

Production Date

Jun 26, 2022

DAYS ▾

JUN 2022

1415161718192021222324252627282930

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 32 Hrs. already and CIP is due on June 27 2022 12:05 PM

Line 2 : Running for 32 Hrs. already and CIP is due on June 27 2022 12:05 PM

Line 3 : Running for already and CIP is due on

Line 4 : Running for 14 Hrs. already and CIP is due on June 28 2022 5:51 AM

Line 5 : Running for already and CIP is due on

Line 7 : Running for already and CIP is due on

Date: June 26, 2022

Utilization: 39.29%

%OEE: 54.57%

Output: 27,950

Daily Performance Summary for All Production Lines

14,00012,00010,0008,0006,0004,0002,0000

L01L04L02L07L06L03L05

100.00%75.00%100.00%0.00%0.00%0.00%0.00%

68.97%52.53%41.08%

12,2498,4057,296000000

L01 SHOWNL02 SHOWNL03 HIDDENL04 SHOWNL05 HIDDENL07 HIDDEN

L01 AUTOFITL02 AUTOFITL04 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 26] 6:00 AM	[Jun 26] 6:00 PM	720 Mins	12.00 Hrs.	7,376 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 26] 6:00 PM	[Jun 27] 12:10 AM	370 Mins	6.17 Hrs.	4,029 Cases
Major Breakdown [Filler: LS Inductor Alarm]	[Jun 27] 12:10 AM	[Jun 27] 4:26 AM	256 Mins	4.27 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 27] 4:26 AM	[Jun 27] 6:00 AM	94 Mins	1.57 Hrs.	844 Cases
TOTAL			1,440 Mins	24.00 Hrs.	12,249 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

100.00%

68.97%

68.96%

100.01%

100.00%

CATEGORY (HR)

Unplanned_Downtime

7.45

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler LS Inductor Alarm [1x/ 4.27 Hrs. OR 256 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

Short Stop

Process Failure

4.27

2.55

0.63

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Straw_Applicator Missing/Fallen Straws [6x/ 1.00 Hrs. OR 60 Mins.]

2. Cardboard_Packer Electrical Devices Malfunction [2x/ 0.55 Hrs. OR 33 Mins.]

3. Filler ASU Automatic Splicing Unit Photocell Alarm [3x/ 0.38 Hrs. OR 23 Mins.]

4. Cardboard_Packer jammed packs [3x/ 0.30 Hrs. OR 18 Mins.]

5. Filler Hydrogen Peroxide Low Level [2x/ 0.25 Hrs. OR 15 Mins.]

6. Filler Waste Box Alarm [2x/ 0.22 Hrs. OR 13 Mins.]

7. Helix Jammed Packs [1x/ 0.20 Hrs. OR 12 Mins.]

8. Trolley Delayed [1x/ 0.10 Hrs. OR 6 Mins.]

EQUIPMENT UNDT (HR)

Filler

Straw_Applicator

Cardboard_Packer

Helix

Trolley

5.30

1.00

0.85

0.20

0.10

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

Grand Total

LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 26] 6:00 AM	[Jun 26] 2:09 PM	489 Mins	8.15 Hrs.	4,033 Cases
Major Breakdown [Filler: Jaw System Dolly Broken/Damaged]	[Jun 26] 2:09 PM	[Jun 26] 5:54 PM	225 Mins	3.75 Hrs.	
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 26] 5:54 PM	[Jun 26] 5:59 PM	5 Mins	0.08 Hrs.	125 Cases
Major Breakdown [Filler: Final Folder Jammed Packs]	[Jun 26] 5:59 PM	[Jun 26] 6:00 PM	1 Mins	0.02 Hrs.	
Major Breakdown [Filler: Final Folder Jammed Packs]	[Jun 26] 6:00 PM	[Jun 26] 8:26 PM	146 Mins	2.43 Hrs.	
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 26] 8:26 PM	[Jun 27] 4:59 AM	513 Mins	8.55 Hrs.	3,138 Cases
Major Breakdown [Filler: Aseptic Chamber Paper Cut]	[Jun 27] 4:59 AM	[Jun 27] 6:00 AM	61 Mins	1.02 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	7,296 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

100.00%

41.08%

41.11%

99.92%

100.00%

CATEGORY (HR)

Unplanned_Downtime

14.13

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Jaw System Dolly Broken/Damaged [1x/ 3.75 Hrs. OR 225 Mins.]

