

Industry 4.0 - Overall Equipment Effectiveness (OEE)

$$\text{OEE} = \text{Performance} \times \text{Availability} \times \text{Quality}$$

$$\text{OEE} = \frac{B}{A} \times \frac{D}{C} \times \frac{F}{E}$$

Performance

A = Total Operative Mode Time

B = Run Time

Time Loss

Availability

C = Normal Speed

D = Actual Speed

Speed Losses

Quality

E = Product Output

F = Actual Good Product

Scrap Losses

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