

Brady
OVERALL EQUIPMENT EFFECTIVENESS WORKSHEET

20

Machine Number:	Shift:
Part Number	Date:

Availability

A. Total Scheduled time A. minutes

B. Employee Downtime

- Breaks minutes
- Lunch minutes
- Meetings minutes
- Planned Maintenance minutes

B. minutes

C. Net Available Time (A - B) C. minutes

D. Downtime

- Equipment Breakdowns minutes
- Setup & Adjustments minutes
- Tooling minutes
- Documented Minor Stoppages minutes

D. minutes

E. Operating time (C - D) E. minutes

F. Availability (E / C) x 100 F. %

Performance Efficiency

G. Total Parts Run G. pieces

H. Ideal Cycle Time H. min/part

I. Performance Efficiency ((H x G) / E) x 100 I. %

Quality Rate

J. Total Rejects J. Pieces

K. Quality Rate ((G - J) / G) x 100 K. %

Overall Equipment Effectiveness

L. Overall Equipment Effectiveness (F x I x K) / 10,000 L. %