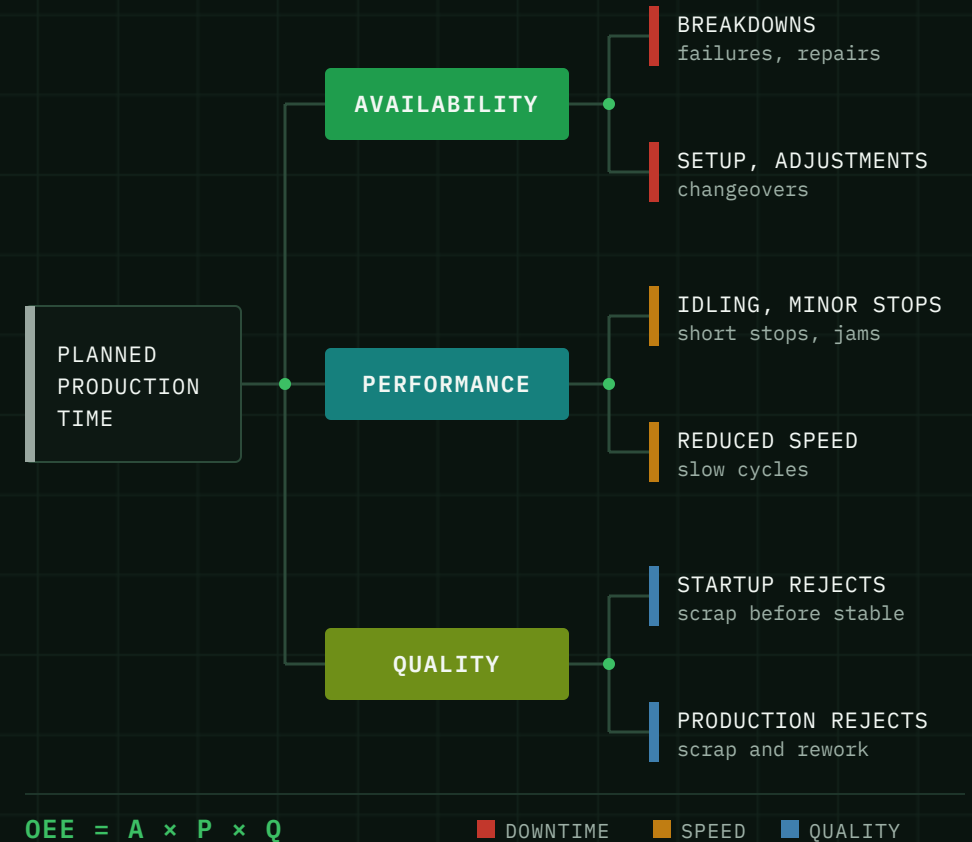


The Six Big Losses Field Guide

What each OEE loss looks like on the floor, how to capture it from machine data, and the first countermeasure.

LOSS TREE · SIX BIG LOSSES



You do not fix OEE. You fix the six losses under it.

