

Production Date

Jul 4, 2022

JUN 2022

JUL 2022

212223242526272829301234567

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 42 Hrs. already and CIP is due on July 5 2022 2:26 AM

Line 2 : Running for 38 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 30 Hrs. already and CIP is due on July 5 2022 2:34 PM

Date: July 4, 2022

Utilization: 40.64%

%OEE: 59.98%

Output: 42,140

Daily Performance Summary for All Production Lines

L01

L07

L02

L05

L06

L03

L04

100.00%

84.51%

100.00%

0.00%

0.00%

0.00%

0.00%

70.10%

63.60%

46.81%

14,955

17,199

9,986

0

0

0

0

L01 SHOWN

L02 SHOWN

L03 HIDDEN

L04 HIDDEN

L05 HIDDEN

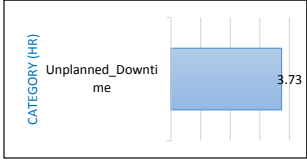
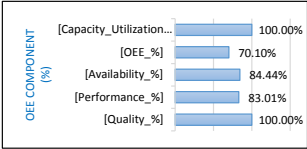
L07 SHOWN

L01 AUTOFIT

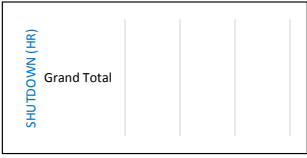
L02 AUTOFIT

L07 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Orange Flavored 250 mL x 27]	[Jul 4] 6:00 AM	[Jul 4] 6:00 PM	720 Mins	12.00 Hrs.	6,985 Cases
Production [Qobtan Orange Flavored 250 mL x 27]	[Jul 4] 6:00 PM	[Jul 5] 6:00 AM	720 Mins	12.00 Hrs.	7,969 Cases
TOTAL			1,440 Mins	24.00 Hrs.	14,954 Cases

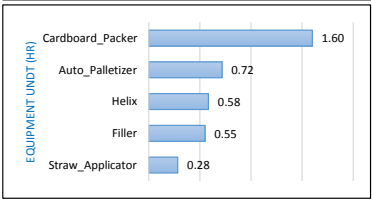


TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

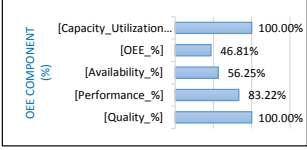


TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

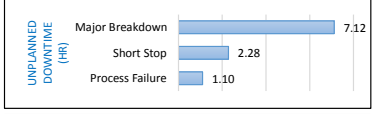
- Cardboard_Packer Divider Jammed Packs [6x/ 1.05 Hrs. OR 63 Mins.]
- Filler ASU Automatic Splicing Unit Malfunction [2x/ 0.55 Hrs. OR 33 Mins.]
- Helix Spider Belt Jammed Packs [3x/ 0.47 Hrs. OR 28 Mins.]
- Cardboard_Packer Device Net Node 51 [1x/ 0.35 Hrs. OR 21 Mins.]
- Straw_Applicator Missing/Fallen Straws [2x/ 0.28 Hrs. OR 17 Mins.]
- Auto_Palletizer Jammed Pallet [2x/ 0.28 Hrs. OR 17 Mins.]
- Auto_Palletizer Infeed Conveyor Sensor Malfunction [1x/ 0.23 Hrs. OR 14 Mins.]
- Auto_Palletizer Outfeed Conveyor Tensioner Broken/Damaged [1x/ 0.20 Hrs. OR 12 Mins.]



LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Filler: Packs Overlap]	[Jul 4] 6:00 AM	[Jul 4] 6:26 AM	26 Mins	0.43 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 4] 6:26 AM	[Jul 4] 1:18 PM	412 Mins	6.87 Hrs.	3,742 Cases
Major Breakdown [Filler: HMI and PLMS Trip-Off]	[Jul 4] 1:18 PM	[Jul 4] 2:54 PM	96 Mins	1.60 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 4] 2:54 PM	[Jul 4] 6:00 PM	186 Mins	3.10 Hrs.	2,116 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 4] 6:00 PM	[Jul 4] 10:28 PM	268 Mins	4.47 Hrs.	2,874 Cases
Major Breakdown [Filler: Final Folder Top Heater Defective]	[Jul 4] 10:28 PM	[Jul 5] 3:33 AM	305 Mins	5.08 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 5] 3:33 AM	[Jul 5] 6:00 AM	147 Mins	2.45 Hrs.	1,254 Cases
TOTAL			1,440 Mins	24.00 Hrs.	9,986 Cases

