

Manufacturing Information System (MIS) Plant 1 Yoyo (Bang Phi)

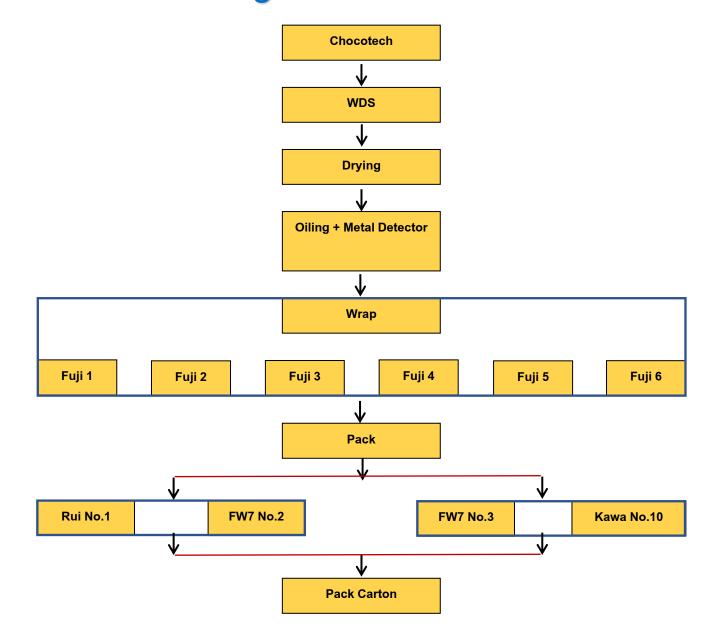


Plant 1 Yoyo

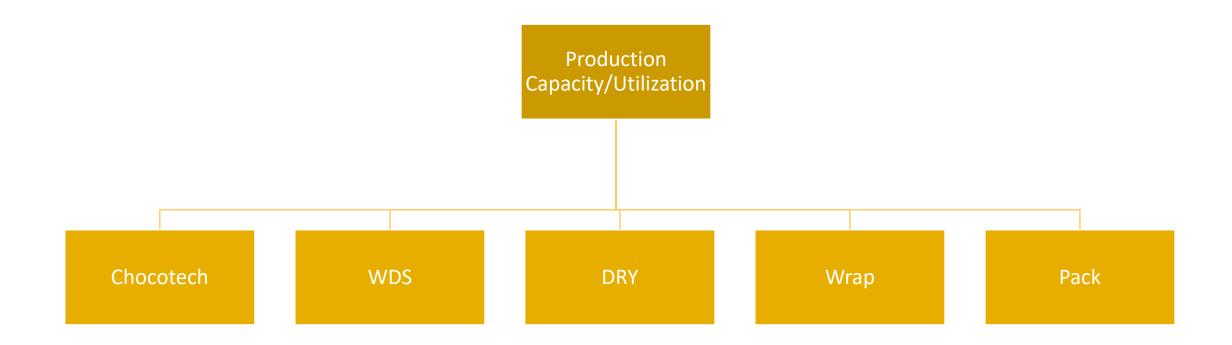




Process Flow Diagram









Chocotech + WDS

Capacity of M/C

| COOKER&DEPOSIT | | | หยอด 5 วัน | เ/สัปดาห์ | Utilization = | 240 | Hrs/Month | |
|----------------|---------|----------|------------|-----------|-----------------------|-------------|------------------|-------|
| | | | | | (12 hrs/day, 20 days) | | | |
| Machines / | Ton | Speed | % | Output | Production | Utilization | 100% Utilization | Man / |
| Lines | (Month) | (kg/min) | OEE | Tons/Hr | Hours | % | (Max Cap -Tons) | Shift |
| Chocotech | 73.35 | 35 | 60 | 1.26 | 58.22 | 24.26 | 302 | 5 |
| WDS | 73.35 | 35 | 60 | 1.26 | 58.22 | 24.26 | 302 | 15 |
| Dry | 73.35 | 16.9 | 100 | 1.014 | 72.33 | 30.14 | 243 | 7 |
| | | | yo หยอด | | | 24.26 | 302 | 27 |

| Week No | = | Chocotech + WDS | Production Out Put | = | Ton |
|---------|---|-----------------|---------------------------|---|-----|
| | | | M/C Utilization | = | % |



