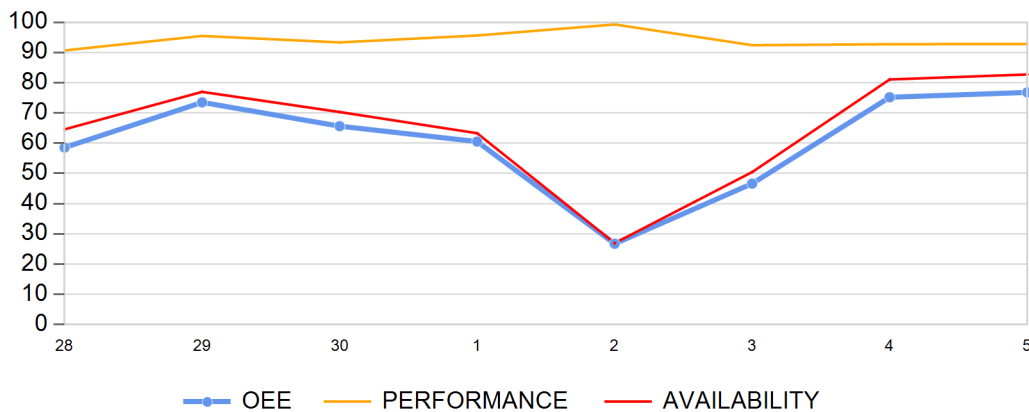
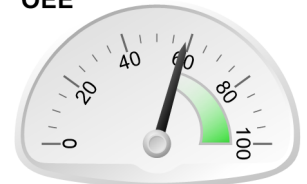
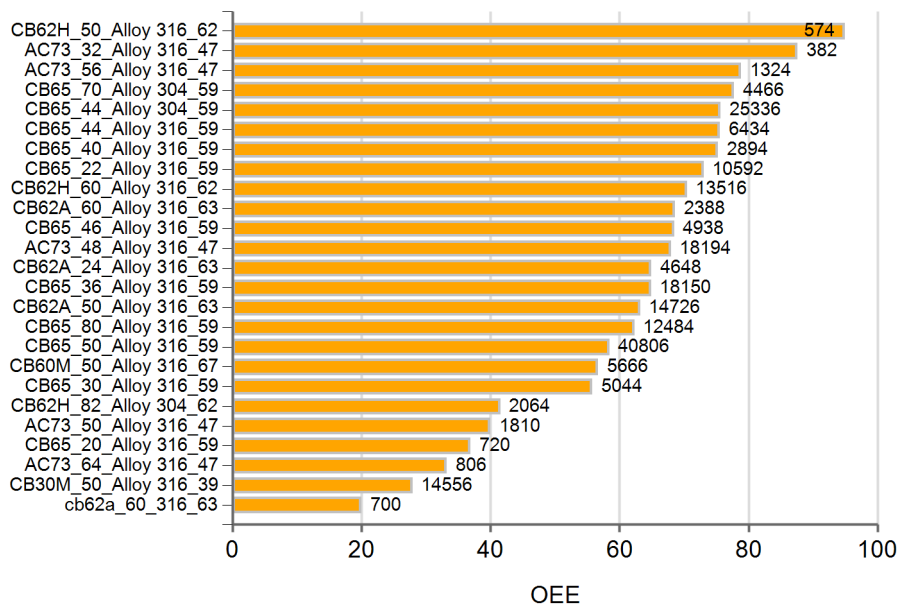


**Sacmi**

2022-11-28 06:01 - 2022-12-05 06:01

OEE / HOUR**OEE****58,8%**

Availability: 62,6%
Performance: 93,9%
Plannedtime: 168,0h
Productiontime: 105,2h
Downtime: 62,8h
Produced units: 213218