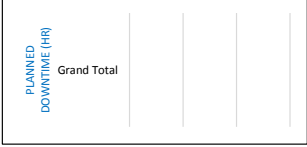
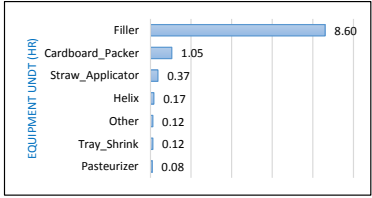


- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
- Filler Final Folder Top Heater Defective [1x/ 5.08 Hrs. OR 305 Mins.]
 - Filler HMI and PLMS Trip-Off [1x/ 1.60 Hrs. OR 96 Mins.]
 - Filler Packs Overlap [1x/ 0.43 Hrs. OR 26 Mins.]

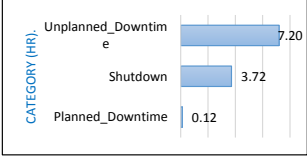
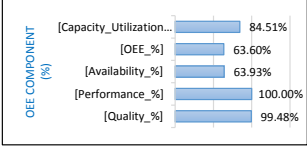


TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- Cardboard_Packer Open Tray [2x/ 0.72 Hrs. OR 43 Mins.]
- Filler HMI and PLMS Trip-Off [1x/ 0.52 Hrs. OR 31 Mins.]
- Straw_Applicator Missing/Fallen Straws [4x/ 0.37 Hrs. OR 22 Mins.]
- Filler LS Longitudinal Sealing TPH Alarm [3x/ 0.35 Hrs. OR 21 Mins.]
- Cardboard_Packer Divider Jammed Packs [3x/ 0.33 Hrs. OR 20 Mins.]
- Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.17 Hrs. OR 10 Mins.]
- Helix Jammed Packs [1x/ 0.17 Hrs. OR 10 Mins.]
- Filler ASU Automatic Splicing Unit Malfunction [x/ 0.13 Hrs. OR 8 Mins.]



LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Apple NASOS 200 mL x 18]	[Jul 4] 6:00 AM	[Jul 4] 11:23 AM	323 Mins	5.38 Hrs.	4,552 Cases
Shutdown [Change Flavor]	[Jul 4] 11:23 AM	[Jul 4] 12:41 PM	78 Mins	1.30 Hrs.	
Production [Original Orange NASOS 200 mL x 18]	[Jul 4] 12:41 PM	[Jul 4] 6:00 PM	319 Mins	5.32 Hrs.	4,067 Cases
Production [Original Orange NASOS 200 mL x 18]	[Jul 4] 6:00 PM	[Jul 4] 9:22 PM	202 Mins	3.37 Hrs.	2,838 Cases
Shutdown [Change Flavor]	[Jul 4] 9:22 PM	[Jul 4] 11:47 PM	145 Mins	2.42 Hrs.	
Production [Original Mixfruit NASOS 200 mL x 18]	[Jul 4] 11:47 PM	[Jul 5] 6:00 AM	373 Mins	6.22 Hrs.	5,742 Cases
TOTAL			1,440 Mins	24.00 Hrs.	17,199 Cases



TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Track 3 US Generator Speed Loss [1x/ 2.97 Hrs. OR 178 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray_Packer Jammed Packs [13x/ 1.40 Hrs. OR 84 Mins.]
- 2. Straw_Applicator Missing/Fallen Straws [6x/ 0.67 Hrs. OR 40 Mins.]
- 3. Filler Loop no longer intact [2x/ 0.50 Hrs. OR 30 Mins.]
- 4. Filler Top Flap Dented [1x/ 0.42 Hrs. OR 25 Mins.]
- 5. Pasteurizer No Product [3x/ 0.33 Hrs. OR 20 Mins.]
- 6. Filler Outfeed Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]
- 7. Filler Electrical Cabinet High Temperature [1x/ 0.18 Hrs. OR 11 Mins.]
- 8. Buffer_Table Jammed Packs [1x/ 0.17 Hrs. OR 10 Mins.]

