

$$x^2 + 3(c) + ab$$

$$f(x) [a+b] + v_i$$

$$\sqrt{ab}(c) x^2 + 3$$

$$f = -0.5 z^2 \frac{\sqrt{I}}{\sqrt{I+1}}$$

$$3 + f(x) + v_i$$

$$K = \frac{[NH_3]^2}{[N_2][H_2]^3}$$

$$\theta + [a] 7 x + 3$$

$$5x^2 + a(b) + v_i$$

$$sb + [a] + (c) x^3$$

New perspective in your CIP! **Digital Solutions**

WONG, HWEE JIAU

TECHNICAL SUPPORT MANAGER

FOOD & BEVERAGE DIVISION - SEA

11 June 2019



Everywhere It Matters.™

Agenda

- ▲ Current Condition
- ▲ Can I have.....
- ▲ Enabling Digital Solutions



The background of the slide features a vibrant blue color scheme. The upper portion is dominated by a close-up, high-resolution image of water ripples, showing concentric circles and intricate patterns of light and shadow. The lower portion of the slide is a solid, bright white, which is separated from the blue background by a smooth, curved white arc.

CURRENT CONDITION

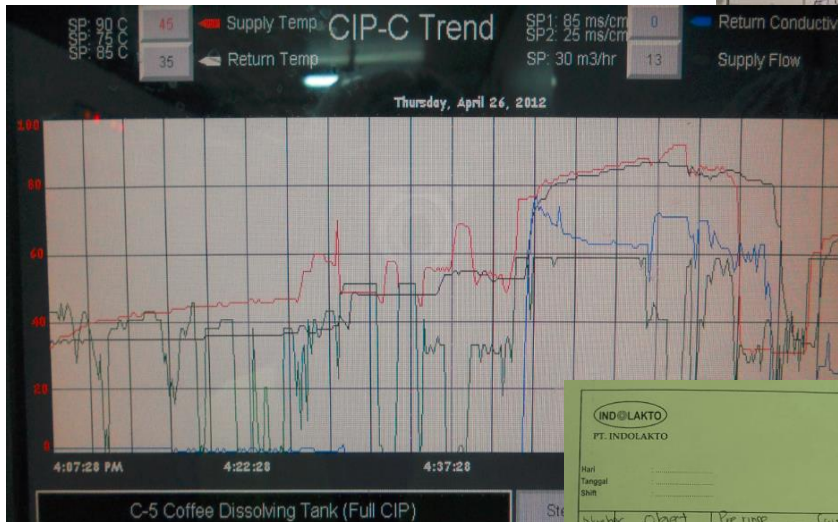
Current Condition

- ▲ Available data limited to 4Ts
- ▲ Anymore potential useful information from CIP
- ▲ What else can you benefit from this information

Current Condition

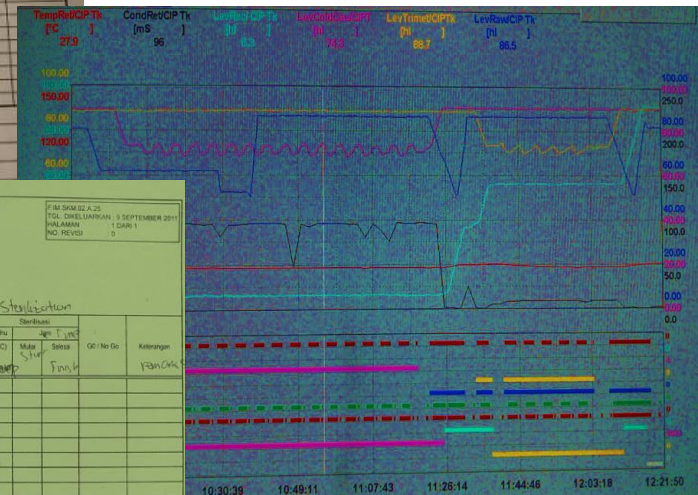
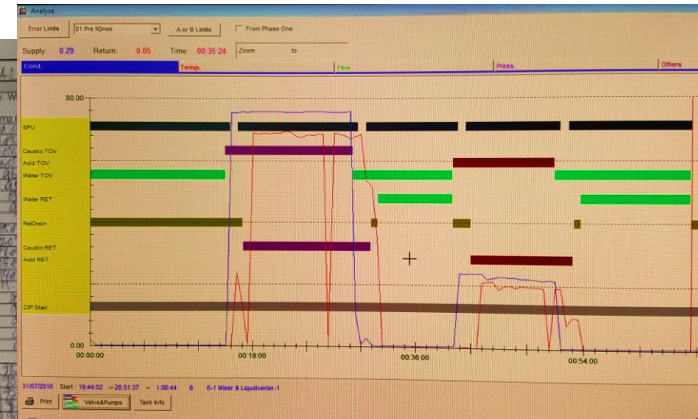
Current recording methods used:-

- Manual
- Realtime trending
- What else?



CIP DAILY RECORD

| Date | Circuit | CIP (W/O Acid) | Mode | Group | Time | Line | Star | W |
|------------|---------|----------------|--------|-----------|-------|------|--------------|------|
| 2012/04/26 | 01 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 02 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 03 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 04 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 05 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 06 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 07 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 08 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 09 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 10 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 11 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 12 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 13 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 14 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 15 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 16 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 17 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 18 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 19 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 20 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 21 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 22 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 23 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 24 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 25 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 26 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 27 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 28 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 29 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |
| 2012/04/26 | 30 | ✓ | W/acid | STER Only | Start | End | Conductivity | Temp |



Current Condition

▲ Can you get an answer for

- How many wash in last 24 hrs?
- How many of them is a good wash?
- Are they running at optimum condition?

▲ What is the opportunity with these records

- Anyone is assessing and analyze
- Beside fulfilling compliance requirement, what can I do with this data?
- Challenge in manual recording
 - Reliability of manually recorded data
 - Traceability for entire CIP process
 - Is it handy for troubleshooting
- Trending
 - How/ who interpret this chart



CAN I HAVE.....

The risks of occasional verification

Hundreds of CIP washes take place each month

Each wash is a **complex combination of temperature, time, flow, and concentration** across multiple phases (pre-rinse, alkaline, acid, sanitizer)

Any number of things can go wrong:

- Under-usage = **quality** issues
- Over-usage = **productivity, cost, sustainability** issues
- Equipment malfunctions > not always visible

Yet, today only a fraction of washes are checked

Deliverables and Examples: Visibility

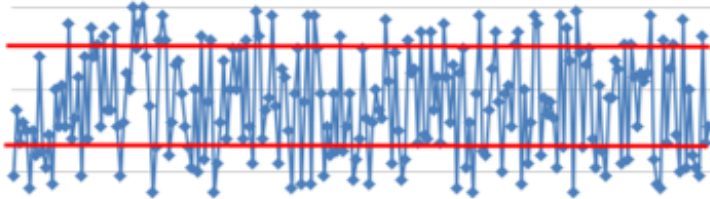
The risk of occasional verification*

PAA Conc



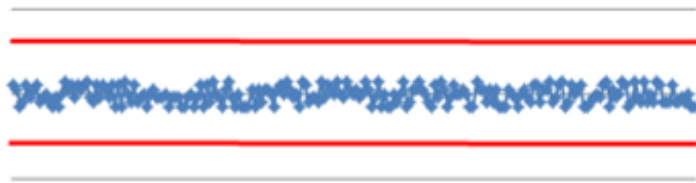
If we measure occasionally, the data may look “good enough” . . .

PAA Conc



. . . but we could be missing the overages and shortages. . .

PAA Conc



If we could “see” everything, we could keep all washes within spec.

*Actual customer sanitizer data

Deliverables and Examples: Visibility

| Start Date/Time | Duration | CIP System | CIP Line | Object | Recipe |
|---------------------|----------|---------------|--------------|---------------------------------------|--------|
| | | 1 | C1A | | |
| 24/05/2019 09:47:06 | 00:04:53 | CIP Station 1 | C1A (4 tank) | C1A_04 Rework pipeline SCM | 0 |
| 24/05/2019 09:11:35 | 00:33:15 | CIP Station 1 | C1A (4 tank) | C1A_04 Rework pipeline SCM | 1 |
| 24/05/2019 09:01:41 | 00:01:36 | CIP Station 1 | C1A (4 tank) | C1A_03 Mixing pipeline SCM | 0 |
| 24/05/2019 08:24:09 | 00:32:56 | CIP Station 1 | C1A (4 tank) | C1A_03 Mixing pipeline SCM | 1 |
| 24/05/2019 08:10:38 | 00:03:58 | CIP Station 1 | C1A (4 tank) | C1A_01_Milk solid dissolving line SCM | 0 |
| 24/05/2019 07:32:56 | 00:33:18 | CIP Station 1 | C1A (4 tank) | C1A_01_Milk solid dissolving line SCM | 1 |
| 24/05/2019 06:55:29 | 00:36:33 | CIP Station 1 | C1A (4 tank) | C1A_01_Milk solid dissolving line SCM | 1 |
| 24/05/2019 03:18:03 | 02:12:28 | CIP Station 1 | C1A (4 tank) | C1A_08 LN-transfer STD to TA Flex UHT | 1 |
| | | | | C1A_09 Transfer | |

| | | | | | |
|---------------------|----------|---------------|--------------|---------------------------------------|---|
| 20/05/2019 22:00:13 | 00:06:02 | CIP Station 1 | C1A (4 tank) | C1A_08 LN-transfer STD to TA Flex UHT | 0 |
| 20/05/2019 17:15:30 | 00:06:02 | CIP Station 1 | C1A (4 tank) | C1A_08 LN-transfer STD to TA Flex UHT | 0 |
| 20/05/2019 09:00:50 | 00:37:44 | CIP Station 1 | C1A (4 tank) | C1A_08 LN-transfer STD to TA Flex UHT | 1 |

