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GLOBAL OPERATIONS

Global Shop Floor Tools – Snacks
Train the Trainer Session

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What is MES?
gSFT Overview and Program Details

What is Global Shop Floor Tools?

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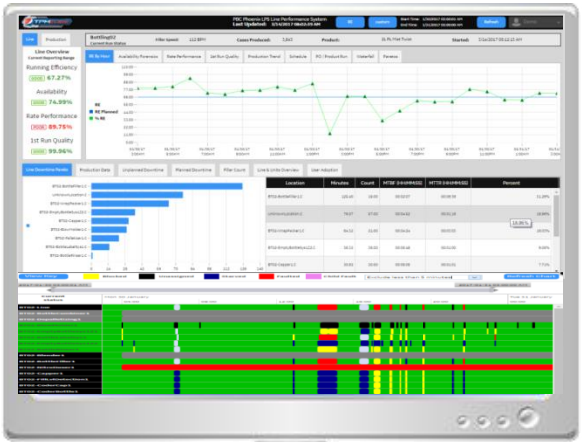
Global Shop Floor Tools is a Manufacturing Execution System (MES) that provides real time detailed performance information that supports Continuous Improvement thru real time data insights.

Real Time Line Status and Productivity Measures

- ✓ TE, NE, Loss Trees
- ✓ Downtime
- ✓ Slow Running
- ✓ Waste
- ✓ Automated Downtime Events
- ✓ Automated Slow running Events
- ✓ Automated Waste Tracking
- ✓ Make vs plan visibility
- ✓ Real time and historical reports

Two Versions Available:

1. **Basic** – Lower Cost, less functionality or machines connected
2. **Enhanced** – Full functionality



[Global Shop Floor Tools - Veurne Snacks Plant]
User Name/Password: admin/admin

Foundational to DVC

[Global Shop Floor Tools - Phoenix Beverage Plant]
User Name/Password: demo/pepsi

Today we have many questions on Efficiency losses

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When are they happening??? Where are they happening ???
Why are they happening ???

Global Shop Floor Tools Dashboard helps:

Collect data directly from PLC or through interfaces

Measure efficiency, components APQ or DTW and trends

Operators and Managers know how they are performing

Measuring and tracking performance helps improve line efficiency!

Benefits of Global Shop Floor Tools

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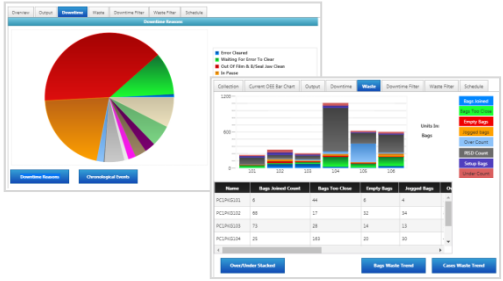
Real Time Data

- Real time Line Status
- Real time Line Performance Data
- Real time Productivity Measures and Analysis:
  - ✓ TE, NE, Loss Trees
  - ✓ Availability/Downtime
  - ✓ Slow Running/Rate Performance
  - ✓ Quality/Waste
- Accurate and Consistent Data and KPIs for tracking and reporting
- Make vs. Plan Visibility
- Real time and historical reports

Automated Data Collection

- Automated Packaging Detailed Downtime Events
- Semi-Automated Processing Downtime Events
- Automated Processing and Packaging Slow running/Rate Loss Performance
- Automated Packaging Waste data
- Semi-Automated Processing Waste
- Reduces or eliminates manual data collection and tracking of gSFT KPIs



Support Continuous Improvement

- With Global Shop Floor Tools, Continuous Improvement Processes share the same information and effective action planning and sustainable improvements are supported

R&R REVIEW AND RESPONSE

lean 6σ

QCDM Process

TPM EDGE

MOTOR+ PEPSICO

Global Shop Floor Tools Program

Who uses gSFT and how is gSFT used?

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gSFT Vision: We will use gSFT to drive performance by sharing fact based real time insights to achieve world class Manufacturing Excellence. gSFT is foundational to Digital Value Chain (DVC).

Managers

- FLMs
- Department Managers
- Engineering/Maintenance Managers
- Process Improvement Managers
- Site Leadership

✓ Review Line and Machine level Performance Hourly, Daily, Weekly

✓ Identify causes impacting performance and develop action plans

✓ Review Performance trends and address root causes

✓ Leverage data for focused improvement events

✓ Understand Site Performance

Frontline

- Processing and Packaging Operators
- Specialists
- Supervisors

✓ Review Line KPIs to identify opportunities and create action plans to win the hour and shift

Sector

- Productivity
- MOS
- LSS
- Engineering/Controls
- SMEs

✓ Review and Analyze Line and Machine Level Performance trends

✓ Deep Dive Line Performance data and implement best practices

✓ Benchmark Line Performance

✓ Commission new equipment

✓ Leverage data for focused improvement events

Global Shop Floor Tools (Snacks MES)

Aligns with Continuous Improvement Methodologies

LSS – Lean Six Sigma is a methodology that focuses on performance improvement by removing waste and reducing variation in processes through data based analysis.

A LSS approach focuses on reducing process variation which improves:

- Removing non-value added work
- Defect reduction
- Quality of products and services
- Employee Morale
- Profit

Global Shop Floor Tools supports 4 out of 5 Lean Six Sigma phases:

- ✓ DEFINE PHASE – Defining Problem, Pain, Charter
- ✓ MEASURE PHASE – Establishing baseline/accuracy of data
- ✓ ANALYZE PHASE – Identifying root causes
- IMPROVE PHASE – Take action to implement solutions to root causes impacting performance
- ✓ CONTROL PHASE – Sustaining results/post audit – Use LPS

Insert Sector Continuous Improvement Methodologies

ESSA – QCDM

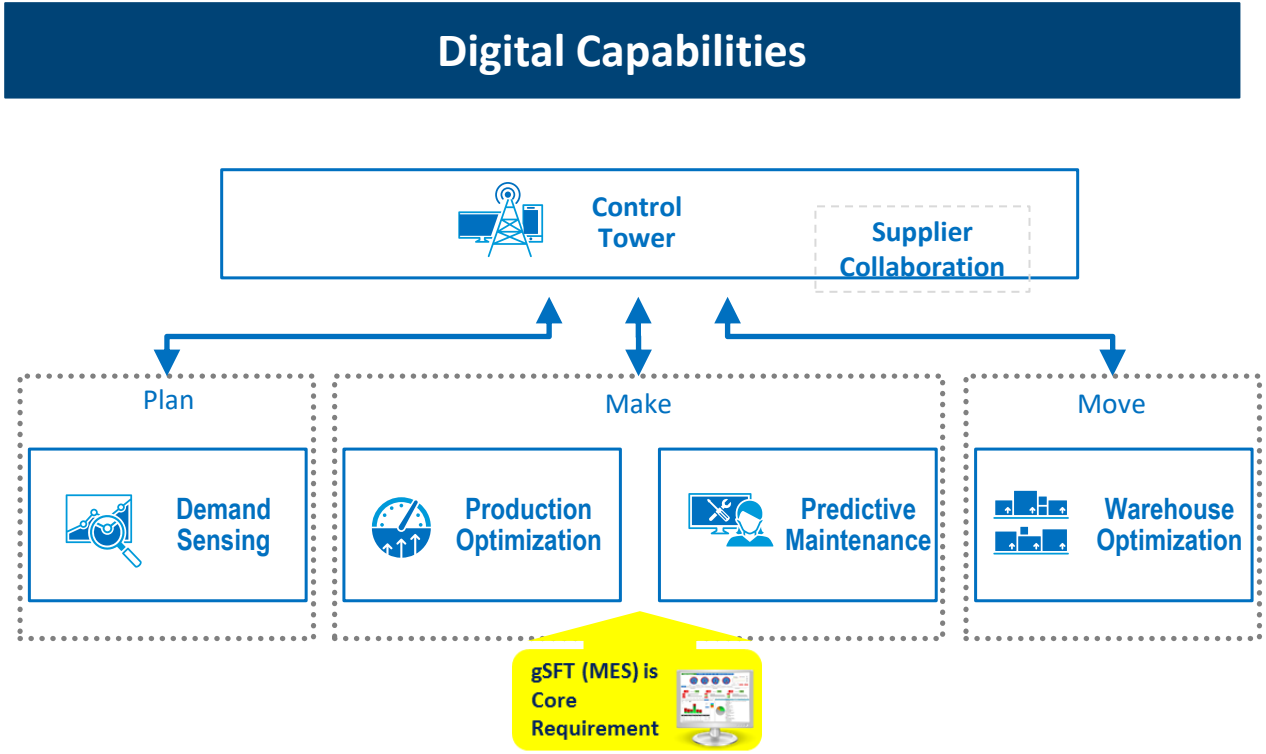
LATAM – MOTOR

AMENA -

gSFT Connection to DVC

Connection to Global Shop Floor Tools

PepsiCo has prioritized 5 digital capabilities that will transform our operations, deliver productivity, and increase our agility to serve customers



Global Shop Floor Tools (Snacks MES)
Your Role – gSFT Owner

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What is your role as gSFT Site Owner?

- ✓ **Responsible for being local MES Subject Matter Expert**
- ✓ **Responsible for identifying future SMEs and building MES capability**
- ✓ **Responsible for development and execution of Change Management Strategy**
  - **Developing and executing Business Integration Strategy (how will MES be used)**
  - **Developing and executing Training Strategy (including customizing Training Materials)**
  - **Developing and tracking MES Success Criteria**
- ✓ **Engagement/Support through UAT**
  - **Support Test Cases provided by TCS**
  - **There can be no High severity issues remaining; High Severity means System unusable, no work around exists**
- ✓ **Advocate for gSFT**
- ✓ **Responsible for identifying and supporting Adoption Risks/Mitigation Actions**

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What is your role as an gSFT Subject Matter Expert?

- ✓ **Responsible for being local MES Subject Matter Expert and building MES capability**
- ✓ **Responsible for supporting Training Strategy**
- ✓ **Engagement/Support through UAT**
  - Support Test Cases provided by TCS
  - There can be no High severity issues remaining; High Severity means System unusable, no work around exists
- ✓ **Advocate for gSFT and identify/support Adoption Risks/Mitigation Actions**

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Global Shop Floor Tools – Snacks Navigation Training

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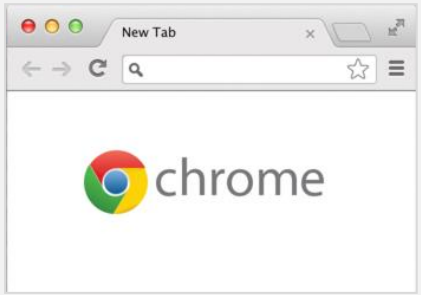
Dashboard Navigation

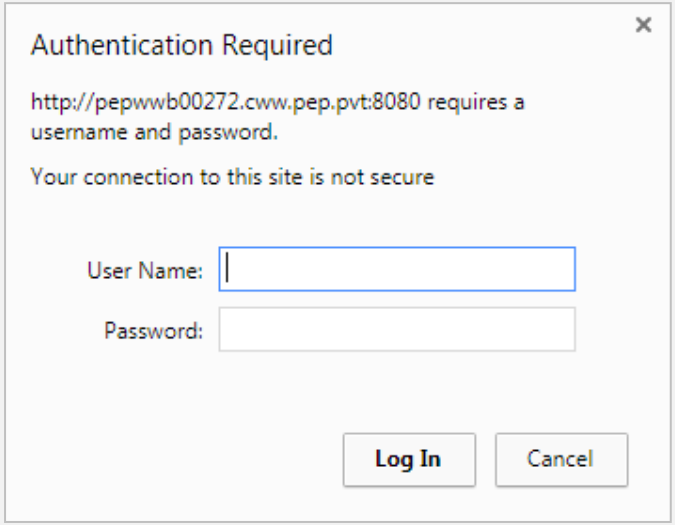
Login to Dashboard

- Web-based URL (Unique to each Site)
- Chrome – Preferred Browser
- OITs, Desktops, Laptops, Mobile devices



http://11.84.46.214:8080/Thingworx/Runtime/index.html#master=MES_Home&mashup=MES_Dashboard

- User Name
  - GPID
  - Generic User Name/Password (admin/admin)
- Device must be connected to PepsiCo Network



Global Shop Floor Tools (Snacks MES)

gSFT LatAm Links

- **Cerrillos:**
  http://meswebcerrillos.cww.pep.pvt:8080/Thingworx/Runtime/index.html#master=MES_Home&mashup=MES_Dashboard
- **Itu:**
  http://11.128.113.9:8080/Thingworx/Runtime/index.html#master=PepsiCo_Master&mashup=MES_Dashboard
- **Curitiba:**
  http://pepwap09680.cww.pep.pvt:8080/Thingworx/Runtime/index.html#master=PepsiCo_Master&mashup=MES_Dashboard
- **Guadalajara:**
  http://meswebguadalajara.cww.pep.pvt:8080/Thingworx/Runtime/index.html#master=PepsiCo_Master&mashup=MES_Dashboard
- **Saltillo:**
  http://meswebsaltillo.cww.pep.pvt:8080/Thingworx/Runtime/index.html#master=MES_Home&mashup=MES_Dashboard
- **Vallejo:**
  http://pepwap09264.cww.pep.pvt:8080/Thingworx/Runtime/index.html#master=MES_Home&mashup=MES_Dashboard

USER: demo

PASSWORD: demo

Global Shop Floor Tools (Snacks MES)

gSFT Access Levels

gSFT Functions (ThingWorx)	Access		
	Read Only	Update	Admin
Setpoint Events			
Update		Y	Y
Downtime Events			
Create/Delete			Y
Update		Y	Y
Split		Y	Y
Waste Events			
Create/Delete			Y
Update		Y	Y
Collaboration			
Add	Y	Y	Y
Edit	Y	Y	Y
Delete			Y
Make vs. Plan			
Edit Cases Required, Scheduled Start/End		Y	Y
OEE by Operator			
Assign Operator		Y	Y
Production Case Entry			
Update		Y	Y
Waste			
Create/Delete		Y	Y
Update		Y	Y
Administration Menu items			
Monetize Year Parameters			
Update			Y
Product Maintenance			
Create/Copy			Y
Modify			Y
Activate/Inactivate			Y
Specification Maintenance			
Update			Y
Reports			
	Y	Y	Y

- **Levels of access can be assigned for a Group or Individual**
- **3 Levels of Access**
  - **Read Only**
  - **Update**
  - **Admin**

- **How to Request New User ID**
  - User ID (Groups or Individuals)
    - Send email to SPAITGSFTSupport@pepsico.com with group name and access level required
  - GPID Access (future):
    - An iDM request process will be developed and communicated at a later date.

Global Shop Floor Tools (Snacks MES)

gSFT Definitions

Project Terminology	
AU	Asset Utilization
DT	Downtime
FTT	Fault Translation Table
HMI	Human-Machine Interface
KPI	Key Performance Indicator
MES	Manufacturing Execution System
MTBF	Mean Time Between Failure
MTTR	Mean Time To Recover
NE	Net Efficiency
OEE	Overall Equipment Effectiveness
OPC	OLE for Process Control (Device Communication protocol)
PA	PA (GEIP Proficy suite MES application)
PC	Potato Chips
PE	Production Event
PLC	Programmable Logic Controller
SSRS	SQL Server Reporting Services
TCS	Tata Consultancy Services
TWX	ThingWorx
WE	Waste Event
WIP	Work In Progress

Global – Equipment Terminology	
Packaging Terms	Description
ACP	Auto Case Packer
BMK	Bag Maker
CHW	Check Weigher
MHW	Multi Head Weigher
PKG	Packaging

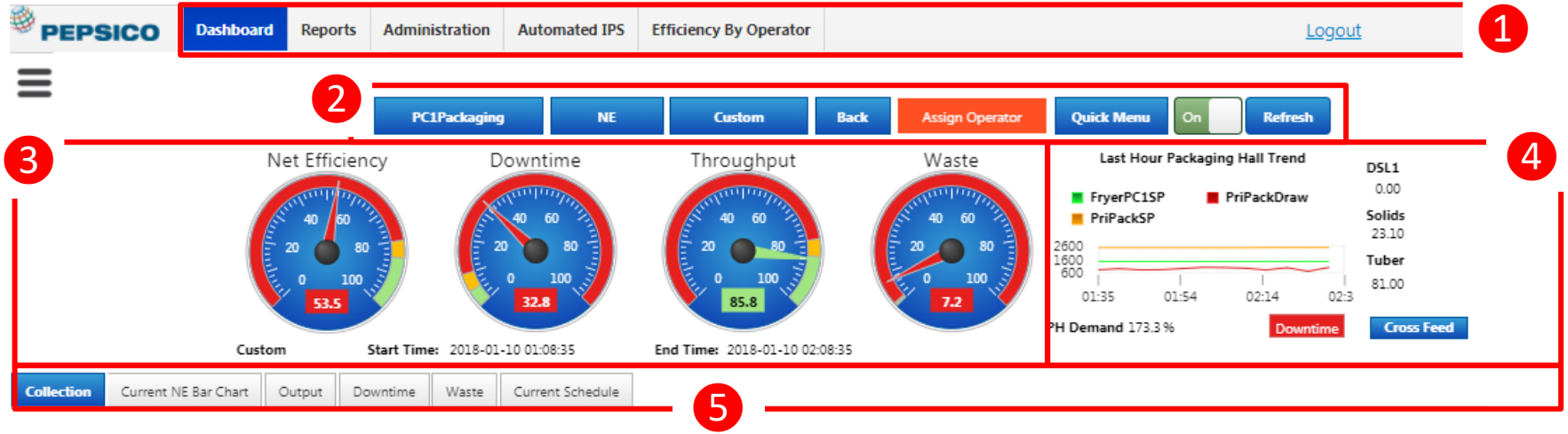
ThingWorx Dashboard: Link to log on to SiteThingWorx dashboard home page below. *Currently, ThingWorx dashboard is available in English*

(Copy link using Chrome Browser – URL is site specific)

At Cerrillos Plan, MES is available in:
_____ Departments (PC), _____Fryers and _____ Auto Packaging Tubes and _____ Manual Packaging tubes.

Global Shop Floor Tools (Snacks MES)

Dashboard Screen Layout



Dashboard consists of:

1. Dashboard Selection – Primary Dashboard, Reports, Administrative, Automated IPS, Packaging Tubes, Efficiency by Operator
2. Reporting Range Section – Select Entity, KPIs, Date Range, Refresh, Back, Shortcuts, Assign Operator
3. Real time performance Gauges for selected entities and date range
4. Processing Mini Trend – Last Hour Throughput
5. Production Trends and Analysis Tabs

This training deck will explain how to navigate through the gSFT Dashboard

Dashboard Screen Layout

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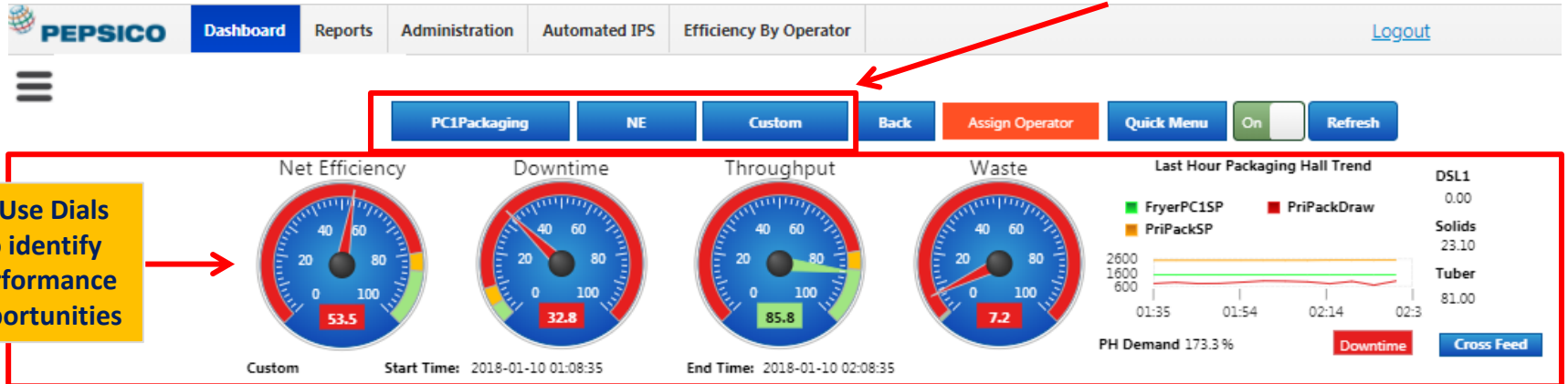
1. Use buttons to select report criteria



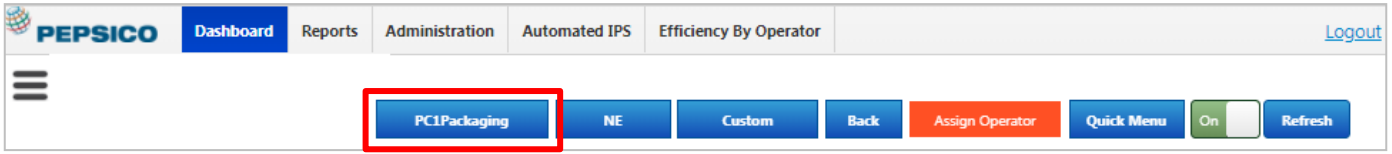
2. Use Dials to identify performance opportunities

3. Use Analysis Tabs to investigate using detailed performance data or trends for the entity/zone/equipment selected. The information is displayed in the main display area here

Note: Dials and Report Criteria stay the same regardless of tab selected

Global Shop Floor Tools (Snacks MES)

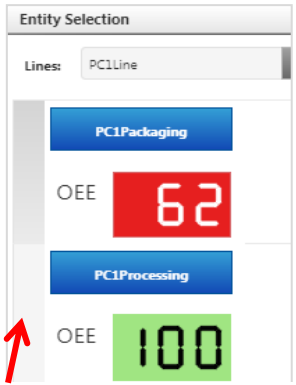
Choosing your data – Select Entity (Area)



Global Shop Floor Tools Dashboard KPI's can be viewed by:

1. **Line Entity – Entire Line and/or Processing Entity – Fryer/Oven**
2. **Packaging Department – Combined Packaging Units**
3. **Packaging Unit - One Single Packaging Unit consisting of: MHW, BMK, INS/CW, ACP**

Select Line from Drop Down menu
Use Blue Buttons for Area selection



Gray or White Areas can be used to refresh screen

Blue buttons can be used to make Entity selection

Select Packaging Unit Name for individual Unit performance

① **Line Entity and/or Processing Line**

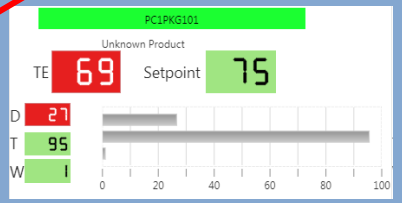
PC1Processing

② **Packaging Department**

PC1Packaging

③ **Single Packaging Unit**

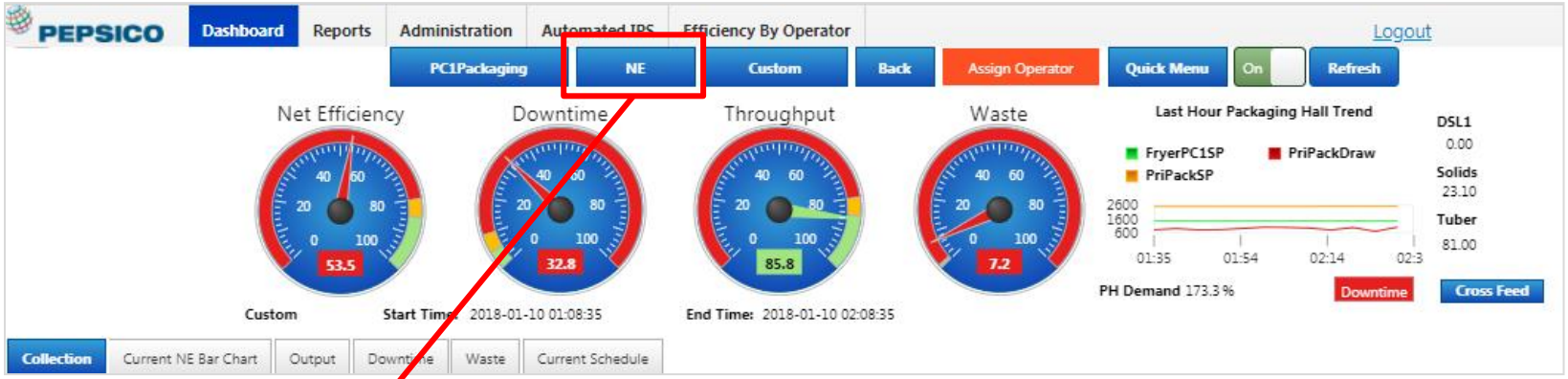
PC1PKG101



Line Names will differ from Site to Site. Above line names are Veurne Plant example

Global Shop Floor Tools (Snacks MES)

Choosing your data: Reporting Metric



NE – Net Efficiency - Overall Efficiency of the Line

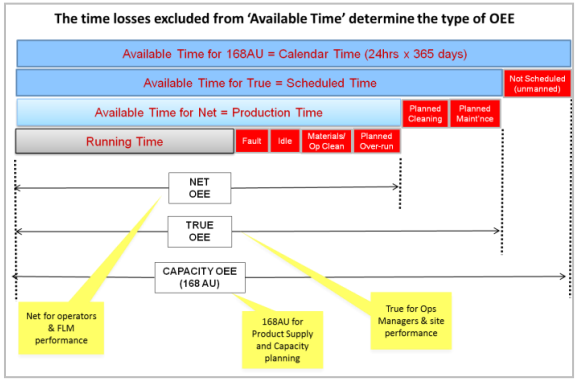
- Excludes Planned Downtime or Dark Hours

TE – True Efficiency - Overall Efficiency of the Line

- Excludes Dark Hours

AU – Overall Capacity Utilization of the Line

- All Hours in one week



TE is the CI Compass

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TE is the CI "compass".....