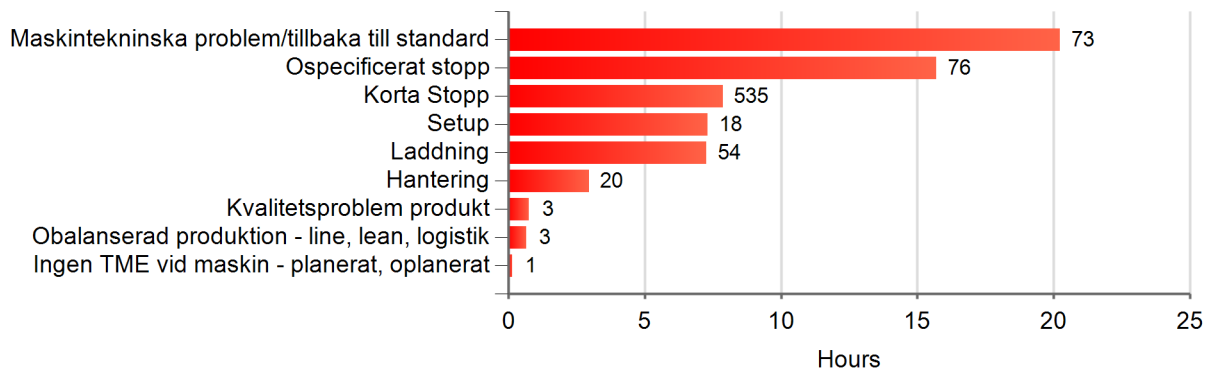
OEE / TYPE**TOP 15 LARGEST DOWNTIME REASONS**

CATEGORY	COMMENTS	DURATION	START	STOPP	SHIFT
HU3 HU3R - Rotationsarm_9	Lägger plattorna bra i överlappet, sen under rotationen så slänger han iväg översta plattan, så den ligger på halva och sen böjer plattan i hissen.	05:27:08	22-12-03 00:32	22-12-03 06:00	Night
HU3 HU3B - Stapling (överlapp)_9		04:25:22	22-12-02 01:34	22-12-02 06:00	Night
HU3 HU3B - Stapling (överlapp)_9		01:54:23	22-12-02 06:00	22-12-02 07:54	Morning
Setup Yttre pelarställ_9	Mareialbyte från 0.25 till 0.3	01:17:44	22-11-30 07:23	22-11-30 08:41	Morning
HU3 HU3R - Rotationsarm_9	Lägger plattorna bra i överlappet, sen under rotationen så slänger han iväg översta plattan, så den ligger på halva och sen böjer plattan i hissen.	01:13:32	22-12-03 06:00	22-12-03 07:13	Morning
Setup Yttre pelarställ_9	Fick ringa hit UH , för baksidan vid överlappet gick ej att justera då det satt fel bricka under, så vi fick greja med det också. & material.	01:11:18	22-12-01 21:27	22-12-01 22:38	Afternoon
Ospecificerat stopp Kvitterat för tidigare skift_9		01:07:34	22-12-02 09:36	22-12-02 10:44	Morning
Ospecificerat stopp Kvitterat för tidigare skift_9		01:01:54	22-12-02 12:00	22-12-02 13:02	Day

