

Production Date

Aug 2, 2022

JUL 2022

20

21

22

23

24

25

26

27

28

29

30

31

1

2

3

4

5

AUG 2022

←

→

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 7 Hrs. already and CIP is due on August 4 2022 10:22 AM

Line 2 : Running for already and CIP is due on

Line 3 : Running for 40 Hrs. already and CIP is due on August 3 2022 1:49 AM

Line 4 : Running for already and CIP is due on

Line 5 : Running for already and CIP is due on

Line 7 : Running for already and CIP is due on

Date: August 2, 2022

Utilization: 27.08%

%OEE: 32.20%

Output: 14,959

Daily Performance Summary for All Production Lines

12,000

10,000

8,000

6,000

4,000

2,000

0

L03

L01

L06

L05

L07

L02

L04

100.00%

89.58%

0.00%

0.00%

0.00%

0.00%

0.00%

39.27%

24.30%

0.00%

0.00%

0.00%

0.00%

0.00%

10,772

4,187

0

0

0

0

0

[Capacity\_Utilization\_%]

[OEE\_%]

[Net Output Count CASES]

L01 SHOWN

L02 HIDDEN

L03 SHOWN

L04 HIDDEN

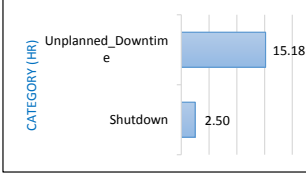
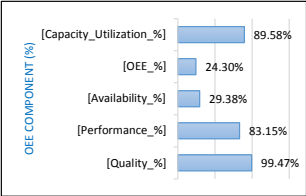
L05 HIDDEN

L07 HIDDEN

L01 AUTOFIT

L03 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mixfruit Drink 250 mL x 27 + 3]	[Aug 2] 6:00 AM	[Aug 2] 11:55 AM	355 Mins	5.92 Hrs.	2,329 Cases
Major Breakdown [Cardboard_Packer: Electrical Devices Error/ Fault]	[Aug 2] 11:55 AM	[Aug 2] 6:00 PM	365 Mins	6.08 Hrs.	
Major Breakdown [Filler: Hydrogen Peroxide Spray System Malfunction]	[Aug 2] 6:00 PM	[Aug 2] 10:22 PM	262 Mins	4.37 Hrs.	
Production Start of Cycle [Original Mixfruit Drink 250 mL x 27 + 3]	[Aug 2] 10:22 PM	[Aug 3] 1:18 AM	176 Mins	2.93 Hrs.	1,782 Cases
Shutdown [Change Over]	[Aug 3] 1:18 AM	[Aug 3] 3:48 AM	150 Mins	2.50 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 3] 3:48 AM	[Aug 3] 4:18 AM	30 Mins	0.50 Hrs.	77 Cases
Major Breakdown [Filler: Paper Misalignment]	[Aug 3] 4:18 AM	[Aug 3] 6:00 AM	102 Mins	1.70 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	4,188 Cases



- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
1. Cardboard\_Packer Electrical Devices Error/ Fault [1x/ 6.08 Hrs. OR 365 Mins.]

2. Filler Hydrogen Peroxide Spray System Malfunction [1x/ 4.37 Hrs. OR 262 Mins.]

3. Filler Paper Misalignment [1x/ 1.70 Hrs. OR 102 Mins.]
- TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]
1. Cardboard\_Packer Electrical Devices Error/ Fault [3x/ 0.92 Hrs. OR 55 Mins.]

2. [Jammed Packs] Helix Conveyor Chain Assembly Broken/Damaged [1x/ 0.60 Hrs. OR 36 Mins.]