AVAILABILITY

Stopped when it should run

BREAKDOWNS

SETUP AND ADJUSTMENTS

PERFORMANCE

Running slower than it can

IDLING AND MINOR STOPS

REDUCED SPEED

QUALITY

Making parts you cannot ship

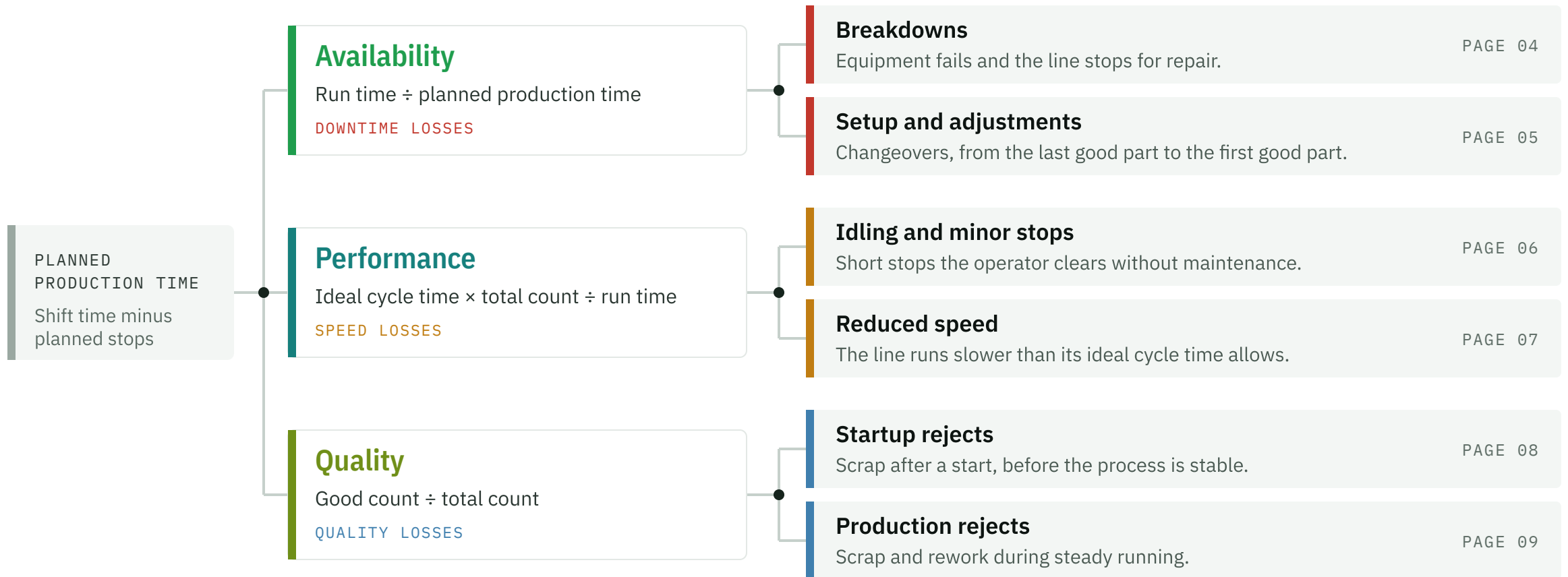
STARTUP REJECTS

PRODUCTION REJECTS

THE CAPTURE RULE

Capture losses from the machine, not from memory. A manual log keeps the long stops and loses the short ones, so the small losses disappear first.

Every lost minute sits on one branch



Breakdowns: fix the repeats first

ON THE FLOOR

Equipment fails and the line stops until maintenance repairs it.

HOW TO CAPTURE IT

Machine stop state with start and end time. Maintenance adds the cause.

THE TRAP

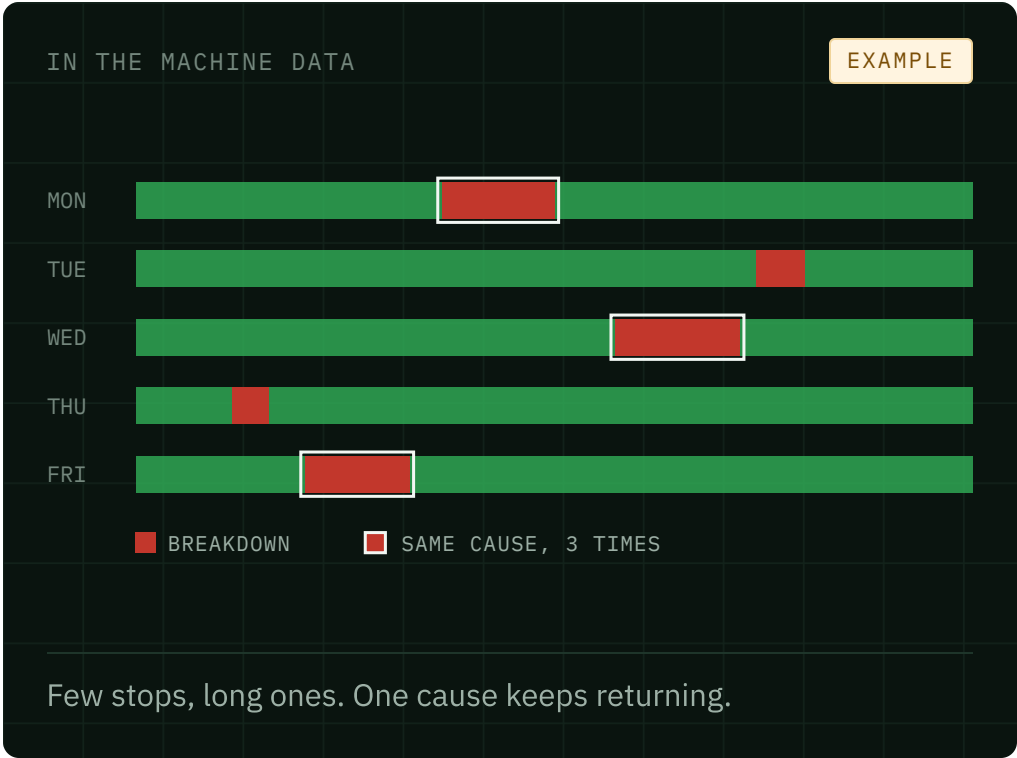
Each failure looks like bad luck on the day. The pattern only shows across days and shifts.

