

OEE from 20% to 62% in three months

No PLC changes. No production stops. What one plant did, and what you can copy on Monday.

• FANUC CNC lines

• 80 machines in 6 weeks

For every scheduled hour, **12 minutes** of good parts

That is what 20.03% OEE means: one fifth of the output the machines could make in the time they were planned to run.

One scheduled hour, in 6-minute blocks



12 min good output

48 min hidden factory

THE FIRST JOB

Downtime without a reason can't be priced, ranked or fixed. So the first job was to see every stop.

What made **speed possible**

Three choices kept the rollout fast and the lines running.



No PLC changes

Nothing in the control logic was touched.



No production stops

Lines kept running during the rollout.



One implementation partner

Rolled out together with Nexus IIOT.

80 machines in 6 weeks

Scaled while production kept running

• Rollout pace

About **three times the good output**

From the same machines, in the same scheduled hours.

OEE

61.66%

Before



20.03%

After 3 months



61.66%

-73%

unclassified downtime

-96%

time spent on reporting

Same FANUC CNC lines, same scheduled hours. Results as reported for the first three months.

What made the difference

What you can copy on Monday.

1

Name every stop before you fix any

Unclassified downtime fell 73%. Once stops had reasons, the biggest losses were obvious.

2

Stop reporting, start acting

96% less time on reports means hours back for the people who solve problems.

3

Scale without stopping the lines

No PLC work and no production stops meant 80 machines in 6 weeks.

Four questions to ask **your own team**

If the answers take more than a minute to find, your hidden factory is probably bigger than you think.

- 1 What share of our downtime has no reason attached?
- 2 How many hours a week go into building OEE reports?
- 3 Which of our lines could connect without touching a PLC?
- 4 What does one minute cost on our bottleneck?

Find out →

Extra output becomes profit when you can sell it. If you can't, the same gain comes back as fewer hours and less overtime.

If a loss has no price tag, it has no priority.

Find out what one minute costs on your bottleneck line, then rank every loss in euros.

Price one minute on your line

Free loss price tag calculator, 3 minutes

[Open →](#)

Find your hidden factory

The 30-day, 7-step field guide

[Read →](#)

[**Book a 30-minute demo with your own line →**](#)

Customer name withheld at their request. Implementation partner: Nexus IIOT. Results as reported for the first three months.