



MAKE EVERY *shift* COUNT 2025

EXECUTIVE SUMMARY

Yield is steady, but production depends on one line.

01 Confirm why only Line B carries production.

All 979 recorded batches ran on Frying Line B. Lines A and Extrusion show downtime but no batch output.

02 Lift yield with product-level fixes.

Full-year yield was 96.6%. The gap is stable enough for targeted improvement.

03 Attack the top downtime causes.

Temperature instability and bearing vibration created the most downtime minutes. Separate planned work from true breakdowns.

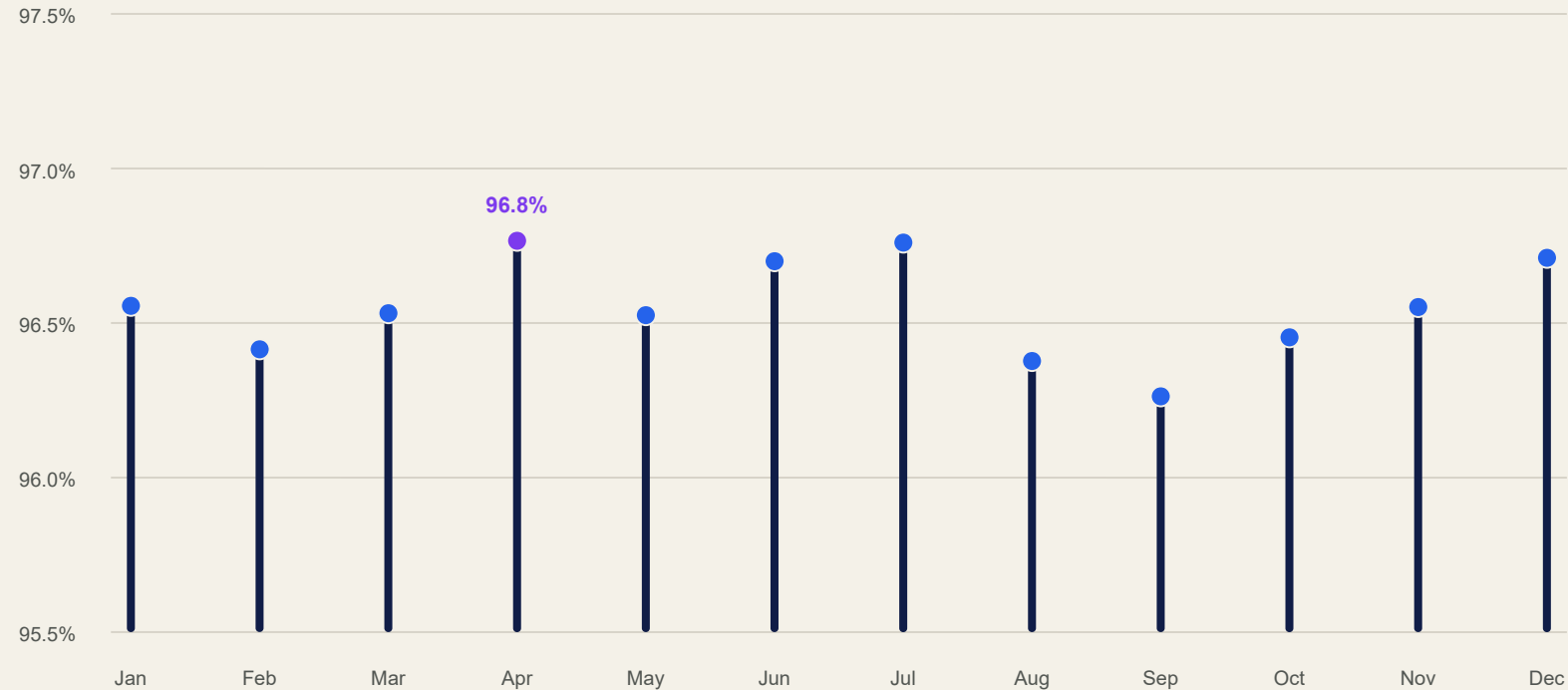
Yield stays near

96.5% through
the year

WHAT IT MEANS

The monthly yield range is narrow. That is good for control, but it also means improvement will come from repeated small fixes rather than one bad month.