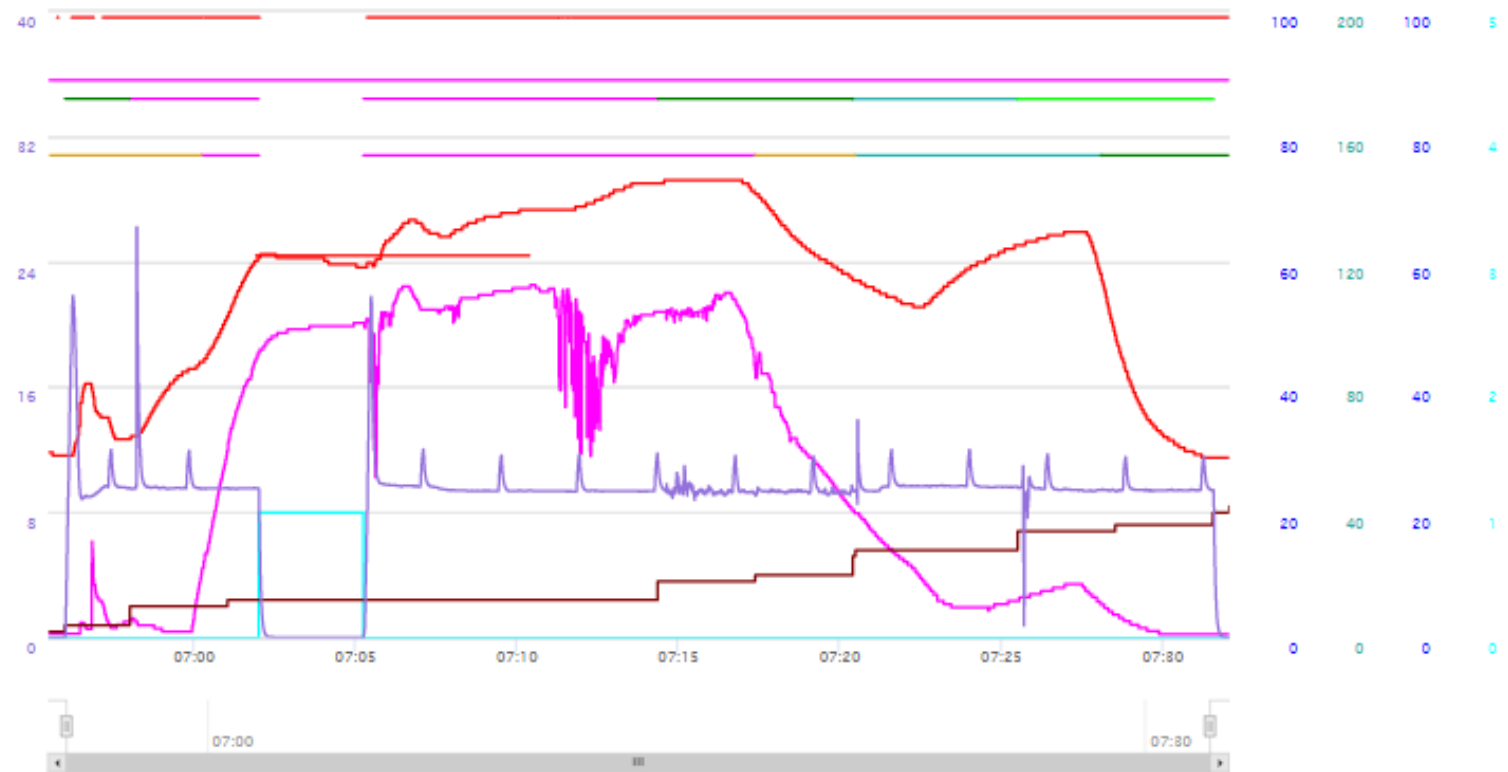
Will it be good, at least, someone reporting this repeated CIP? Best if telling why and provide solutions.

Deliverables and Examples: Optimization

| | | | |
|-----------------|---------------------------------------|-------------------|---------------------|
| CIP System Name | CIP Station 1 | Start Date & Time | 24/05/2019 06:55:29 |
| CIP Line Name | C1A (4 tank) | End Date & Time | 24/05/2019 07:32:03 |
| Object Name | C1A_D1_Milk solid dissolving line SCM | Wash duration | 00:36:33 |
| Recipe | 1 | Wash Descriptor | |

Hide Header

Show Phases

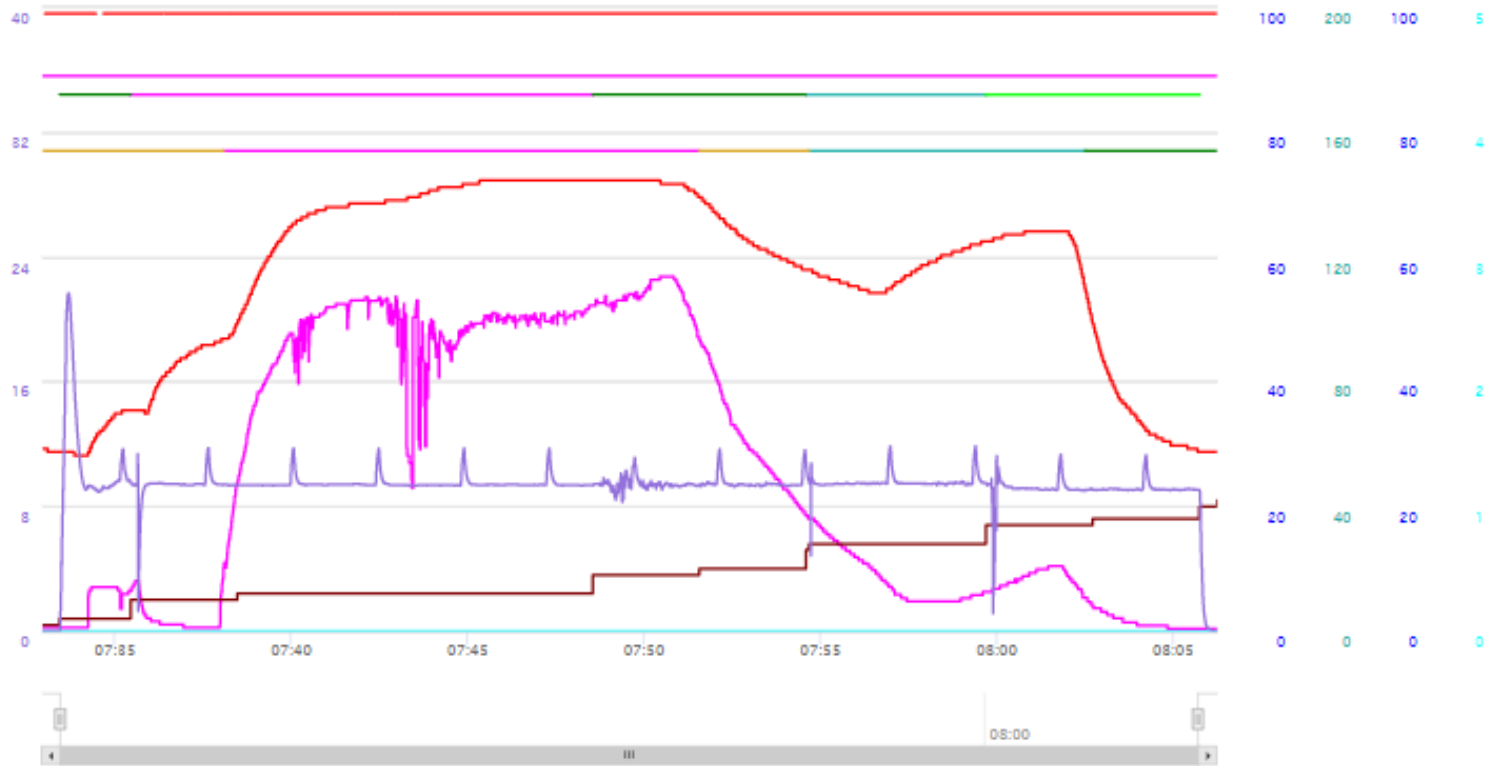


Deliverables and Examples: Optimization

| | | | |
|-----------------|---------------------------------------|-------------------|---------------------|
| CIP System Name | CIP Station 1 | Start Date & Time | 24/05/2019 07:32:56 |
| CIP Line Name | C1A (4 tank) | End Date & Time | 24/05/2019 08:06:15 |
| Object Name | C1A_01_Milk solid dissolving line SCM | Wash duration | 00:33:18 |
| Recipe | 1 | Wash Descriptor | |

Hide Header

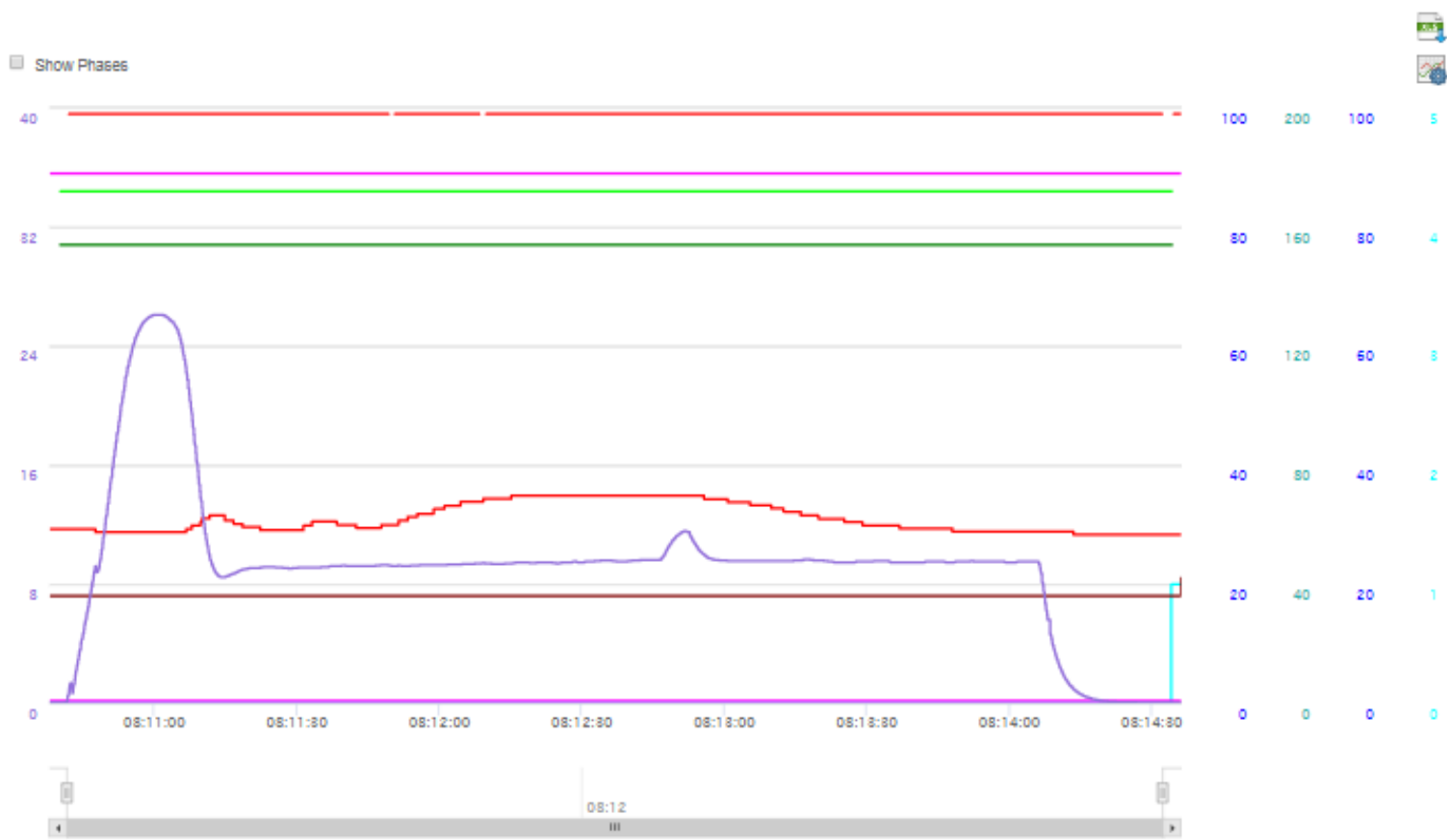
Show Phases



Deliverables and Examples: Optimization

| | | | |
|-----------------|---------------------------------------|-------------------|---------------------|
| CIP System Name | CIP Station 1 | Start Date & Time | 24/05/2019 08:10:38 |
| CIP Line Name | C1A (4 tank) | End Date & Time | 24/05/2019 08:14:36 |
| Object Name | C1A_01_Milk solid dissolving line SCM | Wash duration | 00:03:58 |
| Recipe | 0 | Wash Descriptor | |

