METHODE ELECTRONICS

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)	

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: