



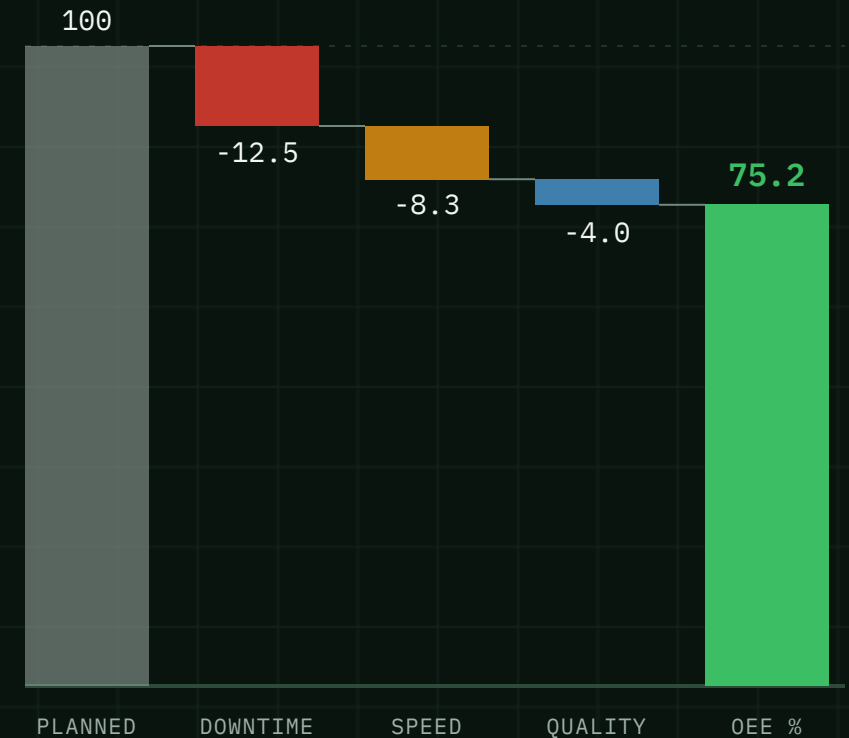
PLAYBOOK · FOR PLANT MANAGERS

The 90-Day OEE Improvement Playbook

Baseline, rank, fix, lock in. A Monday-by-Monday plan to raise OEE without a big-bang project.

13 weeks · 4 phases · 1 review every Monday

LOSS WATERFALL · EXAMPLE SHIFT



OEE rises when every loss has an owner. Not when the number is on a screen.

WEEKS 1 TO 2

Measure it one way

One OEE definition, agreed stops, real cycle times, counts straight from the machines.

WEEKS 3 TO 10

Attack three losses

Rank losses in hours. Pick the top three. One owner, one countermeasure, checked in the data.

WEEKS 11 TO 13

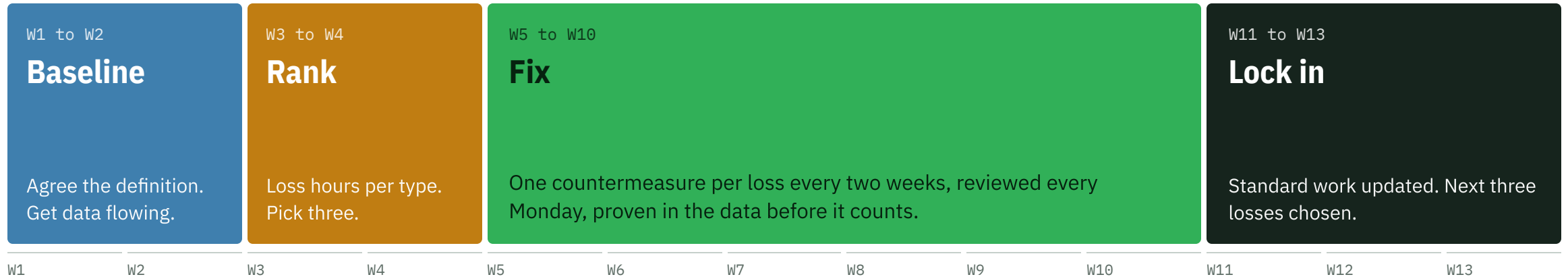
Make it the standard

Fixes go into standard work and maintenance plans. Then the next three losses.

