

Production Date

Aug 22, 2022

AUG 2022

1213141516171819202122232425262728

PRODUCTION CYCLE MONITORING PER LINE

Line 1 : Running for

Line 2 : Running for

Line 3 : Running for

Line 4 : Running for

Line 5 : Running for

Line 7 : Running for

already and CIP is due on

already and CIP is due on

already and CIP is due on

already and CIP is due on

already and CIP is due on

already and CIP is due on

August 23 2022 12:29 PM

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August 24 2022 3:48 PM

August 23 2022 6:37 AM

Date:

August 22, 2022

Utilization:

45.24%

%OEE:

39.71%

Output:

30,279

Daily Performance Summary for All Production Lines

18,00016,00014,00012,00010,0008,0006,0004,0002,0000

L07

L03

L05

L04

L02

L01

L06

100.00%

100.00%

16.67%

100.00%

0.00%

0.00%

0.00%

64.38%

56.66%

28.19%

0.00%

0.00%

0.00%

0.00%

13,735

15,542

1,002

0

0

0

0

[Capacity\_Utilization\_%]

[OEE\_%]

[Net Output Count CASES]

L01 HIDDEN

L02 HIDDEN

L03 SHOWN

L04 SHOWN

L05 SHOWN

L07 SHOWN

L03 AUTOFIT

L04 AUTOFIT

L05 AUTOFIT

L07 AUTOFIT

LINE 3 TETRAPAK A3 SPEED 125 ML					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 22] 6:00 AM	[Aug 22] 1:43 PM	463 Mins	7.72 Hrs.	4,201 Cases
Major Breakdown [Cardboard_Packer: Flight Bar Misalignment]	[Aug 22] 1:43 PM	[Aug 22] 3:07 PM	84 Mins	1.40 Hrs.	
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 22] 3:07 PM	[Aug 22] 6:00 PM	173 Mins	2.88 Hrs.	2,162 Cases
Production [Original Mixfruit Drink 125 mL x 18 + 3]	[Aug 22] 6:00 PM	[Aug 23] 6:00 AM	720 Mins	12.00 Hrs.	9,179 Cases
TOTAL			1,440 Mins	24.00 Hrs.	15,542 Cases
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]					
1. Cardboard_Packer Flight Bar Misalignment [2x/ 2.27 Hrs. OR 136 Mins.]					
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]					
1. Cardboard_Packer Divider Jammed Packs [7x/ 1.13 Hrs. OR 68 Mins.]					
2. Straw_Applicator Missing/Fallen Straws [6x/ 0.95 Hrs. OR 57 Mins.]					
3. Filler Final Folder Jammed Packs [8x/ 0.93 Hrs. OR 56 Mins.]					
4. Cardboard_Packer Tray Transport Chain Broken/Damaged [1x/ 0.50 Hrs. OR 30 Mins.]					
5. Cardboard_Packer Outfeed Conveyor Guide Adjustment [1x/ 0.47 Hrs. OR 28 Mins.]					
6. Filler Waste Box Jammed Packs [3x/ 0.43 Hrs. OR 26 Mins.]					
7. Cardboard_Packer Open Tray [2x/ 0.30 Hrs. OR 18 Mins.]					
8. Cardboard_Packer Tray Jammed [2x/ 0.27 Hrs. OR 16 Mins.]					

[Capacity\_Utilization\_%]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

100.00%

56.66%

67.78%

83.60%

100.00%

CATEGORY (HR).

Unplanned\_Downtime

7.73

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

Grand Total

LINE 4 COMBIBLOC CBB 724					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Major Breakdown [Filler: Hydrogen Peroxide Low Pressure]	[Aug 22] 6:00 AM	[Aug 22] 6:00 PM	720 Mins	12.00 Hrs.	
Major Breakdown [Filler: Hydrogen Peroxide Low Pressure]	[Aug 22] 6:00 PM	[Aug 23] 6:00 AM	720 Mins	12.00 Hrs.	
TOTAL			1,440 Mins	24.00 Hrs.	0 Cases
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]					
1. Filler Hydrogen Peroxide Low Pressure [2x/ 24.00 Hrs. OR 1440 Mins.]					
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]					

[Capacity\_Utilization\_%]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

100.00%

0.00%

0.00%

0.00%

0.00%

CATEGORY (HR).