2. Filler Final Folder Jammed Packs [2x/ 2.45 Hrs. OR 147 Mins.]

3. Filler Aseptic Chamber Paper Cut [1x/ 1.02 Hrs. OR 61 Mins.]

4. Straw_Applicator Missing/Fallen Straws [1x/ 0.87 Hrs. OR 52 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

Short Stop

Process Failure

Breakdown

7.22

4.70

1.35

0.87

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Helix Jammed Packs [8x/ 1.10 Hrs. OR 66 Mins.]

2. Cardboard_Packer Divider Jammed Packs [5x/ 0.92 Hrs. OR 55 Mins.]

3. Cardboard_Packer Open Tray [6x/ 0.85 Hrs. OR 51 Mins.]

4. Straw_Applicator Missing/Fallen Straws [5x/ 0.80 Hrs. OR 48 Mins.]

5. Cardboard_Packer Hang Up [1x/ 0.53 Hrs. OR 32 Mins.]

6. Filler Top Flap Open Flap [1x/ 0.50 Hrs. OR 30 Mins.]

7. Trolley Delayed [2x/ 0.30 Hrs. OR 18 Mins.]

8. Filler ASSU Automatic Strip Splicing Unit Malfunction [x/ 0.28 Hrs. OR 17 Mins.]

EQUIPMENT UNDT (HR)

Filler

Cardboard_Packer

Straw_Applicator

Helix

Trolley

Pasteurizer

8.40

2.53

1.67

1.10

0.30

0.13

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

Grand Total

LINE 4 COMBIBLOC CBB 724					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [No Demand]	[Jun 26] 6:00 AM	[Jun 26] 10:00 AM	240 Mins	4.00 Hrs.	
CIP + SIP	[Jun 26] 10:00 AM	[Jun 26] 1:00 PM	180 Mins	3.00 Hrs.	
Shutdown [Trial Run]	[Jun 26] 1:00 PM	[Jun 26] 3:00 PM	120 Mins	2.00 Hrs.	
Syrup Preparation	[Jun 26] 3:00 PM	[Jun 26] 5:15 PM	135 Mins	2.25 Hrs.	
Supply + Startup	[Jun 26] 5:15 PM	[Jun 26] 5:51 PM	36 Mins	0.60 Hrs.	
Production Start of Cycle [Original Orange Drink 200 mL x 27]	[Jun 26] 5:51 PM	[Jun 26] 6:00 PM	9 Mins	0.15 Hrs.	133 Cases
Production [Original Orange Drink 200 mL x 27]	[Jun 26] 6:00 PM	[Jun 27] 6:00 AM	720 Mins	12.00 Hrs.	8,271 Cases

OEE COMPONENT (%)

[Capacity_Utilization...]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

75.00%

52.53%

46.94%

111.89%

100.00%

CATEGORY (HR)

Planned_Downtime

Shutdown

Unplanned_Downtime

6.05

6.00

3.50

P4 Production Report DASHBOARD v3.xlsm
Printed: 6/27/2022 8:04 AM

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TOTAL				1,440 Mins	24.00 Hrs.	8,404 Cases		
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]				<div>UNPLANNED DOWNTIME (HR)</div> <div>Short Stop2.63</div> <div>Process Failure0.87</div>			<div>SHUTDOWN (HR)</div> <div>No Demand4.00</div> <div>Trial Run2.00</div>	
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]				<div>EQUIPMENT UNDT (HR)</div> <div>Tray_Packer1.52</div> <div>Tray_Shrink0.57</div> <div>Straw_Applicator0.43</div> <div>Auto_Palletizer0.38</div> <div>Buffer_Table0.30</div> <div>Pasteurizer0.18</div> <div>Filler0.12</div>			<div>PLANNED DOWNTIME (HR)</div> <div>CIP + SIP3.00</div> <div>Syrup Preparation2.25</div> <div>Supply + Startup0.60</div> <div>Activation Pattern0.20</div>	
1. Tray_Packer Jammed Packs [8x/ 1.52 Hrs. OR 91 Mins.]								
2. Tray_Shrink Plastic Jammed [3x/ 0.57 Hrs. OR 34 Mins.]								
3. Straw_Applicator Missing/Fallen Straws [2x/ 0.43 Hrs. OR 26 Mins.]								
4. Buffer_Table Jammed Packs [1x/ 0.30 Hrs. OR 18 Mins.]								
5. Auto_Palletizer Fallen Carton [2x/ 0.23 Hrs. OR 14 Mins.]								
6. Pasteurizer No Product [1x/ 0.18 Hrs. OR 11 Mins.]								
7. Auto_Palletizer Adjustment [1x/ 0.15 Hrs. OR 9 Mins.]								
8. Filler Transfer Station Error/ Fault [1x/ 0.12 Hrs. OR 7 Mins.]								

