

ENGINEERING FIELD GUIDE

An OEE pilot is only as good as its counters

Commission an OEE data path by agreeing on time boundaries, ideal cycle time and the meaning of a good part.

01 Agree on the denominator

Write down which periods belong to planned production time. A lunch break with no scheduled production differs from a breakdown during a scheduled run. Apply the same rule across shifts before comparing OEE. Changes in scheduling policy can change the result even when the machine behavior is unchanged.

02 Reconcile counts at a physical boundary

Pick one counting boundary and verify a complete batch against the operator record. Distinguish total parts, first-pass good parts, scrap and rework. Check what happens at counter rollover, a PLC restart and product change. A counter reset should start a new interval, not create negative production.

03 Validate cycle time by product

Use the ideal cycle time for the product and equipment combination, with a named owner for changes. If performance exceeds 100 percent, investigate the time base and count before presenting the metric. Averaging OEE percentages from unequal shifts can mislead; retain the underlying time and count totals.

04 Accept a decision, not just a screen

Run one shift with a manual cross-check. Ask whether the largest reported loss matches an observed event and whether the team knows what to investigate next. Keep unclassified losses visible rather than distributing them by assumed ratios. Accept the pilot when the data supports a repeatable improvement discussion.

TEAM WORKSHEET

From checks to a decision.

Work through this page together. Assign an owner and evidence to each check.

Site / line

Date / version

Owner / team

Pilot boundary

☐ **Agree on the denominator**

Evidence / open issue / owner:

☐ **Reconcile counts at a physical boundary**

Evidence / open issue / owner:

☐ **Validate cycle time by product**

Evidence / open issue / owner:

☐ **Accept a decision, not just a screen**

Evidence / open issue / owner:

Acceptance decision and next step

[] Accept [] Revise [] Hold

Acceptance criterion / result

Next action / owner / due date

Rollback trigger / plan

Project-specific support: aspdijital.com