

Date: July 20, 2022

Utilization: 42.55%

%OEE: 23.97%

Output: 17,757

Daily Performance Summary for All Production Lines

Production Line	Capacity Utilization (%)	OEE (%)	Net Output Count (Cases)
L07	47.85%	66.11%	10,122
L01	100.00%	39.77%	7,635
L02	50.00%	0.00%	0
L03	100.00%	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)

OEE Component (%)	Value
[Capacity_Utilization_...]	100.00%
[OEE_%]	39.77%
[Availability_%]	47.78%
[Performance_%]	83.23%
[Quality_%]	100.00%

Category (hr)	Value
Unplanned_Downtime	6.85
Planned_Downtime	5.68
Grand Total	12.53

Shutdown Time (hr)	Value
CIP + SIP	5.68

OEE COMPONENT (%)	
Capacity_Utilization_%	50.00%
[OEE_ %]	0.00%
[Availability_ %]	0.00%
[Performance_ %]	0.00%
[Quality_ %]	0.00%

CATEGORY (HR).	
Unplanned_Downtime	12.00
Shutdown	12.00

SHUTDOWN (HR)	
No Demand	12.00

PLANNED DOWNTIME (HR)	
Grand Total	

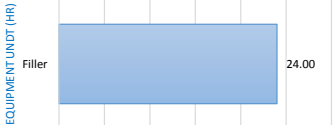
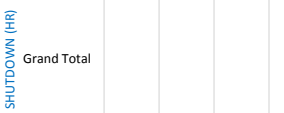
OEE COMPONENT (%)	
[Capacity_Utilization_...]	100.00%
[OEE_%]	0.00%
[Availability_%]	0.00%
[Performance_%]	0.00%
[Quality_%]	0.00%

CATEGORY (HR)	
Unplanned_Downtime	24.00

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

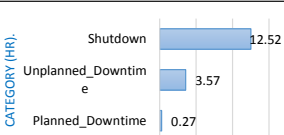
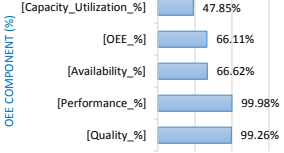
1. Filler TPOP Malfuction [2x/ 24.00 Hrs. OR 1440 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]



LINE 7 COMBIBLOC CBS 124

Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mango NASOS 200 mL x 15 + 3]	[Jul 20] 6:00 AM	[Jul 20] 1:25 PM	445 Mins	7.42 Hrs.	7,364 Cases
Major Breakdown [Filler: Outfeed Plate Misalignment]	[Jul 20] 1:25 PM	[Jul 20] 3:15 PM	110 Mins	1.83 Hrs.	
Production [Original Mango NASOS 200 mL x 15 + 3]	[Jul 20] 3:15 PM	[Jul 20] 5:29 PM	134 Mins	2.23 Hrs.	2,758 Cases
Shutdown [CIP]	[Jul 20] 5:29 PM	[Jul 20] 6:00 PM	31 Mins	0.52 Hrs.	
Shutdown [CIP]	[Jul 20] 6:00 PM	[Jul 20] 8:00 PM	120 Mins	2.00 Hrs.	
Shutdown [No Demand]	[Jul 20] 8:00 PM	[Jul 21] 6:00 AM	600 Mins	10.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	10,122 Cases



TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Outfeed Plate Misalignment [1x/ 1.83 Hrs. OR 110 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Tray_Packer Jammed Packs [5x/ 0.53 Hrs. OR 32 Mins.]
2. Pasteurizer No Product [3x/ 0.30 Hrs. OR 18 Mins.]
3. Auto_Palletizer Jammed Pallet [2x/ 0.28 Hrs. OR 17 Mins.]
4. Auto_Palletizer Fallen Carton [2x/ 0.27 Hrs. OR 16 Mins.]
5. Filler Outfeed Plate Misalignment [1x/ 0.13 Hrs. OR 8 Mins.]
6. Straw_Applicator Missing/Fallen Straws [1x/ 0.12 Hrs. OR 7 Mins.]
7. Filler Outfeed Jammed Packs [1x/ 0.10 Hrs. OR 6 Mins.]

