

**Production Date**

Jul 31, 2022 DAYS ▾

JUL 2022 AUG 2022

19 20 21 22 23 24 25 26 27 28 29 30 31 1 2 3 4

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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 27 + 3]	[Jul 31] 6:00 AM	[Jul 31] 8:46 AM	166 Mins	2.77 Hrs.	546 Cases
Major Breakdown [Cardboard_Packer: Electrical Devices Error/ Fault]	[Jul 31] 8:46 AM	[Jul 31] 3:00 PM	374 Mins	6.23 Hrs.	
Major Breakdown [Pasteurizer: Program Hang]	[Jul 31] 3:00 PM	[Jul 31] 6:00 PM	180 Mins	3.00 Hrs.	
Major Breakdown [Pasteurizer: Program Hang]	[Jul 31] 6:00 PM	[Aug 1] 2:30 AM	510 Mins	8.50 Hrs.	
Production Start of Cycle [Original Apple Drink 250 mL x 27 + 3]	[Aug 1] 2:30 AM	[Aug 1] 6:00 AM	210 Mins	3.50 Hrs.	2,000 Cases
<b>TOTAL</b>			<b>1,440 Mins</b>	<b>24.00 Hrs.</b>	<b>2,546 Cases</b>

### TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Pasteurizer Program Hang [2x/ 11.50 Hrs. OR 690 Mins.]
2. Cardboard\_Packer Electrical Devices Error/ Fault [1x/ 6.23 Hrs. OR 374 Mins.]

### TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard\_Packer Electrical Devices Error/ Fault [7x/ 1.77 Hrs. OR 106 Mins.]
2. Auto\_Palletizer Program Malfunction [2x/ 0.48 Hrs. OR 29 Mins.]
3. Cardboard\_Packer Divider Jammed Packs [1x/ 0.12 Hrs. OR 7 Mins.]
4. Pasteurizer No Product [1x/ 0.08 Hrs. OR 5 Mins.]

#### UNPLANNED DOWNTIME (HR)

Category	Value (HR)
Major Breakdown	17.73
Process Failure	1.47
Short Stop	0.98

#### EQUIPMENT UNDT (HR)

Equipment	Value (HR)
Pasteurizer	11.58
Cardboard_Packer	8.12
Auto_Palletizer	0.48

LINE 3 TETRAPAK A3 SPEED 125 ML						
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]	
Production [Original Raspberry Drink 125 mL x 18 + 3]	[Jul 31] 6:00 AM	[Jul 31] 4:04 PM	604 Mins	10.07 Hrs.	5,720 Cases	
Shutdown [Inventory]	[Jul 31] 4:04 PM	[Jul 31] 4:21 PM	17 Mins	0.28 Hrs.		
Production [Original Raspberry Drink 125 mL x 18 + 3]	[Jul 31] 4:21 PM	[Jul 31] 6:00 PM	99 Mins	1.65 Hrs.	1,048 Cases	
Production [Original Raspberry Drink 125 mL x 18 + 3]	[Jul 31] 6:00 PM	[Jul 31] 8:07 PM	127 Mins	2.12 Hrs.	688 Cases	
Shutdown [Change Over]	[Jul 31] 8:07 PM	[Jul 31] 10:29 PM	142 Mins	2.37 Hrs.		
Production [Nadec Apple Drink 125 mL x 18]	[Jul 31] 10:29 PM	[Aug 1] 12:36 AM	127 Mins	2.12 Hrs.	1,545 Cases	
Major Breakdown (Filler: TS Transversal Sealing Inductor Broken/Damaged)	[Aug 1] 12:36 AM	[Aug 1] 6:00 AM	324 Mins	5.40 Hrs.		
TOTAL			1,440 Mins	24.00 Hrs.	9,001 Cases	

**TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]**

1. Filler TS Transversal Sealing Inductor Broken/Damaged [1x/ 5.40 Hrs. OR 324 Mins.]

Breakdown Type	Hours
Major Breakdown	5.40
Short Stop	5.30
Process Failure	1.08

**TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]**

1. Helix Spider Belt Fallen Packs [22x/ 3.82 Hrs. OR 229 Mins.]

2. Cardboard\_Packer jammed packs [5x/ 0.68 Hrs. OR 41 Mins.]

3. Straw\_Applicator Conveyor Jammed Packs [3x/ 0.50 Hrs. OR 30 Mins.]

4. Filler Final Folder Jammed Packs [4x/ 0.43 Hrs. OR 26 Mins.]

5. [Packs Jam] Filler Final Folder Adjustment [1x/ 0.38 Hrs. OR 23 Mins.]

6. Filler ASSU Automatic Strip Splicing Unit Malfunction [2x/ 0.23 Hrs. OR 14 Mins.]

7. Filler Outfeed Conveyor Jammed Packs [1x/ 0.18 Hrs. OR 11 Mins.]

8. Filler Hydrogen Peroxide Out of Range [1x/ 0.15 Hrs. OR 9 Mins.]

Equipment Unit	Hours
Filler	6.78
Helix	3.82
Cardboard_Packer	0.68
Straw_Applicator	0.50

