

Production Date

Aug 9, 2022

DAYS ▾

JUL 2022

AUG 2022

29

30

31

1

2

3

4

5

6

7

8

9

10

11

12

13

14

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PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for

10 Hrs.

already and CIP is due on

August 11 2022 8:50 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

8 Hrs.

already and CIP is due on

August 11 2022 10:46 AM

Date:

August 9, 2022

Utilization:

20.50%

%OEE:

34.61%

Output:

12,696

Daily Performance Summary for All Production Lines

7,000

6,000

5,000

4,000

3,000

2,000

1,000

0

L07

L01

L05

L02

L06

L03

L04

140.00%

120.00%

100.00%

80.00%

60.00%

40.00%

20.00%

0.00%

■ [Capacity_Utilization_%]

50.00%

93.47%

0.00%

0.00%

0.00%

0.00%

0.00%

■ [OEE_%]

39.41%

32.05%

● [Net Output Count CASES]

6,305

6,391

0

0

0

0

0

L01 SHOWN

L02 HIDDEN

L03 HIDDEN

L04 HIDDEN

L05 HIDDEN

L07 SHOWN

L01 AUTOFIT

L07 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Orange Flavored 250 mL x 27]	[Aug 9] 6:00 AM	[Aug 9] 10:03 AM	243 Mins	4.05 Hrs.	2,912 Cases
CIP + SIP	[Aug 9] 10:03 AM	[Aug 9] 3:03 PM	300 Mins	5.00 Hrs.	
Delay [Filler: Aseptic Chamber Spray System Slow Emptying]	[Aug 9] 3:03 PM	[Aug 9] 6:00 PM	177 Mins	2.95 Hrs.	
Delay [Filler: Aseptic Chamber Spray System Slow Emptying]	[Aug 9] 6:00 PM	[Aug 9] 8:50 PM	170 Mins	2.83 Hrs.	
Production Start of Cycle [Qobtan Orange Flavored 250 mL x 27]	[Aug 9] 8:50 PM	[Aug 9] 9:00 PM	10 Mins	0.17 Hrs.	
Major Breakdown [Pasteurizer: Low Flow Rate]	[Aug 9] 9:00 PM	[Aug 9] 11:33 PM	153 Mins	2.55 Hrs.	
Production [Qobtan Orange Flavored 250 mL x 27]	[Aug 9] 11:33 PM	[Aug 10] 4:05 AM	272 Mins	4.53 Hrs.	3,219 Cases
Shutdown [Change Flavor]	[Aug 10] 4:05 AM	[Aug 10] 5:39 AM	94 Mins	1.57 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Aug 10] 5:39 AM	[Aug 10] 6:00 AM	21 Mins	0.35 Hrs.	259 Cases
TOTAL			1,440 Mins	24.00 Hrs.	6,390 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

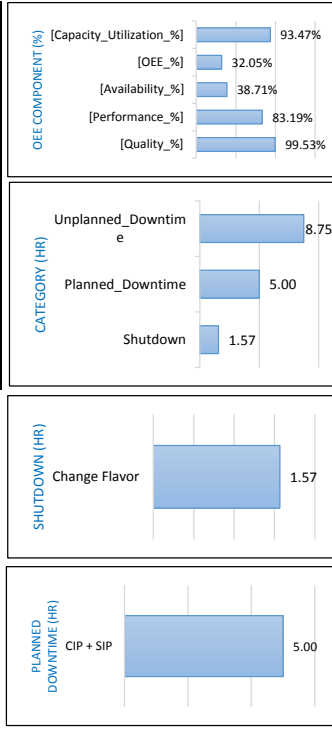
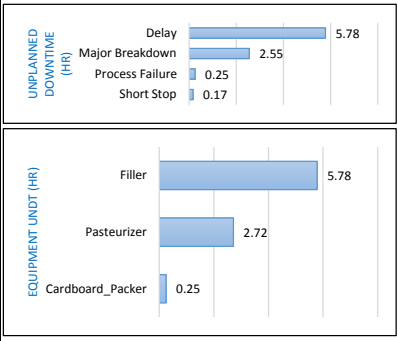
1. Filler Aseptic Chamber Spray System Slow Emptying [2x/ 5.78 Hrs. OR 347 Mins.]

2. [Low Brix] Pasteurizer Low Flow Rate [1x/ 2.55 Hrs. OR 153 Mins.]

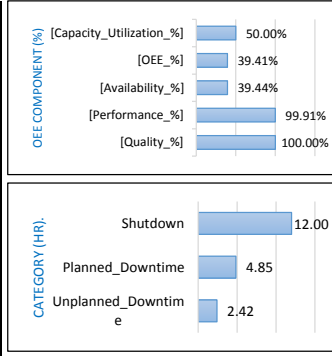
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer jammed packs [1x/ 0.25 Hrs. OR 15 Mins.]

2. Pasteurizer Checking Brix [1x/ 0.17 Hrs. OR 10 Mins.]



LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [No Demand]	[Aug 9] 6:00 AM	[Aug 9] 6:00 PM	720 Mins	12.00 Hrs.	
CIP + SIP	[Aug 9] 6:00 PM	[Aug 9] 10:46 PM	286 Mins	4.77 Hrs.	
Production Start of Cycle [Original Orange NASOS 200 mL x 15 + 3]	[Aug 9] 10:46 PM	[Aug 10] 6:00 AM	434 Mins	7.23 Hrs.	6,305 Cases
TOTAL			1,440 Mins	24.00 Hrs.	6,305 Cases



TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Filler TS Transversal Sealing Track 6 Adjustment [5x/ 0.87 Hrs. OR 52 Mins.]
- 2. [Open Tray] Tray_Packer Glue Unit Glue Nozzle Clogged [2x/ 0.50 Hrs. OR 30 Mins.]
- 3. Tray_Packer Jammed Packs [4x/ 0.48 Hrs. OR 29 Mins.]
- 4. Filler Track 6 Speed Loss [1x/ 0.42 Hrs. OR 25 Mins.]
- 5. Auto_Palletizer Conveyor Full [2x/ 0.15 Hrs. OR 9 Mins.]

