediting costs, and improves overall customer satisfaction.

Mistake Number 4

Working extra hours of overtime to create a cushion that can be called upon for hot jobs

Overtime labor is expensive. Not every employee wants to work overtime, either. If you know that a large order is imminent and you want to clear your schedule to accommodate the order, then perhaps working overtime makes sense. But, what if the order does not arrive when it is expected? What if the order requires manufacturing resources you didn't plan to deploy?

The **JobPack Master Scheduler** is a real-time finite capacity scheduling tool that loads production jobs to maximize the use of machines and other resources and immediately identifies what resources will be overloaded. This allows you to adjust the production schedule to reduce the overloads and meet your customer delivery promises. Add overtime if you need it. Move jobs to other machines or workcenters. Schedule jobs into the future as far as your lead times require.

About JobPack, Inc.: We are experts in automating the shop floor processes of metal fabrication shops, machine shops, foundries and job shops. Our software products reduce manufacturing costs, increase resource utilization and improve delivery performance. With over 20 years experience of development, sales, and support of manufacturing systems, JobPack® Inc has the expertise and knowledge base to provide complete turnkey installations, training, and after sales support services.