Introducing OEE+3

Part of the manu-Fact Suite from

What is OEE and Why is it Important?

OEE is the Overall Equipment Effectiveness on a manufacturing or packing line at a plant.

OEE is the *Gold Standard* of measurement in the industry.

OEE consists of three important measurements.

Overall Equipment Effectiveness

1) Availability: affected by unplanned stops

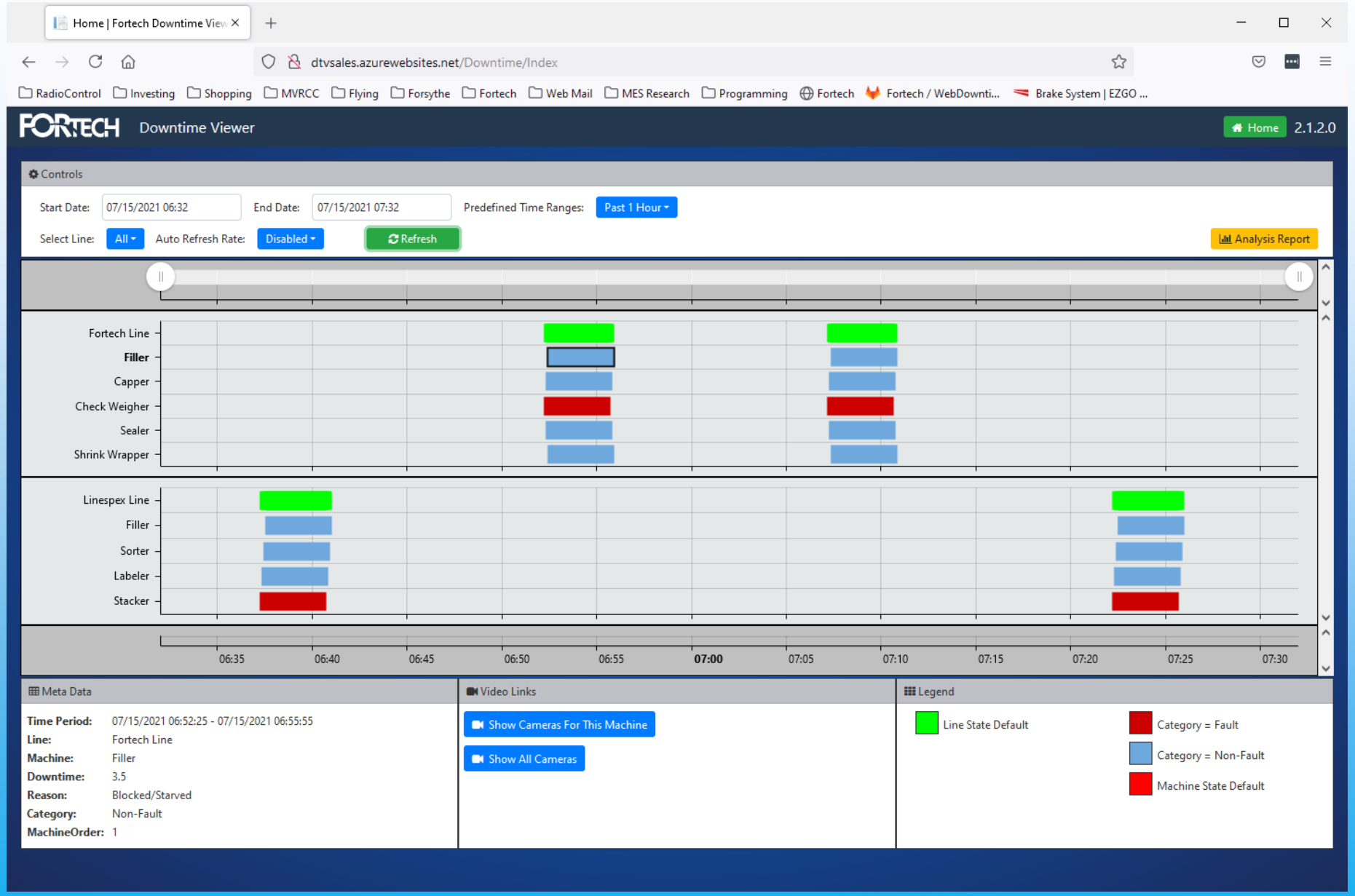
2) Performance: affected by running at a *rate* lower than your target

