



OEE Report Template

10 May 2019 / Vertical Milling Machine / Rosa Shelly

Complete

Score	46.67%	Failed items	8
Site	Sydney		
Company	Primo Manufacturing Co.		
Manufacturing Facility	4245 Jessie St., Coltington OH 43085		
Equipment/Production Process	Vertical Milling Machine		
Machine Operator	Rosa Shelly		
Conducted on	10 May 2019 12:14 PST		

OEE Report Template / Unplanned Downtime

Were there equipment breakdowns/failures?

Yes



Photo 1

OEE Report Template / Unplanned Downtime

Were unplanned repairs made?

Yes

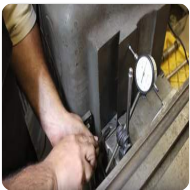


Photo 2

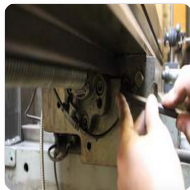


Photo 3

OEE Report Template / Planned Downtime

Was the equipment set up too long?

Yes

53 minutes longer than usual

OEE Report Template / Planned Downtime

Did the changeovers take too long?

Yes

The next production run was on hold for an hour and 24 minutes

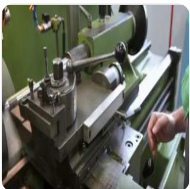


Photo 4

OEE Report Template / Slow Cycles

Was there a lack of maintenance?

Yes

OEE Report Template / Slow Cycles

Was there wear and tear on the equipment?

Yes



Photo 5

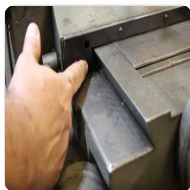


Photo 6



Photo 7

OEE Report Template / Production Rejects

Were there products that had to be reworked to be usable?

Yes

OEE Report Template / Start-up Rejects

Were there start-up losses during ramp up of production?

Yes



Photo 8

Unplanned Downtime

2 failed, 50%

Were there equipment breakdowns/failures?

Yes



Photo 1

Were unplanned repairs made?

Yes

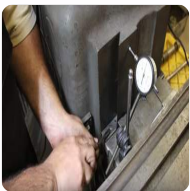


Photo 2

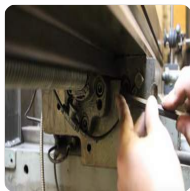


Photo 3

Was there a lack of material?

No

Was there a lack of transport for completed goods?

No

Planned Downtime

2 failed, 33.33%

Was the equipment set up too long?

Yes

53 minutes longer than usual

Did the changeovers take too long?

Yes

The next production run was on hold for an hour and 24 minutes

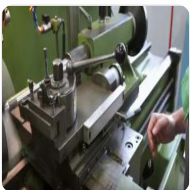


Photo 4

Was the operator frequently absent? (e.g. breaks, comfort room time, etc.)

No

Small Stops

100%

Was there minor idling?

No

Was an incorrect operation done on the equipment?

No

The operator is experienced and properly trained

Slow Cycles

2 failed, 33.33%

Was there a lack of maintenance?

Yes

Was there wear and tear on the equipment?

Yes



Photo 5

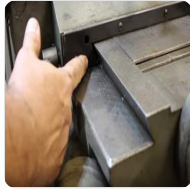


Photo 6



Photo 7

Were wrong settings applied to the equipment? (e.g. set speed slower than possible)

No

Production Rejects

1 failed, 50%

Were there products that cannot be salvaged at all?

No

Were there products that had to be reworked to be usable?

Yes

Start-up Rejects

1 failed, 0%

Were there start-up losses during ramp up of production?

Yes



Photo 8

Completion

Additional Observations

46.67% OEE is below industry standard. Let's keep on using iAuditor for our maintenance checks and quality assurance inspections to increase our overall equipment effectiveness.

Machine Operator Name & Signature

Rosa Shelly

10 May 2019 12:51 PST

Quality Manager Name & Signature

Frank Gene

10 May 2019 12:50 PST

Appendix



Photo 1



Photo 2



Photo 3



Photo 4



Photo 5



Photo 6



Photo 7



Photo 8