Plant Performance

May 1989

Corrugator	Total Time Run Hours (RH) Downtime (DH)	Perf.	No. of Runs	Total m Total m² Ø m / Run Ø m² / Run	Trim Total Trim Ø Roll Size	Total m / h m / h RH Total m² / h m² / h RH	Total m / min m / min RH	Single Wall Double Wall Triple Wall		Staff Time Ø Staff Mach. Perf.	Availability Performance Quality OEE¹
OND	**111'37**	**106.6 %**	**389**	**990.541 m**	3.42 %	**8.874 m / h**	**148 m / min**	1.699.597 m²	169 m / min		86.5 %
				2.168.609 m²	74.247 m²	10.256 m / h	171 m / min	460.848 m²	116 m / min		155.4 %
	96'35 86.5 %			2.546 m	2.189 mm	19.429 m² / h		8.164 m²	127 m / min		99.7 %
	15'02 13.5 %			5.575 m²		22.453 m² / h					134.1 %

Machine	Total Time Set-Up Hours (SH) Run Hours (RH) Downtime (DH)	Perf. Perf. SH Perf. RH	No. of Runs with Die-Cut no Die-Cut Die-Cut Waste	Total Good sht. Total m² Ø sht. / Order Ø m² / Order	Ø No. Out Ø Sheet Size	Total sht. / h sht. / h RH sht. / h RH+DH	Total m²/h m² / h RH m² / h RH+SH	Single Wall Double Wall Triple Wall	No Print 1 Color 2 Colors 3+ Colors		Staff Time Ø Staff Mach. Perf.	Availability Performance Quality OEE¹
20	**146'50**	**1.0 %**	**3**	**5.624 sht.**		**38 sht. / h**	**18 m² / h**	3.457 sht.	5.624 sht.	2.659 m²		4.3 %
	1'05 0.7 %	138.4 %		**2.659 m²**		888 sht. / h	420 m² / h	2.167 sht.				64.5 %
	6'20 4.3 %	0.0 %	3 100.0 %	1.875 sht.	1.00	608 sht. / h	287 m² / h					98.3 %
	139'25 94.9 %			886 m²	0.47 m²							2.7 %
30	**189'03**	**6.1 %**	**23**	**123.026 sht.**		**651 sht. / h**	**338 m² / h**	121.939 sht.	123.026 sht.	63.950 m²		18.6 %
	5'42 3.0 %	177.2 %		**63.950 m²**		3.500 sht. / h	1.819 m² / h	1.087 sht.				59.3 %
	35'09 18.6 %	0.1 %	23 100.0 %	5.349 sht.	1.00	2.650 sht. / h	1.377 m² / h					98.4 %
	148'12 78.4 %			2.780 m²	0.52 m²							10.8 %
31	**176'29**	**5.9 %**	**22**	**61.931 sht.**		**351 sht. / h**	**297 m² / h**	55.115 sht.	61.931 sht.	52.498 m²		35.7 %
	106'35 60.4 %	9.8 %	1 4.5 %	**52.498 m²**		983 sht. / h	833 m² / h	6.816 sht.				43.4 %
	63'00 35.7 %	0.0 %	21 95.5 %	2.815 sht.	1.03	887 sht. / h	752 m² / h					98.5 %
	6'54 3.9 %			2.386 m²	0.85 m²							15.3 %
32	**165'29**	**6.9 %**	**13**	**129.892 sht.**		**785 sht. / h**	**477 m² / h**	128.754 sht.	93.342 sht.	58.270 m²		11.6 %
	38'12 23.1 %	15.7 %		**78.895 m²**		6.771 sht. / h	4.113 m² / h	1.138 sht.	36.550 sht.	20.625 m²		114.0 %
	19'11 11.6 %	4.2 %	13 100.0 %	9.992 sht.	1.04	5.488 sht. / h	3.334 m² / h					99.0 %
	108'06 65.3 %			6.069 m²	0.61 m²							13.1 %
51	**235'01**	**3.5 %**	**25**	**131.058 sht.**		**558 sht. / h**	**515 m² / h**	88.496 sht.	131.058 sht.	120.935 m²		38.4 %
	144'06 61.3 %	3.4 %		**120.935 m²**		1.453 sht. / h	1.341 m² / h	42.562 sht.				72.0 %
	90'12 38.4 %	3.6 %	25 100.0 %	5.242 sht.	3.24	1.453 sht. / h	1.341 m² / h					99.0 %
	0'43			4.837 m²	0.92 m²							27.3 %
58	**163'01**	**4.4 %**	**6**	**52.072 sht.**		**319 sht. / h**	**337 m² / h**	25.290 sht.	52.072 sht.	54.876 m²		13.9 %
	140'21 86.1 %	1.4 %		**54.876 m²**		2.297 sht. / h	2.421 m² / h	26.782 sht.				96.6 %
	22'40 13.9 %	22.9 %	6 100.0 %	8.679 sht.	2.71	2.297 sht. / h	2.421 m² / h					99.1 %
	0'00			9.146 m²	1.05 m²							13.3 %
60	**145'56**	**0.0 %**	**2**	**1.087 sht.**		**7 sht. / h**	**4 m² / h**	1.087 sht.	1.087 sht.	608 m²		5.3 %
	138'16 94.7 %	0.0 %		**608 m²**		142 sht. / h	79 m² / h					14.3 %
	7'40 5.3 %	0.0 %	2 100.0 %	544 sht.	1.00	142 sht. / h	79 m² / h					98.8 %
	0'00			304 m²	0.56 m²							0.7 %

