

# Work Center Analysis

Date: 06/01/01-09/30/01

Company: Star Printing Production SQL

	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non-Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
<b>Dept-ID: 100-Electronic Prepress</b>													
<b>Work Center: 100-Electronic Color</b>													
104-Color Correction	83.48	16.97	2.68	103.13	9.26	112.39	15,469.31	1,389.17	91.8%	446	442	4	1%
105-Input/Scan	38.60	1.29	0.42	40.32	0.00	40.32	6,047.80	0.00	100.0%	665	665	16	
110-Output Film	24.85	1.77	0.63	26.87	0.38	27.26	4,030.94	57.50	98.6%	324	300	11	7%
111-Output RC Paper	12.28	0.00	0.83	12.67	0.43	13.11	1,900.79	65.04	96.7%	119	119	9	
112-Scale Photos	12.60	0.00	0.63	13.22	1.33	14.56	1,983.50	199.92	90.8%	281	266	18	5%
<b>Totals</b>	<b>171.81</b>	<b>20.03</b>	<b>5.19</b>	<b>196.21</b>	<b>11.41</b>	<b>207.62</b>	<b>29,432.34</b>	<b>1,711.63</b>	<b>94.5%</b>				
<b>Work Center: 110-Electronic Stripping</b>													
112-Scale Photos	3.81	0.29	0.00	4.10	0.00	4.10	512.45	0.00	100.0%	88	88	21	
120-Separations	36.86	2.82	1.83	39.68	1.83	41.51	4,959.46	228.71	95.6%	315	315	8	
125-Soft Proof	12.30	1.10	0.45	13.40	0.45	13.85	1,674.50	56.74	96.7%	118	118	9	
130-Preflight	31.03	1.24	0.00	32.26	0.00	32.26	4,033.09	0.00	100.0%	104	104	3	
142-Iris Proofing	4.28	0.00	0.00	4.28	0.00	4.28	534.58	0.00	100.0%	30	30	7	
155-File Manipulation	9.93	0.51	0.00	10.44	0.00	10.44	1,305.35	0.00	100.0%	4	0	0	
160-Job Organization	3.10	0.00	0.00	3.10	0.00	3.10	387.79	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>101.29</b>	<b>5.96</b>	<b>2.28</b>	<b>107.26</b>	<b>2.28</b>	<b>109.54</b>	<b>13,407.22</b>	<b>285.45</b>	<b>97.9%</b>				
<b>Work Center: 120-Dolev Film Output</b>													
110-Output Film	13.88	1.91	1.90	15.78	1.90	17.68	1,578.29	190.17	89.2%	309	308	17	0%
<b>Totals</b>	<b>13.88</b>	<b>1.91</b>	<b>1.90</b>	<b>15.78</b>	<b>1.90</b>	<b>17.68</b>	<b>1,578.29</b>	<b>190.17</b>	<b>89.2%</b>				
<b>Work Center: 198-Elec Prepress Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	0.94	0.94	0.00	9.39	0.0%	0	0	0	
952-No Work	0.30	0.00	0.00	0.30	17.57	17.87	3.02	175.72	1.7%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	2.67	2.67	0.00	26.69	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	6.37	6.37	0.00	63.69	0.0%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	15.04	15.04	0.00	150.37	0.0%	0	0	0	
956-Wait for Instructions	6.17	0.00	0.00	6.17	3.21	9.37	61.67	32.08	65.8%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	142.25	142.25	0.00	1,422.50	0.0%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	3.40	3.40	0.00	34.01	0.0%	0	0	0	
<b>Totals</b>	<b>6.47</b>	<b>0.00</b>	<b>0.00</b>	<b>6.47</b>	<b>191.44</b>	<b>197.91</b>	<b>64.69</b>	<b>1,914.45</b>	<b>3.3%</b>				
<b>Department Totals</b>	<b>293.45</b>	<b>27.90</b>	<b>9.37</b>	<b>325.72</b>	<b>207.04</b>	<b>532.76</b>	<b>44,482.54</b>	<b>4,101.70</b>	<b>61.1%</b>	<b>Payroll Hours:</b>		<b>532.76</b>	