Hide Header

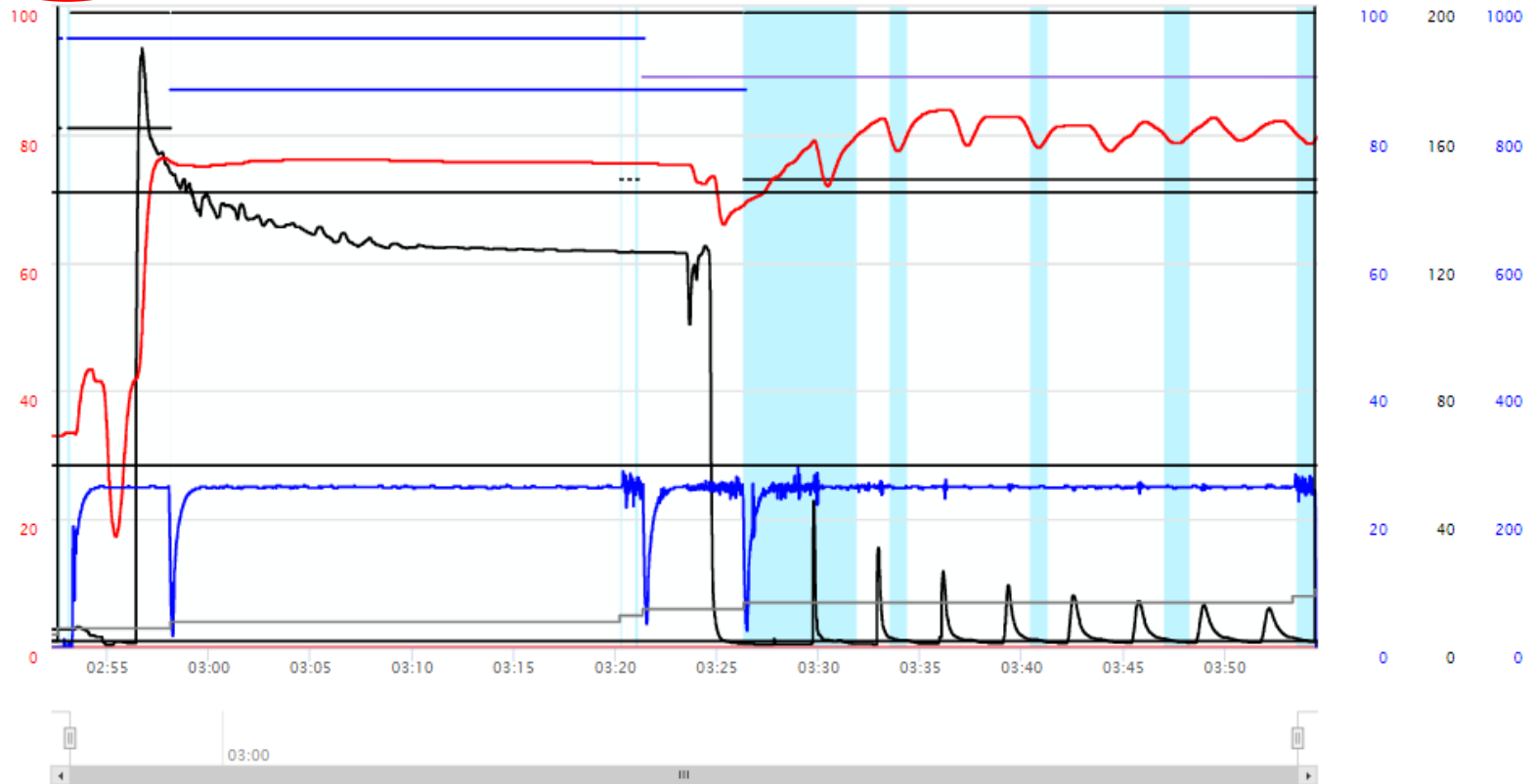


Deliverables and Examples: Visibility

| | | | |
|-----------------|-----------------------|-------------------|---------------------|
| CIP System Name | CIP 03 | Start Date & Time | 31/05/2019 02:52:15 |
| CIP Line Name | Loop 2 CIP 03 | End Date & Time | 31/05/2019 03:54:32 |
| Object Name | Pitching Main 1 short | Wash duration | 01:02:16 |
| Recipe | 432 | Wash Descriptor | |

Hide Header

Show Phases



Deliverables and Examples: Visibility

| Phases Summary | | | | | | |
|---|---------------------|----------------|----------------------------|--------------------|--------|-----|
| Phase Name | Phase Start Time | Phase duration | Phase Detail - Consumption | | | |
| | | | Material Category | Material/Fact Name | Amount | UOM |
| Caustic forward | 31/05/2019 02:52:32 | 00:00:12 | Thermal Energy | Therm Energy | 0.00 | kWh |
| Drain return | 31/05/2019 02:52:34 | 00:00:07 | | | | |
| Caustic forward | 31/05/2019 02:53:03 | 00:28:22 | Thermal Energy | Therm Energy | 95.96 | kWh |
| Drain return | 31/05/2019 02:53:04 | 00:05:02 | | | | |
| Electrical consumption | 31/05/2019 02:53:12 | 01:01:20 | Electrical Energy | CIP03PMP20 | 15.22 | kWh |
| Caustic return | 31/05/2019 02:58:06 | 00:28:18 | | | | |
| Caustic circulation | 31/05/2019 02:58:06 | 00:23:19 | | | | |
| Circulation return | 31/05/2019 03:20:15 | 00:00:06 | | | | |
| Circulation return | 31/05/2019 03:20:38 | 00:00:06 | | | | |
| Circulation return | 31/05/2019 03:21:01 | 00:00:06 | | | | |
| Hot water forward | 31/05/2019 03:21:20 | 00:04:59 | Water | Hot water in | 19.45 | hL |
| | | | Thermal Energy | Therm Energy | 4.08 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:26:19 | 00:05:34 | Thermal Energy | Therm Energy | 17.54 | kWh |
| Hot water forward with circulation at temperature | 31/05/2019 03:31:53 | 00:22:35 | Thermal Energy | Therm Energy | 28.84 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:33:31 | 00:00:51 | Thermal Energy | Therm Energy | 1.52 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:36:59 | 00:00:41 | Thermal Energy | Therm Energy | 0.97 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:40:25 | 00:00:54 | Thermal Energy | Therm Energy | 0.93 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:43:41 | 00:01:44 | Thermal Energy | Therm Energy | 2.61 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:47:01 | 00:01:14 | Thermal Energy | Therm Energy | 1.64 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:50:18 | 00:01:06 | Thermal Energy | Therm Energy | 1.09 | kWh |
| Hot water forward with circulation heat up | 31/05/2019 03:53:33 | 00:00:56 | Thermal Energy | Therm Energy | 0.69 | kWh |

| Wash Consumption & Cost Summary | | | | | |
|---|--------------------|--------------------------|-----|---------------------|------------------|
| Material Category | Material/Fact Name | Total consumption amount | UOM | Cost per unit (GBP) | Total Cost (GBP) |
| Water | Hot water in | 19.45 | hL | £ 0.10 | £ 1.94 |
| Thermal Energy | Therm Energy | 153.67 | kWh | £ 0.02 | £ 3.39 |
| Electrical Energy | CIP03PMP20 | 15.22 | kWh | £ 0.08 | £ 1.14 |
| Material Cost of Wash Occurrence £ 6.47 | | | | | |
| Time Category | Material/Fact Name | Total consumption amount | UOM | Cost per unit (GBP) | Total Cost (GBP) |