3. Filler Paper Overlap [1x/ 0.38 Hrs. OR 23 Mins.]

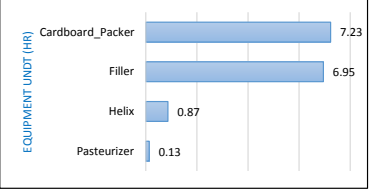
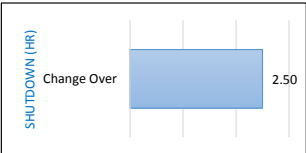
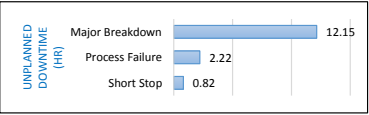
4. Filler Hydrogen Peroxide Out of Range [1x/ 0.28 Hrs. OR 17 Mins.]

5. Helix Spider Belt Jammed Packs [1x/ 0.27 Hrs. OR 16 Mins.]

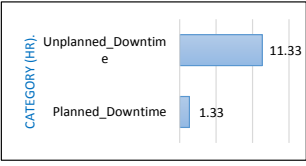
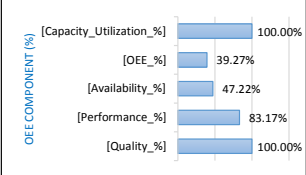
6. Cardboard\_Packer Tray Transport Jammed Packs [1x/ 0.23 Hrs. OR 14 Mins.]

7. Filler ASSU Automatic Strip Splicing Unit Malfunction [1x/ 0.22 Hrs. OR 13 Mins.]

8. Pasteurizer Checking Brix [1x/ 0.13 Hrs. OR 8 Mins.]



LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Cardboard_Packer: Servomotor Malfunction]	[Aug 2] 6:00 AM	[Aug 2] 6:54 AM	54 Mins	0.90 Hrs.	
Production [Original Mango Drink 125 mL x 18 + 3]	[Aug 2] 6:54 AM	[Aug 2] 11:50 AM	296 Mins	4.93 Hrs.	2,389 Cases
Major Breakdown [Cardboard_Packer: Transport Chain Planetray Gear Error/ Fault]	[Aug 2] 11:50 AM	[Aug 2] 3:10 PM	200 Mins	3.33 Hrs.	
Production [Original Mango Drink 125 mL x 18 + 3]	[Aug 2] 3:10 PM	[Aug 2] 6:00 PM	170 Mins	2.83 Hrs.	1,605 Cases
Production [Original Mango Drink 125 mL x 18 + 3]	[Aug 2] 6:00 PM	[Aug 3] 4:40 AM	640 Mins	10.67 Hrs.	6,778 Cases
CIP + SIP	[Aug 3] 4:40 AM	[Aug 3] 6:00 AM	80 Mins	1.33 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	10,772 Cases



- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
1. Cardboard\_Packer Transport Chain Planetray Gear Error/ Fault [1x/ 3.33 Hrs. OR 200 Mins.]

2. Cardboard\_Packer Servomotor Malfunction [1x/ 0.90 Hrs. OR 54 Mins.]

3. Filler Final Folder Top Squeezer Adjustment [1x/ 0.80 Hrs. OR 48 Mins.]
- TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]
1. Cardboard\_Packer jammed packs [7x/ 1.38 Hrs. OR 83 Mins.]

2. Helix Spider Belt Fallen Packs [8x/ 1.12 Hrs. OR 67 Mins.]

3. Straw\_Applicator Missing/Fallen Straws [4x/ 0.98 Hrs. OR 59 Mins.]

4. Filler ASU Automatic Splicing Unit Malfunction [2x/ 0.62 Hrs. OR 37 Mins.]

5. Helix Spider Belt Belt Wornout [1x/ 0.35 Hrs. OR 21 Mins.]

6. Tray\_Shrink Jammed Packs [2x/ 0.33 Hrs. OR 20 Mins.]

7. Cardboard\_Packer Divider Jammed Packs [2x/ 0.28 Hrs. OR 17 Mins.]

8. Tray\_Shrink Jammed [2x/ 0.23 Hrs. OR 14 Mins.]