FIRST COUNTERMEASURE

A work order for every breakdown over a threshold. Rank causes by hours, remove the top one.

TYPICAL OWNER

Maintenance lead

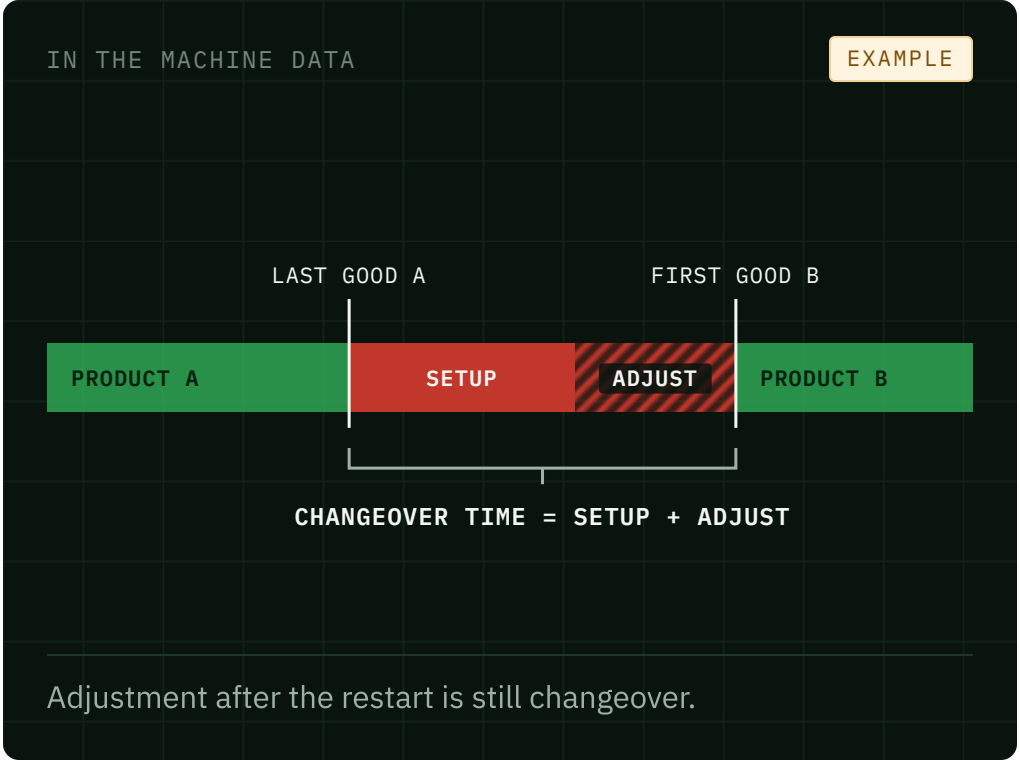


In Fabrico a breakdown can become a maintenance work order, in the same system as the stop.

Request a demo

Changeovers end at the first good part

ON THE FLOOR	Product and tool change, cleaning, then adjustments until parts are good again.
HOW TO CAPTURE IT	Stop tagged as a changeover. The good count from the machine marks its real end.
THE TRAP	Booked as a planned stop, the changeover drops out of OEE and nobody attacks it.
FIRST COUNTERMEASURE	Film one changeover. Do every step you can while the line still runs (SMED).
TYPICAL OWNER	Production lead



YOUR WORST LINE, LAST WEEK

Changeovers

Longest, min

Hours lost

Minor stops never reach the shift log

ON THE FLOOR

Jams, a blocked sensor, an empty feeder. Cleared by the operator, then running again.