Deliverables and Examples: Visibility

Tank Level Monitoring

Start Date & Time: 01/07/2015 - 00:00:00

End Date & Time: 14/08/2015 - 00:00:00

Hide Header



15,000

12,000

9,000

6,000

3,000

0



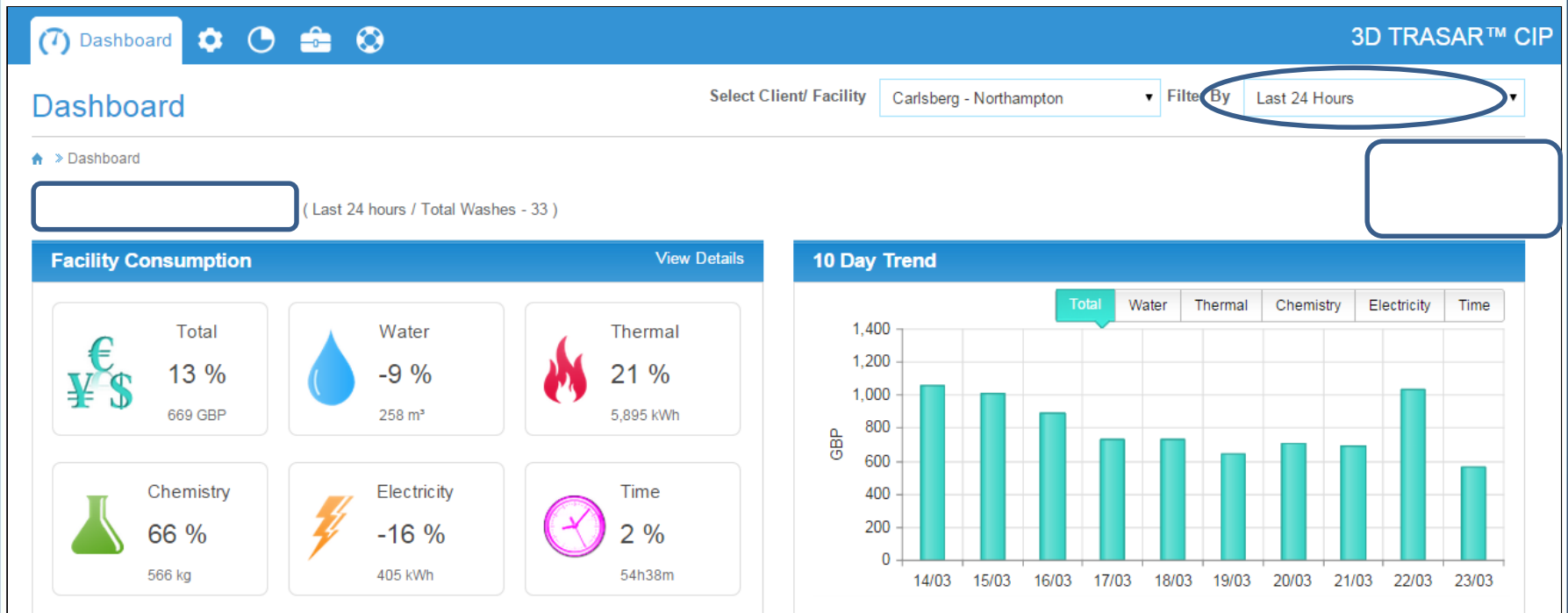
Exceptions

| Exception ID | Exception Date & Time | Exception Name | Description | Notes | Message Sent |
|--------------|-----------------------|----------------------|---|---|--------------|
| 32 | 11/08/2015 - 14:05:27 | Caustic Tank emptied | Caustic Tank solution was drained to empty! | Caustic Tank solution was drained to empty! | |
| 32 | 08/08/2015 - 08:22:04 | Caustic Tank emptied | Caustic Tank solution was drained to empty! | Caustic Tank solution was drained to empty! | |
| 32 | 31/07/2015 - 18:43:21 | Caustic Tank emptied | Caustic Tank solution was drained to empty! | Caustic Tank solution was drained to empty! | |
| 32 | 07/07/2015 - 23:57:12 | Caustic Tank emptied | Caustic Tank solution was drained to empty! | Caustic Tank solution was drained to empty! | |

Deliverables and Examples: TCO

• TCO Savings Opportunities

- The 3DT CIP dashboard enables you to see consumption rates comparing them to
 - Last 28 days compared to the previous 28 days
 - Last 7 days compared to the previous 7 days
 - Last 24 hours compared to the previous 24 hours



Deliverables and Examples: TCO

- **TCO Savings Opportunities**

- We can see from the summary below which cleans have been the most expensive



Top Consuming Washes in the Facility (GBP)

| Water | Thermal | Chemistry | Electricity | Total Wash |
|---|---|--|--|--|
| <p>1 Beer Treat + Cent 3 Short CIP 05/03/2015 - 02:15:54 £ 63.99</p> | <p>1 Beer Treat + Cent 3 Short CIP 26/02/2015 - 23:19:46 £ 87.17</p> | <p>1 Makeup caustic CIP 2 L1 14/03/2015 - 08:11:06 £ 200.65</p> | <p>1 UT 107 full 01/03/2015 - 18:16:49 £ 4.76</p> | <p>1 Makeup caustic CIP 2 L1 14/03/2015 - 08:11:06 £ 202.88</p> |
| <p>2 YSV 02 Full CIP 10/03/2015 - 00:32:50 £ 58.88</p> | <p>2 Beer Treat + Cent 3 Full CIP 02/03/2015 - 09:13:54 £ 76.59</p> | <p>2 Makeup caustic CIP 2 L1 14/03/2015 - 10:33:30 £ 154.30</p> | <p>2 Beer Treat + Cent 3 Full CIP 02/03/2015 - 09:13:54 £ 3.99</p> | <p>2 Makeup caustic CIP 2 L1 14/03/2015 - 10:33:30 £ 163.36</p> |
| <p>3 UT 112 Full CIP 14/03/2015 - 20:36:05 £ 54.75</p> | <p>3 Beer Treat + Cent 3 Short CIP 05/03/2015 - 02:15:54 £ 73.17</p> | <p>3 Makeup acid and caustic CIP2 L1 26/02/2015 - 23:27:58 £ 109.92</p> | <p>3 Beer Treat + Cent 3 Short CIP 07/03/2015 - 15:58:54 £ 3.87</p> | <p>3 Beer Treat + Cent 3 Short CIP 05/03/2015 - 02:15:54 £ 139.15</p> |
| <p>4 Beer Treat + Cent 3 Full CIP 02/03/2015 - 09:13:54 £ 50.09</p> | <p>4 Beer Treat + Cent 3 Short CIP 07/03/2015 - 15:58:54 £ 70.67</p> | <p>4 Makeup caustic CIP 2 L2 13/03/2015 - 02:19:15 £ 108.73</p> | <p>4 Cropping Main 1 Full CIP 09/03/2015 - 20:16:12 £ 3.79</p> | <p>4 Beer Treat + Cent 3 Full CIP 02/03/2015 - 09:13:54 £ 130.67</p> |

Deliverables and Examples: TCO

KPI Showing Daily Utility Usages



Trend Summary

| | | | |
|-------------------|------------|------------------------------|-----|
| Aggregation level | Day | Wash count | 602 |
| Start date | 11/03/2015 | No of exceptions | 743 |
| End date | 25/03/2015 | No of washes with exceptions | 269 |

| Material Category | Material Name | Total | | |
|-------------------|-------------------------------------|--------|-----|----------------|
| | | Amount | UOM | Cost (GBP) |
| Water | Hot water to drain | 5,661 | hL | £849 |
| | Cold water to drain | 18,498 | hL | £1,128 |
| | Prerinse water | 4,681 | hL | £843 |
| | Cold water to drain during prerinse | 4,489 | hL | £857 |
| | Hot water in | 12,711 | hL | £1,271 |
| | Cold water in | 664 | hL | £7 |
| Chemical | Horolith FL | 386 | l | £362 |
| | Caustic + additiv | 10,901 | l | £4,197 |
| Electrical | Electricity | 6,967 | kWh | £523 |
| Thermal | Therm Energy | 84,972 | kWh | £1,869 |
| Total Cost | | | | £11,906 |

| Time Category | Time Name | Total | | |
|--------------------|-----------|--------|-------|------------|
| | | Amount | UOM | Cost (GBP) |
| Aggregate Duration | Timer | 921:32 | HH:MM | £0 |
| Total Cost | | | | £0 |

The above report is emailed daily to Key Personnel, a weekly report can also be generated. Daily consumption figures for CIP 2 & 3 are in the region of £12 k to £13 k

Deliverables and Examples: TCO

• TCO Savings Opportunities

- We can then see from the summary below of last 20 cleans performed which cleans have created exceptions

| Most Recent 20 Washes | | | | | | | View Details |
|-----------------------------|---------------------|------------|---------------|---|--------|---------------------------|----------------------|
| Start Date/ Time (HH:MM:SS) | Duration (HH:MM:SS) | CIP System | CIP Line | Object | Recipe | Total Material Cost (GBP) | Exceptions Triggered |
| 24/03/2015 - 10:37:31 | 00:28:03 | CIP 03 | Loop 3 CIP 03 | Makeup Acid CIP 3 L3 | 0 | £ 34.51 | |
| 24/03/2015 - 10:36:57 | 00:26:15 | CIP 03 | Loop 1 CIP 03 | Makeup caustic CIP 3 L1 | 0 | £ 32.63 | |
| 24/03/2015 - 10:28:43 | 02:13:11 | CIP 02 | Loop 3 CIP 02 | TT 86 Full CIP | 0 | £ 0.00 | ✔ |
| 24/03/2015 - 10:25:28 | 00:02:08 | CIP 02 | Loop 3 CIP 02 | TT 86-94 Drain | 0 | £ 0.00 | |
| 24/03/2015 - 10:01:54 | 00:17:31 | CIP 02 | Loop 1 CIP 02 | Makeup caustic CIP 2 L1 | 0 | £ 29.00 | |
| 24/03/2015 - 09:06:46 | 01:58:12 | CIP 03 | Loop 2 CIP 03 | Cropping Main 1 short | 439 | £ 35.11 | ✔ |
| 24/03/2015 - 07:55:27 | 00:53:51 | CIP 02 | Loop 1 CIP 02 | UT 114 Full CIP | 0 | £ 0.00 | ✔ |
| 24/03/2015 - 07:41:05 | 00:17:34 | CIP 03 | Loop 3 CIP 03 | Makeup Caustic CIP 3 L3 | 0 | £ 17.61 | |
| 24/03/2015 - 06:41:12 | 00:39:12 | CIP 03 | Loop 2 CIP 03 | Pitching Main 1 sterilize | 434 | £ 4.96 | ✔ |
| 24/03/2015 - 06:39:24 | 00:00:24 | CIP 03 | Loop 2 CIP 03 | Pitching Main 2 sterilize | 435 | £ 0.00 | ✔ |
| 24/03/2015 - 04:30:08 | 03:18:28 | CIP 03 | Loop 1 CIP 03 | Filter Line 2 and Centrifuge 2 Full CIP | 427 | £ 61.10 | ✔ |
| 24/03/2015 - 04:29:45 | 01:50:57 | CIP 03 | Loop 2 CIP 03 | Cent Cropping 2 Full CIP | 264 | £ 14.30 | ✔ |
| 24/03/2015 - 03:47:13 | 00:40:00 | CIP 03 | Loop 2 CIP 03 | Pitching Main 1 sterilize | 434 | £ 6.41 | ✔ |
| 24/03/2015 - 03:24:53 | 00:12:23 | CIP 03 | Loop 3 CIP 03 | Makeup Caustic CIP 3 L3 | 0 | £ 5.05 | |
| 24/03/2015 - 02:59:42 | 00:08:44 | CIP 02 | Loop 2 CIP 02 | Makeup Acid CIP 2 L2 | 0 | £ 3.89 | |
| 24/03/2015 - 02:00:13 | 01:50:23 | CIP 03 | Loop 1 CIP 03 | Transfer Line 2 Full CIP | 423 | £ 30.77 | ✔ |
| 24/03/2015 - 01:32:12 | 07:37:27 | CIP 02 | Loop 3 CIP 02 | UT 95 full | 0 | £ 39.46 | ✔ |
| 24/03/2015 - 00:28:12 | 02:30:00 | CIP 02 | Loop 2 CIP 02 | Acid Descale Wortcooler | 0 | £ 14.08 | |
| 24/03/2015 - 00:16:34 | 01:10:08 | CIP 03 | Loop 3 CIP 03 | Prop Line Full CIP | 0 | £ 3.78 | ✔ |
| 23/03/2015 - 23:46:36 | 00:18:39 | CIP 03 | Loop 1 CIP 03 | Makeup caustic CIP 3 L1 | 0 | £ 20.00 | |



