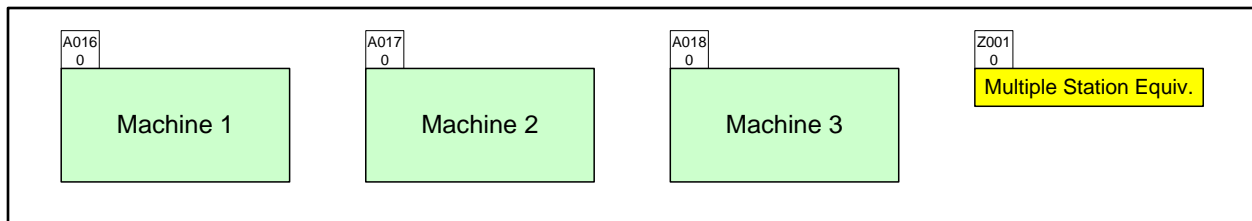


Processing Multi Station Wizard Tutorial

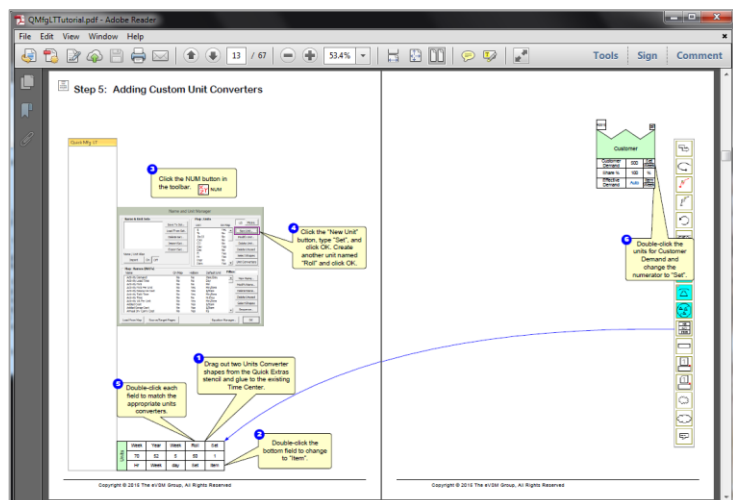
This tutorial will guide you through the steps to draw a simple map and perform common calculations using the Processing Multi Station Wizard.



Viewing/printing eVSM Tutorial:

This tutorial is designed for two page layout. If printing, you will need double-sided print.

For on-screen viewing, save the PDF file to your PC and then open it in Acrobat Reader (not in a web browser). In the Acrobat menus, click "View>Page Display", make sure "Show Cover Page in Two Page View" is checked and then select "Two Page View".



Step 1: Start eVSM

1 On your Desktop, click the "Start eVSM" icon.

2 If you see a message like this, you must "Enable" macros.

3 Click to enable macros.

4 Click "Trust all from publisher" to avoid the security notice in future.

Recycle Bin

Start eVSM

Microsoft Visio Security Notice

Microsoft Office has identified a potential security concern.

Note: The digital signature is valid, but the signature is from a publisher whom you have not yet chosen to trust.

File Path: C:\Program Files\evsm\Setup\Solutions\evsmIcons.vss

Macros have been disabled. Macros might contain viruses or other security hazards. Do not enable this content unless you trust the source of this file.

[More information](#)

[Show Signature Details](#)

Trust all from publisher Enable Macros Disable Macros

Step 2: Learn eVSM Basics

Wiz Processing MultiStation

2

Avoid re-sizing eVSM shapes. Instead grow the drawing page when needed. To resize the page, hold down the "Ctrl" key, and then drag any page edge to the required size. This method works on all four edges of the page.



5

Save your Visio file and then insert a new page via the right-mouse menus on the page-tabs.

VSM

Quick_eVSM

1

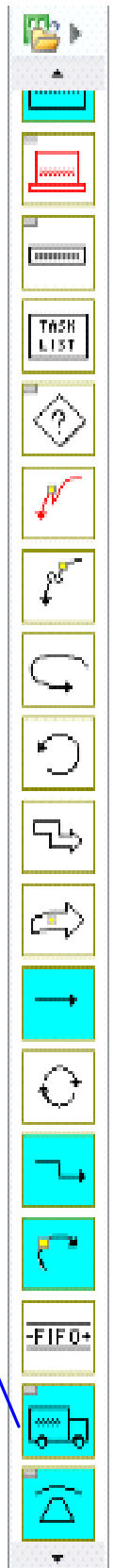
eVSM Help resources are available in the Learn module of the toolbar. Hover over each one to see what they do.