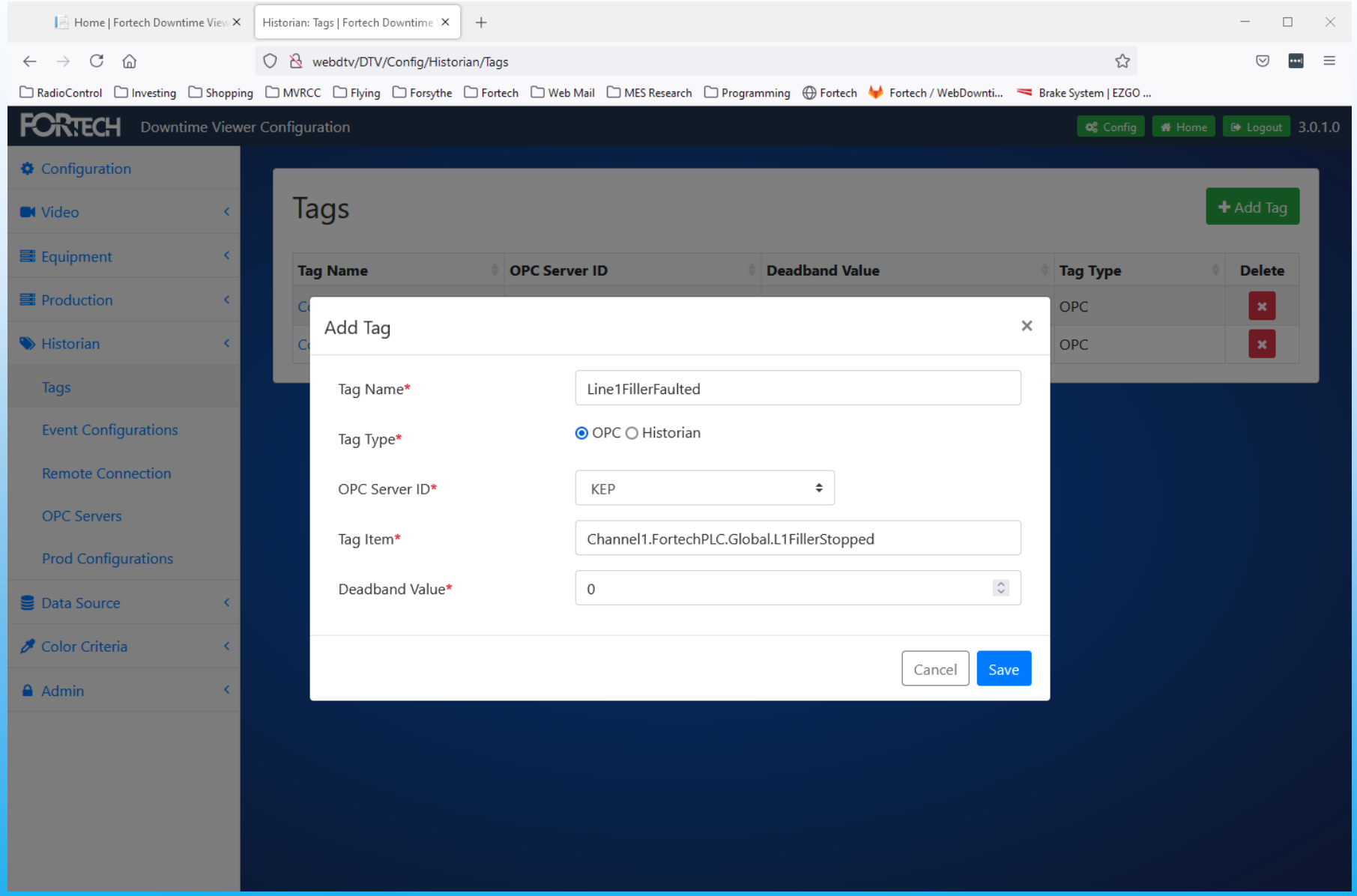
3) Quality: affected by producing bad product

Overall Equipment Effectiveness

When You Multiply Availability x Performance x Quality
a true equipment effectiveness calculation can be developed.

Easy-to-use graphical interface shows unplanned stops for all lines and equipment.



