

# COPAR PLANT PRODUCTION DISPLAY NETWORK

## PRODUCTION SUMMARY (SUPERVISOR OFFICE)

### CORRUGATOR 1

Speed	Average
<b>425</b>	<b>175</b>
Per Hour	Target
<b>25,500</b>	<b>625</b>
Downtime	Shift Total
<b>02:27:32-12</b>	<b>53,671</b>
Copar Corporation 12:06:02	

157 42" Flexo	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>211</b>	<b>12,964</b>	<b>216</b>
	Shift Total	Uptime	Downtime
	<b>85,990</b>	<b>84%</b>	<b>01:04:02-08</b>
181 50" Flexo	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>0</b>	<b>17,438</b>	<b>290</b>
	Shift Total	Uptime	Downtime
	<b>115,666</b>	<b>64%</b>	<b>02:24:06-58</b>
184 Folder Gluer	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>140</b>	<b>6,457</b>	<b>107</b>
	Shift Total	Uptime	Downtime
	<b>25,072</b>	<b>56%</b>	<b>02:45:41-03</b>
Copar Corporation 13:38:39			

### CORRUGATOR 2

Speed	Average
<b>425</b>	<b>175</b>
Per Hour	Target
<b>25,500</b>	<b>625</b>
Downtime	Shift Total
<b>02:27:32-12</b>	<b>53,671</b>
Copar Corporation 12:06:02	

SINGLE COMPUTER

### FLE XO

181 50" Flexo	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>18,000</b>	<b>115,666</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>17,438</b>	<b>64%</b>	<b>290</b>
Downtime	Speed (PPM)	
<b>02:24:06-58</b>	<b>0</b>	

### FLE XO

157 42" Flexo	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>12,500</b>	<b>85,990</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>12,964</b>	<b>84%</b>	<b>216</b>
Downtime	Speed (PPM)	
<b>01:04:02-08</b>	<b>211</b>	

### ROTARY DIE CUTTER

232 Rotary Die Cutter	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>11,900</b>	<b>68,678</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>10,354</b>	<b>90%</b>	<b>172</b>
Downtime	Speed (PPM)	
<b>00:40:21-03</b>	<b>0</b>	

### DIE CUTTER

238 Rotary Die Cutter	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>8,000</b>	<b>40,694</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>7,928</b>	<b>78%</b>	<b>132</b>
Downtime	Speed (PPM)	
<b>01:30:54-14</b>	<b>140</b>	

### FOLDER GLUER

184 Folder Gluer	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>7,900</b>	<b>25,072</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>6,457</b>	<b>56%</b>	<b>107</b>
Downtime	Speed (PPM)	
<b>02:45:41-03</b>	<b>140</b>	

## PRODUCTION SUMMARY (WEB ACCESS)



### PRESS

331 Press	Copar Corporation	13:38:39
Target Speed (PPH)	Shift Total	
<b>3,800</b>	<b>26,737</b>	
Pieces Per Hour	Uptime	Average (PPM)
<b>4,031</b>	<b>81%</b>	<b>67</b>
Downtime	Speed (PPM)	
<b>01:15:41-09</b>	<b>71</b>	



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**PRODUCTION SUMMARY  
(SUPERVISOR OFFICE)**

<b>157 42" Flexo</b>	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>211</b>	<b>12,964</b>	<b>216</b>
	Shift Total	Uptime	Downtime
	<b>85,990</b>	<b>84%</b>	<b>01:04:02-08</b>
<b>181 50" Flexo</b>	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>0</b>	<b>17,438</b>	<b>290</b>
	Shift Total	Uptime	Downtime
	<b>115,666</b>	<b>64%</b>	<b>02:24:06-58</b>
<b>184 Folder Gluer</b>	Speed (PPM)	Pieces Per Hour	Average (PPM)
	<b>140</b>	<b>6,457</b>	<b>107</b>
	Shift Total	Uptime	Downtime
	<b>25,072</b>	<b>56%</b>	<b>02:45:41-03</b>
			<b>13:38:39</b>
Copar Corporation			

- High Definition LED TV Displays
- One Computer Handles Up To 15 Machines
- Fully Customizable
- Speed Is Color Coded  
**RED** Below Target  
**GREEN** Above Target

**CORRUGATOR**

Total Shift Lineal	Shift SQ Footage	
<b>274,841</b>	<b>1,951</b>	
Total Shift Downtime	Wet End Remaining	
<b>00:54:14-3</b>	<b>2,933</b>	
Current Downtime	Time Remaining	
<b>00:00:00</b>	<b>3:21</b>	
Speed	Target Speed	Average Speed
<b>880</b>	<b>891</b>	<b>734</b>
294 Corrugator	Copar Corporation	13:38:39

