

## *DOWNTIME CLASSIFICATION*

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Guidance for own and external downtimes decision

### **Machine System Own Downtimes**

An equipment imputable downtime (own downtime) is the duration of a stoppage of the machine system caused by:

- One component of the equipment installed by the Supplier and covered by the present offer.
- A stoppage of this component for a reason beyond the Buyer's responsibility:
  - Mechanical or electrical part breakdown.
  - Interrupted feeding of the component while utilities, materials, product and power conform to the Supplier's specifications.
  - Container that is damaged or laid down by one of the equipment components.
  - Usual and mandatory operations linked to the equipment design (reel change or film splicing, gluing parts cleaning, etc.). In that case, the Buyer and the Supplier will agree on a Standard Operation Procedure describing the standard quality and duration of execution. Shall the execution not comply with the SOP, the duration of the own downtime will be limited to the ones agreed in the SOP. The excessive downtime will be qualified as External Downtime.
- Non productive time due to pre-heating or pre-cooling processes when consecutive to an own downtime as above described.
- Unplanned downtimes for cleaning when following and as a consequence of an own downtime as above described.

### **Machine System External Downtimes**

A downtime not caused by the equipment (external downtime) is a stoppage of the machine system caused by:

- Any element of the plant, in connection with the equipment, but not covered by the present offer.
- A stoppage of any component of the equipment covered by the present offer for reason beyond the Supplier's responsibility, such as (but not limited to).
  - Shortage in supply of product, materials, utilities or power.
  - Absence of one or more operator.
  - Stoppage of an excessive duration or as a consequence of an inadequate execution of a usual and mandatory operation compared to the agreed Standard Operation Procedure.  
Only the time portion exceeding the time defined in the SOP is deemed as External Downtime.
  - Manual equipment speed limitation without Supplier's formal agreement.
  - Sampling, quality or sanitary procedures.
  - Interrupted supply of materials, product, utilities and power as a consequence of inadequate quality (not complying with Supplier's specifications).
- Non productive time due to pre-heating or pre-cooling processes when following and as a consequence of an external stop