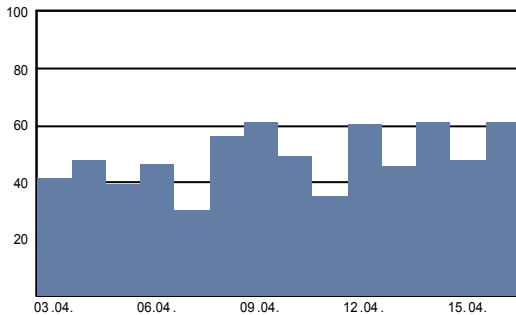


## 20 Slotter Jurine

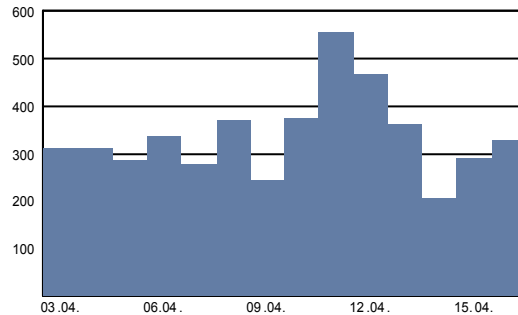
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped		Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks		Hours	Hours	%	Set-Up Hours		Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality
03.04.	23'59	9'26	14'33	4'01	16.7 %	4'31	17'58	6'01	26,245	4,362	461	1.7 %	1,42	3,281	4,642	1.00	8	0'34	41.4 %	311.6 %	98.3 %	126.6 %
04.04.	24'02	0'42	23'20	6'41	27.8 %	5'30	12'53	11'09	48,497	4,350	832	1.7 %	1,39	4,850	6,753	1.00	10	0'33	47.8 %	310.7 %	98.3 %	146.0 %
05.04.	15'57	0'39	15'18	4'06	25.7 %	5'11	9'56	6'01	24,052	3,998	348	1.4 %	1,99	2,187	4,353	1.00	11	0'28	39.3 %	285.5 %	98.6 %	110.7 %
06.04.	6'03	0'23	5'40	1'32	25.3 %	1'31	3'26	2'37	12,270	4,689	57	0.5 %	1,96	3,068	6,012	1.00	4	0'23	46.2 %	334.9 %	99.5 %	153.9 %
07.04.	24'02	0'45	23'17	7'48	32.5 %	8'29	17'02	7'00	27,438	3,920	788	2.8 %	1,77	1,715	3,039	1.00	16	0'32	30.1 %	280.0 %	97.2 %	81.8 %
08.04.	23'58	1'01	22'57	5'31	23.0 %	4'34	11'06	12'52	66,898	5,199	474	0.7 %	1,48	5,146	7,596	1.00	13	0'21	56.1 %	371.4 %	99.3 %	206.7 %
09.04.	23'58	0'59	22'59	5'15	21.9 %	3'42	9'56	14'02	47,956	3,417	559	1.2 %	1,84	5,995	11,058	1.00	8	0'28	61.1 %	244.1 %	98.8 %	147.3 %
10.04.	24'03	0'54	23'09	5'15	21.8 %	6'28	12'37	11'26	59,800	5,230	539	0.9 %	1,24	5,436	6,721	1.00	11	0'35	49.4 %	373.6 %	99.1 %	182.9 %
11.04.	24'00	0'40	23'20	8'25	35.1 %	6'39	15'44	8'16	64,325	7,781	2,552	3.8 %	0,88	5,360	4,743	1.00	12	0'33	35.4 %	555.8 %	96.2 %	189.4 %
12.04.	14'57	0'36	14'21	3'53	26.0 %	1'50	6'19	8'38	56,622	6,559	388	0.7 %	1,52	11,324	17,212	1.00	5	0'22	60.2 %	468.5 %	99.3 %	279.9 %
13.04.	8'00	0'18	7'42	1'47	22.3 %	2'24	4'29	3'31	17,793	5,060	124	0.7 %	1,68	5,931	9,965	1.00	3	0'48	45.7 %	361.4 %	99.3 %	163.9 %
14.04.	24'00	0'23	23'37	4'32	18.9 %	4'42	9'37	14'23	41,475	2,884	209	0.5 %	1,57	5,184	8,146	1.00	8	0'35	60.9 %	206.0 %	99.5 %	124.8 %
15.04.	24'01	0'40	23'21	6'18	26.2 %	5'52	12'50	11'11	45,558	4,074	451	1.0 %	1,67	5,062	8,430	1.00	9	0'39	47.9 %	291.0 %	99.0 %	138.0 %
16.04.	24'01	0'59	23'02	4'09	17.3 %	4'50	9'58	14'03	64,948	4,623	327	0.5 %	1,62	4,996	8,105	1.00	13	0'22	61.0 %	330.2 %	99.5 %	200.4 %
<b>Total</b>	<b>285'01</b>	<b>18'25</b>	<b>266'36</b>	<b>69'13</b>	<b>24.3 %</b>	<b>66'13</b>	<b>153'51</b>	<b>131'10</b>	<b>603,877</b>	<b>4,604</b>	<b>8,109</b>	<b>1.3 %</b>	<b>1.50</b>	<b>4,610</b>	<b>6,913</b>	<b>1.00</b>	<b>131</b>	<b>0'30</b>	<b>49.2 %</b>	<b>328.8 %</b>	<b>98.7 %</b>	<b>159.6 %</b>
<b>Av.</b>	<b>20'21</b>	<b>1'18</b>	<b>19'02</b>	<b>4'56</b>		<b>4'43</b>	<b>10'59</b>	<b>9'22</b>	<b>43,134</b>		<b>579</b>						<b>9.4</b>					

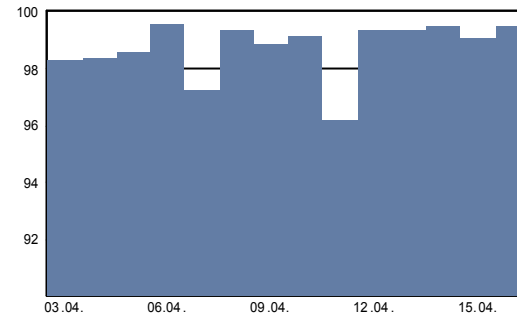
Availability (in %)



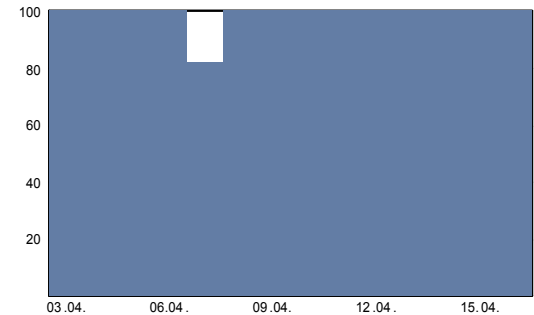
Performance (in %)



Quality (in %)



OEE (in %)

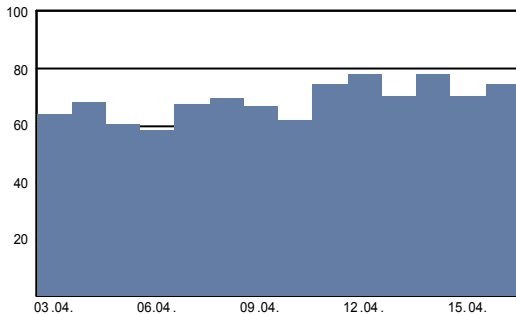


## 30 Martin 1000

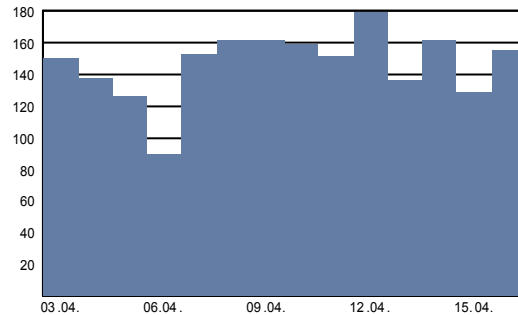
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Set-Up	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>				
	Hours	Breaks		Hours	Hours			%	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>
03.04.	23'57	0'41	23'16	4'43	19.7 %	3'41	9'05	14'52	133,567	8,984	416	0.3 %	0,71	6,071	4,309	1.00	22	0'10	63.9 %	149.7 %	99.7 %	95.4 %
04.04.	23'59	1'02	22'57	2'52	12.0 %	4'23	8'17	15'42	129,756	8,265	1,015	0.8 %	0,60	4,325	2,599	1.00	30	0'09	68.4 %	137.7 %	99.2 %	93.5 %
05.04.	7'58	0'18	7'40	1'44	21.8 %	1'18	3'20	4'38	35,220	7,601	416	1.2 %	0,71	5,031	3,550	1.00	7	0'11	60.4 %	126.7 %	98.8 %	75.7 %
06.04.	9'55	0'00	9'55	2'02	20.5 %	2'05	4'07	5'48	31,246	5,387	475	1.5 %	0,75	5,208	3,930	1.00	6	0'21	58.5 %	89.8 %	98.5 %	51.7 %
07.04.	23'58	0'39	23'19	4'36	19.2 %	3'05	8'20	15'38	142,805	9,135	1,325	0.9 %	0,57	7,140	4,057	1.00	20	0'09	67.0 %	152.2 %	99.1 %	101.1 %
08.04.	24'00	1'02	22'58	2'47	11.6 %	4'10	7'59	16'01	155,245	9,693	701	0.4 %	0,56	7,057	3,920	1.00	22	0'11	69.7 %	161.5 %	99.6 %	112.2 %
09.04.	24'03	1'02	23'01	3'19	13.8 %	4'21	8'42	15'21	148,700	9,687	700	0.5 %	0,60	5,128	3,084	1.00	29	0'09	66.7 %	161.5 %	99.5 %	107.2 %
10.04.	23'50	0'43	23'07	5'30	23.1 %	3'19	9'32	14'18	136,650	9,556	796	0.6 %	0,55	7,192	3,954	1.00	19	0'10	61.9 %	159.3 %	99.4 %	98.0 %
11.04.	23'56	0'57	22'59	2'19	9.7 %	3'37	6'53	17'03	155,290	9,108	852	0.5 %	0,61	7,765	4,752	1.00	20	0'11	74.2 %	151.8 %	99.5 %	112.0 %
12.04.	15'58	0'40	15'18	1'27	9.1 %	1'59	4'06	11'52	127,480	10,743	588	0.5 %	0,48	11,589	5,512	1.00	11	0'11	77.6 %	179.0 %	99.5 %	138.2 %
13.04.	8'08	0'21	7'47	1'22	16.8 %	0'58	2'41	5'27	44,410	8,149	193	0.4 %	0,82	6,344	5,171	1.00	7	0'08	70.0 %	135.8 %	99.6 %	94.7 %
14.04.	23'57	1'05	22'52	2'48	11.7 %	2'19	6'12	17'45	172,550	9,721	509	0.3 %	0,59	10,784	6,343	1.00	16	0'09	77.6 %	162.0 %	99.7 %	125.4 %
15.04.	24'00	9'44	14'16	2'11	9.1 %	2'04	13'59	10'01	77,725	7,760	455	0.6 %	0,53	8,636	4,568	1.00	9	0'14	70.2 %	129.3 %	99.4 %	90.3 %
16.04.	23'55	0'22	23'33	3'06	13.0 %	2'55	6'23	17'32	163,255	9,311	901	0.5 %	0,47	9,070	4,235	1.00	18	0'10	74.5 %	155.2 %	99.5 %	114.9 %
<b>Total</b>	<b>281'34</b>	<b>18'36</b>	<b>262'58</b>	<b>40'46</b>	<b>14.5 %</b>	<b>40'14</b>	<b>99'36</b>	<b>181'58</b>	<b>1,653,899</b>	<b>9,089</b>	<b>9,342</b>	<b>0.6 %</b>	<b>0.58</b>	<b>7,008</b>	<b>4,084</b>	<b>1.00</b>	<b>236</b>	<b>0'10</b>	<b>69.2 %</b>	<b>151.5 %</b>	<b>99.4 %</b>	<b>104.2 %</b>
<b>Av.</b>	<b>20'06</b>	<b>1'19</b>	<b>18'47</b>	<b>2'54</b>		<b>2'52</b>	<b>7'06</b>	<b>13'59</b>	<b>118,136</b>		<b>667</b>						<b>16.9</b>					

