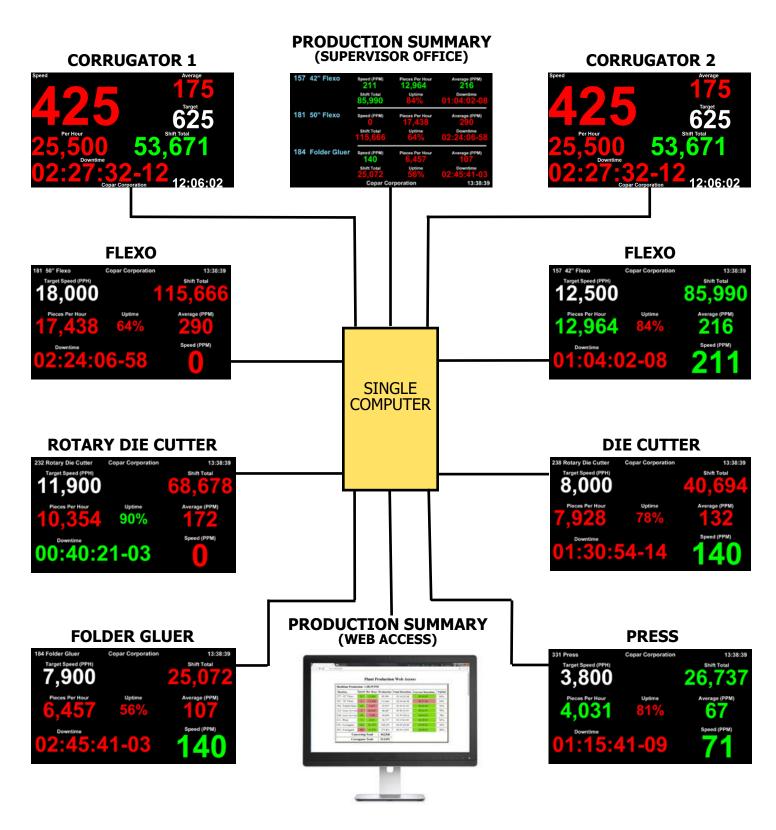
# COPAR PLANT PRODUCTION DISPLAY NETWORK





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# PRODUCTION SUMMARY (SUPERVISOR OFFICE)