Production kg or litres

TE

Scheduled DT	Unscheduled DT	Slow running	Waste
Planned activities	Overrun planned activities and unplanned downtime	Reduced throughput vs. rated speed	Product & packaging waste and product giveaway

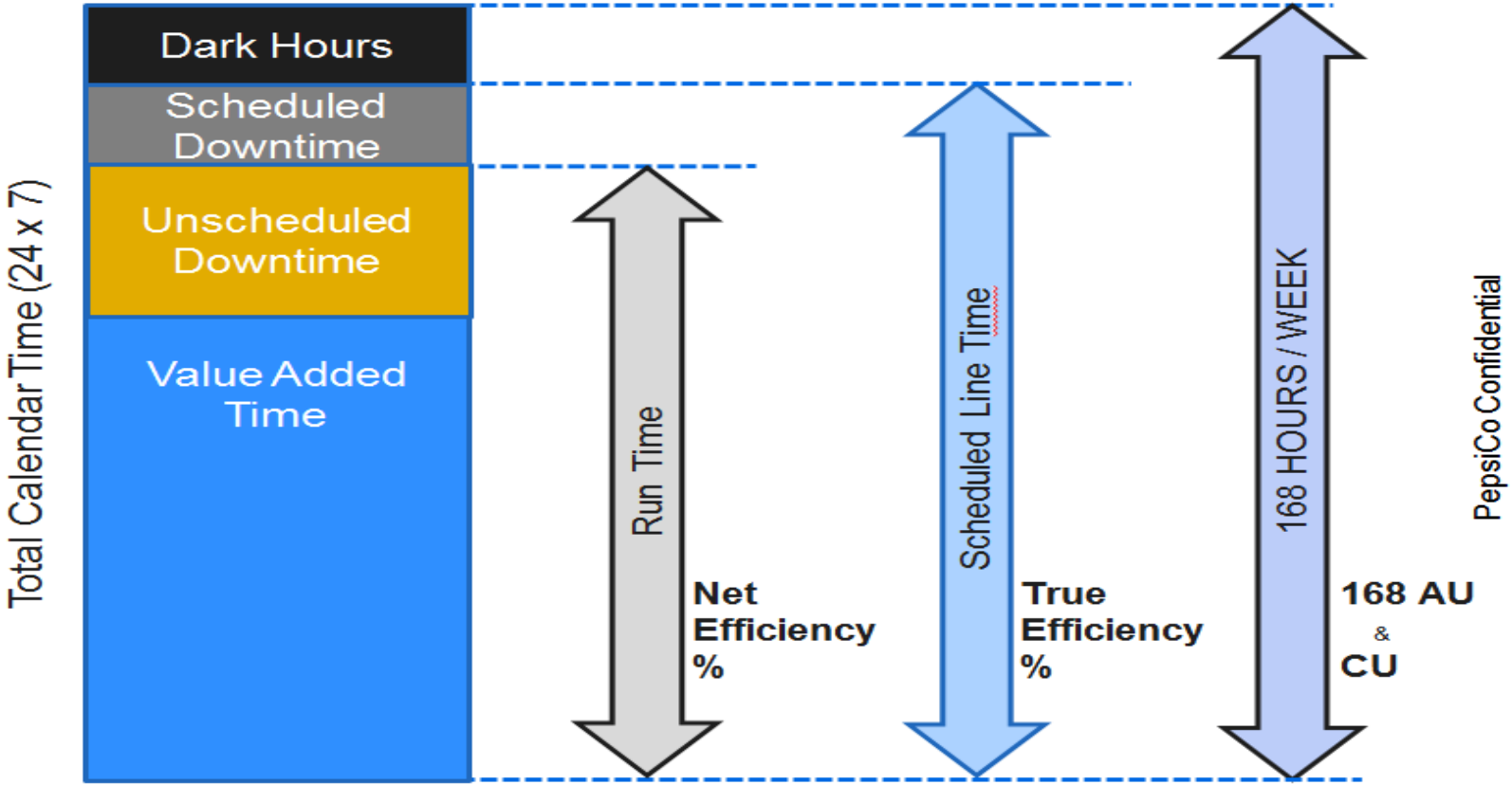
MOS Central Technical Services EUROPE

The only exclusion is unscheduled calendar time or "dark hours".... this is defined as NO activity whatsoever.

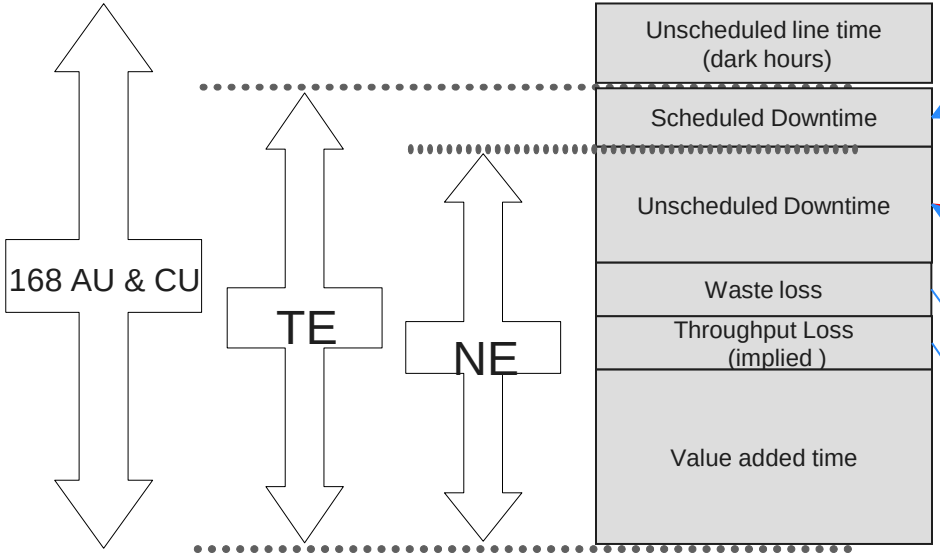
Central Technical Services

smiles

The 168 hours in a week is broken down into categories that feed the different metrics



Numerous factors can reduce value-add run-time of a line...
TE highlights true value-added performance



- Sanitation
- Maintenance
- Changeover
- Network Outages hrs
- Line Setup & Shutdown
- Team Meeting Hrs
- Other

- Overrun on: Sanitattion / Maintenance / Changeover
- Processing Breakdown
- Packaging Breakdown
- RM Shortages hrs
- Quality Issues
- Utilities
- Other

- Waste Loss: Optisort , Unseasoned , Seasoned ,% Giveaway

- Rate Loss

Need to first understand root causes of loss areas when focusing on TE improvement

Pepsico Efficiency definition

Building a top class Supply Chain to put smiles ON A BILLION FACES

$$\frac{\text{How much Good Product was actually made (base)}}{\text{How much Product could have been made if the Line ran “perfectly”}}$$

$$\text{Efficiency} = \frac{(\ldots\ldots\ldots\ldots\ldots)}{(\ldots\ldots\ldots\ldots\ldots) \times (\ldots\ldots\ldots\ldots\ldots)}$$

$$\text{Efficiency} = \frac{\text{(Good Product)}}{\text{(Available Time) x (Nameplate)}}$$

Efficiency components

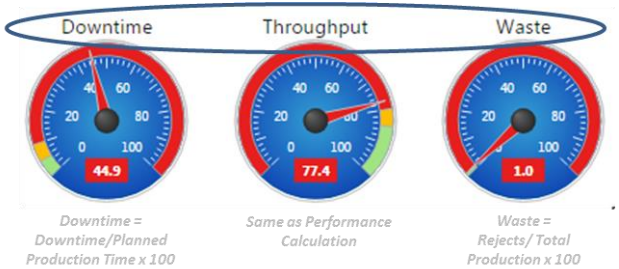
Losses = Downtime & Slow Running & Waste

Losses = Downtime & Throughput & Waste

$$\frac{\text{(Running Time)}}{\text{(Available Time)}} \;\&\; \frac{\text{(Total Product)}}{\text{(Theoretical Product)}} \;\&\; \frac{\text{(Good Product)}}{\text{(Total Product)}}$$

$$\frac{\text{(Running Time)}}{\text{(Available Time)}} \;\&\; \frac{\text{(Total Product)}}{\text{(Running Time) x (Nameplate)}} \;\&\; \frac{\text{(Good Product)}}{\text{(Total Product)}}$$

$$\text{Efficiency} = \frac{\text{(Good Product)}}{\text{(Available Time) x (Nameplate)}}$$



Process (Whole Line performance)

The generic formula for the global Efficiency metrics is

$$Efficiency = \frac{\text{(Net production of base chip)}}{\text{(Theoretical possible production)}} = \frac{\text{(Net Production)}}{\text{(Available Time) x (Nameplate)}}$$

The 3 efficiency metrics differ by the "Available Time" and "Nameplate" used to calculate the theoretical possible production -

Metric	Available Time	Nameplate
168 Asset Utilisation	Calendar time	Technology maximum
True Efficiency	Calendar time – unmanned time	Product maximum *(for PC this is also flexed according to the average potato solids during the available time)*
Net Efficiency	Calendar time – (unmanned time + planned downtime)	

Choosing your data: Time Frame Selection

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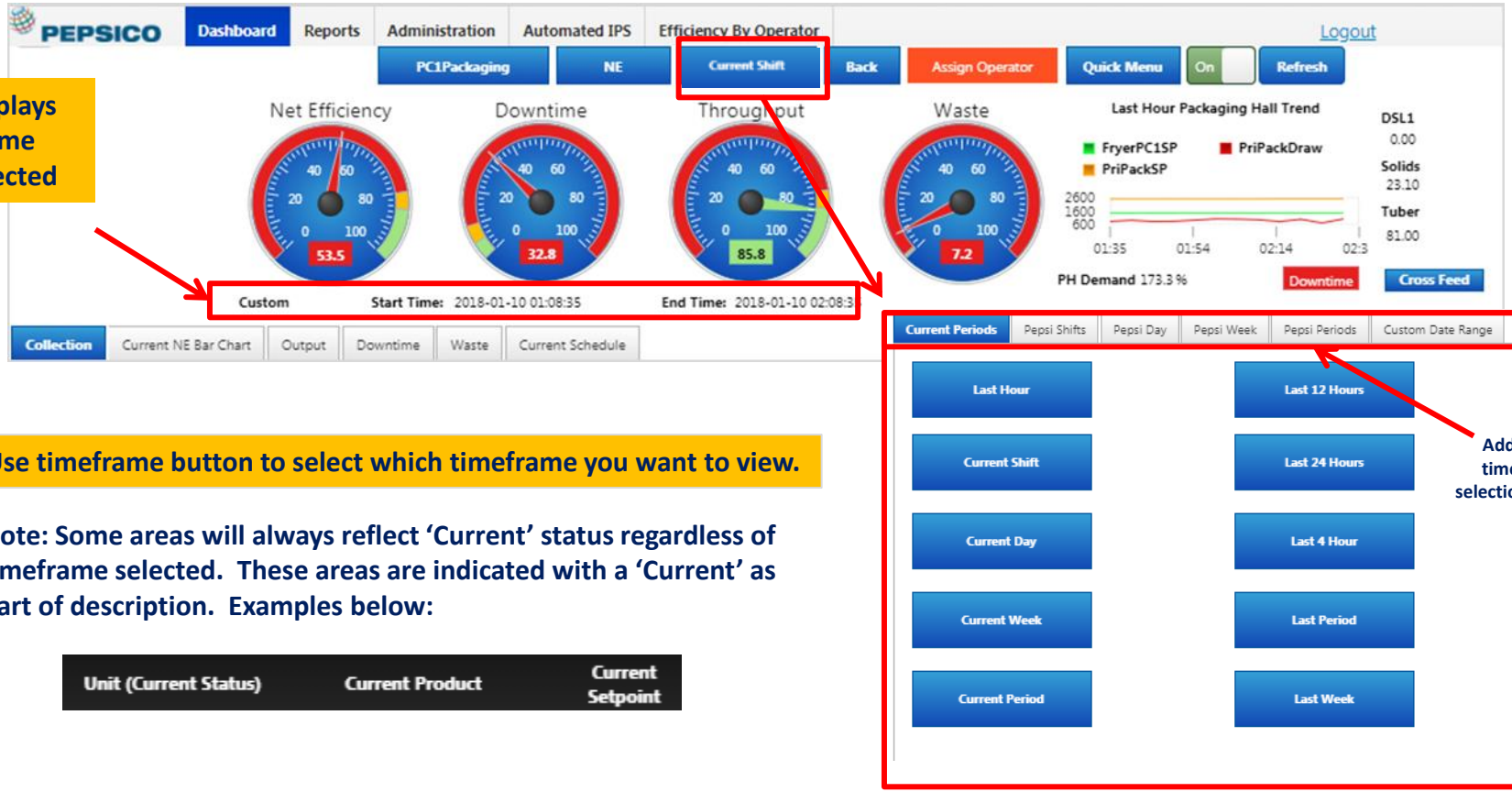


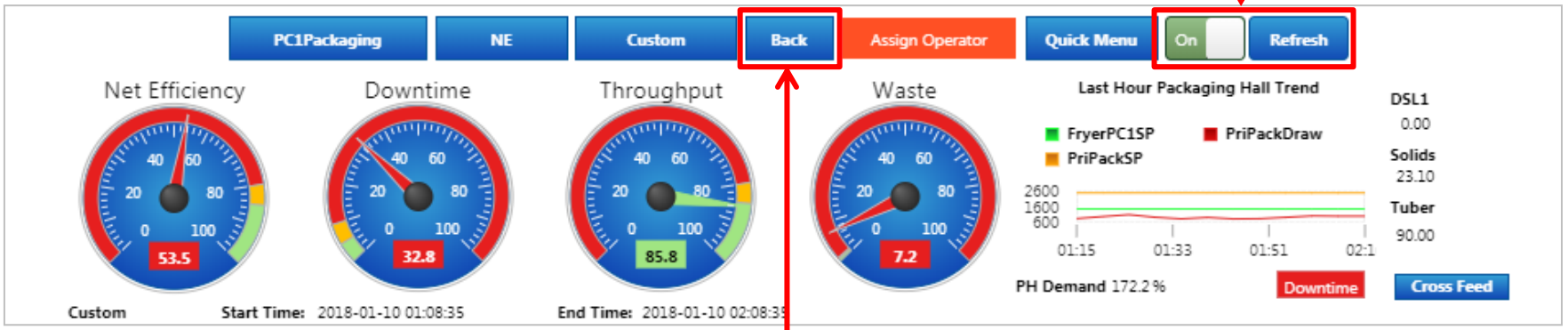
Use timeframe button to select which timeframe you want to view.

Note: Some areas will always reflect 'Current' status regardless of timeframe selected. These areas are indicated with a 'Current' as part of description. Examples below:

Unit (Current Status)	Current Product	Current Setpoint

Refreshing your data

Use Refresh button to refresh or update data.
Auto Refresh button can be enabled for timeframes up to one shift



Use Back button to return to previous screen. Recommendation is to use Back button vs. browser back button

Global Shop Floor Tools (Snacks MES)

Quick Menu for Entity, Timeframe, and KPI selection in one screen

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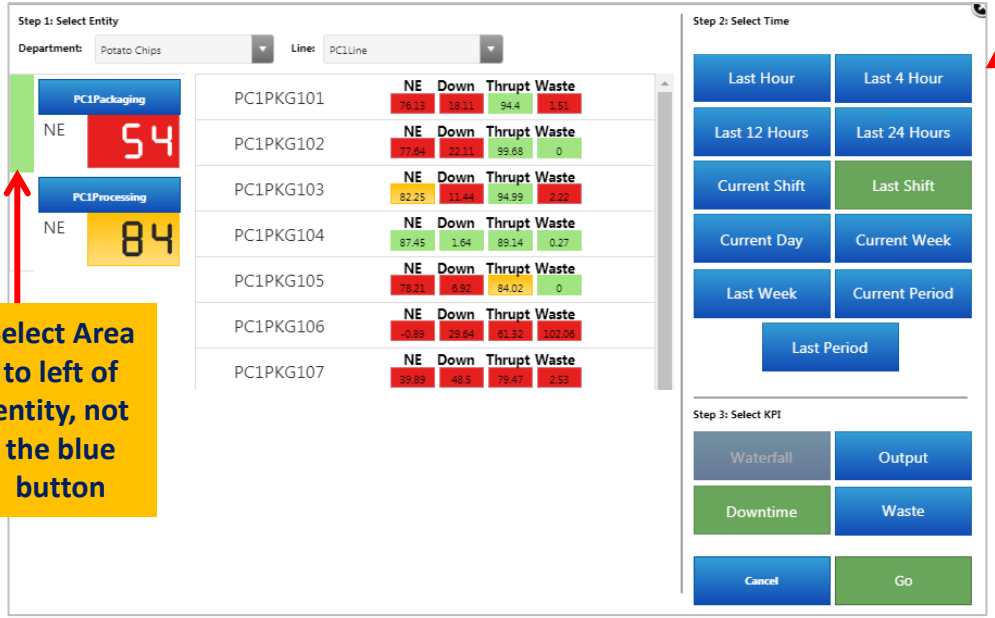
Use Quick Menu buttons to make Frequently used data selections



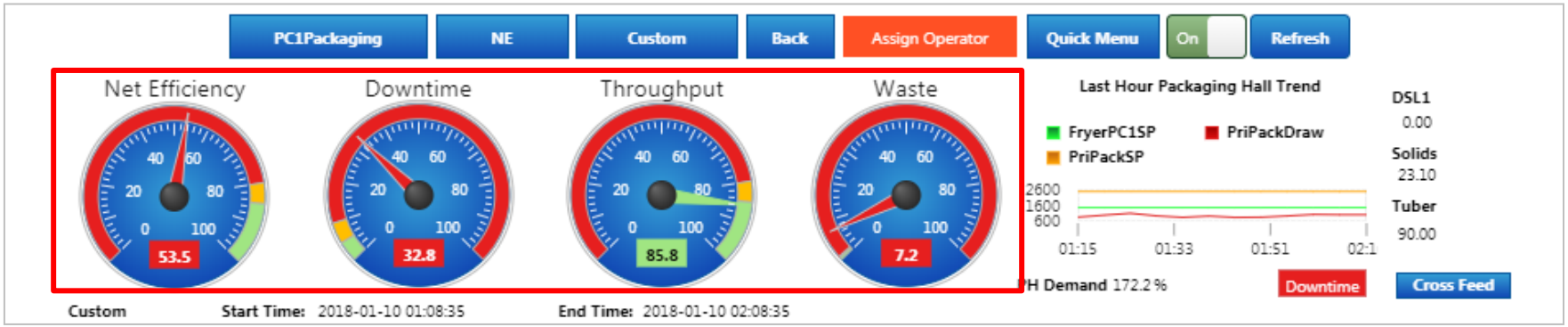
Select Area to left of entity, not the blue button

Step 1: Select Entity
Step 2: Select Time
Step 3: Select KPI
Step 4: Click GO

Button/area will turn green when selected

Global Shop Floor Tools (Snacks MES)

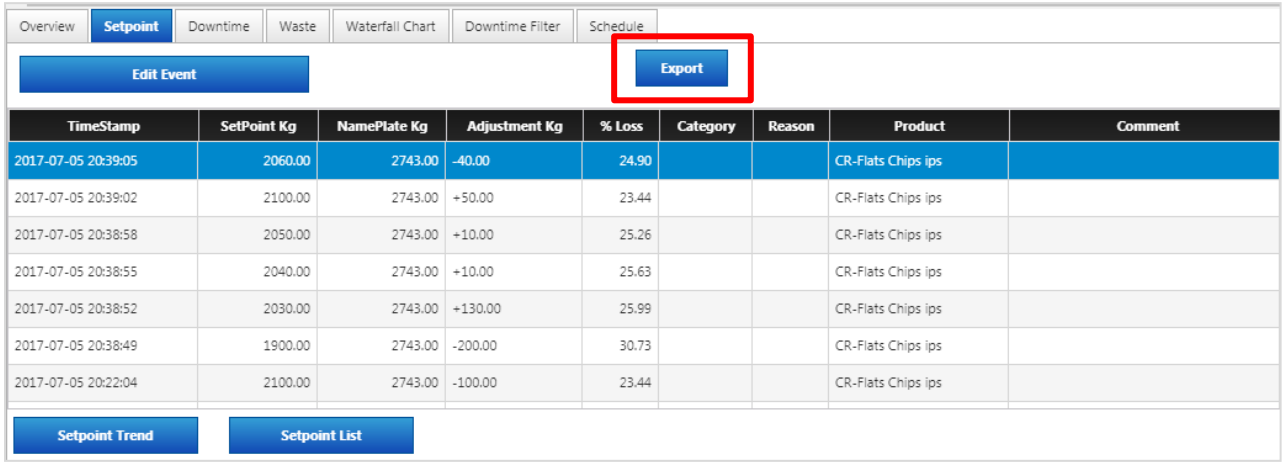
Real time performance Gauges for selected entities and date range



- **Downtime** – The percent of timeline or Unit is down and not available to run. Downtime can be categorized as Planned or Unplanned Downtime
- **Throughput** – The percent throughput vs. Manufacturer's Rated Speed. When a machine runs below its rated speed, the lost production is quantified as rate loss or slow running.
- **Waste –** The percent of throughput lost to quality defects

Exporting Data

- ‘Export’ Button allows data to be exported to CSV
- ‘Export’ Button available in selected screens in Dashboard



TimeStamp	SetPoint Kg	NamePlate Kg	Adjustment Kg	% Loss	Category	Reason	Product	Comment
2017-07-05 20:39:05	2060.00	2743.00	-40.00	24.90			CR-Flats Chips ips	
2017-07-05 20:39:02	2100.00	2743.00	+50.00	23.44			CR-Flats Chips ips	
2017-07-05 20:38:58	2050.00	2743.00	+10.00	25.26			CR-Flats Chips ips	
2017-07-05 20:38:55	2040.00	2743.00	+10.00	25.63			CR-Flats Chips ips	
2017-07-05 20:38:52	2030.00	2743.00	+130.00	25.99			CR-Flats Chips ips	
2017-07-05 20:38:49	1900.00	2743.00	-200.00	30.73			CR-Flats Chips ips	
2017-07-05 20:22:04	2100.00	2743.00	-100.00	23.44			CR-Flats Chips ips	

Packaging

Global Shop Floor Tools (Snacks MES)

Viewing Packaging Department Performance

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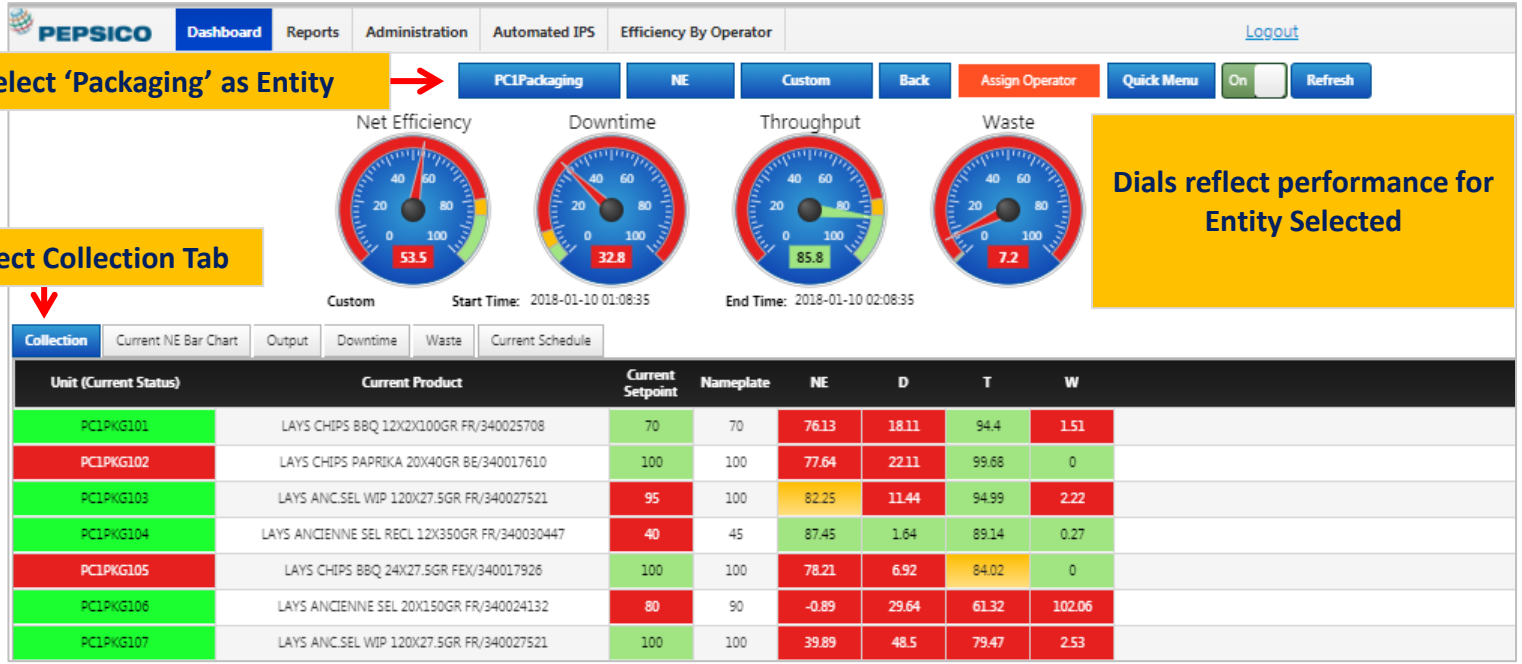
1. Select 'Packaging' as Entity

2. Select Collection Tab



Dials reflect performance for Entity Selected

Unit (Current Status)	Current Product	Current Setpoint	Nameplate	NE	D	T	W
PC1PKG101	LAYS CHIPS BBQ 12X2X100GR FR/340025708	70	70	76.13	18.11	94.4	1.51
PC1PKG102	LAYS CHIPS PAPRIKA 20X40GR BE/340017610	100	100	77.64	22.11	99.68	0
PC1PKG103	LAYS ANC.SEL WIP 120X27.5GR FR/340027521	95	100	82.25	11.44	94.99	2.22
PC1PKG104	LAYS ANCIENNE SEL RECL 12X350GR FR/340030447	40	45	87.45	1.64	89.14	0.27
PC1PKG105	LAYS CHIPS BBQ 24X27.5GR FEX/340017926	100	100	78.21	6.92	84.02	0
PC1PKG106	LAYS ANCIENNE SEL 20X150GR FR/340024132	80	90	-0.89	29.64	61.32	102.06
PC1PKG107	LAYS ANC.SEL WIP 120X27.5GR FR/340027521	100	100	39.89	48.5	79.47	2.53

3. Collection Tab shows the performance of entity selected. In this example, the Packaging Department PC1 has been selected which includes Packaging Units displayed. Click anywhere on the individual packaging station to drill down to individual station.

