Production Date

Jul 15, 2022   DAYS ▾

JUL 2022

5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21

◀ [   ] ▶

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for	**37 Hrs.**	already and CIP is due on	**July 16 2022 8:16 AM**
Line 2 : Running for	---	already and CIP is due on	---
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	**27 Hrs.**	already and CIP is due on	**July 16 2022 6:30 PM**

Date: July 15, 2022
Utilization: 27.59%
%OEE: 71.26%
Output: 29,358

Daily Performance Summary for All Production Lines

	L07	L01	L05	L02	L06	L03	L04
[Capacity_Utilization_%]	93.13%	100.00%	0.00%	0.00%	0.00%	0.00%	0.00%
[OEE_%]	77.21%	65.72%					
[Net Output Count CASES]	15,338	14,020	0	0	0	0	0

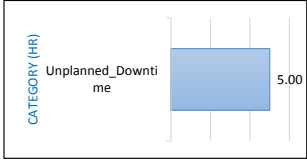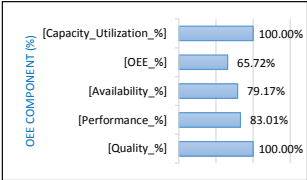L01 SHOWN   L02 SHOWN   L03 HIDDEN   L04 HIDDEN   L05 HIDDEN   L07 SHOWN

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]
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 15] 6:00 AM	[Jul 15] 6:00 PM	720 Mins	12.00 Hrs.	7,269 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 15] 6:00 PM	[Jul 16] 6:00 AM	720 Mins	12.00 Hrs.	6,750 Cases
TOTAL			**1,440 Mins**	**24.00 Hrs.**	**14,019 Cases**

OEE COMPONENT (%)
- [Capacity_Utilization_%] 100.00%
- [OEE_%] 65.72%
- [Availability_%] 79.17%
- [Performance_%] 83.01%
- [Quality_%] 100.00%

CATEGORY (HR)
- Unplanned_Downtime 5.00

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

UNPLANNED DOWNTIME (HR)
- Short Stop 2.83
- Process Failure 2.17

SHUTDOWN (HR)
- Grand Total

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer   jammed packs [5x/ 1.38 Hrs. OR 83 Mins.]
2. Filler ASU Automatic Splicing Unit Loop Empty [8x/ 0.55 Hrs. OR 33 Mins.]
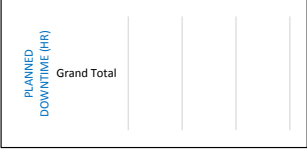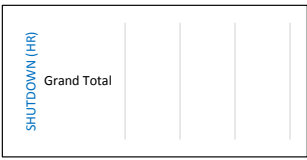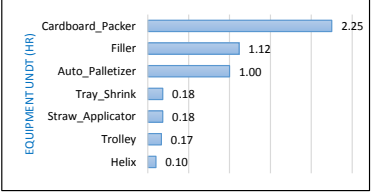3. Cardboard_Packer Electrical Devices Device Net Node 51 [1x/ 0.52 Hrs. OR 31 Mins.]
4. Auto_Palletizer Outfeed Conveyor Tensioner Broken/Damaged [1x/ 0.45 Hrs. OR 27 Mins.]
5. Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.45 Hrs. OR 27 Mins.]
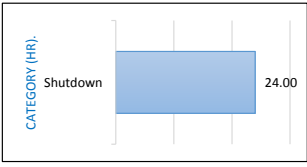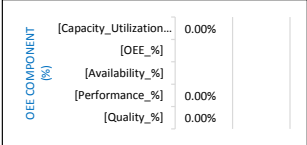6. Cardboard_Packer Divider Jammed Packs [3x/ 0.35 Hrs. OR 21 Mins.]
7. Auto_Palletizer Infeed Conveyor Broken/Damaged [1x/ 0.32 Hrs. OR 19 Mins.]
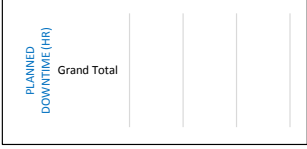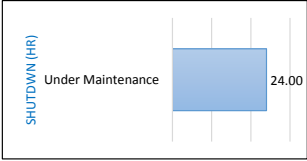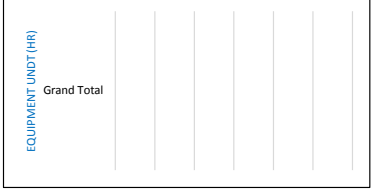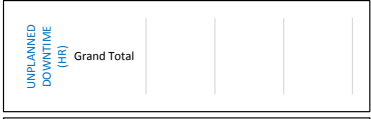8. Auto_Palletizer Jammed Pallet [1x/ 0.23 Hrs. OR 14 Mins.]