PRODUCT QUALITY



ENERGY



PROFITABILITY



WATER

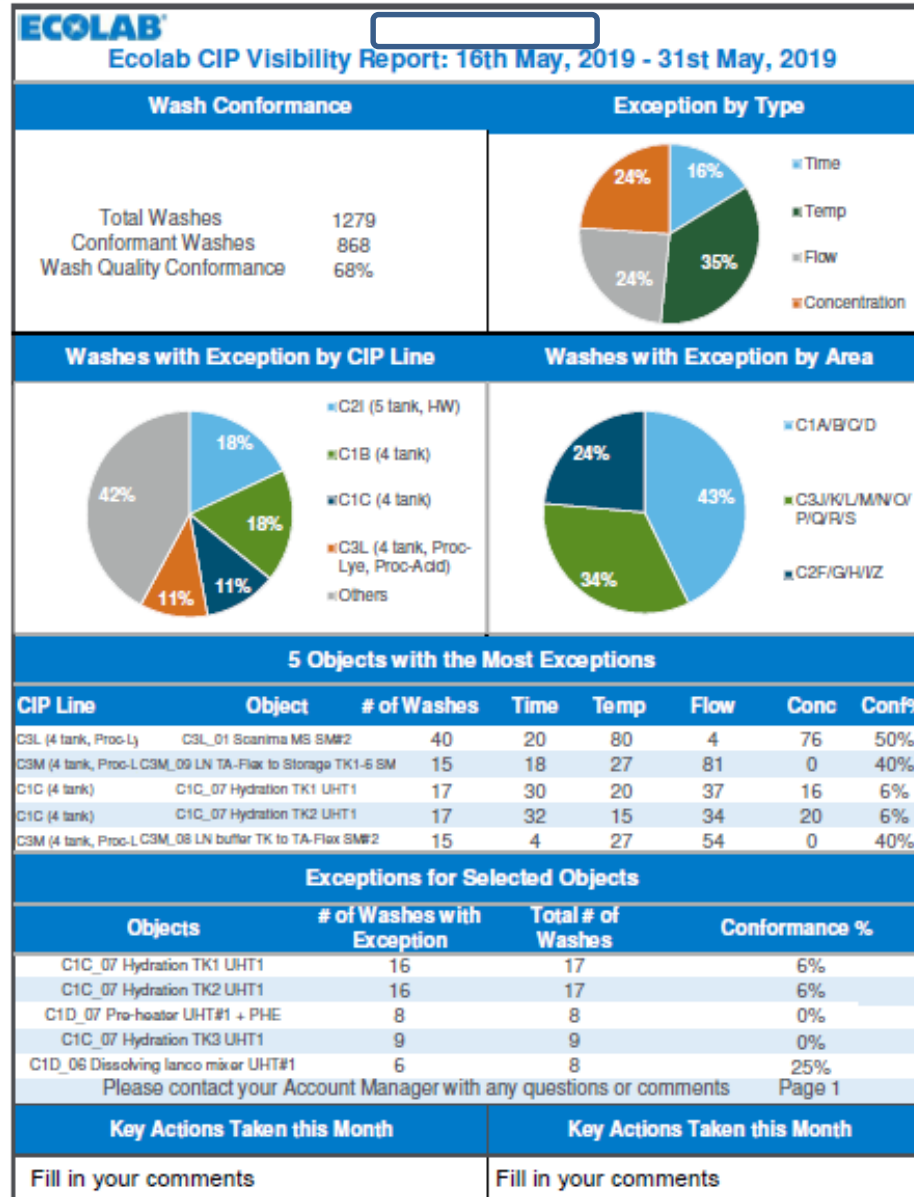


ASSETS

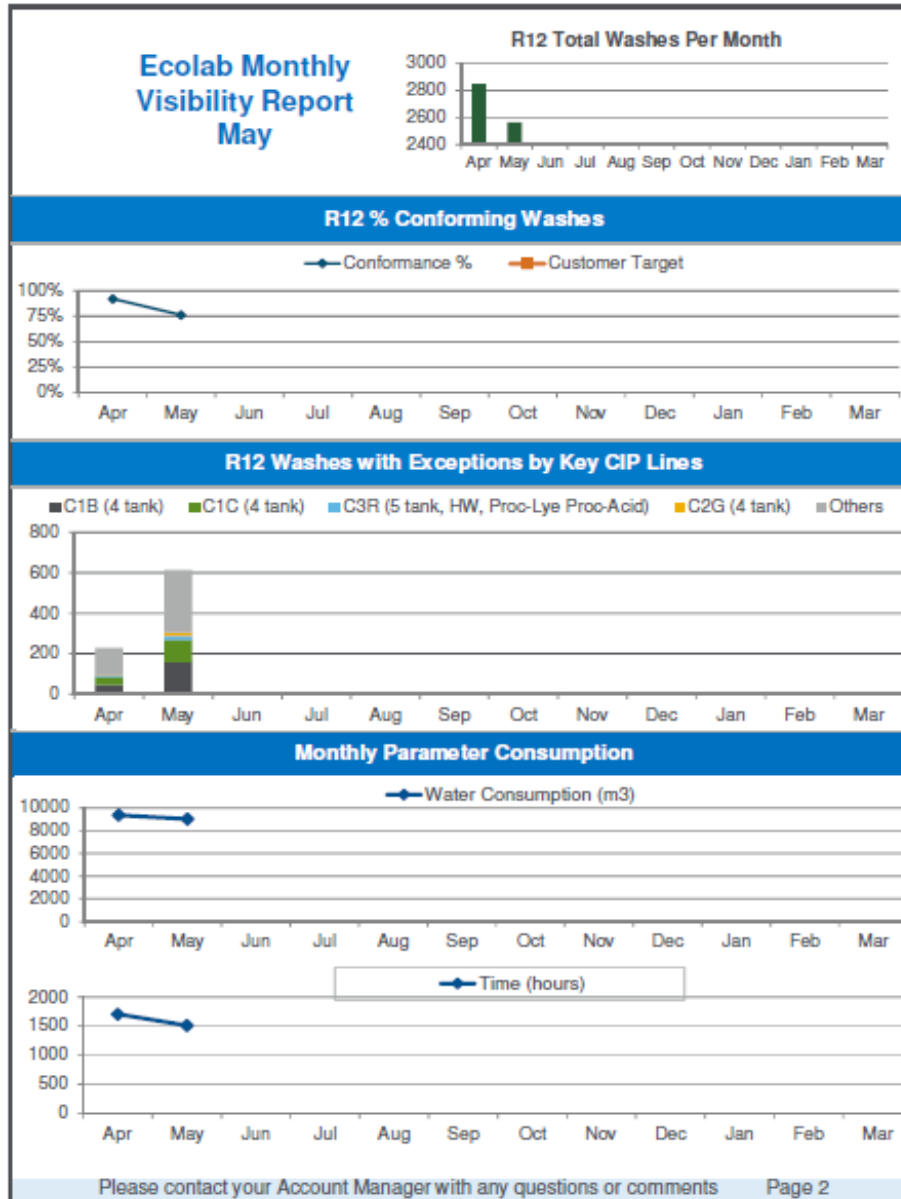


PRODUCTIVITY

Deliverables and Examples: Visibility report

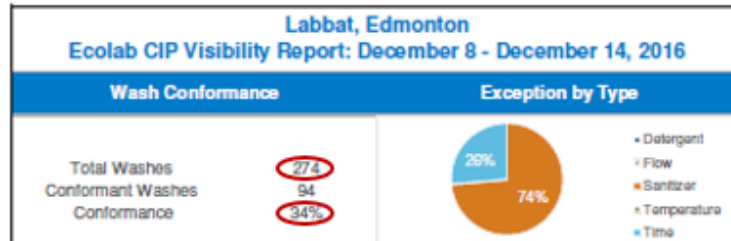


Deliverables and Examples: visibility report

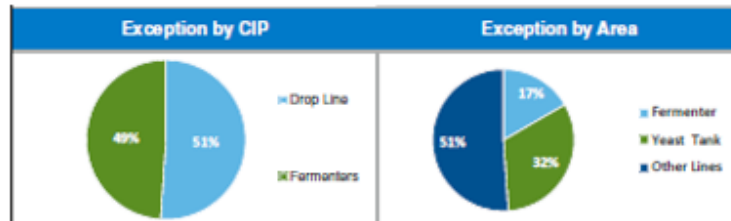


Deliverables and Examples: visibility report

Our analysis can quickly improve your product quality confidence



Answers “Did you wash” and “Did you Wash correctly”?
Shows most common exception type



Which area and CIP had the most exceptions

5 Objects with the Most Exceptions

| CIP | Object | Recipe | Time | Temp | Flow | Conc |
|------------|---------------------|--------|------|------|------|------|
| Drop Line | Injection Line | 255 | 8 | 24 | 0 | 0 |
| Fermenters | Yeast Tank #2 | 32 | 8 | 19 | 0 | 0 |
| Drop Line | Total Dropping Line | 64 | 6 | 10 | 0 | 0 |
| Fermenters | Yeast Tank #3 | 32 | 4 | 11 | 0 | 0 |
| Drop Line | Injection Line | 0 | 1 | 10 | 0 | 0 |

Which object had the most exceptions, and which type

5 Recipes with the Most Exceptions

| Recipe | # of Washes by Recipe | # of Washes with Exceptions | Conformance |
|----------------------------------|-----------------------|-----------------------------|-------------|
| 1 Step Hot Water Cleaning | 20 | 20 | 0% |
| 1 Step Cold Water Cleaning | 44 | 30 | 32% |
| 3 Step Hot Caustic/Acid Cleaning | 3 | 3 | 0% |
| 5 Step Caustic & Acid Cleaning | 57 | 25 | 56% |
| UHT 5 Step Wash- Hot | 0 | 0 | NA |

Which CIP recipe type had the most exceptions



Is the plant’s CIP conformance rate improving over time?

Deliverables and Examples: Quality

Quality

Areas for improvement

Temperature

Conductivity

Flow Rates

Pressures

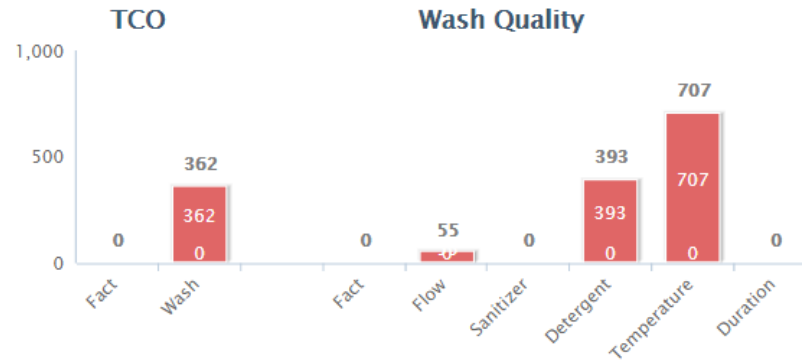
Tracked through the Exception reports



Exceptions

[View Details](#)

Without Communication With Communication



Total Washes - 1155
Total Washes with Exceptions - 548

Deliverables and Examples: Quality

Case Study : Temperature for CIP 3

3DT is showing that the temperatures across the board are on the high side for both caustic and sterilisation cycles.