Global Shop Floor Tools (Snacks MES)

Viewing Packaging Unit Performance in Collection Tab

Unit (Current Status)	Current Product	Current Product Setpoint	NE	D	T	W
PC2PKG201	LAYS ANCIENNE SEL 15X300GR FR/340024174	40.0	47.20	38.81	77.95	1.048

Unit Status

REAL-TIME CURRENT

Green – Bagmaker Currently Running

PC2PKG201

Red – Bagmaker Currently Not Running (any reason)

PC1PKG103

Current Product by Bagmaker

LAYS ANCIENNE SEL 15X300GR FR/340024174

Current Setpoint – Current setpoint by Machine Operator

- **Green – Equipment Setpoint at or above nameplate for running product**
- **Red – Setpoint below nameplate rate defined for running product**

One Single Packaging Unit consists of:

1. Multihead Weigher
2. Bagmaker
3. CheckWeigher or Inspector
4. ACP

Unit Status

based on TIMEFRAME SELECTED

- **NE or TE**
- **D – Downtime at Unit Level**
- **T - Throughput at Unit Level**
- **W - Waste at Unit Level**

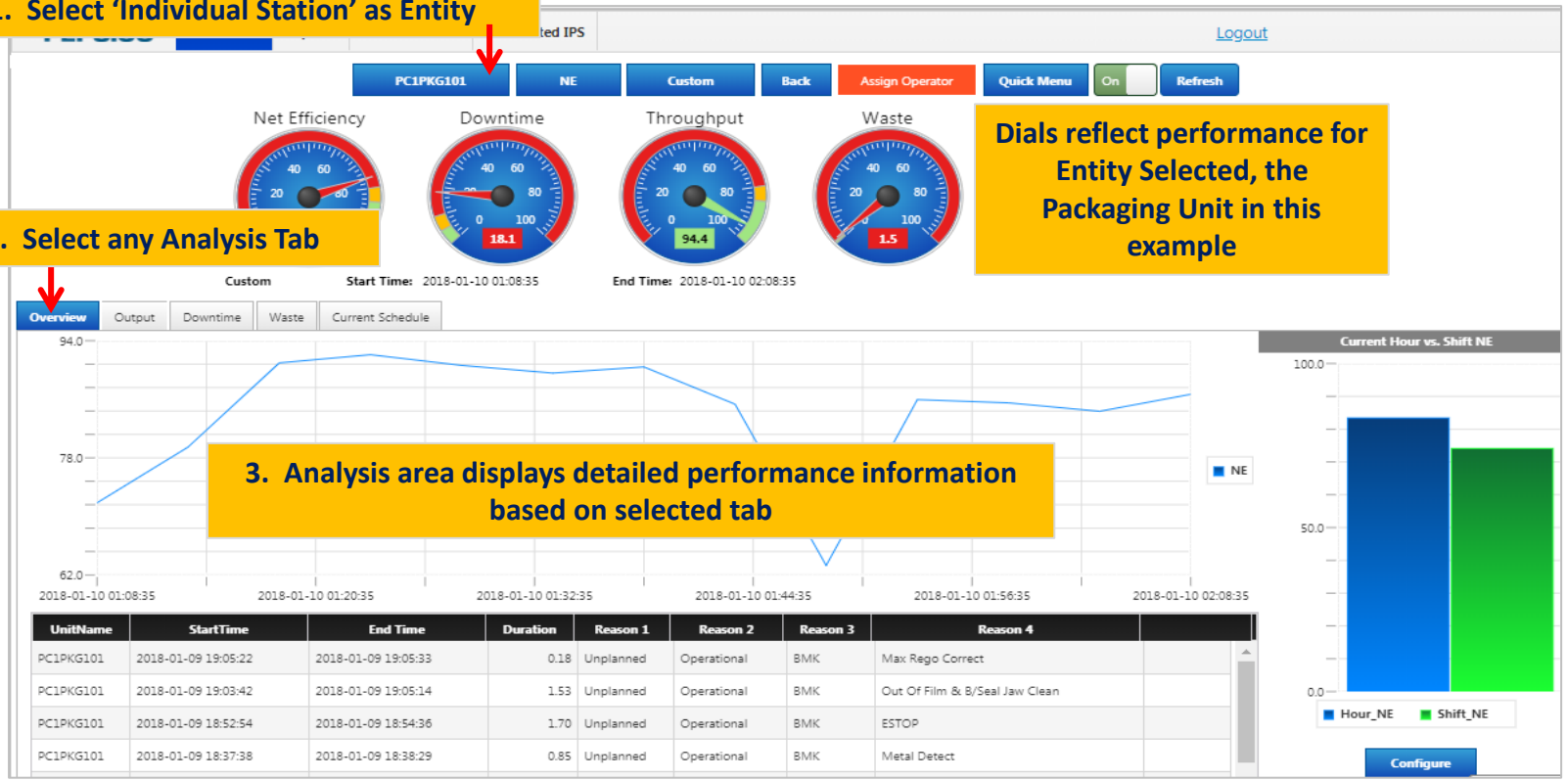
- **Green – At Goal or above**
- **Yellow – Between lower warning and Goal**
- **Red – Below Goal**

Global Shop Floor Tools (Snacks MES)

Viewing Packaging Unit Performance

1. Select 'Individual Station' as Entity

2. Select any Analysis Tab



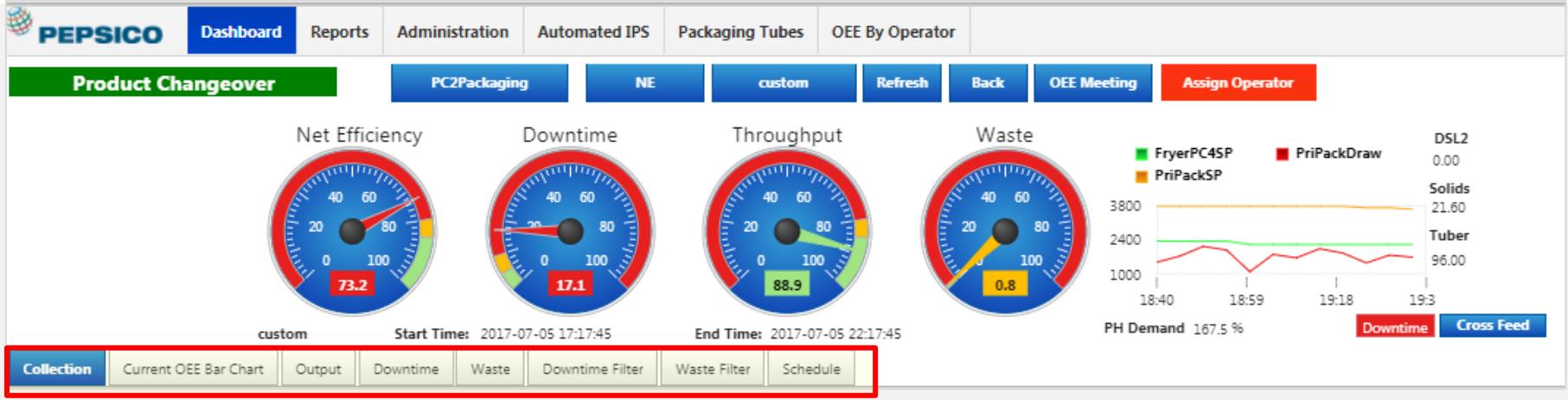
Dials reflect performance for Entity Selected, the Packaging Unit in this example

3. Analysis area displays detailed performance information based on selected tab

UnitName	StartTime	End Time	Duration	Reason 1	Reason 2	Reason 3	Reason 4
PC1PKG101	2018-01-09 19:05:22	2018-01-09 19:05:33	0.18	Unplanned	Operational	BMK	Max Rego Correct
PC1PKG101	2018-01-09 19:03:42	2018-01-09 19:05:14	1.53	Unplanned	Operational	BMK	Out Of Film & B/Seal Jaw Clean
PC1PKG101	2018-01-09 18:52:54	2018-01-09 18:54:36	1.70	Unplanned	Operational	BMK	ESTOP
PC1PKG101	2018-01-09 18:37:38	2018-01-09 18:38:29	0.85	Unplanned	Operational	BMK	Metal Detect

Global Shop Floor Tools (Snacks MES)

Packaging - Real time performance Gauges and Analysis Tabs



Packaging Performance Gauges

- NE, TE, AU
- Downtime
- Throughput
- Waste

Packaging Performance Tabs

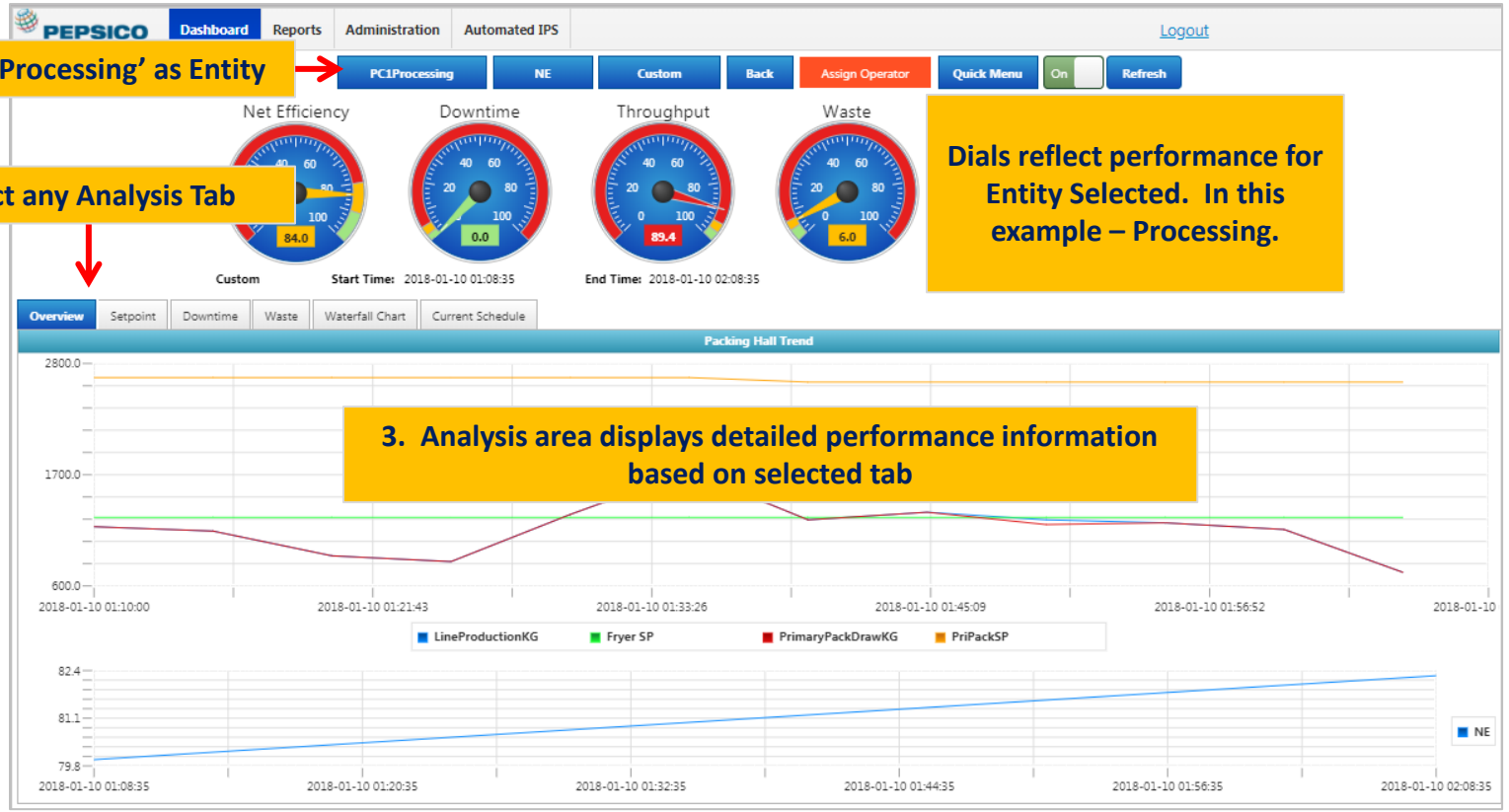
- **Collection** – Packaging Units Performance
- **Current OEE Bar Chart** – NE Hour & Shift
- **Output** - Production Trends
- **Downtime** – Downtime Events
- **Waste** – Waste Trends
- **Downtime Filter** – Downtime Events
- **Waste Filter** – Waste Trends
- **Schedule** – Make vs. Plan

Processing Mini-Trend

- Fryer Setpoint
- Packaging Setpoint
- Packaging Draw
- % Packaging Hall Demand
- Downtime ALERT Downtime
- Slowrunning ALERT Slowtime

Processing

Viewing Processing Performance



Global Shop Floor Tools (Snacks MES)

Processing - Real time performance Gauges and Analysis Tabs

Processing Performance Gauges

- NE, TE, AU
- Downtime
- Throughput
- Waste

Processing Performance Tabs

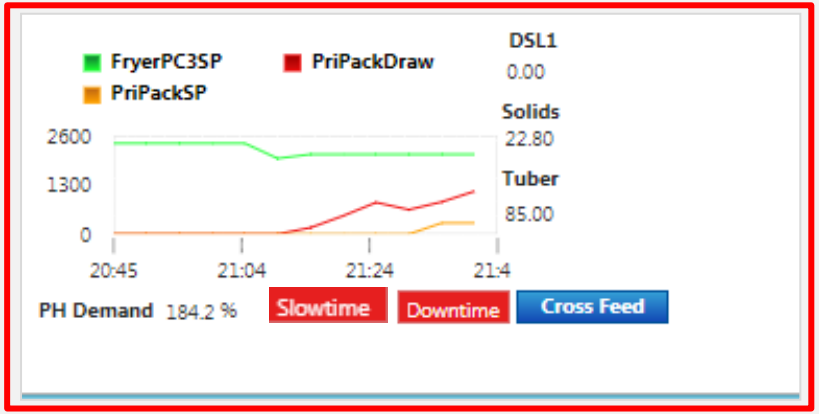
- **Overview** - Production Trends
- **Setpoint** – Setpoint Changes
- **Downtime** – Downtime Events
- **Waste** – Waste Detail
- **Waterfall Chart** – TE Losses
- **Downtime Filter** – Downtime Events
- **Schedule** – Make vs. Plan

Processing Mini-Trend

- Fryer Setpoint
- Packaging Setpoint
- Packaging Draw
- % Packaging Hall Demand
- Downtime ALERT Downtime
- Slowrunning ALERT Slowtime

Global Shop Floor Tools (Snacks MES)

Processing – Mini-Trend



PH Demand: This is Packing Hall Demand. It represents Packing Hall Set point capacity to keep up with Fryer Set Point.
It is a measure how well the Packaging department is keeping up with Fryer Set Point capacity. If the Fryer Output outstrips the current Set Point Capacity for PrimaryPack, the result will be waste with unpackaged chips falling to the floor. Packing Hall Demand would be monitored to ensure it does not drop below 120% of the Fryer output. This is also known as 'Over pull of the Fryer'.

Visibility is there on the Dashboard for both Processing and Packaging, because the information can be used to take proactive action in either or both areas, such as, slow down the fryer, bring up another packaging line, chase whether packaging can lift the set points, or otherwise improve packaging availability.

Processing Mini-Trend provides information for last 60 Minutes regardless of timeframe selected and can be viewed from Main Dashboard for both Processing and Packaging

- Fryer Setpoint FryerPC3SP
- Packaging Setpoint PriPackSP
- Packaging Draw PriPackDraw
- PH Demand: % Packaging Hall Demand
- Downtime ALERT
- Slowrunning ALERT

FRYER SP	2700
PRIPACK SP	2310
PACKING HALL DEMAND	85.6%
Calculation PH Demand = PRIPACK SP/ FRYER SP * 100	

Global Shop Floor Tools (Snacks MES)

KPIs - Data Source and Collection Method

PEPSICO GLOBAL OPERATIONS

KPI Gauge	Line Level	Processing Line	Packaging Department	Packaging Unit
NE/TE	Line Efficiency Automated	Fryer Efficiency Automated	Based on Sum of Dept. Bagmaker Efficiencies Automated	Based on Individual Bagmaker Efficiency Automated
Downtime	Based on Fryer Downtime Semi Automated	Based on Fryer Downtime Semi Automated	Based on Sum of Dept. Bagmaker Downtimes Automated	Based on Individual Bagmaker Downtime Automated
Throughput	Based on Packaging Dept. Output (Total Cases Produced converted to base weight) Semi Automated	Based on Fryer Output Semi Automated	Based on Sum of Dept. Bagmaker Outputs Automated	Based on Individual Bagmaker Output Automated
Waste	Based on Multiple Waste Locations Manual	Based on Multiple Waste Locations Manual	Based on Sum of Dept. Inspector or Checkweigher Rejects Automated	Based on Inspector or Checkweigher Rejects Automated

Automated – No Manual intervention (Full Data from PLC)
Semi Automated - Requires manual updates
Manual – Requires manual entry

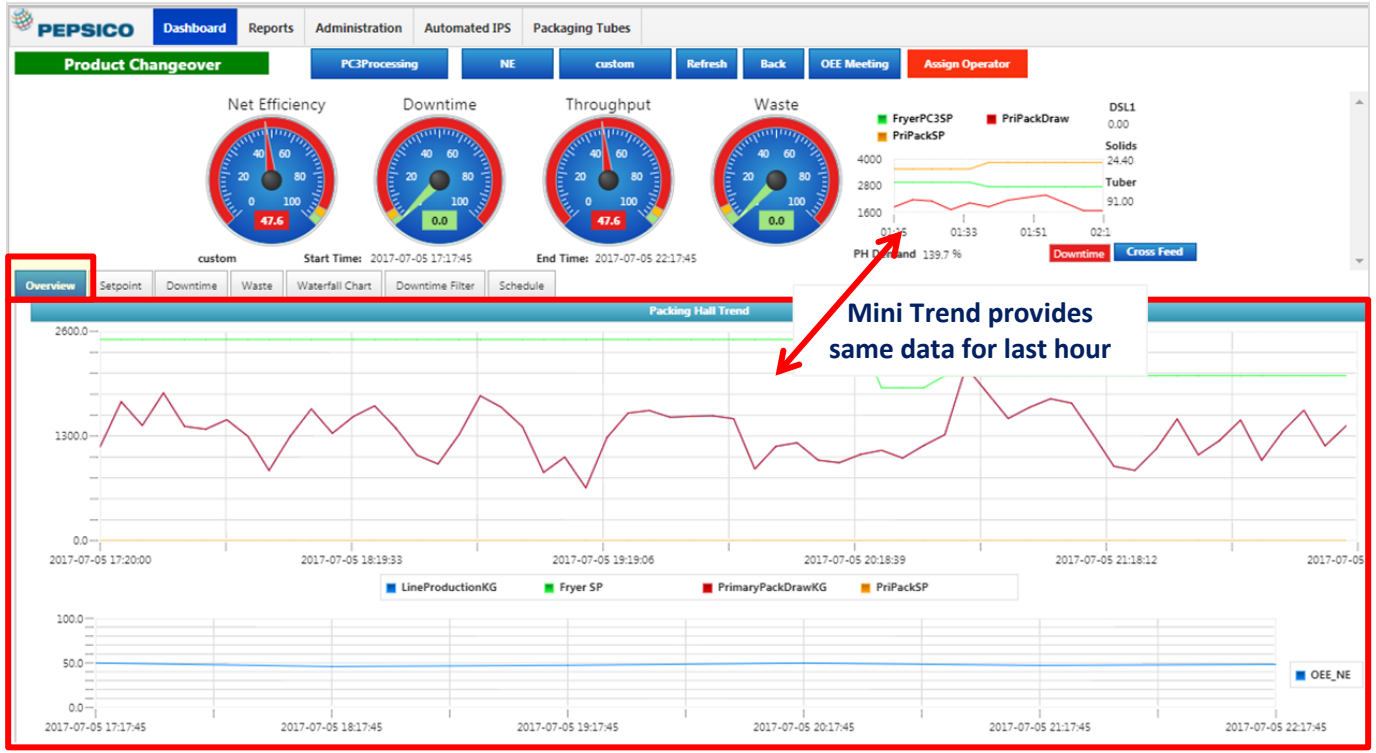
Note: Packaging Dept includes all Packaging Machines in selected Packaging Bank regardless of fryer assignment

Performance Trends

Performance Trends Processing

Global Shop Floor Tools (Snacks MES)

Processing – Overview Tab



- **Gauges display performance for <u>Entire Processing Line</u>**
- **Blue Line – Line Production KG**
  - LineProductionKG
- **Green Line – Fryer Setpoint KG**
  - Fryer SP
- **Red Line – Packaging Draw KG**
  - PrimaryPackDrawKG
- **Yellow Line – Packaging Setpoint KG**
  - PriPackSP
- **Blue Line - NE**
  - OEE_NE

- **Hover over line to see the details of that point**
- **Line Production KG = Packaging Draw KG + Waste Events; unless there a waste event, the blue line will be behind red line**

Processing – Setpoint Tab

- Trend of Nameplate calculation (solids based), and the operator entered Setpoint

- Event record of every operator setpoint change.
- Use the Setpoint List button to input reasons

Overview | **Setpoint** | Downtime | Waste | Waterfall Chart | Downtime Filter | Schedule

