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| Title | Sub title | UNIT | Cumulative month values |
| Design Speed |  | Rpm | 54 |
| Total Time |  |  | 292 |
| SHUTDOWN LOSSES |  |  |  |
| Holidays/Shutdowns | (Planned Shutdwons) | Min | 0 |
| Holidays/Shutdowns | (Priority On Other Line) | Min | 0 |
| Holidays/Shutdowns | (RM/PM Not Avalible in the Factory) | Min | 0 |
| Holidays/Shutdowns | (Man Power Shortage) | Min | 0 |
| No Production Orders | (No Plan) | Min | 0 |
| Planned Modifications | (Line modifications.) | Min |  |
| Planned Modifications | (Development trials.) | Min | 0 |
| Planned Maintenance | (Planned maintenance.) | Min | 0 |
| Planned Maintenance | (Overhauls) | Min | 0 |
| Planned Break | (Tea / Lunch) | Min | 16 |
| Other Shutdown Losses - 1 | (Meetings. JH time. Training.) | Min | 0 |
| DOWNTIME LOSSES |  |  |  |
| Equipment Breakdown | (Electrical / instrumentation) | Min | 0 |
| Equipment Breakdown | (Mechanical) | Min | 2 |
| Equipment Breakdown | (Coding machine) | Min | 0 |
| Equipment Breakdown | (Other stopages > 15 min) | Min | 0 |
| Changeovers | (Pack) | Min | 0 |
| Changeovers | (Product) | Min | 0 |
| Changeovers | (Line Sanitation) | Min | 0 |
| Cutting Blade Change | (Replacement of worn-out machine consumables that contact pack at process points (knife sealer jaw etc.)) | Min | 0 |
| Start-up / Ramp Down | (Line Set-up & adjustments for Speed or Quality) | Min | 0 |
| Utility Loss | (Utility failure (No Power Air Chilled Water) | Min | 0 |
| Management Loss | (Filling bulk Stock Out ) | Min | 0 |
| Operational Motion | (Balance Packing) | Min | 0 |
| PERFORMANCE LOSSES |  |  |  |
| Minor Stoppages | (Unplanned stop <=15 min. (Line Jam. Jaw Cleaning. etc.) Coding Change. Reel change Batch No. Change) | Min | 0 |
| Speed | (Speed less than approved maximum design speed within line) | Min | 0 |
| Line Organisation | (Shift change) | Min | 0 |
| Line Organisation | (No Manpower (Absentisam)) | Min | 0 |
| Logistics | (RM/PM stock Out) | Min | 0 |
| DEFECT LOSSES |  |  |  |
| Defects & Rework | (Quality rework.) | Min | 0 |
| Measurement & Adjustment | (Running Weight adjustment.) | Min | 0 |
| Volume Produced Good |  |  | 710740 |
| Volume Produced Rejected |  |  | 1767 |
| MAN POWER DEPLOYMENT |  |  |  |
| Standard Man Power to be Deploy |  | Nos. | 725 |
| Actual Man-Power is deployed |  | Nos. | 677 |
| Offline Manpower is deployed |  | Nos | 45 |
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