30 min

The engine of the program is one review, every Monday, with the same data and the same agenda. Page 7 has the agenda.

90 days on one line



OUTPUT

Baseline OEE

Per line and shift, one definition everyone signed.

OUTPUT

Loss register

Top three losses in hours, each with one named owner.

OUTPUT

Before and after

For every countermeasure, the loss hours measured on both sides.

OUTPUT

New baseline

Fixes written into standard work. The next three losses chosen.

Five inputs every OEE number is built from

Get these right in week one and most OEE arguments never start.

INPUT	WHAT "RIGHT" MEANS	OWNER	DONE
Shift calendar	Planned production time per line, with breaks and planned stops agreed in writing		☐
Machine states	Run and stop with timestamps, from the machine, not from memory		☐
Counts	Total and good parts per product, counted at the same point on every line		☐
Ideal cycle time	One value per product and machine, taken from design or best proven rate		☐
Scrap and rework	Recorded per machine and shift, with a reason		☐

Want machine states and counts without manual logs? Fabrico records them for every line and shift.

[Request a demo](#)

The formula, and the example that settles arguments

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

AVAILABILITY

Run time ÷
planned
production time

PERFORMANCE

(Ideal cycle time
× total count) ÷
run time

QUALITY

Good count ÷
total count

CROSS-CHECK THAT NEVER LIES

OEE also equals **good count × ideal cycle time ÷ planned time**. If your two answers differ, a definition is wrong.

One shift, worked through

EXAMPLE

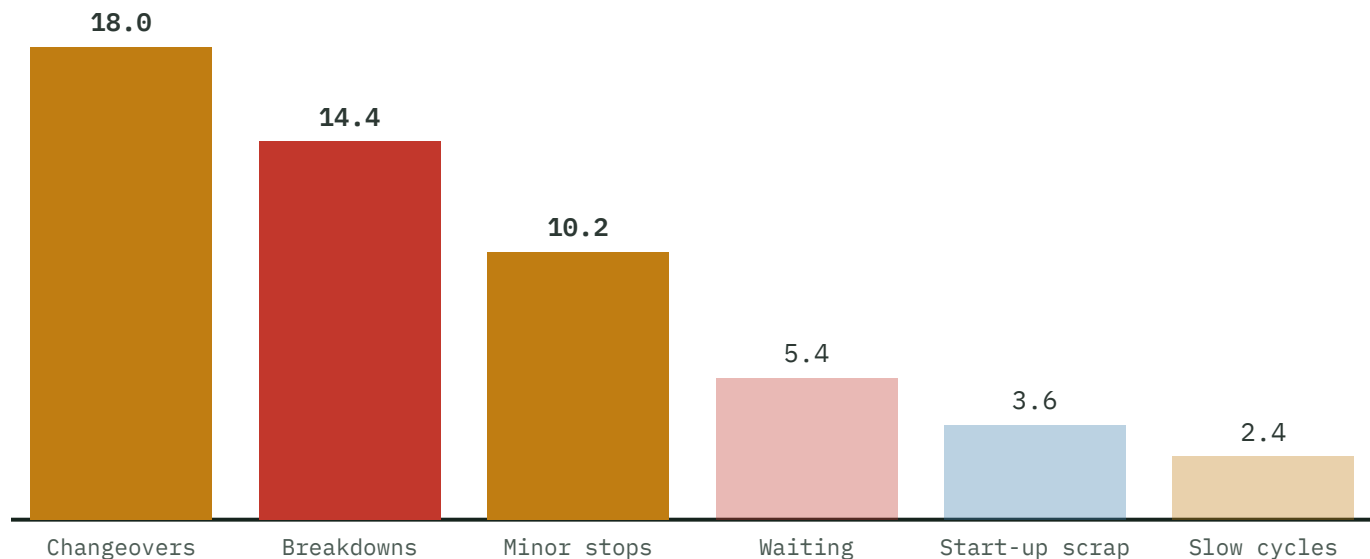
Planned time	480 min
Stops	60 min
Ideal cycle time	1.0 min
Total count / good	380 / 361
Availability	420 ÷ 480 = 87.5%
Performance	380 ÷ 420 = 90.5%
Quality	361 ÷ 380 = 95.0%
OEE	75.2%