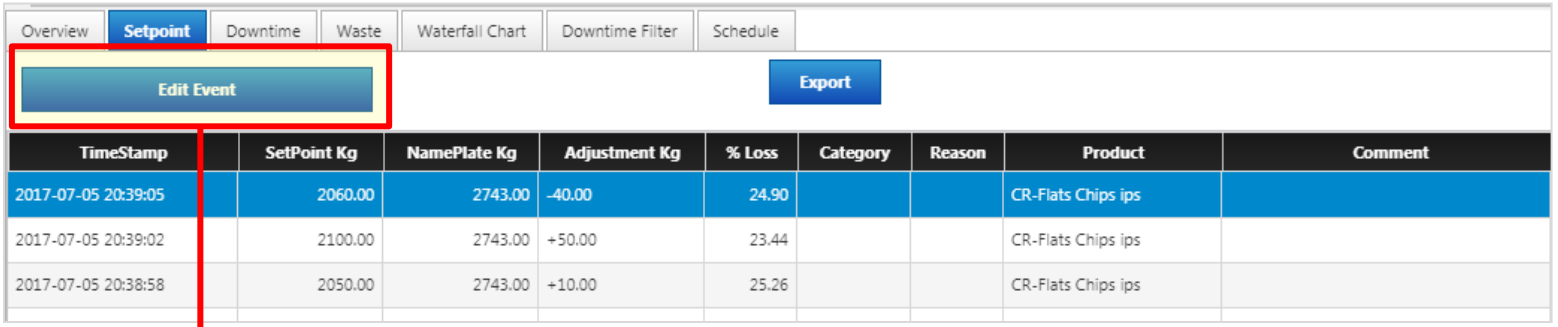
Edit Event **Export**

TimeStamp	SetPoint Kg	NamePlate Kg	Adjustment Kg	% Loss	Category	Reason	Product	Comment
2017-07-05 20:39:05	2060.00	2743.00	-40.00	24.90			CR-Flats Chips ips	
2017-07-05 20:39:02	2100.00	2743.00	+50.00	23.44			CR-Flats Chips ips	
2017-07-05 20:38:58	2050.00	2743.00	+10.00	25.26			CR-Flats Chips ips	
2017-07-05 20:38:55	2040.00	2743.00	+10.00	25.63			CR-Flats Chips ips	
2017-07-05 20:38:52	2030.00	2743.00	+130.00	25.99			CR-Flats Chips ips	
2017-07-05 20:38:49	1900.00	2743.00	-200.00	30.73			CR-Flats Chips ips	
2017-07-05 20:22:04	2100.00	2743.00	-100.00	23.44			CR-Flats Chips ips	

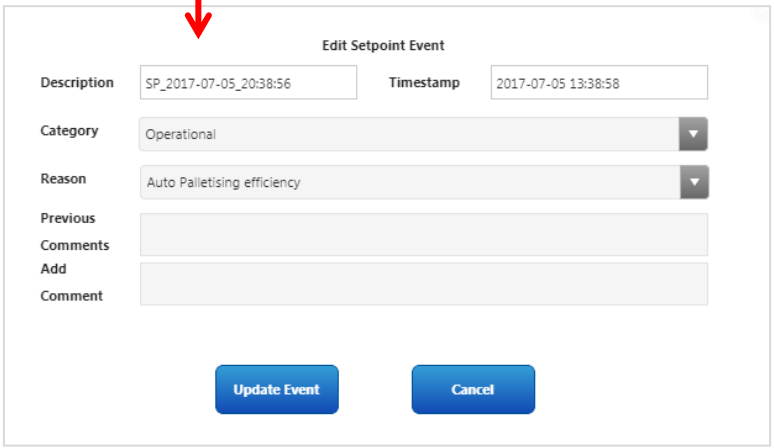
Setpoint Trend **Setpoint List**

Global Shop Floor Tools (Snacks MES)

Processing – Entering Setpoint Change Reasons



TimeStamp	SetPoint Kg	NamePlate Kg	Adjustment Kg	% Loss	Category	Reason	Product	Comment
2017-07-05 20:39:05	2060.00	2743.00	-40.00	24.90			CR-Flats Chips ips	
2017-07-05 20:39:02	2100.00	2743.00	+50.00	23.44			CR-Flats Chips ips	
2017-07-05 20:38:58	2050.00	2743.00	+10.00	25.26			CR-Flats Chips ips	

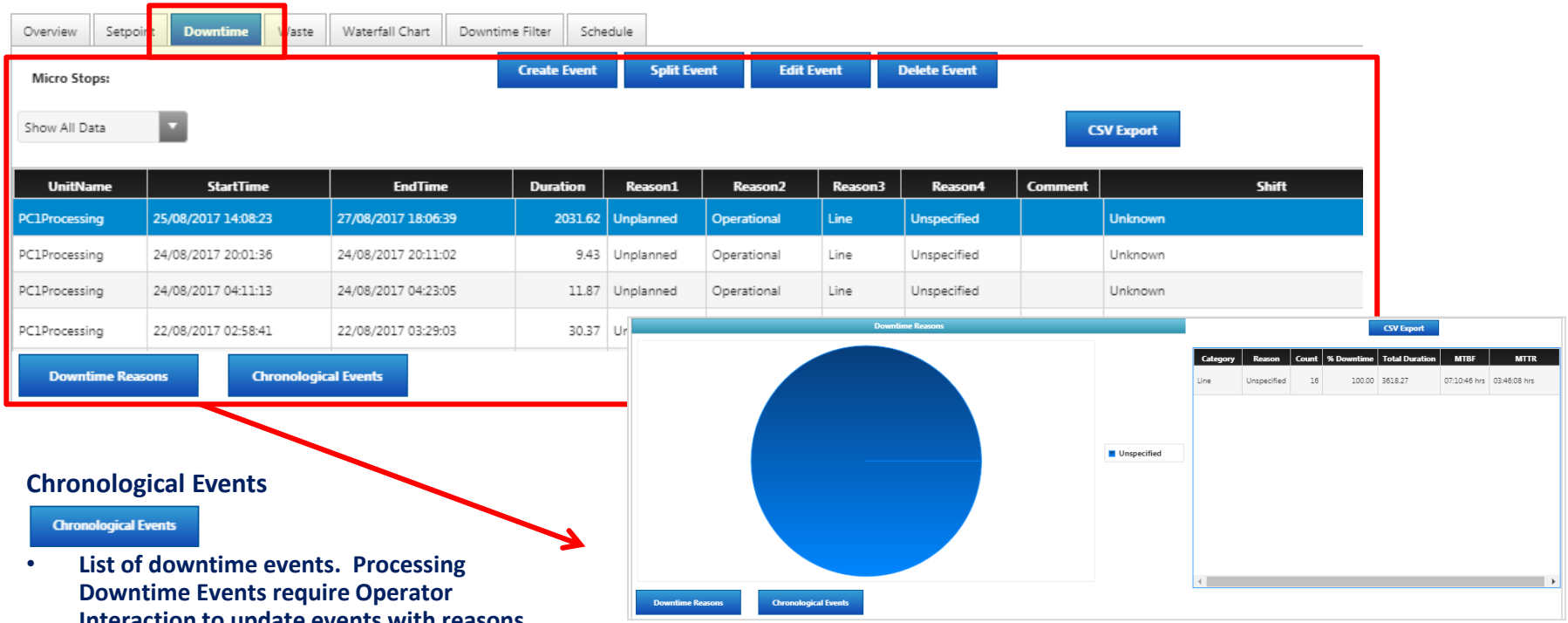


1. Select the Event to edit – Selecting will highlight event in blue
2. Select Edit Event button 

3. Enter
   a. Category
   b. Reason
   c. Comments as needed
4. Select Update Event

Global Shop Floor Tools (Snacks MES)

Processing – Downtime Tab



Chronological Events

Chronological Events

- List of downtime events. Processing Downtime Events require Operator Interaction to update events with reasons and comments
- Select an individual row to Edit or Split an event
- Data can be filtered to exclude events based on duration

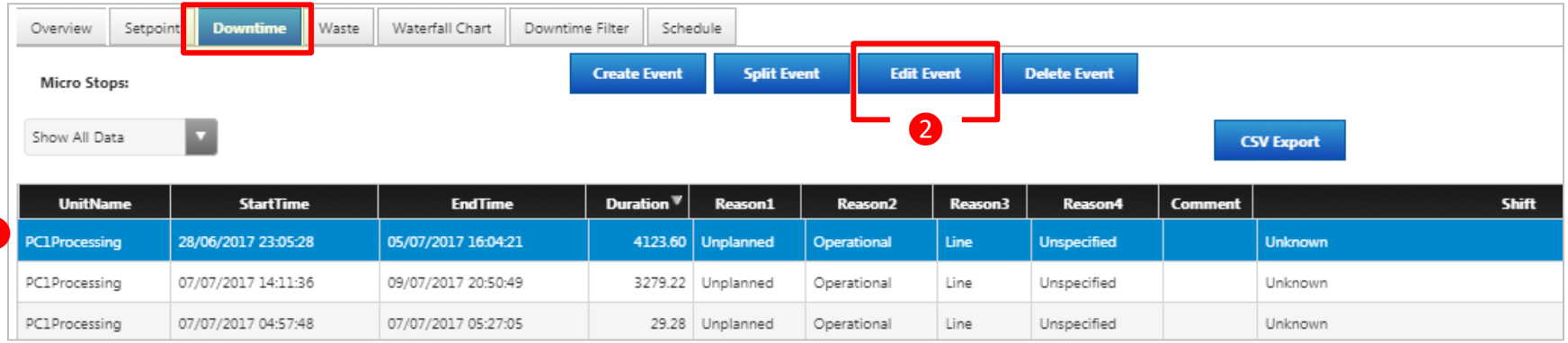
Downtime Reasons

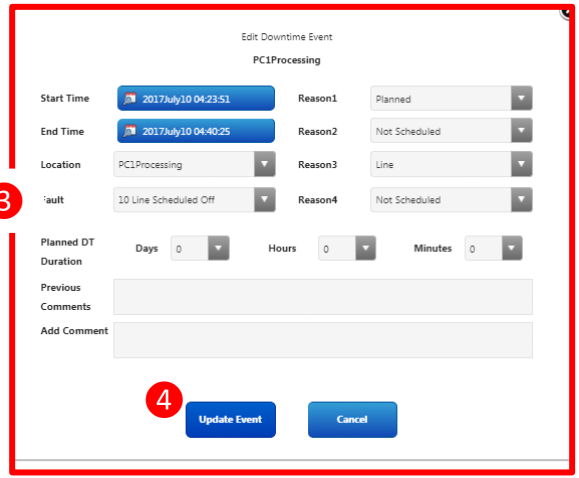
Downtime Reasons

- Downtime Reasons button switches display for graphical analysis
- Table displays Reason, Count, Duration, MTTF and MTTR

Processing or Packaging
Editing a Downtime Event from Downtime Tab

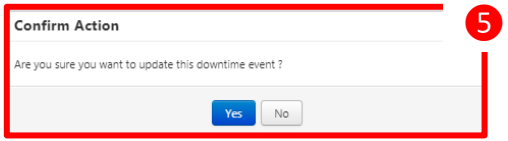
PEPSICO GLOBAL OPERATIONS





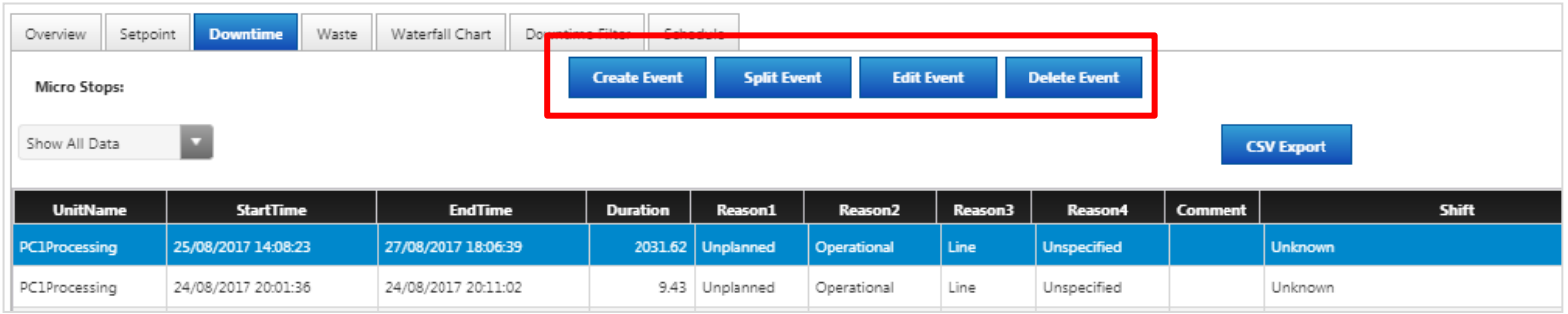
User Privileges may be required to Edit a Downtime Events

1. Select the event to edit. Selecting will highlight event in BLUE
2. Select Edit Event button
3. Update Fault and Reasons if necessary
   a) Dark Hours, Planned Downtime, Unplanned + additional Reasons
   b) Confirm Start/End Time
4. Select Update Event to make Save
5. Confirm Action

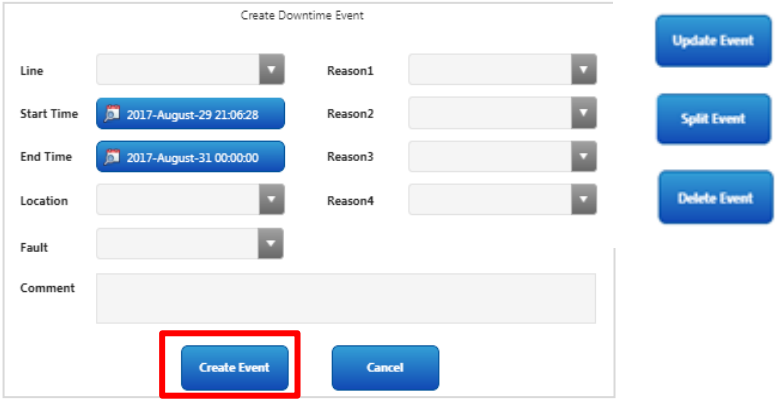


Processing or Packaging
Creating, Splitting or Deleting a Downtime Event

PEPSICO GLOBAL OPERATIONS

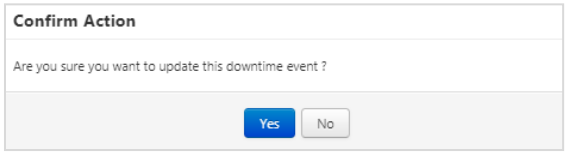


UnitName	StartTime	EndTime	Duration	Reason1	Reason2	Reason3	Reason4	Comment	Shift
PC1Processing	25/08/2017 14:08:23	27/08/2017 18:06:39	2031.62	Unplanned	Operational	Line	Unspecified		Unknown
PC1Processing	24/08/2017 20:01:36	24/08/2017 20:11:02	9.43	Unplanned	Operational	Line	Unspecified		Unknown

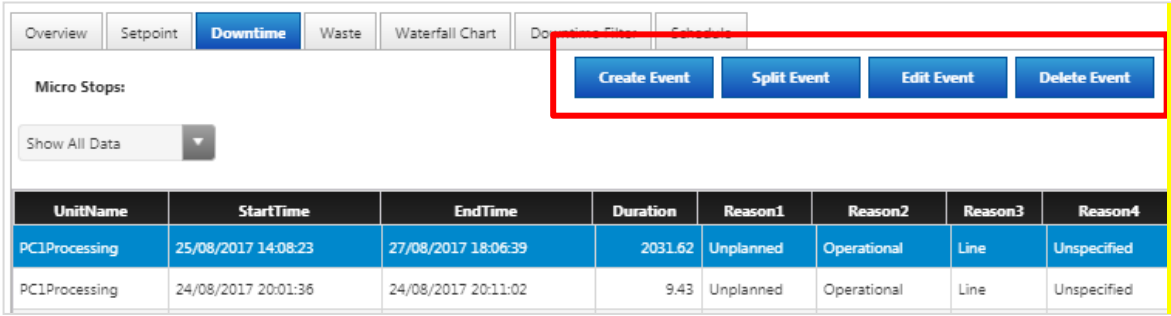


User Privileges required to Create/Edit/Split or Delete Events

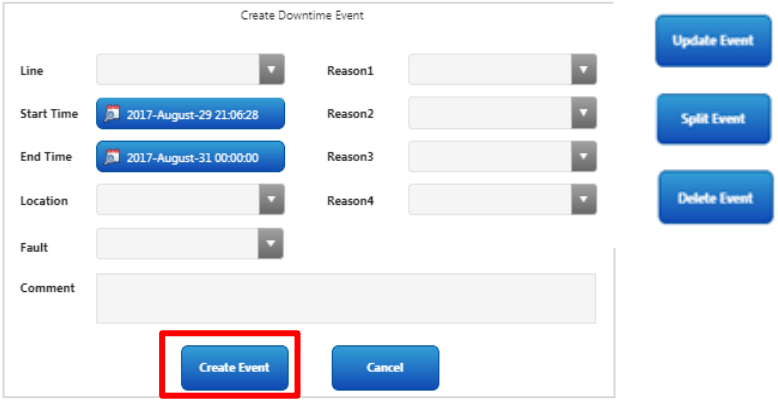
1. Select the event to edit. Selecting will highlight event in blue
2. Select appropriate Create, Split or Delete Event button
3. Update fields as needed
   a) Confirm Start/End Time
4. Select Create, Edit, Split, or Delete Event to make save
5. Confirm Action



Processing or Packaging
Creating, Splitting or Deleting a Downtime Event

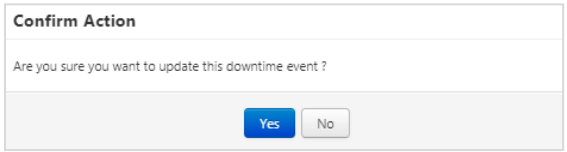


Downtime Duration functionality.
Once a downtime event has started, they can set the Planned Downtime Duration for the existing event.
The system will monitor when the event closes and set the event accordingly.
If the event actually closes after the Planned Downtime Duration, it will split the event for Planned Downtime for the Planned Duration and Overrun for the time after the Planned Duration.



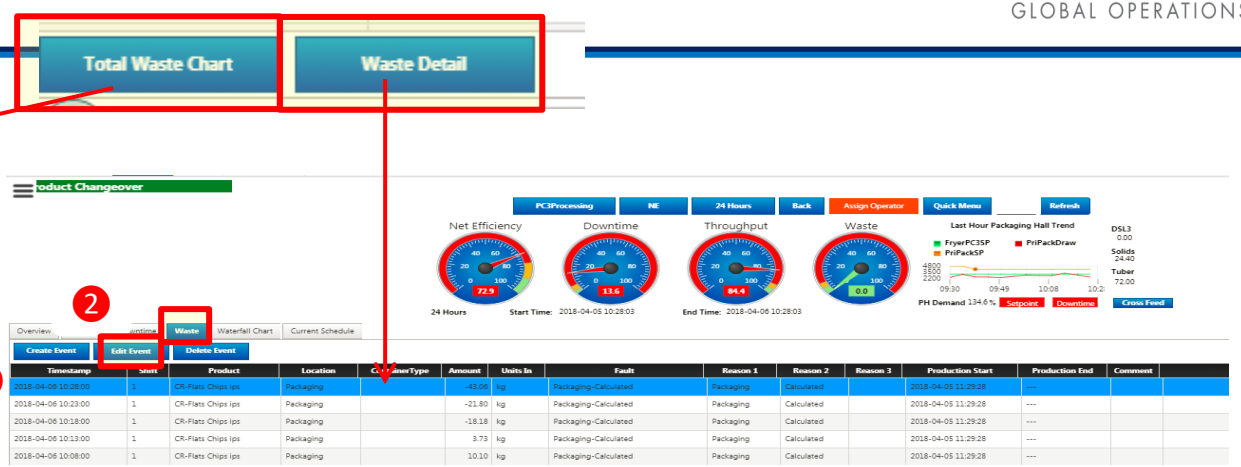
User Privileges required to Create/Edit/Split or Delete Events

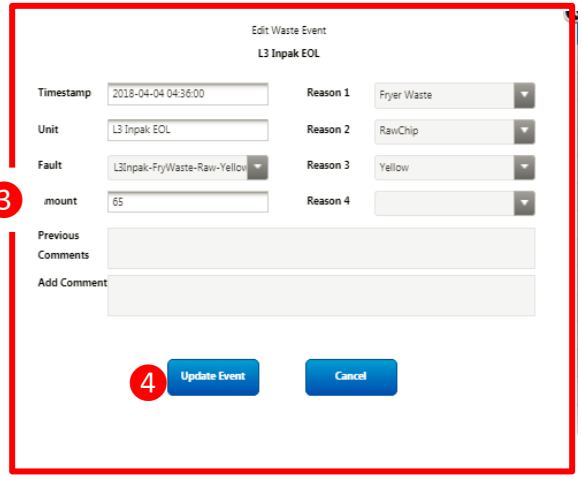
1. Select the event to edit. Selecting will highlight event in blue
2. Select appropriate Create, Split or Delete Event button
3. Update fields as needed
    a) Confirm Start/End Time
4. Select Create, Edit, Split, or Delete Event to make save
5. Confirm Action



Global Shop Floor Tools (Snacks MES)

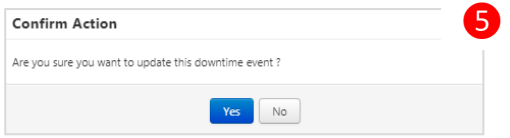
Processing – Waste Tab





User Privileges may be required to Edit a Waste Events

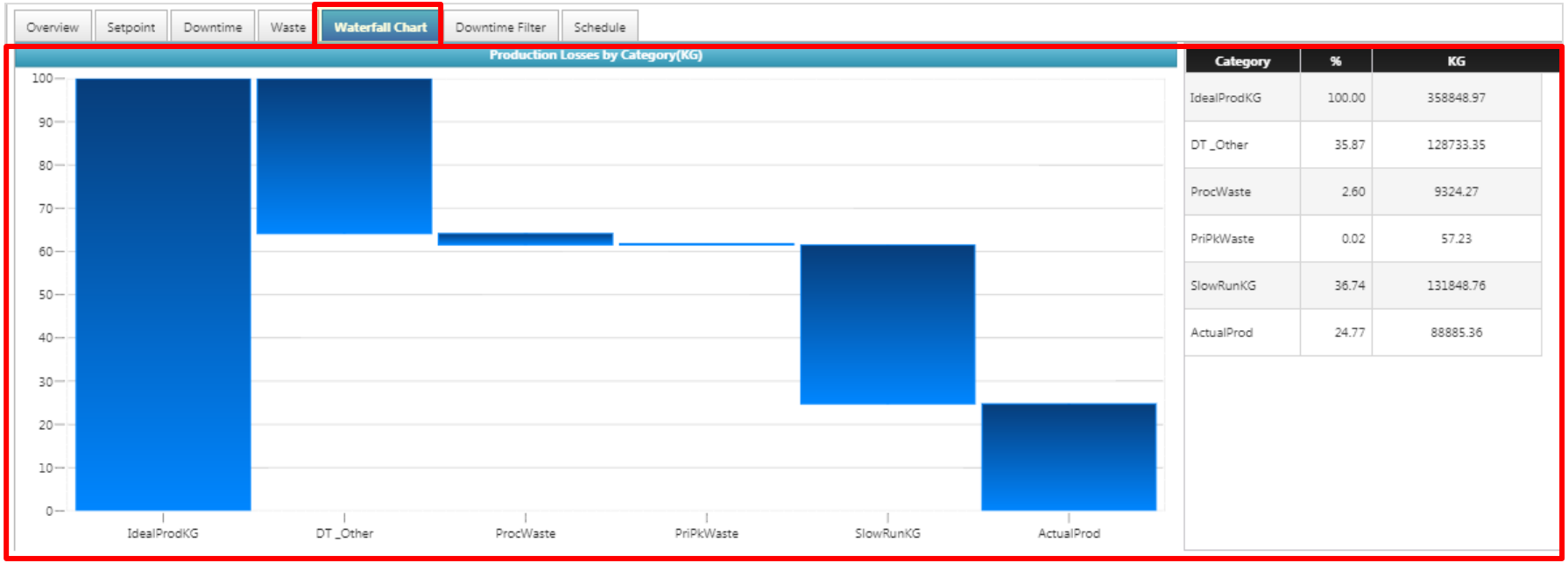
1. Select the event to edit. Selecting will highlight event in BLUE
2. Select Edit Event button
3. Check reason 1,2,3 and add comments if necessary
4. Select Update Event to make Save
5. Confirm Action



Global Shop Floor Tools (Snacks MES)

Processing – Waterfall Chart Tab

- Ideal Production – Left bar
- Good Cases Produced – Right bar
- Percent Loss by Category
- Table to the right of the chart
- Percent values for each Loss Category
- Case impact for each Loss Category



Category	%	KG
IdealProdKG	100.00	358848.97
DT _Other	35.87	128733.35
ProcWaste	2.60	9324.27
PriPkWaste	0.02	57.23
SlowRunKG	36.74	131848.76
ActualProd	24.77	88885.36

PEPSICO
GLOBAL OPERATIONS

Performance Trends
Packaging DEPARTMENT

Global Shop Floor Tools (Snacks MES)

Packaging Department – Collection Tab

Drill down to an individual Packaging Unit by clicking on Unit

- **Gauges display performance for <u>Entire Department</u>**
- **Collection Tab displays performance of each Packaging Unit in that department**
- **Individual Units displayed in:**
  - **Green** – Running
  - **Red** – Stopped
- **KPI Background color:**
  - **Red** – KPI value falls below lower reject spec value
  - **Amber** – KPI value falls between lower reject and lower warning spec value
  - **Green** – KPI value falls above to target spec value
- **Setpoint:**
  - **Red** – Equipment setpoint below product name plate
  - **Green** - Equipment setpoint equal or above product name plate

Global Shop Floor Tools (Snacks MES)

Packaging UNIT – Collection Tab

PEPSICO GLOBAL OPERATIONS

Bagmaker Status REAL-TIME CURRENT

Green – Bagmaker Currently Running

PC1PKG101

Red – Bagmaker Currently Not Running (any reason)

