# Press Strokes per Minute Log

*How-to guide: what the workbook does, how to use it and what every number means.* mfgcalcs.com

# Press Strokes per Minute Log

Turn every press run's stroke counter and stop log into the running strokes per minute, availability and the strokes lost to stops and speed.

For: Press shop supervisors, stamping process and industrial engineers, and production managers running mechanical and servo presses.

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## Quick start

1. On Setup, type your plant and speed band, list your presses, and your dies with their approved strokes per minute and parts per stroke.
2. On Runs, give each press run a row: date, shift, press, die, strokes from the counter, scheduled hours and stop hours.
3. Fix anything the Check column names.
4. Open the Dashboard: strokes made and lost on every press, and each die's running rate against its approved speed.

## What is in the workbook

| | |
|---|---|
| **Start Here** | Read this first: what the workbook does and how to use it. |
| **Setup** | Plant, the speed band, the presses, and the dies with their approved strokes per minute and parts per stroke. |
| **Runs** | One row per press run: counter strokes, scheduled time and stops in; stroke rates, availability and strokes lost out. |
| **Dashboard** | Running strokes per minute against approved speed, and the strokes lost to stops and to speed. |
| **Method** | How every number is calculated, with assumptions, limits and sources. |
| **Verify** | Self-check: the workbook's formulas recomputed on fixed inputs against an independent reference. |

## What each number means

| Quantity | How it is calculated | Units |
|---|---|---|
| **Running hours** | Scheduled hours - stop hours. | h |
| **Running and scheduled SPM** | Strokes / (running hours x 60); strokes / (scheduled hours x 60). | strokes/min |
| **Availability** | Running hours / scheduled hours. | % |

| Quantity | How it is calculated | Units |
|---|---|---|
| **Rate vs approved, speed ratio and status** | Running - approved SPM; running / approved; Out of limits above approved, On target within the band, Below target further under. | strokes/min, %, - |
| **Parts stamped** | Strokes x parts per stroke. | parts |
| **Strokes lost** | To stops: approved SPM x stop hours x 60; to speed: approved SPM x running hours x 60 - strokes. | strokes |

Assumptions, limitations, sources and the self-check (the Verify sheet, which recomputes the workbook's formulas on fixed test inputs) are in the workbook. The last page shows the Dashboard with the example data for Wexcombe Stampings, a fictional business.

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Engineering estimates for planning and improvement work. Verify the results against your own process, data and standards before you rely on them.

# Press Strokes per Minute Log

*Running strokes per minute against approved speed, and the strokes lost to stops and to speed.*

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*Wexcombe Stampings (example): 12 runs from 2 Nov 2026 to 5 Nov 2026. On target within 5% of approved.*

| STROKES | AVAILABILITY | SPEED AGAINST APPROVED | RUNS ABOVE APPROVED SPEED |
|---|---|---|---|
| **103,500** | **84.9%** | **97.1%** | **1** |
| From the stroke counter | Running / scheduled hours | Strokes / strokes at approved SPM | Check the counter and setup |

## Strokes made and lost by press




## Running strokes per minute against approved, by die

