|  |  |  |
| --- | --- | --- |
| **Components** | **Data** | **Comments** |
| Total available time | 24 hours | 24 hours in one day |
| Idle time | 8 hours  | Not required eight hours per day |
| **Scheduled downtime** |  |  |
| No production, breaks, shift change, etc.  | 0.66 hours | Meeting & shift change |
| Planned maintenance | 1.00 hours | Monthly PM |
| Total scheduled downtime | 1.66 hours |  |
| **Unscheduled downtime** |  |  |
| Waiting for operator | 0.46 hours | Operator distracted, on other tasks |
| Failure or breakdowns | 0.33 hours | Mechanical drive coupling |
| Set-ups & changeover | 0.26 hours  | Two size changes  |
| Tooling or part changes  | 0.23 hours  | Screw station bits  |
| Startup & adjustment | 0.30 hours | First shift Monday |
| Input material flow | 0.50 hours | Waiting for raw materials  |
| Total unscheduled downtime | 2.08 hours |  |
| Total downtime (scheduled + unscheduled) | 3.74 hours | 1.66 + 2.08=3.74 hours |
| Uptime | 12.26 hours | (24-8)-3.74=12.26 hours |
| **Availability** | **76.63%** | **12.26/(24-8)x100=76.63%** |
| **Performance efficiency losses** | **(Count)** |  |
| Minor stops | 10 events | Machine jams |
| Reduced speed or cycle time | 100 v.167 units | Design rate: 12.5 units/hour |
| **Performance efficiency**  | **59.88%** | **(100/167)x100=59.88%** |
| **Quality & yield losses**  | **(Count)** |  |
| Scrap product/output | 2 | Waste, non-salvageable |
| Defects, rework | 1 |  |
| Yield/transition | 5 | Startup & adjustment related |
| Rejected units produced | 8 | 2 + 1+ 5=8 |
| Good units produced | 92 | 100-8=92 good units |
| **Quality rate** | **92%** | **(92/100) x 100=92%** |
| **Overall equipment effectiveness** | **42.21%** | **76.63 x 59.88 x92.00=42.21%** |