EQUIPMENT UNDT (HR)
- Cardboard_Packer 2.25
- Filler 1.12
- Auto_Palletizer 1.00
- Tray_Shrink 0.18
- Straw_Applicator 0.18
- Trolley 0.17
- Helix 0.10

PLANNED DOWNTIME (HR)
- Grand Total

LINE 2 TETRAPAK TBA22 250 ML

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Under Maintenance]	[Jul 15] 6:00 AM	[Jul 15] 6:00 PM	720 Mins	12.00 Hrs.	
Shutdown [Under Maintenance]	[Jul 15] 6:00 PM	[Jul 16] 6:00 AM	720 Mins	12.00 Hrs.	
TOTAL			**1,440 Mins**	**24.00 Hrs.**	**0 Cases**

OEE COMPONENT (%)
- [Capacity_Utilization…%] 0.00%
- [OEE_%]
- [Availability_%]
- [Performance_%] 0.00%
- [Quality_%] 0.00%

CATEGORY (HR.)
- Shutdown 24.00

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

UNPLANNED DOWNTIME (HR)
- Grand Total

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

EQUIPMENT UNDT (HR)
- Grand Total

SHUTDWN (HR)
- Under Maintenance 24.00

PLANNED DOWNTIME (HR)
- Grand Total

LINE 7 COMBIBLOC CBS 124

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
CIP + SIP	[Jul 15] 6:00 AM	[Jul 15] 6:30 AM	30 Mins	0.50 Hrs.	
Production Start of Cycle [Original Mango Nectar 200 mL x 27]	[Jul 15] 6:30 AM	[Jul 15] 3:07 PM	517 Mins	8.62 Hrs.	5,627 Cases
Shutdown [Change Flavor]	[Jul 15] 3:07 PM	[Jul 15] 4:46 PM	99 Mins	1.65 Hrs.	
Production [Original Mixfruit Nectar 200 mL x 27]	[Jul 15] 4:46 PM	[Jul 15] 6:00 PM	74 Mins	1.23 Hrs.	1,144 Cases
Production [Original Mixfruit Nectar 200 mL x 27]	[Jul 15] 6:00 PM	[Jul 16] 6:00 AM	720 Mins	12.00 Hrs.	8,567 Cases
TOTAL			**1,440 Mins**	**24.00 Hrs.**	**15,338 Cases**

OEE COMPONENT (%)
- [Capacity_Utilization_%] 93.13%
- [OEE_%] 77.21%
- [Availability_%] 77.48%
- [Performance_%] 99.92%
- [Quality_%] 99.72%

CATEGORY (HR.)
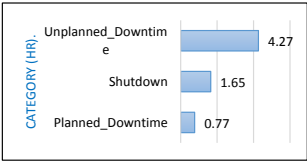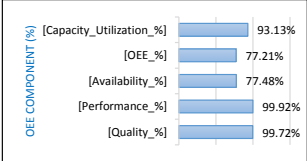- Unplanned_Downtime 4.27
- Shutdown 1.65
- Planned_Downtime 0.77

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Tray_Packer   Jammed Packs [19x/ 2.27 Hrs. OR 136 Mins.]
2. Straw_Applicator   Missing/Fallen Straws [6x/ 0.78 Hrs. OR 47 Mins.]
3. Filler Ultrasonic Track 2 Alarm [1x/ 0.30 Hrs. OR 18 Mins.]
4. Pasteurizer   No Product [2x/ 0.20 Hrs. OR 12 Mins.]
5. Auto_Palletizer Outfeed Conveyor Sensor Malfunction [1x/ 0.17 Hrs. OR 10 Mins.]
6. Tray_Shrink   Plastic Jammed [1x/ 0.17 Hrs. OR 10 Mins.]
7. Buffer_Table   Jammed Packs [1x/ 0.13 Hrs. OR 8 Mins.]
8. Trolley   Delayed [1x/ 0.13 Hrs. OR 8 Mins.]

UNPLANNED DOWNTIME (HR)

Short Stop	3.97
Process Failure	0.30

EQUIPMENT UNDT (HR)

Tray_Packer	2.27
Straw_Applicator	0.78
Filler	0.37
Auto_Palletizer	0.22
Pasteurizer	0.20
Tray_Shrink	0.17
Buffer_Table	0.13
Trolley	0.13

SHUTDOWN (HR)

Change Flavor	1.65

PLANNED DOWNTIME (HR)

CIP + SIP	0.50
Activation Pattern	0.27