3


Blue icons in the main stencil represent families of shapes. Drag out the Transport icon.

4

Use the shape's right-mouse menus to turn it into a car



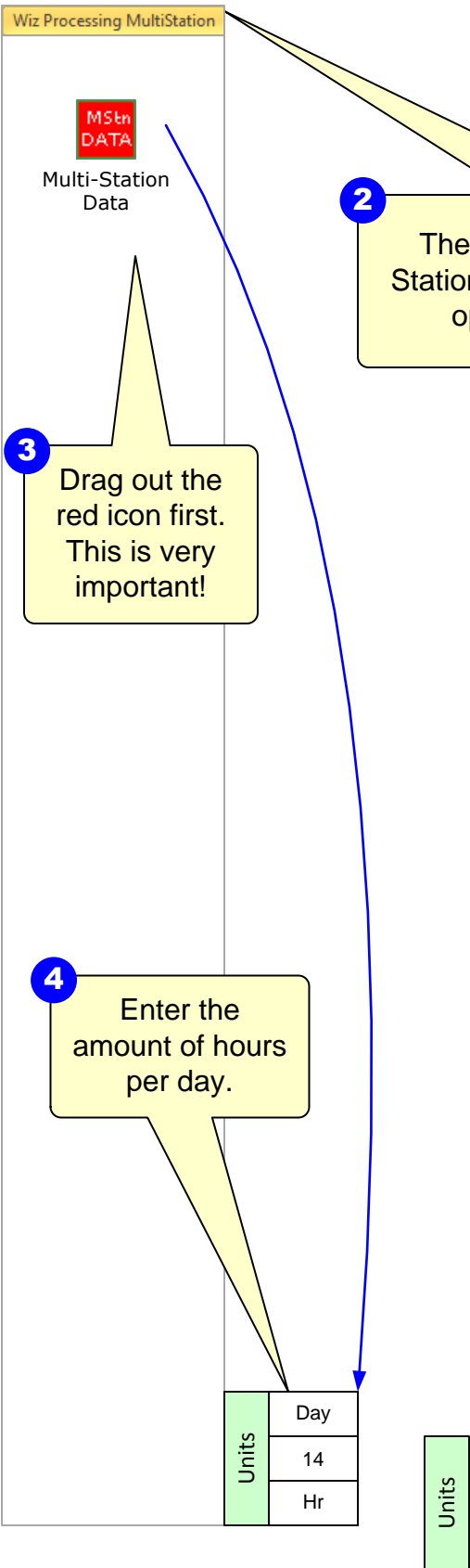
Step 3: Initiate the map for Processing Multi Station Wizard

1 Click the Open button. Select Proc Multi Station and click OK.  Open

2 The Processing Multi Station Wizard stencil will open on the left.

3 Drag out the red icon first. This is very important!

4 Enter the amount of hours per day.





Step 4: Set Up Each Machine

1 The green shapes are called "Centers". Use the centers to represent the flow.

2 Complete as shown below, including annotation and data values.

Wiz Processing Multistar



Activity Center

A018
0

Machine 1		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	5	LOQ Min
Step Yield_M	90	%
Stations_M	2	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	83	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL	Auto	LOQ Day
Contributor All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day

A019
0

Machine 2		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	87	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	80	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL	Auto	LOQ Day
Contributor All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day

A020
0

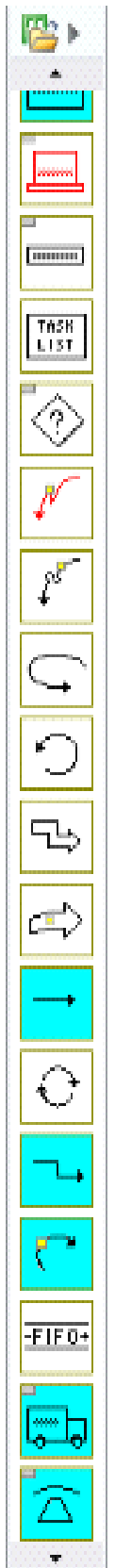
Machine 3		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	88	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	85	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL	Auto	LOQ Day
Contributor All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day

4 Do not change any of the "Auto" fields. These will be calculated later.

Units	Day
	14
	Hr

3

Double-click to change any of the units.



