

OEE Calculation Model

Total operation time						
Planned operation time						No production sceduled
Availability	A Planned production time					Planned downtime
	B Actual operation time				Downtime	
Efficiency	C Theoretical output*					
	D Actual output			Disruption		
Quality	E Good products		Scrap			
			Quality losses			
OEE = $\frac{B}{A}$ x $\frac{D}{C}$ x $\frac{E}{D}$ Utilization factor Efficiency factor Quality factor						

* (operation time x theoretical runrate)