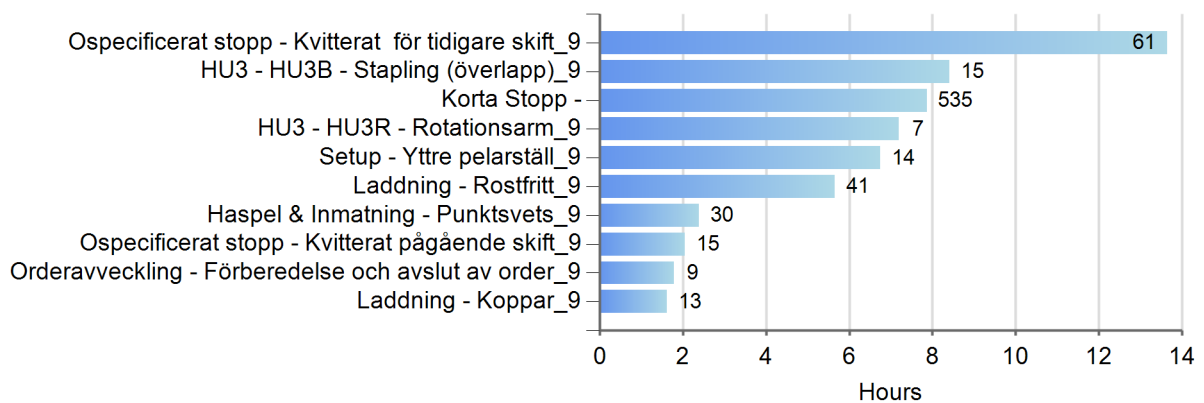


Setup Yttre pelarställ_9	AC73 till CB65, plus att kopparn fastnade i valsmataren	01:00:00	22-11-28 17:00	22-11-28 18:00	Day
Ospecificerat stopp Kvitterat för tidigare skift_9		00:52:39	22-12-01 10:51	22-12-01 11:43	Morning
Setup Yttre pelarställ_9	AC73 till CB65, plus att kopparn fastnade i valsmataren	00:51:47	22-11-28 18:00	22-11-28 18:51	Afternoon
Ospecificerat stopp Kvitterat för tidigare skift_9		00:47:32	22-12-01 17:12	22-12-01 18:00	Day
Ospecificerat stopp Kvitterat för tidigare skift_9		00:43:21	22-12-02 13:02	22-12-02 13:45	Day
Setup Yttre pelarställ_9	byte av verktyg 62 till AC73	00:42:36	22-11-28 07:35	22-11-28 08:18	Morning
Setup Yttre pelarställ_9	plus inre	00:42:20	22-11-30 14:46	22-11-30 15:29	Day

HEAD CATEGORY DOWNTIMES (Duration & Number of frequency)

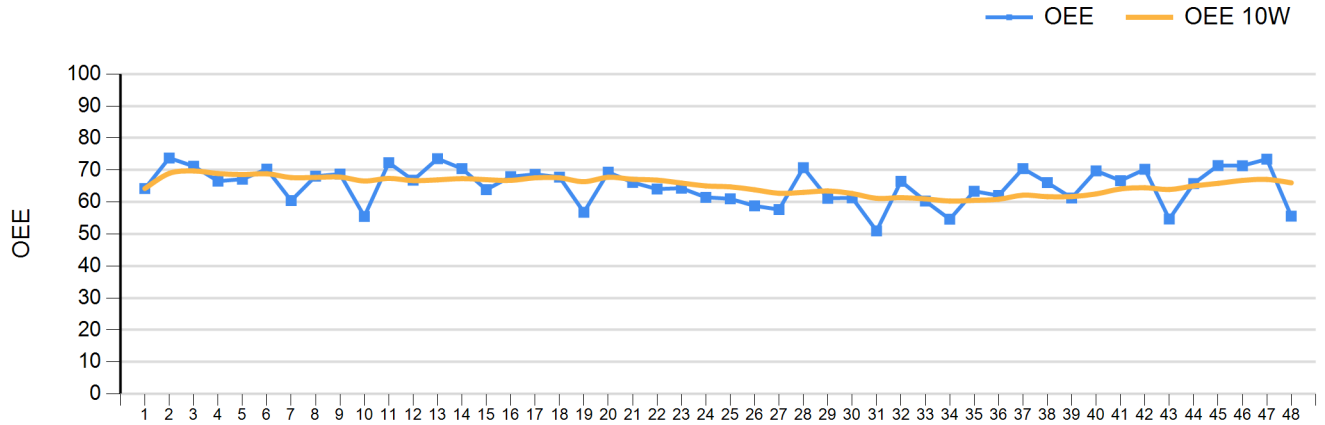


TOP 10 DOWNTIMES CATEGORY (Duration & Number of frequency)





OEE TREND / WEEK



MO SPECIFICATION

ORDER	TOTAL UNITS	PRODUCT	START	END
261295	2064	CB62H_82_Alloy 304_62	22-11-28 06:00	22-11-28 08:18
265599	2340	AC73_48_Alloy 316_47	22-11-28 08:41	22-11-28 09:37
253264	2302	AC73_48_Alloy 316_47	22-11-28 09:22	22-11-28 10:55
253262	2306	AC73_48_Alloy 316_47	22-11-28 10:04	22-11-28 12:27
252439	2330	AC73_48_Alloy 316_47	22-11-28 12:31	22-11-28 14:11
252438	2312	AC73_48_Alloy 316_47	22-11-28 14:48	22-11-28 16:01
253643	1810	AC73_50_Alloy 316_47	22-11-28 16:58	22-11-28 18:07
268758	2006	CB65_80_Alloy 316_59	22-11-28 18:52	22-11-28 20:38
268759	1830	CB65_80_Alloy 316_59	22-11-28 20:21	22-11-28 22:05
268762	2014	CB65_80_Alloy 316_59	22-11-28 22:54	22-11-28 23:04
268836	3592	CB65_50_Alloy 316_59	22-11-28 23:55	22-11-29 01:05
268788	1918	CB65_50_Alloy 316_59	22-11-29 01:54	22-11-29 02:01
268833	3574	CB65_50_Alloy 316_59	22-11-29 02:58	22-11-29 03:56
268872	3612	CB65_50_Alloy 316_59	22-11-29 03:03	22-11-29 06:06
268873	2994	CB65_36_Alloy 316_59	22-11-29 06:53	22-11-29 08:12
268874	3024	CB65_36_Alloy 316_59	22-11-29 08:47	22-11-29 10:17
269688	2998	CB65_36_Alloy 316_59	22-11-29 10:42	22-11-29 12:36
268885	3018	CB65_36_Alloy 316_59	22-11-29 12:23	22-11-29 14:19
270143	1840	CB65_22_Alloy 316_59	22-11-29 14:40	22-11-29 15:18
269684	1864	CB65_22_Alloy 316_59	22-11-29 15:41	22-11-29 16:32
270626	1914	CB65_80_Alloy 316_59	22-11-29 16:27	22-11-29 18:08
268789	1930	CB65_80_Alloy 316_59	22-11-29 18:51	22-11-29 19:03
268837	3628	CB65_50_Alloy 316_59	22-11-29 19:12	22-11-29 22:37



