

Production Date

Aug 3, 2022

JUL 2022

23

24

25

26

27

28

29

30

31

1

2

3

4

5

6

7

8

AUG 2022

DAYS

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 32 Hrs. already and CIP is due on August 4 2022 10:22 AM

Line 2 : Running for already and CIP is due on

Line 3 : Running for 20 Hrs. already and CIP is due on August 4 2022 10:00 PM

Line 4 : Running for already and CIP is due on

Line 5 : Running for already and CIP is due on

Line 7 : Running for already and CIP is due on

Date: August 3, 2022

Utilization: 27.84%

%OEE: 44.10%

Output: 20,972

Daily Performance Summary for All Production Lines

14,000

12,000

10,000

8,000

6,000

4,000

2,000

0

L03

L01

L06

L05

L07

L02

L04

[Capacity_Utilization_%]

94.86%

[OEE_%]

45.66%

[Net Output Count CASES]

11,882

[Capacity_Utilization_%]

100.00%

[OEE_%]

42.61%

[Net Output Count CASES]

9,090

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

[Capacity_Utilization_%]

0.00%

[OEE_%]

0.00%

[Net Output Count CASES]

0

L01 SHOWN

L02 HIDDEN

L03 SHOWN

L04 HIDDEN

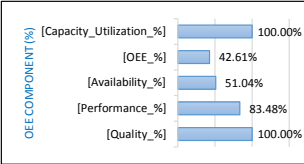
L05 HIDDEN

L07 HIDDEN

L01 AUTOFIT

L03 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Filler: Paper Misalignment]	[Aug 3] 6:00 AM	[Aug 3] 9:54 AM	234 Mins	3.90 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 3] 9:54 AM	[Aug 3] 2:53 PM	299 Mins	4.98 Hrs.	2,748 Cases
Major Breakdown [Cardboard_Packer: Electrical Devices Error/ Fault]	[Aug 3] 2:53 PM	[Aug 3] 5:40 PM	167 Mins	2.78 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 3] 5:40 PM	[Aug 3] 6:00 PM	20 Mins	0.33 Hrs.	210 Cases
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 3] 6:00 PM	[Aug 3] 10:40 PM	280 Mins	4.67 Hrs.	2,181 Cases
Major Breakdown [Filler: Outfeed Conveyor Trip-Off]	[Aug 3] 10:40 PM	[Aug 4] 12:17 AM	97 Mins	1.62 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 4] 12:17 AM	[Aug 4] 6:00 AM	343 Mins	5.72 Hrs.	3,950 Cases
TOTAL			1,440 Mins	24.00 Hrs.	9,089 Cases



- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
1. Filler Paper Misalignmt [1x/ 3.90 Hrs. OR 234 Mins.]

2. Cardboard_Packer Electrical Devices Error/ Fault [1x/ 2.78 Hrs. OR 167 Mins.]

3. Filler Outfeed Conveyor Trip-Off [1x/ 1.62 Hrs. OR 97 Mins.]
- TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]
1. Cardboard_Packer Electrical Devices Error/ Fault [4x/ 1.30 Hrs. OR 78 Mins.]

2. Filler ASSU Automatic Strip Splicing Unit Malfunction [3x/ 0.68 Hrs. OR 41 Mins.]

3. Coder No Print [2x/ 0.65 Hrs. OR 39 Mins.]

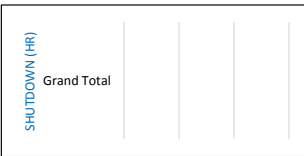
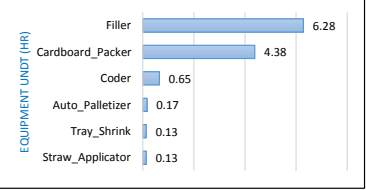
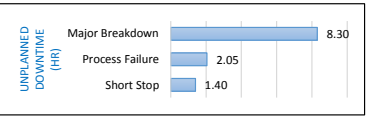
4. Auto_Palletizer Program Malfunction [1x/ 0.17 Hrs. OR 10 Mins.]

5. Tray_Shrink Change Plastic [1x/ 0.13 Hrs. OR 8 Mins.]

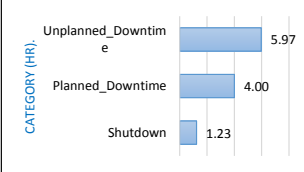
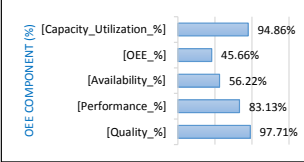
6. Straw_Applicator Missing/Fallen Straws [1x/ 0.13 Hrs. OR 8 Mins.]

7. Cardboard_Packer Divider Jammed Packs [1x/ 0.13 Hrs. OR 8 Mins.]

8. Filler Waste Box Alarm [1x/ 0.08 Hrs. OR 5 Mins.]



LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
CIP + SIP	[Aug 3] 6:00 AM	[Aug 3] 10:00 AM	240 Mins	4.00 Hrs.	
Production Start of Cycle [Original Mango Drink 125 mL x 18 + 3]	[Aug 3] 10:00 AM	[Aug 3] 6:00 PM	480 Mins	8.00 Hrs.	4,698 Cases
Production [Original Mango Drink 125 mL x 18 + 3]	[Aug 3] 6:00 PM	[Aug 4] 12:22 AM	382 Mins	6.37 Hrs.	3,859 Cases
Shutdown [Change Flavor]	[Aug 4] 12:22 AM	[Aug 4] 1:36 AM	74 Mins	1.23 Hrs.	
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 4] 1:36 AM	[Aug 4] 6:00 AM	264 Mins	4.40 Hrs.	3,324 Cases
TOTAL			1,440 Mins	24.00 Hrs.	11,881 Cases



- TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]
1. Helix Spider Belt Fallen Packs [13x/ 2.23 Hrs. OR 134 Mins.]

2. Cardboard_Packer jammed packs [8x/ 1.58 Hrs. OR 95 Mins.]

3. Straw_Applicator Missing/Fallen Straws [2x/ 0.55 Hrs. OR 33 Mins.]

4. Straw_Applicator Conveyor Section Jammed Packs [1x/ 0.42 Hrs. OR 25 Mins.]

5. Filler Waste Box Jammed Packs [2x/ 0.28 Hrs. OR 17 Mins.]

6. Filler Outfeed Conveyor Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

7. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.18 Hrs. OR 11 Mins.]

8. Filler Jaw System Pressure Dolly Broken/Damaged [1x/ 0.18 Hrs. OR 11 Mins.]
- TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]
1. Helix Spider Belt Fallen Packs [13x/ 2.23 Hrs. OR 134 Mins.]

2. Cardboard_Packer jammed packs [8x/ 1.58 Hrs. OR 95 Mins.]

3. Straw_Applicator Missing/Fallen Straws [2x/ 0.55 Hrs. OR 33 Mins.]

4. Straw_Applicator Conveyor Section Jammed Packs [1x/ 0.42 Hrs. OR 25 Mins.]

5. Filler Waste Box Jammed Packs [2x/ 0.28 Hrs. OR 17 Mins.]

6. Filler Outfeed Conveyor Jammed Packs [2x/ 0.25 Hrs. OR 15 Mins.]

7. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.18 Hrs. OR 11 Mins.]

8. Filler Jaw System Pressure Dolly Broken/Damaged [1x/ 0.18 Hrs. OR 11 Mins.]