Step 5: Multi-Station Summary

Wiz Processing MultiStation



Multi-Station Summary

Machine 1		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	5	LOQ Min
Step Yield_M	90	%
Stations_M	2	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	83	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL Contributor	Auto	LOQ Day
All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day

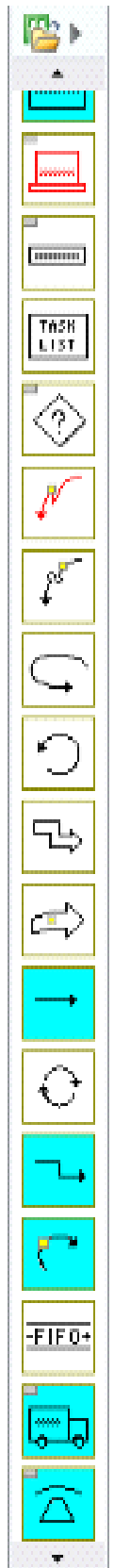
Machine 2		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	87	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	80	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL Contributor	Auto	LOQ Day
All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day

Machine 3		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	88	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	85	%
Tot LOQ Cycle Rate	Auto	Lb Min
CT Capacity Per Day	Auto	Lb Day
WPL Contributor	Auto	LOQ Day
All Stations Time	Auto	Hr Day
Wt Avg SY Fac_M	Auto	Lb Day
Capacity Per Day	Auto	Lb Day


Units	Day
	14
	Hr


1 Drag out the Multi-Station Summary Center.

Z001 0	Multiple Station Equiv.	
LOQ Cycle Rate	Auto	LOQ Hr
Weight Per LOQ	Auto	Lb LOQ
Step Yield	Auto	%
Stations	Auto	Stn
OEE	Auto	%
Activity Time	Auto	Hr Day
MS CT Capacity Per Day	Auto	Lb Day
MS Capacity Per Day	Auto	Lb Day
Wt Avg SY Fac	Auto	Lb Day



Step 6: Perform Calculations

1 Click the "Check" and button fix any problems flagged  Check

2 Click the "Solve" button to calculate  Solve

Wiz Processing MultiStation

Machine 1		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	5	LOQ Min
Step Yield_M	90	%
Stations_M	2	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	83	%
Tot LOQ Cycle Rate	200.00	Lb Min
CT Capacity Per Day	120000.00	Lb Day
WPL Contributor	6000.00	LOQ Day
All Stations Time	20.00	Hr Day
Wt Avg SY Fac_M	89640.00	Lb Day
Capacity Per Day	99600.00	Lb Day

Machine 2		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	87	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	80	%
Tot LOQ Cycle Rate	200.00	Lb Min
CT Capacity Per Day	120000.00	Lb Day
WPL Contributor	6000.00	LOQ Day
All Stations Time	10.00	Hr Day
Wt Avg SY Fac_M	83520.00	Lb Day
Capacity Per Day	96000.00	Lb Day

Machine 3		
Weight per LOQ_M	20	Lb LOQ
LOQ Cycle Rate_M	10	LOQ Min
Step Yield_M	88	%
Stations_M	1	Stn
Activity Time_M	10	Hr Day
OEE Percent_M	85	%
Tot LOQ Cycle Rate	200.00	Lb Min
CT Capacity Per Day	120000.00	Lb Day
WPL Contributor	6000.00	LOQ Day
All Stations Time	10.00	Hr Day
Wt Avg SY Fac_M	89760.00	Lb Day
Capacity Per Day	102000.00	Lb Day

Units	Day
	14
	Hr

3 When complete, note that all blue values show calculated results. The values for the equivalent machine have been calculated from the three individual machines.

Z001 0		
Multiple Station Equiv.		
LOQ Cycle Rate	7.50	LOQ Min
Weight Per LOQ	20.00	Lb LOQ
Step Yield	88.35	%
Stations	4.00	Stn
OEE	82.67	%
Activity Time	10.00	Hr Day
MS CT Capacity Per Day	360000.00	Lb Day
MS Capacity Per Day	297600.00	Lb Day
Wt Avg SY Fac	262920.00	Lb Day