Dry

Capacity of M/C

| Dry | | | | |
|---------------|-------|---------------|-------------|---------|
| | | | | |
| Pallet in Dry | kg | Weight/Pallet | Tray/Pallet | kg/Tray |
| 116 | 1,600 | 140 | 80 | 1.74 |

| Week No | = | Dry Room | Production Out Put | = | Ton |
|---------|---|----------|--------------------|---|-----|
| | | | M/C Utilization | = | % |



Wrap

Capacity of M/C

| WRAP | | | | | | | | | Utilization = | 288 | Hrs/year | |
|-----------------|-------------------|------------|---------|-------|-----------|-----|--------|----------|-----------------------|-------------|------------------|---------|
| | | | | | | | | | (12 hrs/day, 22 days) | | | |
| Machines / | Target | Target | | | Speed | % | Output | | Production | Utilization | 100% Utilization | Man |
| Lines | Wt. (gm) | (Pcs/Case) | - ' ' ' | | (pcs/min) | OEE | Ton/Hr | Case/Hr | Hours | % | (Max Cap -Case) | (Shift) |
| FW3400 No 1 - 6 | 5 | 576 | 30530 | 87.93 | 2100 | 71 | 0.4473 | 155.3125 | 197 | 68.25 | 42456 | 15 |
| | | | | | | | | | | | | |
| | สรุป Yoyo ห่อเม็ด | | | | | | | | 197 | 68.25 | 42456 | 15 |

| Week No | = | Fuji No. 1 - 6 | Production Out Put | = | Ton |
|---------|---|----------------|--------------------|---|-----|
| | | | M/C Utilization | = | % |



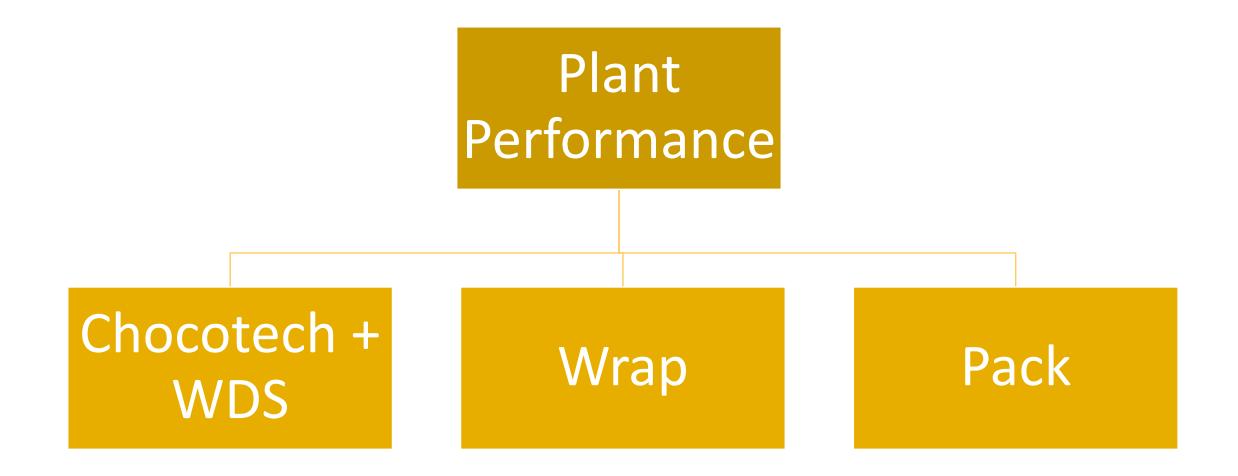
Pack

Capacity of M/C

| PACK | | | | | | | | | | Utilization = | 288 | Hrs/year | |
|----------------------|------------------|----------|------------|------------------------|-------|-----------|-------|--------|---------|-----------------------|-------------|------------------|---------|
| | | | | | | | | | | (12 hrs/day, 22 days) | | | |
| Machines / | Products | Target | Target | Demand per month(Peak) | | Speed | % | Output | | Production | Utilization | 100% Utilization | Man |
| Lines | | Wt. (gm) | (Pcs/Case) | Case | Ton | (pcs/min) | OEE | Ton/Hr | Case/Hr | Hours | % | (Max Cap -Case) | (Shift) |
| Kawa | Yoyo 20B | 80 | 24 | 24800 | 47.62 | 80 | 71.85 | 0.28 | 144 | 173 | 59.92 | 34,488 | 12 |
| | | | | | | | | | | | | | |
| | | | | สรุป Yoyo 20 baht | | | | | | 173 | 59.92 | 34,488 | 12 |
| | | | | | | | | | | | | | |
| Rui #1, FW7#2, Fw7#3 | Yoyo5B | 20 | 144 | 13000 | 37.44 | 182 | 71.85 | 0.16 | 54 | 239 | 82.84 | 13077 | 18 |
| | | | | | | | | | | | | | |
| | | | | สรุป Yoyo 5 baht | | | | | | 239 | 82.84 | 13077 | 18 |
| สรุปแผนเ | นกYoyo ส่วน Pack | | | 37800 65.49 | | | | | | 411 | 79.47 | 47565 | 30 |