Caustic Cycle Set points

The recipe shows a feed temp of 85°C with a return temp of 75°C

Sterilisation Cycle Set points

The recipe shows a feed temp of 92°C with a return temp of 79.2°C

Both caustic and sterilisation cycles exceed the stated set points.

Estimated annual saving of

transfer line mains £2.40 per clean : £346 per annum

cropping mains £2.80 per clean : £2,184 per annum

pitching mains £2.80 per clean : £660 per annum

Assuming initial heating from an ambient temperature



Deliverables and Examples: Quality

CIP System Name CIP 03

Start Date & Time 18/03/2015 - 09:31:38

CIP Line Name Loop 1 CIP 03

End Date & Time 18/03/2015 - 11:17:07

Object Name Transfer Line 1 Full CIP

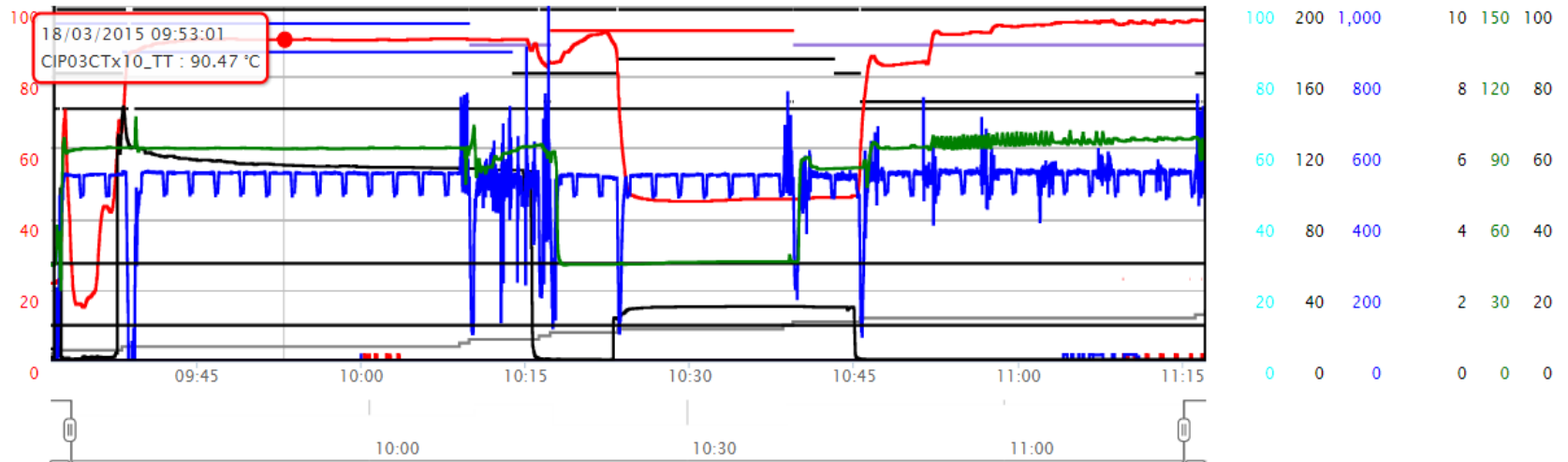
Wash Duration 01:45:29

Recipe 422

Wash Descriptor

Hide Header

Show Phases



Caustic cycle showing a return temperature of **90.7°C** should be no more than 75°C

Deliverables and Examples: Quality

CIP System Name CIP 03

Start Date & Time 18/03/2015 - 09:31:38

CIP Line Name Loop 1 CIP 03

End Date & Time 18/03/2015 - 11:17:07

Object Name Transfer Line 1 Full CIP

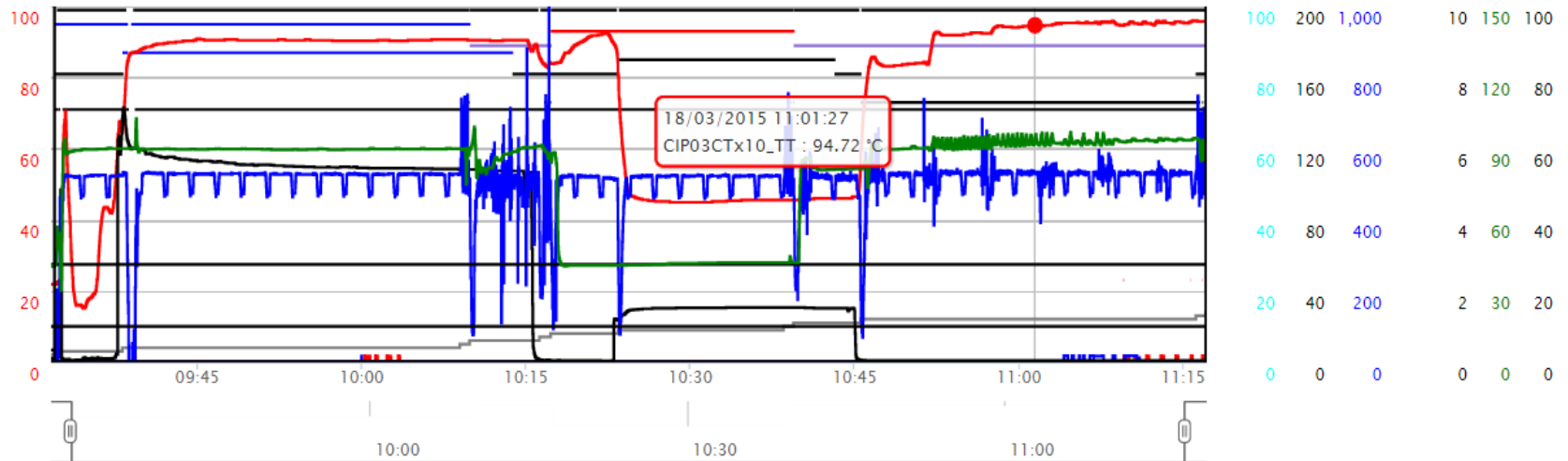
Wash Duration 01:45:29

Recipe 422

Wash Descriptor

Hide Header

Show Phases



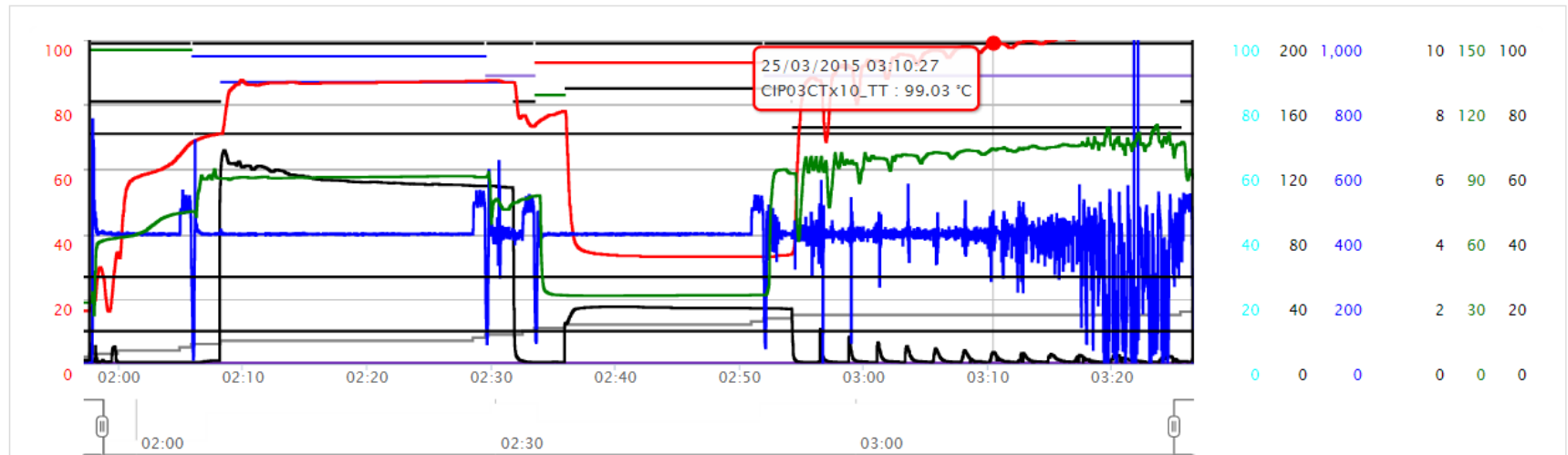
Sterilisation cycle showing a return temperature of **94.7°C** should be no more than 80°C

Deliverables and Examples: Quality

| | | | |
|-----------------|-------------------------------------|-------------------|-----------------------|
| CIP System Name | CIP 03 | Start Date & Time | 25/03/2015 - 01:57:09 |
| CIP Line Name | Loop 1 CIP 03 | End Date & Time | 25/03/2015 - 03:26:35 |
| Object Name | Yeast collection line 1 Full CIP | Wash Duration | 01:29:26 |
| Recipe | 418 | Wash Descriptor | |

Hide Header

Show Phases



Another example of high return temperatures during the sterilisation cycle. Temperature shown **99.03c** which is causing the **flow to fluctuate** due to steam being pushed into the feed line

Deliverables and Examples: Quality

Case Study: Conductivity CIP 2

All the cleans associated with CIP 2 are mainly Fermentation vessels with the exception of the Wort Cooler so there is the potential for high levels of CO₂ being left in the vessel resulting in **carbonation of the caustic** which makes the caustic solution ineffective for cleaning



To try and combat this the CIP set is run at a conductivity of 175mS (3.3% w/w) even with such a high conductivity reading the carbonate level can drop down to below the required minimum level of 85mS.

