

OVERALL EQUIPMENT EFFECTIVENESS

MACHINE NAME: Machine 2003

Date Range: 1/12/06 8:00 AM to 1/12/06 4:00 PM **Interval:** Shift

EQUIPMENT AVAILABILITY **INTERVAL PERIOD:** 1/12/06 8:00 AM to 1/12/06 4:00 PM

A. Total Available Time		<u>480</u>	min
B. Planned Downtime		<u>60</u>	min
C. Net Available time (Total Available Time - Planned)	(A - B)	<u>420</u>	min
D. Unplanned Downtime		<u>82</u>	min
E. Operating time (Net Available Time - Unplanned Downtime)	(C - D)	<u>338</u>	min
F. Equipment Availability (Operating Time/ Net Available Time)	(E / C x 100)	<u>80</u>	%

PERFORMANCE EFFICIENCY

G. Total Parts Run (Good and Bad)		<u>28,260</u>	parts
H. Ideal Production Rate (machine rating)		<u>6,000</u>	parts/hr
Actual Production Rate (calculated)	(These values are provided for information only and are not used for OEE calculation)	<u>5017</u>	parts/hr
Cycle Time		<u>0.72</u>	sec

I. Performance Efficiency (Total Parts Run / Operating Time) / Ideal Production Rate x 100)	$100 \times (G / E) / (H / 60)$	<u>84</u>	%
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QUALITY RATE

J. Total Defects (Rework + Scrap)		<u>455</u>	parts
K. Quality Rate (Total Parts Run - Total Defects) / Total Parts Run x 100)	$((G - J) / G \times 100)$	<u>98</u>	%

OEE

Overall Equipment Effectiveness (OEE) (Equipment Availability x Performance Efficiency x Quality Rate x 100)	$(F \times I \times K)$	<u>66</u>	%
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