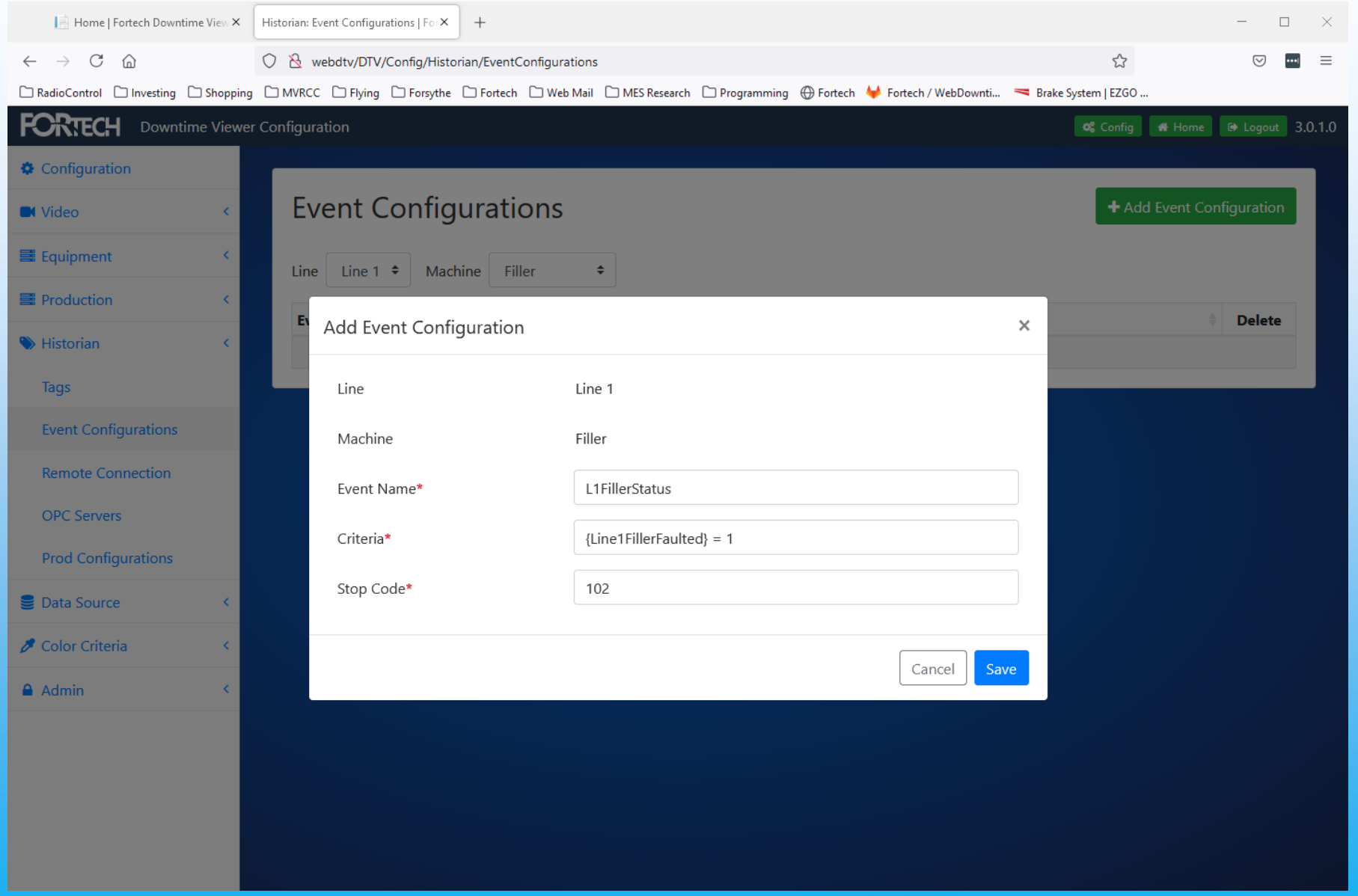


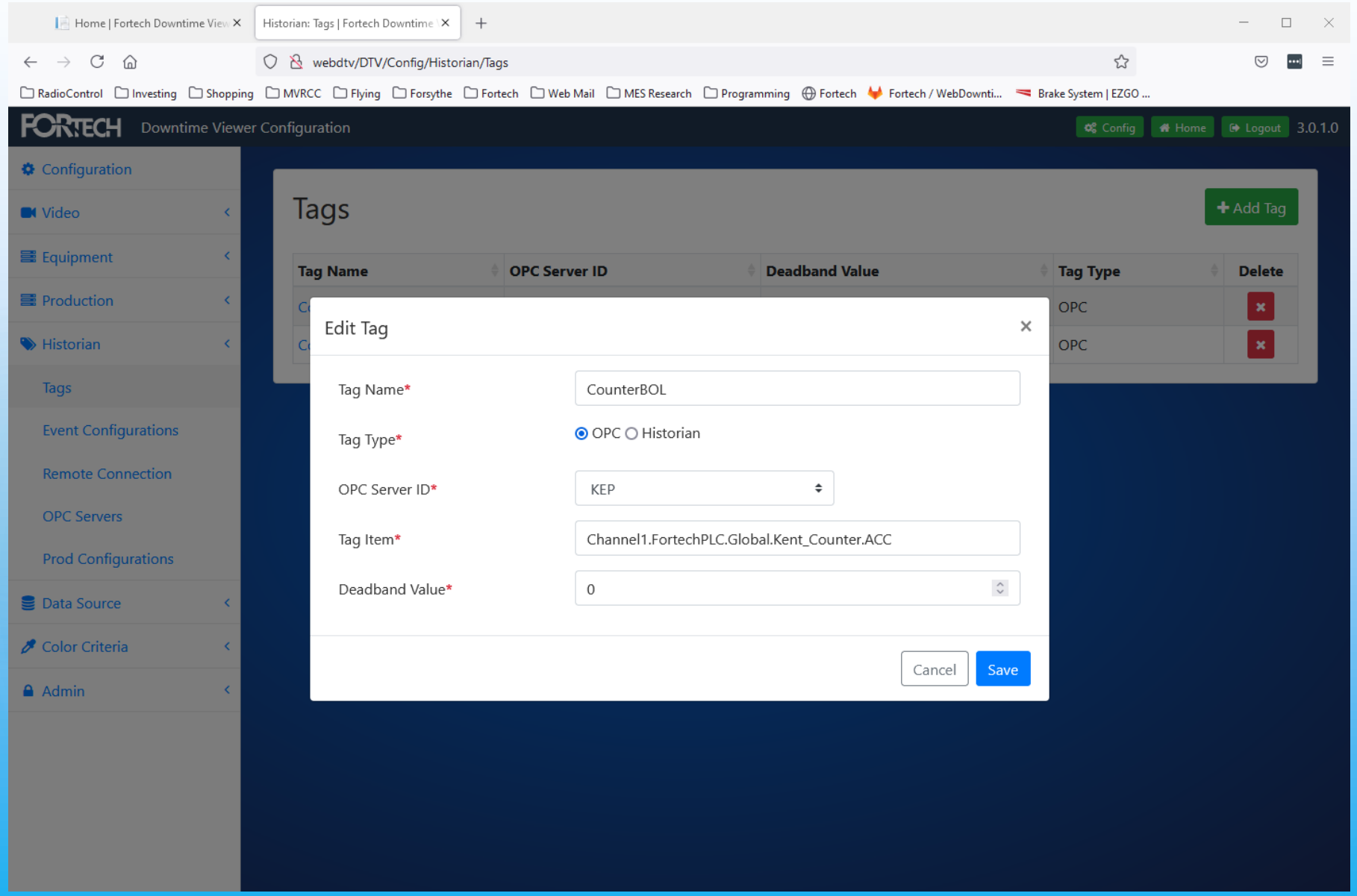
Setup to collect downtimes is as easy as defining a PLC tag to monitor.

Create a downtime event based on the PLC tag.

When the criteria is true, a downtime is started.

When false, the downtime ends.