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<b>Dept-ID: 300-Stripping and Proofing</b>													
<b>Work Center: 301-Stripping</b>													
200-Line Shot	12.41	0.45	0.72	12.87	0.72	13.58	707.59	39.38	94.7%	72	72	5	
201-Half Tone	26.29	1.70	0.00	27.99	0.00	27.99	1,539.29	0.00	100.0%	201	197	7	2%
202-Duotones	0.96	0.00	0.00	0.96	0.00	0.96	52.76	0.00	100.0%	3	3	3	
203-Reverse	4.41	0.00	0.00	4.41	0.00	4.41	242.74	0.00	100.0%	15	15	3	
204-PMT	5.32	0.00	0.00	5.32	0.00	5.32	292.87	0.00	100.0%	29	29	5	
225-Contacting	21.81	1.63	0.84	23.44	0.84	24.28	1,288.96	46.41	96.5%	125	125	5	
300-Stripping	241.08	4.72	0.53	245.79	0.53	246.33	13,518.71	29.33	99.8%	1,718	1,573	6	8%
<b>Totals</b>	<b>312.28</b>	<b>8.50</b>	<b>2.09</b>	<b>320.78</b>	<b>2.09</b>	<b>322.87</b>	<b>17,642.92</b>	<b>115.12</b>	<b>99.4%</b>				
<b>Work Center: 302-Proofing</b>													
225-Contacting	21.63	1.30	0.00	22.93	0.00	22.93	1,146.57	0.00	100.0%	87	87	4	
245-Combined Proof	8.99	0.00	0.00	8.99	0.00	8.99	449.58	0.00	100.0%	20	20	2	
250-Proof Assembly	14.75	0.00	0.00	14.75	0.00	14.75	737.63	0.00	100.0%	62	62	4	
301-Dylux Proof	62.23	0.00	0.00	62.23	0.00	62.23	3,111.33	0.00	100.0%	6,565	6,549	105	0%
302-Color Key	27.13	0.00	0.00	27.13	0.00	27.13	1,356.56	0.00	100.0%	132	131	5	1%
303-Match Print	4.00	0.98	0.00	4.98	0.00	4.98	248.89	0.00	100.0%	22	18	4	18%
304-Scatter Proof	3.20	0.00	0.00	3.20	0.00	3.20	159.84	0.00	100.0%	8	8	3	
<b>Totals</b>	<b>141.92</b>	<b>2.28</b>	<b>0.00</b>	<b>144.20</b>	<b>0.00</b>	<b>144.20</b>	<b>7,210.40</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 398-Conv Prepress Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	0.40	0.40	0.00	3.96	0.0%	0	0	0	
952-No Work	0.00	0.00	0.00	0.00	5.80	5.80	0.00	58.01	0.0%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	1.73	1.73	0.00	17.30	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	3.94	3.94	0.00	39.40	0.0%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	3.83	3.83	0.00	38.32	0.0%	0	0	0	
956-Wait for Instructions	0.40	0.00	0.00	0.40	2.32	2.72	4.00	23.22	14.7%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	92.94	92.94	0.00	929.41	0.0%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	2.63	2.63	0.00	26.34	0.0%	0	0	0	
<b>Totals</b>	<b>0.40</b>	<b>0.00</b>	<b>0.00</b>	<b>0.40</b>	<b>113.60</b>	<b>114.00</b>	<b>4.00</b>	<b>1,135.96</b>	<b>0.4%</b>				
<b>Department Totals</b>	<b>454.61</b>	<b>10.78</b>	<b>2.09</b>	<b>465.38</b>	<b>115.69</b>	<b>581.08</b>	<b>24,857.32</b>	<b>1,251.08</b>	<b>80.1%</b>	<b>Payroll Hours:</b>		<b>581.08</b>	

