

Production Date

Aug 7, 2022

DAYS ▾

JUL 2022      AUG 2022



PRODUCTION CYCLE MONITORING PER LINE

**Line 1 :** Running for **9 Hrs.** already and CIP is due on **August 9 2022 9:18 AM**  
**Line 2 :** Running for already and CIP is due on  
**Line 3 :** Running for **14 Hrs.** already and CIP is due on **August 9 2022 5:04 AM**  
**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 7, 2022

Utilization:

25.00%

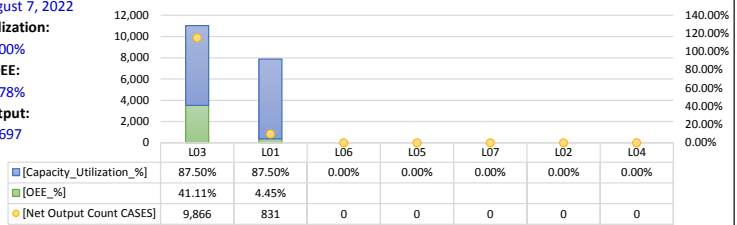
%OEE:

22.78%

Output:

10,697

Daily Performance Summary for All Production Lines



L01 SHOWN

L02 HIDDEN

L03 SHOWN

L04 HIDDEN

L05 HIDDEN

L07 HIDDEN

L01 AUTOFIT

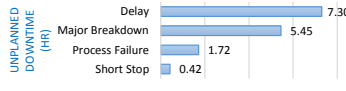
L03 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Weekend]	[Aug 7] 6:00 AM	[Aug 7] 8:00 AM	120 Mins	2.00 Hrs.	
Shutdown [Startup Activity]	[Aug 7] 8:00 AM	[Aug 7] 9:00 AM	60 Mins	1.00 Hrs.	
CIP + SIP	[Aug 7] 9:00 AM	[Aug 7] 2:00 PM	300 Mins	5.00 Hrs.	
Delay [Cardboard_Packer: Electrical Devices Error/ Fault]	[Aug 7] 2:00 PM	[Aug 7] 6:00 PM	240 Mins	4.00 Hrs.	
Delay [Cardboard_Packer: Electrical Devices Error/ Fault]	[Aug 7] 6:00 PM	[Aug 7] 9:18 PM	198 Mins	3.30 Hrs.	
Production Start of Cycle [Qobtan Apple Flavored 250 mL x 27]	[Aug 7] 9:18 PM	[Aug 7] 10:24 PM	66 Mins	1.10 Hrs.	298 Cases
Major Breakdown [Filler: LS Longitudinal Sealing Pressure Roller Broken/Damaged]	[Aug 7] 10:24 PM	[Aug 8] 3:51 AM	327 Mins	5.45 Hrs.	
Production [Qobtan Apple Flavored 250 mL x 27]	[Aug 8] 3:51 AM	[Aug 8] 6:00 AM	129 Mins	2.15 Hrs.	534 Cases
TOTAL			1,440 Mins	24.00 Hrs.	832 Cases

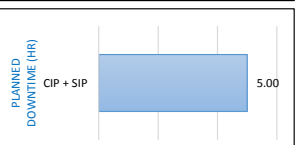
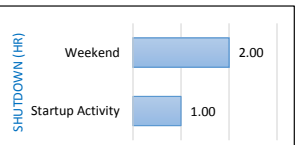
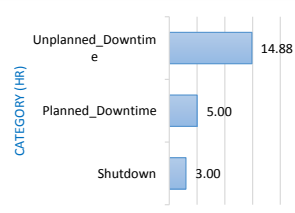
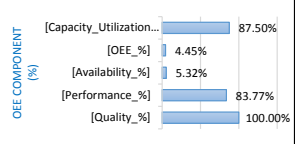
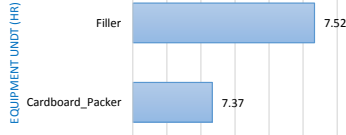
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

- Cardboard\_Packer Electrical Devices Error/ Fault [2x/ 7.30 Hrs. OR 438 Mins.]
- [Weak Sealing ] Filler LS Longitudinal Sealing Pressure Roller Broken/Damaged [1x/ 5.45 Hrs. OR 327 Mins.]



TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- Filler Final Folder Heater Malfunction [5x/ 2.07 Hrs. OR 124 Mins.]
- Cardboard\_Packer jammed packs [1x/ 0.07 Hrs. OR 4 Mins.]

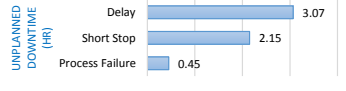


LINE 3 TETRAPAK A3 SPEED 125 ML

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [Weekend]	[Aug 7] 6:00 AM	[Aug 7] 8:00 AM	120 Mins	2.00 Hrs.	
Shutdown [Startup Activity]	[Aug 7] 8:00 AM	[Aug 7] 9:00 AM	60 Mins	1.00 Hrs.	
CIP + SIP	[Aug 7] 9:00 AM	[Aug 7] 2:00 PM	300 Mins	5.00 Hrs.	
Delay [Other: Waiting for Materials]	[Aug 7] 2:00 PM	[Aug 7] 5:04 PM	184 Mins	3.07 Hrs.	
Production Start of Cycle [Original Orange Drink 125 mL x 18 + 3]	[Aug 7] 5:04 PM	[Aug 7] 6:00 PM	56 Mins	0.93 Hrs.	815 Cases
Production [Original Orange Drink 125 mL x 18 + 3]	[Aug 7] 6:00 PM	[Aug 8] 6:00 AM	720 Mins	12.00 Hrs.	9,051 Cases
TOTAL			1,440 Mins	24.00 Hrs.	9,866 Cases

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

- Other Waiting for Materials [1x/ 3.07 Hrs. OR 184 Mins.]



TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

- Straw\_Applicator Conveyor Section Servomotor Error/ Fault [4x/ 0.78 Hrs. OR 47 Mins.]
- Cardboard\_Packer jammed packs [4x/ 0.77 Hrs. OR 46 Mins.]
- Filler ASSU Automatic Strip Splicing Unit Malfunction [1x/ 0.23 Hrs. OR 14 Mins.]
- Cardboard\_Packer Divider Jammed Packs [1x/ 0.18 Hrs. OR 11 Mins.]
- Straw\_Applicator Missing/Fallen Straws [1x/ 0.17 Hrs. OR 10 Mins.]
- Coder Bad Print [1x/ 0.17 Hrs. OR 10 Mins.]
- Tray\_Shrink Fallen Packs [1x/ 0.12 Hrs. OR 7 Mins.]
- Filler Final Folder Jammed Packs [1x/ 0.10 Hrs. OR 6 Mins.]

