

Production Date

Jul 25, 2022

JUL 2022

1112131415161718192021222324252627

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 28 Hrs. already and CIP is due on July 26 2022 2:24 PM

Line 2 : Running for already and CIP is due on

Line 3 : Running for 12 Hrs. already and CIP is due on July 27 2022 6:56 AM

Line 4 : Running for already and CIP is due on

Line 5 : Running for already and CIP is due on

Line 7 : Running for 19 Hrs. already and CIP is due on July 26 2022 11:37 PM

Date: July 25, 2022

Utilization: 37.77%

%OEE: 43.40%

Output: 34,905

Daily Performance Summary for All Production Lines

16,00014,00012,00010,0008,0006,0004,0002,0000

L07L01L03L02L06L05L04

[Capacity_Utilization_%]69.58%94.79%100.00%0.00%0.00%0.00%0.00%

[OEE_%]66.38%41.88%28.87%

[Net Output Count CASES]14,78010,8889,23700000

L01 SHOWNL02 HIDDENL03 SHOWNL04 HIDDENL05 HIDDENL07 SHOWN

L01 AUTOFITL03 AUTOFITL07 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Apple Drink 250 mL x 18 + 3]	[Jul 25] 6:00 AM	[Jul 25] 8:59 AM	179 Mins	2.98 Hrs.	1,961 Cases
Major Breakdown [Filler: Magazine Feeder Motor Malfunction]	[Jul 25] 8:59 AM	[Jul 25] 2:52 PM	353 Mins	5.88 Hrs.	
Production [Original Apple Drink 250 mL x 18 + 3]	[Jul 25] 2:52 PM	[Jul 25] 6:00 PM	188 Mins	3.13 Hrs.	1,960 Cases
Production [Original Apple Drink 250 mL x 18 + 3]	[Jul 25] 6:00 PM	[Jul 25] 11:57 PM	357 Mins	5.95 Hrs.	3,818 Cases
Shutdown [Change Flavor]	[Jul 25] 11:57 PM	[Jul 26] 1:12 AM	75 Mins	1.25 Hrs.	
Production [Original Orange Drink 250 mL x 18 + 3]	[Jul 26] 1:12 AM	[Jul 26] 6:00 AM	288 Mins	4.80 Hrs.	3,148 Cases
TOTAL			1,440 Mins	24.00 Hrs.	10,887 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]94.79%

[OEE_%]41.88%

[Availability_%]50.70%

[Performance_%]83.17%

[Quality_%]99.32%

CATEGORY (HR)

Unplanned_Downtime11.22

Shutdown1.25

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Magazine Feeder Motor Malfunction [1x/ 5.88 Hrs. OR 353 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer jammed packs [7x/ 1.28 Hrs. OR 77 Mins.]

2. Auto_Palletizer Conveyor Full [8x/ 1.08 Hrs. OR 65 Mins.]

3. Auto_Palletizer Fallen Carton [2x/ 0.55 Hrs. OR 33 Mins.]

4. Auto_Palletizer Program Adjustment [2x/ 0.42 Hrs. OR 25 Mins.]

5. Straw_Applicator Glue Unit Nozzle Clogged [1x/ 0.40 Hrs. OR 24 Mins.]

6. Filler ASSU Automatic Strip Splicing Unit Malfunction [2x/ 0.37 Hrs. OR 22 Mins.]

7. Coder Bad Print [2x/ 0.32 Hrs. OR 19 Mins.]

8. Straw_Applicator Missing/Fallen Straws [1x/ 0.23 Hrs. OR 14 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown5.88

Short Stop4.08

Process Failure1.25

EQUIPMENT UNDT (HR)

Filler6.45

Auto_Palletizer2.05

Cardboard_Packer1.53

Straw_Applicator0.63

Coder0.32

Helix0.23

SHUTDOWN (HR)

Change Flavor1.25

PLANNED DOWNTIME (HR)

Grand Total

LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Nadec Mixfruit Drink 125 mL x 18]	[Jul 25] 6:00 AM	[Jul 25] 12:40 PM	400 Mins	6.67 Hrs.	3,568 Cases
CIP + SIP	[Jul 25] 12:40 PM	[Jul 25] 6:00 PM	320 Mins	5.33 Hrs.	
Delay [Filler: ASU Automatic Splicing Unit Adjustment]	[Jul 25] 6:00 PM	[Jul 25] 6:56 PM	56 Mins	0.93 Hrs.	
Production Start of Cycle [Nadec Orange Drink 125 mL x 18]	[Jul 25] 6:56 PM	[Jul 26] 6:00 AM	664 Mins	11.07 Hrs.	5,670 Cases
TOTAL			1,440 Mins	24.00 Hrs.	9,238 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]100.00%

[OEE_%]28.87%

[Availability_%]35.28%

[Performance_%]83.30%

[Quality_%]98.23%

CATEGORY (HR)

Unplanned_Downtime10.20

Planned_Downtime5.33

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler ASU Automatic Splicing Unit Adjustment [1x/ 0.93 Hrs. OR 56 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Helix Spider Belt Jammed Packs [15x/ 2.03 Hrs. OR 122 Mins.]