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<b>Dept-ID: 400-Plating</b>													
<b>Work Center: 401-Platemaking</b>													
401-Frame Plating	175.99	8.99	13.30	186.71	11.58	198.28	8,401.87	520.96	94.2%	1,262	1,223	6	3%
402-Step and Repeat Plating	61.26	0.00	3.04	61.26	3.04	64.30	2,756.83	136.82	95.3%	391	386	6	1%
403-Plate Checking	63.11	3.16	3.73	67.63	2.36	70.00	3,043.49	106.36	96.6%	1,111	1,111	16	
<b>Totals</b>	<b>300.36</b>	<b>12.15</b>	<b>20.07</b>	<b>315.60</b>	<b>16.98</b>	<b>332.58</b>	<b>14,202.19</b>	<b>764.14</b>	<b>94.9%</b>				
<b>Work Center: 498-Platemaking Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	2.19	2.19	0.00	21.88	0.0%	0	0	0	
952-No Work	0.00	0.00	0.00	0.00	7.52	7.52	0.00	75.18	0.0%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	0.75	0.75	0.00	7.50	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	15.26	15.26	0.00	152.65	0.0%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	4.52	4.52	0.00	45.21	0.0%	0	0	0	
956-Wait for Instructions	0.00	0.00	0.00	0.00	4.95	4.95	0.00	49.45	0.0%	0	0	0	
990-Paid Leave/Vacation/Sick	8.08	0.00	0.00	8.08	98.31	106.40	80.83	983.14	7.6%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	2.42	2.42	0.00	24.19	0.0%	0	0	0	
<b>Totals</b>	<b>8.08</b>	<b>0.00</b>	<b>0.00</b>	<b>8.08</b>	<b>135.92</b>	<b>144.00</b>	<b>80.83</b>	<b>1,359.20</b>	<b>5.6%</b>				
<b>Department Totals</b>	<b>308.45</b>	<b>12.15</b>	<b>20.07</b>	<b>323.69</b>	<b>152.90</b>	<b>476.59</b>	<b>14,283.02</b>	<b>2,123.34</b>	<b>67.9%</b>		<b>Payroll Hours:</b>	<b>476.59</b>	

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<b>Dept-ID: 500-Sheetfed Press</b>													
<b>Work Center: 501-228 Sheetfed Press</b>													
501-Makeready Straight	15.52	0.00	0.00	15.52	0.00	15.52	1,660.77	0.00	100.0%	2,050	2,050	132	
502-Makeready Perfector	1.76	0.00	0.00	1.76	0.00	1.76	187.82	0.00	100.0%	4	4	2	
503-Run Straight	35.65	0.00	0.00	35.65	0.00	35.65	3,814.89	0.00	100.0%	238,360	232,250	6,514	3%
504-Run Perfector	2.61	0.00	0.00	2.61	0.00	2.61	279.54	0.00	100.0%	12,100	11,000	4,211	9%
505-Wash Up	13.07	0.00	0.00	13.07	0.00	13.07	1,398.77	0.00	100.0%	18	18	1	
550-Wait for Plates	2.36	0.00	0.00	2.36	0.00	2.36	252.37	0.00	100.0%	0	0	0	
551-Wait for Stock	0.00	0.00	0.00	0.00	0.50	0.50	0.00	53.97	0.0%	0	0	0	
552-Wait for Ink	0.41	0.00	0.00	0.41	0.00	0.41	44.02	0.00	100.0%	0	0	0	
553-Wait For Customer OK	0.64	0.00	0.00	0.64	0.00	0.64	68.45	0.00	100.0%	0	0	0	
554-Mix Ink	0.50	0.00	0.00	0.50	0.00	0.50	53.47	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>72.52</b>	<b>0.00</b>	<b>0.00</b>	<b>72.52</b>	<b>0.50</b>	<b>73.03</b>	<b>7,760.10</b>	<b>53.97</b>	<b>99.3%</b>				
<b>Work Center: 502-428 Sheetfed Press</b>													
501-Makeready Straight	70.91	0.00	6.89	72.58	5.22	77.80	14,370.33	1,034.17	93.3%	969	404	5	58%
503-Run Straight	144.06	0.00	0.84	144.06	0.84	144.90	28,523.95	166.26	99.4%	797,190	752,983	5,197	6%
505-Wash Up	45.35	0.00	0.00	45.35	0.00	45.35	8,980.18	0.00	100.0%	131	131	3	
550-Wait for Plates	3.44	0.00	0.92	3.44	0.92	4.36	681.50	182.10	78.9%	0	0	0	
551-Wait for Stock	2.18	0.00	0.00	2.18	0.00	2.18	432.52	0.00	100.0%	0	0	0	
552-Wait for Ink	3.41	0.00	0.00	3.41	0.00	3.41	674.69	0.00	100.0%	0	0	0	
553-Wait For Customer OK	16.07	0.00	1.02	16.07	1.02	17.09	3,182.48	201.24	94.1%	0	0	0	
554-Mix Ink	2.39	0.00	0.00	2.39	0.00	2.39	474.17	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>287.83</b>	<b>0.00</b>	<b>9.67</b>	<b>289.49</b>	<b>8.00</b>	<b>297.49</b>	<b>57,319.82</b>	<b>1,583.77</b>	<b>97.3%</b>				
<b>Work Center: 503-LS 640C</b>													
501-Makeready Straight	15.97	0.00	0.00	15.97	1.75	17.73	3,881.33	426.05	90.1%	2,165	2,165	122	
502-Makeready Perfector	1.42	0.00	0.74	1.42	0.74	2.16	345.59	178.95	65.9%	12	12	6	
503-Run Straight	53.26	0.00	1.01	53.26	1.01	54.27	12,943.11	245.09	98.1%	370,300	354,475	6,531	4%
504-Run Perfector	3.75	0.00	0.00	3.75	0.00	3.75	911.40	0.00	100.0%	19,000	18,750	4,999	1%
505-Wash Up	10.69	0.00	0.00	10.69	0.00	10.69	2,596.99	0.00	100.0%	26	26	2	
550-Wait for Plates	1.95	0.00	1.14	1.95	1.14	3.09	474.34	276.68	63.2%	0	0	0	
551-Wait for Stock	0.41	0.00	0.00	0.41	0.00	0.41	99.29	0.00	100.0%	0	0	0	
553-Wait For Customer OK	3.86	0.00	0.00	3.86	0.00	3.86	937.67	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>91.32</b>	<b>0.00</b>	<b>2.88</b>	<b>91.32</b>	<b>4.64</b>	<b>95.95</b>	<b>22,189.72</b>	<b>1,126.77</b>	<b>95.2%</b>				
<b>Work Center: 504-540 Sheetfed Press</b>													
501-Makeready Straight	21.82	0.00	0.00	21.82	0.00	21.82	4,408.43	0.00	100.0%	815	10	0	99%
503-Run Straight	154.25	0.00	0.00	154.25	0.00	154.25	31,158.50	0.00	100.0%	760,441	703,444	4,560	7%
505-Wash Up	6.20	0.00	0.00	6.20	0.00	6.20	1,251.73	0.00	100.0%	16	16	3	
<b>Totals</b>	<b>182.27</b>	<b>0.00</b>	<b>0.00</b>	<b>182.27</b>	<b>0.00</b>	<b>182.27</b>	<b>36,818.66</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 505-L528</b>													
501-Makeready Straight	3.28	0.00	0.00	3.28	0.00	3.28	583.98	0.00	100.0%	15	15	5	