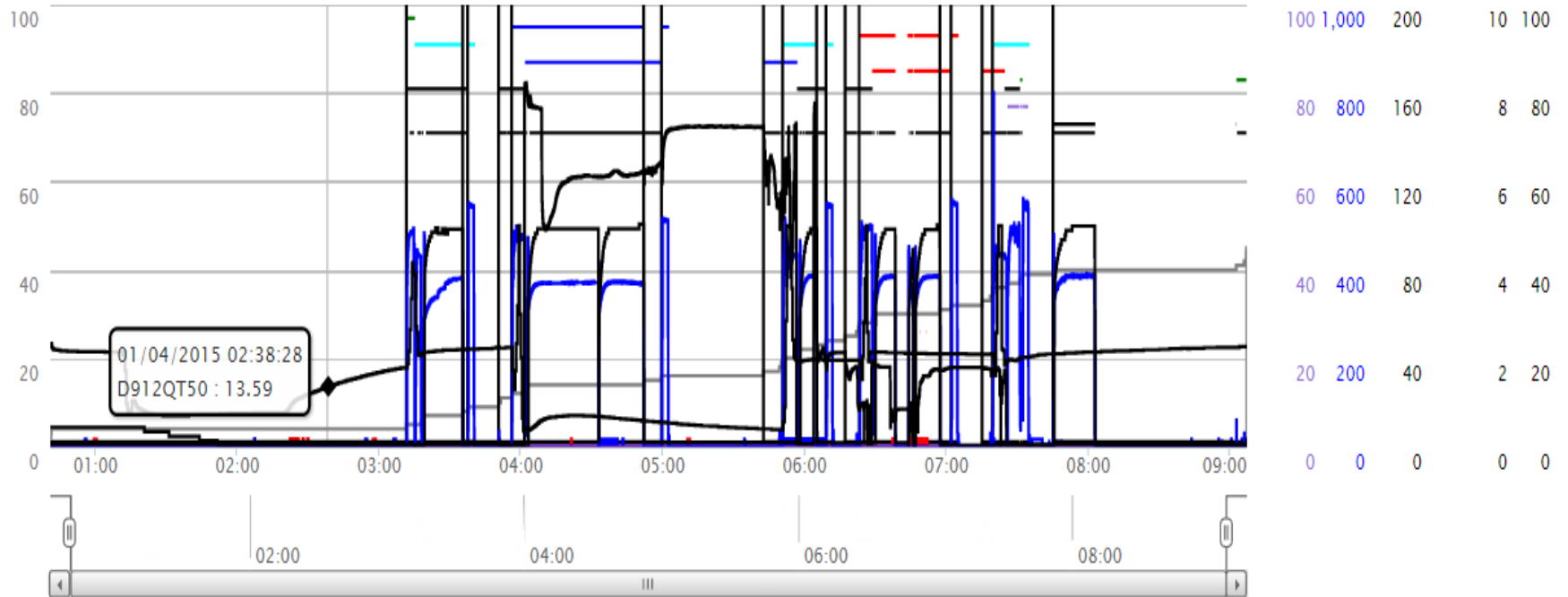
By **evacuating all the CO₂** from the vessels this would result in the vessels being cleaned with a **lower conductivity** thus reducing caustic usage per clean and the CIP set would not need to be dumped so frequently saving money

We are using 3DT to **monitor oxygen** meter readings and pressure reading (pressure on the spray device inside the tank)

We are using 3DT to track and create exception reports on the high and low caustic values.

Tracking of Oxygen in the tanks

Show Phases

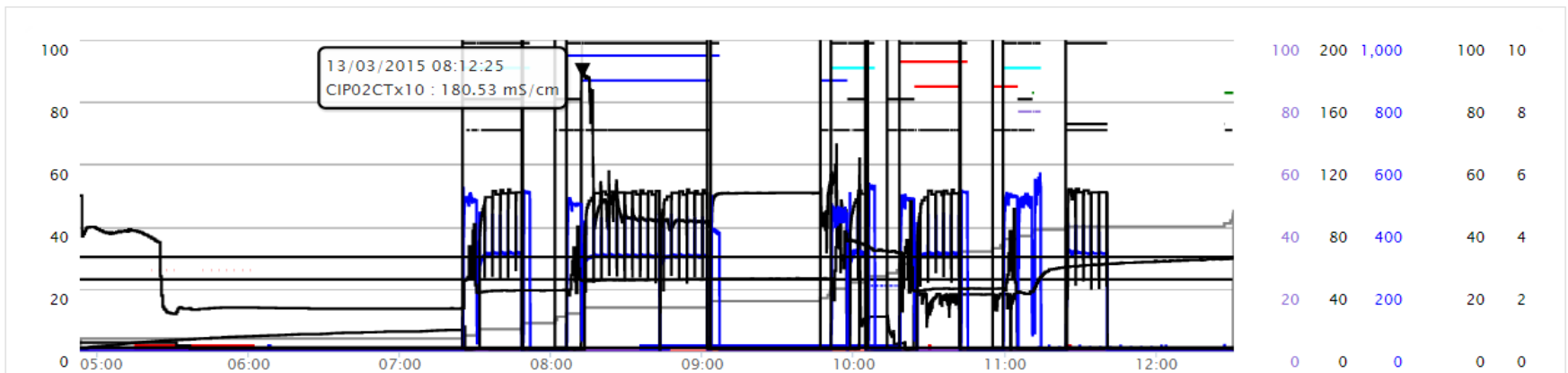


Deliverables and Examples: Quality

| | | | |
|-----------------|-----------------|-------------------|-----------------------|
| CIP System Name | CIP 02 | Start Date & Time | 13/03/2015 - 04:52:59 |
| CIP Line Name | Loop 1 CIP 02 | End Date & Time | 13/03/2015 - 12:30:43 |
| Object Name | UT 117 Full CIP | Wash Duration | 07:37:44 |
| Recipe | 0 | Wash Descriptor | |

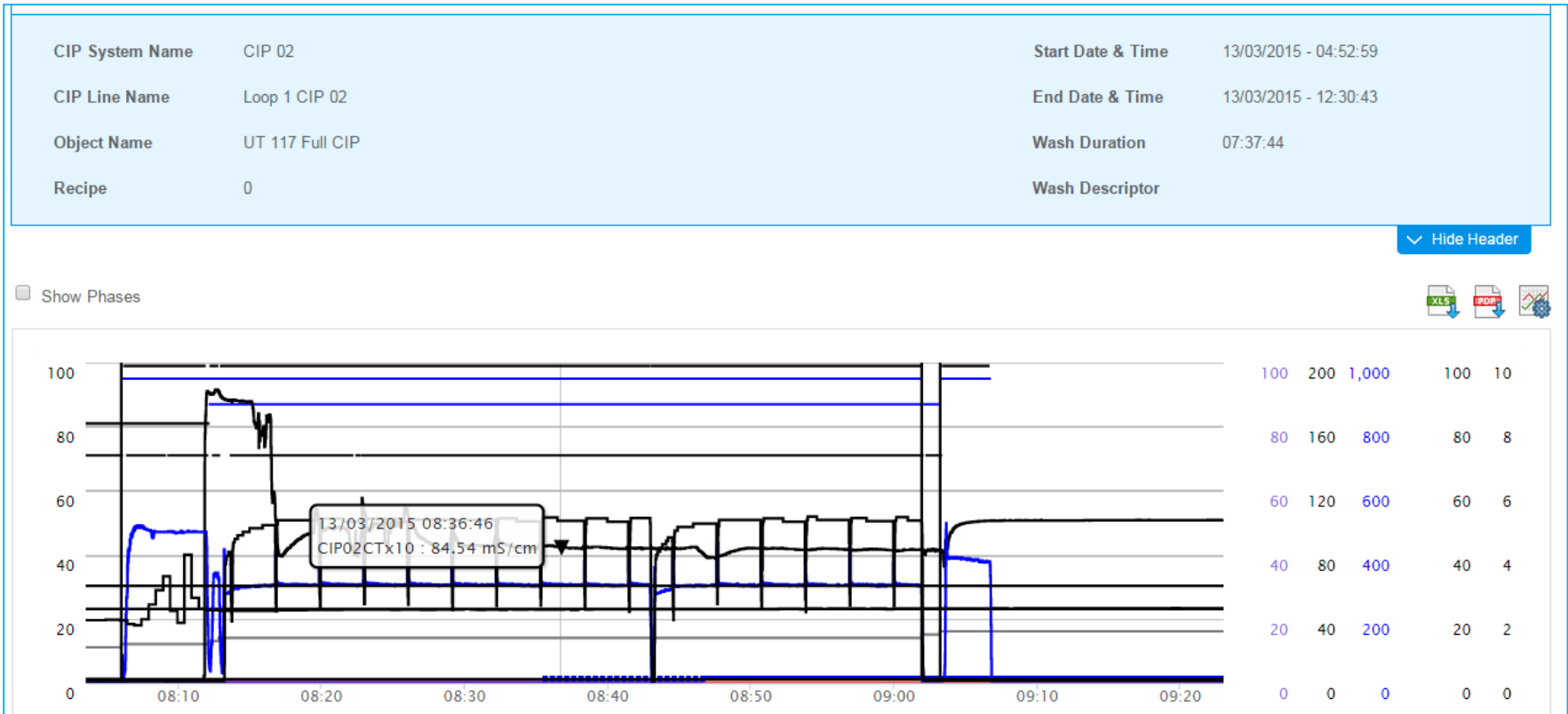
Hide Header

Show Phases



Conductivity level at the start of the caustic cycle showing a reading of 180.51mS/cm

Deliverables and Examples: Quality



An enlarged view of the caustic cycle showing the conductivity dropping down to below 85mS/cm

Deliverables and Examples: Quality

• Case study: Conductivity CIP 2

- Due to the high carbonate levels associated with CIP 2 it is necessary to drop the CIP set regularly on average after 5 cleans
- During the make up of CIP 2 once the return probe saw a conductivity of 175 mS the make up would stop.
- Although the return probe was seeing 175 mS this was not necessarily the conductivity in the caustic tank, as there could be some layering of the caustic solution.
- Solution : the CIP set is circulated for longer to make sure that the correct conductivity is achieved in the tank as well AND the conductivity is reduced to 150 mS (as make up is better controlled)
- We regularly see the CIP Makes Ups as the most expensive activity on a daily basis
 - The example on the left shows the same CIP set recharge costs 140 minutes apart....



| Total Wash | |
|------------|--|
| 1 | Makeup caustic CIP 2 L1 14/03/2015 - 08:11:06 £ 202.88 |
| 2 | Makeup caustic CIP 2 L1 14/03/2015 - 10:33:30 £ 163.36 |

Deliverables and Examples: Compliance

- 3DT offers the facility to monitor the performance of each CIP carried out in near real time.
- Exceptions can be set up to email key personnel of any non compliance relating to Time, Temperature, & Conductivity, which will allow site to investigate immediately any problems relating to the cleans.



