

Production Date

Aug 10, 2022 DAYS ▾

Line	Status	Duration	Last Production Time
Line 1	Running	33 Hrs.	August 11 2022 8:50 AM
Line 2	Running		
Line 3	Running		
Line 4	Running		
Line 5	Running		
Line 6	Stopped	32 Hrs.	August 11 2022 10:46 AM
Line 7	Stopped		

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]	[Aug 10] 6:00 AM	[Aug 10] 6:00 PM	720 Mins	12.00 Hrs.	7,783 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Aug 10] 6:00 PM	[Aug 11] 6:00 AM	720 Mins	12.00 Hrs.	8,310 Cases
TOTAL			1,440 Mins	24.00 Hrs.	16,093 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

UNPLANNED DOWNTIME (HR)

Short Stop

1.48

Process Failure

0.75

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Filler Jaw System Fill Weight Low Level [2x/ 0.48 Hrs. OR 29 Mins.]

2. Pasteurizer No Product [5x/ 0.47 Hrs. OR 28 Mins.]

3. Helix Spider Belt Jammed Packs [1x/ 0.42 Hrs. OR 25 Mins.]

4. Filler ASSU Automatic Strip Splicing Unit Malfunction [2x/ 0.27 Hrs. OR 16 Mins.]

5. Straw_Applicator Missing/Fallen Straws [1x/ 0.22 Hrs. OR 13 Mins.]

6. Other ODS Validation [1x/ 0.12 Hrs. OR 7 Mins.]

7. Cardboard_Packer Open Tray [1x/ 0.08 Hrs. OR 5 Mins.]

8. Cardboard_Packer Divider Jammed Packs [1x/ 0.08 Hrs. OR 5 Mins.]

EQUIPMENT UNDT (HR)

Filler

0.78

Pasteurizer

0.47

Helix

0.42

Straw_Applicator

0.22

Cardboard_Packer

0.17

Other

0.12

Coder

0.07

LINE 7 COMBIBLOC CBS 124

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Orange NASOS 200 mL x 15 + 3]	[Aug 10] 6:00 AM	[Aug 10] 8:57 AM	177 Mins	2.95 Hrs.	2,895 Cases
Shutdown [Change Flavor]	[Aug 10] 8:57 AM	[Aug 10] 12:10 PM	193 Mins	3.22 Hrs.	
Production [Original Mango NASOS 200 mL x 15 + 3]	[Aug 10] 12:10 PM	[Aug 10] 6:00 PM	350 Mins	5.83 Hrs.	5,650 Cases
Production [Original Mango NASOS 200 mL x 15 + 3]	[Aug 10] 6:00 PM	[Aug 10] 11:16 PM	316 Mins	5.27 Hrs.	4,684 Cases
Change Flavor	[Aug 10] 11:16 PM	[Aug 11] 1:43 AM	147 Mins	2.45 Hrs.	
Production [Original Mixfruit NASOS 200 mL x 15 + 3]	[Aug 11] 1:43 AM	[Aug 11] 6:00 AM	257 Mins	4.28 Hrs.	4,345 Cases
TOTAL			1,440 Mins	24.00 Hrs.	17,574 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Track 6 Speed Loss [1x/ 2.67 Hrs. OR 160 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray_Packer Jammed Packs [7x/ 0.85 Hrs. OR 51 Mins.]
- 2. Pasteurizer No Product [4x/ 0.47 Hrs. OR 28 Mins.]
- 3. Buffer_Table Infeed Belt Jammed Packs [2x/ 0.30 Hrs. OR 18 Mins.]
- 4. Straw_Applicator Missing/Fallen Straws [2x/ 0.18 Hrs. OR 11 Mins.]
- 5. Tray_Packer Tray Jammed [1x/ 0.12 Hrs. OR 7 Mins.]
- 6. Buffer_Table Jammed Packs [1x/ 0.12 Hrs. OR 7 Mins.]
- 7. Auto_Palletizer Conveyor Full [2x/ 0.08 Hrs. OR 5 Mins.]

