Teaching Learning Community

*Excellence and Beyond...*

# Most Common OEE Mistakes

eCourse

# 1. Mistake: Focusing on the OEE score, not the losses

- Monitoring your OEE score on its own is not all that helpful to improving production. It tells you the “what” but not the “why”.
- The true value of OEE comes from identifying the underlying losses and where they come from
  - Availability Loss,
  - Performance Loss and
  - Quality Loss

***Takeaway: First and foremost, think of OEE as an improvement measure, rather than a KPI.***

# 2. Mistake: Using OEE to compare unrelated processes

- OEE score comparisons don’t mean anything unless you are comparing the same equipment, running the same product, in the same environment
- For example, why compare the OEE score from a production line with 10 changeovers a day to one with just two changeovers?
- These comparisons are only a distraction.

***Takeaway: Compare with care. Focus on OEE as a tool to measure improvement and manage progress over time for a particular asset***

# 3. Mistake: Not engaging operators in the process

- Operators are essential to the OEE process;
- They are the ones who will be monitoring and using the data to make changes and improvements.
- Without engaging operators, you run the risk of OEE being seen as “just another” KPI, abstract metric, or worse, a tool to blame individuals when things go wrong.
- Without their buy-in, OEE is just another number.

***Takeaway: Engage your operators in the OEE implementation process from the start. Provide training to help them understand how it will guide their tasks and why it’s important to the company.***

# 4. Mistake: Excluding changeovers in your OEE calculation

- We assume changeovers are an unavoidable part of production & might be tempted to exclude them in the OEE calculation
- It's important to remember that changeover time is lost production time – it's time that could otherwise be spent producing an output.
- Excluding changeovers from your OEE calculation will incorrectly increase Availability (and your OEE score), hiding the opportunity to increase production by streamlining changeovers

***Takeaway: By including changeover time in your OEE calculation, you can identify opportunities to streamline changeovers and increase production.***

# 5. Mistake: Implementing OEE across the whole plant

- There is no value in calculating the OEE for a whole plant, won't pinpoint where the losses are.
- OEE is best used on a single piece of equipment or production line to measure performance and analyse the losses.
- By focusing on a single asset, with the breakdown of availability, performance and quality, you can hone in on the opportunities for improvement.

***Takeaway: By including changeover time in your OEE calculation, you can identify opportunities to streamline changeovers and increase production.***

# 6. Mistake: Your data collection is too slow

- OEE measurement should be used to identify sources of losses and correct them
- If the measurement method is a combination of automated and manual data, put it into a spreadsheet, it might be ineffective - by the time you have identified the issue and worked out how to improve the process, you will have lost hours of production capacity.
- If you want to unlock to the full benefit of OEE, use software to automatically collect and report on OEE in real-time.
- This can automatically feed through to an OEE dashboard so that managers and operators can see the KPI instantly

***Takeaway: With the right data at their fingertips, operators will be able to see where to reduce losses and improve performance. .***