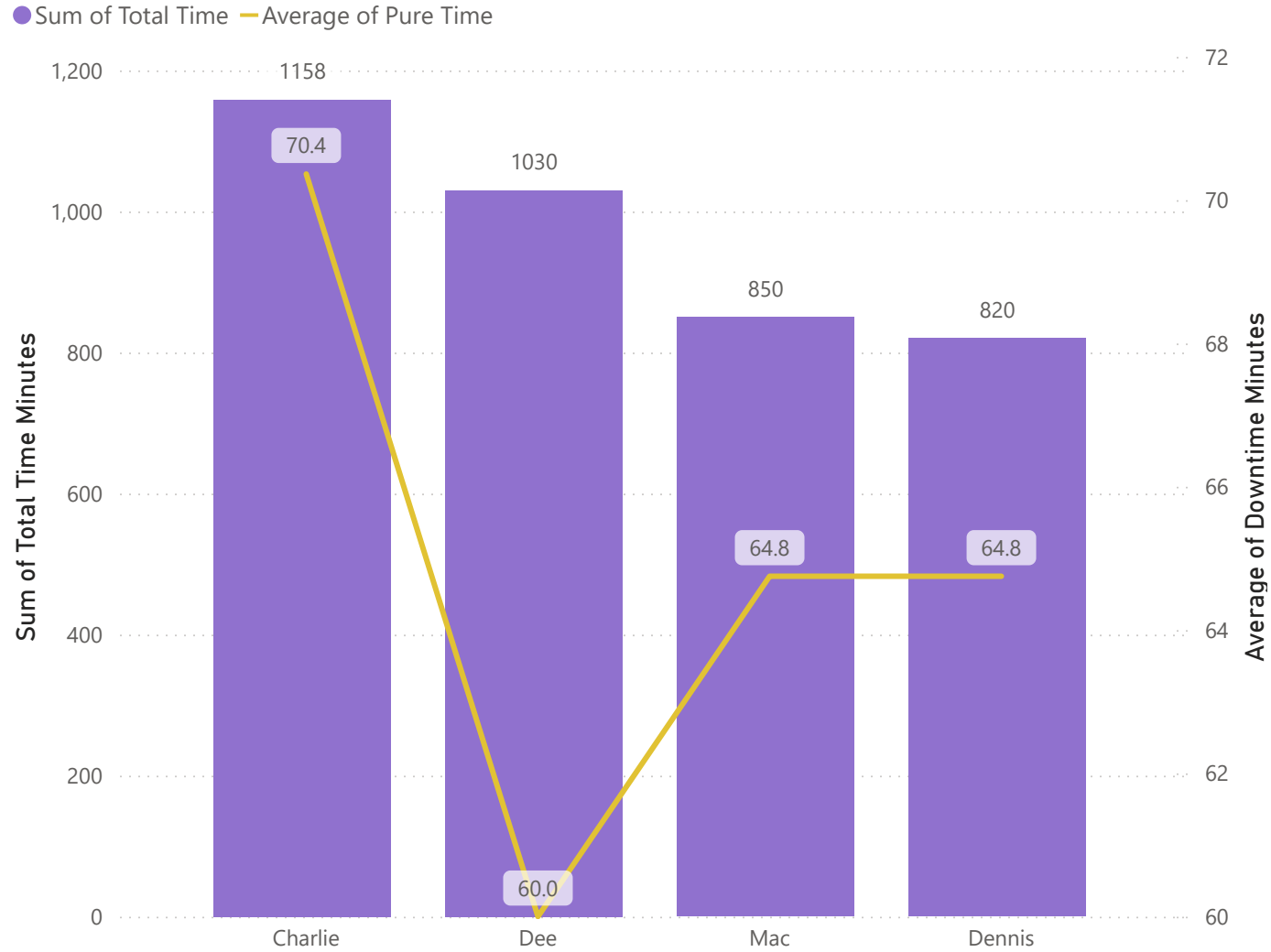


Drink manufacturing

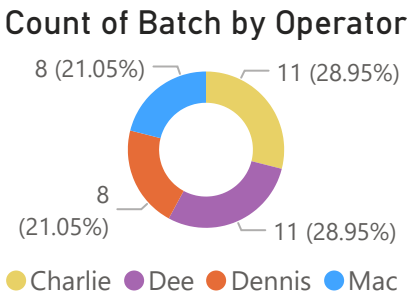
6

Count of Product

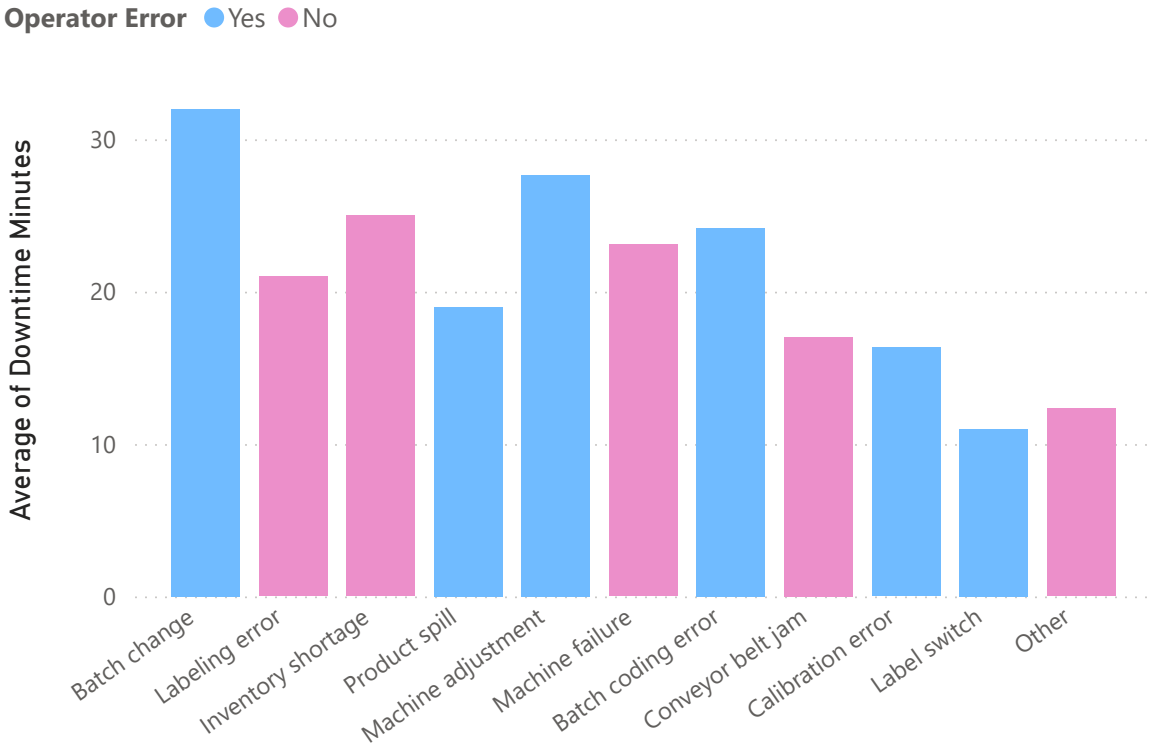
Sum of Total Time (Mins) and Average of Pure Time (Mins) by Operator



| Flavor | Count of Batch |
|------------|----------------|
| Cola | 20 |
| Root Beer | 7 |
| Lemon lime | 6 |
| Diet Cola | 4 |
| Orange | 1 |
| Total | 38 |



Average of Downtime Minutes by Description and Operator Error



Downtime Minutes by Operator

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

Sum of Downtime Minutes by Product