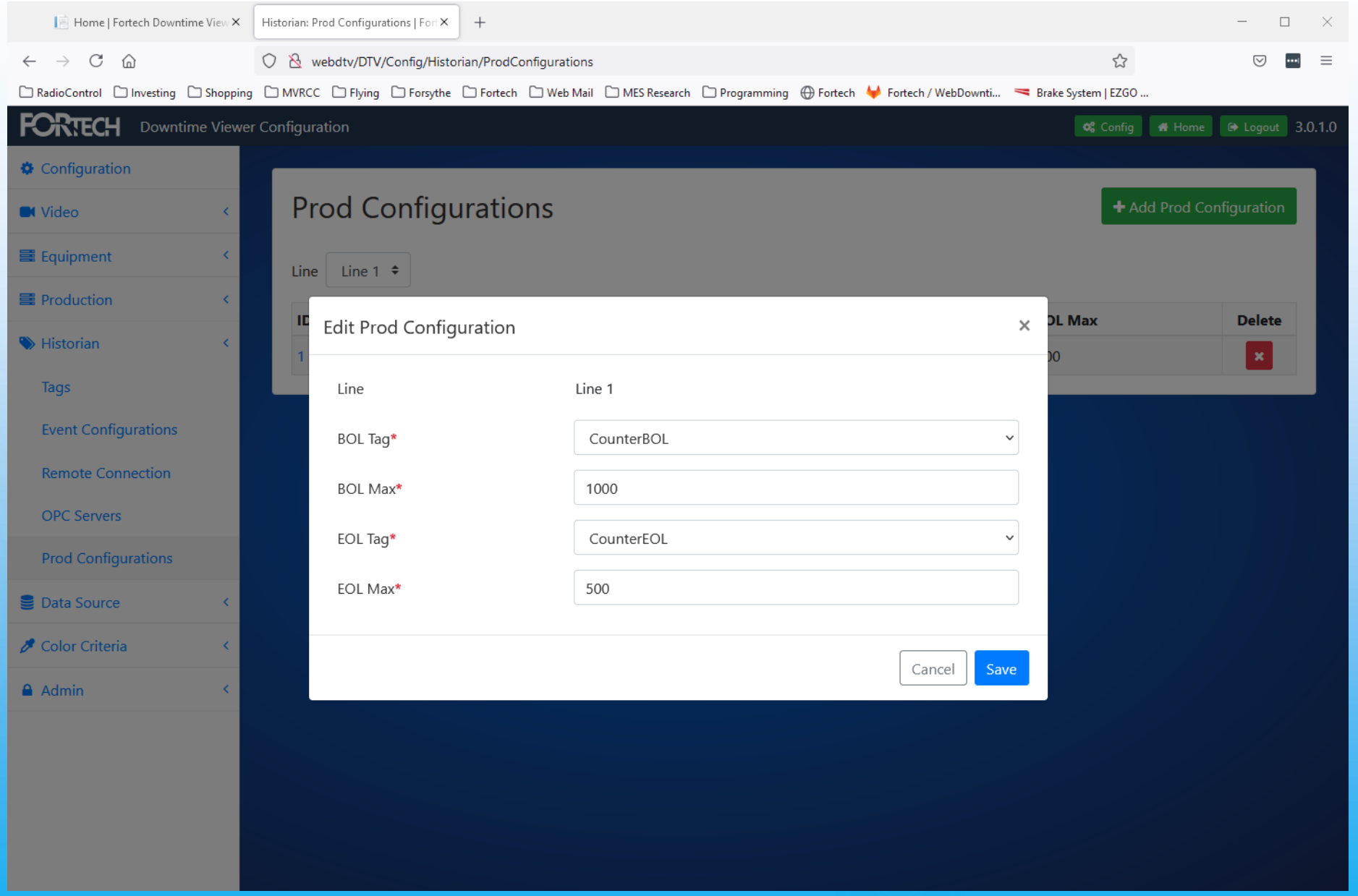


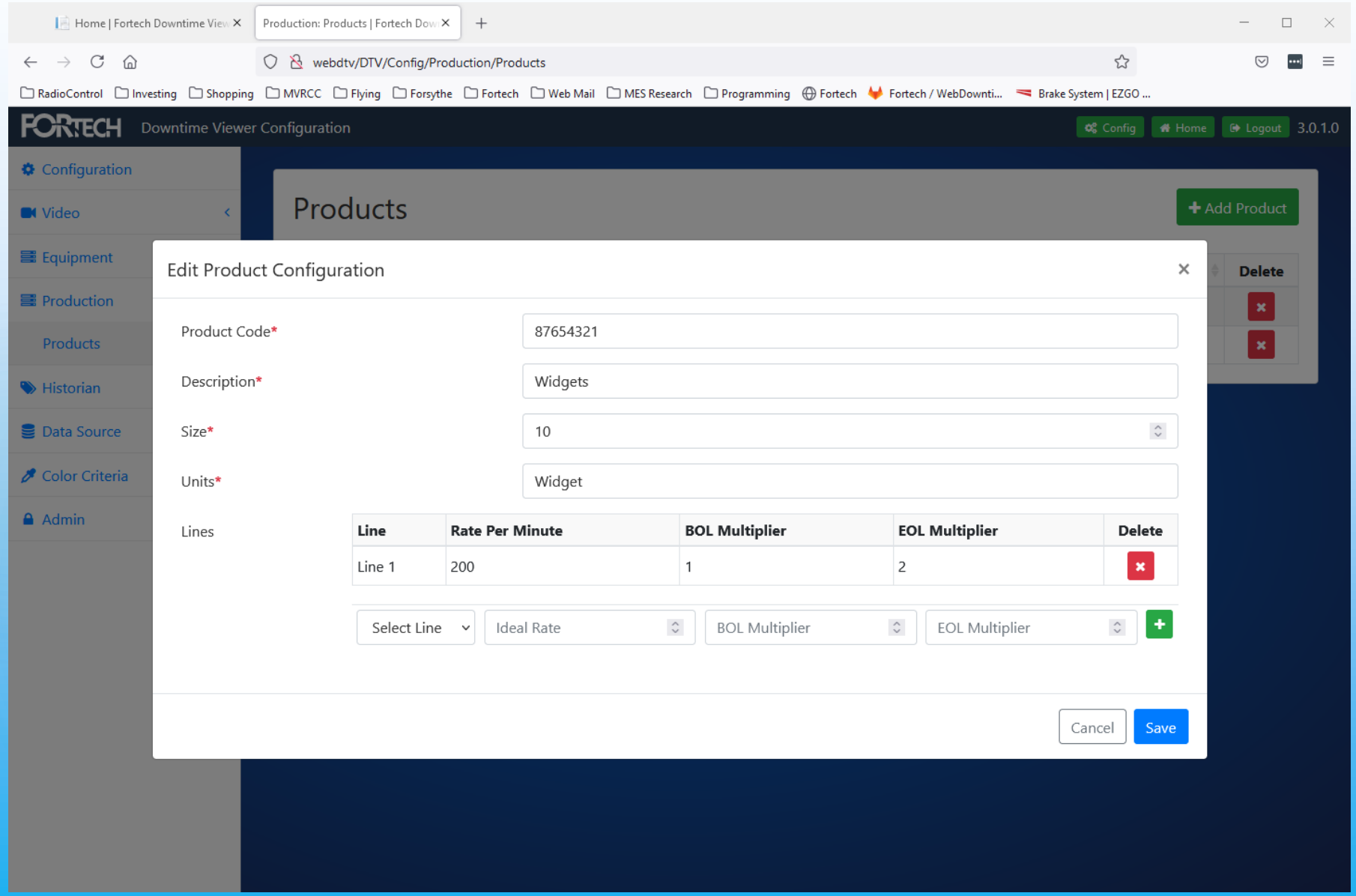


Setup to collect production is as easy as defining a PLC tag to monitor for the beginning of the line (BOL) and one for the end (EOL).