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503-Run Straight	5.50	0.00	0.00	5.50	0.00	5.50	979.54	0.00	100.0%	23,450	22,000	3,998	6%
505-Wash Up	2.78	0.00	0.00	2.78	0.00	2.78	495.14	0.00	100.0%	9	9	3	
<b>Totals</b>	<b>11.57</b>	<b>0.00</b>	<b>0.00</b>	<b>11.57</b>	<b>0.00</b>	<b>11.57</b>	<b>2,058.66</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 506-240 Sheetfed Press</b>													
501-Makeready Straight	8.02	0.00	0.00	8.02	0.00	8.02	761.90	0.00	100.0%	663	3	0	100%
503-Run Straight	9.05	0.00	0.00	9.05	0.00	9.05	860.06	0.00	100.0%	77,332	76,292	8,427	1%
505-Wash Up	1.64	0.00	0.00	1.64	0.00	1.64	155.47	0.00	100.0%	2	2	1	
<b>Totals</b>	<b>18.71</b>	<b>0.00</b>	<b>0.00</b>	<b>18.71</b>	<b>0.00</b>	<b>18.71</b>	<b>1,777.43</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 507-Multilith</b>													
501-Makeready Straight	1.38	0.00	0.00	1.38	0.00	1.38	62.25	0.00	100.0%	98	52	38	47%
503-Run Straight	26.75	0.00	0.00	26.75	0.00	26.75	1,203.75	0.00	100.0%	218,901	215,948	8,073	1%
505-Wash Up	0.67	0.00	0.00	0.67	0.00	0.67	30.00	0.00	100.0%	1	1	1	
<b>Totals</b>	<b>28.80</b>	<b>0.00</b>	<b>0.00</b>	<b>28.80</b>	<b>0.00</b>	<b>28.80</b>	<b>1,296.00</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 591-Sheetfed Press Helper</b>													
598-Second Pressman	106.51	0.00	0.00	106.51	53.99	160.50	1,065.07	539.92	66.4%	0	0	0	
599-Helper	49.41	0.00	0.00	49.41	131.34	180.75	494.10	1,313.40	27.3%	0	0	0	
<b>Totals</b>	<b>155.92</b>	<b>0.00</b>	<b>0.00</b>	<b>155.92</b>	<b>185.33</b>	<b>341.25</b>	<b>1,559.17</b>	<b>1,853.32</b>	<b>45.7%</b>				
<b>Work Center: 598-Sheetfed Press Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	4.34	4.34	0.00	43.40	0.0%	0	0	0	
952-No Work	0.00	0.00	0.00	0.00	4.52	4.52	0.00	45.18	0.0%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	0.59	0.59	0.00	5.93	0.0%	0	0	0	
954-Meeting	0.62	0.00	0.00	0.62	5.76	6.38	6.21	57.64	9.7%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	5.46	5.46	0.00	54.65	0.0%	0	0	0	
956-Wait for Instructions	0.00	0.00	0.00	0.00	7.71	7.71	0.00	77.11	0.0%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	118.58	118.58	0.00	1,185.83	0.0%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	1.29	1.29	0.00	12.86	0.0%	0	0	0	
<b>Totals</b>	<b>0.62</b>	<b>0.00</b>	<b>0.00</b>	<b>0.62</b>	<b>148.26</b>	<b>148.88</b>	<b>6.21</b>	<b>1,482.60</b>	<b>0.4%</b>				
<b>Department Totals</b>	<b>849.55</b>	<b>0.00</b>	<b>12.55</b>	<b>851.22</b>	<b>346.73</b>	<b>1,197.95</b>	<b>130,785.77</b>	<b>6,100.43</b>	<b>71.1%</b>	<b>Payroll Hours:</b>		<b>1,197.95</b>	