Check: 361 × 1.0 ÷ 480 = 75.2%

Rank losses in hours, not in percent

Hours are what a supervisor can see, count and win back. Plot two weeks of stop data, then pick three.

LOSS HOURS, TWO WEEKS • EXAMPLE LINE
TOP 3 = 42.6 OF 54.0 HOURS



EXAMPLE

- ☐ **Hours, per loss type**, from machine stop data, not from shift notes.
- ☐ **Top three only.** A fourth action splits the team and nothing moves.
- ☐ **One owner per loss**, named in the register, reviewed every Monday.

The Monday review: 30 minutes, same agenda

0 to 5

OEE against baseline

Per line, last week against the baseline. No debate on the number.

5 to 15

Top three losses

Hours this week against last week, per owner.

15 to 22

Countermeasures

Done, in progress, blocked. Blocked items get a decision today.

22 to 27

New losses

Anything that crossed its threshold since last Monday.

27 to 30

Decisions

Owner and date for every decision, read back aloud.

IN THE ROOM

- ✓ Plant manager
- ✓ Production lead
- ✓ Maintenance lead
- ✓ Quality lead
- ✓ Continuous improvement lead

Minutes on the left are the agenda clock.

Every loss gets one owner and a first action

LOSS	TYPE	TYPICAL OWNER	FIRST ACTION
Breakdowns	DOWN	Maintenance lead	A work order from every stop over the threshold. Root cause on repeats.
Changeovers	DOWN	Production lead	Film the longest changeover. Move steps outside the stop.
Minor stops	SPEED	Line supervisor	Reason codes operators will actually use, five to eight per line.
Slow cycles	SPEED	Process engineer	Running rate against ideal rate, per product.
Start-up scrap	QUALITY	Shift lead	A start-up checklist, signed at the first good part.
Process defects	QUALITY	Quality lead	Scrap by machine and shift, reviewed with the loss owner.

In Fabrico a stop can become a work order for its owner, in the same system as the OEE data.

Request a demo

Day 90: what done looks like

SCORECARD

- ☐ Same OEE definition on every line
- ☐ Baseline and current OEE published per line
- ☐ Top three losses down, proven in the data
- ☐ Owners and actions reviewed every Monday
- ☐ Fixes written into standard work
- ☐ Next three losses chosen, owners named

TRAPS

Chasing the number. Talk about loss hours, not OEE points.

Moving definitions. Changing "planned stop" mid-program erases progress.

Manual logs only. Short stops never reach the log, so the biggest speed losses stay invisible.

Reviews without decisions. A review that ends with no owner and date is a report.

Run your Day 90 scorecard on live machine data. One screen for the whole review.

