

OEE Calculation Model



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|--------------|----------------------------------|-----------------------------|--------------------|---------------------|-------------------------|---|----------------|
| | | Total operation time | | | | | |
| | | Planned operation time | | | No production scheduled | | |
| Availability | A Planned production time | | | Planned downtime | | | |
| | B Actual operation time | | | Downtime | | | |
| Efficiency | C Theoretical output* | | | Disruption | | | |
| | D Actual output | | | | | | |
| Quality | E Good products | | Scrap | | | | |
| | | Quality losses | Performance losses | Availability losses | | | |
| OEE | | = | B/A | x | D/C | x | E/D |
| | | | Utilization factor | | Efficiency factor | | Quality factor |

* (operation time x theoretical runrate)