| Week No | = | Pack M/C | Production Out Put | = | Case |
|---------|---|----------|--------------------|---|------|
| | | | M/C Utilization | = | % |







Week No. =

| | Month | | Week No = |
|--------------|---------------------|-------------------|-----------|
| | Utilization | (%) | |
| | Plan | (kg) | |
| Delivery | Aatual | (kg) | |
| | Plan attainment (%) | % | |
| | Speed | (kg/hr) | |
| Productivity | %OEE | Target = 60 | |
| | MH/Tom | Target = 146 | |
| | Waste (kg) | | |
| Cost | % Waste | Target = 3 | |
| | % Down time | Target = ??? | |
| | Defect Product | (kg) | |
| Quality | Defect Product | Target <= 0.009 % | |
| | Customer Complain | Target <= 4 Case | |
| | Stsff Use | | |
| Morale | %Ab | sent | |
| | % Turno | overate | |
| Safety | Accident | 0 Case | |

Chocotech + WDS



Week No. =

| | Month | | Week No = |
|--------------|-------------------|-------------------|-----------|
| | Unitization | % | |
| Delivery | Plan | (kg) | |
| Delivery | Aatual | (kg) | |
| | STD Speed Fuji | (pcs/min) | |
| Productivity | %OEE | Target = 75.44 | |
| | MH/Tom | | |
| | Waste (kg) | | |
| Cost | % Waste | Target <= 3 % | |
| | % Down time | | |
| | Defect Product | (kg) | |
| Quality | Defect Product | Target <= 0.009 % | |
| | Customer Complain | Target <= 4 Case | |
| | Stsff Use | | |
| Morale | %Abs | sent | |
| | % Turno | overate | |
| Safety | Accident | Target = 0 Case | |

Wrap

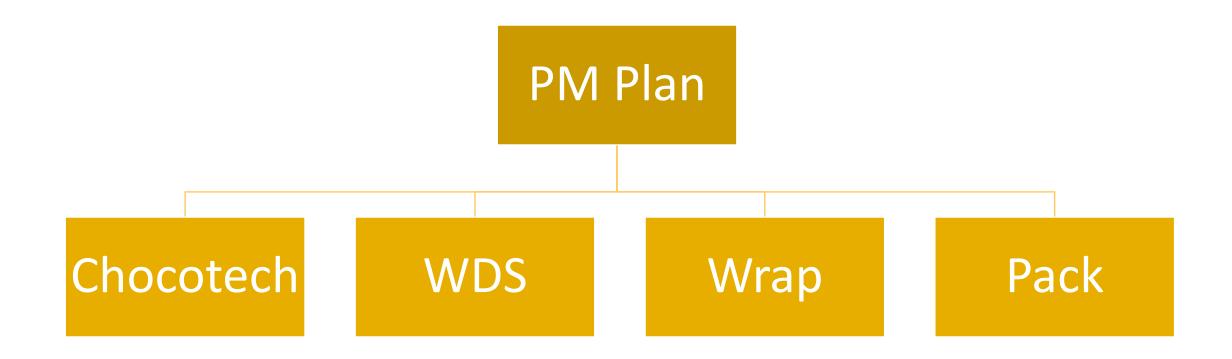


Week No. =

| | Month | | Week No = |
|--------------|---------------------|-------------------|-----------|
| | Unitization | % | |
| | Plan | Case | |
| Delivery | Aatual | (kg) | |
| Delivery | Aatuai | Case | |
| | Plan attainment (%) | % | |
| | STD Speed | (ซอง/min) | |
| Productivity | %OEE | Target = 75.44 | |
| Todactivity | MH/Tom | Target = 146 | |
| | MH/ctn | Target = 0.33 | |
| | Waste Foil (kg) | | |
| Cost | % Waste Foil | Target <= 3 % | |
| | % Down time | | |
| | Defect Product | (kg) | |
| Quality | Defect Product | Target <= 0.009 % | |
| | Customer Complain | Target <= 4 Case | |
| | Stsff Use | | |
| Morale | %Abs | sent | |
| | % Turno | overate | |
| Safety | Accident | Target = 0 Case | |