Add Your Company Logo To Any Screen

Interfaces With Web-Fed or Sheet-Fed Machines

HDMI Video Servers Drive Any Size/Resolution LED TV

Cat 5/6 Network Connections

Connects Via Private Network Or Can Utilize Your Existing Network

**FLEXO**

Speed	<b>50" Flexo</b>	Average
<b>140</b>		<b>32</b>
		Minimum Speed
		<b>6000</b>
Per Hour	Shift Total	
<b>8,400</b>	<b>5,041</b>	
Downtime	Uptime	
<b>01:57:32-14</b>	<b>25%</b>	
Copar Corporation		<b>09:35:43</b>

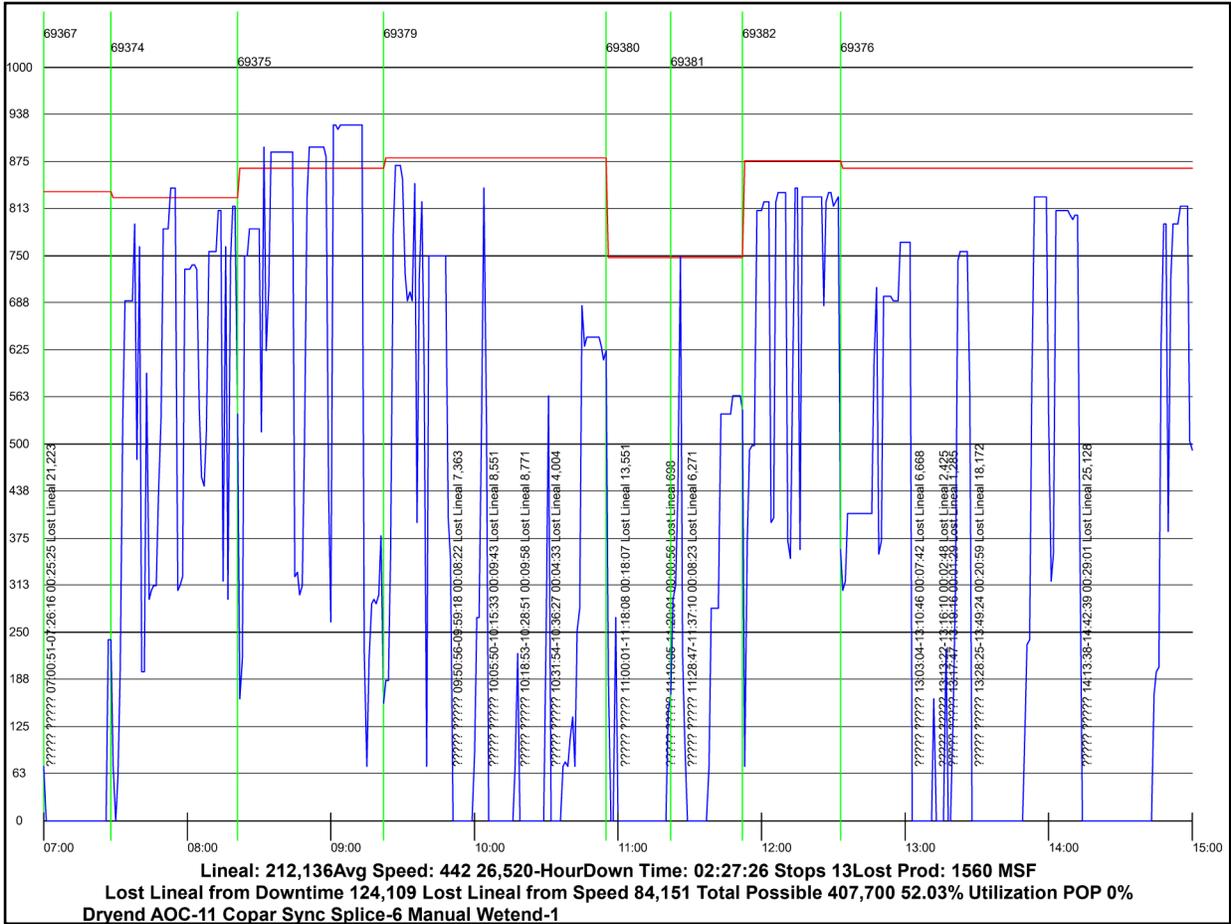
Real Time Web Based Production Reports

View From Plant Network or Secure VPN Access From Mobile Devices

Records Stored on Hard Drive

Automatic E-Mail Reports Sent To Key Personnel

# DIGITAL CHART RECORDER



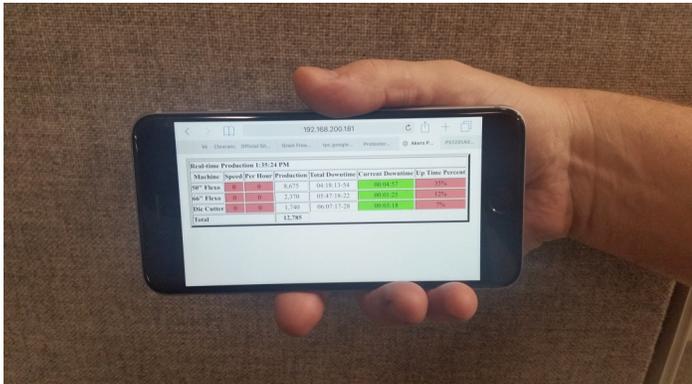
## SHIFT TOTALS

Lineal	Total Possible	Down Time	Speed Loss	Utilization	Stops	POP Usage	CSC Auto	CTC
67	397,975	397,975	0	0%	0	0	0	0
68	397,975	397,975	0	0%	0	0	0	0
69	397,975	397,975	0	0%	0	0	0	0
70	397,975	397,975	0	0%	0	0	0	0