Unplanned\_Downtime

24.00

SHUTDOWN (HR)

Grand Total

PLANNED DOWNTIME (HR)

Grand Total

LINE 5 COMBIBLOC CBB 724					
Event Description	Event Start	Event End	Duration [Minutes]	Duration [Hours]	Production Output [Cases]
Shutdown [No Demand]	[Aug 22] 6:00 AM	[Aug 22] 6:00 PM	720 Mins	12.00 Hrs.	
Shutdown [No Demand]	[Aug 22] 6:00 PM	[Aug 23] 2:00 AM	480 Mins	8.00 Hrs.	
Syrup Preparation	[Aug 23] 2:00 AM	[Aug 23] 3:15 AM	75 Mins	1.25 Hrs.	
Product Supply	[Aug 23] 3:15 AM	[Aug 23] 3:48 AM	33 Mins	0.55 Hrs.	
Production Start of Cycle [Original Orange Drink 200 mL x 27]	[Aug 23] 3:48 AM	[Aug 23] 6:00 AM	132 Mins	2.20 Hrs.	1,002 Cases

[Capacity\_Utilization...]

[OEE\_%]

[Availability\_%]

[Performance\_%]

[Quality\_%]

16.67%

28.19%

28.33%

99.49%

100.00%

CATEGORY (HR).

Shutdown

20.00

Planned\_Downtime

1.80

Unplanned\_Downtime

1.07

P4 Production Report DASHBOARD v3 .xlsx  
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		TOTAL		1,440 Mins	24.00 Hrs.	1,002 Cases
TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]						
TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]						
1. Straw_Applicator Adjustment [3x/ 0.43 Hrs. OR 26 Mins.] 2. Tray_Packer Jammed Packs [2x/ 0.35 Hrs. OR 21 Mins.] 3. Filler Outfeed Jammed Packs [1x/ 0.22 Hrs. OR 13 Mins.] 4. Straw_Applicator Missing/Fallen Straws [1x/ 0.07 Hrs. OR 4 Mins.]						

### TOP DOWNTIME CONTRIBUTOR [Breakdown, Minor and Major Breakdown]

1. Straw\_Applicator Missing/Fallen Straws [9x/ 1.48 Hrs. OR 89 Mins.]
2. [Loose Plastic] Tray\_Shrink Plastic Heater Temperature Malfunction [4x/ 1.28 Hrs. OR 77 Mins.]
3. [Paper Tearing At The Top ] Filler Top Sealing Adjustment [2x/ 0.72 Hrs. OR 43 Mins.]
4. Tray\_Packer Jammed Packs [4x/ 0.47 Hrs. OR 28 Mins.]
5. Tray\_Shrink Cutting Error [4x/ 0.47 Hrs. OR 28 Mins.]
6. Other ODS Validation [4x/ 0.43 Hrs. OR 26 Mins.]
7. Auto\_Palletizer Damaged Pallet [1x/ 0.23 Hrs. OR 14 Mins.]
8. Trolley Malfunction [1x/ 0.22 Hrs. OR 13 Mins.]

**UNPLANNED DOWNTIME (HR)**

Category	Value (HR)
Short Stop	3.97
Process Failure	2.22

**EQUIPMENT UNDY (HR)**

Equipment	Value (HR)
Tray_Shrink	1.93
Straw_Applicator	1.48
Filler	1.02
Tray_Packer	0.47
Other	0.43
Auto_Palletizer	0.23
Trolley	0.22
Pasteurizer	0.22
Coder	0.18

### TOP DOWNTIME CONTRIBUTOR [Short Stop and Process Failure]

**SHUTDOWN (HR)**

Category	Value (HR)
Grand Total	6.19

**PLANNED DOWNTIME (HR)**

Category	Value (HR)
CIP + SIP	1.95
Activation Pattern	0.35