Configure a production event for each line specifying the tag and max value for both the beginning and end of line.

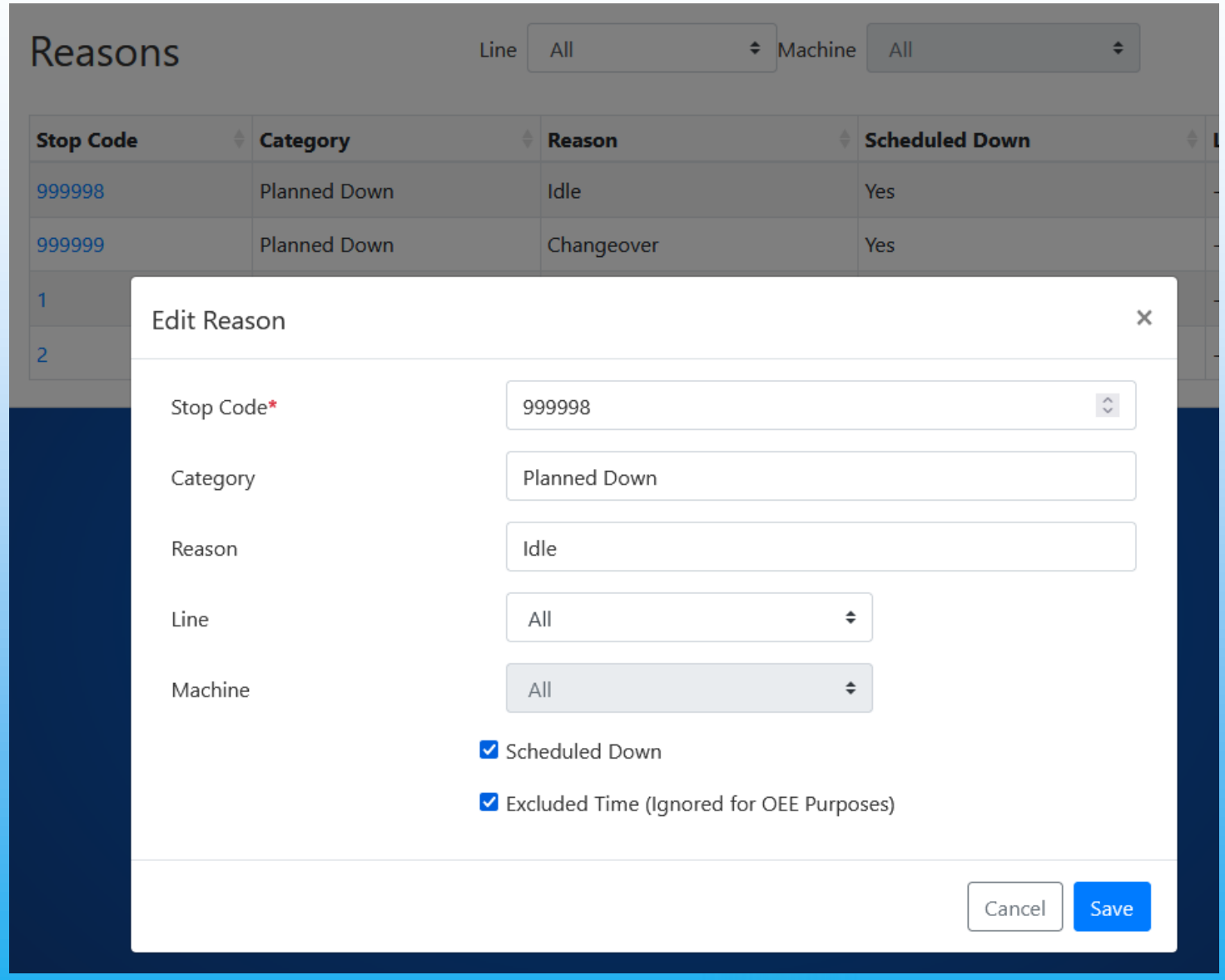
Note: these tags are accumulators that cycle back around to 1 once they hit their max value.





