



# OEE Report Template

9 Jun 2023 / Vertical Milling Machine / Rosa Shelly

**Complete**

|       |               |               |          |         |          |
|-------|---------------|---------------|----------|---------|----------|
| Score | <b>46.67%</b> | Flagged items | <b>8</b> | Actions | <b>0</b> |
|-------|---------------|---------------|----------|---------|----------|

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**Site conducted**

Sydney

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**Company**

Primo Manufacturing Co.

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**Manufacturing Facility**

4245 Jessie St., Coltington OH  
43085

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**Equipment/Production Process**

Vertical Milling Machine

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**Machine Operator**

Rosa Shelly

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**Conducted on**

09.06.2023 14:41 PST

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**Flagged items**

8 flagged

OEE Report Template / Unplanned Downtime

**Were there equipment breakdowns/failures?**

Yes



Photo 1

OEE Report Template / Unplanned Downtime

**Were unplanned repairs made?**

Yes



Photo 2



Photo 3

OEE Report Template / Planned Downtime

**Was the equipment set up too long?**

Yes

53 minutes longer than usual

OEE Report Template / Planned Downtime

**Did the changeovers take too long?**

Yes

The next production run was on hold for an hour and 24 minutes



Photo 4

OEE Report Template / Slow Cycles

**Was there a lack of maintenance?**

Yes

OEE Report Template / Slow Cycles

**Was there wear and tear on the equipment?**

Yes



Photo 5



Photo 6



Photo 7

OEE Report Template / Production Rejects

**Were there products that had to be reworked to be usable?**

Yes

OEE Report Template / Start-up Rejects

**Were there start-up losses during ramp up of production?**

Yes



Photo 8

## Unplanned Downtime

2 flagged, 50%

Were there equipment breakdowns/failures?

Yes



Photo 1

Were unplanned repairs made?

Yes



Photo 2



Photo 3

Was there a lack of material?

No

Was there a lack of transport for completed goods?

No

## Planned Downtime

2 flagged, 33.33%

Was the equipment set up too long?

Yes

53 minutes longer than usual

Did the changeovers take too long?

Yes

The next production run was on hold for an hour and 24 minutes



Photo 4

Was the operator frequently absent? (e.g. breaks, comfort room time, etc.)

No

## Small Stops

100%

Was there minor idling?

No

Was an incorrect operation done on the equipment?

No

The operator is experienced and properly trained

## Slow Cycles

2 flagged, 33.33%

Was there a lack of maintenance?

Yes

Was there wear and tear on the equipment?

Yes



Photo 5



Photo 6



Photo 7

Were wrong settings applied to the equipment? (e.g. set speed slower than possible)

No

## Production Rejects

1 flagged, 50%

Were there products that cannot be salvaged at all?

No

Were there products that had to be reworked to be usable?

Yes

## Start-up Rejects

1 flagged, 0%

Were there start-up losses during ramp up of production?

Yes



Photo 8

## Completion

### Additional Observations

46.67% OEE is below industry standard. Let's keep on using iAuditor for our maintenance checks and quality assurance inspections to increase our overall equipment effectiveness.

### Machine Operator Name & Signature

Rosa Shelly  
09.06.2023 14:49 PST

### Quality Manager Name & Signature

Frank Gene

A handwritten signature in black ink, appearing to be 'John Doe', located in the top left corner of the page.

09.06.2023 14:49 PST

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## Media summary



Photo 1



Photo 2



Photo 3



Photo 4



Photo 5



Photo 6



Photo 7



Photo 8