

# COPAR PLANT PRODUCTION DISPLAY NETWORK

## PRODUCTION SUMMARY (SUPERVISOR OFFICE)

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

## CORRUGATOR 1

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

## CORRUGATOR 2

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

## FLEXO

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

## FLEXO

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

SINGLE  
COMPUTER

## ROTARY DIE CUTTER

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

## DIE CUTTER

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

## PRODUCTION SUMMARY (WEB ACCESS)



## FOLDER GLUER

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

## PRESS

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




**COPAR SOLUTIONS™**

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## PRODUCTION SUMMARY (SUPERVISOR OFFICE)

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

## CORRUGATOR

Total Shift Lineal <b>274,841</b>	Shift SQ Footage <b>1,951</b>
Total Shift Downtime <b>00:54:14-3</b>	Wet End Remaining <b>2,933</b>
Current Downtime <b>00:00:00</b>	Time Remaining <b>3:21</b>
Speed <b>880</b>	Target Speed <b>891</b>
	Average Speed <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>140</b>	50" Flexo	Average <b>32</b>
		Minimum Speed <b>6000</b>
Per Hour <b>8,400</b>	Shift Total <b>5,041</b>	
Downtime <b>01:57:32-14</b>	Uptime <b>25%</b>	
	Copar Corporation	09:35:43

