

OEE Improvement Rating

Understanding, Measuring and Improving Overall Equipment Effectiveness (OEE) can be elusive for many sites. Everyone is too busy working around never ending problems to have time to sit back and reflect on how OEE should be properly measured and improved resulting in a lot of frustration for people as production plant & equipment doesn't perform to its full potential.

Too often OEE is used as feedback to Operators however in many situations they have little understanding or control of OEE performance as it encompasses the 7 big losses that can be influenced by Technical, People Development, Supplier, Planning and Management issues. This is why we refer to OEE as an Improvement Driver rather than a performance measure to be compared. As such, we recommend at least Good Output (preferably also Downtime and Scrap / Rework) be formally reviewed to expectation on an hourly basis so that corrective actions can be initiated in a timely way. Whereas OEE is normally reviewed on a weekly basis to monitor the impact of the OEE focused improvement teams.

This simple rating sheet can be used to do a quick health check on your OEE Improvement process for a Production Area or Line.

If you score below 50%, we suggest there could be significant opportunity for improvement. Use your score as a baseline for your improvement activities, then as you apply the learning from the book **"Understanding, Measuring, and Improving OEE"** by CTPM's Founder & President, Ross Kennedy (available to purchase by [clicking here](#)), monitor the improvement to your score to ensure you are focusing on the right things that will lift capacity, reduce costs, and reduce frustrations while creating a safer workplace.

Determine your Starting Point

On the following page the OEE Improvement Rating Sheet will allow you to score each of your Production Lines or Areas to establish a starting point or baseline to monitor the impact of your OEE improvement activities.

For each of the 10 requirements, please give your Production Line or Area a score of 0 to 5, using the Rating Legend as a guide, by selecting the relevant check box in the appropriate column.

Once you score each requirement, total the number of check boxes selected in each column then multiply each column total by the appropriate score as outlined in the table. Then add up your scores per column (out of a possible 50) and multiply it by 2 to give you a % rating (out of possible 100).

If you would like CTPM to collate the results of all your rating sheets, just scan and send them through to Nelson at nelson.rodriques@ctpm.org.au and the results will be sent back as soon as possible.

OEE Improvement Rating Sheet

This Rating Sheet outlines the 10 Requirements of OEE Improvement. It can be used to establish a starting point or baseline for your Production Area or Line and to monitor the impact of OEE improvement activities.

Site: _____

Production Area or Line: _____

Assessor: _____

Date of Assessment: _____

Rating Legend

- 0 – No evidence of activity or 0%
- 1 – Attempted but limited results or 10%
- 2 – Some evidence of activity or 25%
- 3 – Half-way to full implementation or 50%
- 4 – Close to full implementation or 75%
- 5 – Fully implemented or 100%

Requirements for OEE Improvement	0	1	2	3	4	5
1. OEE calculations are based on definitions where there is a direct correlation to good output produced and OEE performance (if OEE increases by 5% then 5% good output is produced in the same time, or the same good output is produced in 5% less time)						
2. OEE definitions are documented, understood by everyone, and used consistently in all calculations						
3. OEE is calculated using the High Level OEE equation at least each week and plotted on a weekly run chart to allow monitoring of trends						
4. OEE Loss Analysis using the OEE Loss Analysis Spreadsheets is conducted on each Production Line at least annually so that all OEE losses are understood down to 2 nd Level Pareto for both Loss and Section, Ideal Vision is confirmed and the gap is classified into Technical or People Development issues so as to identify the type and number of teams for future improvement activities						
5. Continuous Recording of losses, Sampling Observations and High Level OEE calculations are all used to conduct an OEE Loss Analysis						
6. Each year the gap between OEE Baseline and Ideal Vision is closed by at least 50% on the premise that each year a new OEE Baseline, based on the previous 6 weeks before the end of the year, is established and your OEE Ideal Vision is updated based on your current agreed assumptions						
7. OEE improvement has sustained or improved over the last 6 weeks						
8. OEE Weekly Run Chart shows clear tendency of continuous improvement						
9. Production improvement activities are linked to improving or sustaining OEE						
10. OEE improvement has been translated into at least 5% regular on-going improvement time for Operators through their regular (weekly) Production Area Based Team improvement activities (Work Area Management / 5S, Clean for Inspection, Train for Inspection, Manage by Inspection)						
Number per Column:						
Multiply by:	0	1	2	3	4	5
Score per Column:						
Total / 50:						
X 2	%					