

64hrs 18mins

Total Production Time

41hrs 10mins

Effective Production Time

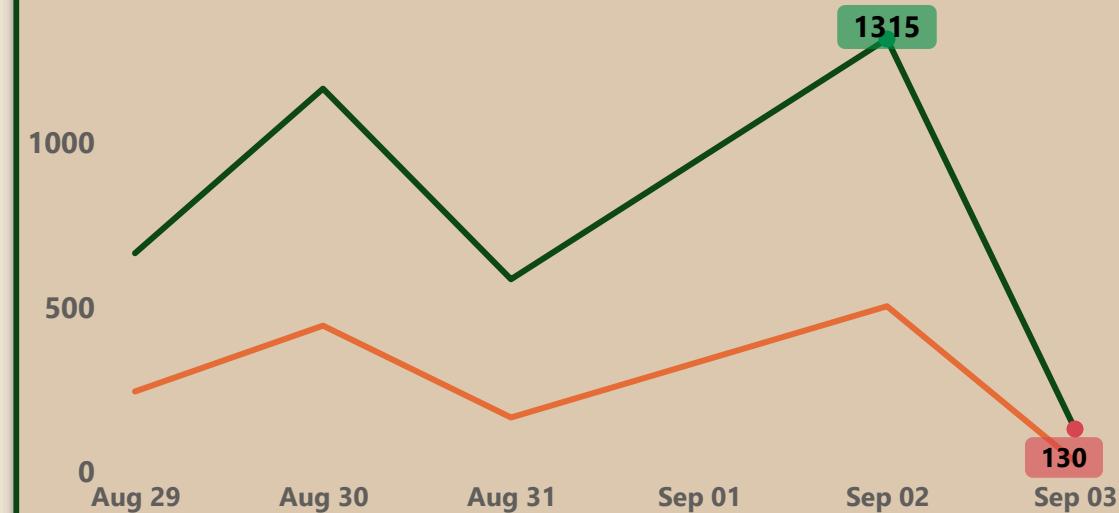
23hrs 8mins

Total Downtime

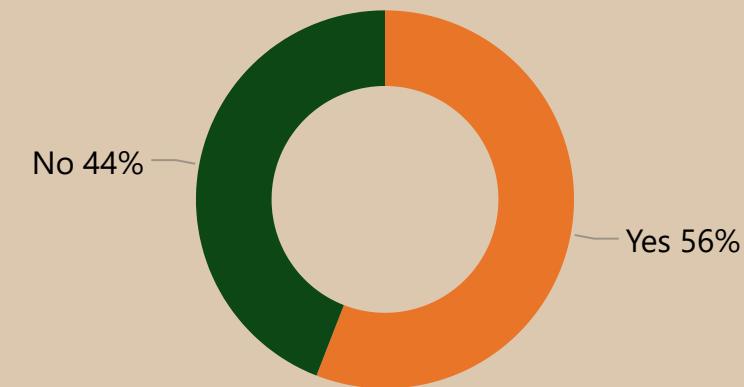
36.0%

Downtime Rate

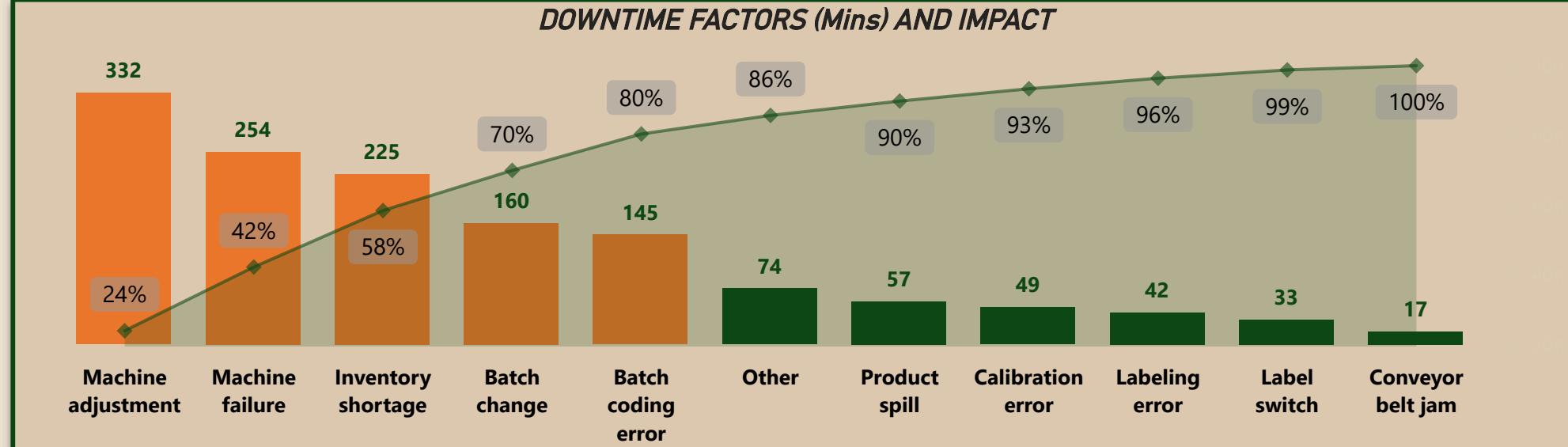
TOTAL PRODUCTION VS DOWNTIME



DOWNTIME CAUSED BY OPERATOR'S ERROR



DOWNTIME FACTORS (Mins) AND IMPACT



64.0%

Overall Line Efficiency

38

Total Batches

35

Batches with Downtime

40 mins

Avg Downtime per Batch

OPERATOR - PERFORMANCE

| | Batch change | Batch coding error | Calibration error | Conveyor belt jam | Inventory shortage | Label switch | Labeling error | Machine adjustment | Machine failure | Other | Product spill | Total |
|--------------|--------------|--------------------|-------------------|-------------------|--------------------|--------------|----------------|--------------------|-----------------|-----------|---------------|-------------|
| Charlie | 10 | 44 | 24 | | 17 | 10 | 22 | 118 | 85 | 32 | 22 | 384 |
| Dee | 20 | 30 | 25 | 17 | 85 | 23 | 20 | 79 | 36 | 20 | 15 | 370 |
| Dennis | | 24 | | | 43 | | | 120 | 88 | 7 | 20 | 302 |
| Mac | 130 | 47 | | | 80 | | | 15 | 45 | 15 | | 332 |
| Total | 160 | 145 | 49 | 17 | 225 | 33 | 42 | 332 | 254 | 74 | 57 | 1388 |

PRODUCT - PERFORMANCE

| | Batch change | Batch coding error | Calibration error | Conveyor belt jam | Inventory shortage | Label switch | Labeling error | Machine adjustment | Machine failure | Other | Product spill | Total |
|--------------|--------------|--------------------|-------------------|-------------------|--------------------|--------------|----------------|--------------------|-----------------|-----------|---------------|-------------|
| CO-600 | 20 | 44 | 10 | 17 | 108 | 20 | | 57 | 116 | 45 | 57 | 494 |
| CO-2L | | 31 | | | 42 | | 22 | 120 | 55 | 7 | | 277 |
| RB-600 | | 30 | 15 | | 20 | 13 | 20 | 135 | 18 | 7 | | 258 |
| LE-600 | 80 | 20 | 24 | | 25 | | | 20 | | | | 169 |
| DC-600 | | 20 | | | 30 | | | | 50 | 15 | | 115 |
| OR-600 | 60 | | | | | | | | 15 | | | 75 |
| Total | 160 | 145 | 49 | 17 | 225 | 33 | 42 | 332 | 254 | 74 | 57 | 1388 |