

**Date:** August 15, 2022

**Utilization:** 39.92%

**%OEE:** 64.51%

**Output:** 45,609

**Daily Performance Summary for All Production Lines**

Production Line	Capacity Utilization (%)	OEE (%)	Net Output Count
L01	88.33%	72.25%	17,505
L07	100.00%	63.01%	13,442
L03	91.11%	58.67%	14,662
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)

QEE COMPONENT (%)	Value
[Capacity_Utilization_%]	88.33%
[OEE_%]	72.25%
[Availability_%]	86.79%
[Performance_%]	83.51%
[Quality_%]	99.68%

  

CATEGORY (HR)	Value
Unplanned_Downtime	2.80
Shutdown	2.80

  

SHUTDOWN (HR)	Value
Change Flavor	2.80

  

PLANNED DOWNTIME (HR)	Value
Grand Total	

The figure consists of three horizontal bar charts, each with a different color theme (blue, orange, and green).

**Chart 1: OEE COMPONENT (%)**

Component	Value (%)
Capacity_Utilization_%	91.11%
[OEE_ %]	58.67%
[Availability_ %]	71.04%
[Performance_ %]	83.15%
[Quality_ %]	99.32%

**Chart 2: SHUTDOWN (HR)**

Category	Value (HR)
Unplanned_Downtime	6.33
Shutdown	2.13

**Chart 3: PLANNED DOWNTIME (HR)**

Category	Value (HR)
Change Flavor	2.13
Grand Total	2.13

Figure 10 consists of two horizontal bar charts. The top chart, titled 'OEE COMPONENT (%)', displays five components: Capacity\_Utilization\_%, OEE\_%, Availability\_%, Performance\_%, and Quality\_%. The bottom chart, titled 'CATEGORY (HR)', displays two categories: Unplanned\_Downtime and Planned\_Downtime.

OEE Component (%)	Value (%)
Capacity_Utilization_%	100.00%
OEE_%	63.01%
Availability_%	63.33%
Performance_%	100.03%
Quality_%	99.45%

  

Category (HR)	Value (HR)
Unplanned_Downtime	5.45
Planned_Downtime	3.35

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Track 6 Speed Loss [1x/ 2.03 Hrs. OR 122 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray\_Packer Jammed Packs [7x/ 1.12 Hrs. OR 67 Mins.]
- 2. Straw\_Applicator Missing/Fallen Straws [4x/ 0.55 Hrs. OR 33 Mins.]
- 3. Filler Top Sealing Track 6 Low Pressure [1x/ 0.32 Hrs. OR 19 Mins.]
- 4. Buffer\_Table Fallen Packs [2x/ 0.30 Hrs. OR 18 Mins.]
- 5. Buffer\_Table Infeed Belt Jammed Packs [1x/ 0.30 Hrs. OR 18 Mins.]
- 6. Coder Faulty [1x/ 0.23 Hrs. OR 14 Mins.]
- 7. Coder Bad Print [1x/ 0.12 Hrs. OR 7 Mins.]
- 8. Tray\_Shrink Cutting Error [1x/ 0.12 Hrs. OR 7 Mins.]

