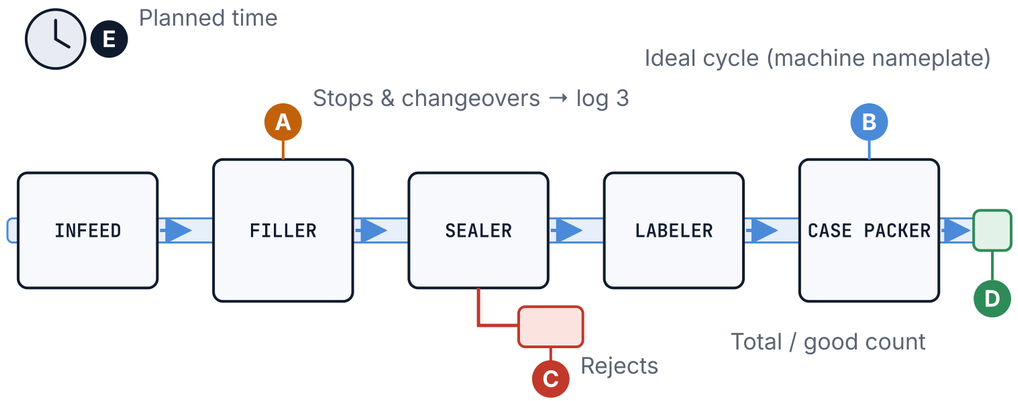
OEE WORKSHEET · CONCLUSION

EQUIPMENT	PERIOD	SHIFT	SHEET
PREPARED BY	CHECKED BY	DATE	UNIT

1 LINE PKG-01 · WHERE EACH NUMBER COMES FROM



2 CALCULATION VS. TARGET

≥ target · up to 5 pts below · more than 5 below

METRIC	FORMULA	VALUES	TARGET	RESULT
RUN TIME	Planned time − stops		—	
AVAILABILITY	Run time ÷ planned time		90%	
PERFORMANCE	(Ideal cycle × total) ÷ run time		95%	
QUALITY	Good ÷ total count		99.9%	
OEE	A × P × Q		85%	
CHECK	Good × ideal cycle ÷ planned time		—	

3 STOP LOG · POINT A · PARETO

CAUSE	MIN	%	CUM. %
Changeover			
Minor stops			
Breakdown			
Startup			
Total stops			

4 RESULT AND ACTION

OEE =

ACTION

5 OEE BY DAY