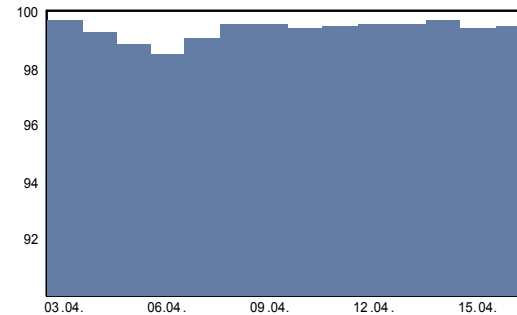
Availability (in %)



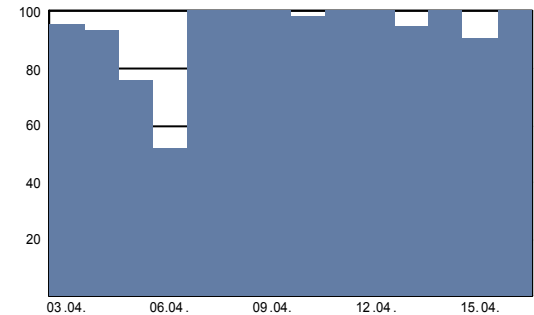
Performance (in %)



Quality (in %)



OEE (in %)

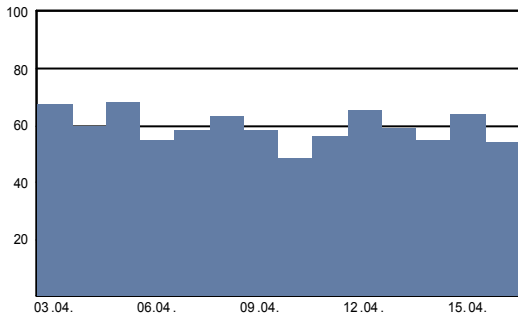


31 Rapidex

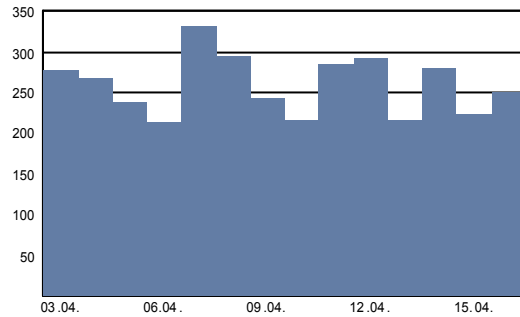
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Hours	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size			Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>					
	Hours	Breaks		Hours	Hours			%	Set-Up	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>
03.04.	23'52	0'58	22'54	3'13	13.5 %	4'17	8'28	15'24	98,450	6,393	1,086	1.1 %	0,93	8,204	7,629	1.14	12	0'21	67.2 %	278.0 %	98.9 %	184.9 %
04.04.	23'55	1'02	22'53	3'34	14.9 %	5'42	10'18	13'37	84,050	6,173	1,173	1.4 %	1,03	5,603	5,745	1.00	15	0'23	59.5 %	268.4 %	98.6 %	157.5 %
05.04.	8'01	0'19	7'42	0'45	9.4 %	1'44	2'48	5'13	28,725	5,506	688	2.3 %	0,83	5,745	4,793	1.00	5	0'21	67.7 %	239.4 %	97.7 %	158.4 %
06.04.	6'59	0'20	6'39	0'52	12.4 %	2'08	3'20	3'39	17,930	4,912	170	0.9 %	1,32	5,977	7,892	1.00	3	0'43	54.9 %	213.6 %	99.1 %	116.1 %
07.04.	23'58	11'41	12'17	1'37	6.7 %	3'31	16'49	7'09	54,298	7,594	600	1.1 %	0,98	4,525	4,433	1.00	12	0'18	58.2 %	330.2 %	98.9 %	190.1 %
08.04.	23'56	1'05	22'51	2'42	11.3 %	5'45	9'32	14'24	97,328	6,759	755	0.8 %	0,96	6,489	6,230	1.00	15	0'23	63.0 %	293.9 %	99.2 %	183.8 %
09.04.	23'58	0'20	23'38	4'55	20.5 %	4'54	10'09	13'49	76,974	5,571	1,029	1.3 %	0,85	7,697	6,538	1.28	10	0'29	58.5 %	242.2 %	98.7 %	139.7 %
10.04.	23'55	0'40	23'15	3'49	16.0 %	8'06	12'35	11'20	56,591	4,993	1,211	2.1 %	0,84	3,329	2,804	1.00	17	0'29	48.7 %	217.1 %	97.9 %	103.6 %
11.04.	23'54	0'40	23'14	4'11	17.5 %	6'05	10'56	12'58	85,175	6,569	1,187	1.4 %	0,81	7,098	5,743	1.00	12	0'30	55.8 %	285.6 %	98.6 %	157.2 %
12.04.	14'00	3'01	10'59	1'03	7.5 %	2'48	6'52	7'08	47,980	6,726	347	0.7 %	0,99	7,997	7,933	1.00	6	0'28	64.9 %	292.4 %	99.3 %	188.6 %
13.04.	7'48	6'42	1'06	0'13	2.8 %	0'14	7'09	0'39	3,240	4,985	12	0.4 %	0,99	1,620	1,611	1.00	2	0'07	59.1 %	216.7 %	99.6 %	127.6 %
14.04.	23'58	1'08	22'50	4'24	18.4 %	5'58	11'30	12'28	79,980	6,416	1,062	1.3 %	1,11	4,999	5,559	1.03	16	0'22	54.6 %	278.9 %	98.7 %	150.3 %
15.04.	23'56	0'40	23'16	1'58	8.2 %	6'22	9'00	14'56	76,861	5,147	1,266	1.6 %	1,04	5,124	5,323	1.15	15	0'25	64.2 %	223.8 %	98.4 %	141.3 %
16.04.	23'58	0'21	23'37	5'31	23.0 %	5'17	11'09	12'49	74,190	5,789	1,181	1.6 %	0,81	4,637	3,741	1.00	16	0'20	54.3 %	251.7 %	98.4 %	134.4 %
<b>Total</b>	<b>276'08</b>	<b>28'57</b>	<b>247'11</b>	<b>38'47</b>	<b>14.0 %</b>	<b>62'51</b>	<b>130'35</b>	<b>145'33</b>	<b>881,772</b>	<b>6,058</b>	<b>11,767</b>	<b>1.3 %</b>	<b>0.95</b>	<b>5,652</b>	<b>5,343</b>	<b>1.06</b>	<b>156</b>	<b>0'24</b>	<b>58.9 %</b>	<b>263.4 %</b>	<b>98.7 %</b>	<b>153.1 %</b>
<b>Av.</b>	<b>19'43</b>	<b>2'04</b>	<b>17'39</b>	<b>2'46</b>		<b>4'29</b>	<b>9'19</b>	<b>10'23</b>	<b>62,984</b>		<b>841</b>						<b>11.1</b>					

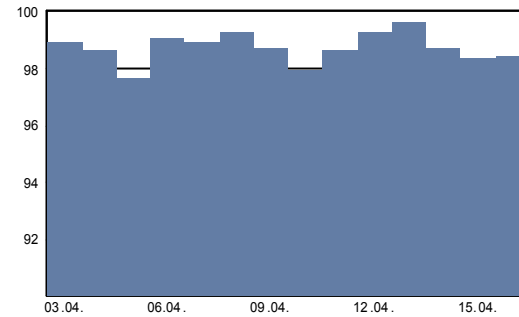
Availability (in %)



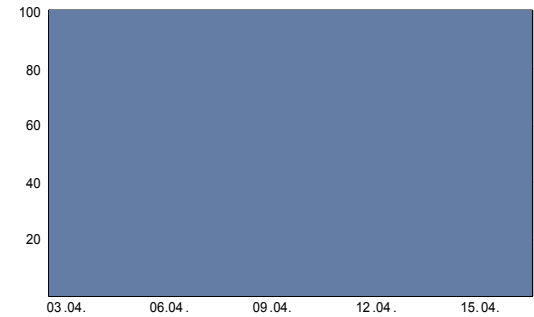
Performance (in %)



Quality (in %)



OEE (in %)

