



FUSS & O'NEILL

Manufacturing Solutions, LLC

"Enhancing Productivity"

Setting an OEE Target

Equipment Name: Various

X	Basic Skill
X	CounterMeasure
X	Accessibility
X	Safety
X	Mistake Proofing
X	Productivity

When implementing TPM we have found that giving the teams a target of 90% which is world class could have a detrimental effect. This becomes a corporate target and no ownership is developed. An alternative, is to set the 'Best Of the Best' or B.O.B. This is taken from past data on that machine and is the Best Availability x Best Performance x Best Quality. This can become a realistic target that the operator knows the machine is capable of. This becomes the target and the team works to that target. When they have achieved the target for at least four weeks then you can re-set B.O.B.

OVERALL EQUIPMENT EFFECTIVENESS

BEST OF BEST WORKSHEET

WEEK No	Availability X	Performance X	Quality =	OEE
1	71%	67%	96%	46%
2	85%	88%	94%	70%
3	77%	72%	99%	55%
4	92%	76%	92%	64%

BEST =	92%	88%	99%	80%
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Average	81%	76%	95%	58%
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