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

High Definition LED TV Displays

One Computer Handles Up To 15 Machines

**Fully Customizable** 

Speed Is Color Coded RED Below Target GREEN Above Target

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

#### CORRUGATOR



#### **FLEXO**



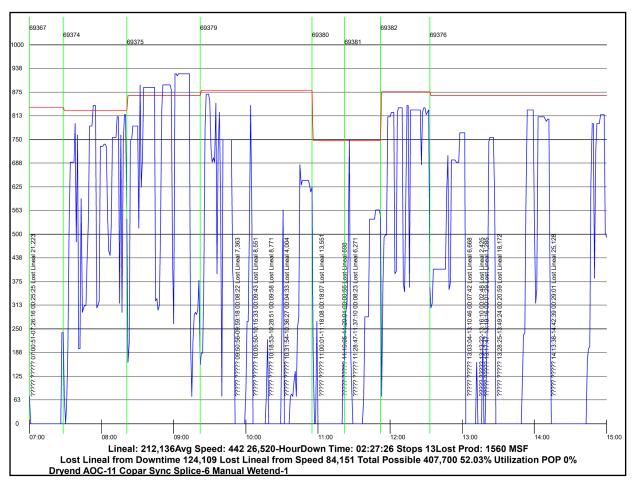
Real Time Web Based Production Reports

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**

730	NIF LINEAL 195.659	(2) Lineal 330,453	IST EINHAL IIT.UWZ	(4) Dinesi 250,479	(5) Lineal 271,/44	(0) Lineal 205,944
	Total Possible 277,957	Total Possible 403,640	Total Possible 399,814	Total Possible 392,297	Total Possible 366,921	Total Possible 393,534
I	Downtime Loss 90,288	Downtime Loss 43,914	Downtime Loss 253,263	Downtime Loss 87,302	Downtime Loss 40,841	Downtime Loss 146,529
I	Speed Loss +7,990	Speed Loss 29,273	Speed Loss 29,509	Speed Loss 46,516	Speed Loss 28,336	Speed Loss 41,061
1	Utilization 70.4%	Utilization 81.9%	Utilization 29.3%	Utilization 65.9%	Otilization 81.1%	Utilization 52.3%
1	Stops-15 02:48:15	Stops=7 00:52:12	Stops=5 04:55:36	Stops=14 01:46:55	Stops-8 00:58:40	Stope=12 02:59:26
I	Dry-10 Wet-6 Manual-3	Dry-18 Wet-5 Manual-3	Dry-6 Met-2 Manual-1	Dry-16 Wet-3 Manual-3	Dry-15 Wet-5 Manual-2	Dry-8 Wet-3 Manual-2
I	POP Usage-0%	POP Usage-0%	POP Usage-0%	POP Usage-0%	POP Usage-0%	POP Usage-0%
I	C88C Auto 68.4%	C88C Auto 65.2%	CSSC Auto 67.7%	CSSC Auto 64.5%	C88C Auto 68.2%	CSSC Auto 66%
ı	CTC Auto 100%	CTC Auto 100%	CTC Auto 100%	CTC Auto 100%	CTC Auto 100%	CTC Auto 100%
(7) Lineal	(8) Lineal 397,775	(9) Lineal 121,150		(11)Lineal 86,101	(12)Lineal 261,194	(13)Lineal 355,777
Total Possible 0		Total Possible 336,824		Total Possible 409,698		Total Possible 400,467
Downtime Loss 392,640	Downtime Loss 3,973	Downtime Loss 188,304	Downtime Loss 192,416	Downtime Loss 304,528	Downtime Loss 83,210	Downtime Loss 19,463
Speed Loss	Speed Loss +9,758	Speed Loss 27,370	Speed Loss 2,861	Speed Loss 19,069	Speed Loss 58,052	Speed Loss 25,227
Utilization 0%	Utilization 101.5%	Utilization 36%	Utilization 51.4%	Utilization 21%	Utilization 64.9%	Utilization 88.8%
Stops-1 08:00:00	Stops-1 00:05:06	Stops-8 04:54:18	Stops-5 03:42:45	Stops-7 05:50:39	Stops-12 01:39:12	Stops-6 00:22:46
Dry-0 Met-0 Manual-0	Dry-18 Wet-6 Manual-2	Dry-9 Wet-5 Manual-2	Dry-5 Met-3 Manual-1	Dry-7 Net-2 Manual-4	Dry-8 Wet-3 Manual-1	Dry-12 Wet-5 Manual-3
POP Usage-0%	POP Usage-0%	POP Usage-0%	POP Usage-0h	POP Usage-0's	POP Usage-0%	POP Usage-0%
CSSC Auto 0h	CSSC Auto 68.5%	CSSC Auto 76.76	CSSC Auto 74.3%	CSSC Auto 69.6%	CSSC Auto 62.76 CTC Auto 1009	CSSC Auto 73%
CRC 0%	CTC Auto 1004	CTC Auto 100%	CTC Auto 1004	CTC Auto 100%	CTC Auto 100%	CTC Auto 1004
(14)Lineal	(15)Lineal 212,136	(16)Lineal 164,632	(17)Lineal 38,966	(18)Lineal 295,910	(19)Lineal 198,191	(20)Lineal
Total Possible 0	Total Possible 407,700	Total Possible 378,904	Total Possible 384,744		Total Possible 383,153	Total Possible 0
Downtime Loss	Downtime Loss 124,109	Downtime Loss 177,811	Downtime Loss 333,111	Downtime Loss 64,389	Downtime Loss 130,779	Downtime Loss
Speed Loss	Speed Loss 71,455	Speed Loss 36,461	Speed Loss 12,667	Speed Loss 43,873	Speed Loss 54,183	Speed Loss
Utilization 09 Stops-0 00:00:00	Utilization 52% Stops-13 02:27:26	Utilization 43.4% Stops-11 03:43:41	Utilization 10.19 Stops-3 06:52:16	Utilization 73.2% Stops-7 01:20:33	Otilization 51.7% Stops-16 02:36:54	Utilization 0% Stops-0 00:00:00
Dry-0 Not-0 Manual-0	Dry-11 Wet-6 Manual-1	Dry-9 Wet-4 Manual-2	Dry-6 Wet-3 Manual-0	Dry-18 Wet-7 Manual-3	Dry-10 Wet-6 Manual-1	Dry-0 Wet-0 Manual-0
POP Unage-03	POP Unage-05	POP Unage-01	POP Unage-Ol	POP Unage-03	POP Unage-01	POP Unage-Ol
CSSC Auto 0%	CSSC Auto 61.85	CSSC Auto 56.43	CSSC Auto 88.93	CSSC Auto 63.55	CSSC Auto 75.93	CSSC Auto 05
CTC 0%	CTC Auto 1009	CTC Auto 1009	CTC Auto 100%	CTC Auto 100%	CTC Auto 1009	CTC 0%
(21)Lineal	(22)Lineal 338,930	(23)Lineal 314,231	(24)Lineal 98,681	(25)Lineal 248,184	(26)Lineal 385,858	(27)Lineal
Total Possible 0	Total Possible 394,201	Total Possible 397,113	Total Possible 398,480		Total Possible 410,705	Total Possible 0
Downtime Loss	Downtime Loss 38,760	Downtime Loss 53,801	Downtime Loss 270,652	Downtime Loss 115,592	Downtime Loss 8,242	Downtime Loss 363,360
Speed Loss	Speed Loss 16,511	Speed Loss 29,081	Speed Loss 29,147	Speed Loss 49,461	Speed Loss 16,605	Speed Loss
Utilization 0%	Utilization 86%	Utilization 79.1%	Utilization 24.8%	Utilization 60.1%	Utilization 94%	Utilization Ot
Stops-0 00:00:00	Stops-7 00:47:19	Stops-9 01:05:23	Stops-6 05:25:02	Stops-12 02:14:01	Stops-3 00:09:44	Stops-1 08:00:00
Dry-0 Met-0 Manual-0 POP Usage-03	Dry-14 Wet-6 Manual-3	Dry-15 Wet-5 Manual-3 POP Hange-05	Dry-2 Met-2 Manual-0 FOP Heage-0h	Dry-10 Met-5 Manual-3	Dry-17 Wet-5 Manual-4 POP Hange-05	Dry-0 Wet-0 Manual-0 POP Usage-0h
	CSSC Auto 64.1%	CSSC Auto 709	CSSC Auto 609	CSSC Auto 57.69	CSSC Auto 67.1%	CSSC Auto 0%
CSSC Auto 0%	CSSC Auto 64.1%	CSSC Auto 70%	CSSC Auto 60%	CSSC Auto 57.6%	CSSC Auto 67.1%	CSSC Auto 0%
CTC UE			CAC WRED TOOK	CTC AUTO 100%	CTC AUGO 100%	CYC UE
(28)Lines1	(29)Lines1 179,067	(30)Lineal 312,514	(1)	(2)	(3)	(4)
Total Possible 0	Total Possible 350,750	Total Possible 397,020				I
Downtime Loss 363,360	Downtime Loss 135,689	Downtime Loss 50,281				I
Speed Loss	Speed Loss 35,994	Speed Loss 34,225				l .
Utilization 0%	Utilization 51.1%	Utilization 78.7%				I
Stops-1 08:00:00	Stops-10 03:03:04	Stops-8 01:08:38				
Dry-0 Wet-0 Manual-0	Dry-8 Wet-2 Manual-1	Dry-13 Wet-3 Manual-2				1
POP Usage-03	POP Usage-0%	POP Usage-05				

