

Production Date

Jul 30, 2022 DAYS ▾

JUL 2022 AUG 2022

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

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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 Raspberry Drink 250 mL x 18 + 3]	[Jul 30] 6:00 AM	[Jul 30] 6:09 AM	9 Mins	0.15 Hrs.	
CIP + SIP	[Jul 30] 6:09 AM	[Jul 30] 11:09 AM	300 Mins	5.00 Hrs.	
Delay [Pasteurizer: Heater Leaking]	[Jul 30] 11:09 AM	[Jul 30] 1:38 PM	149 Mins	2.48 Hrs.	
Production Start of Cycle [Original Apple Drink 250 mL x 27 + 3]	[Jul 30] 1:38 PM	[Jul 30] 2:36 PM	58 Mins	0.97 Hrs.	108 Cases
Major Breakdown [Filler: Aseptic Chamber High Temperature]	[Jul 30] 2:36 PM	[Jul 30] 6:00 PM	204 Mins	3.40 Hrs.	
Major Breakdown [Filler: Aseptic Chamber High Temperature]	[Jul 30] 6:00 PM	[Jul 30] 8:00 PM	120 Mins	2.00 Hrs.	
Major Breakdown [Filler: Squeegee Roller Adjustment]	[Jul 30] 8:00 PM	[Jul 30] 10:52 PM	172 Mins	2.87 Hrs.	
Production [Original Apple Drink 250 mL x 27 + 3]	[Jul 30] 10:52 PM	[Jul 31] 6:00 AM	428 Mins	7.13 Hrs.	2,894 Cases
			TOTAL	1,440 Mins	24.00 Hrs.
					3,002 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. [Accumulated Aluminium] Filler Aseptic Chamber High Temperature [2x/ 5.40 Hrs. OR 324 Mins.]

2. [Peroxide Residue Too High] Filler Squeegee Roller Adjustment [1x/ 2.87 Hrs. OR 172 Mins.]

3. Pasteurizer Heater Leaking [1x/ 2.48 Hrs. OR 149 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer Electrical Devices Error/ Fault [13x/ 3.43 Hrs. OR 206 Mins.]

2. Cardboard_Packer Divider Jammed Packs [1x/ 0.23 Hrs. OR 14 Mins.]

3. Pasteurizer No Product [1x/ 0.07 Hrs. OR 4 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

Delay

Process Failure

Short Stop

8.27

2.48

2.15

1.58

EQUIPMENT UNGT (HR)

Filler

Cardboard_Packer

Pasteurizer

8.27

3.67

2.55

LINE 3 TETRAPAK A3 SPEED 125 ML

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mango Drink 125 mL x 18 + 3]	[Jul 30] 6:00 AM	[Jul 30] 9:18 AM	198 Mins	3.30 Hrs.	1,763 Cases
CIP + SIP	[Jul 30] 9:18 AM	[Jul 30] 2:18 PM	300 Mins	5.00 Hrs.	
Delay [Pasteurizer: Water Valve Gasket Leaking]	[Jul 30] 2:18 PM	[Jul 30] 3:52 PM	94 Mins	1.57 Hrs.	
Production Start of Cycle [Original Raspberry Drink 125 mL x 18 + 3]	[Jul 30] 3:52 PM	[Jul 30] 6:00 PM	128 Mins	2.13 Hrs.	1,467 Cases
Production [Original Raspberry Drink 125 mL x 18 + 3]	[Jul 30] 6:00 PM	[Jul 31] 6:00 AM	720 Mins	12.00 Hrs.	7,786 Cases
TOTAL			1,440 Mins	24.00 Hrs.	11,016 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Pasteurizer Water Valve Gasket Leaking [1x/ 1.57 Hrs. OR 94 Mins.]

UNPLANNED DOWNTIME (HR)

Short Stop4.88

Delay1.57

Process Failure0.73

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Helix Spider Belt Fallen Packs [22x/ 3.25 Hrs. OR 195 Mins.]

2. [Splicing Malfunction] Filler ASU Automatic Splicing Unit Teflon Tape Broken/Damaged [1x/ 0.73 Hrs. OR 44 Mins.]

3. Filler ASU Automatic Splicing Unit Malfunction [3x/ 0.57 Hrs. OR 34 Mins.]

4. Helix Spider Belt Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

5. Filler Outfeed Conveyor Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

6. Pasteurizer No Product [2x/ 0.17 Hrs. OR 10 Mins.]

7. Filler Final Folder Jammed Packs [1x/ 0.15 Hrs. OR 9 Mins.]

8. Filler Waste Box Jammed Packs [1x/ 0.08 Hrs. OR 5 Mins.]

EQUIPMENT UINDT (HR)

Helix3.50

Filler1.88

Pasteurizer1.73

Cardboard_Packer0.07