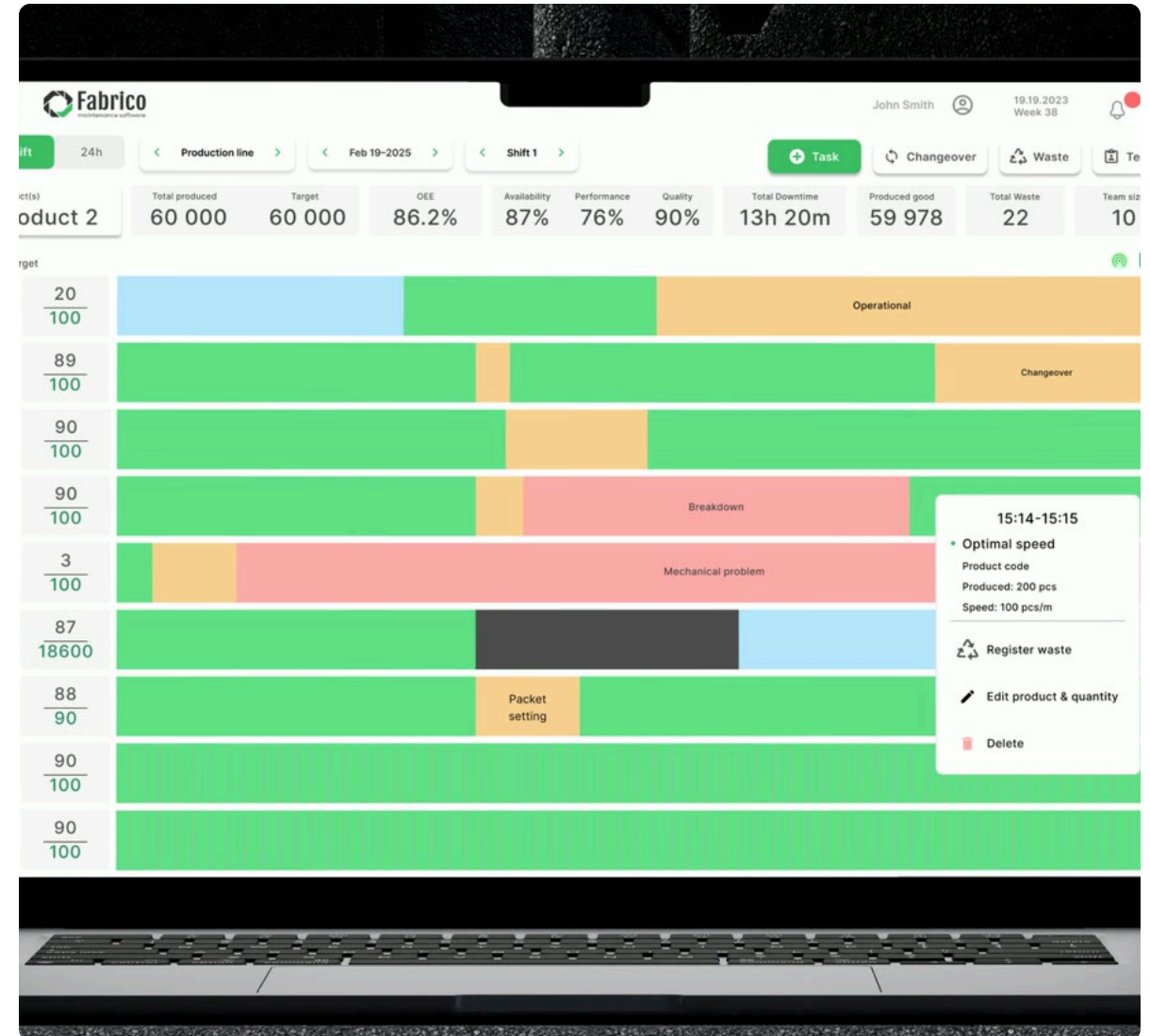
[Request a demo](#)

The same playbook, run from the machines

Fabrico is a cloud-based MES and OEE platform for manufacturers, with maintenance management (CMMS) built in.

- ✓ **Machine data** for availability, performance and quality, per line and shift
- ✓ **Every stop with its cause**, from operators or AI computer vision
- ✓ **A stop becomes a work order** in the same system
- ✓ **The Monday review** on one screen, same data for everyone

[Request a demo](#)





NEXT STEP

See your own losses in 30 minutes

A 30-minute demo with a Fabrico consultant, on your lines and your questions. No commitment.

[Request a demo](#)

[Contact us](#)

team@fabrico.io · fabrico.io



Scan to request a demo