VersaCall’s VT2000 System – Discrete Manufacturing
Assembly Line Performance - Communications

Complete & Concise Performance Visibility - Prototype Line

- System Monitors & Reports both the Overall Line Performance and Individual Work Stations within the 4400 line – Assembly Time Varies by Station
- Require operator scanning in Part Number – Takt Time associated with P/N will measure assembly line performance.
- For Downtime Occurrences - downtime codes will have to selected from pull down list of codes – currently 16 codes – can be expanded or contracted.
- System will be able to send communications to e-mail, phones (all types), overhead paging system [Optional 2 way radio and on-site paging system]
- Line communication options are currently – Supervisor, Engineer & Quality [Can be expanded or contracted later]

II Line 4400 - 8 Station - Monitoring Performance [Stns 10 – 80]

Note: Standard Drives do not utilize Station 30 - Filter Pack Drives Uses Station 30 Performance is not being captured for Station 90
**Issues: Takt Time Varies by Product**
1. 15 minutes to 1 hour
2. Capture Performance Each Station by Part Number
3. Station 30 only used for Filter Pack Product
4. Look Up Tables Accessed for Std Takt Time
5. Capturing Product Change Over - Assembly Time Varies

Proposed Virtual Call Station Mock Up

4400 Line - Station 20

**Communications**

1. Supervisor

2. Engineering

3. Quality

**Production**

Start

End

Down

Select from Pull Down List – Currently 16 Downtime Codes

**Start Production**

Part Number: Scanned In

Takt Time: Time based up Part #

Enter

Start Production Time Remaining 4:16

Start Production

Part Number: Scanned In

Takt Time: Time based up Part #

Enter
One Screen Provides Both Line & Individual Work Station Performance

Takt Time Re-sets When Line is Advanced

Note
End of Workday Status
At the end of workday information is frozen and appears on the screens on the start next day’s shift.

Individual Work Zone Assembly Time is Captured
Work Zones Change Color Upon Completion

Example

Color Changes When Takt Time Is Exceeded

Downtime Codes - 16 Codes
**Additional Options – Assembly Line Performance Monitoring**

47:15

<table>
<thead>
<tr>
<th>Daily Target</th>
<th>Actual</th>
</tr>
</thead>
<tbody>
<tr>
<td>25</td>
<td>27</td>
</tr>
</tbody>
</table>

**55” Display Panel**

Target vs. Actual Performance

Takt Time Performance

Hr. by Hr. Takt Time Pull Performance

Remaining Takt Time

**Other Screen Layout Options for Consideration**

**Call Stations - 5 Work Zones/ Work Stations - Stack Lights Optional**

**Light Designations**

1. Support Required
2. Work Complete
3. Help Required

**Wireless Call Station** [Labels-Programmable]

4085 Line 10:14

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Line Pull Module - Station 5 [VersaCall Takt Time Module]

Optional - Takt Time Near Ending Notification  Audio / Light Signal – *Wireless*

*Wireless Combination Module*
*Audio[MP3] – Rotating Light-Programmable*
  - Wireless
  - Programmable Tones/Tunes – 4 Different Options
  - LED Rotating Lights
  - Wireless Activated Lights – Place anywhere.

Separate Wireless Light or Audio Module  Also Available