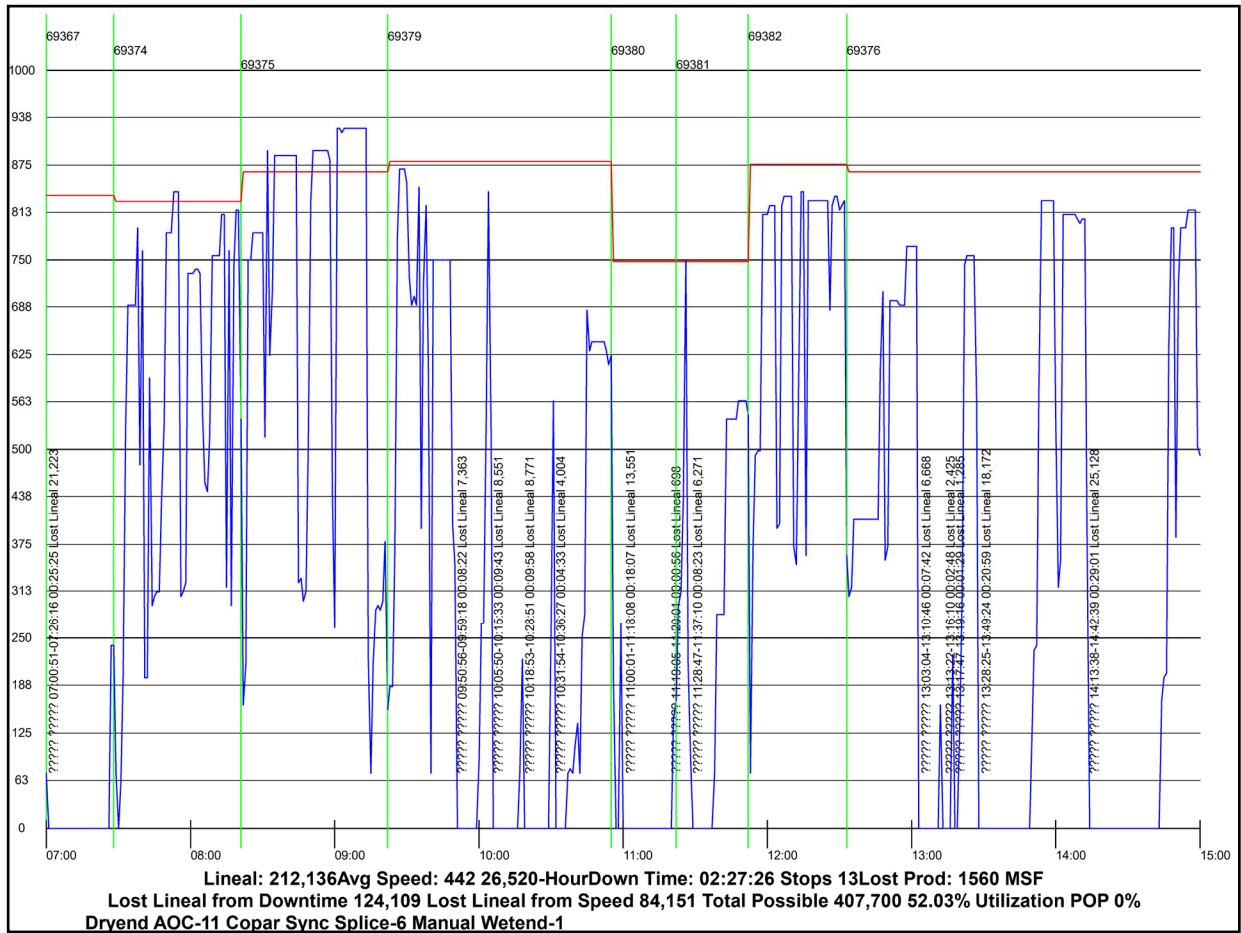
Real Time Web Based Production Reports

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



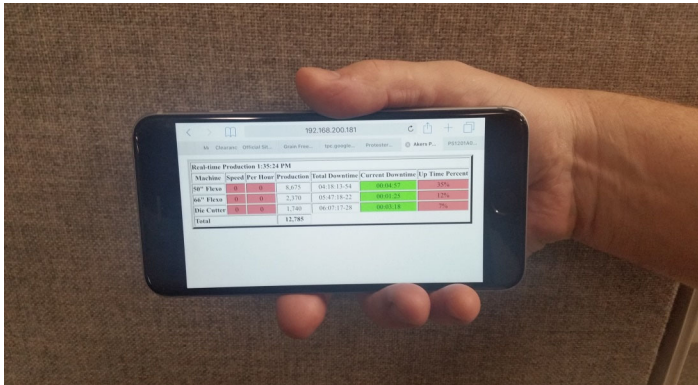
## SHIFT TOTALS

7) Lineal Total Possible 277,950 Downline Loss 90,284 Speed Loss 17,292 Utilization 70.4% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	8) Lineal 397,775 Total Possible 397,775 Downline Loss 397,775 Speed Loss 17,292 Utilization 95.4% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	9) Lineal 121,150 Total Possible 336,404 Downline Loss 199,304 Speed Loss 17,292 Utilization 36% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	10) Lineal 204,878 Total Possible 402,150 Downline Loss 197,272 Speed Loss 17,292 Utilization 51.4% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	11) Lineal 261,134 Total Possible 402,150 Downline Loss 141,016 Speed Loss 17,292 Utilization 64.9% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	12) Lineal 261,134 Total Possible 402,150 Downline Loss 141,016 Speed Loss 17,292 Utilization 64.9% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%	13) Lineal 355,777 Total Possible 402,150 Downline Loss 146,373 Speed Loss 17,292 Utilization 63.8% Stages: 01:00:00 Dry-0 Wet-0 Manual-0 POP Usage-0 CSC Auto 68.4% CTC Auto 100%
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## DOWNTIME

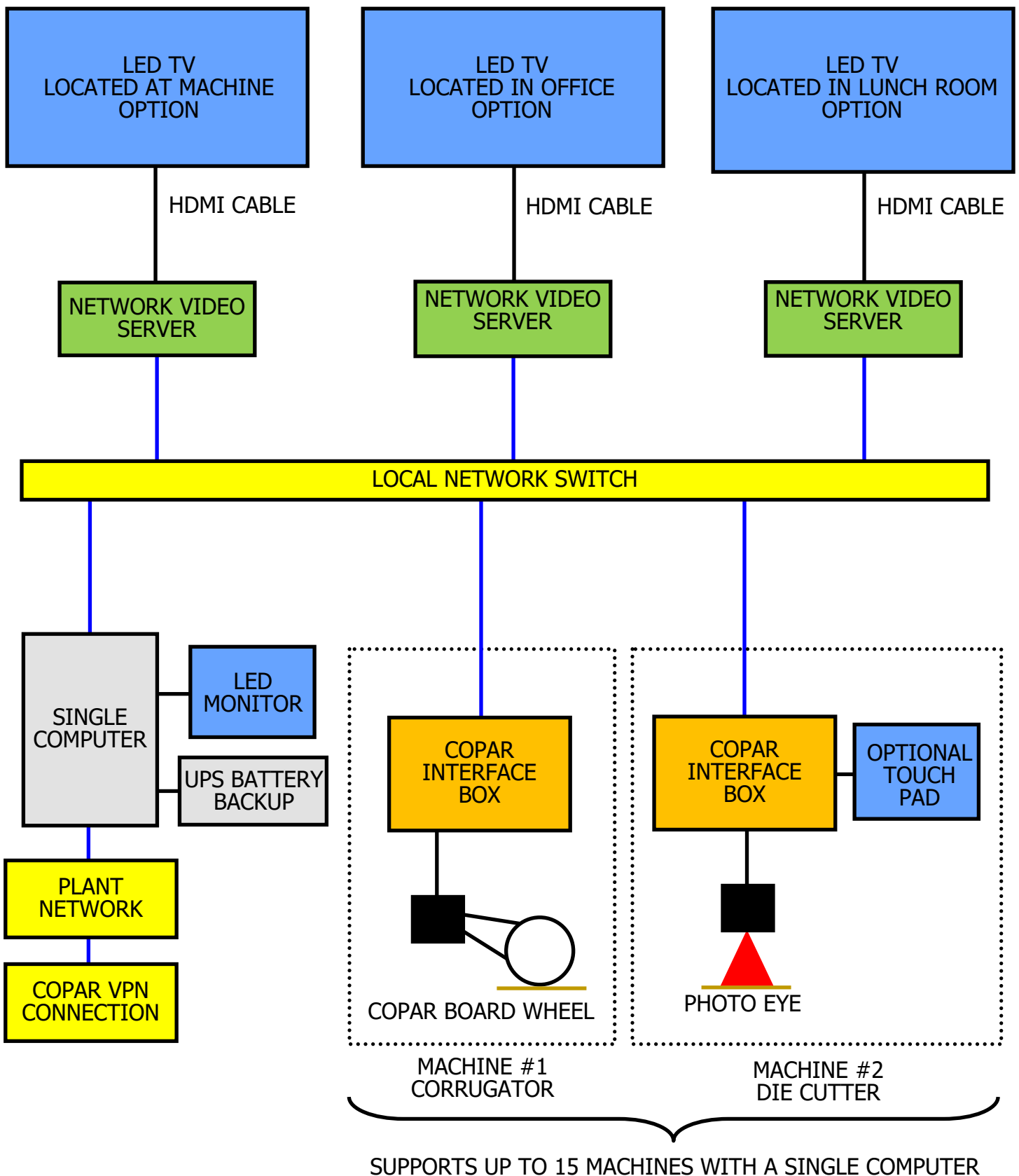
1/1/2017-1/7/2017 Location - Reason Shift 1			Stops	Total
Location	Reason			
????	????		1	08:00:00
C flute medium splicer	Splice tore out		6	00:21:31
DB splicer	Jam		2	00:18:19
Fosber	Maintenance		1	00:12:51
Fosber	Jam		2	00:11:30
Bridge	Snapped bridge		1	00:10:42
C flute medium splicer	Web tore out		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	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			



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