HOW TO CAPTURE IT

The machine run signal, every stop counted. Sum those under your threshold per shift.

THE TRAP

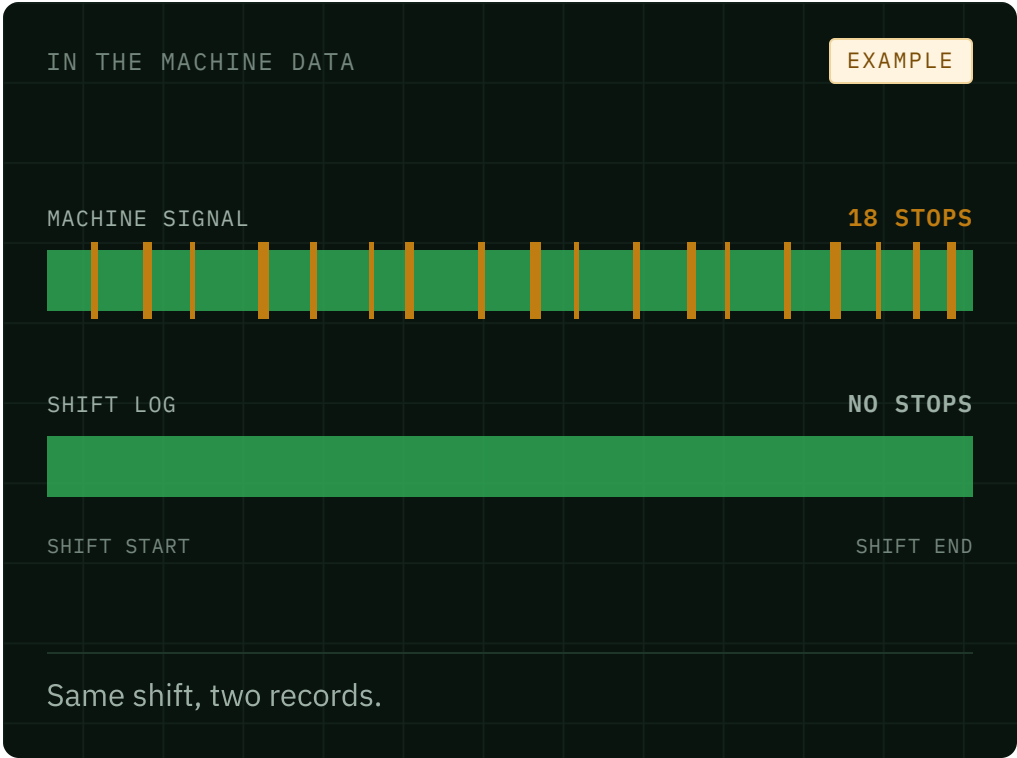
Too short to write down, too frequent to ignore. Together they can outweigh a breakdown.

FIRST COUNTERMEASURE

Count them by cause for one week. Fix the most frequent one at the machine.

TYPICAL OWNER

Line supervisor



Fabrico records every stop with its cause, from operators or AI computer vision.

Request a demo

Reduced speed is the loss nobody hears

ON THE FLOOR

The line runs, just slower than it can: turned down after a problem, worn tooling, habit.

HOW TO CAPTURE IT

Actual cycle time from the machine against the ideal cycle time, per product.