Pack







Chocotech

| | | | | | | | | | | | | | | | | | | | | | In | specti | on | | | | | | | | | | | | | | | | | | | |
|---|--------|----|-----|---|-----|---|-----|---|----|----|------|-------|------|------|----|------|------|------|----|----|----|--------|------|------|----|----|-----|-------|------|----|----|----|----|------|------|------|----|-----|----|----|-----|-------|
| List of Machines | Month | | Jar | 1 | | | Feb | | | Ma | ar | | | Apr | | | May | | | Ju | n | | | Jul | | | Aug | 9 | | Se | ер | | | Oct | | | | Nov | | | Dec | ; |
| | Week | 1 | 2 | 3 | 4 5 | 6 | 7 | 8 | 9 | 10 | 11 1 | 12 13 | 3 14 | 1 15 | 16 | 17 1 | 18 1 | 9 20 | 21 | 22 | 23 | 24 25 | 5 26 | 5 27 | 28 | 29 | 30 | 31 32 | 2 33 | 34 | 35 | 36 | 37 | 38 3 | 39 4 | 0 41 | 42 | 43 | 44 | 45 | 46 | 47 48 |
| Chocothech | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Buffer Autograv hopper | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1.ตรวจเช็คระบบไฟฟ้า ปุ่มสวิทซ์ พร้อมใช้งานหรือไม่ | Plan | EN | | | E | N | | | EN | | | EI | N | | | EN | | | EN | | | EI | N | | | EN | | | EN | | | | EN | | | ΕN | 1 | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2.ตรวจเช็คมอเตอร์ไฟฟ้า;วัดกระแส,โอมห์,ความร้อน | Plan | | | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3.ทวนสอบการทำงานของSensor โดยการ Manual test | Plan | EN | | | El | N | | | EN | | | EI | N | | | EN | | | EN | | | El | N | | | EN | | | EN | | | 1 | EN | | | ΕN | 1 | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4ตรวจเช็คหน้าแปลนลูปปั้มว่ามีรอยน้ำรั่วหรือไม่ | Plan | EN | | | El | N | | | EN | | | EI | N | | | EN | | | EN | | | EI | N | | | EN | | | EN | | | | EN | | | ΕN | 1 | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5.ตรวจเช็คระดับน้ำมันเกียร์ที่เกียร์บ็อค เพียงพอหรือไม่ | Plan | | | | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | | | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6.ตรวจเช็คใบกวน บิดงอ ผิดปกติหรือไม่ | Plan | | | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7.ตรวจเช็ค ข้อต่อ วาล์น้ำ,สตีม ข้อต่อต่างๆมีการรั่วซึมหรือไม่ | Plan | | | | | | | | | | | | | | | | | | | EN | | | | | | | | | 1 | | | 1 | T | | | | | | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