2. Auto_Palletizer Manual Palletizing [4x/ 1.65 Hrs. OR 99 Mins.]

3. Filler ASU Automatic Splicing Unit Malfunction [8x/ 1.33 Hrs. OR 80 Mins.]

4. Cardboard_Packer jammed packs [5x/ 1.28 Hrs. OR 77 Mins.]

5. Helix Communication Error [3x/ 0.95 Hrs. OR 57 Mins.]

6. Auto_Palletizer Jammed Pallet [2x/ 0.47 Hrs. OR 28 Mins.]

7. Filler Hydrogen Peroxide Alarm [1x/ 0.35 Hrs. OR 21 Mins.]

8. Tray_Shrink Conveyor System Jammed [2x/ 0.32 Hrs. OR 19 Mins.]

UNPLANNED DOWNTIME (HR)

Short Stop5.68

Process Failure3.58

Delay0.93

EQUIPMENT UNDT (HR)

Filler3.32

Helix2.98

Auto_Palletizer2.12

Cardboard_Packer1.28

Tray_Shrink0.32

Other0.18

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

CIP + SIP5.33

LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [No Demand]	[Jul 25] 6:00 AM	[Jul 25] 11:37 AM	337 Mins	5.62 Hrs.	
Production Start of Cycle [Original Mixfruit NASOS 200 mL x 15 + 3]	[Jul 25] 11:37 AM	[Jul 25] 1:37 PM	120 Mins	2.00 Hrs.	1,972 Cases
Major Breakdown [Other: Lack of Coordination]	[Jul 25] 1:37 PM	[Jul 25] 3:34 PM	117 Mins	1.95 Hrs.	
Production [Original Mixfruit NASOS 200 mL x 15 + 3]	[Jul 25] 3:34 PM	[Jul 25] 6:00 PM	146 Mins	2.43 Hrs.	2,506 Cases
Production [Original Mixfruit NASOS 200 mL x 15 + 3]	[Jul 25] 6:00 PM	[Jul 26] 4:19 AM	619 Mins	10.32 Hrs.	10,302 Cases
Shutdown [CIP]	[Jul 26] 4:19 AM	[Jul 26] 6:00 AM	101 Mins	1.68 Hrs.	

OEE COMPONENT (%)

[Capacity_Utilization_%]69.58%

[OEE_%]66.38%

[Availability_%]66.57%

[Performance_%]100.02%

[Quality_%]99.69%

CATEGORY (HR)

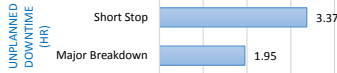
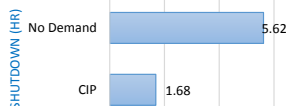
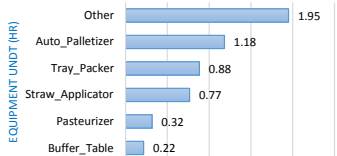

Shutdown7.30

Unplanned_Downtime5.32

Planned_Downtime0.27

P4 Production Report DASHBOARD v3.xlsm
Printed: 7/26/2022 6:57 AM

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TOTAL			1,440 Mins	24.00 Hrs.	14,780 Cases	
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]						
1. Other Lack of Coordination [1x/ 1.95 Hrs. OR 117 Mins.]						
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]						
1. Straw_Applicator Missing/Fallen Straws [6x/ 0.77 Hrs. OR 46 Mins.]						
2. Tray_Packer Jammed Packs [5x/ 0.73 Hrs. OR 44 Mins.]						
3. Auto_Palletizer Outfeed Conveyor Tensioner Broken/Damaged [5x/ 0.60 Hrs. OR 36 Mins.]						
4. Auto_Palletizer Conveyor Full [3x/ 0.40 Hrs. OR 24 Mins.]						
5. Pasteurizer No Product [2x/ 0.32 Hrs. OR 19 Mins.]						
6. Buffer_Table Jammed Packs [1x/ 0.22 Hrs. OR 13 Mins.]						
7. Auto_Palletizer Fallen Carton [1x/ 0.18 Hrs. OR 11 Mins.]						
8. Tray_Packer Carton Jammed [1x/ 0.15 Hrs. OR 9 Mins.]						