



10 May 2019 / Vertical Milling Machine / Rosa Shelly

OEE Report Template Conducted on 10th May, 2019 By SafetyCulture Staff

Complete

Inspection score	Failed items
46.67%	8
Site Sydney	
Company Primo Manufacturing Co.	
Manufacturing Facility 4245 Jessie St., Coltington OH 43085	
Equipment/Production Process Vertical Milling Machine	
Machine Operator Rosa Shelly	
Conducted on 📅 10th May, 2019 ⌚ 12:14 PM +08	

OEE Report Template / Unplanned Downtime

Were there equipment breakdowns/failures?

Yes

Photos



Photo 1

Were unplanned repairs made?

Yes

Photos



Photo 2



Photo 3

OEE Report Template / Planned Downtime

Was the equipment set up too long?

Yes

Notes

53 minutes longer than usual

Did the changeovers take too long?

Yes

Notes

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

Photos



Photo 4

OEE Report Template / Slow Cycles

OEE Report Template / Slow cycles

Was there a lack of maintenance? Yes

Was there wear and tear on the equipment? Yes

Photos



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

Photos



Photo 8

Unplanned Downtime

2 Failed

Were there equipment breakdowns/failures?

Yes

Photos



Photo 1

Were unplanned repairs made?

Yes

Photos



Photo 2



Photo 3

Was there a lack of material?


No

Was there a lack of transport for completed goods?

No

Planned Downtime

2 Failed




Was the equipment set up too long?	<input checked="" type="radio"/> Yes
Notes 53 minutes longer than usual	
Did the changeovers take too long?	<input checked="" type="radio"/> Yes
Notes The next production run was on hold for an hour and 24 minutes	
Photos	
	
Photo 4	
Was the operator frequently absent? (e.g. breaks, comfort room time, etc.)	<input type="radio"/> No

Small Stops

Was there minor idling?	<input type="radio"/> No
Was an incorrect operation done on the equipment?	<input type="radio"/> No
Notes The operator is experienced and properly trained	

Slow Cycles

2 Failed

Was there a lack of maintenance?	<input type="radio"/> Yes	
Was there wear and tear on the equipment?	<input type="radio"/> Yes	
Photos		
		
Photo 5	Photo 6	Photo 7
Were wrong settings applied to the equipment? (e.g. set speed slower than possible)	<input type="radio"/> No	


Production Rejects

1 Failed

Were there products that cannot be salvaged at all?	<input type="radio"/> No
Were there products that had to be reworked to be usable?	<input type="radio"/> Yes

Start-up Rejects

1 Failed

Were there start-up losses during ramp up of production?	<input type="radio"/> Yes
Photos	
	
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

10th May, 2019 12:51 PM +08

Quality Manager Name & Signature



Frank Gene

10th May, 2019 12:50 PM +08

Photos

8 Photos



Photo 1



Photo 2



Photo 3



Photo 4



Photo 5



Photo 6



Photo 7



Photo 8