



Did you Know?

Good Sheet Counter

Explanation

The good sheet counter separates the make-ready process from the good production process. By activating the good sheet counter the make-ready process ends and the good production starts. All sheets which are printed after the good sheet counter is activated, are counted as net impressions. All other sheets which are counted while the good sheet counter is deactivated are counted as waste sheets.

The good sheet counter should always be activated as soon as the make-ready process is done. This ensures that all make-ready sheets are counted as waste sheets.

Waste sheets can also be produced during good production. In case of any process interruptions such as paper run issues or blanket wash the first sheets after the restart of the good production are waste sheets and should be counted as run waste. In order to do so, the good sheet counter has to be deactivated until the quality of the sheets is back to normal.

There are several ways to activate the good sheet counter. It can be activated manually by the operator at the press center or the control panel. Another possibility is (this depends on software version of the press) to automatically activate the good sheet counter after a certain number of sheets were printed or a defined delta E was reached.

Influences

It is very important to use the good sheet counter properly. As described, the good sheet counter not only separates the make-ready process from the good production process but also counts the amount of waste sheets and good sheets (net impressions). Furthermore, the time spend for make-ready and good production is also defined by using the good sheet counter.

With that, the good sheet counter has a very high influence on almost all performance KPI's. Incorrect make-ready times and waste sheets will lead to low quality data and thus result in incorrect performance KPI's. The following KPI's are influenced by the good sheet counter:

- Overall Equipment Effectiveness (OEE)
- Net Output
- Net Productivity
- Net Impressions
- Average Good Production Speed
- Make Ready Time
- Basic Make Ready Time
- Fine Tuning Time
- Production Time

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- Make Ready Waste
 - Run Waste

Because of this high influence, the data for all the jobs where the good sheet counter was not used properly, are marked as invalid data. This is one of the major reasons as why for some months there might be a higher amount of invalid data shown in the Heidelberg Assistant.

Summary

The use of the good sheet counter is mandatory in order to calculate accurate performance KPI's. If the good sheet counter is used in the wrong way, not used at all or simply activated too soon or too late, make-ready, good production times and sheets cannot be counted correctly. With this data, accurate calculations are not possible which is why they are marked as invalid.