

Production Date

Jun 27, 2022

JUN 2022

151617181920212223242526272829301

JUL...

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for 17 Hrs. already and CIP is due on June 29 2022 2:52 AM

Line 2 : Running for 11 Hrs. already and CIP is due on June 29 2022 9:07 AM

Line 3 : Running for already and CIP is due on

Line 4 : Running for 38 Hrs. already and CIP is due on June 28 2022 5:51 AM

Line 5 : Running for already and CIP is due on

Line 7 : Running for already and CIP is due on

Date: June 27, 2022

Utilization: 41.46%

%OEE: 46.45%

Output: 25,778

Daily Performance Summary for All Production Lines

L01

L04

L02

L07

L06

L03

L05

96.60%

93.61%

100.00%

0.00%

0.00%

0.00%

0.00%

59.75%

55.35%

25.19%

10,250

11,054

4,474

0

0

0

0

L01 SHOWN

L02 SHOWN

L03 HIDDEN

L04 SHOWN

L05 HIDDEN

L07 HIDDEN

L01 AUTOFIT

L02 AUTOFIT

L04 AUTOFIT

LINE 1 TETRAPAK A3 SPEED 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 27] 6:00 AM	[Jun 27] 8:11 AM	131 Mins	2.18 Hrs.	1,609 Cases
Major Breakdown [Filler: Pendulum Roller Stucked Up]	[Jun 27] 8:11 AM	[Jun 27] 2:52 PM	401 Mins	6.68 Hrs.	
Production Start of Cycle [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 27] 2:52 PM	[Jun 27] 6:00 PM	188 Mins	3.13 Hrs.	1,916 Cases
Production [Qobtan Mixfruit Flavored 250 mL x 27]	[Jun 27] 6:00 PM	[Jun 28] 5:11 AM	671 Mins	11.18 Hrs.	6,725 Cases
Shutdown [Change Flavor]	[Jun 28] 5:11 AM	[Jun 28] 6:00 AM	49 Mins	0.82 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	10,250 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

96.60%

59.75%

60.39%

100.02%

98.91%

CATEGORY (HR)

Unplanned_Downtime

Shutdown

9.18

0.82

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Pendulum Roller Stucked Up [1x/ 6.68 Hrs. OR 401 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer jammed packs [5x/ 0.92 Hrs. OR 55 Mins.]

2. Cardboard_Packer Electrical Devices Malfunction [1x/ 0.32 Hrs. OR 19 Mins.]

3. Filler ASSU Automatic Strip Splicing Unit Malfunction [2x/ 0.32 Hrs. OR 19 Mins.]

4. Filler Electrical Cabinet Devicenet Alarm [1x/ 0.22 Hrs. OR 13 Mins.]

5. Filler TS Transversal Sealing Alarm [1x/ 0.17 Hrs. OR 10 Mins.]

6. Cardboard_Packer Tray Jammed [1x/ 0.17 Hrs. OR 10 Mins.]

7. Straw_Applicator Missing/Fallen Straws [1x/ 0.12 Hrs. OR 7 Mins.]

8. Helix Outfeed Conveyor Chain Jammed Packs [1x/ 0.08 Hrs. OR 5 Mins.]

UNPLANNED DOWNTIME (HR)

Major Breakdown

Short Stop

Process Failure

6.68

1.85

0.65

EQUIPMENT UNDT (HR)

Filler

Cardboard_Packer

Straw_Applicator

Helix

7.58

1.40

0.12

0.08

SHUTDOWN (HR)

Change Flavor

0.82

PLANNED DOWNTIME (HR)

Grand Total

LINE 2 TETRAPAK TBA22 250 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Filler: Aseptic Chamber Paper Cut]	[Jun 27] 6:00 AM	[Jun 27] 7:01 AM	61 Mins	1.02 Hrs.	
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 27] 7:01 AM	[Jun 27] 8:18 AM	77 Mins	1.28 Hrs.	120 Cases
Major Breakdown [Cardboard_Packer: Transport Chain Finger Broken/Damaged]	[Jun 27] 8:18 AM	[Jun 27] 10:42 AM	144 Mins	2.40 Hrs.	
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 27] 10:42 AM	[Jun 27] 12:25 PM	103 Mins	1.72 Hrs.	908 Cases
Inventory	[Jun 27] 12:25 PM	[Jun 27] 1:03 PM	38 Mins	0.63 Hrs.	
Production [Qobtan Mango Flavored 250 mL x 27]	[Jun 27] 1:03 PM	[Jun 27] 4:24 PM	201 Mins	3.35 Hrs.	1,862 Cases
CIP + SIP	[Jun 27] 4:24 PM	[Jun 27] 6:00 PM	96 Mins	1.60 Hrs.	
CIP + SIP	[Jun 27] 6:00 PM	[Jun 27] 9:07 PM	187 Mins	3.12 Hrs.	
Production Start of Cycle [Qobtan Mango Flavored 250 mL x 27]	[Jun 27] 9:07 PM	[Jun 28] 12:40 AM	213 Mins	3.55 Hrs.	1,584 Cases
Major Breakdown [Filler: Jaw Unit Flap Folder Broken/Damaged]	[Jun 28] 12:40 AM	[Jun 28] 6:00 AM	320 Mins	5.33 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	4,474 Cases

OEE COMPONENT (%)

[Capacity_Utilization_%]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

100.00%

25.19%

26.39%

100.02%

95.44%

CATEGORY (HR)

Unplanned_Downtime

Planned_Downtime

12.32

5.35

TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Filler Jaw Unit Flap Folder Broken/Damaged [1x/ 5.33 Hrs. OR 320 Mins.]

