

Production Date

Aug 16, 2022

AUG 2022

1213141516171819202122232425262728

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 10 Hrs. already and CIP is due on August 18 2022 8:14 AM

Line 2 : Running for already and CIP is due on

Line 3 : Running for --- already and CIP is due on ---

Line 4 : Running for already and CIP is due on

Line 5 : Running for already and CIP is due on

Line 7 : Running for 21 Hrs. already and CIP is due on August 17 2022 9:27 PM

Date: August 16, 2022

Utilization: 29.30%

%OEE: 46.64%

Output: 21,503

Daily Performance Summary for All Production Lines

	L07	L03	L01	L02	L06	L05	L04
[Capacity_Utilization_%]	100.00%	5.07%	100.00%	0.00%	0.00%	0.00%	0.00%
[OEE_%]	65.10%	63.00%	27.35%				
[Net Output Count CASES]	13,887	876	6,740	0	0	0	0

L01 SHOWNL02 HIDDENL03 SHOWNL04 HIDDENL05 HIDDENL07 SHOWN

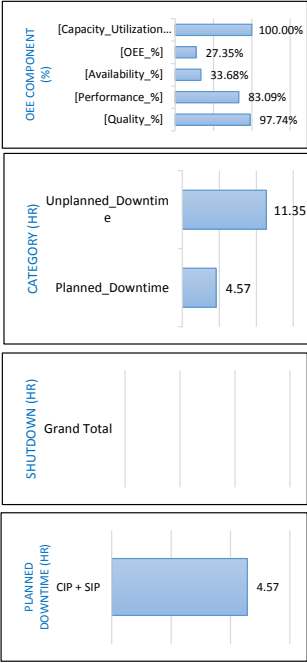
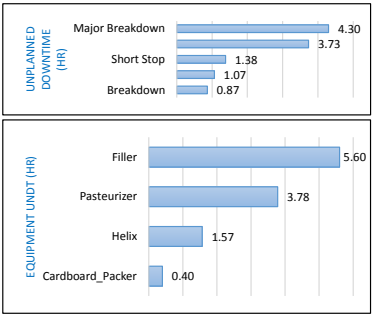
L01 AUTOFITL03 AUTOFITL07 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mango Drink 250 mL x 18 + 3]	[Aug 16] 6:00 AM	[Aug 16] 11:56 AM	356 Mins	5.93 Hrs.	4,069 Cases
CIP + SIP	[Aug 16] 11:56 AM	[Aug 16] 4:30 PM	274 Mins	4.57 Hrs.	
Delay [Pasteurizer: Sterilization Malfunction]	[Aug 16] 4:30 PM	[Aug 16] 6:00 PM	90 Mins	1.50 Hrs.	
Delay [Pasteurizer: Sterilization Malfunction]	[Aug 16] 6:00 PM	[Aug 16] 8:14 PM	134 Mins	2.23 Hrs.	
Production Start of Cycle [Qobtan Orange Flavored 250 mL x 27]	[Aug 16] 8:14 PM	[Aug 16] 8:34 PM	20 Mins	0.33 Hrs.	27 Cases
Major Breakdown [Filler: Aseptic Chamber Pressure Roller Broken/Damaged]	[Aug 16] 8:34 PM	[Aug 17] 12:52 AM	258 Mins	4.30 Hrs.	
Production [Qobtan Orange Flavored 250 mL x 27]	[Aug 17] 12:52 AM	[Aug 17] 6:00 AM	308 Mins	5.13 Hrs.	2,644 Cases
TOTAL			1,440 Mins	24.00 Hrs.	6,740 Cases

- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
1. [Weak Sealing ] Filler Aseptic Chamber Pressure Roller Broken/Damaged [1x/ 4.30 Hrs. OR 258 Mins.]

2. Pasteurizer Sterilization Malfunction [2x/ 3.73 Hrs. OR 224 Mins.]

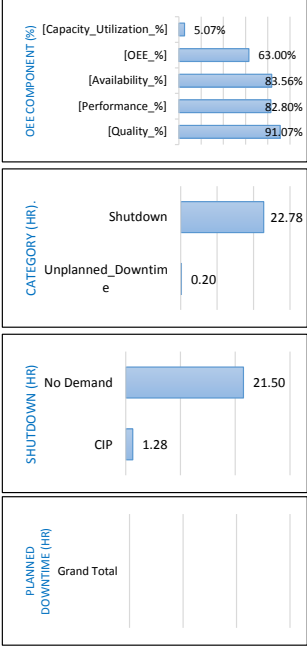
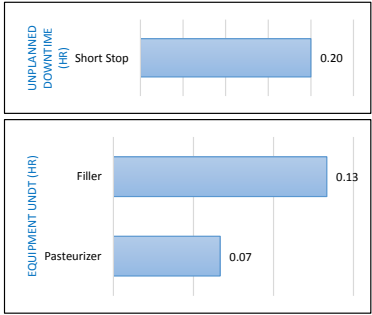
3. Helix Spider Belt Jammed Packs [1x/ 0.87 Hrs. OR 52 Mins.]



LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Orange Drink 125 mL x 18 + 3]	[Aug 16] 6:00 AM	[Aug 16] 7:13 AM	73 Mins	1.22 Hrs.	876 Cases
Shutdown [CIP]	[Aug 16] 7:13 AM	[Aug 16] 8:30 AM	77 Mins	1.28 Hrs.	
Shutdown [No Demand]	[Aug 16] 8:30 AM	[Aug 16] 6:00 PM	570 Mins	9.50 Hrs.	
Shutdown [No Demand]	[Aug 16] 6:00 PM	[Aug 17] 6:00 AM	720 Mins	12.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	876 Cases

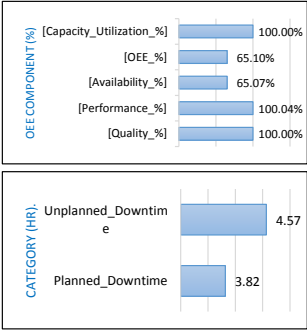
- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
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- TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]
1. Filler Design Correction Alarm [1x/ 0.13 Hrs. OR 8 Mins.]

2. Pasteurizer No Product [1x/ 0.07 Hrs. OR 4 Mins.]



LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
CIP + SIP	[Aug 16] 6:00 AM	[Aug 16] 9:27 AM	207 Mins	3.45 Hrs.	
Production Start of Cycle [Original Mixfruit Nectar 200 mL x 27]	[Aug 16] 9:27 AM	[Aug 16] 6:00 PM	513 Mins	8.55 Hrs.	5,844 Cases
Production [Original Mixfruit Nectar 200 mL x 27]	[Aug 16] 6:00 PM	[Aug 17] 6:00 AM	720 Mins	12.00 Hrs.	8,043 Cases
TOTAL			1,440 Mins	24.00 Hrs.	13,887 Cases

- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
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1. Filler Track 6 Speed Loss [1x/ 3.20 Hrs. OR 192 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Straw\_Applicator Missing/Fallen Straws [5x/ 0.52 Hrs. OR 31 Mins.]
- 2. Tray\_Packer Jammed Packs [5x/ 0.47 Hrs. OR 28 Mins.]
- 3. Pasteurizer No Product [2x/ 0.30 Hrs. OR 18 Mins.]
- 4. Tray\_Shrink Change Plastic [1x/ 0.08 Hrs. OR 5 Mins.]

