

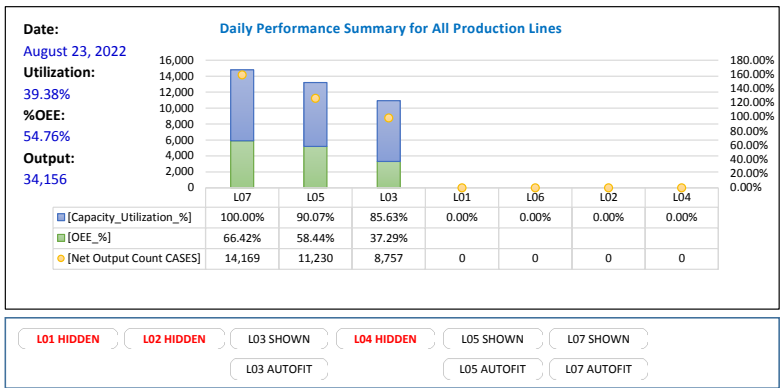
Production Date

Aug 23, 2022 DAYS ▾

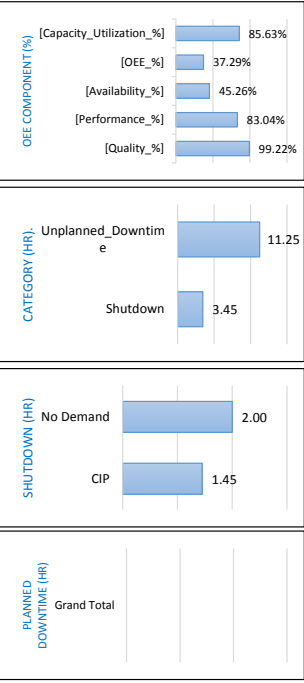
AUG 2022

12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28
											23					

◀ ▶



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 23] 6:00 AM	[Aug 23] 10:30 AM	270 Mins	4.50 Hrs.	3,191 Cases
Major Breakdown [Filler: Electrical Cabinet Safety Relay Error/ Fault]	[Aug 23] 10:30 AM	[Aug 23] 3:30 PM	300 Mins	5.00 Hrs.	
Major Breakdown [Pasteurizer: Valve Leaking]	[Aug 23] 3:30 PM	[Aug 23] 6:00 PM	150 Mins	2.50 Hrs.	
Major Breakdown [Pasteurizer: Valve Leaking]	[Aug 23] 6:00 PM	[Aug 23] 6:49 PM	49 Mins	0.82 Hrs.	
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 23] 6:49 PM	[Aug 24] 2:33 AM	464 Mins	7.73 Hrs.	5,566 Cases
Shutdown [CIP]	[Aug 24] 2:33 AM	[Aug 24] 4:00 AM	87 Mins	1.45 Hrs.	
Shutdown [No Demand]	[Aug 24] 4:00 AM	[Aug 24] 6:00 AM	120 Mins	2.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	8,757 Cases
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]					
1. Filler Electrical Cabinet Safety Relay Error/ Fault [1x/ 5.00 Hrs. OR 300 Mins.]					
2. Pasteurizer Valve Leaking [2x/ 3.32 Hrs. OR 199 Mins.]					
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]					
1. Filler Final Folder Jammed Packs [4x/ 0.65 Hrs. OR 39 Mins.]					
2. Cardboard_Packer Tray Transport Vacuum Tray Jammed [4x/ 0.63 Hrs. OR 38 Mins.]					
3. Straw_Applicator Missing/Fallen Straws [5x/ 0.57 Hrs. OR 34 Mins.]					
4. Cardboard_Packer Infeed Divider Jammed Packs [3x/ 0.50 Hrs. OR 30 Mins.]					
5. Pasteurizer No Product [2x/ 0.22 Hrs. OR 13 Mins.]					
6. Cardboard_Packer jammed packs [1x/ 0.18 Hrs. OR 11 Mins.]					
7. Trolley Delayed [1x/ 0.10 Hrs. OR 6 Mins.]					
8. Filler Hydrogen Peroxide Out of Range [2x/ 0.08 Hrs. OR 5 Mins.]					