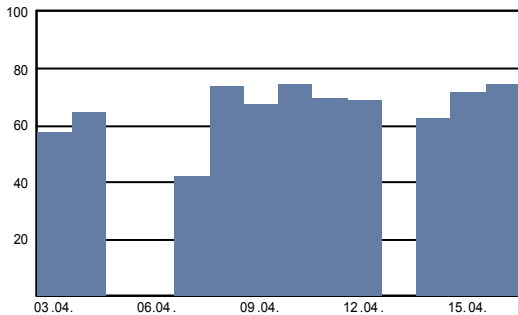


## 32 Martin 1000

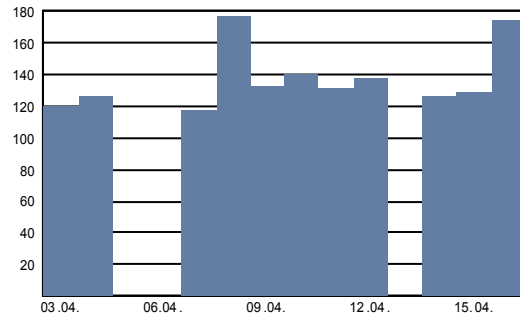
03.04.1989 - 16.04.1989

Date	Open		Work		Downtimes		Stopped		Run		Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks	Hours	Hours	%	Set-Up	Hours	Hours	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality	OEE
03.04.	15'57	0'39	15'18	3'18	20.7 %	3'13	7'10	8'47			63,510	7,231	436	0.7 %	0,73	5,293	3,858	1.00	12	0'16	57.4 %	120.5 %	99.3 %	68.7 %
04.04.	17'56	0'19	17'37	3'38	20.3 %	2'35	6'32	11'24			86,460	7,584	668	0.8 %	0,57	5,404	3,081	1.00	16	0'10	64.7 %	126.4 %	99.2 %	81.2 %
07.04.	19'53	0'43	19'10	7'31	37.8 %	3'32	11'46	8'07			57,100	7,035	378	0.7 %	0,66	4,079	2,702	1.00	14	0'15	42.3 %	117.2 %	99.3 %	49.3 %
08.04.	15'56	0'25	15'31	2'15	14.1 %	1'52	4'32	11'24			120,950	10,610	450	0.4 %	0,57	15,119	8,548	1.00	8	0'14	73.5 %	176.8 %	99.6 %	129.4 %
09.04.	23'59	1'00	22'59	3'36	15.0 %	3'58	8'34	15'25			122,275	7,931	1,044	0.8 %	0,65	5,823	3,809	1.00	21	0'11	67.1 %	132.2 %	99.2 %	87.9 %
10.04.	23'50	9'08	14'42	2'43	11.4 %	1'01	12'52	10'58			91,940	8,384	2,708	2.9 %	0,53	15,323	8,092	1.00	6	0'10	74.6 %	139.7 %	97.1 %	101.3 %
11.04.	24'00	0'38	23'22	4'45	19.8 %	2'28	7'51	16'09			127,210	7,877	763	0.6 %	0,54	8,481	4,574	1.00	15	0'10	69.1 %	131.3 %	99.4 %	90.2 %
12.04.	15'55	0'39	15'16	2'36	16.3 %	2'08	5'23	10'32			86,740	8,235	423	0.5 %	0,60	8,674	5,199	1.00	10	0'13	69.0 %	137.2 %	99.5 %	94.2 %
14.04.	15'58	0'21	15'37	2'46	17.3 %	3'08	6'15	9'43			73,310	7,545	434	0.6 %	0,76	3,858	2,919	1.00	19	0'10	62.2 %	125.7 %	99.4 %	77.8 %
15.04.	16'02	0'43	15'19	1'50	11.4 %	2'32	5'05	10'57			84,780	7,742	352	0.4 %	0,80	6,056	4,860	1.00	14	0'11	71.5 %	129.0 %	99.6 %	91.9 %
16.04.	15'59	0'40	15'19	2'20	14.6 %	1'35	4'35	11'24			119,535	10,486	442	0.4 %	0,51	9,961	5,086	1.00	12	0'08	74.4 %	174.8 %	99.6 %	129.6 %
<b>Total</b>	<b>205'25</b>	<b>15'15</b>	<b>190'10</b>	<b>37'18</b>	<b>18.2 %</b>	<b>28'02</b>	<b>80'35</b>	<b>124'50</b>			<b>1,033,810</b>	<b>8,282</b>	<b>8,098</b>	<b>0.8 %</b>	<b>0.61</b>	<b>7,033</b>	<b>4,323</b>	<b>1.00</b>	<b>147</b>	<b>0'11</b>	<b>65.6 %</b>	<b>138.0 %</b>	<b>99.2 %</b>	<b>89.9 %</b>
<b>Av.</b>	<b>18'40</b>	<b>1'23</b>	<b>17'17</b>	<b>3'23</b>		<b>2'32</b>	<b>7'19</b>	<b>11'20</b>			<b>93,983</b>		<b>736</b>						<b>13.4</b>					

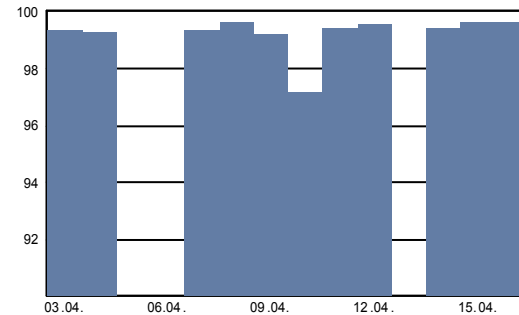
Availability (in %)



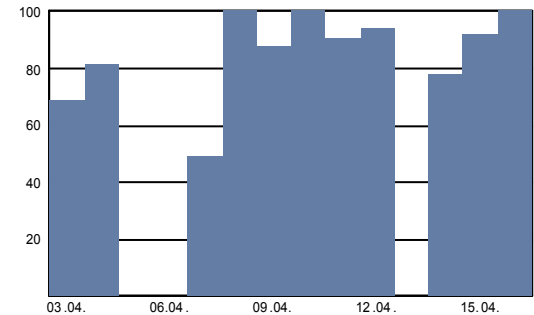
Performance (in %)



Quality (in %)



OEE (in %)

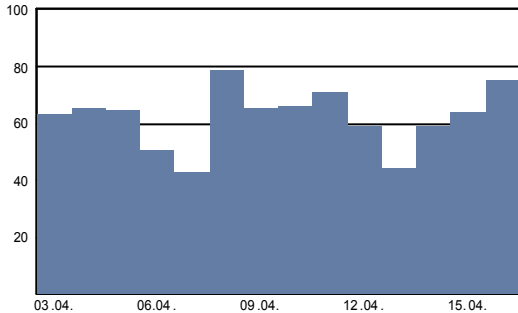


## 51 Bobst

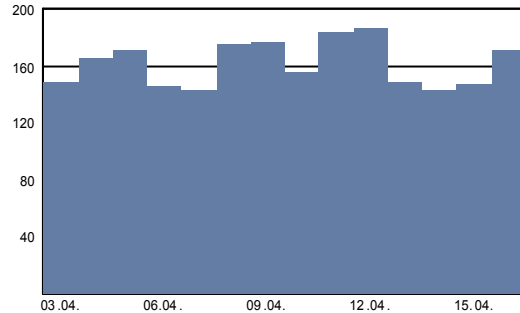
03.04.1989 - 16.04.1989

Date	Open		Work	Downtimes		Stopped		Run	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks	Hours	Hours	%	Set-Up	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality	OEE
03.04.	23'59	6'45	17'14	4'13	17.6 %	2'06	13'04	10'55	33,047	3,027	43	0.1 %	0,57	4,131	2,346	3.82	8	0'16	63.3 %	148.4 %	99.9 %	93.9 %
04.04.	23'56	0'39	23'17	5'24	22.6 %	2'42	8'45	15'11	51,481	3,391	37	0.1 %	0,64	4,680	2,975	4.49	11	0'15	65.2 %	166.2 %	99.9 %	108.3 %
05.04.	23'57	1'54	22'03	5'15	21.9 %	2'33	9'42	14'15	49,697	3,488	152	0.3 %	0,80	4,970	3,999	2.31	10	0'15	64.6 %	171.0 %	99.7 %	110.1 %
06.04.	7'59	0'23	7'36	2'56	36.7 %	0'49	4'08	3'51	11,416	2,965	29	0.3 %	0,70	5,708	3,989	1.46	2	0'25	50.7 %	145.4 %	99.7 %	73.4 %
07.04.	23'55	0'58	22'57	11'27	47.9 %	1'41	14'06	9'49	28,682	2,922	99	0.3 %	0,74	4,097	3,029	2.76	7	0'14	42.8 %	143.2 %	99.7 %	61.1 %
08.04.	23'56	0'41	23'15	2'47	11.6 %	2'09	5'37	18'19	65,748	3,590	63	0.1 %	0,92	7,305	6,705	4.35	9	0'14	78.8 %	176.0 %	99.9 %	138.5 %
09.04.	23'59	13'09	10'50	2'29	10.4 %	1'19	16'57	7'02	25,420	3,614	66	0.3 %	0,70	5,084	3,576	2.52	5	0'16	64.9 %	177.2 %	99.7 %	114.7 %
10.04.	23'57	8'41	15'16	3'51	16.1 %	1'23	13'55	10'02	31,748	3,164	39	0.1 %	0,67	3,528	2,364	4.32	9	0'09	65.7 %	155.1 %	99.9 %	101.8 %
11.04.	23'59	4'29	19'30	4'14	17.7 %	1'25	10'08	13'51	52,007	3,755	70	0.1 %	0,67	8,668	5,800	3.08	6	0'14	71.0 %	184.1 %	99.9 %	130.6 %
12.04.	8'14	4'34	3'40	0'55	11.1 %	0'36	6'05	2'09	8,205	3,816	11	0.1 %	0,66	4,103	2,700	5.40	2	0'18	58.6 %	187.1 %	99.9 %	109.5 %
13.04.	7'58	0'21	7'37	3'52	48.5 %	0'22	4'35	3'23	10,222	3,021	496	4.6 %	0,75	10,222	7,678	1.24	1	0'22	44.4 %	148.1 %	95.4 %	62.7 %
14.04.	23'58	17'02	6'56	2'29	10.4 %	0'22	19'53	4'05	11,890	2,912	23	0.2 %	0,67	11,890	7,975	1.52	1	0'22	58.9 %	142.7 %	99.8 %	83.9 %
15.04.	23'59	0'59	23'00	6'20	26.4 %	1'55	9'14	14'45	44,539	3,020	31	0.1 %	0,73	6,363	4,669	3.60	7	0'16	64.1 %	148.0 %	99.9 %	94.9 %
16.04.	23'58	8'21	15'37	2'42	11.3 %	1'10	12'13	11'45	40,921	3,483	13	0.0 %	0,64	13,640	8,667	5.44	3	0'23	75.2 %	170.7 %	100.0 %	128.4 %
<b>Total</b>	<b>287'44</b>	<b>68'56</b>	<b>218'48</b>	<b>58'54</b>	<b>20.5 %</b>	<b>20'32</b>	<b>148'22</b>	<b>139'22</b>	<b>465,023</b>	<b>3,337</b>	<b>1,172</b>	<b>0.3 %</b>	<b>0.72</b>	<b>5,741</b>	<b>4,132</b>	<b>3.59</b>	<b>81</b>	<b>0'15</b>	<b>63.7 %</b>	<b>163.6 %</b>	<b>99.7 %</b>	<b>103.9 %</b>
<b>Av.</b>	<b>20'33</b>	<b>4'55</b>	<b>15'37</b>	<b>4'12</b>		<b>1'28</b>	<b>10'35</b>	<b>9'57</b>	<b>33,216</b>		<b>84</b>						<b>5.8</b>					

