

Date: July 19, 2022

Utilization: 39.18%

%OEE: 41.76%

Output: 30,178

Daily Performance Summary for All Production Lines

Production Line	Capacity Utilization (%)	OEE (%)	Net Output Count (CASES)
L07	84.38%	73.67%	19,891
L01	89.86%	58.26%	10,287
L03	100.00%	0.00%	0
L02	0.00%	0.00%	0
L06	0.00%	0.00%	0
L05	0.00%	0.00%	0
L04	0.00%	0.00%	0

Legend: [Capacity_Utilization_%] (Blue), [OEE_%] (Green), [Net Output Count CASES] (Yellow)

Legend: L01 SHOWN, L02 HIDDEN, L03 SHOWN, L04 HIDDEN, L05 HIDDEN, L07 SHOWN, L01 AUTOFIT, L03 AUTOFIT, L07 AUTOFIT

Figure 10 consists of two horizontal bar charts. The top chart, titled 'OEE COMPONENT (%)', displays five components: Capacity_Utilization_... (89.86%), [OEE_%] (58.26%), [Availability_%] (70.09%), [Performance_%] (83.57%), and [Quality_%] (99.46%). The bottom chart, titled 'CATEGORY (HR)', displays two categories: Unplanned_Downtime (6.45) and Shutdown (2.43).

OEE COMPONENT (%)	Value (%)
[Capacity_Utilization_...	89.86%
[OEE_%]	58.26%
[Availability_%]	70.09%
[Performance_%]	83.57%
[Quality_%]	99.46%

CATEGORY (HR)	Value (HR)
Unplanned_Downtime	6.45
Shutdown	2.43

Planned Downtime (hr)	Change Flavor	2.43
Grand Total		

OEE COMPONENT (%)	
[Capacity_Utilization_%]	100.00%
[OEE_%]	0.00%
[Availability_%]	0.00%
[Performance_%]	0.00%
[Quality_%]	0.00%

CATEGORY (HR)	
Unplanned_Downtime	24.00

PLANNED DOWNTIME (HR)	SHUTDOWN (HR)
Grand Total	

The top chart displays OEE components as percentages. The y-axis is labeled 'OEE COMPONENT (%)'. The components and their values are: Capacity_Utilization_%, 84.38%; [OEE_], 73.67%; [Availability_], 73.83%; [Performance_], 100.04%; and [Quality_], 99.75%.

The bottom chart displays downtime categories in hours. The y-axis is labeled 'CATEGORY (HR)'. The categories and their values are: Unplanned_Downtime, 4.90; Shutdown, 3.75; and Planned_Downtime, 0.40.

OEE Component (%)	Value (%)
Capacity_Utilization_%	84.38%
[OEE_]	73.67%
[Availability_]	73.83%
[Performance_]	100.04%
[Quality_]	99.75%

Category (HR)	Value (HR)
Unplanned_Downtime	4.90
Shutdown	3.75
Planned_Downtime	0.40

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Straw_Applicator Missing/Fallen Straws [11x/ 1.65 Hrs. OR 99 Mins.]
- 2. Tray_Packer Jammed Packs [9x/ 1.28 Hrs. OR 77 Mins.]
- 3. Other Waiting for Materials [2x/ 0.62 Hrs. OR 37 Mins.]
- 4. Auto_Palletizer Fallen Carton [2x/ 0.42 Hrs. OR 25 Mins.]
- 5. Filler Discharger Jammed Packs [1x/ 0.23 Hrs. OR 14 Mins.]
- 6. Auto_Palletizer Outfeed Conveyor Sensor Malfunction [1x/ 0.17 Hrs. OR 10 Mins.]
- 7. Trolley Delayed [1x/ 0.17 Hrs. OR 10 Mins.]
- 8. Tray_Packer Carton Jammed [1x/ 0.17 Hrs. OR 10 Mins.]