71	397,975	397,975	0	0%	0	0	0	0
72	397,975	397,975	0	0%	0	0	0	0
73	397,975	397,975	0	0%	0	0	0	0
74	397,975	397,975	0	0%	0	0	0	0
75	397,975	397,975	0	0%	0	0	0	0
76	397,975	397,975	0	0%	0	0	0	0
77	397,975	397,975	0	0%	0	0	0	0
78	397,975	397,975	0	0%	0	0	0	0
79	397,975	397,975	0	0%	0	0	0	0
80	397,975	397,975	0	0%	0	0	0	0
81	397,975	397,975	0	0%	0	0	0	0
82	397,975	397,975	0	0%	0	0	0	0
83	397,975	397,975	0	0%	0	0	0	0
84	397,975	397,975	0	0%	0	0	0	0
85	397,975	397,975	0	0%	0	0	0	0
86	397,975	397,975	0	0%	0	0	0	0
87	397,975	397,975	0	0%	0	0	0	0
88	397,975	397,975	0	0%	0	0	0	0
89	397,975	397,975	0	0%	0	0	0	0
90	397,975	397,975	0	0%	0	0	0	0
91	397,975	397,975	0	0%	0	0	0	0
92	397,975	397,975	0	0%	0	0	0	0
93	397,975	397,975	0	0%	0	0	0	0
94	397,975	397,975	0	0%	0	0	0	0
95	397,975	397,975	0	0%	0	0	0	0
96	397,975	397,975	0	0%	0	0	0	0
97	397,975	397,975	0	0%	0	0	0	0
98	397,975	397,975	0	0%	0	0	0	0
99	397,975	397,975	0	0%	0	0	0	0
100	397,975	397,975	0	0%	0	0	0	0

