

64hrs 18mins

Total Production Time

41hrs 10mins

Effective Production Time

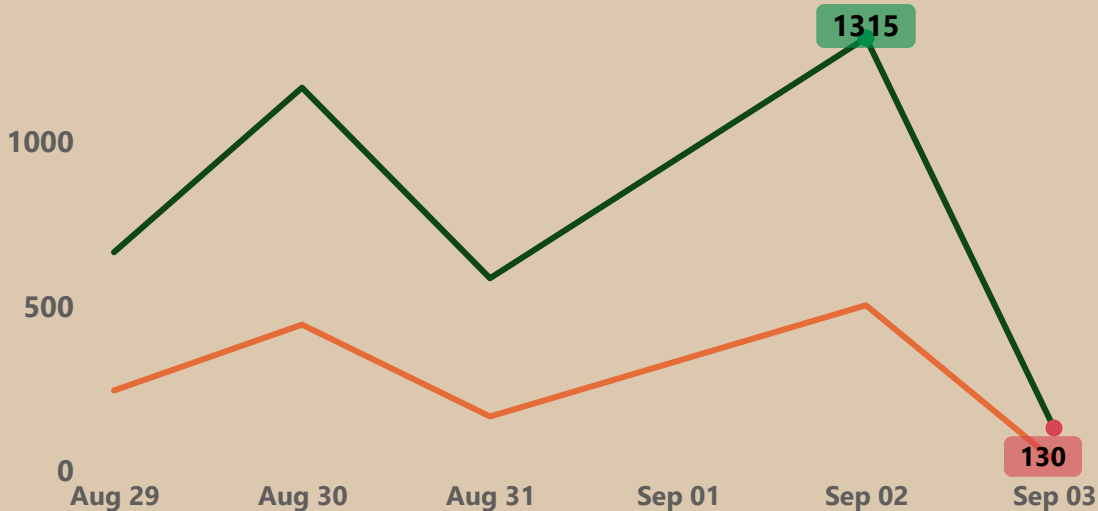
23hrs 8mins

Total Downtime

36.0%

Downtime Rate

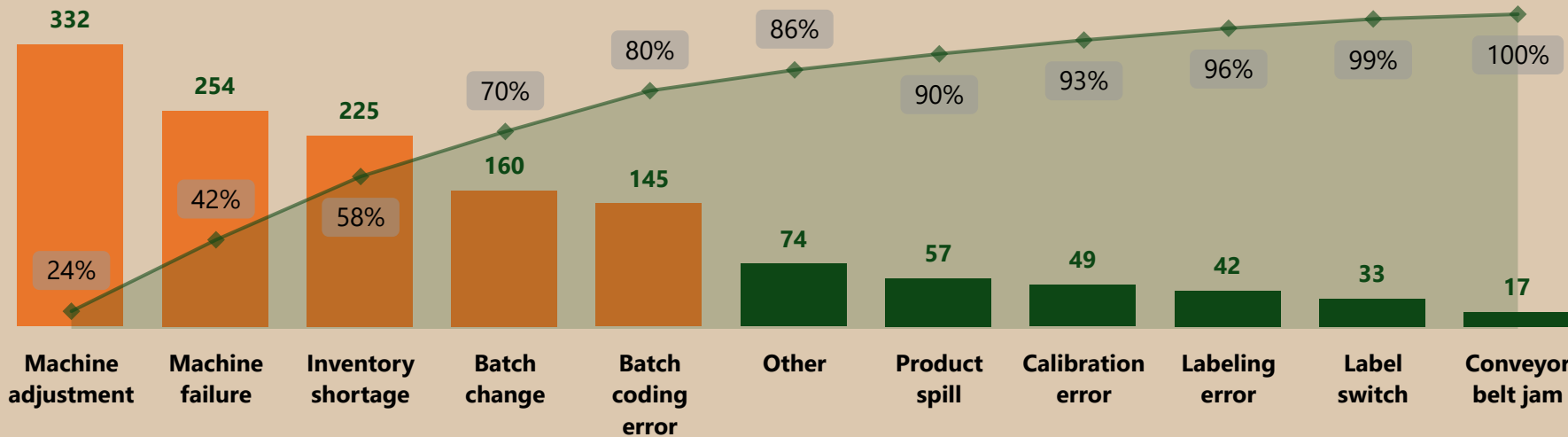
TOTAL PRODUCTION VS DOWNTIME



DOWNTIME CAUSED BY OPERATOR'S ERROR



DOWNTIME FACTORS (Mins) AND IMPACT



WOLF COLA CO.

Downtime Analysis

Performance Analysis

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