PC1PKG103

Active Product by Bagmaker

LAYS CH.SALT&VINEGAR 9X2X130GR FR/340026605

Setpoint – Current setpoint by Machine Operator

- **Green – Equipment Setpoint at or above nameplate for running product**
- **Red – Setpoint below nameplate rate defined for running product**

Bagmaker Status based on TIMEFRAME SELECTED

- **NE or TE**
- **Downtime – Unit Level**
- **Throughput – Unit Level**
- **Waste – Unit Level**

- **Green – At Goal or above**
- **Yellow – Between lower warning and Goal**
- **Red – Below Goal**

One Single Packaging Unit consists of:

1. Multihead Weigher
2. Bagmaker,
3. CheckWeigher or Inspector
4. ACP

Global Shop Floor Tools (Snacks MES)

Packaging UNIT – Collection Tab

PEPSICO GLOBAL OPERATIONS

Unit (Current Status)	Current Product	Current Product Setpoint	NE	D	T	W
PC2PKG201	LAYS ANCIENNE SEL 15X300GR FR/340024174	40.0	47.20	38.81	77.95	1.048

Unit Status

REAL-TIME CURRENT

Green – Bagmaker Currently Running

PC1PKG101

Red – Bagmaker Currently Not Running (any reason)

PC1PKG103

Current Product by Bagmaker

LAYS CH.SALT&VINEGAR 9X2X130GR FR/340026605

Current Setpoint – Current setpoint by Machine Operator

- **Green – Equipment Setpoint at or above nameplate for running product**
- **Red – Setpoint below nameplate rate defined for running product**

One Single Packaging Unit consists of:

1. Multihead Weigher
2. Bagmaker
3. CheckWeigher or Inspector
4. ACP

Unit Status

based on TIMEFRAME SELECTED

- **NE or TE**
- **D – Downtime at Unit Level**
- **T - Throughput at Unit Level**
- **W - Waste at Unit Level**

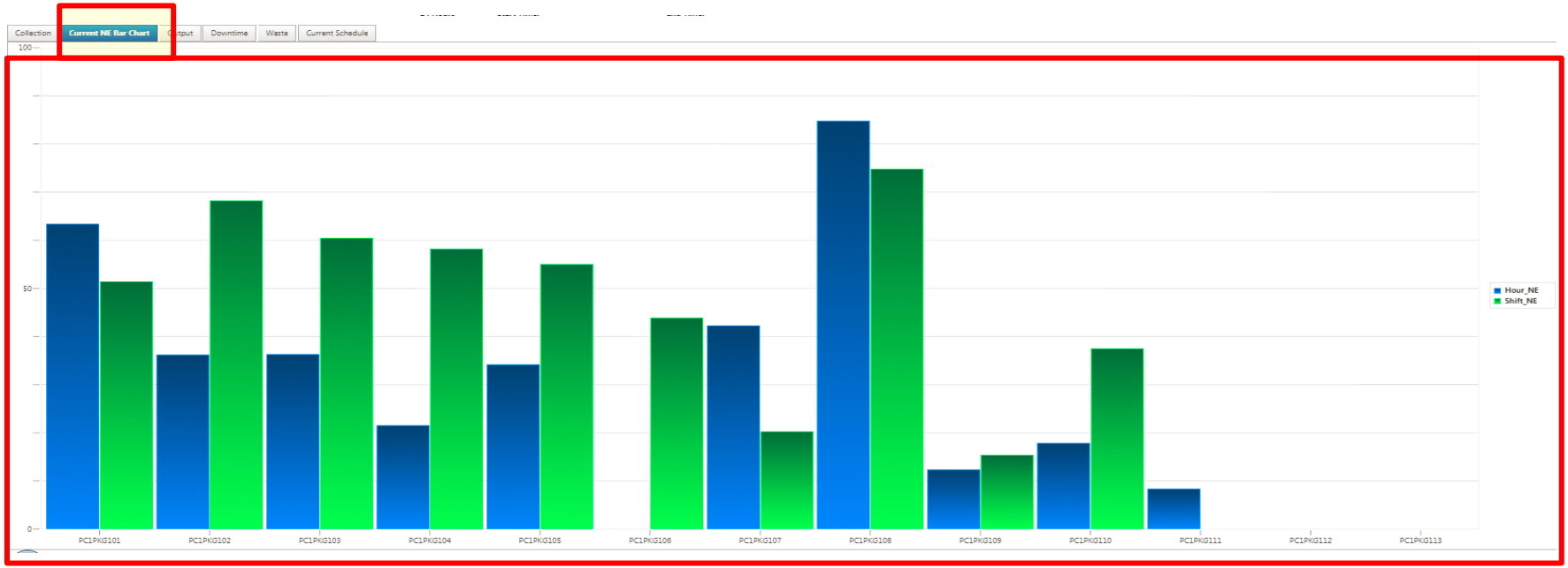
- **Green – At Goal or above**
- **Yellow – Between lower warning and Goal**
- **Red – Below Goal**

Packaging Department – Current OEE Bar Chart Tab

PEPSICO GLOBAL OPERATIONS

NE OEE% for each unit (zone or station) – Metric displayed is always NE

- Blue = performance over the last hour
- Green = performance for shift so far

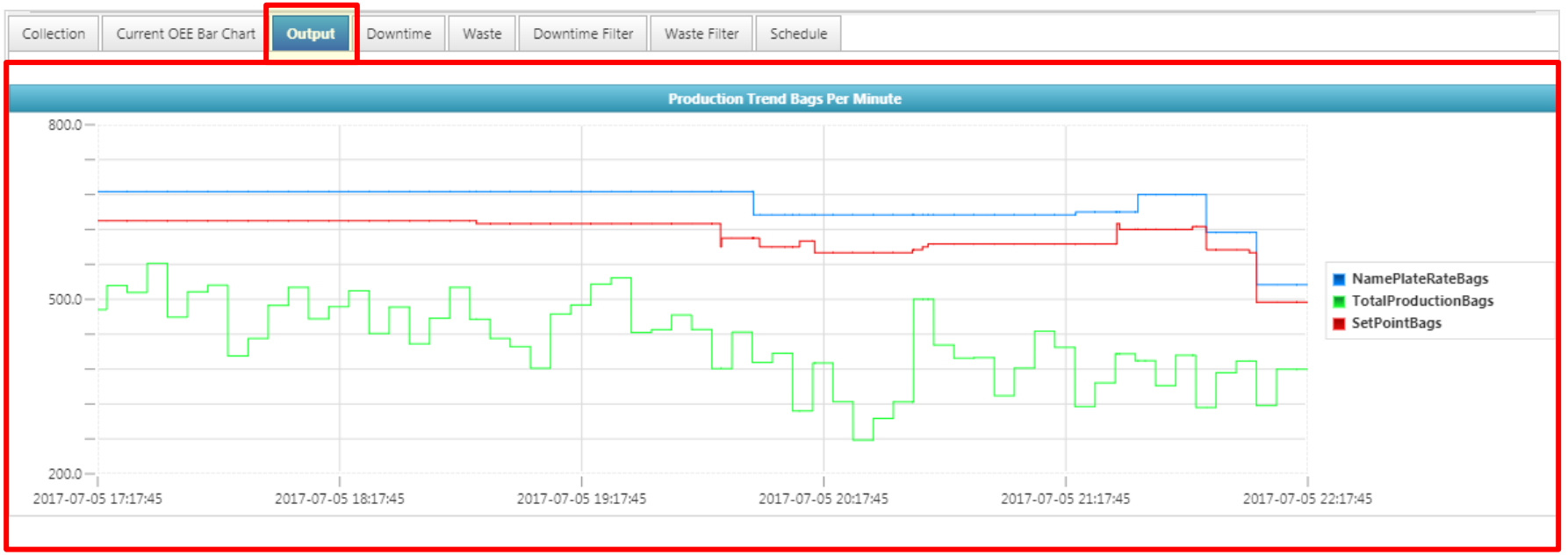


Packaging Department – Output Tab

Production Trend Bags per Minute

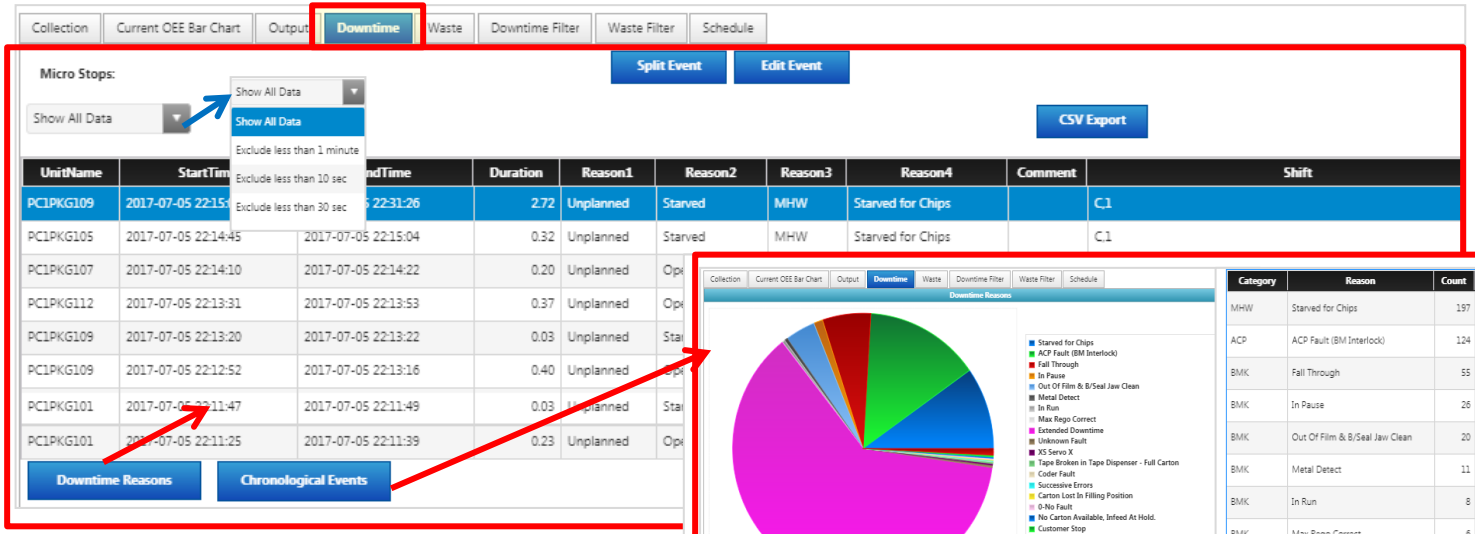
- Blue – Nameplate Rate Bags
- Green – Total Production Bags
- Red – Machine Operator Setpoint Bags

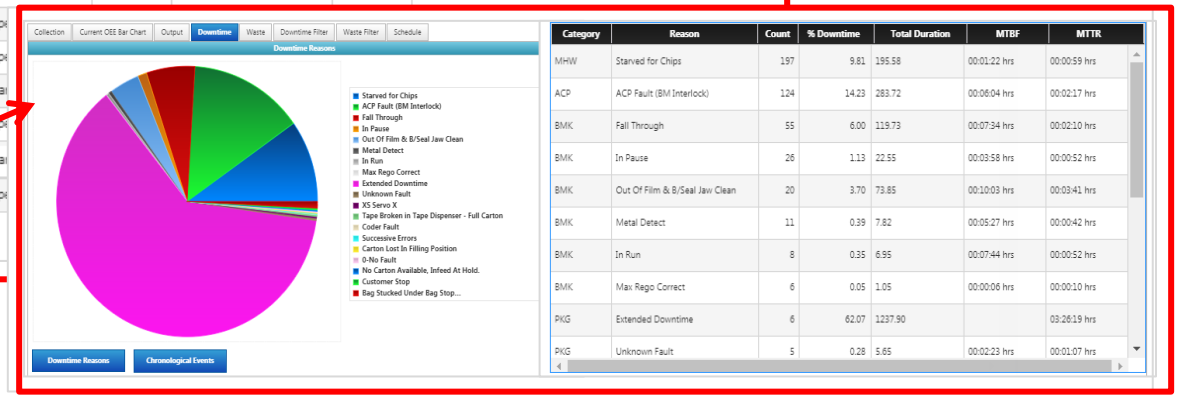
If looking at Entire Packaging Department, this number would be SUM of all Bagmakers for selected reporting timeframe



Global Shop Floor Tools (Snacks MES)

Packaging Department – Downtime Tab





Chronological Events

Chronological Events

- List of downtime events with automatic reasons populated (where available).
- Select an individual row to Edit or Split an event
- Data can be filtered to exclude events based on duration

Downtime Reasons

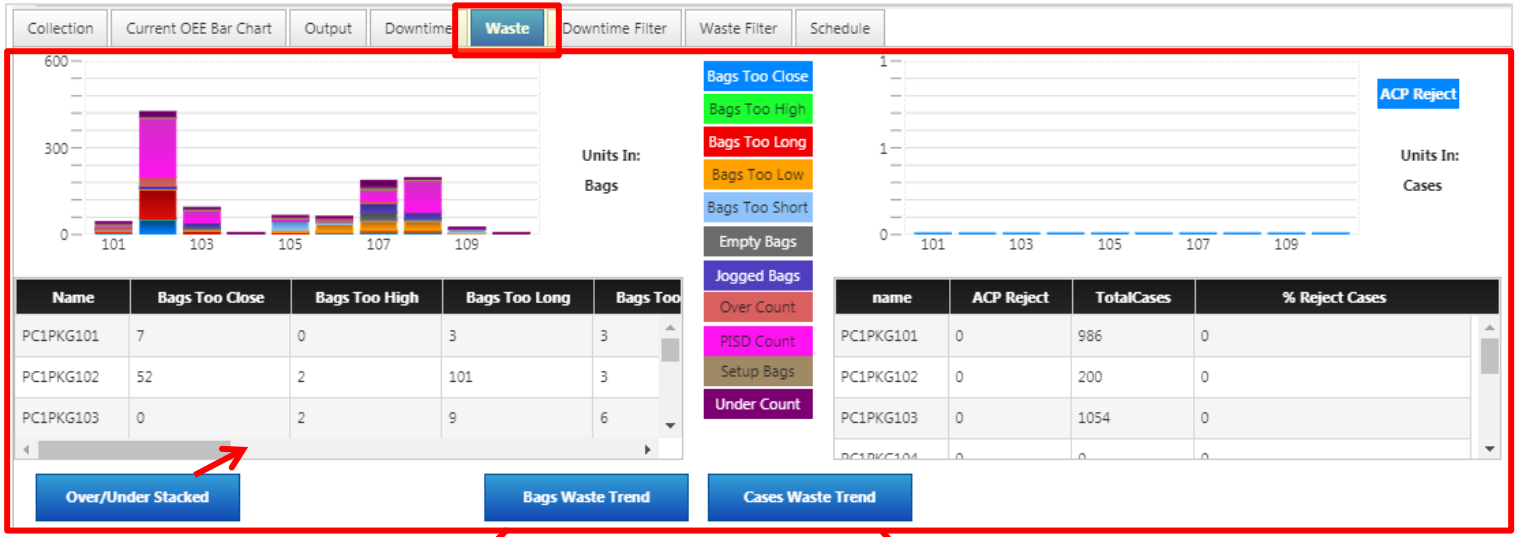
Downtime Reasons

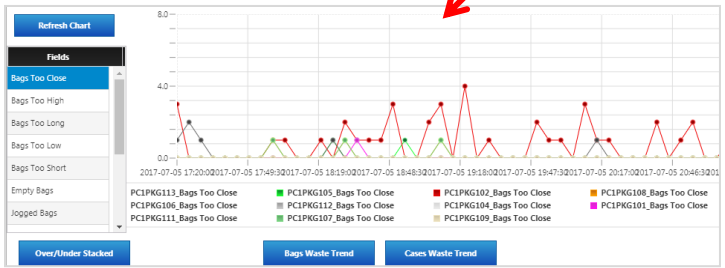
- Downtime Reasons button switches display for graphical analysis
- Table displays Reason, Count, Duration, MTTF and MTTR

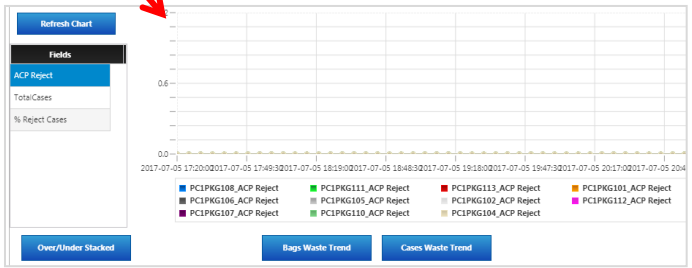
Global Shop Floor Tools (Snacks MES)

Packaging Department – Waste Tab

PEPSICO GLOBAL OPERATIONS







Over/Under Stacked

Stacked bar chart for each unit showing waste by category

Bags Waste Trend

Cases Waste Trend

Waste Trend button switches display for trend analysis view

Global Shop Floor Tools (Snacks MES)

Packaging Department – Downtime Event Details

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Table to the right provides details on Downtime Event Header

KPI	Downtime
Line Level	Based on Fryer Downtime
Processing Entity	Based on Fryer Downtime
Packaging Entity (Single Unit)	Based on Individual Bagmaker Downtime
Packaging Entity (Department)	Based on Sum of Dept. Bagmaker Downtimes

Definition	Packaging	Processing
Unit Name	Packaging Machine	Fryer or Oven
Start Time	Event Start Time	
End Time	Event End Time – will show no end if event is still in progress	
Duration	Duration of Downtime Event - Decimal format	
Reason 1	Auto – May be Planned or Unplanned No fault events become Planned after 60 Minutes No Manual updates required	Automatically captured as: Reason 1: Unplanned Reason 2: Operational Reason 3: Line Reason 4: Unspecified Manual updates required to update Reasons 1 - 4
Reason 2	Level 2 Fault Reason (Blocked, Starved, Operational, etc.)	
Reason 3	Fault Location (MHW, Bagmaker, CW or INS, ACP)	
Reason 4	Available Detailed Fault	
Shift	Configured Shifts for Site	

Downtime Event Examples

PC1Packaging

UnitName	StartTime	EndTime	Duration	Reason1	Reason2	Reason3	Reason4	Comment	Shift
PC1PKG109	2017-05-15 21:03:08	2017-05-15 21:03:10	0.03	Unplanned	Starved	MHW	Starved for Chips		C3

PC1Processing

UnitName	StartTime	EndTime	Duration	Reason1	Reason2	Reason3	Reason4	Comment	Shift
PC1Processing	2017-08-12 00:35:59	---	4373.07	Unplanned	Operational	Line	Unspecified		C1

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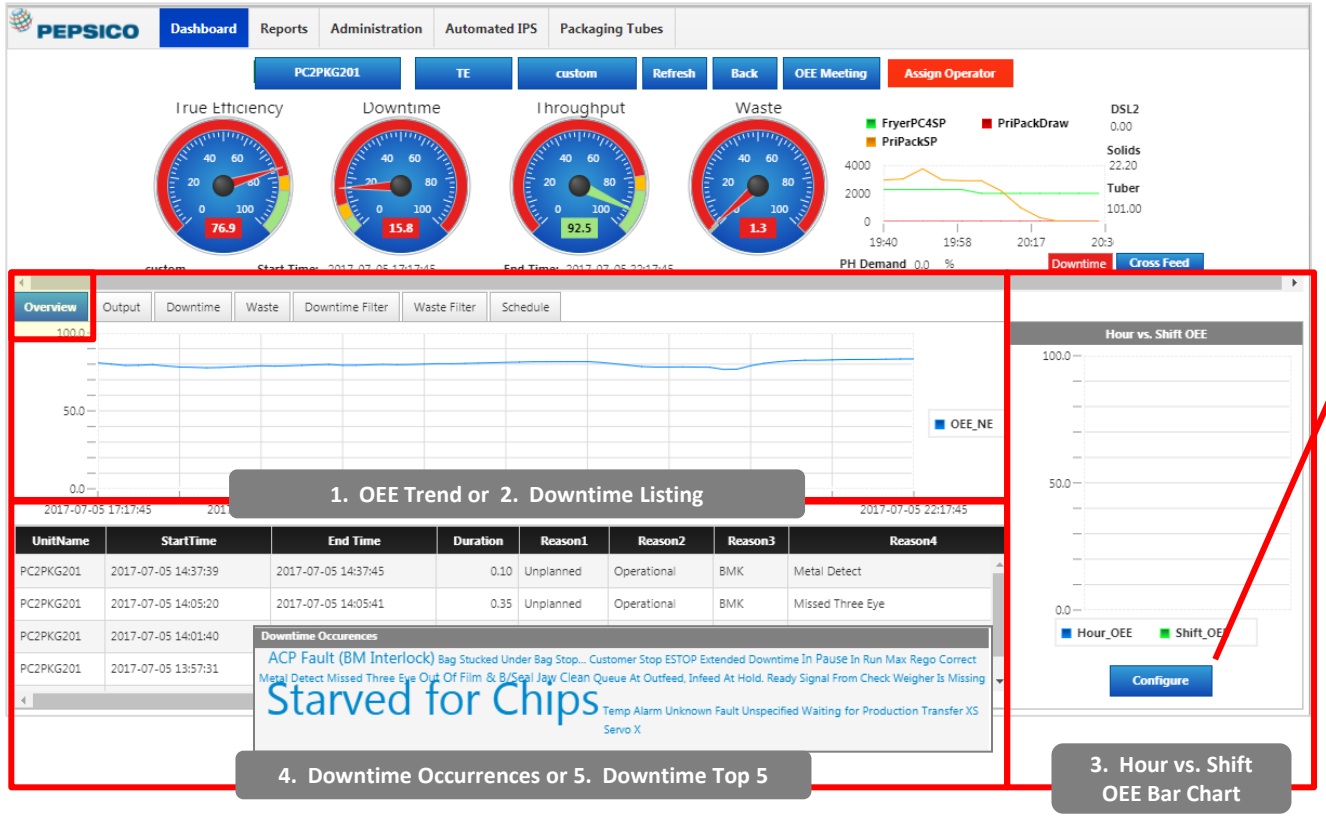
Performance Trends
Packaging UNIT

Global Shop Floor Tools (Snacks MES)

Packaging Individual UNIT – Overview Tab



- **Gauges display performance for <u>INDIVIDUAL PACKAGING UNIT</u>**
- **'Configure' Button enables different views of NE Performance**

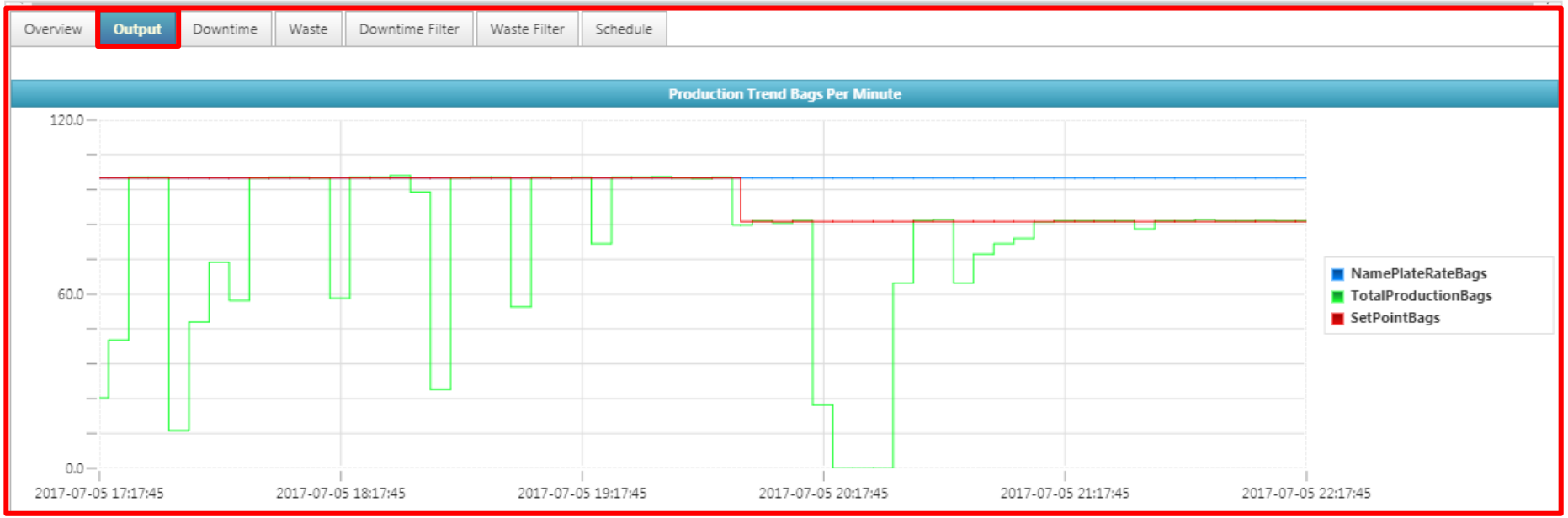
1. **OEE Trend View:**
   - NE Trend for selected timeframe
2. **Downtime Listing:**
   - Displays Downtime Events for selected timeframe
3. **Hour vs. Shift OEE Bar Chart:**
   - Last Hour vs. Shift NE
4. **Downtime Occurrences:**
   - Downtime Faults Word Cloud. Top Faults will appear in largest font
5. **Downtime Top 5:**
   - Displays Top 5 Downtime Faults