Good cases as a share of planned cases



All recorded batches

ran on Frying

Line B

CHECK FIRST

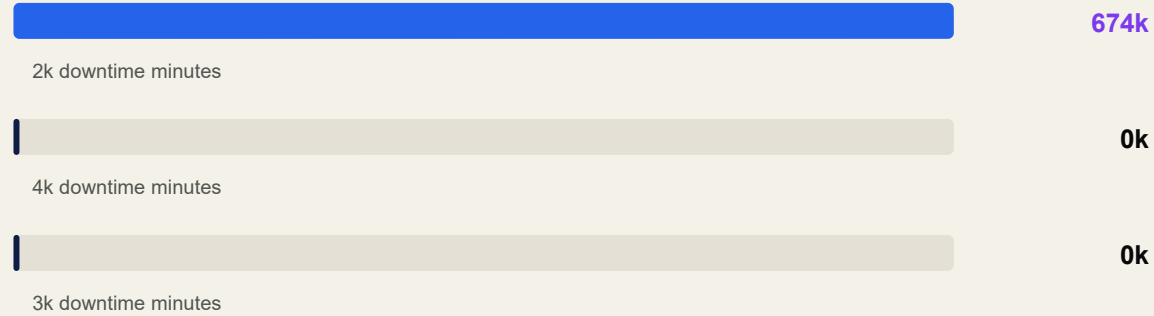
This is a major concentration risk or a data-capture gap. Verify whether Lines A and Extrusion were idle, used outside the batch system, or assigned incorrectly.

Frying Line B

Frying Line A

Extrusion and Baking Line

Good cases by production line



The three shifts

have almost the same yield

WHAT IT MEANS

Morning produces more because it has more batches, not because it converts better. Night yield is only slightly lower. Focus on product and cause, then coach shifts.

