



OVERALL EQUIPMENT EFFECTIVENESS FOR MOULDS

Part Number:	Date:
Serial Number:	Project Name:
Part Name:	Project Number:
Supplier:	Prepared by:

a. Target Running Hours	0
b. No of Cavities	0
c. Cycle time in sec	0
d. Target Production Quantities	
e. Actually Production Quantities	0
f. Actual Running Hours	0
g. Parts Approved (Quantity)	0

OEE CALCULATION

Equipment Rate (ER=f/a*100)	
Performance Rate (PR=e/d)	
Quality Rate (QR=g/e)	

OEE (ER*PR*QR)	
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- Target Running Hours:** Continuous 8 hours run.
- No of Cavities:** Number of cavities in mould.
- Cycle time in sec:** Cycle time as specified in the Mould specification sheet (already established)
- Target Production Quantities:** The number of parts the mould can generate with the criteria given
- Actual Running Hours:** The actual running time of the machine
- Parts Approved:** The total number of parts of in order
- Equipment Rate:** The result should be ≥95%
- Performance Rate:** The result should be ≥95%
- Quality Rate:** The result should be ≥99%
- OEE:** The result should be ≥89%

- Notes:**
- A.** A full shot sampled at start/stop and at 1 hour intervals should be checked visually and dimensionally. The CC dimensions generated from these measurements to be submitted in a report accompanied with the measured parts clearly identified for each hour.
 - B.** The 8 hours continues run is effective when all parameters are set with no further process interventions.
 - C.** A Process setting chart must be filled during the OEE process and forward with OEE results.

REMARKS: