		DAICEL Group Run @ Rate / OEE Analysis					
Part #: Supplier: Location:				Revision: Supplier #:			
Supplier Quoted Pro	oduction Ra	ate:			per Hour		
Number of Machine Number of Molds Av Number of Cavities	es Available vailable: per Mold:	2:					
Planned Run Date: Planned Shifts: Planned Downtime:	:		Minutes	Planned Hours to	Run:		
Reason(s) for Planne	ed Downtir	me:					
Date:		Enter Start Time	Result From:	s Actual Shifts:	To	:	
Actual Downtime: Detail Downtime (Pl	lanned/Un	planned):	Minutes		-		-
Total F Comments:	Produced:		Total Rejected:]]actual
Total F Comments: – Supplier Run@Rate	Produced:	endation:	Total Rejected:]]		ACTUAL
Total F Comments: Supplier Run@Rate Actions	Produced:	endation:	Total Rejected:]	Due Date	Status]actual
Total F Comments: Supplier Run@Rate Actions	Produced:	endation:	Total Rejected:]	Due Date	Status]ACTUAL
Total F Comments: Supplier Run@Rate Actions	Produced:	endation: Overall Equ	Total Rejected: Responsible		Due Date	Status]actual
Total F Comments: Supplier Run@Rate Actions Shift Length	Produced:	endation: Overall Equ	Total Rejected: Responsible uipment Effectiver	ness (OEE) Minutes	Due Date	Status]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length 	Produced:	endation: Overall Equ Hours Breaks	Total Rejected: Responsible uipment Effectiver 0	ness (OEE) Minutes Minutes Each	Due Date	Status Minutes Total]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break	Produced:	endation: Overall Equ Hours Breaks Breaks	Total Rejected: Responsible Jipment Effectiver 0	ness (OEE) Minutes Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes	Total Rejected: Responsible	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total]actual
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute	Total Rejected: Responsible	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute	Total Rejected: Responsible	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Minutes Total Minutes Total]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute	Total Rejected: Responsible	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Minutes Total Minutes Total]ACTUAL
Total F Comments: Supplier Run@Rate Actions Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Planned Productio	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Shif	Total Rejected: Responsible Imprent Effectiver 0 Imprent Ffectiver	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total Minutes Total Minutes]actual
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Planned Productio Operating Tin	Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Pieces per Minute Shif Planned Proc	Total Rejected: Responsible Jipment Effectiver 0 Lungth - Breaks Juction Time - Dov	ness (OEE) Minutes Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total Minutes Total Minutes Minutes Minutes]ACTUAL
Total F Comments: Supplier Run@Rate Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Planned Productio Operating Tin Good Piece	Produced: Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Pieces per Minute Shif Planned Proc Total Pi	Total Rejected:	mess (OEE) Minutes Minutes Each Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total Minutes Minutes Minutes Minutes Minutes]ACTUAL
Total F Comments: Supplier Run@Rate Actions Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Reject Pieces Planned Productio Operating Tin Good Piece	Produced: Produced:	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Shif Planned Proc Total Pi	Total Rejected: Responsible Responsible	Minutes Minutes Each Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total Minutes Total Minutes Minutes Minutes Minutes Minutes]ACTUAL
Total F Comments: Supplier Run@Rate Actions Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Reject Pieces Planned Productio Operating Tin Good Piece	Produced: e Recomme on Time me es	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Pieces per Minute Shif Planned Proc Total Pi Operating Time / Plan	Total Rejected:	mess (OEE) Minutes Minutes Each Minutes Each Minutes Each Minutes Each Minutes Each Minutes Each	Due Date	Status Status Minutes Total Minutes Total Minutes Minutes Minutes Minutes Minutes]ACTUAL
Total F Comments: Supplier Run@Rate Actions Actions Shift Length Breaks Lunch Break Down Time Ideal Run Rate Total Pieces Reject Pieces Reject Pieces Reject Pieces Planned Productio Operating Tin Good Piece	Produced: e Recomme on Time me es	endation: Overall Equ Hours Breaks Breaks Breaks Minutes Pieces per Minute Pieces per Minute Shif Planned Proc Total Pieces / Operatin (Total Pieces / Operatin Good Pieces	Total Rejected: Responsible Responsible I I I I I I I I I I I I I I I I I I	Minutes Minutes Each Minutes Each Minutes Each Minutes Each Minutes Each ime n Rate	Due Date	Status Status Minutes Total Minutes Total Minutes Minutes Minutes Minutes Minutes	

SDI/Daicel Disposition:		
SDE/QE Signature	Date	

PASS	ACCEPT	OPTIONAL	
REJECT	REJECT	REQUIRED	

_	_					
The Fo	rmulas	lass OFF th	e OFE calcu	lation is has		
Availabi	litv					
Availability takes into account Down Time Loss ar						
Availab	ilitv = Ope	erating Tim	e / Planne	d Productic		
Perform	ance					
Performar	nce takes ir	nto account	t Speed Lo	oss. and is		
Perforn	nance = Id	leal Cycle T	Time / (Op	erating Tin		
Ideal Cvcl	<i>e Time</i> is t	he minimu	m cvcle tin	ne that voi		
Since Run	Rate is the	e reciproca	I of Cycle ⁻	Time, <i>Perfc</i>		
Perform	nance = (7	otal Pieces	; / Operatii	ng Time) /		
Performar	nce is cappo	ed at 100%	6, to ensur	e that if ar		
Quality						
Quality ta	kes into ac	count Qua	lity Loss,	and is calc		
Quality	= Good Pie	eces / Tota	l Pieces			
OEE						
OEE takes	into accou	int all thre	e OEE Fac	tors, and i		
OEE = A	vailability	x Performa	nce x Qua	lity		
It is very	important t	o recogniz	e that imp	roving OEE		
OEE Factor	Shift 1	Shift 2				
Availabi	90.00%	95.00%				
lity						
Perform	95.00%	95.00%				
ance	00 500/					
Quality	99.50%	96.00%				
OEE	85.10%	86.60%				
Superficia	Ily, it may	appear tha	t the seco	nd shift is r		
The beaut	y of UEE is	not that i	t gives you	one magi		
Examp	le OEE (Calculat	ion			
The table	below cont	ains hypot	netical shi	rt data, to		
Item	Data					
Shift	8 hours					
Length	= 460 min.					
Short	2 @ 15					
Breaks	min. =					
	30 min.					
Meal	1 @ 30					
вгеак	min. = 30 min					
Down	47					
Time	minutes					
Ideal	60					
Run	pieces					
Rate	per					
	minute					

Total	19,271		
Pieces	pieces		
Reject	423 nieces		
Planned	pieces		
Product			
ion			
Time			
	420		
	= 420		
	minutes	 	
Operati			
ng mie			
	373		
	= 373		
	minutes		
Good			
Pieces			
	=		
	19,271 -		
	423	 	
	= 18 8/8		
	pieces		
Availabi			
lity			
	= 373		
	minutes		
	/ 420 minutes		
	=		
	- 0.8881		
	or		
	88.81%		
Perform			
ance			
	= (10.271		
	pieces /		
	373		
	minutes)		
	/ 60		
	pieces		
	minute		
	_		
	- 0.8611		
	or		
	86.11%	 	
Quality			

	= 18,848 / 19,271 pieces		
	= 0.9780 or 97.80%		
OEE			
	= 0.8881 x 0.8611 x 0.9780		
	= 0.7479 or 74.79%		