

Production Date

Jul 5, 2022

JUN 2022

JUL 2022

23

24

25

26

27

28

29

30

1

2

3

4

5

6

7

8

9

DAYS

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 11 Hrs. already and CIP is due on July 7 2022 9:14 AM

Line 2 : Running for 14 Hrs. already and CIP is due on July 7 2022 6:11 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 17 Hrs. already and CIP is due on July 7 2022 3:05 AM

Date: July 5, 2022

Utilization: 42.86%

%OEE: 32.92%

Output: 22,953

Daily Performance Summary for All Production Lines

10,000

9,000

8,000

7,000

6,000

5,000

4,000

3,000

2,000

1,000

0

L07

L02

L01

L05

L06

L03

L04

[Capacity\_Utilization\_%]

[OEE\_%]

[Net Output Count CASES]

100.00%

39.69%

8,857

100.00%

35.47%

7,567

100.00%

23.61%

6,529

0.00%

0

0.00%

0

0.00%

0

0.00%

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 5] 6:00 AM	[Jul 5] 9:46 AM	226 Mins	3.77 Hrs.	2,055 Cases
CIP + SIP	[Jul 5] 9:46 AM	[Jul 5] 2:46 PM	300 Mins	5.00 Hrs.	
Delay [Pasteurizer: Pump Leaking]	[Jul 5] 2:46 PM	[Jul 5] 9:14 PM	388 Mins	6.47 Hrs.	
Production Start of Cycle [Original Mixfruit Drink 250 mL x 18]	[Jul 5] 9:14 PM	[Jul 6] 3:56 AM	402 Mins	6.70 Hrs.	4,474 Cases
Major Breakdown [Filler: Bath Roller Bushing Wornout]	[Jul 6] 3:56 AM	[Jul 6] 6:00 AM	124 Mins	2.07 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	6,529 Cases

OEE COMPONENT (%)

[Capacity\_Utilization\_...]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

100.00%

23.61%

28.40%

83.14%

100.00%

CATEGORY (HR)

Unplanned\_Downtime

Planned\_Downtime

12.18

5.00

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Pasteurizer Pump Leaking [1x/ 6.47 Hrs. OR 388 Mins.]

2. Filler Bath Roller Bushing Wornout [1x/ 2.07 Hrs. OR 124 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard\_Packer Divider Jammed Packs [8x/ 1.57 Hrs. OR 94 Mins.]

2. Straw\_Applicator Glue Unit Nozzle Clogged [1x/ 0.73 Hrs. OR 44 Mins.]

3. Trolley Delayed [1x/ 0.60 Hrs. OR 36 Mins.]

4. Straw\_Applicator Missing/Fallen Straws [1x/ 0.38 Hrs. OR 23 Mins.]

5. Filler ASSU Automatic Strip Splicing Unit Malfunction [1x/ 0.20 Hrs. OR 12 Mins.]

6. Helix Spider Belt Jammed Packs [1x/ 0.10 Hrs. OR 6 Mins.]

7. Other Unaccounted Downtime [1x/ 0.07 Hrs. OR 4 Mins.]

UNPLANNED DOWNTIME (HR)

Delay

Process Failure

Major Breakdown

Short Stop

6.47

2.15

2.07

1.50

EQUIPMENT UNDT (HR)

Pasteurizer

Filler

Cardboard\_Packer

Straw\_Applicator

Trolley

Helix

Other

6.47

2.27

1.57

1.12

0.60

0.10

0.07

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

CIP + SIP

5.00

LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 5] 6:00 AM	[Jul 5] 12:59 PM	419 Mins	6.98 Hrs.	2,512 Cases
Major Breakdown [Filler: Squeegee Roller Wornout]	[Jul 5] 12:59 PM	[Jul 5] 6:00 PM	301 Mins	5.02 Hrs.	
Major Breakdown [Filler: Squeegee Roller Wornout]	[Jul 5] 6:00 PM	[Jul 5] 6:11 PM	11 Mins	0.18 Hrs.	
Production Start of Cycle [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 5] 6:11 PM	[Jul 5] 9:36 PM	205 Mins	3.42 Hrs.	1,391 Cases
Major Breakdown [Filler: Overlap Adjustment]	[Jul 5] 9:36 PM	[Jul 5] 11:23 PM	107 Mins	1.78 Hrs.	
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jul 5] 11:23 PM	[Jul 6] 6:00 AM	397 Mins	6.62 Hrs.	3,664 Cases
TOTAL			1,440 Mins	24.00 Hrs.	7,567 Cases

OEE COMPONENT (%)

[Capacity\_Utilization\_...]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

100.00%

35.47%

52.15%

68.01%

100.00%

CATEGORY (HR)

Unplanned\_Downtime

11.48

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Squeegee Roller Wornout [2x/ 5.20 Hrs. OR 312 Mins.]