Create your products, specify the line(s) on which they run, the target rate and a multiplier if units are different between beginning and end of line.

Using the "Scheduled Down" and "Excluded Time" designators, you can control how constraint stops are handled with respect to OEE calculations.



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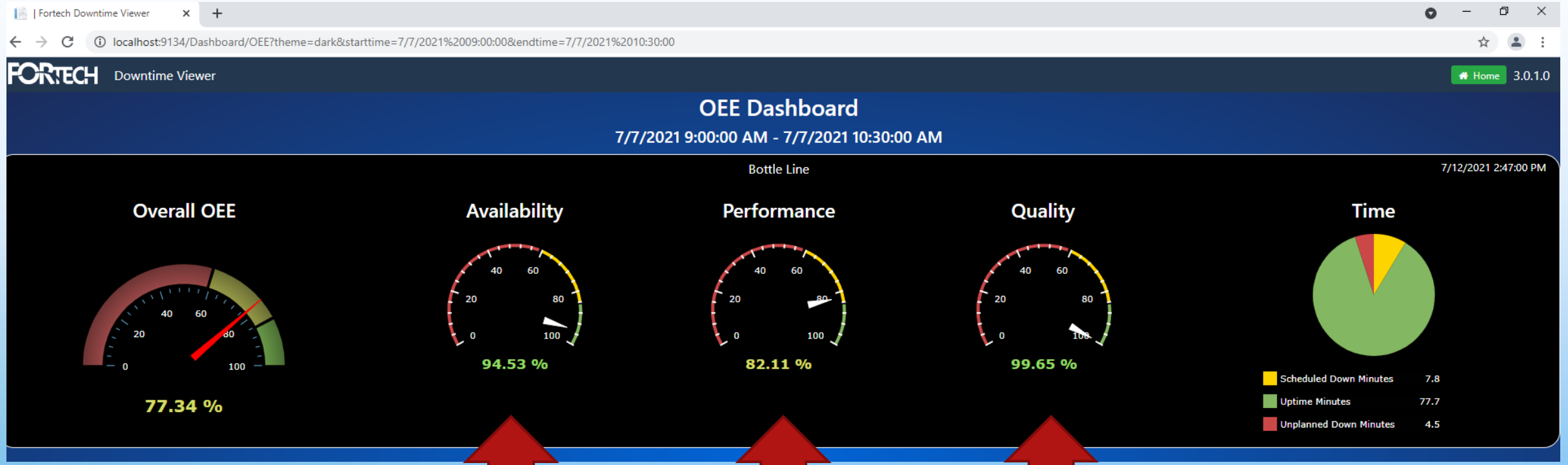