WDS

| | | | | | | | | | | | | | | | | | | | | Inspecti | on | | | | | | | | | | | | | | | | | |
|---|--------|----|----|-----|-----|----|---|-----|----|-----|----|-------|-----|----|-------|-----|----|-------|----|----------|------|------|------|----|----|------|------|-----|----|----|-------|----|------|------|----|----|-------|----|
| List of Machines | Month | | Ja | n | | Fe | b | | N | 1ar | | , | Apr | | N | Лау | | J | un | | | Jul | | Α | ug | | 5 | Sep | | | Oct | | | Nov | | | Dec | |
| | Week | 1 | 2 | 3 4 | 4 5 | 6 | 7 | 8 9 | 10 | 11 | 12 | 13 14 | 15 | 16 | 17 18 | 19 | 20 | 21 22 | 23 | 24 2 | 5 26 | 27 2 | 3 29 | 30 | 31 | 32 3 | 3 34 | 35 | 36 | 37 | 38 39 | 40 | 41 4 | 2 43 | 44 | 45 | 46 47 | 48 |
| WDS | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Destacker | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1.ตรวจเช็คระบบไฟฟ้าเซนเซอร์/ลิมิตสวิทช์ ตู้ควบคุมผิดปกติหรือไม่ | Plan | EN | | | EN | | | EI | Z | | E | EN | | E | N | | E | ≣N | | E | N | | EN | | | E | N | | | EN | | | EN | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2.ตรวจเช็คมอเตอร์ไฟฟ้า;วัดกระแส,โอมห์,ความร้อน | Plan | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3.ตรวจเช็คระดับน้ำมันเกียร์ที่เกียร์บ๊อค เพียงพอหรือไม่ | Plan | EN | | | EN | | | EI | N | | E | EN | | E | ΞN | | E | ĒΝ | | E | N | | ΕN | | | E | N | | | EN | | | EN | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4.ตรวจเช็คลูกปืน และจุดหมุนต่างๆ ชำรุดผิดปกติหรือไม่ | Plan | EN | | | EN | | | EI | N | | E | EN | | E | ΞN | | E | ≣N | | E | N | | EN | | | El | N | | | EN | | | EN | | | EN | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5.ตรวจเช็คซุปเปอร์ลีนชำรุด สึกหรอ หรือไม่ | Plan | | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6.ตรวจเช็คสายพาน ชำรุดผิดปกติหรือไม่ | Plan | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7.โคลงสร้างเครื่องจักรพร้อมใช้งานหรือไม่ | Plan | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | | | | | | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | ı | | | | | | | | | |
| 8.ทำความสะอาด บริเวณรอบๆ ทั่วไปของเครื่องจักร | Plan | | | | | | | | | | | | | | | | | EN | | | | | | | | | | | ı | | | | | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



Wrap

| | | | | | | | | | | | | | | | | | | | ı | nspecti | on | | | | | | | | | | | | | | | | |
|---|--------|---|-----|-----|---|-----|-----|-----|----|-------|----|------|------|----|------|-------|-----|------|----|---------|------|-----|-------|----|----|-------|----|------|-------|----|------|-------|----|------|------|------|-------|
| List of Machines | Month | | Jar | 1 | | Fel | b | | Ма | r | | Apr | | | May | , | | Ju | ın | | | Jul | | Αι | ıg | | Se | р | | 0 | ct | | N | lov | | | Dec |
| | Week | 1 | 2 | 3 4 | 5 | 6 | 7 8 | 3 9 | 10 | 11 12 | 13 | 14 1 | 5 16 | 17 | 18 1 | 19 20 | 0 2 | 1 22 | 23 | 24 2 | 5 26 | 27 | 28 29 | 30 | 31 | 32 33 | 34 | 35 3 | 36 37 | 38 | 39 4 | 40 41 | 42 | 43 4 | 14 4 | 5 46 | 47 48 |
| Wrap | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| เครื่อง ห่อเม็ด FUJI 3400 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| าตรวจเช็คสภาพอุปกรณ์ไฟฟ้า ปุ่ม พร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2ตรวจเช็ค EN-SEAL ใบมีดตัด ว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3ตรวจเช็คการขันแน่นสกรู น๊อต | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4ตรวจเช็คจาระบีระบบหล่อลื่นเครื่องจักร | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5ตรวจเช็คถาดรับขนมว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6ตรวจเช็คชุดเรียงเม็ด ลูกกลิ้งปัด ว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7ตรวจเช็คสายพานเรียงเม็ด ว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8ตู้ดูดฟอล์ยเปล่าทำงานปกติหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | | | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



