

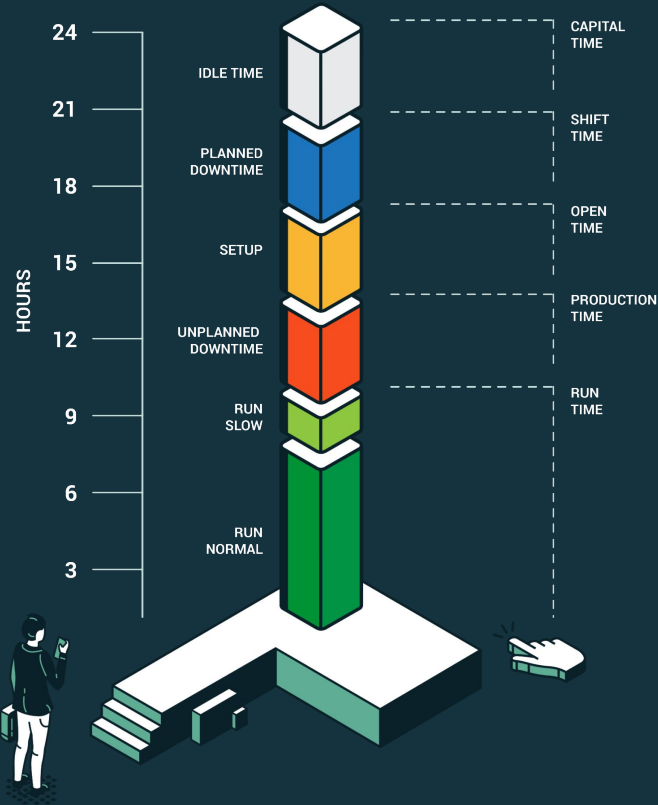


Measuring OEE in OFS

Operations Feedback Systems



OEE =
Overall Equipment
Effectiveness



$$OEE\% = Q\% \times PE\% \times AVA\%$$

Quality
(Yield)

Performance
(Speed)

Availability
(Time)

Units Out
Units In

Run Speed
Rated Speed

Run Time
Available Time

Capital
(24x7)
AVA(c)

Shift
(excludes
idle time)
AVA(s)

Open
(excludes
idle time and
planned DT)
AVA

Production
(excludes idle, planned
DT and setup)
AVA(p)

How do I use these metrics?

$AVA = OEE \text{ (Open)}$

$AVA_{\underline{c}} = OEE_{\underline{c}}$

$AVA_{\underline{s}} = OEE_{\underline{s}}$

$AVA_{\underline{p}} = OEE_{\underline{p}} \text{ (LE)} - \text{"Line Efficiency"}$