# Work Center Analysis

Date: 06/01/01-09/30/01

Company: Star Printing Production SQL

	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non-Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
<b>Dept-ID: 600-Web Press</b>													
<b>Work Center: 601-526 Half Web</b>													
505-Wash Up	7.35	0.00	0.00	7.35	0.00	7.35	882.03	0.00	100.0%	2	2	0	
550-Wait for Plates	1.18	0.00	0.00	1.18	0.00	1.18	141.11	0.00	100.0%	0	0	0	
553-Wait For Customer OK	1.96	0.00	0.00	1.96	0.00	1.96	235.07	0.00	100.0%	0	0	0	
554-Mix Ink	1.52	0.00	0.00	1.52	0.00	1.52	182.53	0.00	100.0%	0	0	0	
650-M/R Folder	3.78	0.00	0.00	3.78	0.00	3.78	453.10	0.00	100.0%	0	0	0	
655-M/R Sheeter	49.04	0.00	0.00	49.04	0.00	49.04	5,885.19	0.00	100.0%	11,007	11,007	224	
665-Run Folder	12.58	0.00	0.00	12.58	0.00	12.58	1,509.04	0.00	100.0%	0	0	0	
667-Run Sheeter	120.56	0.00	0.00	120.56	0.00	120.56	14,467.17	0.00	100.0%	549,194	376,024	3,119	32%
<b>Totals</b>	<b>197.96</b>	<b>0.00</b>	<b>0.00</b>	<b>197.96</b>	<b>0.00</b>	<b>197.96</b>	<b>23,755.24</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 602-636 Full Web</b>													
505-Wash Up	2.08	0.00	0.00	2.08	0.00	2.08	415.88	0.00	100.0%	0	0	0	
551-Wait for Stock	0.42	0.00	0.00	0.42	0.00	0.42	84.00	0.00	100.0%	0	0	0	
553-Wait For Customer OK	0.68	0.00	0.00	0.68	0.00	0.68	136.06	0.00	100.0%	0	0	0	
650-M/R Folder	6.86	0.00	0.00	6.86	0.00	6.86	1,372.30	0.00	100.0%	0	0	0	
655-M/R Sheeter	3.33	0.00	0.00	3.33	0.00	3.33	665.16	0.00	100.0%	0	0	0	
665-Run Folder	16.64	0.00	0.00	16.64	0.00	16.64	3,327.10	0.00	100.0%	0	0	0	
667-Run Sheeter	9.17	0.00	0.00	9.17	0.00	9.17	1,834.04	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>39.17</b>	<b>0.00</b>	<b>0.00</b>	<b>39.17</b>	<b>0.00</b>	<b>39.17</b>	<b>7,834.54</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 603-536 Full Web With Folder</b>													
650-M/R Folder	12.66	0.00	0.00	12.66	0.00	12.66	2,786.02	0.00	100.0%	0	0	0	
665-Run Folder	25.24	0.00	0.00	25.24	0.00	25.24	5,551.88	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>37.90</b>	<b>0.00</b>	<b>0.00</b>	<b>37.90</b>	<b>0.00</b>	<b>37.90</b>	<b>8,337.90</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 690-Second Web Pressman</b>													
598-Second Pressman	66.99	0.00	0.00	66.99	56.95	123.93	1,674.69	1,423.64	54.1%	0	0	0	
<b>Totals</b>	<b>66.99</b>	<b>0.00</b>	<b>0.00</b>	<b>66.99</b>	<b>56.95</b>	<b>123.93</b>	<b>1,674.69</b>	<b>1,423.64</b>	<b>54.1%</b>				
<b>Work Center: 691-Web Press Helper</b>													
599-Helper	41.91	0.00	0.00	41.91	83.53	125.44	544.82	1,085.89	33.4%	0	0	0	
<b>Totals</b>	<b>41.91</b>	<b>0.00</b>	<b>0.00</b>	<b>41.91</b>	<b>83.53</b>	<b>125.44</b>	<b>544.82</b>	<b>1,085.89</b>	<b>33.4%</b>				
<b>Work Center: 698-Web Press Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	2.21	2.21	0.00	22.14	0.0%	0	0	0	
952-No Work	0.00	0.00	0.00	0.00	10.65	10.65	0.00	106.53	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	10.35	10.35	0.00	103.54	0.0%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	2.81	2.81	0.00	28.10	0.0%	0	0	0	
956-Wait for Instructions	0.80	0.00	0.00	0.80	3.09	3.89	7.95	30.96	20.4%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	80.00	80.00	0.00	800.00	0.0%	0	0	0	
999-Break	0.70	0.00	0.00	0.70	0.00	0.70	7.02	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>1.50</b>	<b>0.00</b>	<b>0.00</b>	<b>1.50</b>	<b>109.12</b>	<b>110.62</b>	<b>14.97</b>	<b>1,091.27</b>	<b>1.4%</b>				