2. Cardboard_Packer Transport Chain Finger Broken/Damaged [1x/ 2.40 Hrs. OR 144 Mins.]

3. Filler Aseptic Chamber Paper Cut [1x/ 1.02 Hrs. OR 61 Mins.]

TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

1. Cardboard_Packer Open Tray [7x/ 1.23 Hrs. OR 74 Mins.]

2. Cardboard_Packer Divider Jammed Packs [3x/ 0.68 Hrs. OR 41 Mins.]

3. Cardboard_Packer jammed packs [3x/ 0.62 Hrs. OR 37 Mins.]

4. Straw_Applicator Missing/Fallen Straws [3x/ 0.53 Hrs. OR 32 Mins.]

5. Filler ASSU Automatic Strip Splicing Unit Malfunction [1x/ 0.15 Hrs. OR 9 Mins.]

6. Filler Final Folder Jammed Packs [1x/ 0.10 Hrs. OR 6 Mins.]

7. Filler ASU Automatic Splicing Unit Malfunction [1x/ 0.10 Hrs. OR 6 Mins.]

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

UNPLANNED DOWNTIME (HR)

Major Breakdown

Short Stop

Process Failure

8.75

2.90

0.67

EQUIPMENT UNDT (HR)

Filler

Cardboard_Packer

Straw_Applicator

6.85

4.93

0.53

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

CIP + SIP

Inventory

4.72

0.63

LINE 4 COMBIBLOC CBB 724					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Orange Drink 200 mL x 27]	[Jun 27] 6:00 AM	[Jun 27] 7:50 AM	110 Mins	1.83 Hrs.	1,381 Cases
Shutdown [Change Flavor]	[Jun 27] 7:50 AM	[Jun 27] 9:22 AM	92 Mins	1.53 Hrs.	
Production [Original Mixfruit Drink 200 mL x 27]	[Jun 27] 9:22 AM	[Jun 27] 6:00 PM	518 Mins	8.63 Hrs.	5,372 Cases
Production [Original Mixfruit Drink 200 mL x 27]	[Jun 27] 6:00 PM	[Jun 28] 12:57 AM	417 Mins	6.95 Hrs.	4,301 Cases
CIP + SIP	[Jun 28] 12:57 AM	[Jun 28] 6:00 AM	303 Mins	5.05 Hrs.	

OEE COMPONENT (%)

[Capacity_Utilization...]

[OEE_%]

[Availability_%]

[Performance_%]

[Quality_%]

93.61%

55.35%

55.71%

99.94%

99.42%

CATEGORY (HR)

Planned_Downtime

Unplanned_Downtime

Shutdown

5.43

4.52

1.53

P4 Production Report DASHBOARD v3.xlsm
Printed: 6/28/2022 7:41 AM

Page 1 of 3

TOTAL				1,440 Mins	24.00 Hrs.	11,054 Cases	
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]				<div>UNPLANNED DOWNTIME (HR)</div> <div>Short Stop3.67</div> <div>Process Failure0.85</div>			<div>SHUTDOWN (HR)</div> <div>Change Flavor1.53</div>
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]				<div>EQUIPMENT UMDT (HR)</div> <div>Tray_Packer2.82</div> <div>Pasteurizer0.67</div> <div>Filler0.50</div> <div>Tray_Shrink0.27</div> <div>Trolley0.15</div> <div>Straw_Applicator0.12</div>			<div>PLANNED DOWNTIME (HR)</div> <div>CIP + SIP5.05</div> <div>Activation Pattern0.38</div>
1. Tray_Packer Jammed Packs [13x/ 1.85 Hrs. OR 111 Mins.]							
2. Pasteurizer No Product [4x/ 0.67 Hrs. OR 40 Mins.]							
3. Filler Discharger Defective [1x/ 0.50 Hrs. OR 30 Mins.]							
4. Tray_Packer Divider Jammed Packs [3x/ 0.43 Hrs. OR 26 Mins.]							
5. Tray_Packer Tray Jammed [3x/ 0.35 Hrs. OR 21 Mins.]							
6. Tray_Packer Infeed Pusher Jammed Packs [1x/ 0.18 Hrs. OR 11 Mins.]							
7. Tray_Shrink Plastic Jammed [1x/ 0.17 Hrs. OR 10 Mins.]							
8. Trolley Delayed [1x/ 0.15 Hrs. OR 9 Mins.]							