Packaging Individual UNIT – Output Tab

Production Trend for selected timeframe in bags per minute

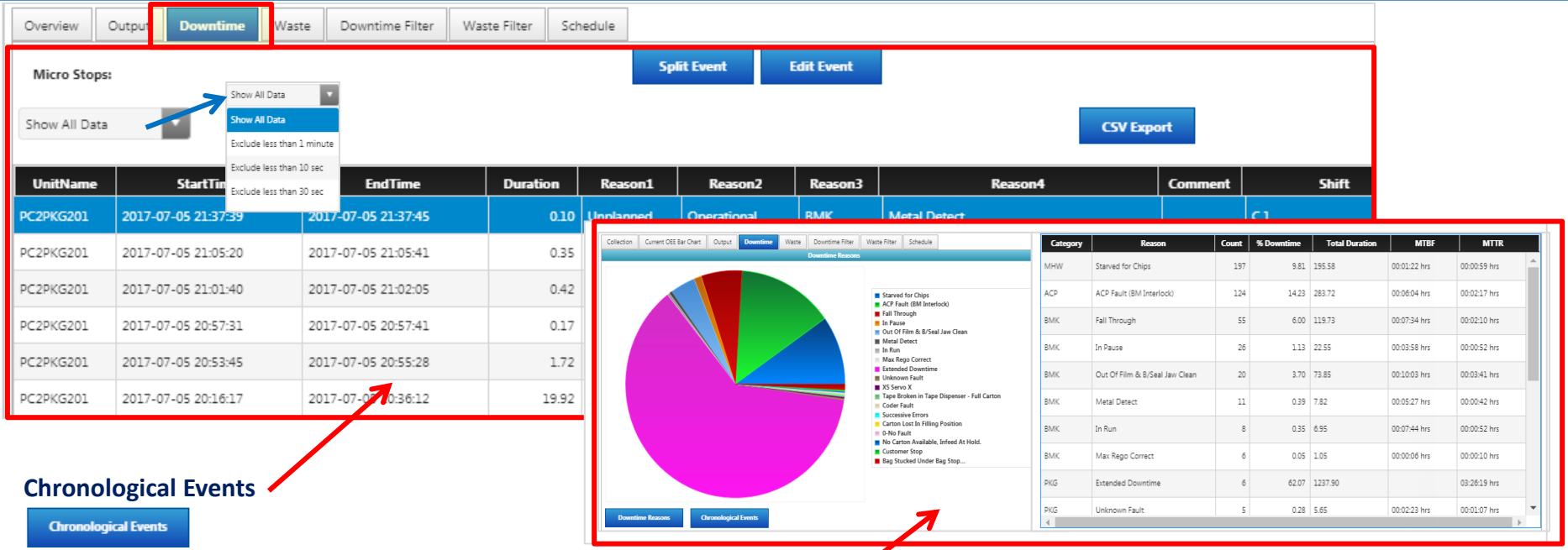
- Blue – Bagmaker Nameplate Rate in Bags per minute
- Green – Bagmaker Total Production in Bags per minute
- Red – Bagmaker Setpoint Bags in Bags per minute

Hover line to view any single point



Packaging Individual UNIT – Downtime Tab

List of downtimes captured for selected timeframe



Chronological Events

Chronological Events

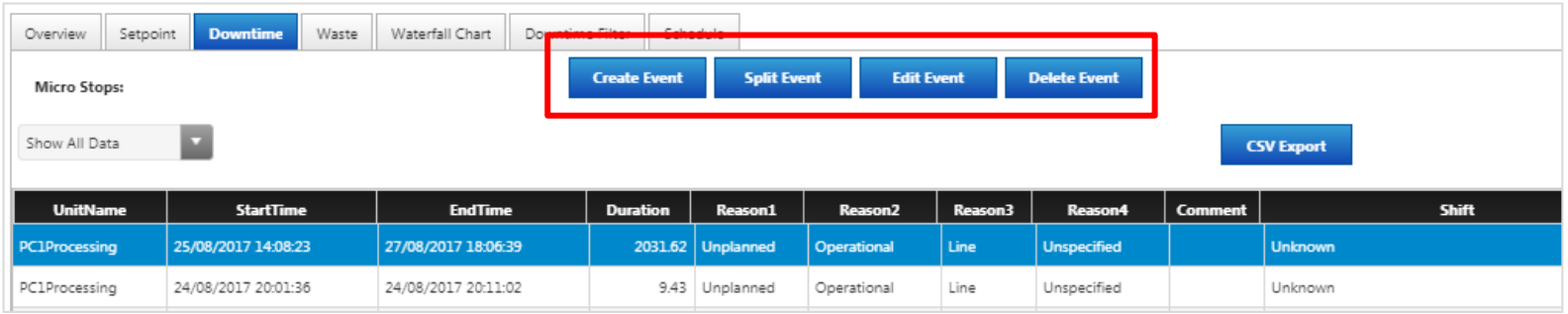
- List of downtime events with automatic reasons populated (where available).
- Highlight an individual row to Edit or Split an event
- Data can be filtered to exclude events based on duration

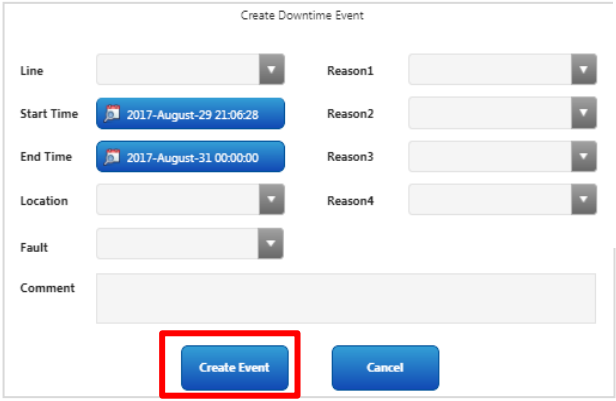
Downtime Reasons

Downtime Reasons

- Downtime Reasons button switches display for graphical analysis
- Table displays Reason, Count, Duration, MTTF and MTTR

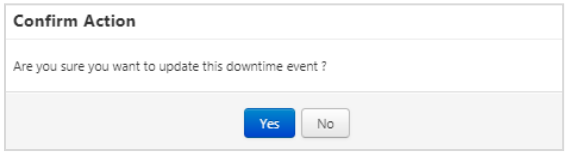
Processing or Packaging
Creating, Editing, Splitting or Deleting a Downtime Event



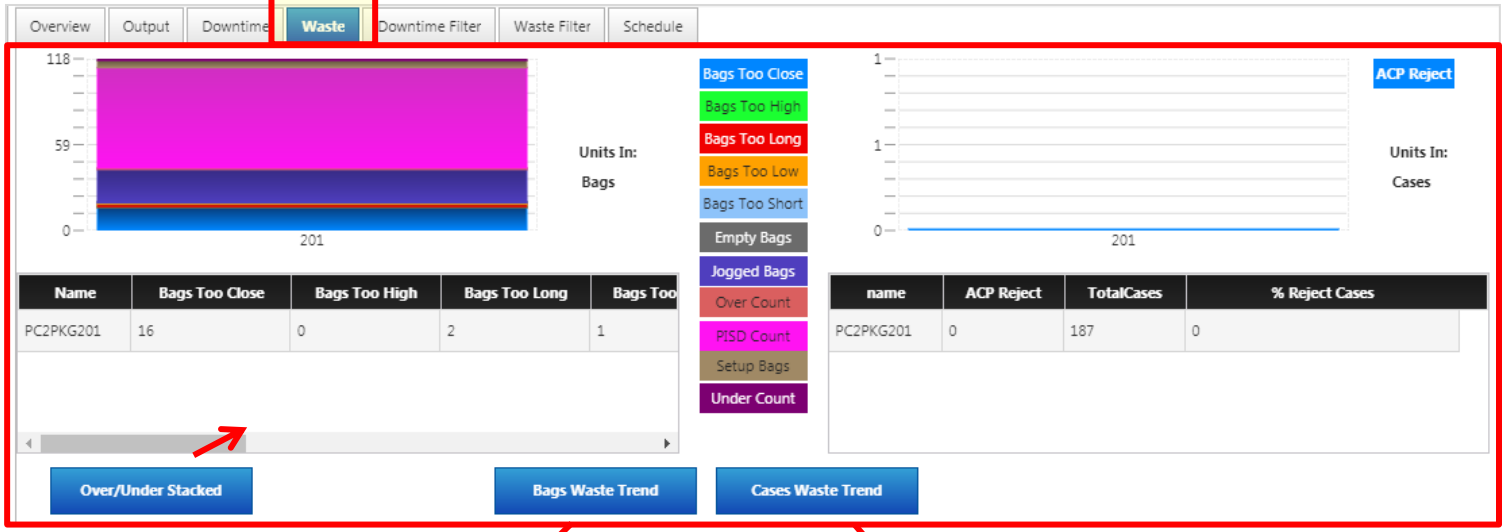


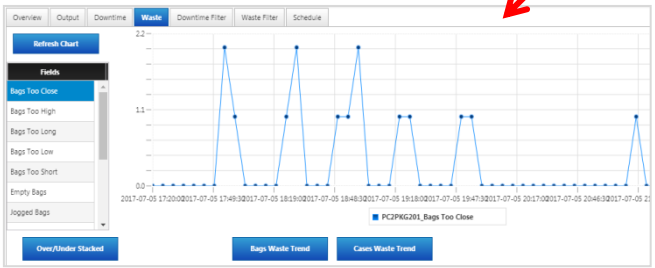
User Privileges required to Create/Edit/Split or Delete Events

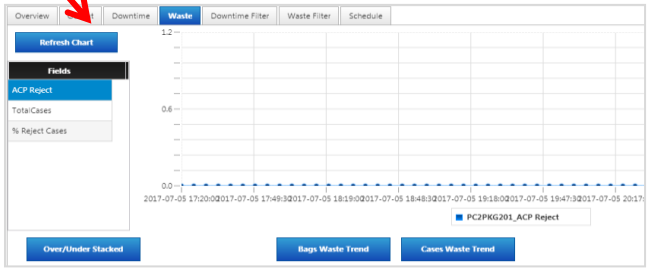
1. Select the event to edit. Selecting will highlight event in blue
2. Select appropriate Create, Edit, Split or Delete Event button
3. Update fields as needed
    a) Confirm Start/End Time
4. Select Create, Edit, Split, or Delete Event to make save
5. Confirm Action



Packaging Individual UNIT – Waste Tab
Comment







Over/Under Stacked

Stacked bar chart for Individual unit showing waste by category

Bags Waste Trend

Cases Waste Trend

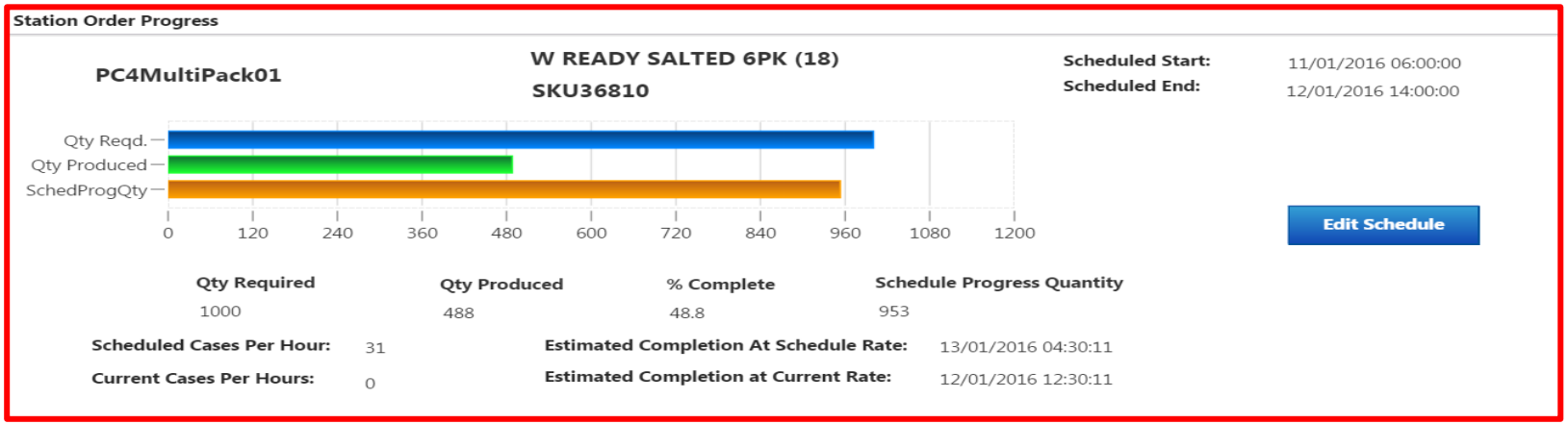
Waste Trend button switches display for trend analysis view

Schedule Tab

Global Shop Floor Tools (Snacks MES)

Schedule Tab

- Schedule Tab provides visibility to Production Make vs. Plan
- Operator enters the planned amount after each product changeover and system tracks production counts
- Operator manual entry is required for items below:
  - Total number of cases required (Scheduled Amount).
  - Production run scheduled start date & time (Scheduled Start Time).
  - Production run scheduled completion date & time (Scheduled End Time).



Make Vs. Plan Screen

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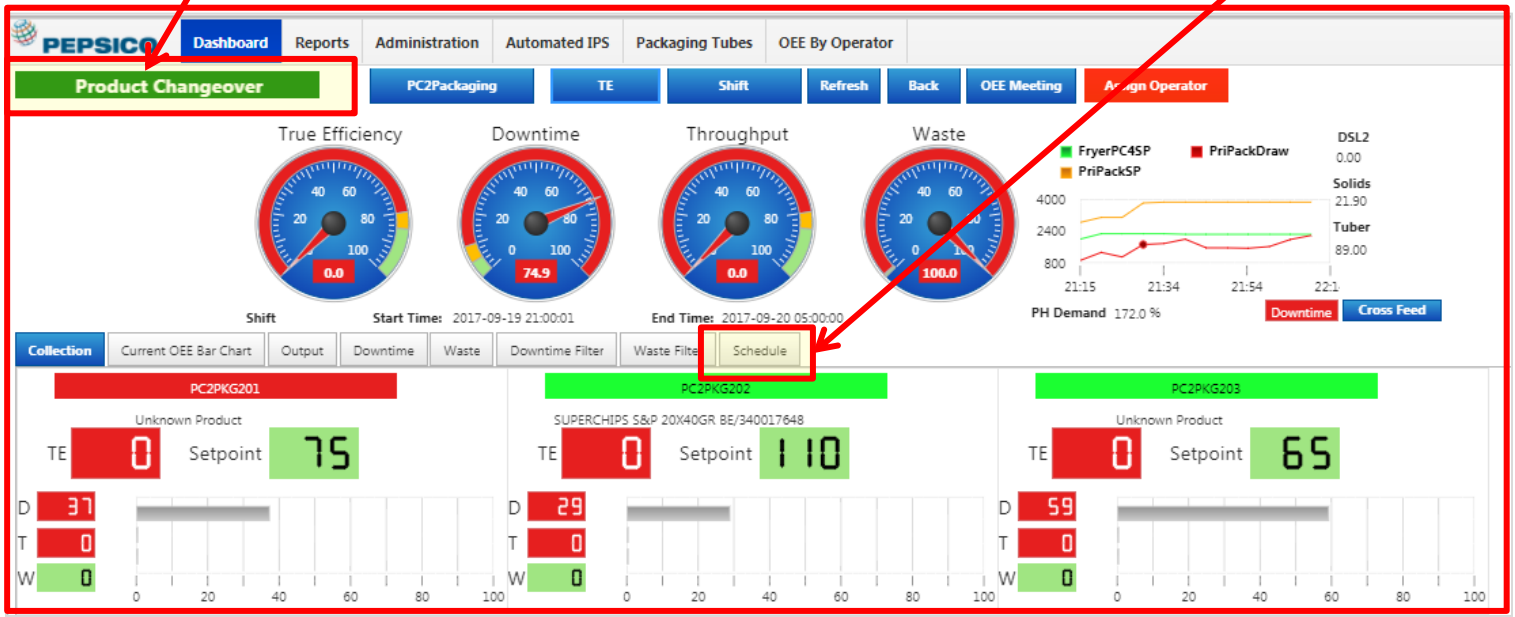
This Banner is displayed when Production Plan details are required. Click on it to enter details

Alternatively, click on the Schedule Tab and enter the Production Plan details there



Click on the ‘Product Changeover’ green slider running will display the Make Vs Plan Popup Screen.

Entering Production Plan via 'Product Changeover' Banner

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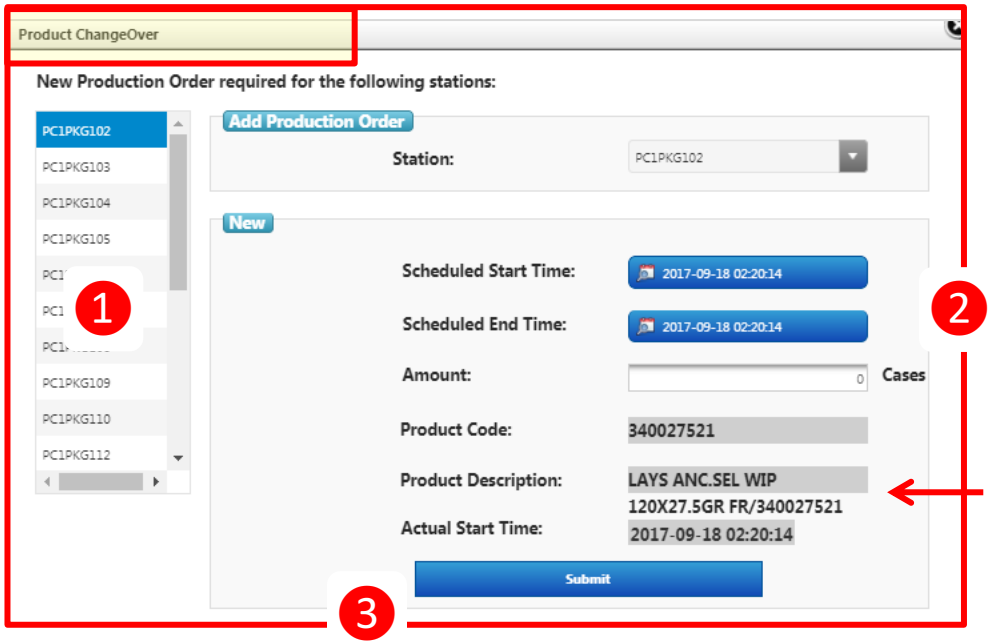
Click on the 'Product Changeover' green slider running will display the Make Vs Plan Popup Screen.

List of all Packaging Units that require Production Order Plan

Step 1: Select the Packaging Unit that requires Production Order Plan



Step 2: Enter the following Production Order Information:

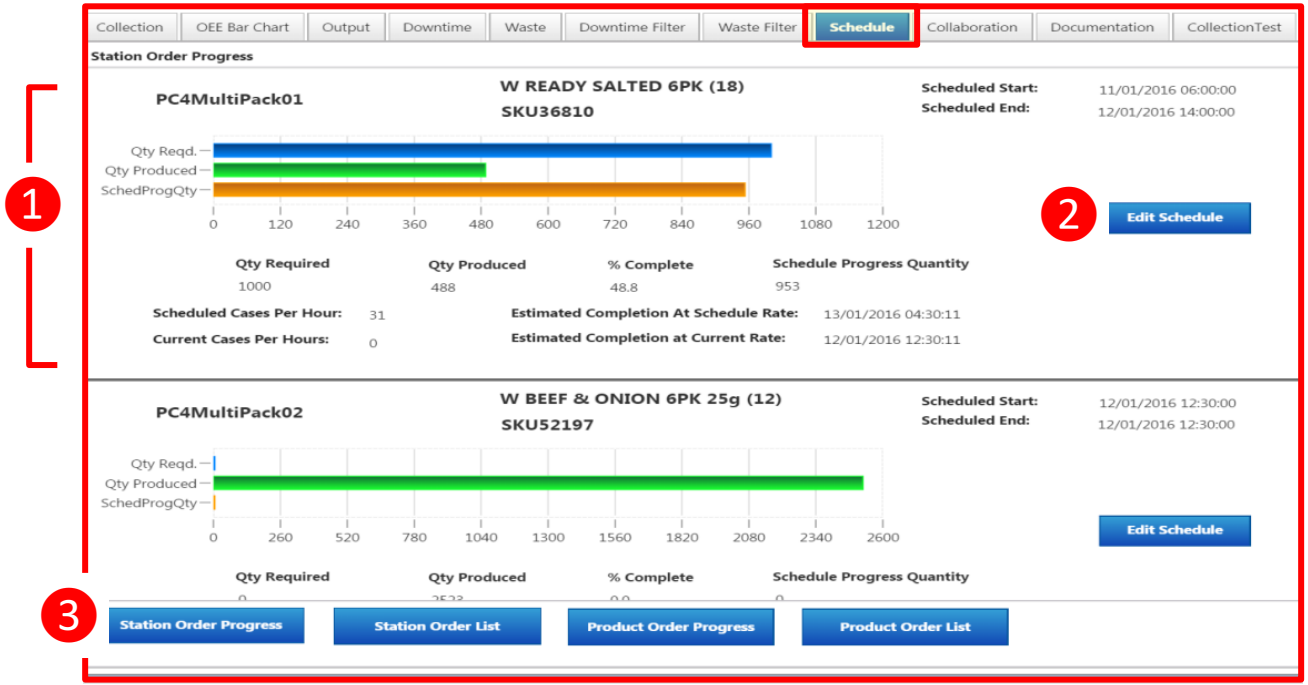
- **Scheduled (Planned) Start Date and Time**
- **Scheduled (Planned) End Completion Date and Time**
- **Amount - Number of Cases Required**

This area is system populated and shows the SKU currently running on the station

Step 3: Submit to save the changes

Schedule Tab

Select Schedule Tab to view Production Order Progress.

