

Overall Equipment Effectiveness

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oee overall equipment effectiveness is the gold standard for measuring manufacturing productivity simply put it identifies the percentage of manufacturing time that is truly productive

learn how to calculate oee to gain insight into the effectiveness of your manufacturing process and improve production

examples of things that create availability loss include unplanned stops such as equipment failures and material shortages and planned stops such as changeover time changeover time is included

oee overall equipment effectiveness measures the ratio of fully productive time to planned production time if your oee score is 100 then you are making only good parts

as fast as

equipment failure accounts for any significant period of time in which equipment is scheduled for production but is not running due to a failure of some sort a more generalized way to think of

the nature of this calculation makes achieving a high oee score quite challenging for example if all three factors are 90 the resultant oee will only be 73 in practice the generally accepted world

the preferred method is to use nameplate capacity the design capacity specified by the equipment builder an alternate method is to perform a time study measuring the absolute fastest speed the

understand what oee overall equipment effectiveness is how to measure it and how to use it to improve manufacturing productivity

use the teep formula to measure machine utilization and improve total effective equipment performance

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