2. Filler Overlap Adjustment [2x/ 2.65 Hrs. OR 159 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Straw\_Applicator Missing/Fallen Straws [5x/ 1.00 Hrs. OR 60 Mins.]

2. Filler Squeegee Roller Malfunction [2x/ 0.72 Hrs. OR 43 Mins.]

3. Cardboard\_Packer Glue Unit Glue Nozzle Clogged [1x/ 0.47 Hrs. OR 28 Mins.]

4. Filler ASU Automatic Splicing Unit Malfunction [2x/ 0.42 Hrs. OR 25 Mins.]

5. Helix Jammed Packs [3x/ 0.32 Hrs. OR 19 Mins.]

6. Cardboard\_Packer Open Tray [1x/ 0.20 Hrs. OR 12 Mins.]

7. Auto\_Palletizer Conveyor Full [1x/ 0.20 Hrs. OR 12 Mins.]

8. Filler Final Folder Jammed Packs [x/ 0.17 Hrs. OR 10 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

Process Failure

Short Stop

Breakdown

6.98

2.10

1.53

0.87

EQUIPMENT UNDT (HR)

Filler

Straw\_Applicator

Cardboard\_Packer

Helix

Auto\_Palletizer

Pasteurizer

9.22

1.00

0.67

0.32

0.20

0.08

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

Grand Total

LINE 7 COMBIBLOC CBS 124					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mixfruit NASOS 200 mL x 18]	[Jul 5] 6:00 AM	[Jul 5] 7:24 AM	84 Mins	1.40 Hrs.	1,170 Cases
CIP + SIP	[Jul 5] 7:24 AM	[Jul 5] 12:24 PM	300 Mins	5.00 Hrs.	
Delay [Filler: Track 3 Top Flap Malfunction]	[Jul 5] 12:24 PM	[Jul 5] 3:05 PM	161 Mins	2.68 Hrs.	
Production Start of Cycle [Original Apple Nectar 200 mL x 27]	[Jul 5] 3:05 PM	[Jul 5] 6:00 PM	175 Mins	2.92 Hrs.	1,422 Cases
Production [Original Apple Nectar 200 mL x 27]	[Jul 5] 6:00 PM	[Jul 6] 2:00 AM	480 Mins	8.00 Hrs.	4,705 Cases
Major Breakdown [Straw_Applicator: Grooved Wheel Shaft Adjustment]	[Jul 6] 2:00 AM	[Jul 6] 4:00 AM	120 Mins	2.00 Hrs.	
Production [Original Apple Nectar 200 mL x 27]	[Jul 6] 4:00 AM		120 Mins	2.00 Hrs.	

OEE COMPONENT (%)

[Capacity\_Utilization\_...]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

100.00%

39.69%

39.86%

99.77%

99.79%

CATEGORY (HR)

Unplanned\_Downtime

Planned\_Downtime

9.23

5.20

P4 Production Report DASHBOARD v3.xlsm  
Printed: 7/6/2022 8:11 AM

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	TOTAL	1,440 Mins	24.00 Hrs.	7,297 Cases	
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TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

- 1. Filler Track 3 Top Flap Malfunction [1x/ 2.68 Hrs. OR 161 Mins.]
- 2. Straw\_Applicator Grooved Wheel Shaft Adjustment [1x/ 2.00 Hrs. OR 120 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- 1. Tray\_Packer Jammed Packs [12x/ 1.87 Hrs. OR 112 Mins.]
- 2. Filler Track 3 US Generator Adjustment [6x/ 1.47 Hrs. OR 88 Mins.]
- 3. Filler Track 1 Parallelity Adjustment [1x/ 0.45 Hrs. OR 27 Mins.]
- 4. Straw\_Applicator Missing/Fallen Straws [2x/ 0.43 Hrs. OR 26 Mins.]
- 5. Pasteurizer No Product [2x/ 0.20 Hrs. OR 12 Mins.]
- 6. Filler Discharger Jammed Packs [1x/ 0.13 Hrs. OR 8 Mins.]

