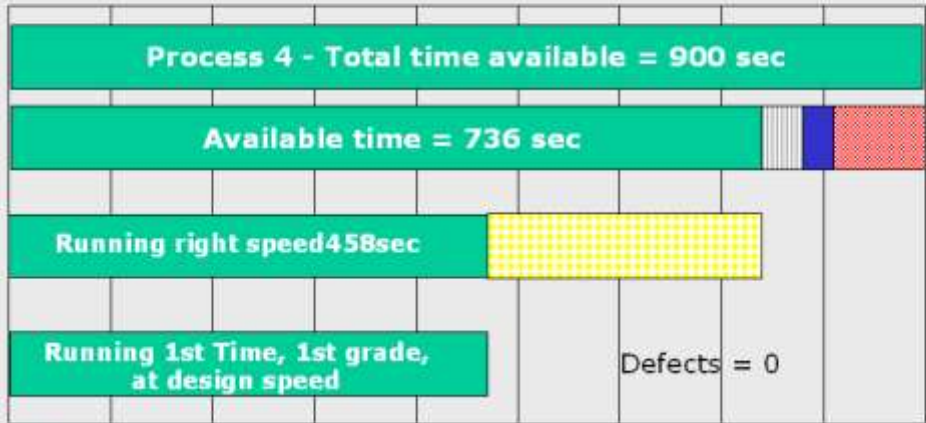


Simulation - Process 4

Overall Equipment Effectiveness (OEE)

Time 100s 200s 300s 400s 500s 600s 700s 800s 900s



Availability
82 %

Performance
62 %

Quality
100 %

OEE
51 %

- Downtime = Meals + other $5 + 2 * 30.0s = 65 \text{ sec}$
- Downtime = Breakdown $1 * 60.0s = 60 \text{ sec}$
- Change Over = Base plate Colour $13 * 3.0s = 39 \text{ sec}$
- Running Slow = Design speed (7.5s) Actual (12.7s) $60 * 5.2s = 310 \text{ sec}$

OEE Calculation = Availability x Performance x Quality