

Production Date

Aug 4, 2022

DAYS

JUL 2022

AUG 2022

23242526272829303112345678

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for

already and CIP is due on

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

already and CIP is due on

Date:
August 4, 2022

Utilization:
16.95%

%OEE:
48.92%

Output:
15,121

Daily Performance Summary for All Production Lines

L03

L01

L06

L05

L07

L02

L04

70.90%

47.78%

0.00%

0.00%

0.00%

0.00%

0.00%

63.31%

27.56%

12,312

2,809

0

0

0

0

0

[Capacity_Utilization_%]

[OEE_%]

[Net Output Count CASES]

L01 SHOWN

L02 HIDDEN

L03 SHOWN

L04 HIDDEN

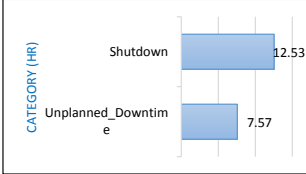
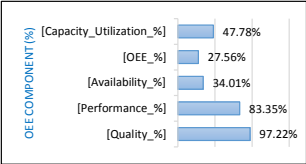
L05 HIDDEN

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 [Qobtan Apple Flavored 250 mL x 27]	[Aug 4] 6:00 AM	[Aug 4] 7:18 AM	78 Mins	1.30 Hrs.	890 Cases
Major Breakdown [Filler: LS Longitudinal Sealing	[Aug 4] 7:18 AM	[Aug 4] 1:36 PM	378 Mins	6.30 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 4] 1:36 PM	[Aug 4] 5:28 PM	232 Mins	3.87 Hrs.	1,919 Cases
Shutdown [CIP]	[Aug 4] 5:28 PM	[Aug 4] 6:00 PM	32 Mins	0.53 Hrs.	
Shutdown [Weekend]	[Aug 4] 6:00 PM	[Aug 5] 6:00 AM	720 Mins	12.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	2,809 Cases



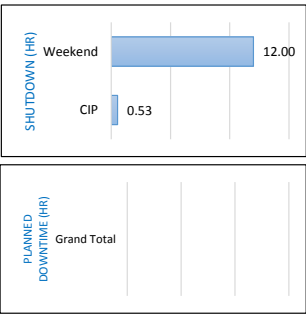
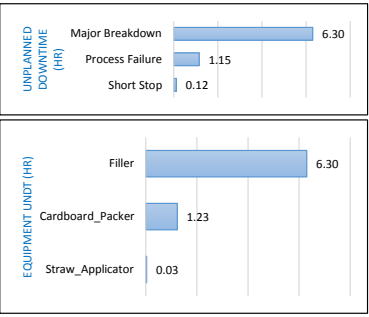
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. [Accumulated Aluminium] Filler LS Longitudinal Sealing Malfunction [1x/ 6.30 Hrs. OR 378 Mins.]

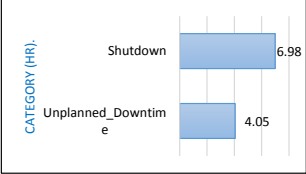
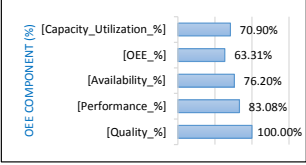
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer Electrical Devices Error/ Fault [3x/ 1.23 Hrs. OR 74 Mins.]

2. Straw_Applicator Missing/Fallen Straws [1x/ 0.03 Hrs. OR 2 Mins.]



LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 4] 6:00 AM	[Aug 4] 6:00 PM	720 Mins	12.00 Hrs.	7,984 Cases
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 4] 6:00 PM	[Aug 4] 11:01 PM	301 Mins	5.02 Hrs.	4,329 Cases
Shutdown [CIP]	[Aug 4] 11:01 PM	[Aug 5] 12:30 AM	89 Mins	1.48 Hrs.	
Shutdown [Weekend]	[Aug 5] 12:30 AM	[Aug 5] 6:00 AM	330 Mins	5.50 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	12,313 Cases



TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Helix Spider Belt Fallen Packs [7x/ 1.12 Hrs. OR 67 Mins.]

2. Cardboard_Packer jammed packs [6x/ 0.90 Hrs. OR 54 Mins.]

3. Filler ASU Automatic Splicing Unit Malfunction [4x/ 0.60 Hrs. OR 36 Mins.]

4. Straw_Applicator Missing/Fallen Straws [2x/ 0.42 Hrs. OR 25 Mins.]

5. Cardboard_Packer Flight Bar Jammed Packs [2x/ 0.27 Hrs. OR 16 Mins.]

6. Tray_Shrink Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

7. Filler Final Folder Jammed Packs [1x/ 0.15 Hrs. OR 9 Mins.]

8. Filler Hydrogen Peroxide Out of Range [2x/ 0.13 Hrs. OR 8 Mins.]

