



DF CONSULTING

OEE Tracker

DFC-LT-15 · Availability x Performance x Quality. One row per shift, per machine.

Ideal cycle time is the fastest the machine has ever run a good part, not the rate on the quote. Planned production time excludes time you chose not to run; everything else you lose is downtime. Record the loss reason on every row or the number cannot be acted on.

MACHINE / LINE	AREA	MONTH

[illegible]



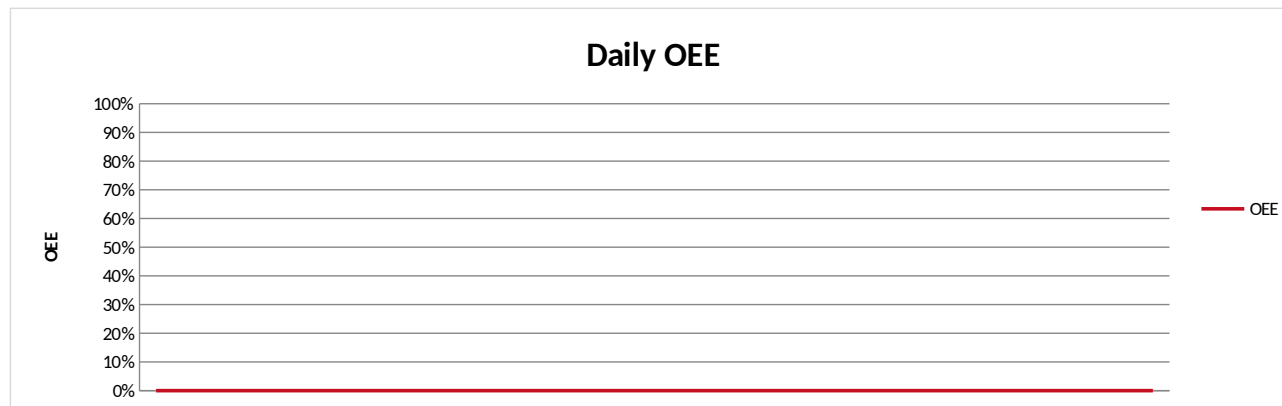
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MACHINE / LINE	AREA	MONTH

Date	Shift	Planned time (min)	Downtime (min)	Run time (min)	Ideal cycle (s/pc)	Total count	Good count	Availability	Performance	Quality	OEE	TEEP ref	Biggest loss this shift
PERIOD		0	0	0		0	0						

World class is often quoted as 85% OEE. Ignore the benchmark and watch your own trend — a machine that is not the constraint does not need a high OEE, it needs to be available when the constraint calls for it.





Total the minutes lost by cause, then work the top two. Nothing else.

Rank by minutes lost, not by how often it happens. Frequent small stops usually beat one long breakdown, and they are almost always cheaper to fix.

Loss category	Minutes lost	% of total	Cumulative %	Countermeasure / owner
Breakdown				
Setup / changeover				
Minor stops				
Reduced speed				
Startup rejects				
Production rejects				
Material starve				
No operator				
Other				
TOTAL MINUTES LOST	0			

Minutes lost by cause