# Work Center Analysis

Date: 06/01/01-09/30/01

Company: Star Printing Production SQL

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	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non- Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
Department Totals	385.43	0.00	0.00	385.43	249.60	635.02	42,162.16	3,600.80	60.7%		Payroll Hours:		635.02

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# Work Center Analysis

	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non-Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
<b>Dept-ID: 700-Bindery</b>													
<b>Work Center: 700-Wholenberg Cutter</b>													
701-Setup	17.78	0.00	0.00	17.78	0.00	17.78	1,280.46	0.00	100.0%	205	180	10	12%
702-Cutting	103.52	0.00	0.00	103.52	0.00	103.52	7,453.28	0.00	100.0%	1,437,557	1,436,766	13,879	0%
953-Clean Up	5.03	0.00	0.00	5.03	0.00	5.03	361.90	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>126.33</b>	<b>0.00</b>	<b>0.00</b>	<b>126.33</b>	<b>0.00</b>	<b>126.33</b>	<b>9,095.64</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 701-T66 Folder</b>													
701-Setup	25.82	0.00	0.00	25.82	0.00	25.82	1,368.38	0.00	100.0%	204	204	8	
703-Folding	95.27	0.00	0.00	95.27	0.00	95.27	5,049.06	0.00	100.0%	541,395	539,300	5,661	0%
953-Clean Up	6.40	0.00	0.00	6.40	0.00	6.40	339.05	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>127.48</b>	<b>0.00</b>	<b>0.00</b>	<b>127.48</b>	<b>0.00</b>	<b>127.48</b>	<b>6,756.49</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 702-Mueller Stitcher</b>													
701-Setup	25.39	0.00	0.00	25.39	0.00	25.39	3,021.17	0.00	100.0%	59	59	2	
710-Stitching/Trimming	118.10	0.00	0.00	118.10	0.00	118.10	14,054.11	0.00	100.0%	115,120	114,000	965	1%
953-Clean Up	5.93	0.00	0.00	5.93	0.00	5.93	705.80	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>149.42</b>	<b>0.00</b>	<b>0.00</b>	<b>149.42</b>	<b>0.00</b>	<b>149.42</b>	<b>17,781.08</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 703-Drill</b>													
701-Setup	0.91	0.00	0.00	0.91	0.00	0.91	31.92	0.00	100.0%	0	0	0	
706-Drilling	2.92	0.00	0.00	2.92	0.00	2.92	102.05	0.00	100.0%	4,000	4,000	1,372	
<b>Totals</b>	<b>3.83</b>	<b>0.00</b>	<b>0.00</b>	<b>3.83</b>	<b>0.00</b>	<b>3.83</b>	<b>133.97</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 705-Shrink Wrapper</b>													
701-Setup	5.56	0.00	0.00	5.56	0.00	5.56	288.98	0.00	100.0%	0	0	0	
707-Shrink Wrapping	55.70	0.00	0.00	55.70	0.00	55.70	2,896.59	0.00	100.0%	607,025	7,025	126	99%
953-Clean Up	0.77	0.00	0.00	0.77	0.00	0.77	39.87	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>62.03</b>	<b>0.00</b>	<b>0.00</b>	<b>62.03</b>	<b>0.00</b>	<b>62.03</b>	<b>3,225.44</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 710-Handwork</b>													
701-Setup	6.51	0.00	0.00	6.51	0.00	6.51	195.38	0.00	100.0%	0	0	0	
709-Handwork	76.32	0.00	0.00	76.32	0.00	76.32	2,289.73	0.00	100.0%	3,000	3,000	39	
<b>Totals</b>	<b>82.84</b>	<b>0.00</b>	<b>0.00</b>	<b>82.84</b>	<b>0.00</b>	<b>82.84</b>	<b>2,485.11</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 720-Chandler Price Diecutter</b>													
701-Setup	1.50	0.00	0.00	1.50	0.00	1.50	105.00	0.00	100.0%	2	2	1	
702-Cutting	3.50	0.00	0.00	3.50	0.00	3.50	245.00	0.00	100.0%	21,500	21,500	6,143	
<b>Totals</b>	<b>5.00</b>	<b>0.00</b>	<b>0.00</b>	<b>5.00</b>	<b>0.00</b>	<b>5.00</b>	<b>350.00</b>	<b>0.00</b>	<b>100.0%</b>				
<b>Work Center: 798-Bindery Indirect Labor</b>													
950-Delays	0.00	0.00	0.00	0.00	1.37	1.37	0.00	13.69	0.0%	0	0	0	
952-No Work	0.00	0.00	0.00	0.00	10.05	10.05	0.00	100.48	0.0%	0	0	0	
953-Clean Up	1.18	0.00	0.00	1.18	0.30	1.49	11.85	3.01	79.7%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	3.36	3.36	0.00	33.59	0.0%	0	0	0	
955-Training	8.07	0.00	0.00	8.07	0.00	8.07	80.67	0.00	100.0%	0	0	0	

# Work Center Analysis

Date: 06/01/01-09/30/01

Company: Star Printing Production SQL

	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non-Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
956-Wait for Instructions	0.00	0.00	0.00	0.00	1.55	1.55	0.00	15.47	0.0%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	58.42	58.42	0.00	584.17	0.0%	0	0	0	
999-Break	0.81	0.00	0.00	0.81	6.79	7.60	8.13	67.88	10.7%	0	0	0	
<b>Totals</b>	<b>10.06</b>	<b>0.00</b>	<b>0.00</b>	<b>10.06</b>	<b>81.82</b>	<b>91.89</b>	<b>100.65</b>	<b>818.29</b>	<b>11.0%</b>				
<b>Work Center: 799-Bindery Helper</b>													
712-Folder Helper	22.33	0.00	0.00	22.33	7.82	30.15	491.22	172.10	74.1%	0	0	0	
713-Stitcher Helper	39.88	0.00	0.00	39.88	0.00	39.88	877.25	0.00	100.0%	0	0	0	
799-Bindery Helper	146.02	0.00	0.00	146.02	54.08	200.10	3,212.49	1,189.78	73.0%	0	0	0	
<b>Totals</b>	<b>208.23</b>	<b>0.00</b>	<b>0.00</b>	<b>208.23</b>	<b>61.90</b>	<b>270.13</b>	<b>4,580.96</b>	<b>1,361.88</b>	<b>77.1%</b>				
<b>Department Totals</b>	<b>775.21</b>	<b>0.00</b>	<b>0.00</b>	<b>775.21</b>	<b>143.73</b>	<b>918.94</b>	<b>44,509.34</b>	<b>2,180.17</b>	<b>84.4%</b>		<b>Payroll Hours:</b>		918.94
<b>Dept-ID: 800-Mailing</b>													
<b>Work Center: 800-Mailing</b>													
800-Mailing	0.00	0.00	0.00	0.00	37.90	37.90	0.00	2,122.46	0.0%	0	0	0	
<b>Totals</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>37.90</b>	<b>37.90</b>	<b>0.00</b>	<b>2,122.46</b>	<b>0.0%</b>				
<b>Work Center: 898-Mailing Indirect Labor</b>													
952-No Work	0.00	0.00	0.00	0.00	5.78	5.78	0.00	57.83	0.0%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	9.74	9.74	0.00	97.44	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	1.21	1.21	0.00	12.14	0.0%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	8.00	8.00	0.00	80.00	0.0%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	0.32	0.32	0.00	3.23	0.0%	0	0	0	
<b>Totals</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>25.06</b>	<b>25.06</b>	<b>0.00</b>	<b>250.64</b>	<b>0.0%</b>				
<b>Department Totals</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>62.96</b>	<b>62.96</b>	<b>0.00</b>	<b>2,373.10</b>	<b>0.0%</b>		<b>Payroll Hours:</b>		62.96