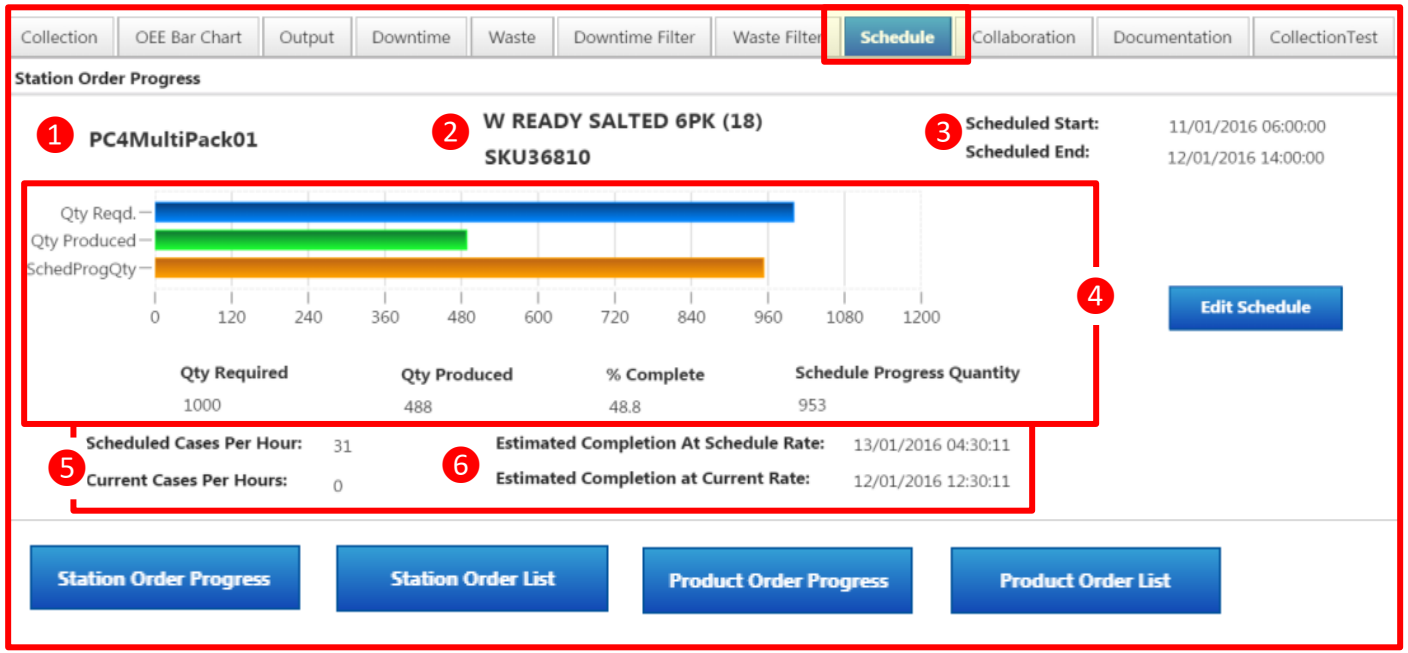


1. **Production Plan Details**
2. **'Edit Schedule' Button to update Production Order Plan by Packaging Unit**
3. **Select Views**
   - **By Order**
     - **Station Order Progress**
     - **Station Order List**
   - **By Product**
     - **Product Order Progress**
     - **Product Order List**

gSFT will determine UOM based on SKU

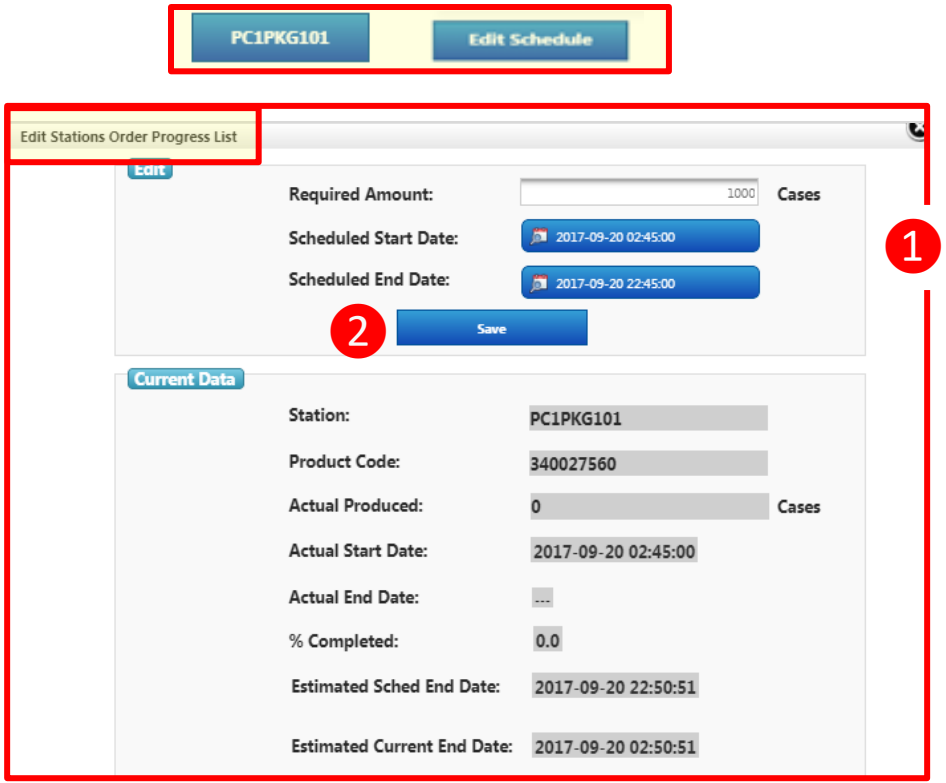
Global Shop Floor Tools (Snacks MES)

Schedule Tab Details



1. **Packaging Unit**
2. **SKU Details**
3. **The Scheduled (Planned) Start and End Dates**
4. **Production Amount Information**
   - **Quantity Required :** *Manually entered by Operator*
   - **Quantity Produced:** *Automatically tracked*
   - **% Complete:** *Produced Qty/Qty Required*
   - **Scheduled Progress Quantity:** *How many Units should have been made?*
5. **Scheduled and Current Cases per Hour:** *How many cases should we be making each hour & how many are we making?*
6. **Estimated Completion at Scheduled and Current:** *When will the Production Plan be completed?*

Making Changes to Production Order via 'Edit Schedule' or Unit Button

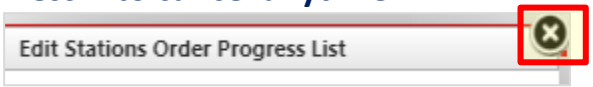


Step 1: Enter the following Production Order Information:

- **Required Amount**
- **Scheduled Start Date**
- **Scheduled End Date**

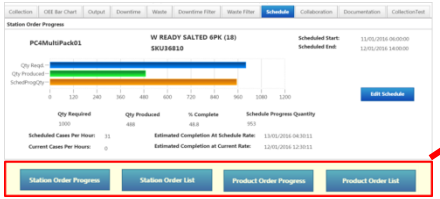
Step 2: Save changes

Press X to cancel anytime

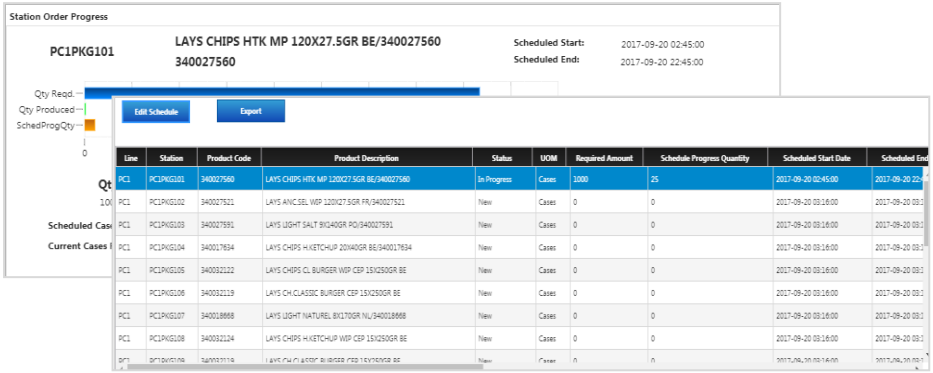


Global Shop Floor Tools (Snacks MES)

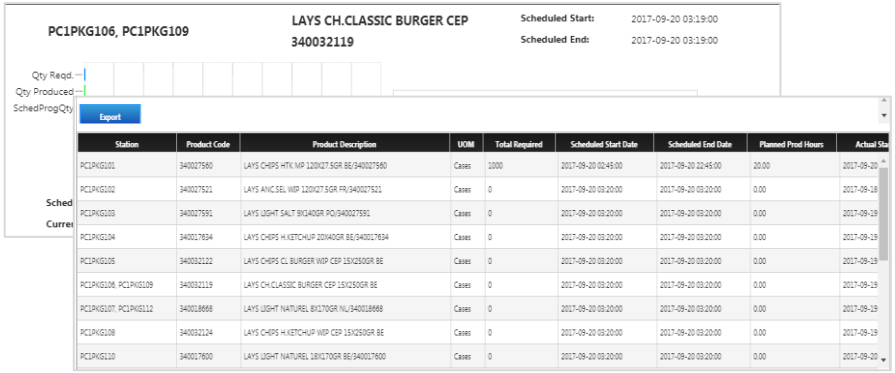
Production Order Progress - Views



1: Progress by Order – Graphical or List



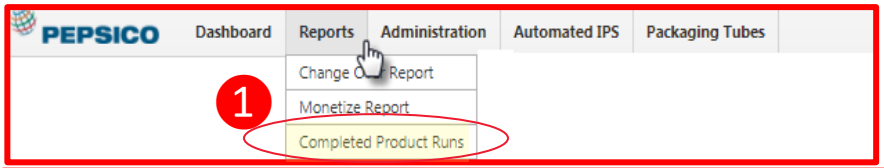
2: Progress by Product – Graphical or List



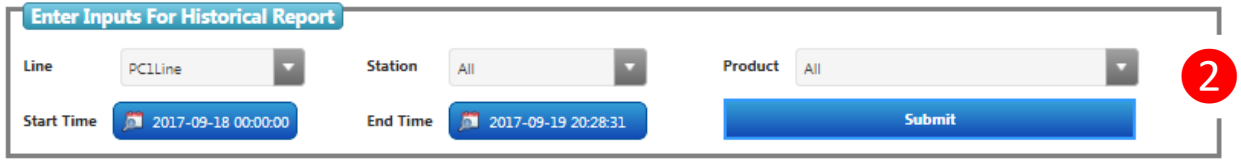
Stations running the same SKU are grouped together

Export Data using Export Button on either View

Production Order Progress - View through Completed Product Run



1. From Main Dashboard Header, select Reports >> Completed Production Runs



2. Make Filtering Selections and Submit

3. Export to Save in Excel

Line	Station	Product Code	Product Description	Calculated On	Status	Total Cases Rqd	Scheduled Start Date	Scheduled End Date	Planned
PC1	PC1PKG101	340030447	LAYS ANCIENNE SEL RECL 12X350GR FR/340030447	18-09-2017 09:19:46	Closed	0	20-09-2017 03:32:00	20-09-2017 03:32:00	0.00
PC1	PC1PKG101	340017979	LAYS ANCIENNE SEL 20X45GR FR/340017979	18-09-2017 18:56:41	Closed	0	20-09-2017 03:32:00	20-09-2017 03:32:00	0.00
PC1	PC1PKG101	340027521	LAYS ANC.SEL WIP 120X27.5GR FR/340027521	19-09-2017 01:57:45	Closed	0	20-09-2017 03:32:00	20-09-2017 03:32:00	0.00
PC1	PC1PKG101	340026516	LAYS CHIPS CLASSIC BURGER 12X120GR NL/340026516	19-09-2017 12:01:33	Closed	0	20-09-2017 03:32:00	20-09-2017 03:32:00	0.00
PC1	PC1PKG101	340017804	LAYS CHIPS CLASSIC BURGER 20X40GR BE/340017804	19-09-2017 18:45:53	Closed	1000	18-09-2017 23:48:00	19-09-2017 23:48:00	24.00

The Completed Production Report data is displayed

Efficiency by Operator

Efficiency by Operator

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Select 'Efficiency by Operator' to view Efficiency by Operator

Select 'Assign Operator' to assign Packaging Units to Operator

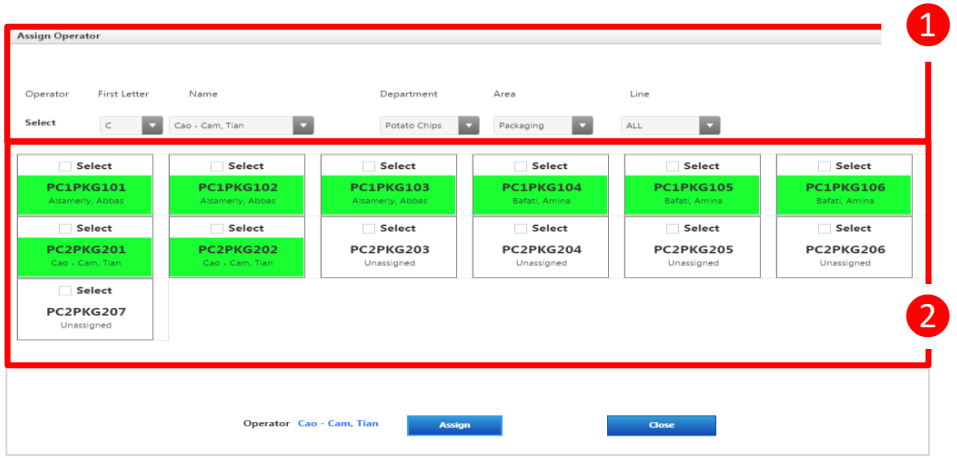
Note: Efficiency by operator navigation button will not be visible when viewing dashboard for Processing or single Packaging Tube

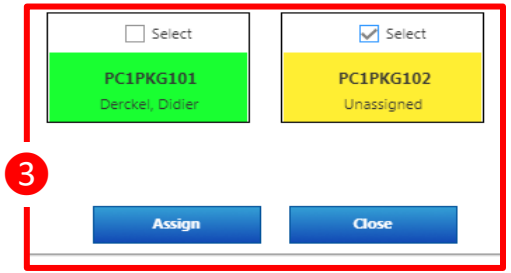
Efficiency by Operator

1. **Select Filters**
   - Select drop down first letter to filter Operator names by letter
   - Select Operator from dropdown menu
   - Select Department, Area, or Line to filter packaging units by selection

2. **Select Packaging Units to assign.**
   - Unit background color turns yellow when selected

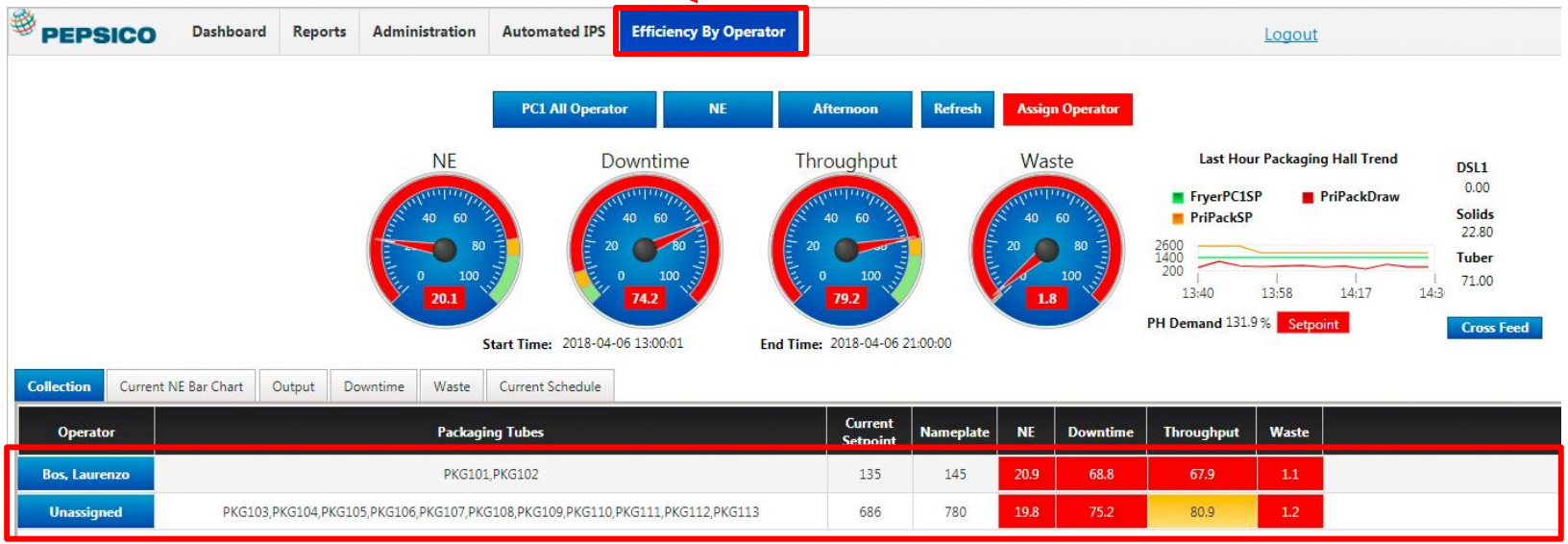
3. **Select 'Assign' to Assign. Unit Background color turns green and displays Operator name assigned to unit. Select 'Close' to exit**





Efficiency by Operator

View Efficiency by Operator by selecting from Menu



Collection Tab will display performance by Operator

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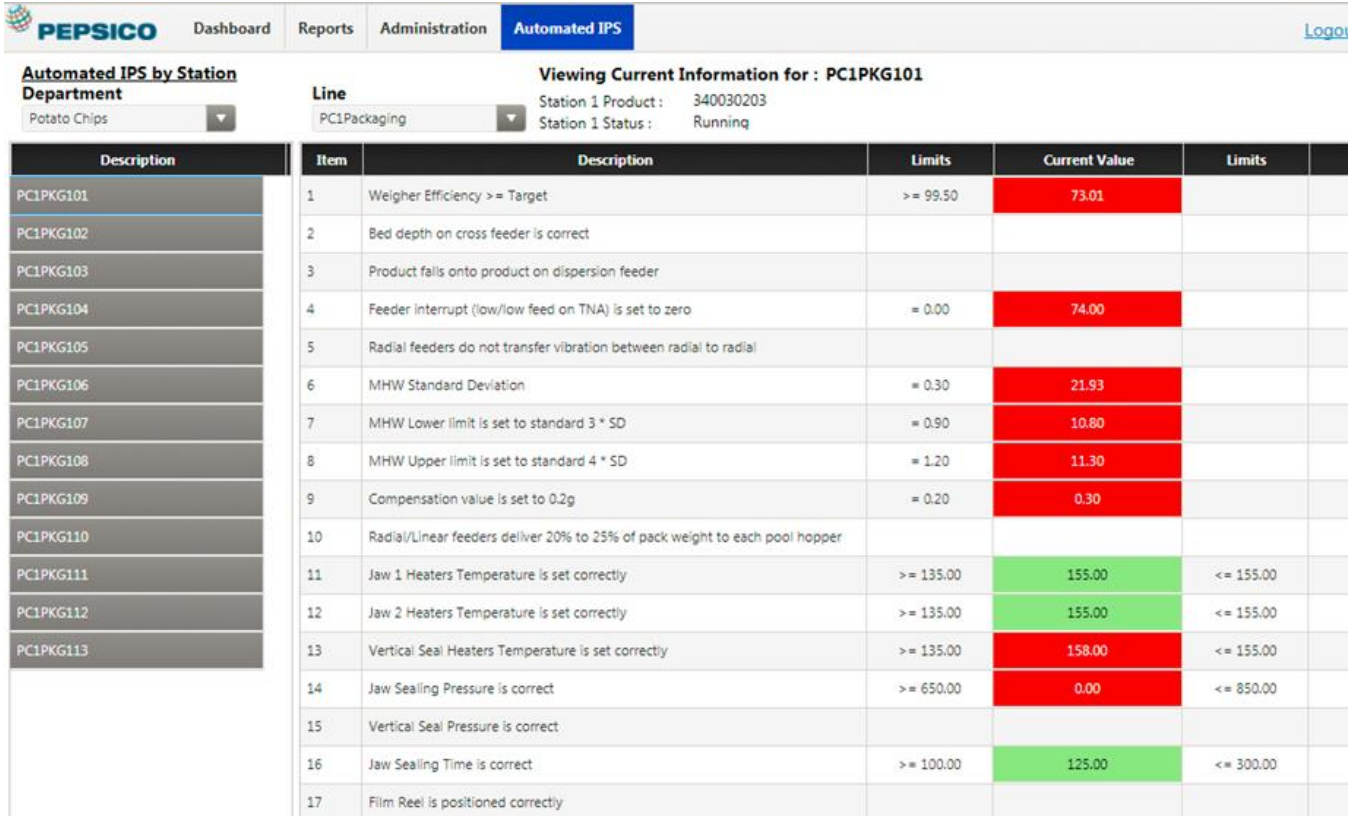
Automated IPS

Automated IPS

PEPSICO GLOBAL OPERATIONS



PEPSICO Dashboard | Reports | Administration | Automated IPS | Logo

Automated IPS by Station

Department: Potato Chips

Line: PC1Packaging

Viewing Current Information for : PC1PKG101

Station 1 Product : 340030203

Station 1 Status : Running

Description
PC1PKG101
PC1PKG102
PC1PKG103
PC1PKG104
PC1PKG105
PC1PKG106
PC1PKG107
PC1PKG108
PC1PKG109
PC1PKG110
PC1PKG111
PC1PKG112
PC1PKG113

Item	Description	Limits	Current Value	Limits
1	Weigher Efficiency >= Target	>= 99.50	73.01	
2	Bed depth on cross feeder is correct			
3	Product falls onto product on dispersion feeder			
4	Feeder interrupt (low/low feed on TNA) is set to zero	= 0.00	74.00	
5	Radial feeders do not transfer vibration between radial to radial			
6	MHW Standard Deviation	= 0.30	21.93	
7	MHW Lower limit is set to standard 3 * SD	= 0.90	10.80	
8	MHW Upper limit is set to standard 4 * SD	= 1.20	11.30	
9	Compensation value is set to 0.2g	= 0.20	0.30	
10	Radial/Linear feeders deliver 20% to 25% of pack weight to each pool hopper			
11	Jaw 1 Heaters Temperature is set correctly	>= 135.00	155.00	<= 155.00
12	Jaw 2 Heaters Temperature is set correctly	>= 135.00	155.00	<= 155.00
13	Vertical Seal Heaters Temperature is set correctly	>= 135.00	158.00	<= 155.00
14	Jaw Sealing Pressure is correct	>= 650.00	0.00	<= 850.00
15	Vertical Seal Pressure is correct			
16	Jaw Sealing Time is correct	>= 100.00	125.00	<= 300.00
17	Film Reel is positioned correctly			

Exercises

EXERCISE
Using PC1 - Packing "Cost"

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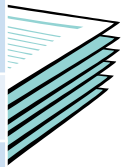
Ref	Question	Answer
1	In the last shift, which ACP has the highest reject count waste?	
2	For this machine, which is the biggest waste problem/reason?	
3	Has the problem been consistent through the shift, or was there a period when it was particularly bad?	
4	What was the total reject waste % in the last hour blow of by the bagmaker?	
5	What was the Waste % in the last hour measured by total bags made versus good bags made ?	
6	Can the difference between question 4 and 5 be explained?	



EXERCISE
Using PC1 - Packing “Delivery” (without Make v Plan)

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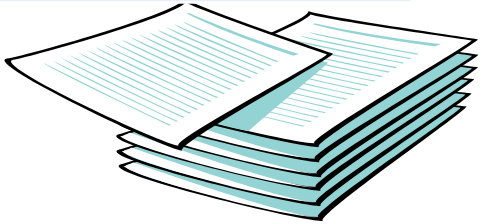
Pick any station

Ref	Question	Answer
1	How many Good bags did it make in the last hour?	
2	What was the gap v the nameplate?	
3	How many bags were lost due to the Speed setpoint?	
4	How many minutes “downtime” occurred?	
5	What were the top 3 downtime reasons by time?	