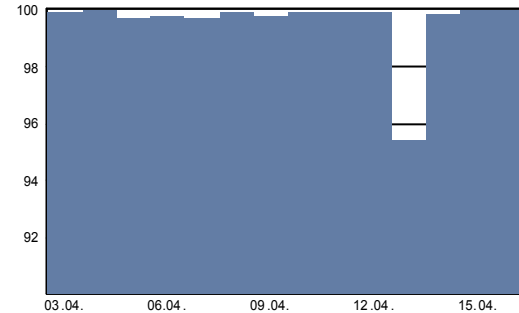
Availability (in %)



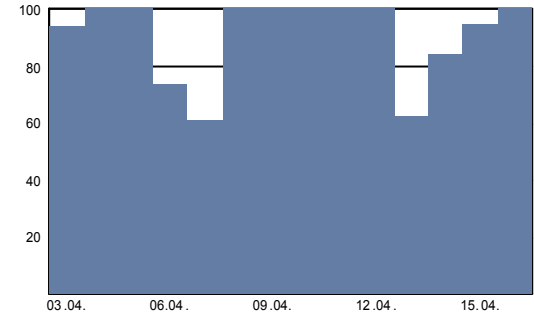
Performance (in %)



Quality (in %)



OEE (in %)

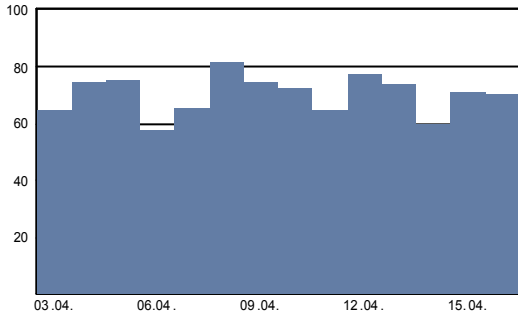


58 Ward

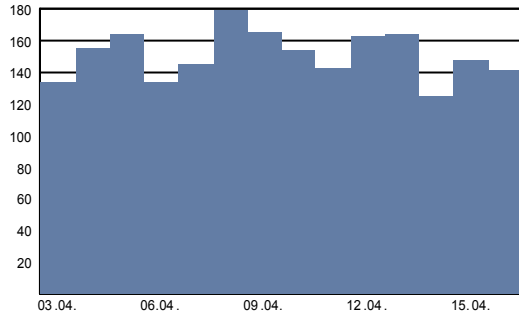
03.04.1989 - 16.04.1989

Date	Open		Work		Downtimes		Stopped		Run		Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks	Hours	Hours	Hours	%	Set-Up	Hours	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality	OEE
03.04.	23'55	1'00	22'55	5'42	23.8 %	2'28	9'10	14'45	47,266	3,204	130	0.3 %	0,81	5,252	4,263	2.59	9	0'16	64.4 %	133.5 %	99.7 %	85.7 %		
04.04.	23'56	0'40	23'16	3'34	14.9 %	2'23	6'37	17'19	64,514	3,726	50	0.1 %	0,90	4,301	3,878	3.45	15	0'10	74.4 %	155.2 %	99.9 %	115.4 %		
05.04.	23'56	4'08	19'48	3'05	12.9 %	1'55	9'08	14'48	58,294	3,939	355	0.6 %	0,95	7,287	6,923	2.98	8	0'14	74.7 %	164.1 %	99.4 %	121.9 %		
06.04.	8'01	0'20	7'41	1'23	17.3 %	1'53	3'36	4'25	14,249	3,226	24	0.2 %	0,71	3,562	2,515	3.04	4	0'28	57.5 %	134.4 %	99.8 %	77.1 %		
07.04.	23'57	2'02	21'55	4'26	18.5 %	3'07	9'35	14'22	50,050	3,484	62	0.1 %	0,78	4,550	3,539	2.99	11	0'17	65.6 %	145.2 %	99.9 %	95.0 %		
08.04.	24'00	8'11	15'49	1'48	7.5 %	1'12	11'11	12'49	55,161	4,304	22	0.0 %	0,88	7,880	6,914	2.74	7	0'10	81.0 %	179.3 %	100.0 %	145.3 %		
09.04.	23'57	1'00	22'57	3'17	13.7 %	2'40	6'57	17'00	67,382	3,964	64	0.1 %	0,77	5,615	4,325	2.66	12	0'13	74.1 %	165.2 %	99.9 %	122.2 %		
10.04.	23'55	1'00	22'55	3'48	15.9 %	2'32	7'20	16'35	61,457	3,706	140	0.2 %	0,66	5,121	3,369	3.45	12	0'13	72.4 %	154.4 %	99.8 %	111.5 %		
11.04.	23'57	1'01	22'56	4'53	20.4 %	3'14	9'08	14'49	50,667	3,420	103	0.2 %	0,86	4,606	3,965	3.94	11	0'18	64.6 %	142.5 %	99.8 %	91.9 %		
12.04.	23'56	0'59	22'57	3'27	14.4 %	1'50	6'16	17'40	69,029	3,907	61	0.1 %	1,16	7,670	8,861	3.00	9	0'12	77.0 %	162.8 %	99.9 %	125.2 %		
13.04.	8'01	0'20	7'41	1'20	16.6 %	0'42	2'22	5'39	22,217	3,932	12	0.1 %	0,97	7,406	7,156	3.53	3	0'14	73.5 %	163.8 %	99.9 %	120.4 %		
14.04.	24'00	10'16	13'44	2'52	11.9 %	2'41	15'49	8'11	24,560	3,001	140	0.6 %	0,69	3,070	2,130	2.56	8	0'20	59.6 %	125.1 %	99.4 %	74.1 %		
15.04.	23'59	1'03	22'56	4'19	18.0 %	2'24	7'46	16'13	57,696	3,558	46	0.1 %	0,88	7,212	6,357	2.44	8	0'18	70.7 %	148.2 %	99.9 %	104.7 %		
16.04.	23'59	0'40	23'19	4'54	20.4 %	2'01	7'35	16'24	55,748	3,399	51	0.1 %	0,90	5,575	5,017	2.74	10	0'12	70.3 %	141.6 %	99.9 %	99.5 %		
<b>Total</b>	<b>303'29</b>	<b>32'40</b>	<b>270'49</b>	<b>48'48</b>	<b>16.1 %</b>	<b>31'02</b>	<b>112'30</b>	<b>190'59</b>	<b>698,290</b>	<b>3,656</b>	<b>1,260</b>	<b>0.2 %</b>	<b>0.87</b>	<b>5,498</b>	<b>4,760</b>	<b>3.00</b>	<b>127</b>	<b>0'15</b>	<b>70.5 %</b>	<b>152.3 %</b>	<b>99.8 %</b>	<b>107.2 %</b>		
<b>Av.</b>	<b>21'40</b>	<b>2'20</b>	<b>19'20</b>	<b>3'29</b>		<b>2'13</b>	<b>8'02</b>	<b>13'38</b>	<b>49,878</b>		<b>90</b>							<b>9.1</b>						

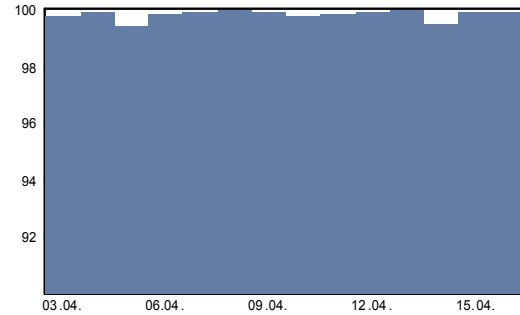
Availability (in %)



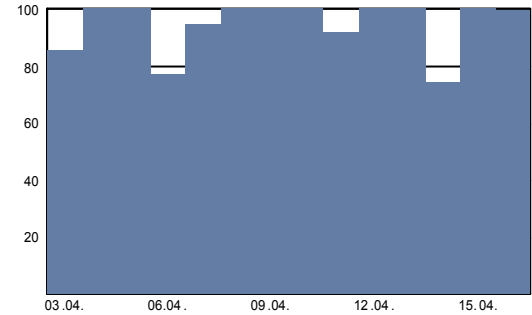
Performance (in %)



Quality (in %)



OEE (in %)