THE TRAP

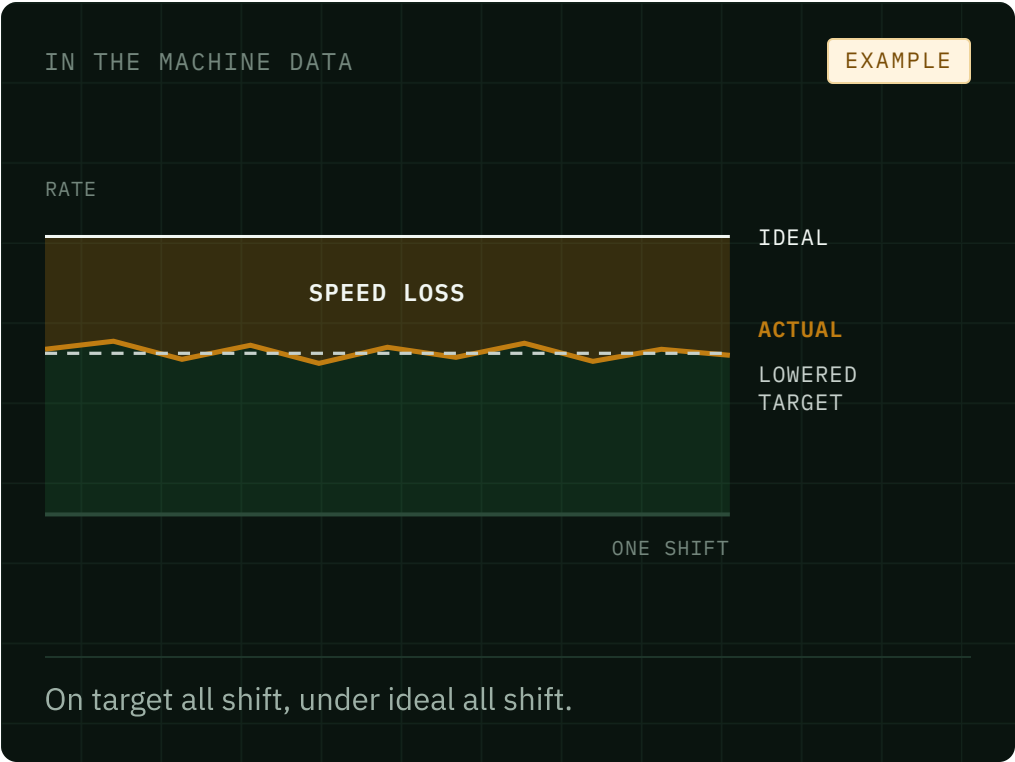
Measured against a lowered “standard” rate, performance looks fine.

FIRST COUNTERMEASURE

One ideal cycle time per product, from design or best proven rate.

TYPICAL OWNER

Process engineer



YOUR WORST PRODUCT

Ideal cycle time _____

Actual cycle time _____

Ideal ÷ actual _____

Startup rejects belong in the scrap count

ON THE FLOOR

Scrap made after a start or restart while temperature, pressure and settings settle.

HOW TO CAPTURE IT

Reject count per machine, tagged to the window after each start.

THE TRAP

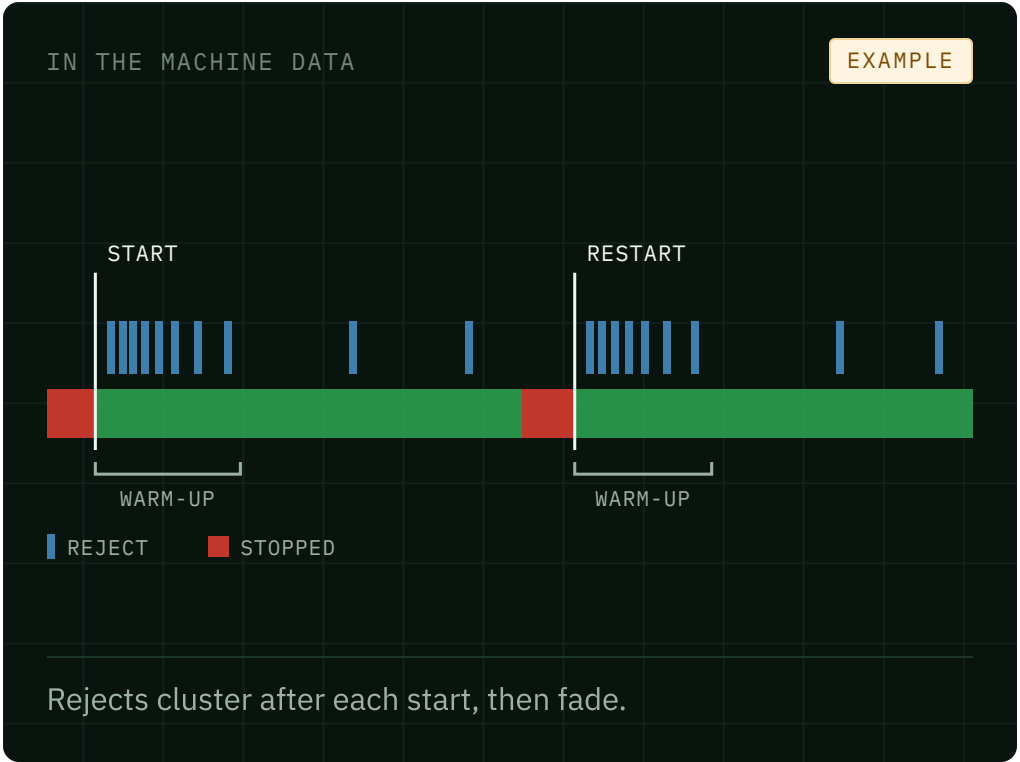
Called “warm-up” and left out of the count, or binned before anyone counts it.

