



Most managers are already clear on areas of major loss, but the understanding of root cause and doing something about it can be a much more difficult task. The deployment of specialist tools- such as an OEE system means that exposing losses and quantifying potential wins is made considerably easier.

## OEE = AVAILABILITY x PERFORMANCE x QUALITY

**AVAILABILITY** – The time the plant was actually available for production, compared to manufacturing requirements

**PRODUCTION** – The rate that actual units are produced, compared to design output

**QUALITY** – A measure of good quality, saleable product, minus any waste

An OEE score as a percentage indicates the relative level of performance, against the optimum that could be achieved. Lost opportunity is highlighted, giving the manager a better understanding for areas of increased profitability.

An OEE system is more than creating a percentage. With a well implemented system and accurate real-time data capture, an OEE system enables the manager to assess the most urgent / profitable lines or products to pursue, effectively manage losses and improve operations. Each highlighted deficiency then becomes an opportunity for increased productivity, profitability and staff morale.

**OEE seeks to drive all elements of waste out of the manufacturing process**

## IDHAMMAR SYSTEMS OEE vs. OEE SPREADSHEET METHOD

Whether familiar, or new to the OEE metric, initial data capture will probably start, by using a spreadsheet. This works well for most customers up to a certain size. Many Idhammar customers would recommend using a spreadsheet in the initial stages of implementation to 'get used to' the metric.

However, when a certain level is reached, the spreadsheet method becomes severely limited by the complexity of data handling, manual reporting and the inability to perform root cause analysis.

### IDHAMMAR SYSTEMS OEE

- Data can be manually/automatically captured
- Flexible, user defined reports can be generated automatically
- Drill down the detail behind data to identify cause
- Every second of production can be accounted for and analysed
- Automatic data capture delivers accurate real-time management information
- Multi User access
- Built in features prevent unauthorised access, data repository is secure and backed-up

### OEE SPREADSHEET METHOD

- Data handling/reporting typically takes 20hrs pcm, per production line
- No simple way of analysing detail behind data
- Spreadsheet transcript errors can easily happen
- Difficult to record minor stoppages: <1minute
- Estimated, rather than calculated wastage figures
- Timelines and level of detail is dependent on manual process
- Spreadsheets – single "read only" user access
- Data security & potential data loss; copy/paste or delete activity threatens data integrity