### **DOWNTIME**

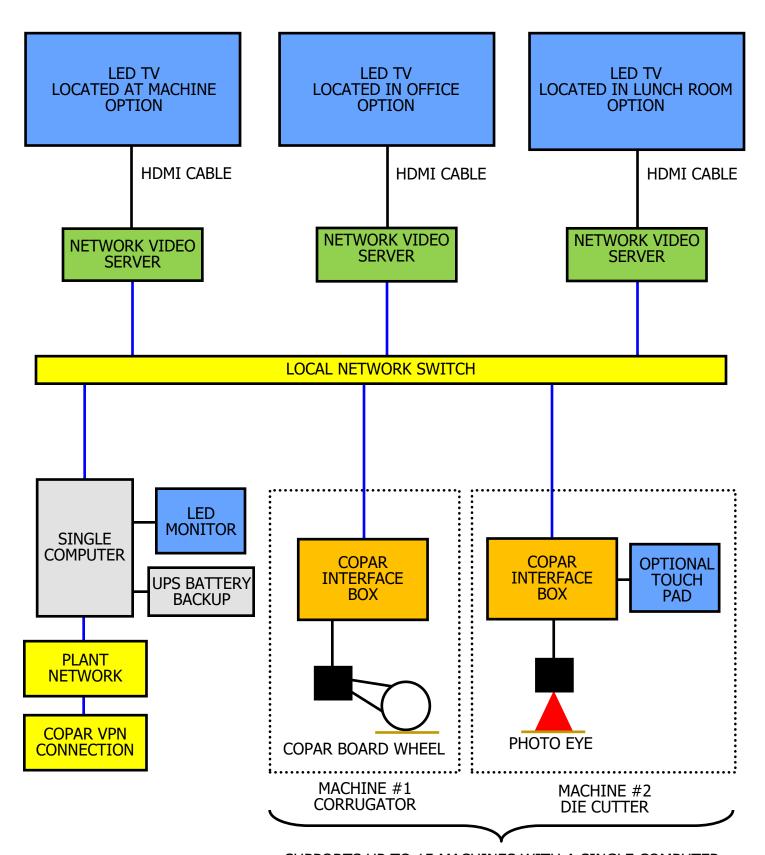
Location	Reason	Stops	Total
????	????	1	08:00:00
C flute medium splicer	Splice tore out	6	00:21:31
DB splicer	Jam	2	00:18:19
Fosber `	Maintenance	1	00:12:51
Fosber	Jam	2	00:11:30
Bridge	Snapped bridge	1	00:10:42
C flute medium splicer	Web tore out	1	00:10:42
C-flute	Web tore out	2	00:09:09
Hot plate 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 flute 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
		Total	10:11:06

# **REAL TIME PRODUCTION**



# **WEB ACCESS**

Realtime Production 1:38:39 PM						
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%
Converting Total		362,846				
Corrugator Total		513,091				



SUPPORTS UP TO 15 MACHINES WITH A SINGLE COMPUTER

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