Comes from unplanned stops

Comes from beginning of line speed compared to target speed

Comes from comparison of beginning and end of line counts

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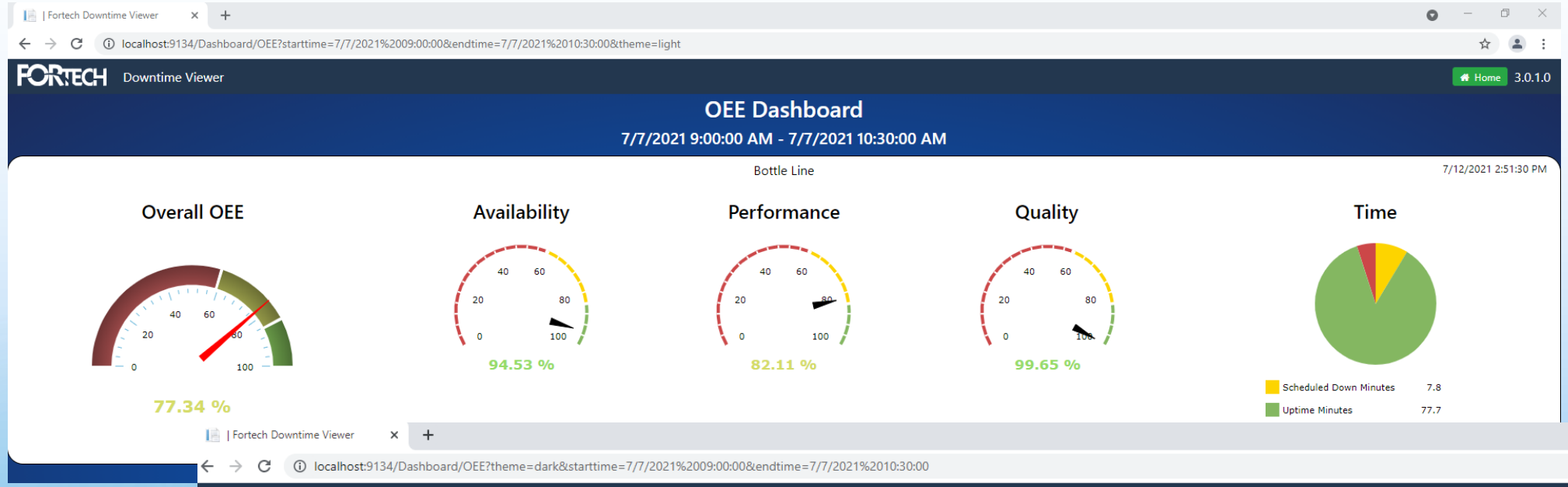
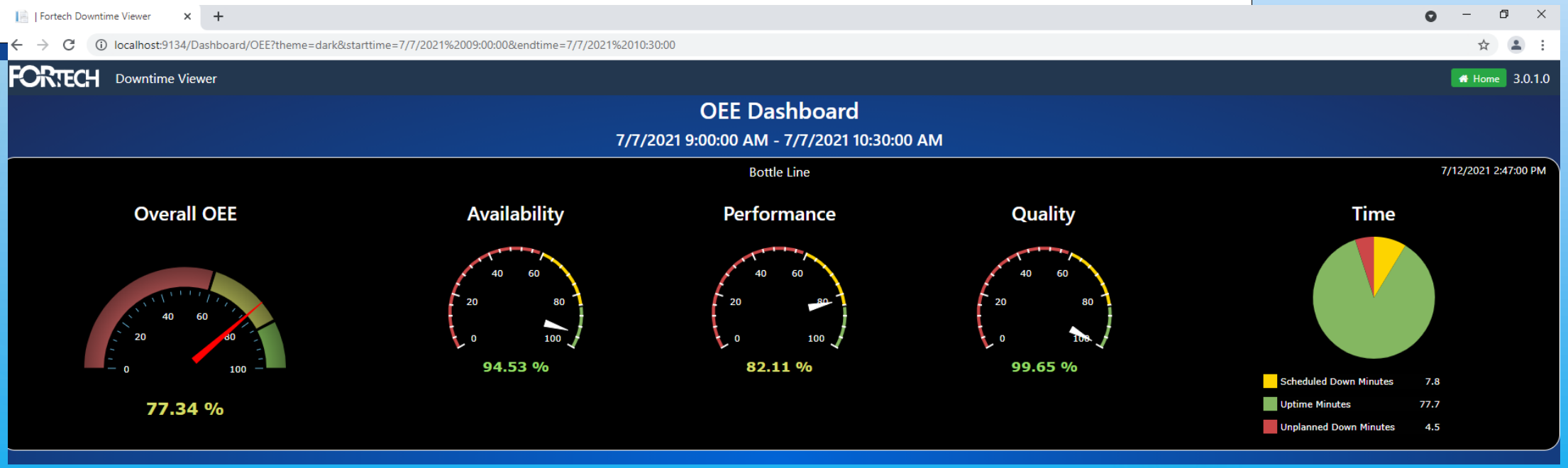
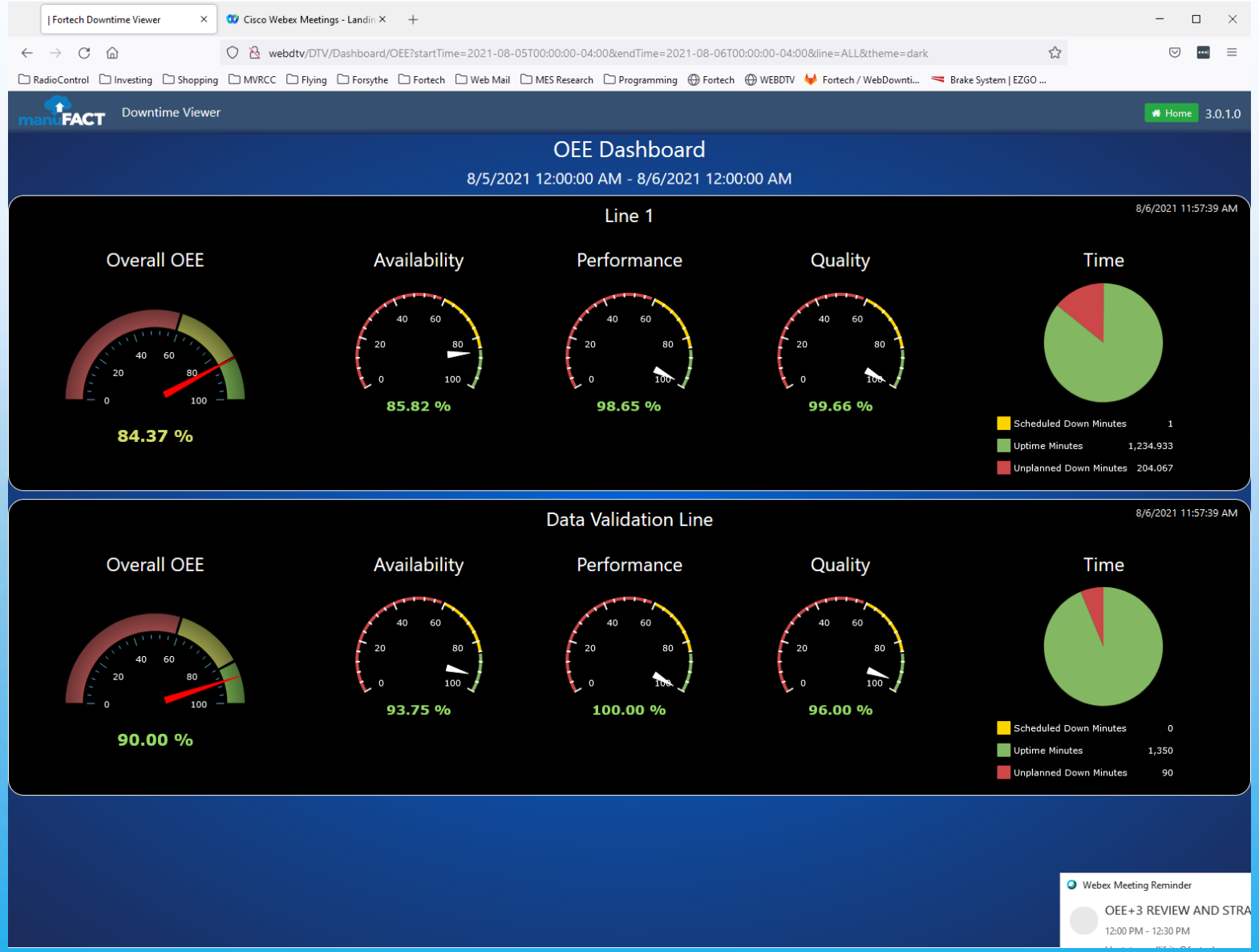