255492	860	CB65_80_Alloy 316_59	22-11-29 19:43	22-11-29 19:43
243388	1784	CB65_50_Alloy 316_59	22-11-29 22:22	22-11-29 23:30
227189	3300	CB65_46_Alloy 316_59	22-11-29 23:29	22-11-30 01:14
243394	1802	CB65_50_Alloy 316_59	22-11-30 01:45	22-11-30 02:08
264979	2894	CB65_40_Alloy 316_59	22-11-30 02:51	22-11-30 03:55
268739	3020	CB65_36_Alloy 316_59	22-11-30 03:04	22-11-30 05:21
268740	3096	CB65_36_Alloy 316_59	22-11-30 05:38	22-11-30 08:41
252437	2506	AC73_48_Alloy 316_47	22-11-30 08:18	22-11-30 10:59
252436	2294	AC73_48_Alloy 316_47	22-11-30 10:00	22-11-30 12:16
253646	1804	AC73_48_Alloy 316_47	22-11-30 12:43	22-11-30 13:22
268453	656	AC73_56_Alloy 316_47	22-11-30 13:25	22-11-30 13:25
268452	668	AC73_56_Alloy 316_47	22-11-30 13:11	22-11-30 14:09
270008	806	AC73_64_Alloy 316_47	22-11-30 14:38	22-11-30 15:29
269333	382	AC73_32_Alloy 316_47	22-11-30 14:12	22-11-30 14:12
266570	1148	CB62A_24_Alloy 316_63	22-11-30 15:30	22-11-30 16:06
266571	1140	CB62A_24_Alloy 316_63	22-11-30 16:39	22-11-30 16:39
266242	1188	CB62A_24_Alloy 316_63	22-11-30 16:13	22-11-30 17:47
266568	1172	CB62A_24_Alloy 316_63	22-11-30 17:12	22-11-30 18:47
269381	2772	CB62H_60_Alloy 316_62	22-11-30 18:12	22-11-30 20:58
269382	4226	CB62H_60_Alloy 316_62	22-11-30 20:02	22-11-30 23:55
268798	2150	CB62H_60_Alloy 316_62	22-11-30 23:04	22-12-01 00:56
269348	2172	CB62H_60_Alloy 316_62	22-12-01 00:03	22-12-01 02:08
268797	2196	CB62H_60_Alloy 316_62	22-12-01 02:34	22-12-01 03:58
267230	574	CB62H_50_Alloy 316_62	22-12-01 02:16	22-12-01 02:16
268763	2388	CB62A_60_Alloy 316_63	22-12-01 03:01	22-12-01 05:35
268776	2418	CB62A_50_Alloy 316_63	22-12-01 05:25	22-12-01 06:44
268777	2394	CB62A_50_Alloy 316_63	22-12-01 06:15	22-12-01 08:02
268778	2434	CB62A_50_Alloy 316_63	22-12-01 08:57	22-12-01 10:33
ffg	700	cb62a_60_316_63	22-12-01 10:26	22-12-01 12:10
268779	2634	CB62A_50_Alloy 316_63	22-12-01 12:49	22-12-01 13:36
271335	2434	CB62A_50_Alloy 316_63	22-12-01 13:23	22-12-01 15:55
271336	2412	CB62A_50_Alloy 316_63	22-12-01 15:04	22-12-01 18:00
271080	2852	CB60M_50_Alloy 316_67	22-12-01 18:59	22-12-01 19:53
271081	2814	CB60M_50_Alloy 316_67	22-12-01 19:06	22-12-01 22:38
271078	5312	CB30M_50_Alloy 316_39	22-12-01 22:21	22-12-02 17:06
271529	4608	CB30M_50_Alloy 316_39	22-12-02 17:53	22-12-02 19:31