# Work Center Analysis

Date: 06/01/01-09/30/01

Company: Star Printing Production SQL

	Original Hours	Alteration Hours	Rework Hours	Total Chargeable Hours	Total Non-Chg Hours	Total Hours	Total Chargeable Cost	Non-Chargeable Cost	% Chg	Count 1 Quantity	Count 2 Quantity	Per Hour Production	Waste %
<b>Dept-ID: 900-Shipping and Receiving</b>													
<b>Work Center: 900-Warehouse/Packing</b>													
900-Box Pack	82.24	0.00	0.00	82.24	23.19	105.43	1,233.54	347.82	78.0%	1,287,700	62,700	595	95%
901-Skid Pack	19.16	0.00	0.00	19.16	0.00	19.16	287.35	0.00	100.0%	0	0	0	
953-Clean Up	0.57	0.00	0.00	0.57	0.00	0.57	8.61	0.00	100.0%	0	0	0	
<b>Totals</b>	<b>101.97</b>	<b>0.00</b>	<b>0.00</b>	<b>101.97</b>	<b>23.19</b>	<b>125.16</b>	<b>1,529.50</b>	<b>347.82</b>	<b>81.5%</b>				
<b>Work Center: 901-Shipping/Receiving</b>													
902-Shipping/Receiving	17.02	0.00	0.00	17.02	37.76	54.77	255.24	566.32	31.1%	25,015	15	0	100%
953-Clean Up	0.00	0.00	0.00	0.00	7.77	7.77	0.00	116.53	0.0%	0	0	0	
<b>Totals</b>	<b>17.02</b>	<b>0.00</b>	<b>0.00</b>	<b>17.02</b>	<b>45.52</b>	<b>62.54</b>	<b>255.24</b>	<b>682.85</b>	<b>27.2%</b>				
<b>Work Center: 998-Ship/Rec Indirect Labor</b>													
952-No Work	0.00	0.00	0.00	0.00	28.86	28.86	0.00	288.59	0.0%	0	0	0	
953-Clean Up	0.00	0.00	0.00	0.00	0.82	0.82	0.00	8.19	0.0%	0	0	0	
954-Meeting	0.00	0.00	0.00	0.00	8.75	8.75	0.00	87.50	0.0%	0	0	0	
955-Training	0.00	0.00	0.00	0.00	1.76	1.76	0.00	17.60	0.0%	0	0	0	
956-Wait for Instructions	0.00	0.00	0.00	0.00	0.39	0.39	0.00	3.94	0.0%	0	0	0	
990-Paid Leave/Vacation/Sick	0.00	0.00	0.00	0.00	58.75	58.75	0.00	587.50	0.0%	0	0	0	
999-Break	0.00	0.00	0.00	0.00	0.76	0.76	0.00	7.64	0.0%	0	0	0	
<b>Totals</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>	<b>100.09</b>	<b>100.09</b>	<b>0.00</b>	<b>1,000.96</b>	<b>0.0%</b>				
<b>Department Totals</b>	<b>118.98</b>	<b>0.00</b>	<b>0.00</b>	<b>118.98</b>	<b>168.81</b>	<b>287.79</b>	<b>1,784.74</b>	<b>2,031.63</b>	<b>41.3%</b>		<b>Payroll Hours:</b>	<b>287.79</b>	
<b>Report Totals</b>	<b>3,185.67</b>	<b>50.83</b>	<b>44.08</b>	<b>3,245.63</b>	<b>1,447.46</b>	<b>4,693.09</b>	<b>302,864.89</b>	<b>23,762.25</b>	<b>69.2%</b>				