Comparison periods — 178 regimes

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What is compared with what, and what is deliberately excluded · fictional document

Fictional document — demonstration example

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Fictional document, produced for the demonstration. **A comparison period only means something if the machine is doing the same thing.** The rules below are the ones that brought the rate of empty flags down from **23 % to 7 %**, and every one of them can be changed by the maintenance manager.

Splitting by regime

Notion	Definition	Effect on the comparison
Regime	**A combination of part produced, rate and material**	**The same press does not have the same signature depending on what it makes**
Regimes identified over 6 years	**178**	Across the 34 presses
Example	ABS housing → glass-filled technical part	**Temperature, pressure and cycle time change with no wear involved**

The three rules applied

Rule	Why	Changeable
First 30 days after a refurbishment or sub-assembly change excluded	**A rebuilt machine resembles neither the old one nor yet itself**	Yes
No flag on a regime seen for under 40 hours	**“Not enough history to compare” is useful information; an alert built on five points is not**	Yes
Ramp-ups and Monday-morning restarts excluded	They pull every average and have never announced anything	Yes

What the correction produced

Measure	Before the rule	After the rule
Flags over the half-year	96	—
Flags with nothing behind them	**22, that is 23 %**	**7 % over the last 8 weeks**
Of which linked to a refurbishment or a reference change	**17 of 22**	—
Checking time lost	25 min per flag — 9 h over the half-year	≈ 3 h at the corrected rate

> **The only thing asked of the site:** record the refurbishment or reference change **in the CMMS, in one line, when it happens**. Technicians already record their jobs; there is no extra tool.

Exclusion period after a refurbishment chosen by the site (30 days by default): _____

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