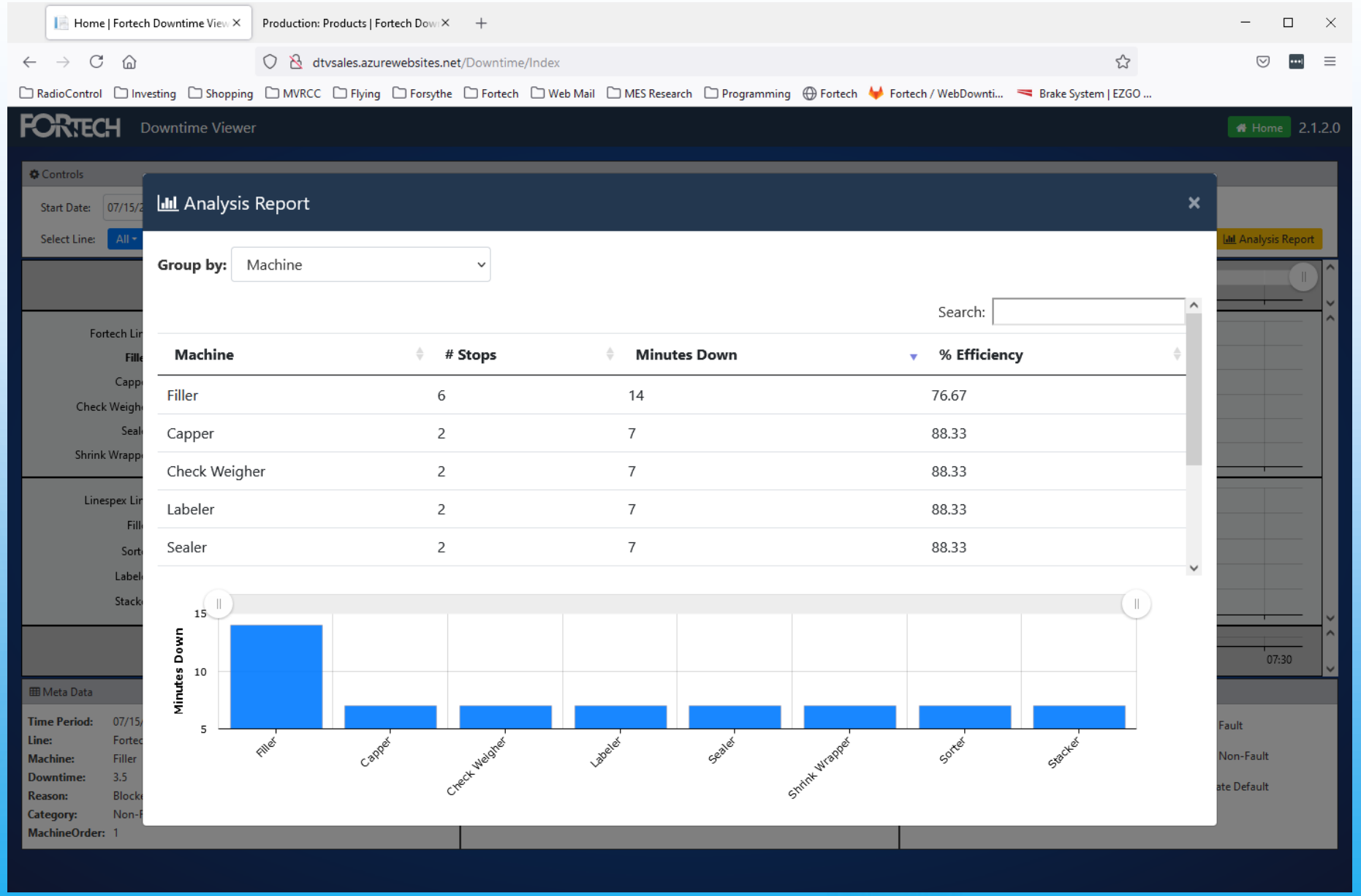


OEE Dashboard is available in light or dark styling



OEE Dashboard can show all lines in the plant at one time

Use the Analysis Report to determine the best place to focus corrective actions from unplanned stops.



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The “+” sign is for our state-of-the-art camera system and is an optional item.

The “3” represents the three critical measurements of Overall Equipment Effectiveness.

For Additional Information Contact Us At:

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Thank You!