

Production Date

Aug 8, 2022

DAYS ▾

JUL 2022

AUG 2022

29

30

31

1

2

3

4

5

6

7

8

9

10

11

12

13

14

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PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 33 Hrs. already and CIP is due on August 9 2022 9:18 AM

Line 2 : Running for already and CIP is due on

Line 3 : Running for 37 Hrs. already and CIP is due on August 9 2022 5:04 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 already and CIP is due on

Date:

August 8, 2022

Utilization:

27.96%

%OEE:

58.26%

Output:

27,373

Daily Performance Summary for All Production Lines

16,000

14,000

12,000

10,000

8,000

6,000

4,000

2,000

0

L01

L03

L06

L05

L07

L02

L04

[Capacity_Utilization_%]

95.69%

[OEE_%]

66.84%

[Net Output Count CASES]

13,646

[Capacity_Utilization_%]

100.00%

[OEE_%]

50.05%

[Net Output Count CASES]

13,727

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

L01 SHOWN

L02 HIDDEN

L03 SHOWN

L04 HIDDEN

L05 HIDDEN

L07 HIDDEN

L01 AUTOFIT

L03 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 8] 6:00 AM	[Aug 8] 2:37 PM	517 Mins	8.62 Hrs.	4,161 Cases
Shutdown [Change Flavor]	[Aug 8] 2:37 PM	[Aug 8] 3:39 PM	62 Mins	1.03 Hrs.	
Production [Qobtan Orange Flavored 250 mL x 27]	[Aug 8] 3:39 PM	[Aug 8] 6:00 PM	141 Mins	2.35 Hrs.	1,554 Cases
Production [Qobtan Orange Flavored 250 mL x 27]	[Aug 8] 6:00 PM	[Aug 9] 6:00 AM	720 Mins	12.00 Hrs.	7,931 Cases
TOTAL			1,440 Mins	24.00 Hrs.	13,646 Cases

OEE COMPONENT (%)

[Capacity_Utilization_...]

95.69%

[OEE_%]

66.84%

[Availability_%]

80.62%

[Performance_%]

83.03%

[Quality_%]

99.85%

CATEGORY (HR)

Unplanned_Downtime

4.45

Shutdown

1.03

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer Divider Jammed Packs [4x/ 1.02 Hrs. OR 61 Mins.]

2. Other ODS Validation [4x/ 0.78 Hrs. OR 47 Mins.]

3. Filler Final Folder Jammed Packs [3x/ 0.57 Hrs. OR 34 Mins.]

4. Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.52 Hrs. OR 31 Mins.]

5. Cardboard_Packer Open Tray [1x/ 0.25 Hrs. OR 15 Mins.]

6. Filler ASU Automatic Splicing Unit Loop Empty [1x/ 0.23 Hrs. OR 14 Mins.]

7. Other Waiting for Materials [1x/ 0.22 Hrs. OR 13 Mins.]

8. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.22 Hrs. OR 13 Mins.]

UNPLANNED DOWNTIME (HR)

Short Stop

2.93

Process Failure

1.52

EQUIPMENT UNDT (HR)

Filler

1.72

Cardboard_Packer

1.53

Other

1.00

Pasteurizer

0.20

SHUTDOWN (HR)

Change Flavor

1.03

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 [Original Orange Drink 125 mL x 18 + 3]	[Aug 8] 6:00 AM	[Aug 8] 10:34 AM	274 Mins	4.57 Hrs.	3,444 Cases
Major Breakdown [Filler: Top Forming Roller Scratch]	[Aug 8] 10:34 AM	[Aug 8] 3:33 PM	299 Mins	4.98 Hrs.	
Production [Original Orange Drink 125 mL x 18 + 3]	[Aug 8] 3:33 PM	[Aug 8] 6:00 PM	147 Mins	2.45 Hrs.	1,767 Cases
Production [Original Orange Drink 125 mL x 18 + 3]	[Aug 8] 6:00 PM	[Aug 9] 4:42 AM	642 Mins	10.70 Hrs.	8,517 Cases
CIP + SIP	[Aug 9] 4:42 AM	[Aug 9] 6:00 AM	78 Mins	1.30 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	13,728 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]

100.00%

[OEE_%]

50.05%

[Availability_%]

60.76%

[Performance_%]

83.37%

[Quality_%]

98.79%

CATEGORY (HR)

Unplanned_Downtime

8.12

Planned_Downtime

1.30

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. [Accumulated Plastic] Filler Top Forming Roller Scratch [1x/ 4.98 Hrs. OR 299 Mins.]

1. Cardboard_Packer jammed packs [4x/ 0.67 Hrs. OR 40 Mins.]

2. Helix Spider Belt Jammed Packs [2x/ 0.42 Hrs. OR 25 Mins.]

3. Cardboard_Packer Tray Transport Tray Jammed [2x/ 0.40 Hrs. OR 24 Mins.]

4. Tray_Shrink Jammed Packs [2x/ 0.40 Hrs. OR 24 Mins.]

5. Straw_Applicator Jammed Packs [2x/ 0.27 Hrs. OR 16 Mins.]

6. Cardboard_Packer Divider Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

7. Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.25 Hrs. OR 15 Mins.]

8. Cardboard_Packer Grouping Flight Bar Out of Timing [1x/ 0.17 Hrs. OR 10 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

4.98

Short Stop

2.58

Process Failure

0.55

EQUIPMENT UNDT (HR)

Filler

5.32

Cardboard_Packer

1.63

Helix

0.42

Tray_Shrink

0.40

Straw_Applicator

0.27

Pasteurizer

0.08

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

CIP + SIP

1.30

P4 Production Report DASHBOARD v3.xlsm
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