271530	4636	CB30M_50_Alloy 316_39	22-12-02 19:28	22-12-02 22:51
271713	2470	CB65_50_Alloy 316_59	22-12-02 22:08	22-12-03 08:30
271714	1930	CB65_80_Alloy 316_59	22-12-03 08:29	22-12-03 09:36
268838	3594	CB65_50_Alloy 316_59	22-12-03 09:23	22-12-03 11:49
268839	3678	CB65_50_Alloy 316_59	22-12-03 11:10	22-12-03 13:57
268840	3622	CB65_50_Alloy 316_59	22-12-03 13:02	22-12-03 16:02
261382	2524	CB65_30_Alloy 316_59	22-12-03 16:08	22-12-03 19:10
256377	1520	CB65_50_Alloy 316_59	22-12-03 16:49	22-12-03 16:49
261385	2520	CB65_30_Alloy 316_59	22-12-03 19:50	22-12-03 21:03
246691	792	CB65_22_Alloy 316_59	22-12-03 21:17	22-12-03 22:34
243389	480	CB65_20_Alloy 316_59	22-12-03 21:39	22-12-03 21:39
228720	1638	CB65_46_Alloy 316_59	22-12-03 22:25	22-12-04 00:10
246694	814	CB65_22_Alloy 316_59	22-12-04 00:23	22-12-04 00:23
246692	794	CB65_22_Alloy 316_59	22-12-04 00:11	22-12-04 01:23
243218	240	CB65_20_Alloy 316_59	22-12-04 00:14	22-12-04 00:14
268735	3236	CB65_44_Alloy 304_59	22-12-04 01:00	22-12-04 03:52
246693	792	CB65_22_Alloy 316_59	22-12-04 01:35	22-12-04 01:35
268832	3178	CB65_44_Alloy 304_59	22-12-04 03:07	22-12-04 05:49
268834	3160	CB65_44_Alloy 304_59	22-12-04 05:10	22-12-04 07:23
258490	2212	CB65_70_Alloy 304_59	22-12-04 07:36	22-12-04 08:41
258491	2220	CB65_70_Alloy 304_59	22-12-04 08:18	22-12-04 10:02
268835	3122	CB65_44_Alloy 304_59	22-12-04 10:56	22-12-04 12:08
268487	34	CB65_70_Alloy 304_59	22-12-04 10:00	22-12-04 10:00
268877	3128	CB65_44_Alloy 304_59	22-12-04 12:51	22-12-04 13:55
272149	3174	CB65_44_Alloy 304_59	22-12-04 13:04	22-12-04 15:56
272150	3166	CB65_44_Alloy 304_59	22-12-04 15:03	22-12-04 17:56
272333	3172	CB65_44_Alloy 304_59	22-12-04 17:03	22-12-04 20:10
268846	3264	CB65_44_Alloy 316_59	22-12-04 20:49	22-12-04 22:18
268847	3170	CB65_44_Alloy 316_59	22-12-04 22:41	22-12-05 00:08
272222	1834	CB65_22_Alloy 316_59	22-12-05 00:51	22-12-05 01:05
272223	1862	CB65_22_Alloy 316_59	22-12-05 01:54	22-12-05 02:12
268880	3620	CB65_50_Alloy 316_59	22-12-05 02:47	22-12-05 04:40
225512	2392	CB65_50_Alloy 316_59	22-12-05 04:19	22-12-05 06:00

OEE DETAILS SPECIFIKATION / PRODUCT



PRODUCT	AVAILABILITY	PERFORMANCE	OEE	TOTAL UNITS
CB30M_50_Alloy 316_39	27,9	99,6	27,8	14556
CB60M_50_Alloy 316_67	58,6	96,6	56,6	5666
CB62A_50_Alloy 316_63	63,7	94,0	59,9	22462
AC73_64_Alloy 316_47	71,9	87,3	62,7	22516
CB65_50_Alloy 316_59	69,4	93,9	65,2	131864
CB62H_60_Alloy 316_62	66,5	98,0	65,2	16154