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Machine	Total Time Set-Up Hours (SH) Run Hours (RH) Downtime (DH)		Perf. Perf. SH Perf. RH	No. of Runs with Die-Cut no Die-Cut Die-Cut Waste		Total Good sht. Total m² Ø sht. / Order Ø m² / Order	Ø No. Out Ø Sheet Size	Total sht. / h sht. / h RH sht. / h RH+DH	Total m²/h m² / h RH m² / h RH+SH	Single Wall Double Wall Triple Wall	No Print 1 Color 2 Colors 3+ Colors		Staff Time Ø Staff Mach. Perf.	Availability Performance Quality OEE[1]
65	**5'45** 0'15 5'30 0'00	 4.3 % 95.7 % 	**0.0 %** 0.0 % 0.0 % 	**1** 1 	 100.0 % 	**1.087 sht.** **608 m²** 1.087 sht. 608 m²	 1.00 0.56 m²	**189 sht. / h** 198 sht. / h 198 sht. / h 	**106 m² / h** 111 m² / h 111 m² / h 	1.087 sht.	1.087 sht.	608 m²		95.7 % 80.0 % 98.8 % 75.6 %
81	**5'00** 0'50 4'10 0'00	 16.7 % 83.3 % 	**5.0 %** 30.0 % 0.0 % 	**1** 1 	 100.0 % 									83.3 %
88	**154'31** 0'35 17'40 136'16	 0.4 % 11.4 % 	**0.0 %** 0.0 % 0.0 % 	**2** 2 	 100.0 % 	**21.108 sht.** **12.714 m²** 10.554 sht. 6.357 m²	 1.00 0.60 m²	**137 sht. / h** 1.195 sht. / h 1.195 sht. / h 	**82 m² / h** 720 m² / h 720 m² / h 	21.108 sht.	21.108 sht.	12.714 m²		11.4 % 87.0 % 98.1 % 9.8 %
89	**136'41** 1'15 135'26 0'00	 0.9 % 99.1 % 	**0.7 %** 80.0 % 0.0 % 	**1** 1 	 100.0 % 									99.1 %

Note

[1] **Availability** takes into account Downtime Loss. Calculated as the ratio of Run Hours to Work Hours.
Performance takes into account Speed Loss. Calculated as the ratio of Actual Run Speed to Target Speed.
Quality takes into account Quality Loss. Calculated as the ratio of Good Produced Quantity to Total Produced Quantity.

[2] There is no Target Speed given for this machine. Instead this report shows the relation between the Planning Speed and the Actual Speed including downtimes to calculate Performance. Please enter an appropriate Target Speed for this machine to get reliable values!

OEE (Overall Equipment Efficiency)
OEE is the product of Availability, Performance and Quality, and offers an excellent way to monitor and improve the efficiency of your manufacturing process.

(Source: http://www.oee.com/oee_factors.html)