

**Production Date**

Jul 16, 2022 DAYS ▾

JUL 2022

5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21
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<b>LINE 1 TETRAPAK A3 SPEED 250 ML</b>					
<b>Event Description</b>	<b>Event Start</b>	<b>Event End</b>	<b>Duration [Minutes]</b>	<b>Duration [Hours]</b>	<b>Production Output [Cases]</b>
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 16] 6:00 AM	[Jul 16] 6:25 AM	25 Mins	0.42 Hrs.	239 Cases
CIP + SIP	[Jul 16] 6:25 AM	[Jul 16] 11:25 AM	300 Mins	5.00 Hrs.	
Delay [Pasteurizer: Homogenizer Abnormal Sound ]	[Jul 16] 11:25 AM	[Jul 16] 6:00 PM	395 Mins	6.58 Hrs.	
Delay [Pasteurizer: Homogenizer Abnormal Sound ]	[Jul 16] 6:00 PM	[Jul 16] 7:13 PM	73 Mins	1.22 Hrs.	
Production Start of Cycle [Qobtan Orange Flavored 250	[Jul 16] 7:13 PM	[Jul 17] 6:00 AM	647 Mins	10.78 Hrs.	7,191 Cases
<b>TOTAL</b>			<b>1,440 Mins</b>	<b>24.00 Hrs.</b>	<b>7,430 Cases</b>

### TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Pasteurizer Homogenizer Abnormal Sound [2x/ 7.80 Hrs. OR 468 Mins.]

### TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.38 Hrs. OR 23 Mins.]
2. Filler ASU Automatic Splicing Unit Loop Empty [3x/ 0.27 Hrs. OR 16 Mins.]
3. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.13 Hrs. OR 8 Mins.]
4. Helix Jammed Packs [1x/ 0.10 Hrs. OR 6 Mins.]
5. Cardboard\_Packer jammed packs [1x/ 0.08 Hrs. OR 5 Mins.]
6. Other Unaccounted Downtime [1x/ 0.07 Hrs. OR 4 Mins.]
7. Filler Waste Box Malfunction [1x/ 0.07 Hrs. OR 4 Mins.]

LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Under Maintenance]	[Jul 16] 6:00 AM	[Jul 16] 6:00 PM	720 Mins	12.00 Hrs.	
Shutdown [Under Maintenance]	[Jul 16] 6:00 PM	[Jul 17] 6:00 AM	720 Mins	12.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	0 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

### TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

EQUIPMENT UNDT (Hr)							
Grand Total							

<b>LINE 7 COMMBLOC CBS 124</b>						
<b>Event Description</b>	<b>Event Start</b>	<b>Event End</b>	<b>Duration <small>[Minutes]</small></b>	<b>Duration <small>[Hours]</small></b>	<b>Production Output <small>[Cases]</small></b>	
Production [Original Mixfruit Nectar 200 mL x 27]	[Jul 16] 6:00 AM	[Jul 16] 8:20 AM	140 Mins	2.33 Hrs.	1,288 Cases	
Major Breakdown [Filler: Track 1 Paper Peeling On LS Side]	[Jul 16] 8:20 AM	[Jul 16] 10:23 AM	123 Mins	2.05 Hrs.		
Production [Original Mixfruit Nectar 200 mL x 27]	[Jul 16] 10:23 AM	[Jul 16] 4:10 PM	347 Mins	5.78 Hrs.	4,282 Cases	
CIP + SIP	[Jul 16] 4:10 PM	[Jul 16] 6:00 PM	110 Mins	1.83 Hrs.		
CIP + SIP	[Jul 16] 6:00 PM	[Jul 16] 9:45 PM	225 Mins	3.75 Hrs.		
Production Start of Cycle [Original Apple Nectar 200 mL x 27]	[Jul 16] 9:45 PM	[Jul 17] 6:00 AM	495 Mins	8.25 Hrs.	5,487 Cases	
<b>TOTAL</b>			<b>1,440 Mins</b>	<b>24.00 Hrs.</b>	<b>11,057 Cases</b>	

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Track 1 Paper Peeling On LS Side [1x/ 2.05 Hrs. OR 123 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray\_Packer Jammed Packs [8x/ 1.00 Hrs. OR 60 Mins.]
- 2. Straw\_Applicator Missing/Fallen Straws [6x/ 0.87 Hrs. OR 52 Mins.]
- 3. Filler Ultrasonic Track 2 Alarm [3x/ 0.85 Hrs. OR 51 Mins.]
- 4. Filler Discharger Jammed Packs [1x/ 0.30 Hrs. OR 18 Mins.]
- 5. Filler Track 1 Paper Peeling On LS Side [2x/ 0.22 Hrs. OR 13 Mins.]
- 6. Pasteurizer No Product [1x/ 0.12 Hrs. OR 7 Mins.]
- 7. Tray\_Shrink Plastic Jammed [1x/ 0.10 Hrs. OR 6 Mins.]