No emails means there are no CIP issues and thus demonstrates 100% compliance

3DTCIP BENEFITS

CREATING VALUE BEYOND CIP

Food Safety & Quality

- ✓ Validate the CIP process
- ✓ Verify CIP performance
- ✓ Improve shelf life
- ✓ Drive food safety /quality enhancements
- ✓ Protect your brand and consumer engagement
- ✓ Compliance documentation
- ✓ Peace of mind

Operational Efficiency

- ✓ Turn information into action
- ✓ Enhance throughput/reduce loss
- ✓ Optimize the total cost of operation
- ✓ Enhance the asset useful life
- ✓ Capability to support new product introductions
- ✓ Expert support
- ✓ Preventative Maintenance

Sustainability

- ✓ Contribute to corporate sustainability goals with proof
- ✓ Lower the operational costs through water, energy and waste efforts
- ✓ Support elevating brand image

Employee Safety

- ✓ Easy to operate and minimize the risks
- ✓ Better training

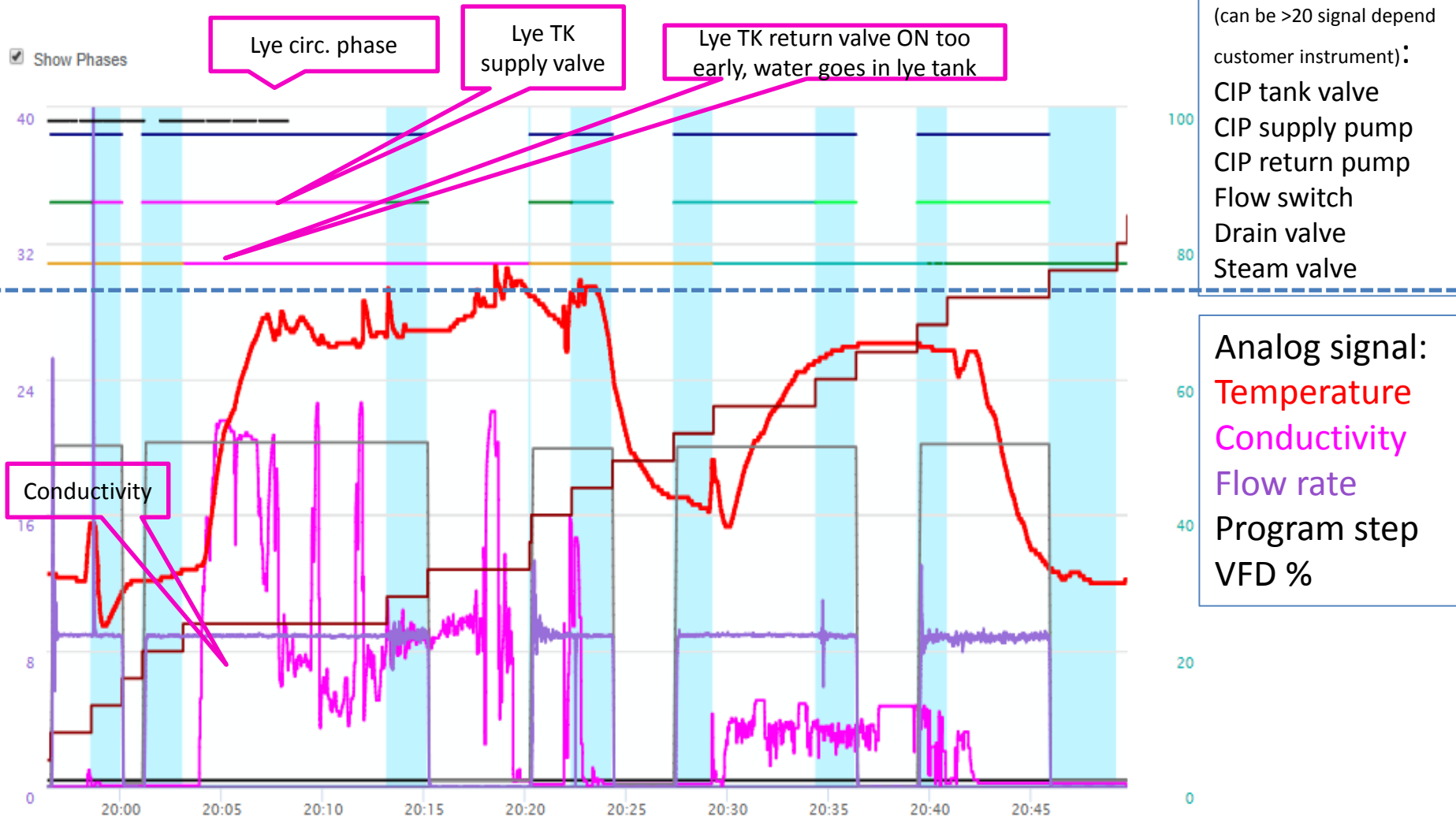


ENABLING DIGITAL SOLUTIONS

Enabler



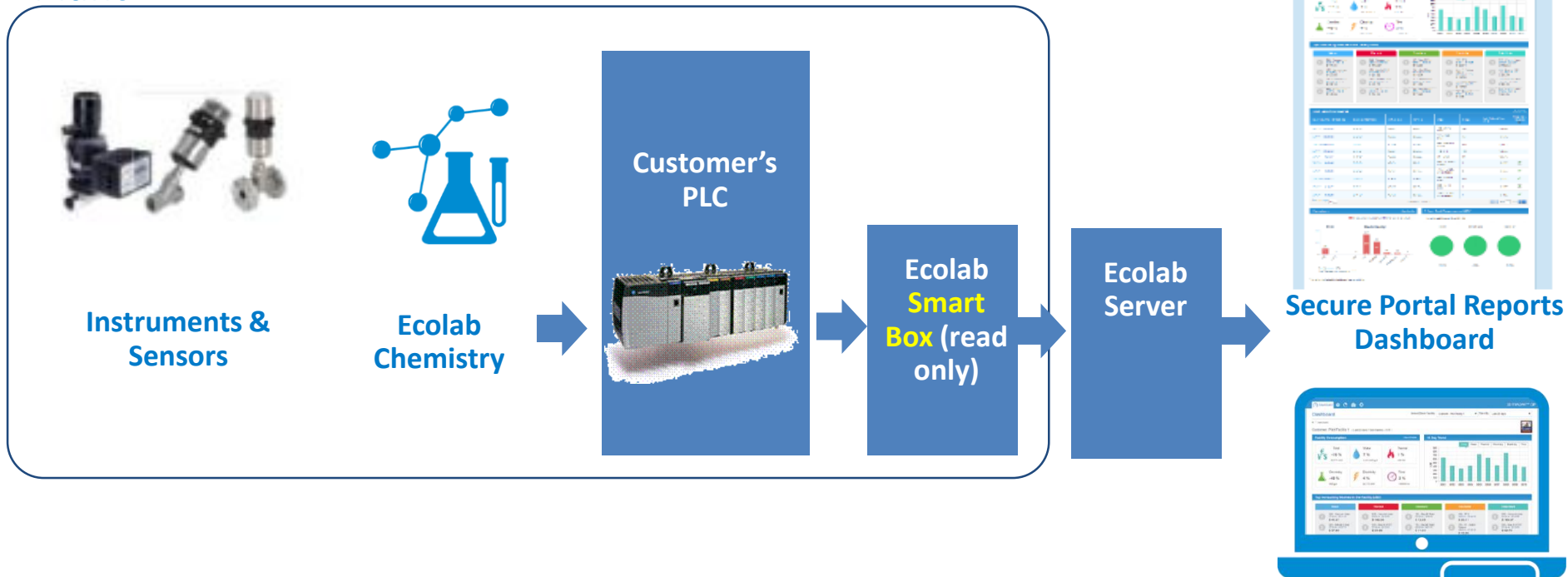
Enabler



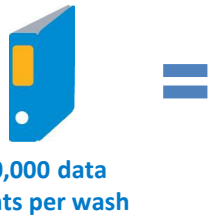
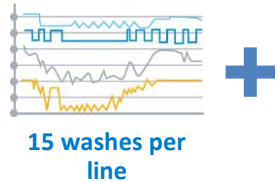
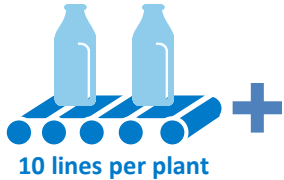
Hardware Investment :- Smart Box

reads PLC information and sends the data to a secure server where the data is translated into actionable information by our proprietary monitoring system. Customers and Ecolab personnel then have access to the dashboard.

Plant

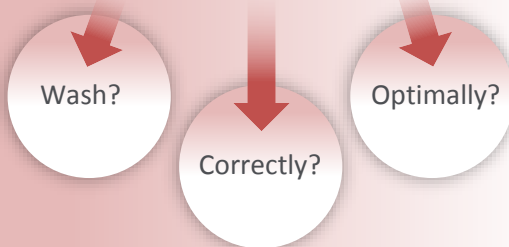
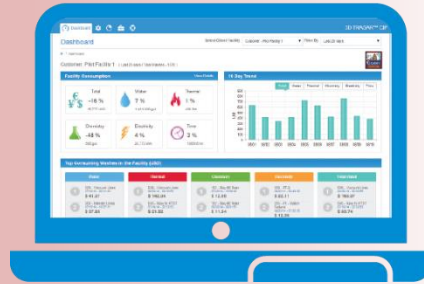


Enabler



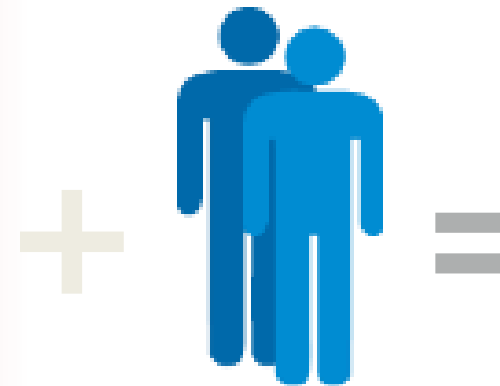
1M+ CIP data points per plant per day

Brings order to your CIP data and easily answers the 3 critical questions:



Customer's commitment

- CIP Champion
- CI Team



Results

- Quality/Consistency
- Productivity
- Safety/ TCO
- Sustainability

Ecolab's Support

- Account Manager
- CIP Analyst
- Installation Engineer
- System Assurance Center
- Next phase – in development

Digital can transform...

FROM

TO

Manual
Static
Limited Visibility
Periodic
Reactive
Variable
Individual Knowledge

Automated
Dynamic
Data Driven Optimization
Continuous
Proactive
Consistent
Dependable Outcomes

The Next Level of CIP technology

Partnership on the leading Edge

3D TRASAR™
Clean-in-Place

A new integrated service offering that combines Expert Analysis and specialized software to transform raw CIP data into savings and increased operational efficiency for your facility.

Detect by Data Transformation

24/7 CIP monitoring to transform disparate CIP data into integrated, actionable information you can use to measure plant performance

Determine through Expert Analysis

Ecolab CIP experts will uncover hidden savings and identify opportunities to improve your plants

Deliver with Recommendations for Action

Prioritized expert recommendations, diagnostic reporting, and the ongoing support of Ecolab's World Class Service

