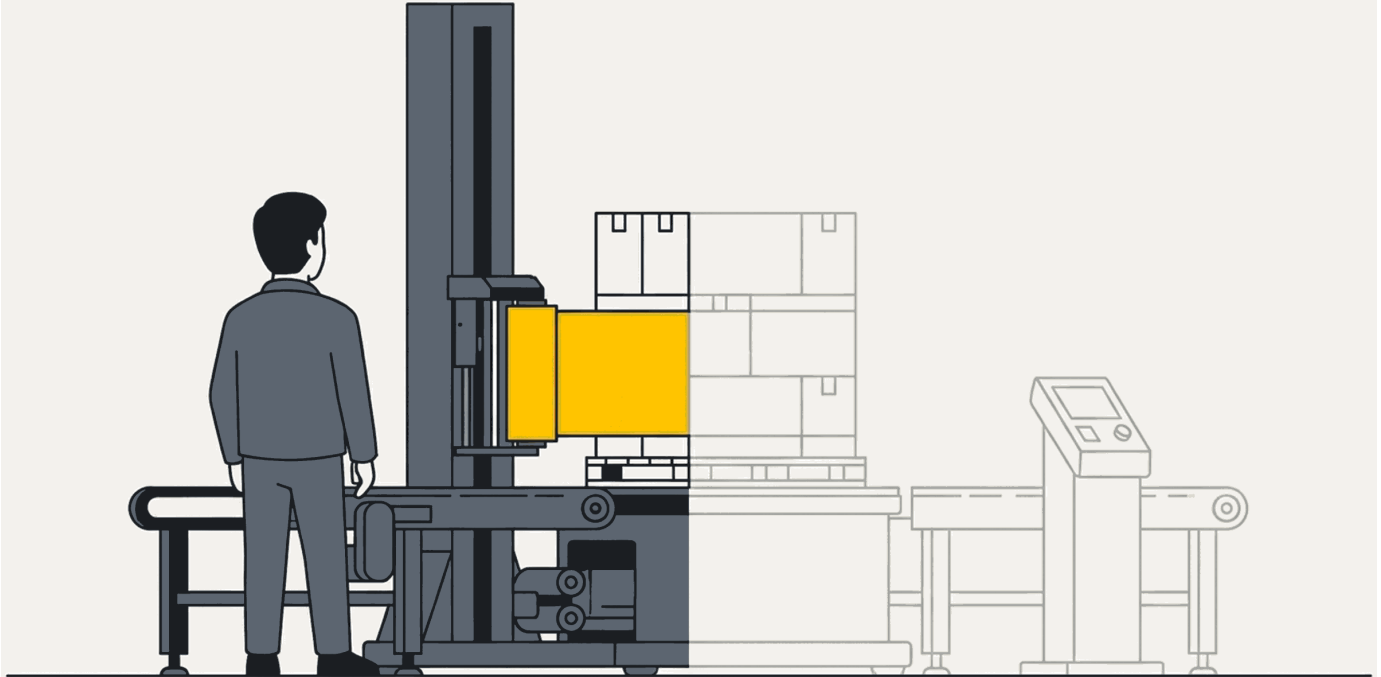


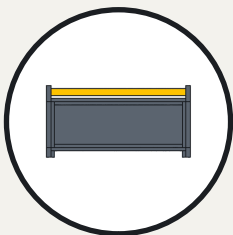
OEE

How much of your machine do you actually get?

LEAN DAY TOOLKIT

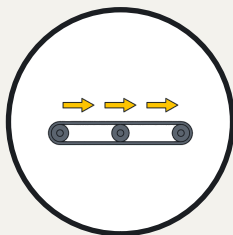


Availability times performance times quality. Three honest fractions multiply into one number - and the factor that drags it down is where your capacity went. World class is 85%. Most floors find they own a second machine they never use.



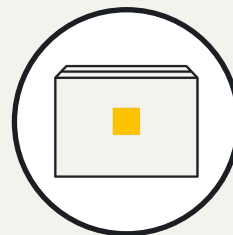
AVAILABILITY

Did it run when planned?



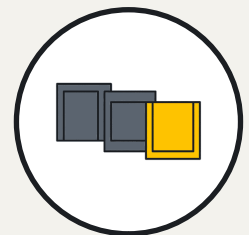
PERFORMANCE

At its rated speed?



QUALITY

Right first time?



MULTIPLY

Three fractions, one truth

AVAILABILITY

Planned time minus the stops.
Run the hour board and the
downtime log offers the number
- one tap fills it in.

PERFORMANCE

Rated speed against real speed.
Slow cycles hide better than
stoppages.

QUALITY

Only right-first-time counts.
Rework is a loss wearing a
uniform.

READ THE WEAKEST

$89\% \times 80\% \times 97\%$ is 69% - and
the 80% names the problem.

**The cheapest capacity
you will ever buy is the
machine you already
own.**