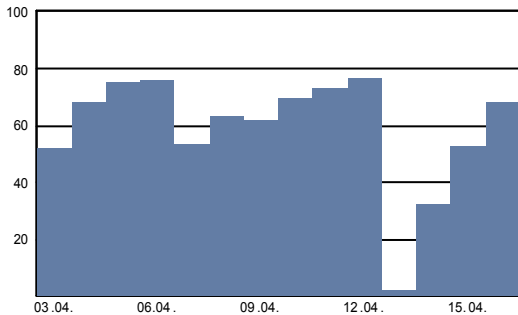


## 60 Coupeuse de rabats

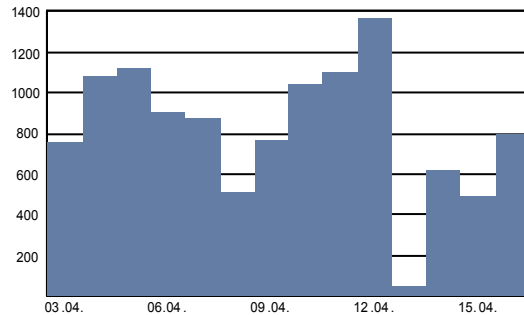
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Set-Up	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>				
	Hours	Breaks		Hours	%			Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality
03.04.	23'59	1'15	22'44	4'27	18.6 %	6'33	12'15	11'44	89,320	7,613	1,804	2.0 %	0,29	6,871	1,974	1.00	13	0'30	51.6 %	761.3 %	98.0 %	385.1 %
04.04.	23'58	0'44	23'14	4'43	19.7 %	2'41	8'08	15'50	171,200	10,813	2,848	1.6 %	0,09	28,533	2,677	1.00	6	0'27	68.1 %	081.3 %	98.4 %	724.8 %
05.04.	23'58	0'54	23'04	3'34	14.9 %	2'07	6'35	17'23	195,130	11,225	2,463	1.2 %	0,24	24,391	5,970	1.00	8	0'16	75.4 %	122.5 %	98.8 %	835.4 %
06.04.	14'08	0'36	13'32	2'16	16.0 %	1'00	3'52	10'16	92,500	9,010	2,081	2.2 %	0,25	30,833	7,559	1.00	3	0'20	75.9 %	901.0 %	97.8 %	668.5 %
07.04.	23'58	0'57	23'01	6'35	27.5 %	4'06	11'38	12'20	108,010	8,758	1,180	1.1 %	0,27	12,001	3,222	1.00	9	0'27	53.6 %	875.8 %	98.9 %	464.2 %
08.04.	23'58	3'01	20'57	3'53	16.2 %	3'51	10'45	13'13	67,440	5,103	1,115	1.6 %	0,35	11,240	3,936	1.00	6	0'39	63.1 %	510.3 %	98.4 %	316.7 %
09.04.	24'01	0'56	23'05	5'40	23.6 %	3'10	9'46	14'15	109,640	7,694	2,062	1.8 %	0,38	9,137	3,450	1.00	12	0'16	61.7 %	769.4 %	98.2 %	466.2 %
10.04.	23'55	0'58	22'57	4'14	17.7 %	2'49	8'01	15'54	165,630	10,417	2,484	1.5 %	0,20	18,403	3,737	1.00	9	0'19	69.3 %	041.7 %	98.5 %	711.0 %
11.04.	23'56	1'01	22'55	4'23	18.3 %	1'49	7'13	16'43	183,490	10,976	2,497	1.3 %	0,24	26,213	6,418	1.00	7	0'16	72.9 %	097.6 %	98.7 %	789.9 %
12.04.	21'57	0'53	21'04	2'43	12.4 %	2'12	5'48	16'09	220,817	13,673	865	0.4 %	0,23	24,535	5,556	1.00	9	0'15	76.7 %	367.3 %	99.6 %	1044.1 %
13.04.	7'55	0'41	7'14	4'10	52.6 %	2'54	7'45	0'10	80	480	339	80.9 %	0,39			1.00	0		2.3 %	48.0 %	19.1 %	0.2 %
14.04.	23'57	2'26	21'31	12'25	51.8 %	2'07	16'58	6'59	43,370	6,211	1,482	3.3 %	0,29	8,674	2,516	1.00	5	0'25	32.5 %	621.1 %	96.7 %	194.9 %
15.04.	23'59	1'00	22'59	5'07	21.3 %	5'46	11'53	12'06	59,020	4,878	1,859	3.1 %	0,34	8,431	2,888	1.00	7	0'49	52.6 %	487.8 %	96.9 %	249.0 %
16.04.	23'55	0'59	22'56	4'01	16.8 %	3'21	8'21	15'34	123,951	7,963	1,048	0.8 %	0,32	12,395	3,973	1.00	10	0'20	67.9 %	796.3 %	99.2 %	536.0 %
<b>Total</b>	<b>307'34</b>	<b>16'21</b>	<b>291'13</b>	<b>68'11</b>	<b>22.2 %</b>	<b>44'26</b>	<b>128'58</b>	<b>178'36</b>	<b>1,629,598</b>	<b>9,124</b>	<b>24,127</b>	<b>1.5 %</b>	<b>0.25</b>	<b>15,669</b>	<b>3,916</b>	<b>1.00</b>	<b>104</b>	<b>0'26</b>	<b>61.3 %</b>	<b>912.4 %</b>	<b>98.5 %</b>	<b>551.4 %</b>
<b>Av.</b>	<b>21'58</b>	<b>1'10</b>	<b>20'48</b>	<b>4'52</b>		<b>3'10</b>	<b>9'12</b>	<b>12'45</b>	<b>116,400</b>		<b>1,723</b>						<b>7.4</b>					

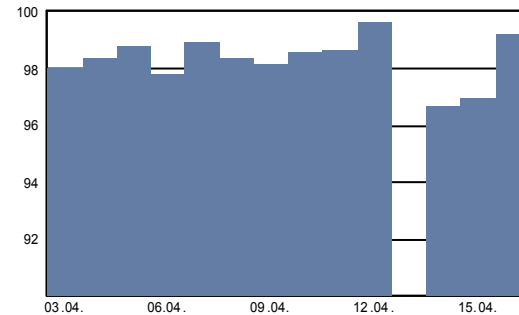
Availability (in %)



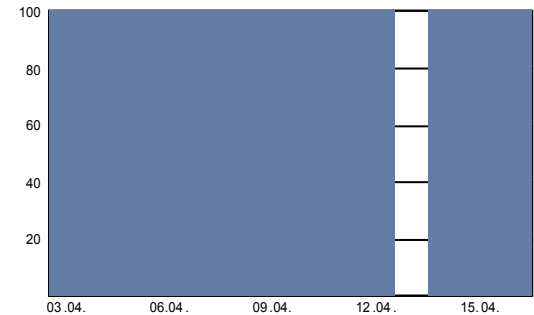
Performance (in %)



Quality (in %)



OEE (in %)

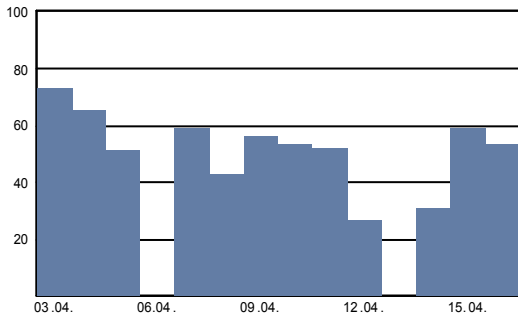


## 65 Piqueuse manuelle

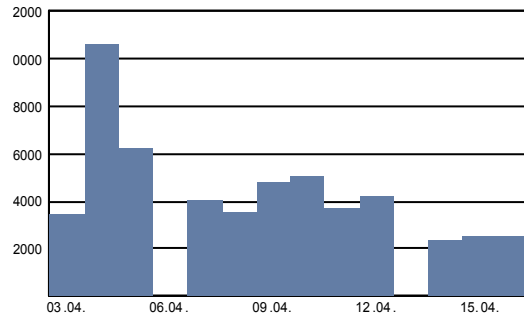
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Set-Up	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>				
	Hours	Breaks		Hours	Hours			%	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>
03.04.	18'06	2'35	15'31	3'20	18.4 %	0'52	6'47	11'19	97,802	8,642	752	0.8 %	0,76	48,901	36,954	1.00	2	0'26	72.9 %	456.9 %	99.2 %	2502.0 %
04.04.	12'15	6'47	5'28	1'13	9.9 %	0'40	8'40	3'35	94,666	26,418	282	0.3 %	0,23	94,666	21,555	1.00	1	0'40	65.5 %	567.4 %	99.7 %	3906.2 %
05.04.	7'59	1'38	6'21	1'24	17.5 %	1'43	4'45	3'14	50,486	15,614	227	0.4 %	0,19	50,486	9,786	1.00	1	1'43	50.9 %	245.7 %	99.6 %	3166.0 %
07.04.	16'13	5'51	10'22	2'26	15.0 %	1'50	10'07	6'06	61,315	10,052	388	0.6 %	0,24	12,263	2,959	1.00	5	0'22	58.8 %	020.7 %	99.4 %	2351.0 %
08.04.	16'08	2'50	13'18	4'42	29.1 %	2'53	10'25	5'43	50,938	8,910	557	1.1 %	0,24	6,367	1,504	1.00	8	0'22	43.0 %	564.2 %	98.9 %	1515.4 %
09.04.	16'04	2'51	13'13	5'00	31.1 %	0'46	8'37	7'27	89,034	11,951	933	1.0 %	0,28	22,259	6,138	1.00	4	0'12	56.4 %	780.3 %	99.0 %	2666.7 %
10.04.	16'10	12'41	3'29	1'16	7.8 %	0'22	14'19	1'51	23,493	12,699	111	0.5 %	0,30	11,747	3,497	1.00	2	0'11	53.1 %	079.6 %	99.5 %	2685.1 %
11.04.	16'07	4'28	11'39	4'33	28.2 %	1'04	10'05	6'02	56,565	9,375	810	1.4 %	0,36	28,283	10,222	1.00	2	0'32	51.8 %	750.2 %	98.6 %	1914.7 %
12.04.	8'06	3'45	4'21	2'05	25.7 %	1'06	6'56	1'10	12,270	10,517	278	2.2 %	0,57			1.00	0		26.8 %	206.9 %	97.8 %	1103.3 %
14.04.	16'16	12'37	3'39	2'10	13.3 %	0'21	15'08	1'08	6,650	5,868	142	2.1 %	0,57	3,325	1,884	1.00	2	0'11	31.1 %	347.1 %	97.9 %	713.5 %
15.04.	16'05	2'13	13'52	4'13	26.2 %	1'29	7'55	8'10	51,966	6,363	262	0.5 %	0,29	17,322	5,003	1.00	3	0'30	58.9 %	545.3 %	99.5 %	1491.5 %
16.04.	16'04	3'12	12'52	3'45	23.3 %	2'14	9'11	6'53	43,814	6,365	336	0.8 %	0,30	10,954	3,304	1.00	4	0'34	53.5 %	546.1 %	99.2 %	1351.7 %
<b>Total</b>	<b>175'33</b>	<b>61'28</b>	<b>114'05</b>	<b>36'07</b>	<b>20.6 %</b>	<b>15'20</b>	<b>112'55</b>	<b>62'38</b>	<b>638,999</b>	<b>10,202</b>	<b>5,078</b>	<b>0.8 %</b>	<b>0.35</b>	<b>18,794</b>	<b>6,561</b>	<b>1.00</b>	<b>34</b>	<b>0'27</b>	<b>54.9 %</b>	<b>1080.9 %</b>	<b>99.2 %</b>	<b>2222.8 %</b>
<b>Av.</b>	<b>14'37</b>	<b>5'07</b>	<b>9'30</b>	<b>3'00</b>		<b>1'16</b>	<b>9'24</b>	<b>5'13</b>	<b>53,250</b>		<b>423</b>						<b>2.8</b>					

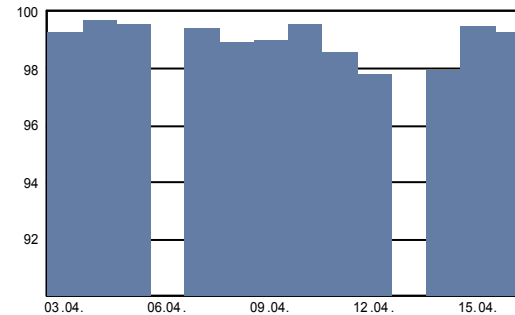
Availability (in %)



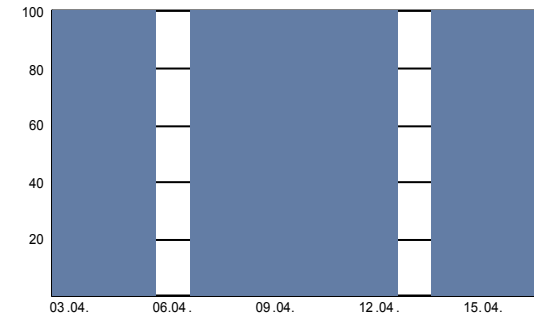
Performance (in %)



Quality (in %)



OEE (in %)