Pack

| | | | | | | | | | | | | | | | | | | | | Insp | pection | 1 | | | | | | | | | | | | | | | | | | |
|--|--------|---|-----|-----|---|-----|-----|---|------|------|----|----|------|-------|------|-----|----|------|-----|------|---------|----|----|------|-------|----|----|----|----|------|----|----|-------|----|----|--------|----|--------|--------|--------|
| List of Machines | Month | | Jar | 1 | | Feb | | | Mar | | | Ар | r | | N | lay | | | Jun | | | J | ul | | Д | ug | | | Se | р | | Oc | t | | N | Vov | | | Dec | |
| | Week | 1 | 2 | 3 4 | 5 | 6 | 7 8 | 9 | 10 1 | 1 12 | 13 | 14 | 15 1 | 16 17 | 7 18 | 19 | 20 | 21 2 | 2 2 | 3 24 | 25 | 26 | 27 | 28 2 | 29 30 | 31 | 32 | 33 | 34 | 35 3 | 37 | 38 | 39 40 | 41 | 42 | 43 | 44 | 45 4 | 46 4 | 17 48 |
| Pack | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| เครื่อง Pack FW7 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1ตรวจเช็คสภาพสวิทช์ไฟฟ้าหน้าจอชำรุดหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | E | N | | | EN | | | EN | | | | EN | | | EN | | | EN | | | Е | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2ตรวจเช็ค BASE SEAL JAW ว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | E | N | | | EN | | | EN | | | | EN | | | EN | | | EN | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3ตรวจเช็คการขันแน่นสกรู น๊อต | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | E | N | | | EN | | | EN | | | | EN | | | EN | | | EN | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4ตรวจเซ็คแรงดันในโตรเจนปกติหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | T | EN | | | Е | N | | | EN | | T | EN | | | | EN | | | EN | | | EN | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5ตรวจเซ็ค ALIGNMENT SEALว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | | EN | | | EN | | | EN | | | Е | N | | | EN | | | EN | | | | EN | | | EN | | | EN | | | E | EN | |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | \top | \top | |
| 6ตรวจเช็คตึงของสายพานแวคคัมว่าพร้อมใช้งานหรือไม่ | Plan | | EN | | | EN | | T | EN | | | EN | | | EN | | | E | N | | | EN | | | EN | | | | EN | | | EN | | | EN | \Box | | E | EN | |
| | Actual | | | | | | | T | | | | | | | | | | | | | | | | | | | | | | | | | | | | \Box | ΙŤ | \top | \top | |
| 7ตรวจเช็คสภาพของ ROLLER ร้อยฟิล์มลูกโป่งรั่วซึมหรือไม่ | Plan | | EN | | | EN | | Ī | EN | | | EN | | | EN | | | E | N | | | EN | | ı | EN | | | | EN | | | EN | | | EN | \Box | | E | EN | \top |
| | Actual | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



To Do List: Plant 1

To Do List



To Do List: Plant 1

To Do List

Updated On : 12 June 2020 (ล่าสุด)

| Areas | เนื้อหา | | Due Date | ผู้รับผิดชอบ | Status |
|--------------------|---|-------------|----------|----------------|--------|
| 1. Plant 1 | 1 ทดลองเปลี่ยน Filter ของเครื่อง Starch dryer จากของเยอรมันเป็นของไทย จำนวน 2 ตัว (จาก 132 ตัว) เพื่อตรวจสอบอายุดการใช้งาน | Cost Saving | 1/6/20 | Amontep, Natee | Done |
| (Yoyo / RTD Jelly) | 2 Modify ตัวกั้นหัวชั่ง เครื่อง Pack Rui เพื่อแก้ไขปัญหาขบเม็ด และลด foil เสีย | Cost Saving | 16/5/20 | Wasin, Natee | Done |
| | 3 ใช้ถุงพลาสติกคลุมถาดรับเม็ด Yoyo เหมือนกับโรงงาน 2 เพื่อลดความถี่ในการล้าง ทำความสะอาดถาดรับเม็ด Yoyo | Cost Saving | 8/5/20 | Amontep, Natee | Done |
| | 4 ซ่อมเครื่องห่อ Fuji No 4,6 เพื่อแก้ปัญหา ขบเม็ด ,เม็ดคู่ และซองเปล่า โดยคุณเจษ | Recovery MC | 1/6/20 | Wasin, Natee | |
| | 5 ซ่อมเครื่อง Pack KAWA หัวชั่งเสีย 7 หัว ให้ใช้งานได้ตามปกติ | MC | 1/6/20 | Wasin, Natee | |
| | 6 เพิ่ม Filter กรองอากาศก่อนเข้า Air unit เพื่อลดการเปลี่ยน Filter ในตัว Air unit | Cost Saving | 1/6/20 | Amontep, Natee | |
| | 7 เปลี่ยนระบบ Heater ถังกลูโคส เป็นคอยล์ร้อน | Cost Saving | 10/6/20 | Amontep, Natee | Done |
| | 8 ติดตั้งสายพานแพ็คกล่อง+เครื่อง Tape Machine ลดพนักงานได้ 4 คน | Cost Saving | 31/7/20 | Wasin, Natee | |