## DOWNTIME

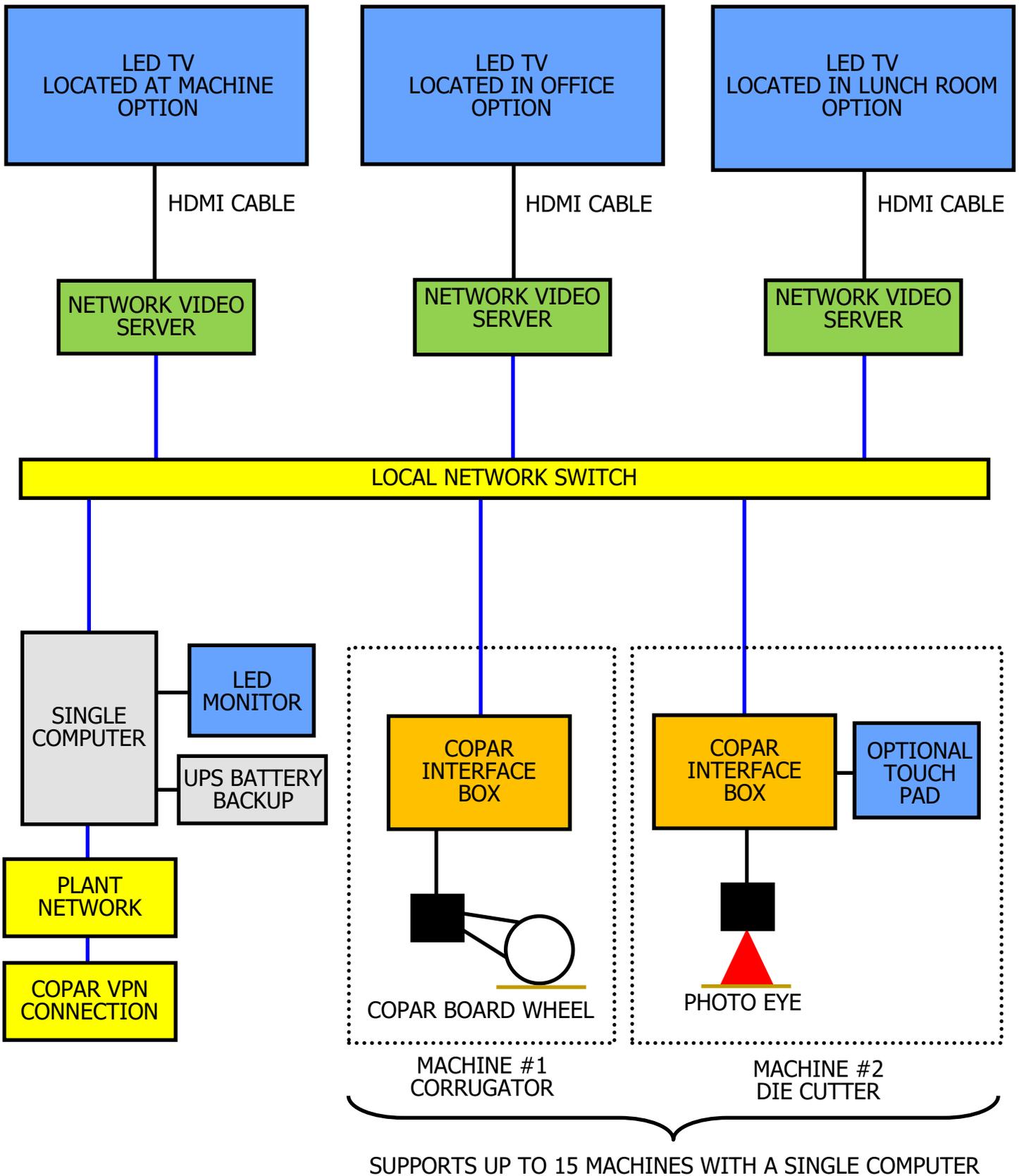
Location	Reason	Stops	Total
1/1/2017-1/7/2017	Location - Reason Shift 1		
????	????	1	08:00:00
DB fluter medium splicer	Splice tore out	6	00:21:31
DB splicer	Jam	2	00:18:19
Fosber	Maintenance	1	00:12:51
Fosber	Jam	2	00:11:30
Bridge	Snapped bridge	1	00:10:42
C fluter medium splicer	Web tore out	1	00:10:42
C-flute	Web tore out	2	00:09:09
Hot plate section	Splice tore out while running	1	00:07:17
Bottom stacker	Jam	1	00:06:04
DB glue unit	bottom Web tore out	1	00:04:35
DB splicer	Splice tore out	1	00:04:15
C fluter liner splicer	Splice tore out while running	1	00:04:06
C-flute	Maintenance	1	00:03:05
Hot plate section	Web tore out	1	00:02:59
Fosber	Bad Setup	1	00:01:56
Trim chute	Jam	1	00:01:18
Bottom stacker	Photo eye stopped machine	1	00:00:47
<b>Total</b>		<b>13</b>	<b>10:11:06</b>

## REAL TIME PRODUCTION



## WEB ACCESS

Machine	Speed	Per Hour	Production	Total Downtime	Current Downtime	Uptime
157 - 42" Flexo	211	12,964	85,990	01:04:02-08	00:00:00	84%
181 - 50" Flexo	0	17,438	115,666	02:24:06-58	00:21:04	64%
184 - Folder Gluer	140	6,457	25,072	02:45:41-03	00:00:00	56%
232 - Rotary Die Cutter	0	10,354	68,687	00:40:21-03	00:03:51	90%
238 - Rotary Die Cutter	140	7,928	40,694	01:30:54-14	00:00:00	78%
331 - Press	71	4,031	26,737	01:15:41-09	00:00:00	81%
194 - Corrugator	636	35,919	238,250	00:29:32-08	00:00:00	92%
294 - Corrugator	880	41,454	274,841	00:54:14-03	00:00:00	86%
<b>Converting Total</b>			<b>362,846</b>			
<b>Corrugator Total</b>			<b>513,091</b>			



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