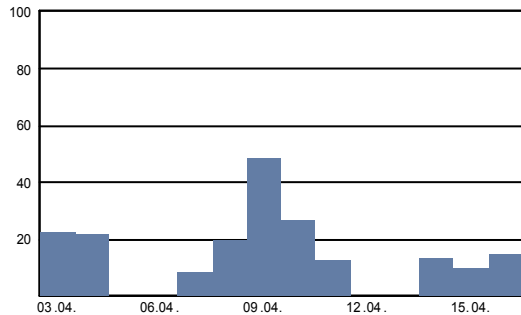


## 81 Mitrailleuse

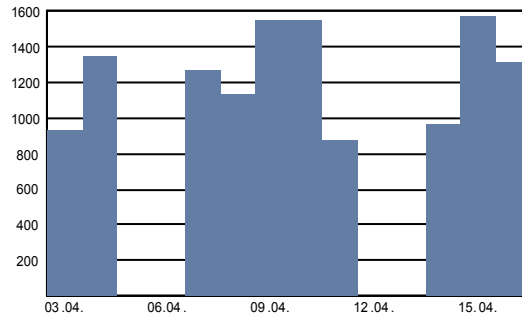
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped		Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks		Hours	Hours	%	Set-Up Hours		Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality
03.04.	24'02	0'20	23'42	16'03	66.8 %	2'22	18'45	5'17	24,692	4,674	1,525	5.8 %	0,68	4,938	3,367	1.00	5	0'28	22.3 %	934.7 %	94.2 %	196.3 %
04.04.	12'28	0'00	12'28	5'30	44.1 %	4'13	9'43	2'45	18,499	6,727	1,101	5.6 %	0,71	9,250	6,548	1.00	2	2'07	22.1 %	345.4 %	94.4 %	280.1 %
07.04.	24'15	0'17	23'58	17'24	71.8 %	4'29	22'10	2'05	13,224	6,348	1,028	7.2 %	0,67	2,645	1,777	1.00	5	0'54	8.7 %	269.5 %	92.8 %	102.4 %
08.04.	24'04	0'00	24'04	14'28	60.1 %	4'51	19'19	4'45	27,005	5,685	1,150	4.1 %	0,70	5,401	3,797	1.00	5	0'58	19.7 %	137.1 %	95.9 %	215.3 %
09.04.	24'01	0'00	24'01	8'32	35.5 %	3'52	12'24	11'37	90,092	7,755	1,634	1.8 %	0,57	30,031	17,004	1.00	3	1'17	48.4 %	551.1 %	98.2 %	736.9 %
10.04.	24'00	0'00	24'00	10'43	44.7 %	6'54	17'37	6'23	49,420	7,742	1,588	3.1 %	0,66	12,355	8,189	1.00	4	1'44	26.6 %	548.4 %	96.9 %	399.0 %
11.04.	24'05	4'57	19'08	10'33	43.8 %	6'07	21'37	2'28	10,800	4,378	950	8.1 %	0,73	3,600	2,630	1.00	3	2'02	12.9 %	875.7 %	91.9 %	103.8 %
14.04.	10'50	0'00	10'50	8'57	82.6 %	0'26	9'23	1'27	6,981	4,814	950	12.0 %	0,54	2,327	1,258	1.00	3	0'09	13.4 %	962.9 %	88.0 %	113.4 %
15.04.	9'55	0'00	9'55	6'50	68.9 %	2'07	8'57	0'58	7,571	7,832	679	8.2 %	0,78	3,786	2,968	1.00	2	1'04	9.7 %	566.4 %	91.8 %	140.1 %
16.04.	24'02	0'00	24'02	17'10	71.4 %	3'17	20'27	3'35	23,575	6,579	260	1.1 %	0,97	11,788	11,439	1.00	2	1'39	14.9 %	315.8 %	98.9 %	194.0 %
<b>Total</b>	<b>201'42</b>	<b>5'34</b>	<b>196'08</b>	<b>116'10</b>	<b>57.6 %</b>	<b>38'38</b>	<b>160'22</b>	<b>41'20</b>	<b>271,859</b>	<b>6,577</b>	<b>10,865</b>	<b>3.8 %</b>	<b>0.67</b>	<b>7,996</b>	<b>5,354</b>	<b>1.00</b>	<b>34</b>	<b>1'08</b>	<b>21.1 %</b>	<b>1315.4 %</b>	<b>96.2 %</b>	<b>266.6 %</b>
<b>Av.</b>	<b>20'10</b>	<b>0'33</b>	<b>19'36</b>	<b>11'37</b>		<b>3'51</b>	<b>16'02</b>	<b>4'08</b>	<b>27,186</b>		<b>1,087</b>						<b>3.4</b>					

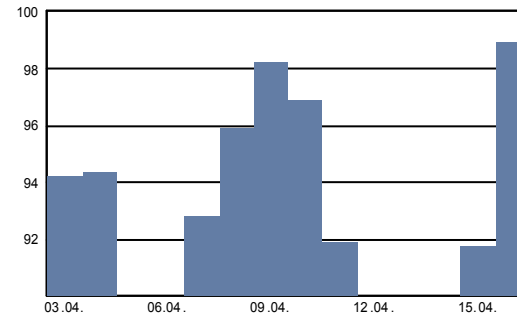
Availability (in %)



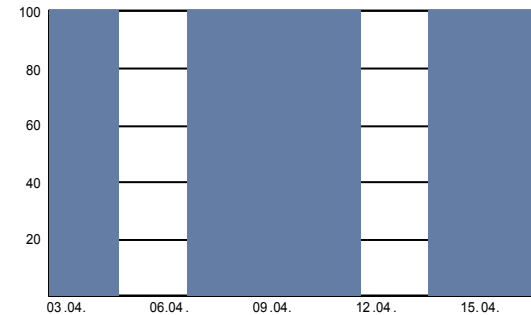
Performance (in %)



Quality (in %)



OEE (in %)

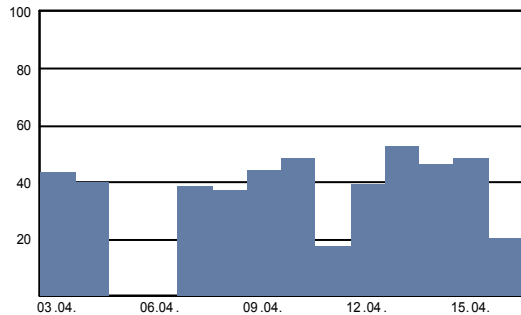


## 88 Roda 1

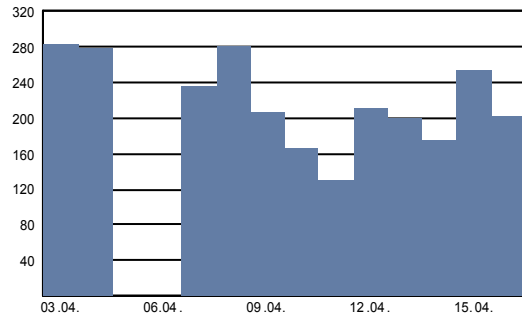
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Set-Up	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>				
	Hours	Breaks		Hours	Hours			%	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>
03.04.	24'02	1'48	22'14	11'49	49.2 %	0'47	14'24	9'38	38,043	3,949	89	0.2 %	0,58	12,681	7,399	1.00	3	0'16	43.3 %	282.1 %	99.8 %	121.9 %
04.04.	23'58	1'20	22'38	12'58	54.1 %	0'40	14'58	9'00	35,062	3,896	77	0.2 %	0,71	7,012	4,964	1.00	5	0'08	39.8 %	278.3 %	99.8 %	110.4 %
07.04.	24'00	6'25	17'35	9'17	38.7 %	1'30	17'12	6'48	22,393	3,293	77	0.3 %	0,66	3,199	2,125	1.00	7	0'13	38.7 %	235.2 %	99.7 %	90.7 %
08.04.	24'00	8'07	15'53	9'26	39.3 %	0'34	18'07	5'53	23,199	3,943	52	0.2 %	0,67	3,867	2,575	1.00	6	0'06	37.0 %	281.7 %	99.8 %	104.1 %
09.04.	24'00	1'00	23'00	12'37	52.6 %	0'16	13'53	10'07	29,390	2,905	56	0.2 %	0,54	29,390	15,944	1.00	1	0'16	44.0 %	207.5 %	99.8 %	91.1 %
10.04.	24'00	1'24	22'36	11'24	47.5 %	0'14	13'02	10'58	25,578	2,332	108	0.4 %	0,56	25,578	14,273	1.00	1	0'14	48.5 %	166.6 %	99.6 %	80.5 %
11.04.	23'55	3'08	20'47	16'14	67.9 %	0'52	20'14	3'41	6,680	1,814	248	3.6 %	0,79	3,340	2,648	1.00	2	0'26	17.7 %	129.5 %	96.4 %	22.1 %
12.04.	15'59	0'40	15'19	8'51	55.4 %	0'24	9'55	6'04	17,980	2,964	187	1.0 %	0,57	8,990	5,140	1.00	2	0'12	39.6 %	211.7 %	99.0 %	83.0 %
13.04.	16'01	1'46	14'15	6'44	42.0 %	0'00	8'30	7'31	20,950	2,787	59	0.3 %	0,57	10,475	5,941	1.00	2	0'00	52.7 %	199.1 %	99.7 %	104.7 %
14.04.	23'59	8'39	15'20	7'52	32.8 %	0'19	16'50	7'09	17,460	2,442	93	0.5 %	0,84	5,820	4,905	1.00	3	0'06	46.6 %	174.4 %	99.5 %	80.9 %
15.04.	24'01	2'19	21'42	9'48	40.8 %	1'26	13'33	10'28	37,245	3,558	123	0.3 %	0,58	7,449	4,354	1.00	5	0'17	48.2 %	254.2 %	99.7 %	122.2 %
16.04.	24'00	2'13	21'47	12'57	54.0 %	4'24	19'34	4'26	12,606	2,843	83	0.7 %	0,90	2,101	1,901	1.00	6	0'44	20.4 %	203.1 %	99.3 %	41.1 %
<b>Total</b>	<b>271'55</b>	<b>38'49</b>	<b>233'06</b>	<b>129'57</b>	<b>47.8 %</b>	<b>11'26</b>	<b>180'12</b>	<b>91'43</b>	<b>286,586</b>	<b>3,125</b>	<b>1,252</b>	<b>0.4 %</b>	<b>0.64</b>	<b>6,665</b>	<b>4,254</b>	<b>1.00</b>	<b>43</b>	<b>0'16</b>	<b>39.3 %</b>	<b>223.2 %</b>	<b>99.6 %</b>	<b>87.4 %</b>
<b>Av.</b>	<b>22'39</b>	<b>3'14</b>	<b>19'25</b>	<b>10'49</b>		<b>0'57</b>	<b>15'01</b>	<b>7'38</b>	<b>23,882</b>		<b>104</b>						<b>3.6</b>					