Morning



353 batches

Afternoon



313 batches

Night



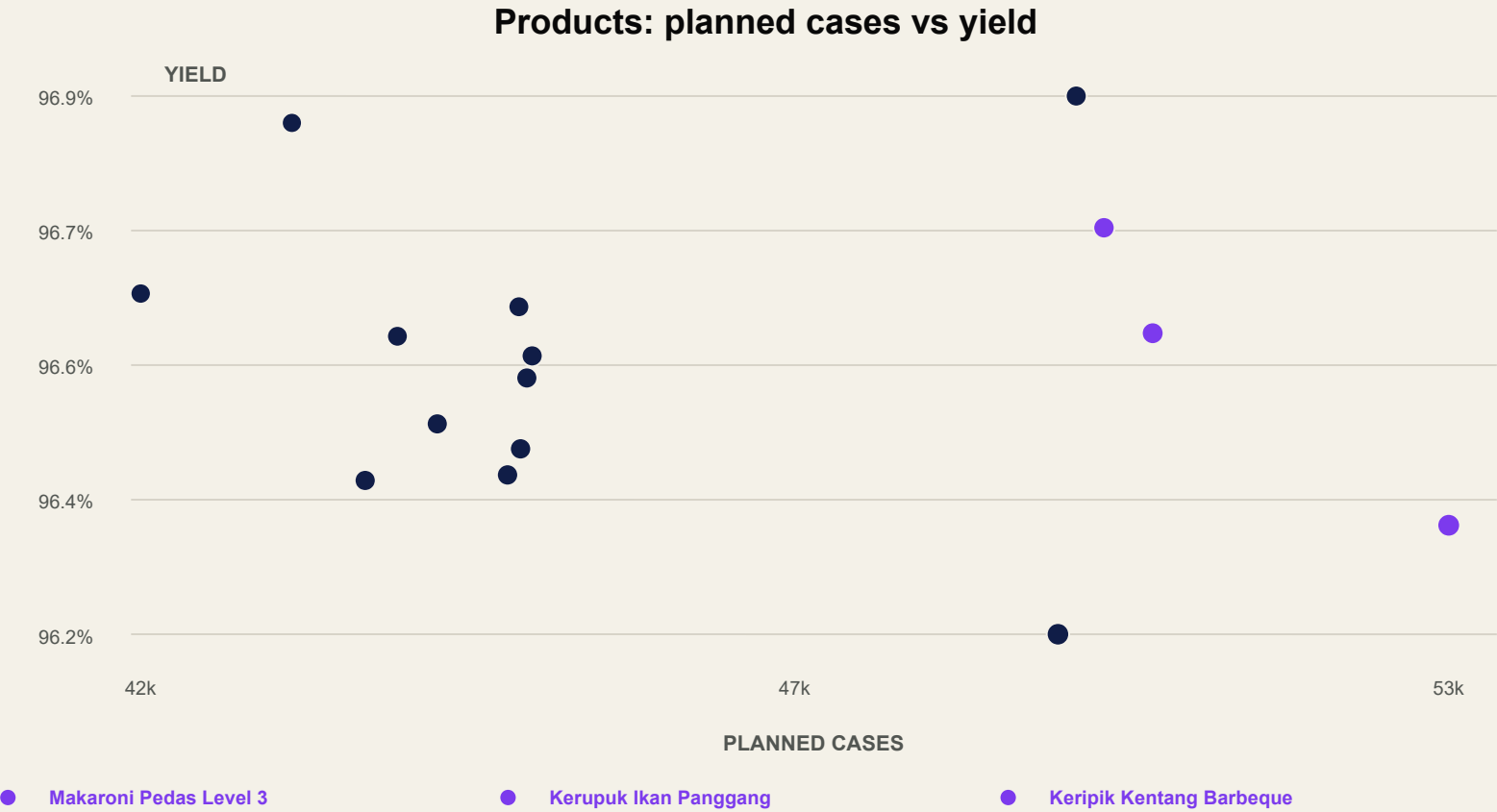
313 batches

Yield by shift

A few products sit
below the factory
average

WHAT IT MEANS

The scatter compares planned volume and yield. High-volume products with lower yield deserve first attention because a small improvement returns more good cases.



Temperature and

bearings lead total

downtime

WHAT IT MEANS

Total downtime mixes planned and unplanned events. The note under each bar shows unplanned minutes - use those minutes for breakdown reduction, while keeping needed cleaning and maintenance.

