GANG-NAIL GUIDELINES No.129

ANOTHER MITEK ADVANTAGE

SUFFICIENT ALLOWANCE

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Are you finding it difficult to reach your daily production targets? Have you noticed a trend toward less EqA per job?

A quick review of a number of truss plants revealed that it has become increasingly difficult to consistently achieve an expected daily EqA output.

In addressing this problem there are many factors to consider.

The first area to look at might be the flow of work including the cut material, or the equipment and the crew, etc. If no issues are identified, perhaps there are some additional production activities that are impacting the output.

One area that should not be overlooked is a check of all EqA activities to ensure that they are being sufficiently measured and applied.

Although it is generally accepted that EqA allowance for some trusses with specific configurations or joint types may require adjustment from time to time, there may be adjustments required for other activities that exist in the process that are not immediately obvious.

An interesting finding from recent investigations was that some activities that were impacting on production were a result of trends in building and material availability.

A shift towards larger span trusses and the use of internal supports highlighted some additional production activities that were, in some cases, undervalued.

Depending on the type of manufacturing equipment, there can be significant work required to locate and press additional support positions.

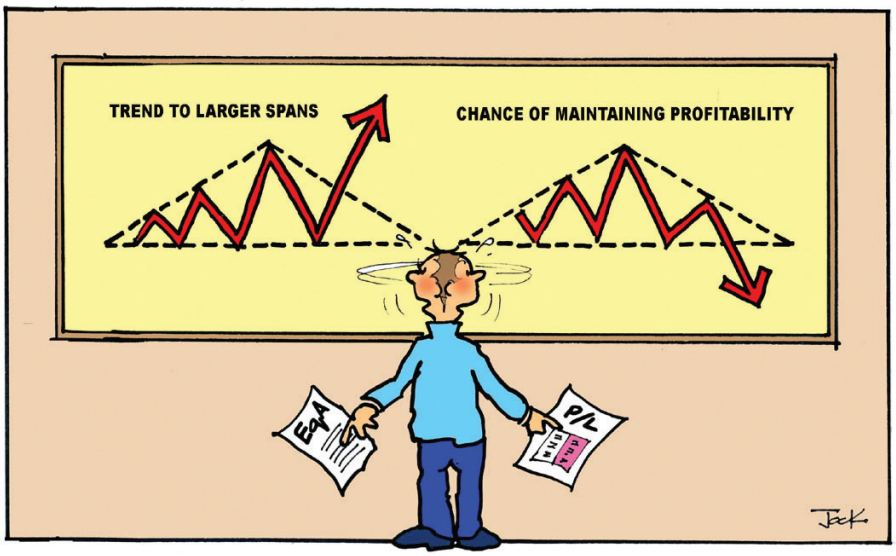
These larger span trusses were also found to have an impact on EqA due simply to the additional time it took to physically walk around the truss.

In some instances additional time was taken in extending or maneuvering pressing equipment, along with an increase in the handling of additional components.

In other cases, additional components were as a result of an increase in the number of spliced chords required in large span trusses due partly to a trend in the use of shorter stock lengths of timber.

These additional splices and the removal of the completed large span trusses also contributed to the additional EqA.

Often the combined additional activities required for large span trusses with internal supports resulted in a 20% increase in EqA!



These activities will of course have a significant impact on the costings.

The importance of monitoring production cannot be understated as it will help to highlight any inconsistencies in output totals and identify where additional activities are affecting production output.

The success of production based costing and scheduling systems relies on accurate measurement and the inclusion of all activities that impact on production.

When the correct EqA allowance is applied for all production activities, costing will better reflect manufacturing, scheduling will be more accurate and production targets will be more achievable.

It is important to clarify that the basic EqA system that uses the Standard "A" type truss production unit remains unchanged.

Whilst the aim is to produce as many of these units as efficiently as possible, any activity that holds up or adds value to the unit must be measured and included, and assigned an EqA value.

Monitoring and maintaining production output records will not only help in day to day management; but will also help identify trends that may impact on output levels over time.

Allowance for trends can be built in to the EqA system. For example, a span adjustment factor may be all that is necessary to apply additional EqA over a base span.

Or an increase in the EqA value for splicing allowance may be included to allow for the splicing of chords in large span trusses.

The increased use of monitoring systems by truss plants and the level of detail included in the reports has been most valuable in identifying activities that impact production.

There may be opportunities to eliminate or reduce the impact of these activities, but if they are found to either hold up or add value to the unit they can be simply included into the EqA system - to ensure that you have sufficient allowance. TTN