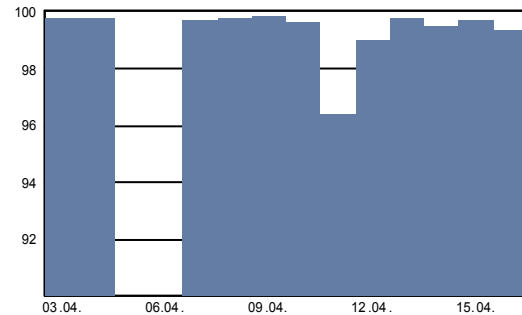
Availability (in %)



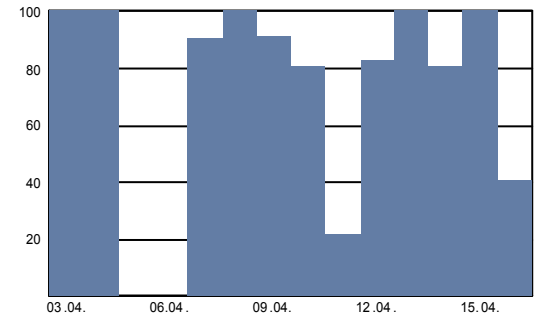
Performance (in %)



Quality (in %)



OEE (in %)

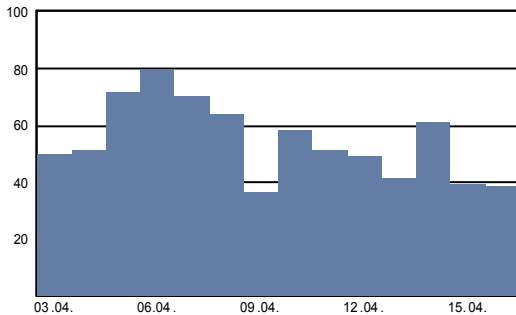


## 89 Roda 2

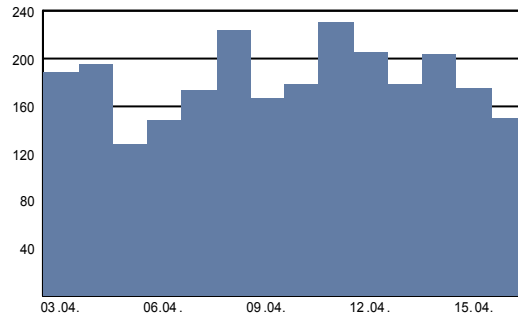
03.04.1989 - 16.04.1989

Date	Open		Work Hours	Downtimes		Stopped Hours	Run Hours	Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>				
	Hours	Breaks		Hours	Hours			%	Set-Up	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability
03.04.	23'58	1'00	22'58	6'45	28.2 %	4'45	12'30	11'28	30,360	2,648	80	0.3 %	0,64	7,590	4,889	3.08	4	1'11	49.9 %	189.1 %	99.7 %	94.2 %
04.04.	24'00	0'40	23'20	4'15	17.7 %	7'05	12'00	12'00	32,713	2,726	47	0.1 %	0,57	5,452	3,134	2.09	6	1'11	51.4 %	194.7 %	99.9 %	100.0 %
05.04.	24'00	1'00	23'00	2'55	12.2 %	3'37	7'32	16'28	29,633	1,800	49	0.2 %	0,77	7,408	5,713	2.31	4	0'54	71.6 %	128.5 %	99.8 %	91.9 %
06.04.	15'00	0'20	14'40	1'28	9.8 %	1'35	3'23	11'37	24,220	2,085	11	0.0 %	0,78	4,844	3,763	3.06	5	0'19	79.2 %	148.9 %	100.0 %	117.9 %
07.04.	24'00	0'40	23'20	4'43	19.7 %	2'12	7'35	16'25	40,025	2,438	45	0.1 %	0,65	13,342	8,653	2.05	3	0'44	70.4 %	174.1 %	99.9 %	122.4 %
08.04.	23'59	1'09	22'50	7'15	30.2 %	1'03	9'27	14'32	45,423	3,125	62	0.1 %	0,49	22,712	11,140	1.06	2	0'32	63.6 %	223.2 %	99.9 %	141.9 %
09.04.	24'00	1'00	23'00	9'12	38.3 %	5'25	15'37	8'23	19,520	2,328	38	0.2 %	0,72	3,904	2,799	1.95	5	1'05	36.4 %	166.3 %	99.8 %	60.5 %
10.04.	24'00	1'00	23'00	6'11	25.8 %	3'27	10'38	13'22	33,432	2,501	33	0.1 %	0,65	5,572	3,634	7.53	6	0'35	58.1 %	178.7 %	99.9 %	103.7 %
11.04.	24'00	0'39	23'21	9'58	41.5 %	1'21	11'58	12'02	38,921	3,234	53	0.1 %	0,54	38,921	20,883	1.00	1	1'21	51.5 %	231.0 %	99.9 %	118.9 %
12.04.	16'00	0'40	15'20	4'44	29.6 %	3'01	8'25	7'35	21,870	2,884	26	0.1 %	0,65	10,935	7,058	1.41	2	1'31	49.5 %	206.0 %	99.9 %	101.8 %
13.04.	16'02	0'40	15'22	6'28	40.3 %	2'35	9'43	6'19	15,731	2,490	17	0.1 %	0,63	5,244	3,319	1.63	3	0'52	41.1 %	177.9 %	99.9 %	73.0 %
14.04.	24'00	1'00	23'00	8'42	36.3 %	0'20	10'02	13'58	39,860	2,854	80	0.2 %	0,56	13,287	7,378	1.00	3	0'07	60.7 %	203.9 %	99.8 %	123.5 %
15.04.	24'03	1'00	23'03	8'20	34.7 %	5'41	15'01	9'02	22,219	2,460	51	0.2 %	0,81	3,703	2,982	5.24	6	0'57	39.2 %	175.7 %	99.8 %	68.7 %
16.04.	23'57	0'58	22'59	7'05	29.6 %	7'05	15'08	8'49	18,440	2,091	270	1.4 %	0,71	2,634	1,861	3.54	7	1'01	38.4 %	149.4 %	98.6 %	56.5 %
<b>Total</b>	<b>310'59</b>	<b>11'46</b>	<b>299'13</b>	<b>88'01</b>	<b>28.3 %</b>	<b>49'12</b>	<b>148'59</b>	<b>162'00</b>	<b>412,367</b>	<b>2,545</b>	<b>862</b>	<b>0.2 %</b>	<b>0.64</b>	<b>7,235</b>	<b>4,598</b>	<b>2.53</b>	<b>57</b>	<b>0'52</b>	<b>54.1 %</b>	<b>181.8 %</b>	<b>99.8 %</b>	<b>98.2 %</b>
<b>Av.</b>	<b>22'12</b>	<b>0'50</b>	<b>21'22</b>	<b>6'17</b>		<b>3'30</b>	<b>10'38</b>	<b>11'34</b>	<b>29,455</b>		<b>62</b>						<b>4.1</b>					

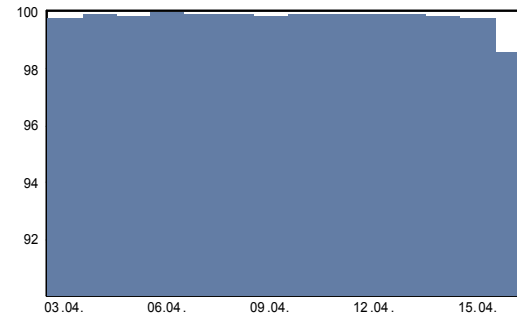
Availability (in %)



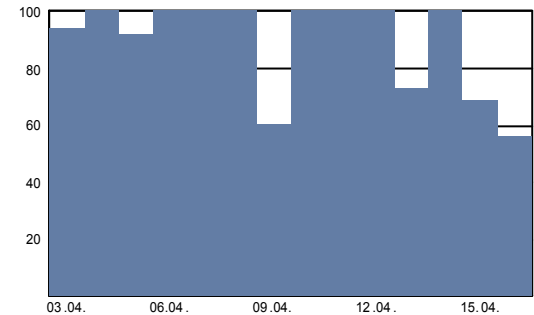
Performance (in %)



Quality (in %)



OEE (in %)

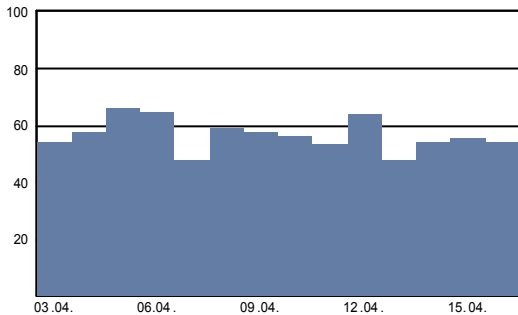


All Machines (by Date)

