

Production Date



PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 34 Hrs. already and CIP is due on July 7 2022 9:14 AM

Line 2 : Running for 37 Hrs. already and CIP is due on July 7 2022 6:11 AM

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 40 Hrs. already and CIP is due on July 7 2022 3:05 AM

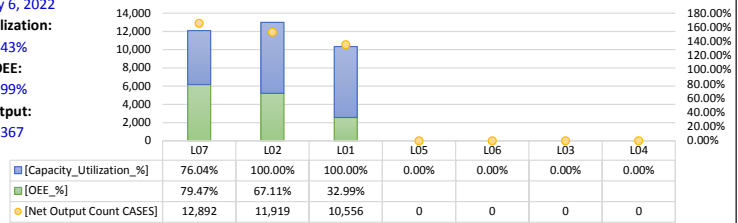
Date: July 6, 2022

Utilization: 39.43%

%OEE: 57.99%

Output: 35,367

Daily Performance Summary for All Production Lines



L01 SHOWN L02 SHOWN L03 HIDDEN L04 HIDDEN L05 HIDDEN L07 SHOWN

L01 AUTOFIT L02 AUTOFIT L07 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML

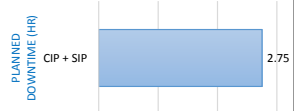
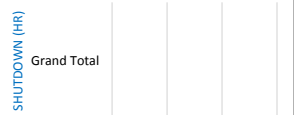
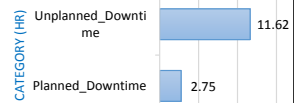
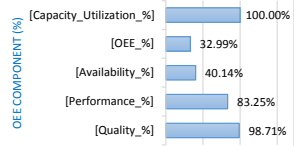
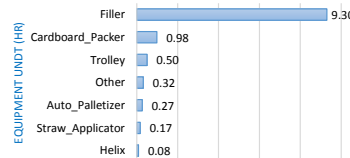
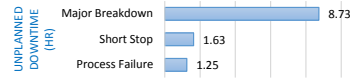
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Filler: Bath Roller Bushing Wornout]	[Jul 6] 6:00 AM	[Jul 6] 9:12 AM	192 Mins	3.20 Hrs.	
Production [Original Mixfruit Drink 250 mL x 18]	[Jul 6] 9:12 AM	[Jul 6] 10:52 AM	100 Mins	1.67 Hrs.	1,527 Cases
Major Breakdown [Filler: ASU Automatic Splicing Unit Weak Sealing]	[Jul 6] 10:52 AM	[Jul 6] 4:24 PM	332 Mins	5.53 Hrs.	
Production [Original Mixfruit Drink 250 mL x 18]	[Jul 6] 4:24 PM	[Jul 6] 6:00 PM	96 Mins	1.60 Hrs.	1,198 Cases
Production [Original Mixfruit Drink 250 mL x 18]	[Jul 6] 6:00 PM	[Jul 7] 3:15 AM	555 Mins	9.25 Hrs.	7,831 Cases
CIP + SIP	[Jul 7] 3:15 AM	[Jul 7] 6:00 AM	165 Mins	2.75 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	10,556 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

- Filler ASU Automatic Splicing Unit Weak Sealing [1x/ 5.53 Hrs. OR 332 Mins.]
- Filler Bath Roller Bushing Wornout [1x/ 3.20 Hrs. OR 192 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- Cardboard\_Packer jammed packs [6x/ 0.98 Hrs. OR 59 Mins.]
- Trolley Delayed [2x/ 0.50 Hrs. OR 30 Mins.]
- Filler ASU Automatic Splicing Unit Malfunction [3x/ 0.37 Hrs. OR 22 Mins.]
- Other Unaccounted Downtime [1x/ 0.32 Hrs. OR 19 Mins.]
- Auto\_Palletizer Outfeed Conveyor Rollers Stuck up [1x/ 0.27 Hrs. OR 16 Mins.]
- Straw\_Applicator Missing/Fallen Straws [1x/ 0.17 Hrs. OR 10 Mins.]
- Filler ASSU Automatic Strip Splicing Unit Malfunction [1x/ 0.13 Hrs. OR 8 Mins.]
- Helix Jammed Packs [1x/ 0.08 Hrs. OR 5 Mins.]