LINE 5 COMBIBLOC CBW 724

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Orange Drink 200 mL x 27]	[Aug 23] 6:00 AM	[Aug 23] 6:00 PM	720 Mins	12.00 Hrs.	5,605 Cases
Production [Original Orange Drink 200 mL x 27]	[Aug 23] 6:00 PM	[Aug 23] 11:54 PM	354 Mins	5.90 Hrs.	3,912 Cases
Shutdown [Change Flavor]	[Aug 23] 11:54 PM	[Aug 24] 2:17 AM	143 Mins	2.38 Hrs.	
Production [Original Mango Drink 200 mL x 27]	[Aug 24] 2:17 AM	[Aug 24] 6:00 AM	223 Mins	3.72 Hrs.	1,713 Cases
TOTAL			1,440 Mins	24.00 Hrs.	11,230 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Track 6 Speed Loss [1x/ 2.65 Hrs. OR 159 Mins.]

UNPLANNED DOWNTIME (HR)

Short Stop

Process Failure

Breakdown

3.47

2.67

2.65

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. [Missing/Fallen Straws] Straw_Applicator Grooved Wheel Broken/Damaged [5x/ 1.50 Hrs. OR 90 Mins.]

2. Tray_Packer Open Tray [5x/ 1.18 Hrs. OR 71 Mins.]

3. Straw_Applicator Missing/Fallen Straws [7x/ 0.93 Hrs. OR 56 Mins.]

4. Auto_Palletizer Rollers Broken/Damaged [2x/ 0.72 Hrs. OR 43 Mins.]

5. Buffer_Table Fallen Packs [4x/ 0.62 Hrs. OR 37 Mins.]

6. Tray_Packer Jammed Packs [5x/ 0.58 Hrs. OR 35 Mins.]

7. [Missing/Fallen Straws] Straw_Applicator Sensor Malfunction [2x/ 0.33 Hrs. OR 20 Mins.]

8. [Missing/Fallen Straws] Straw_Applicator Hotmet Equipment Nozzle Dirty [1x/ 0.22 Hrs. OR 13 Mins.]

EQUIPMENT DOWNTIME (HR)

Straw_Applicator

Filler

Tray_Packer

Auto_Palletizer

Buffer_Table

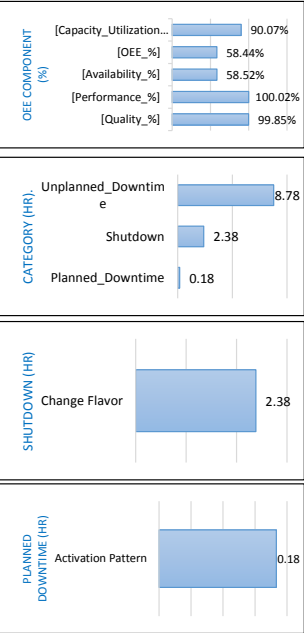
2.98

2.65

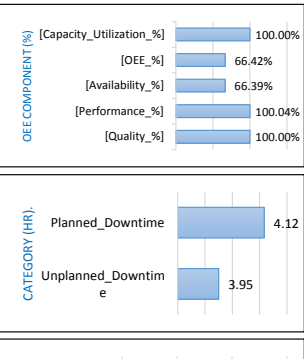
1.77

0.77

0.62



LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
CIP + SIP	[Aug 23] 6:00 AM	[Aug 23] 9:46 AM	226 Mins	3.77 Hrs.	
Production Start of Cycle [Original Apple Nectar 200 mL x 27]	[Aug 23] 9:46 AM	[Aug 23] 6:00 PM	494 Mins	8.23 Hrs.	5,970 Cases
Production [Original Apple Nectar 200 mL x 27]	[Aug 23] 6:00 PM	[Aug 24] 6:00 AM	720 Mins	12.00 Hrs.	8,199 Cases
TOTAL			1,440 Mins	24.00 Hrs.	14,169 Cases
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]					



TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray_Packer Jammed Packs [12x/ 1.63 Hrs. OR 98 Mins.]
- 2. Straw_Applicator Missing/Fallen Straws [5x/ 0.65 Hrs. OR 39 Mins.]
- 3. Filler Outfeed Conveyor Jammed Packs [1x/ 0.47 Hrs. OR 28 Mins.]
- 4. Buffer_Table Outfeed Belt Jammed Packs [1x/ 0.25 Hrs. OR 15 Mins.]
- 5. [Missing/Fallen Straws] Straw_Applicator Applicator Unit Cleaning [1x/ 0.23 Hrs. OR 14 Mins.]
- 6. Buffer_Table Jammed Packs [1x/ 0.22 Hrs. OR 13 Mins.]
- 7. Other ODS Validation [1x/ 0.20 Hrs. OR 12 Mins.]
- 8. Filler Magazine Feeder Track 3 Error/ Fault [1x/ 0.13 Hrs. OR 8 Mins.]