Temperature instability

Bearing vibration

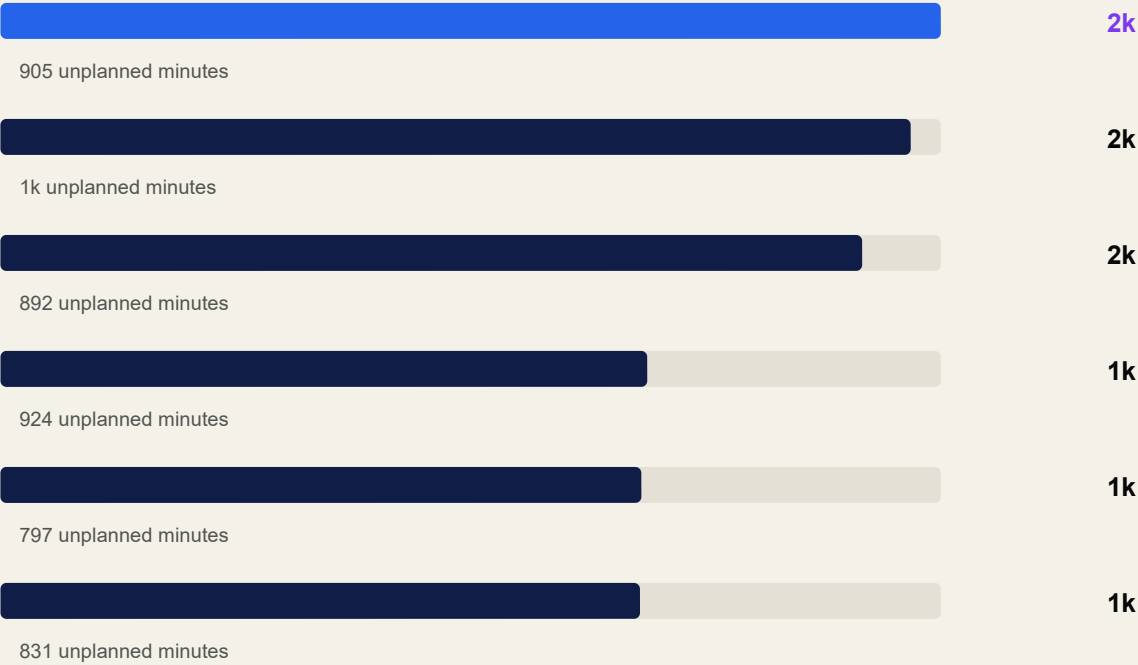
Cleaning and sanitation

Changeover

Film feed jam

Preventive maintenance

Downtime minutes by reason



Small process gains

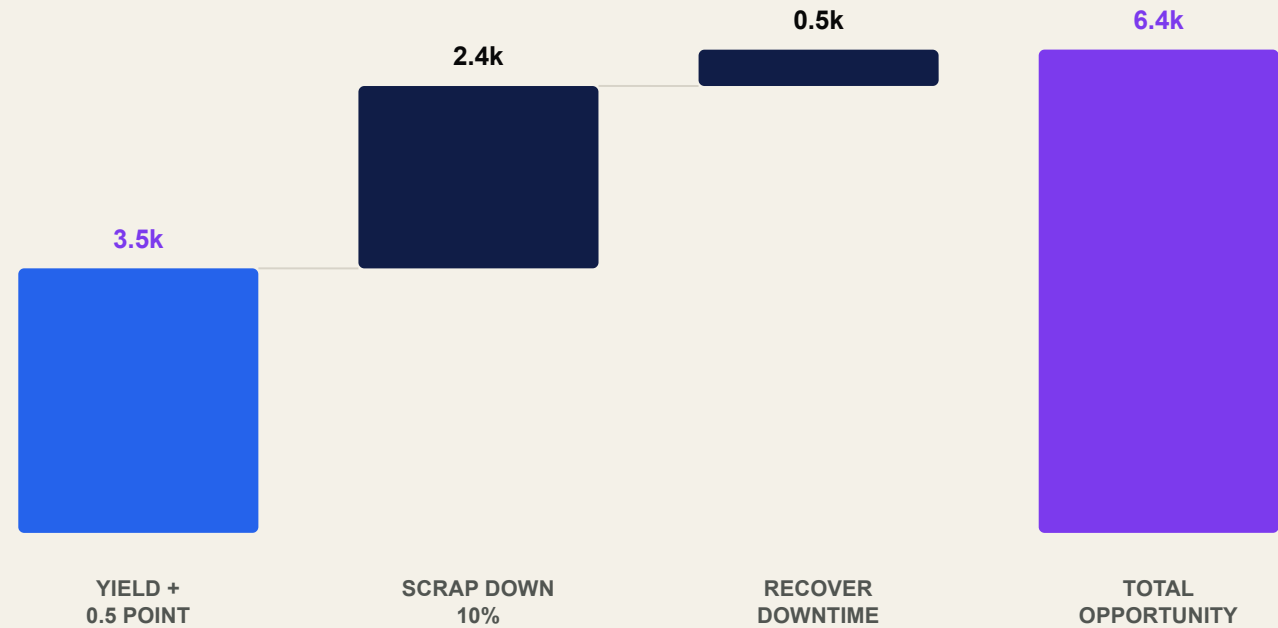
could recover about

6k cases

SCENARIO

This scenario adds 0.5 percentage point of yield, cuts scrap 10%, and recovers 15% of unplanned downtime at an assumed 35 cases per hour.

Illustrative annual case recovery



Scenario only - not a forecast

DO THESE THREE THINGS FIRST

Simple actions, clear owners, and one number to watch.

01

Verify line assignment

Reconcile every 2025 batch to the physical line and explain zero-output lines.

OWNER

Plant manager

WATCH

Batches by line

02

Run two loss sprints

Fix temperature instability and bearing vibration with named causes and due dates.

OWNER

Maintenance

WATCH

**Unplanned
downtime**

03

Target three products

Use the highest-volume, lower-yield products for weekly yield checks.

OWNER

Production + QA

WATCH

**Good cases /
planned**

THE BOTTOM LINE

The factory is stable, but it is too dependent on one recorded line.

The first job is to verify line data and operating status. Then use short loss-reduction sprints on the largest downtime causes and high-volume products.

96.6%

Full-year production yield

979

Batches recorded on Line B

6k cases

Illustrative recovery

Use the first 30 days to confirm the data, then scale only what improves the chosen KPI.