

Production Date

Jul 3, 2022

JUN 2022

20

21

22

23

24

25

26

27

28

29

30

1

2

3

4

5

6

JUL 2022

DAYS ▾

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 17 Hrs. already and CIP is due on July 5 2022 2:26 AM

Line 2 : Running for 13 Hrs. already and CIP is due on July 5 2022 6:42 AM

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 5 Hrs. already and CIP is due on July 5 2022 2:34 PM

Date: July 3, 2022

Utilization: 30.65%

%OEE: 33.47%

Output: 16,236

Daily Performance Summary for All Production Lines

12,000

10,000

8,000

6,000

4,000

2,000

0

L01

L07

L02

L05

L06

L03

L04

[Capacity\_Utilization\_%]

[OEE\_%]

[Net Output Count CASES]

87.50%

53.97%

10,074

43.75%

19.59%

2,742

83.33%

19.24%

3,420

0.00%

0

0.00%

0

0.00%

0

0.00%

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]
Shutdown [Weekend]	[Jul 3] 6:00 AM	[Jul 3] 9:00 AM	180 Mins	3.00 Hrs.	
CIP + SIP	[Jul 3] 9:00 AM	[Jul 3] 2:26 PM	326 Mins	5.43 Hrs.	
Production Start of Cycle [Qobtan Orange Flavored 250 mL x 27]	[Jul 3] 2:26 PM	[Jul 3] 6:00 PM	214 Mins	3.57 Hrs.	2,520 Cases
Production [Qobtan Orange Flavored 250 mL x 27]	[Jul 3] 6:00 PM	[Jul 4] 6:00 AM	720 Mins	12.00 Hrs.	7,554 Cases
TOTAL			1,440 Mins	24.00 Hrs.	10,074 Cases

OEE COMPONENT (%)

[Capacity\_Utilization\_%]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

87.50%

53.97%

65.48%

82.42%

100.00%

CATEGORY (HR)

Planned\_Downtime

Shutdown

Unplanned\_Downtime

5.43

3.00

1.82

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Cardboard\_Packer Electrical Devices Malfunction [1x/ 0.98 Hrs. OR 59 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard\_Packer Divider Jammed Packs [1x/ 0.33 Hrs. OR 20 Mins.]

2. Pasteurizer No Product [1x/ 0.32 Hrs. OR 19 Mins.]

3. Cardboard\_Packer Error/ Fault [1x/ 0.15 Hrs. OR 9 Mins.]

4. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.03 Hrs. OR 2 Mins.]

UNPLANNED DOWNTIME (HR)

Breakdown

Process Failure

Short Stop

0.98

0.65

0.18

EQUIPMENT UNDT (HR)

Cardboard\_Packer

Pasteurizer

Filler

1.47

0.32

0.03

SHUTDOWN (HR)

Weekend

3.00

PLANNED DOWNTIME (HR)

CIP + SIP

5.43

LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Weekend]	[Jul 3] 6:00 AM	[Jul 3] 9:00 AM	180 Mins	3.00 Hrs.	
CIP + SIP	[Jul 3] 9:00 AM	[Jul 3] 2:00 PM	300 Mins	5.00 Hrs.	
Delay [Cardboard_Packer: Transport Chain Adjustment]	[Jul 3] 2:00 PM	[Jul 3] 6:00 PM	240 Mins	4.00 Hrs.	
Delay [Cardboard_Packer: Transport Chain Adjustment]	[Jul 3] 6:00 PM	[Jul 3] 6:42 PM	42 Mins	0.70 Hrs.	
Production Start of Cycle [Qobtan Orange Flavored 250 mL x 27]	[Jul 3] 6:42 PM	[Jul 4] 2:42 AM	480 Mins	8.00 Hrs.	3,420 Cases
Shutdown [Change Flavor]	[Jul 4] 2:42 AM	[Jul 4] 3:42 AM	60 Mins	1.00 Hrs.	
Major Breakdown [Filler: Packs Overlap]	[Jul 4] 3:42 AM	[Jul 4] 6:00 AM	138 Mins	2.30 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	3,420 Cases

OEE COMPONENT (%)

[Capacity\_Utilization\_%]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

83.33%

19.24%

26.75%

71.91%

100.00%

CATEGORY (HR)

Unplanned\_Downtime

Planned\_Downtime

Shutdown

9.65

5.00

4.00

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Cardboard\_Packer Transport Chain Adjustment [2x/ 4.70 Hrs. OR 282 Mins.]

2. Filler Packs Overlap [1x/ 2.30 Hrs. OR 138 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard\_Packer Open Tray [7x/ 1.38 Hrs. OR 83 Mins.]

2. Straw\_Applicator Missing/Fallen Straws [4x/ 0.62 Hrs. OR 37 Mins.]

3. Filler Packs Overlap [1x/ 0.33 Hrs. OR 20 Mins.]

4. Cardboard\_Packer Divider Jammed Packs [1x/ 0.18 Hrs. OR 11 Mins.]

5. Helix Jammed Packs [1x/ 0.07 Hrs. OR 4 Mins.]

6. Filler Final Folder Jammed Packs [1x/ 0.07 Hrs. OR 4 Mins.]

UNPLANNED DOWNTIME (HR)

Delay

Major Breakdown

Short Stop

Process Failure

4.70

2.30

1.48

1.17

EQUIPMENT UNDT (HR)

Cardboard\_Packer

Filler

Straw\_Applicator

Helix

6.27

2.70

0.62

0.07

SHUTDOWN (HR)

Weekend

Change Flavor

3.00

1.00

PLANNED DOWNTIME (HR)

CIP + SIP

5.00

LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Weekend]	[Jul 3] 6:00 AM	[Jul 3] 9:00 AM	180 Mins	3.00 Hrs.	
CIP + SIP	[Jul 3] 9:00 AM	[Jul 3] 2:00 PM	300 Mins	5.00 Hrs.	
Shutdown [No Materials]	[Jul 3] 2:00 PM	[Jul 3] 6:00 PM	240 Mins	4.00 Hrs.	
Shutdown [No Materials]	[Jul 3] 6:00 PM	[Jul 4] 12:30 AM	390 Mins	6.50 Hrs.	
Delay [Filler: Ultrasonic Track 3 Error/ Fault]	[Jul 4] 12:30 AM	[Jul 4] 2:34 AM	124 Mins	2.07 Hrs.	
Production Start of Cycle [Original Apple NASOS 200 mL x 18]	[Jul 4] 2:34 AM	[Jul 4] 6:00 AM	206 Mins	3.43 Hrs.	2,742 Cases
TOTAL			1,440 Mins	24.00 Hrs.	2,742 Cases

OEE COMPONENT (%)

[Capacity\_Utilization...]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

43.75%

19.59%

23.65%

82.82%

100.00%

CATEGORY (HR)

Shutdown

Planned\_Downtime

Unplanned\_Downtime

13.50

5.08

2.93

P4 Production Report DASHBOARD v3.xlsm  
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TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Ultrasonic Track 3 Error/ Fault [1x/ 2.07 Hrs. OR 124 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Buffer\_Table Jammed Packs [1x/ 0.27 Hrs. OR 16 Mins.]
- 2. Pasteurizer No Product [1x/ 0.27 Hrs. OR 16 Mins.]
- 3. Auto\_Palletizer Fallen Carton [1x/ 0.12 Hrs. OR 7 Mins.]
- 4. Tray\_Packer Jammed Packs [1x/ 0.12 Hrs. OR 7 Mins.]
- 5. Straw\_Applicator Missing/Fallen Straws [1x/ 0.10 Hrs. OR 6 Mins.]