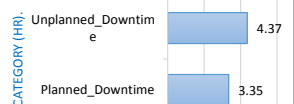
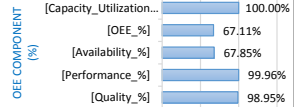
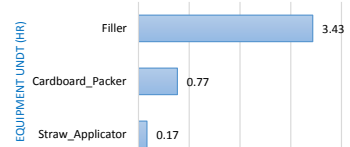
LINE 2 TETRAPAK TBA22 250 ML

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 6] 6:00 AM	[Jul 6] 6:00 PM	720 Mins	12.00 Hrs.	7,493 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 6] 6:00 PM	[Jul 7] 2:39 AM	519 Mins	8.65 Hrs.	4,426 Cases
CIP + SIP	[Jul 7] 2:39 AM	[Jul 7] 6:00 AM	201 Mins	3.35 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	11,919 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

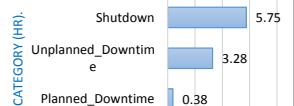
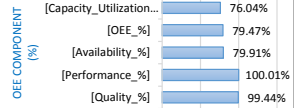
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- Filler Final Folder Top Flap Open Flap [3x/ 1.53 Hrs. OR 92 Mins.]
- Filler LS Longitudinal Sealing TPIH Alarm [2x/ 0.88 Hrs. OR 53 Mins.]
- Filler ASU Automatic Splicing Unit Malfunction [5x/ 0.63 Hrs. OR 38 Mins.]
- Cardboard\_Packer Open Tray [4x/ 0.42 Hrs. OR 25 Mins.]
- Cardboard\_Packer Divider Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]
- Straw\_Applicator Missing/Fallen Straws [2x/ 0.17 Hrs. OR 10 Mins.]
- Filler Design Correction Alarm [1x/ 0.10 Hrs. OR 6 Mins.]
- Cardboard\_Packer jammed packs [x/ 0.10 Hrs. OR 6 Mins.]



LINE 7 COMBIBLOC CBS 124

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Apple Nectar 200 mL x 27]	[Jul 6] 6:00 AM	[Jul 6] 10:03 AM	243 Mins	4.05 Hrs.	2,535 Cases
Shutdown [Change Flavor]	[Jul 6] 10:03 AM	[Jul 6] 11:21 AM	78 Mins	1.30 Hrs.	
Production [Original Orange Nectar 200 mL x 27]	[Jul 6] 11:21 AM	[Jul 6] 6:00 PM	399 Mins	6.65 Hrs.	4,581 Cases
Production [Original Orange Nectar 200 mL x 27]	[Jul 6] 6:00 PM	[Jul 7] 1:33 AM	453 Mins	7.55 Hrs.	5,776 Cases
Shutdown [CIP]	[Jul 7] 1:33 AM	[Jul 7] 2:33 AM	60 Mins	1.00 Hrs.	
Shutdown [No Demand]	[Jul 7] 2:33 AM	[Jul 7] 6:00 AM	207 Mins	3.45 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	12,892 Cases



TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray\_Packer Jammed Packs [14x/ 2.12 Hrs. OR 127 Mins.]
- 2. Straw\_Applicator Missing/Fallen Straws [5x/ 0.62 Hrs. OR 37 Mins.]
- 3. Tray\_Shrink Plastic Jammed [1x/ 0.17 Hrs. OR 10 Mins.]
- 4. Filler Track 3 US Generator Adjustment [1x/ 0.17 Hrs. OR 10 Mins.]
- 5. Tray\_Shrink Cutting Error [1x/ 0.13 Hrs. OR 8 Mins.]
- 6. Tray\_Packer Carton Jammed [1x/ 0.08 Hrs. OR 5 Mins.]