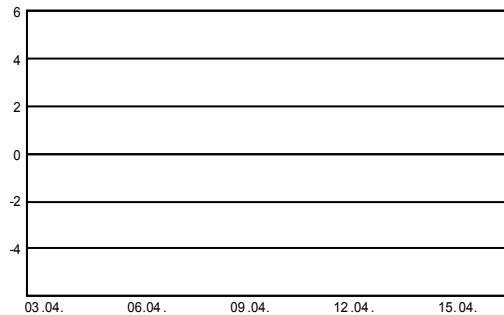
03.04.1989 - 16.04.1989

Date	Open		Work		Downtimes		Stopped		Run		Production <sup>2</sup>		Waste		Ø Order Size			Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks	Hours	Hours	%	Set-Up	Hours	Hours	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality
03.04.	249'46	26'27	223'19	67'34	27.1 %	35'35	129'36	120'10		682,302	5,678	6,822	1.0 %	0,71	6,962	4,950	1.36	98	0'22	53.8 %		99.0 %	
04.04.	234'23	13'55	220'28	54'22	23.2 %	38'34	106'51	127'32		816,898	6,405	8,130	1.0 %	0,57	6,982	3,984	1.45	117	0'20	57.8 %		99.0 %	
05.04.	135'46	10'50	124'56	22'48	16.8 %	20'08	53'46	82'00		471,237	5,747	4,698	1.0 %	0,58	8,727	5,046	1.46	54	0'22	65.6 %		99.0 %	
06.04.	68'05	2'22	65'43	12'29	18.3 %	11'01	25'52	42'13		203,831	4,828	2,847	1.4 %	0,64	7,549	4,846	1.41	27	0'24	64.2 %		98.6 %	
07.04.	252'09	30'58	221'11	77'50	30.9 %	37'32	146'20	105'49		605,340	5,721	5,970	1.0 %	0,62	5,554	3,435	1.32	109	0'21	47.8 %		99.0 %	
08.04.	247'55	27'32	220'23	57'34	23.2 %	32'54	118'00	129'55		775,335	5,968	5,401	0.7 %	0,71	7,677	5,425	1.41	101	0'20	59.0 %		99.3 %	
09.04.	256'00	23'17	232'43	63'52	24.9 %	34'23	121'32	134'28		826,383	6,146	8,185	1.0 %	0,65	7,513	4,909	1.23	110	0'19	57.8 %		99.0 %	
10.04.	255'35	37'09	218'26	58'44	23.0 %	36'35	132'28	123'07		735,739	5,976	9,757	1.3 %	0,57	7,664	4,338	1.64	96	0'23	56.4 %		98.7 %	
11.04.	255'49	22'38	233'11	74'28	29.1 %	34'41	131'47	124'02		831,130	6,701	10,085	1.2 %	0,56	9,133	5,136	1.31	91	0'23	53.2 %		98.8 %	
12.04.	155'02	16'27	138'35	31'44	20.5 %	17'54	66'05	88'57		668,993	7,521	3,174	0.5 %	0,62	11,946	7,372	1.27	56	0'19	64.2 %		99.5 %	
13.04.	79'53	11'09	68'44	25'56	32.5 %	10'09	47'14	32'39		134,643	4,124	1,252	0.9 %	0,89	6,412	5,730	1.50	21	0'29	47.5 %		99.1 %	
14.04.	234'53	54'57	179'56	59'57	25.5 %	22'43	137'37	97'16		518,086	5,326	5,124	1.0 %	0,76	6,168	4,679	1.09	84	0'16	54.1 %		99.0 %	
15.04.	234'00	20'21	213'39	57'14	24.5 %	37'38	115'13	118'47		565,180	4,758	5,575	1.0 %	0,76	6,649	5,050	1.53	85	0'27	55.6 %		99.0 %	
16.04.	247'48	18'45	229'03	67'40	27.3 %	38'09	124'34	123'14		740,983	6,013	4,912	0.7 %	0,65	7,336	4,742	1.44	101	0'23	53.8 %		99.3 %	
<b>Total</b>	<b>2907'04</b>	<b>316'47</b>	<b>2590'17</b>	<b>732'12</b>	<b>25.2 %</b>	<b>407'56</b>	<b>1456'55</b>	<b>1450'09</b>		<b>8,576,080</b>	<b>5,914</b>	<b>81,932</b>	<b>0.9 %</b>	<b>0.65</b>	<b>7,457</b>	<b>4,813</b>	<b>1.38</b>	<b>1150</b>	<b>0'21</b>	<b>56.0 %</b>		<b>99.1 %</b>	
<b>Av.</b>	<b>207'38</b>	<b>22'37</b>	<b>185'01</b>	<b>52'18</b>		<b>29'08</b>	<b>104'03</b>	<b>103'34</b>		<b>612,577</b>		<b>5,852</b>							<b>82.1</b>				

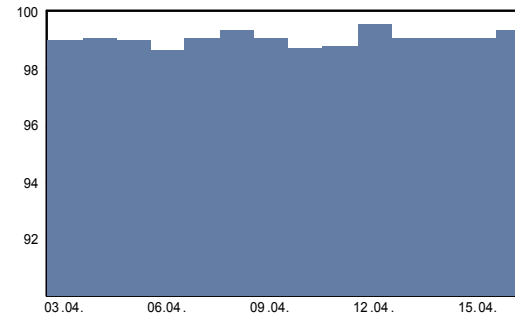
Availability (in %)



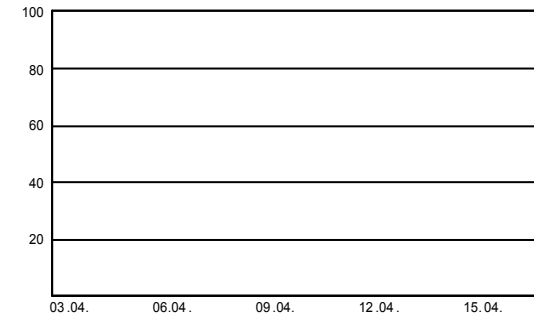
Performance (in %)



Quality (in %)



OEE (in %)

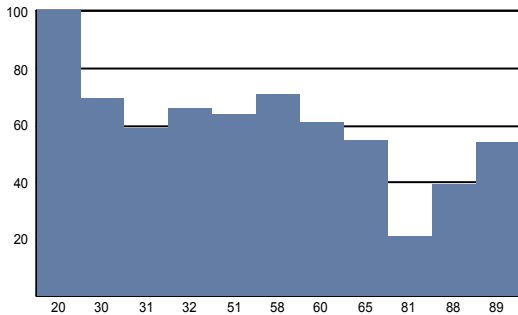


All Machines (by Machine)

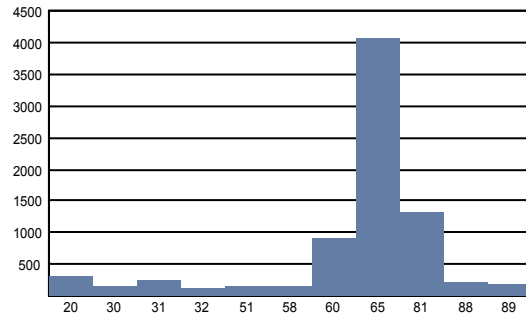
03.04.1989 - 16.04.1989

Mach.	Open		Work		Downtimes		Stopped		Run		Production <sup>2</sup>		Waste		Ø Order Size				Set-Up		OEE (Overall Equipment Efficiency) <sup>1</sup>			
	Hours	Breaks	Hours	Hours	Hours	%	Set-Up	Hours	Hours	Hours	Sheets	sht / h	Sheets	%	m <sup>2</sup> / sht.	Sheets	m <sup>2</sup>	No. Out	No.	Ø h	Availability	Performance <sup>3</sup>	Quality	OEE
20	285'01	18'25	266'36	69'13	24.3 %	66'13	153'51	131'10	603,877	4,604	8,109	1.3 %	1,50	4,610	6,913	1.00	131	0'30	49.2 %	328.8 %	98.7 %	159.6 %		
30	281'34	18'36	262'58	40'46	14.5 %	40'14	99'36	181'58	1,653,899	9,089	9,342	0.6 %	0,58	7,008	4,084	1.00	236	0'10	69.2 %	151.5 %	99.4 %	104.2 %		
31	276'08	28'57	247'11	38'47	14.0 %	62'51	130'35	145'33	881,772	6,058	11,767	1.3 %	0,95	5,652	5,343	1.06	156	0'24	58.9 %	263.4 %	98.7 %	153.1 %		
32	205'25	15'15	190'10	37'18	18.2 %	28'02	80'35	124'50	1,033,810	8,282	8,098	0.8 %	0,61	7,033	4,323	1.00	147	0'11	65.6 %	138.0 %	99.2 %	89.9 %		
51	287'44	68'56	218'48	58'54	20.5 %	20'32	148'22	139'22	465,022	3,337	1,173	0.3 %	0,72	5,741	4,132	3.59	81	0'15	63.7 %	163.6 %	99.7 %	103.9 %		
58	303'29	32'40	270'49	48'48	16.1 %	31'02	112'30	190'59	698,287	3,656	1,263	0.2 %	0,87	5,498	4,760	3.00	127	0'15	70.5 %	152.3 %	99.8 %	107.2 %		
60	307'34	16'21	291'13	68'11	22.2 %	44'26	128'58	178'36	1,629,598	9,124	24,127	1.5 %	0,25	15,669	3,916	1.00	104	0'26	61.3 %	912.4 %	98.5 %	551.4 %		
65	175'33	61'28	114'05	36'07	20.6 %	15'20	112'55	62'38	638,999	10,202	5,078	0.8 %	0,35	18,794	6,561	1.00	34	0'27	54.9 %	080.9 %	99.2 %	2222.8 %		
81	201'42	5'34	196'08	116'10	57.6 %	38'38	160'22	41'20	271,859	6,577	10,865	3.8 %	0,67	7,996	5,354	1.00	34	1'08	21.1 %	315.4 %	96.2 %	266.6 %		
88	271'55	38'49	233'06	129'57	47.8 %	11'26	180'12	91'43	286,586	3,125	1,252	0.4 %	0,64	6,665	4,254	1.00	43	0'16	39.3 %	223.2 %	99.6 %	87.4 %		
89	310'59	11'46	299'13	88'01	28.3 %	49'12	148'59	162'00	412,367	2,545	862	0.2 %	0,64	7,235	4,598	2.53	57	0'52	54.1 %	181.8 %	99.8 %	98.2 %		
<b>Total</b>	<b>2907'04</b>	<b>316'47</b>	<b>2590'17</b>	<b>732'12</b>	<b>25.2 %</b>	<b>407'56</b>	<b>1456'55</b>	<b>1450'09</b>	<b>8,576,076</b>	<b>5,914</b>	<b>81,936</b>	<b>0.9 %</b>	<b>0.65</b>	<b>7,457</b>	<b>4,813</b>	<b>1.38</b>	<b>1150</b>	<b>0'21</b>	<b>56.0 %</b>	<b>422.4 %</b>	<b>99.1 %</b>	<b>234.3 %</b>		
<b>Av.</b>	<b>264'16</b>	<b>28'47</b>	<b>235'28</b>	<b>66'33</b>		<b>37'05</b>	<b>132'26</b>	<b>131'49</b>	<b>779,643</b>		<b>7,449</b>						<b>104.5</b>							

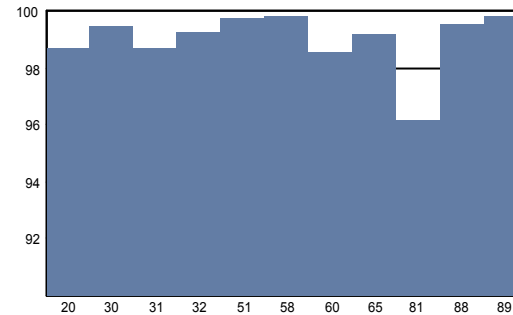
Availability (in %)



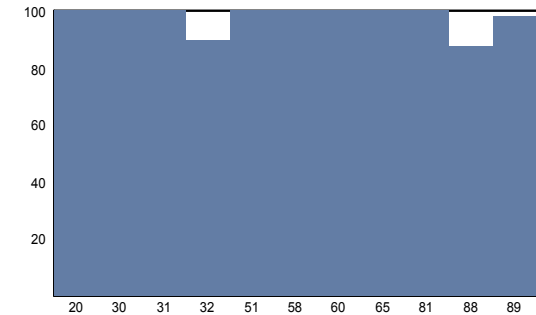
Performance (in %)



Quality (in %)



OEE (in %)



## Note

- <sup>1</sup> **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.

<sup>2</sup> Production and production speed are given in passes.

<sup>3</sup> The performance of the machine is calculated using the target capacity. If the target capacity is not given, the Performance column stays empty. In this case please enter a target capacity in the machine settings for the machine in question.

## 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](http://www.oee.com/oee_factors.html))