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Advanced Users Appendix

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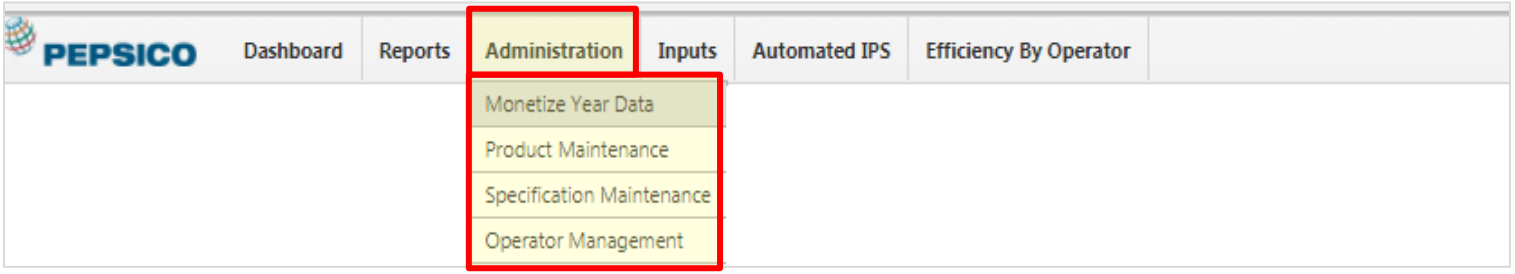
GLOBAL OPERATIONS

New Administrator Menu

Global Shop Floor Tools (Snacks MES)

New Administration Menu



1. **Monetize Year Data – Use to set targets for Monetize Report**
2. **Product Maintenance – Use to add New Products**
3. **Specification Maintenance – Use to add Product Specifications and set KPI Gauge targets**
4. **Operator Management – Use to add Operator Names to be used in Efficiency by Operator**

New Administration Menu - Monetize Year Data

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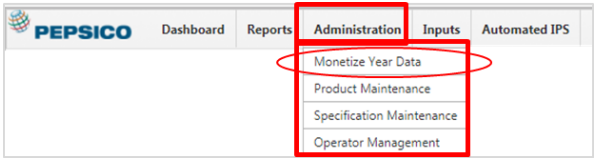
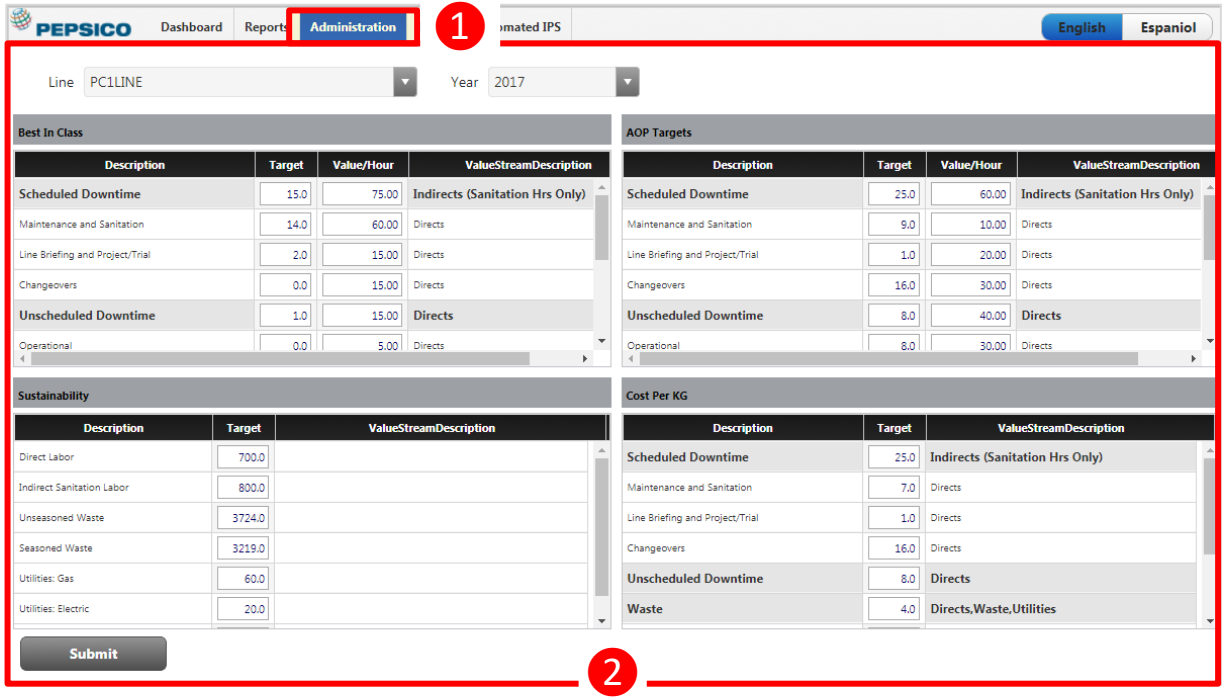
Monetize Year Data – Use to set targets for Monetize Report

1. **Select Administration > Monetize Year Data**

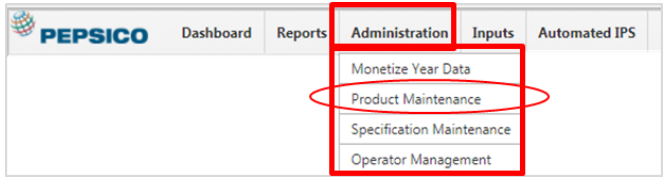


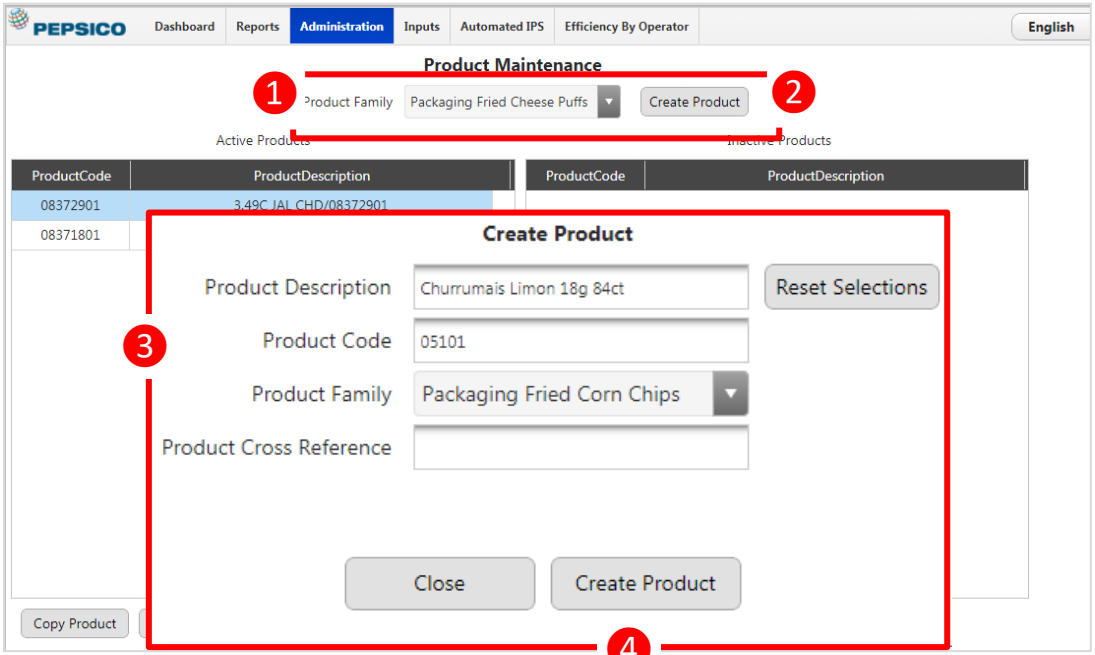
2. **Enter Targets and Values**
   - **Best in Class and AOP Targets - Target # of Hours and Value ($)/Hr**
   - **Sustainability Targets (Hrs) - Target # of Hour**
   - **Cost Per KG Targets ($) - Target USD M**



Global Shop Floor Tools (Snacks MES)

New Administration Menu - Product Maintenance (Creating a Product)





1. **Select Product Family - Packaging or Processing**
2. **Select Create Product**
3. **Create Product**
   - **Enter Product Description** - This description will appear in Collection Tab

Unit (Current Status)	Current Product
PC1PKG01	LSS Lays Sour Cream

   - **Enter Product Code (or Recipe)**
   - **Select Product Family from drop down**
   - **Enter Product Cross Reference (Not applicable for sites using Recipes)**
4. **Select Create Product**

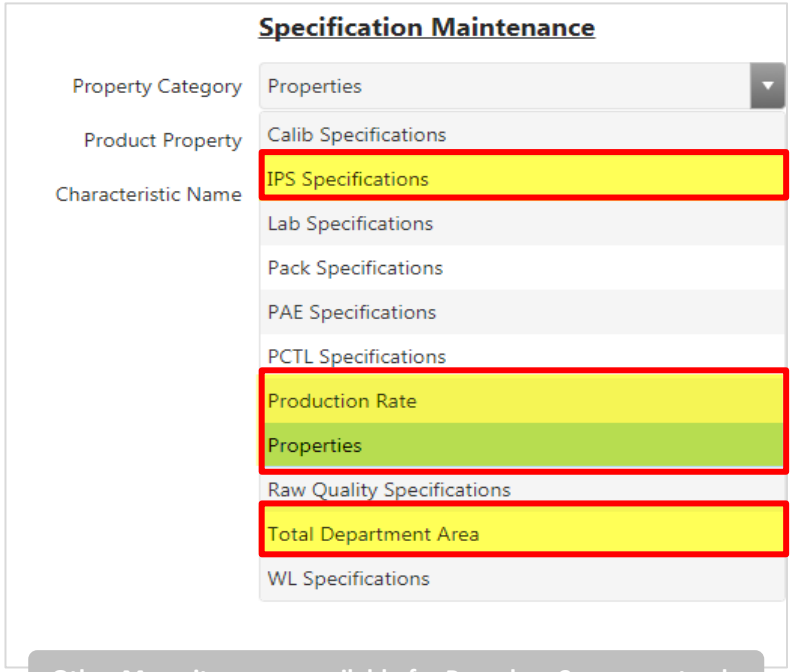
Please note: Products may not be deleted. If product is discontinued, move to Inactive

To Inactive -> <- To Active

Global Shop Floor Tools (Snacks MES)

New Administration Menu - Specification Maintenance

Select Specification Maintenance from Administration Menu



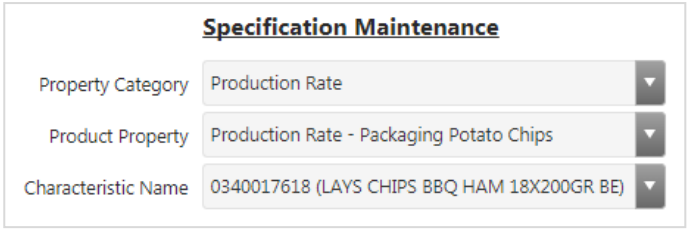
1. **IPS Specifications – Use to set parameters for Auto IPS**
2. **Production Rate – Use to set Nameplate by Product in Processing and Packaging**
3. **Properties – Use to set Product Properties**
4. **Total Department Area – Use to set KPI Gauge Limits**

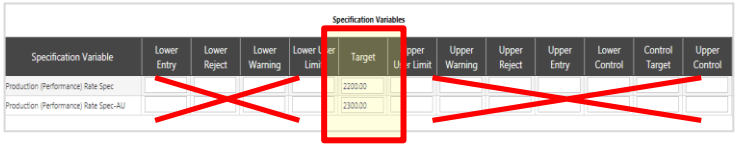
Other Menu items are available for Paperless Component only

Specification Maintenance – Production Rates for Packaging and Processing

PEPSICO GLOBAL OPERATIONS

Packaging



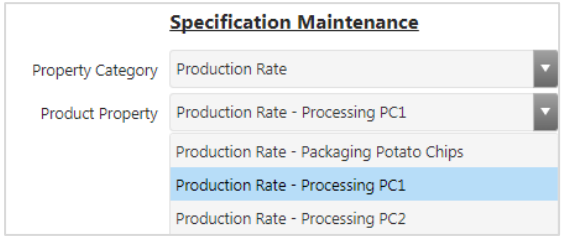


1. **Select Property Category: Production Rate**
2. **Select Product Property: Production Rate – Dept. Packaging**
3. **Select Characteristic Name: Product**
4. **Enter TARGET - Nameplate Rate Spec**

- **Production (Performance) Rate Spec: Bags/Minutes used in NE/TE**
- **Production (Performance) Rate Spec: Bags/Minute used in AU**

Do not fill out remaining fields

Processing

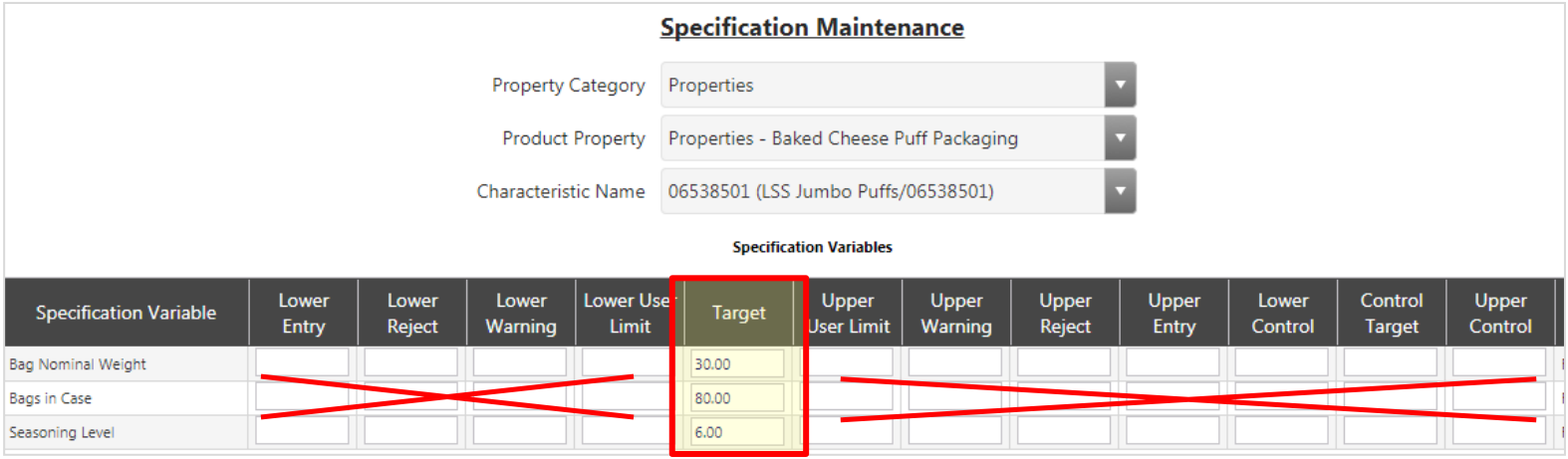


1. **Select Property Category: Production Rate**
2. **Select Product Property: Production Rate – Dept. Processing**
3. **Select Characteristic Name: Product**
4. **Enter Nameplate Rate Spec**

a. **Production (Performance) Max Rate Spec –** Maximum allowed value of Rate Spec (b)
b. **Production (Performance) Rate Spec -** System calculated Production Rate Spec based on the Potato Solid and Fryer Type matrix – If value is entered, it will override current value until next product change
c. **Production (Performance) Rate Spec – AU -** Fixed value maintained by Fryer

Do not fill out remaining fields

Specification Maintenance – Properties

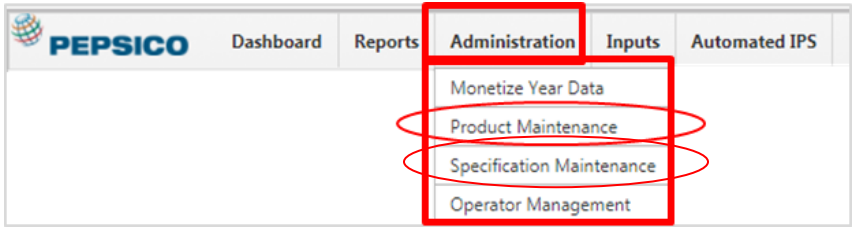


1. **Select Property Category: Properties**
2. **Select Product Property: Properties – DEPARTMENT**
3. **Select Characteristic Name: Product**
4. **Enter Specification Variables**
   - **Bag Nominal Weight**
   - **Bags in Case**
   - **Seasoning Level**

Do not fill out remaining fields

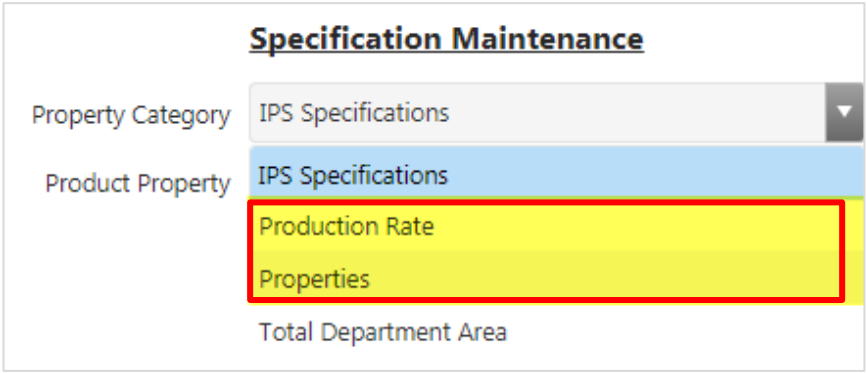
Summary – Product Maintenance

1. **Create Product in 'Product Maintenance Screen'**
    1. **Product Description**
    2. **Product Code or Recipe**
    3. **Product Family**
    4. **Product Cross Reference**



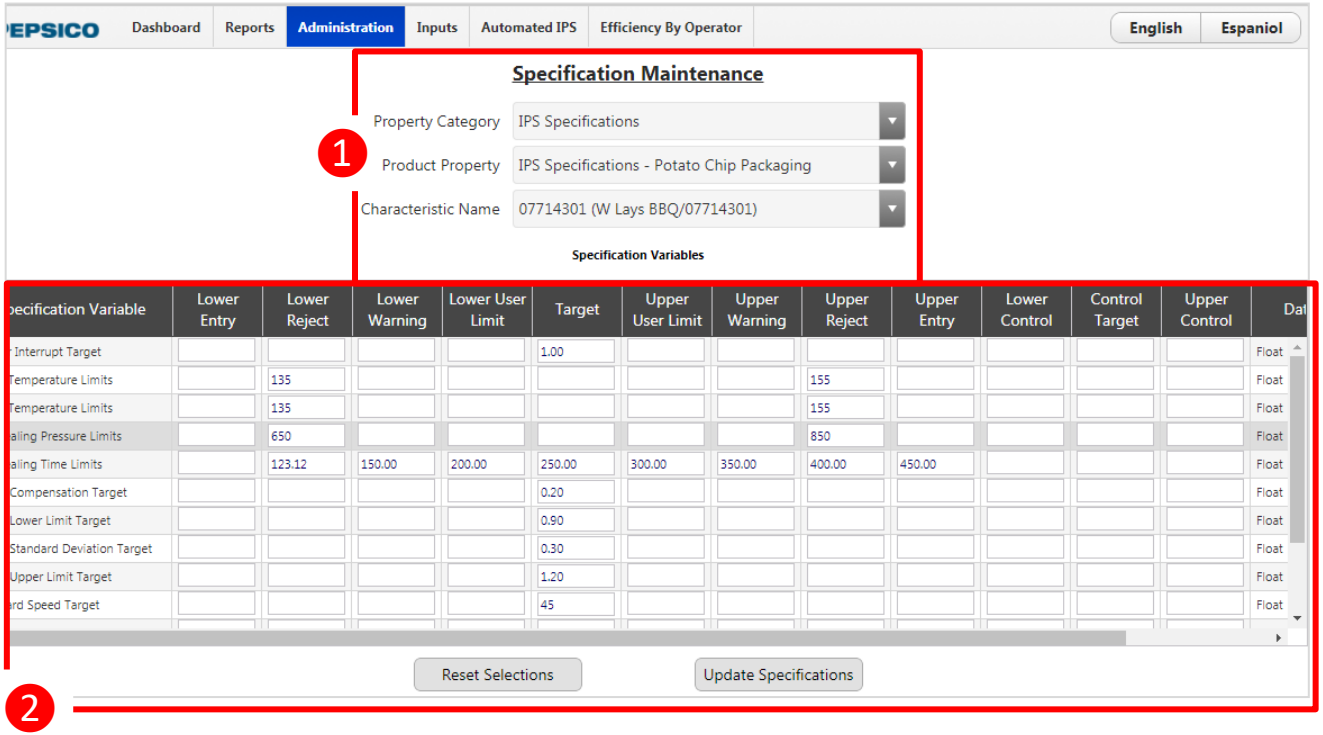
2. **Add Product Nameplate Rates in 'Specification Maintenance > Production Rate ' for Packaging and Processing (if necessary)**

3. **Add Product Properties in 'Specification Maintenance > Properties'**



Global Shop Floor Tools (Snacks MES)

Specification Maintenance – IPS Specifications



1. **Make Product Selections**
   - **Property Category**
   - **Product Property**
   - **Characteristic Name (Product Code)**

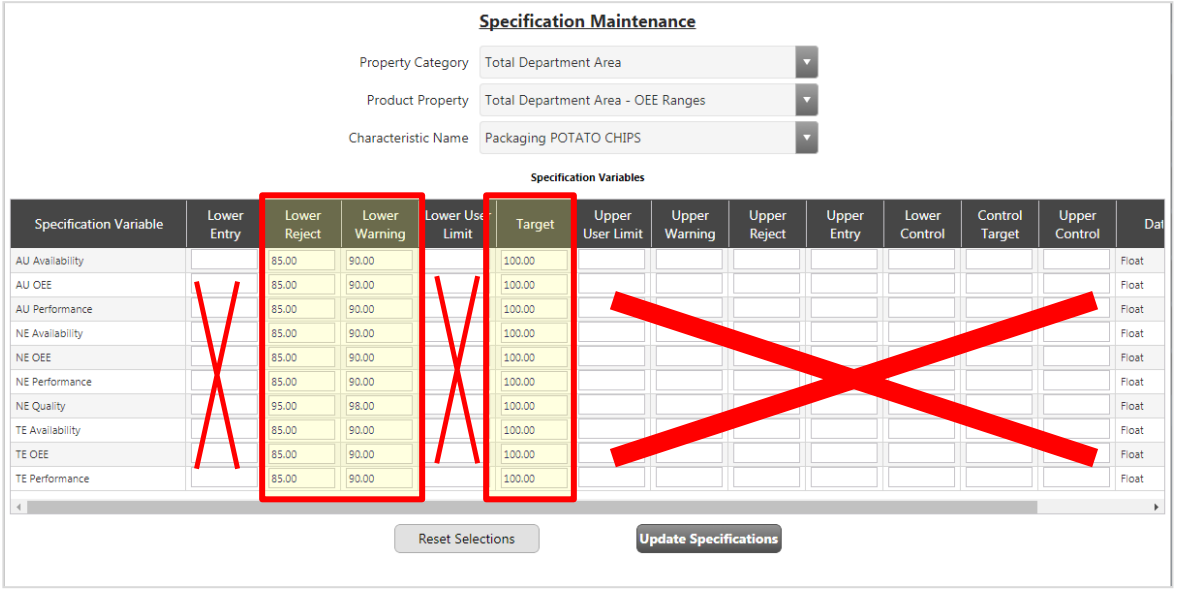
2. **Enter Specification Variable specifications – Please check with Mike Hayes for input on which variables should be completed.**

3. **Update Specifications**

Specification Maintenance – Total Department Area

PEPSICO GLOBAL OPERATIONS

1. **Select Property Category: Total Department Area**
2. **Select Product Property: Total Department Area – OEE Ranges**
3. **Select Characteristic Name: Department**
4. **Enter Specification Variables**
   - **AU Availability**
   - **AU OEE**
   - **AU Performance**
   - **NE Availability**
   - **NE OEE**
   - **NE Performance**
   - **NE Quality**
   - **TE Availability**
   - **TE OEE**
   - **TE Performance**

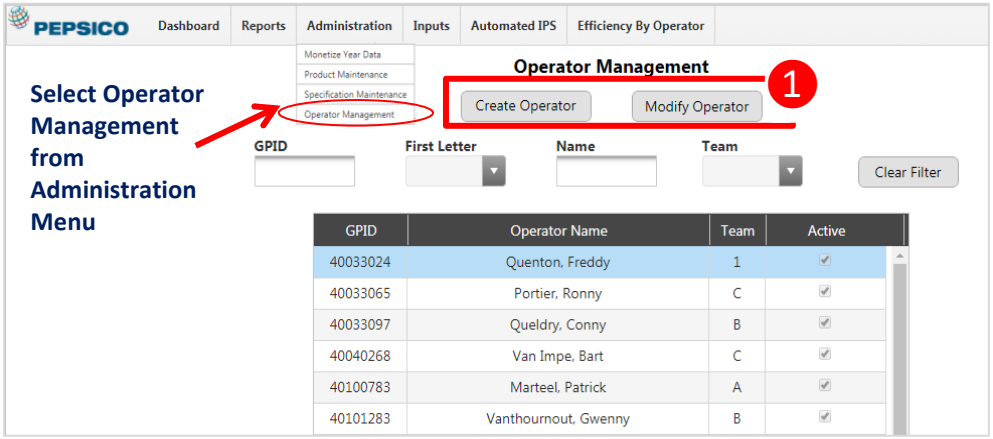


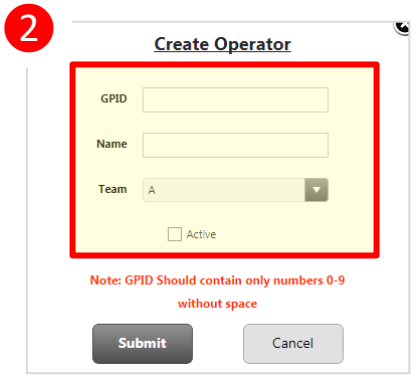
In this example: <85 will be Red; 85 to 90 will be Yellow; >90 will be Green

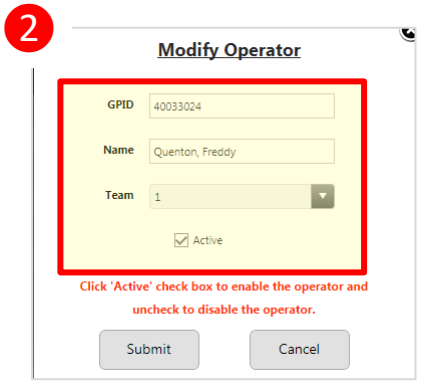
Do not fill out remaining fields

Global Shop Floor Tools (Snacks MES)

New Administration Menu - Operator Management





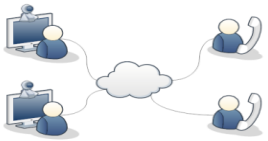


1. Select ‘Create Operator’ to add a new Operator or ‘Modify Operator’ to edit an existing Operator
2. Update fields
   a. Enter GPID – Should contain only numbers without spaces
   b. Enter Name
   c. Enter Team – This is the crew that the Operator is assigned to (may be the same)
   d. Check ‘Active’ check box to enable the Operator and uncheck to disable Operator
3. Select Submit

Global Shop Floor Tools

Hypercare Support

PEPSICO
GLOBAL OPERATIONS



Hypercare Meetings

Conference Calls

- Dates TBD: 30 minute calls (Daily)
- Dates TBD: 30 minute calls (Mon, Wed, Fri)
- Dates TBD: Weekly calls

ATTENTION!

For All Support Requests first consult with local site support (Names of local gSFT Owners) confirming the issue

() Phone Number Voice Mail: 24/7 x 365

USE ONLY for High Priority Incidents

- System is Down
- No Data visible in Application

Email: SPA - IT GSFT Support <SPAITGSFTSupport@pepsico.com>
ALL Support Requests
Sun – Fri: 1:30 AM – 6:00 PM (Eastern Time)

Global Shop Floor Tools

Post Hypercare Support (Go-Live Status)

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GLOBAL OPERATIONS

ATTENTION!

For All Support Requests first consult with local site support (Names of local gSFT Owners) confirming the issue

For all System Issues

Submit email to: SPA – IT GSFT Support
SPA - IT GSFT Support <SPAITGSFTSupport@pepsico.com>
Support Window: 24x7x365

For "How to" Questions, contact local Site Support first.

If local Site Support unable to resolve, contact (Name of Sector gSFT Owner) or email: SPA - IT GSFT Support <SPAITGSFTSupport@pepsico.com>

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Let’s go and have a look on the floor!