FIRST COUNTERMEASURE

A startup checklist with the settings that matter, signed off at the first good part.

TYPICAL OWNER

Shift lead



YOUR WORST LINE, LAST WEEK

Starts

Rejects after starts

Per start

Production rejects: count rework too

ON THE FLOOR

Defects made during steady running: out of tolerance, surface faults, wrong assembly.

HOW TO CAPTURE IT

Good and reject counts from the machine or inspection station, with a defect reason.

THE TRAP

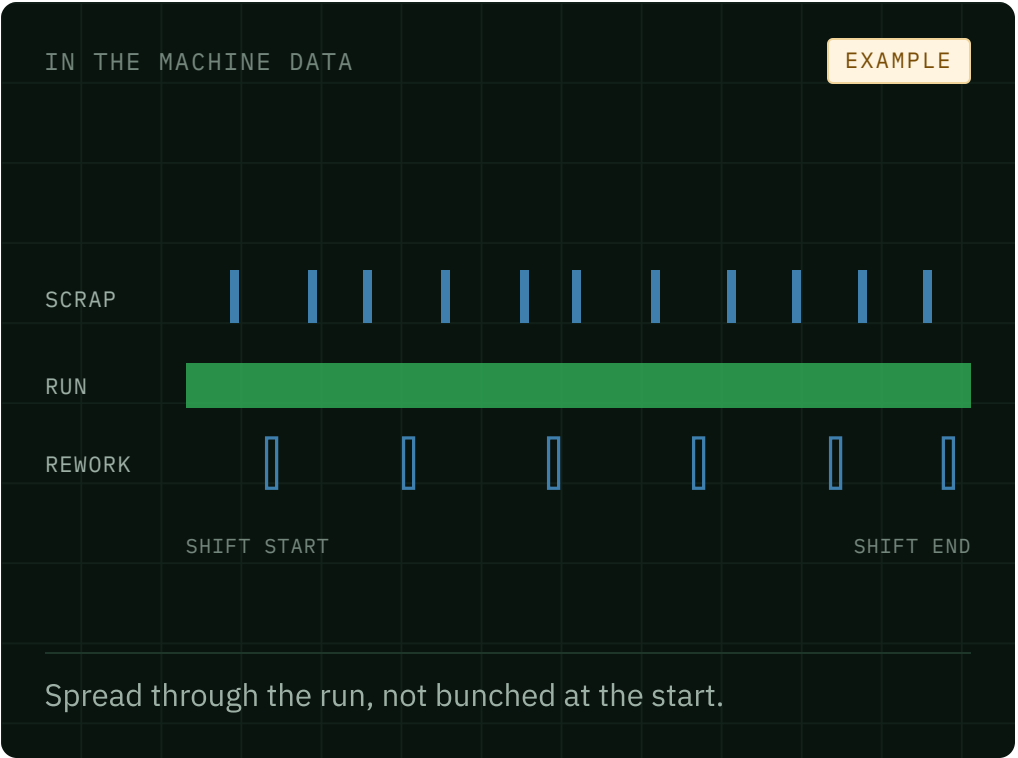
A reworked part joins the good count and the loss disappears from the data.

FIRST COUNTERMEASURE

Rank defect types by machine and shift, then attack the top one with its owner.

TYPICAL OWNER

Quality lead

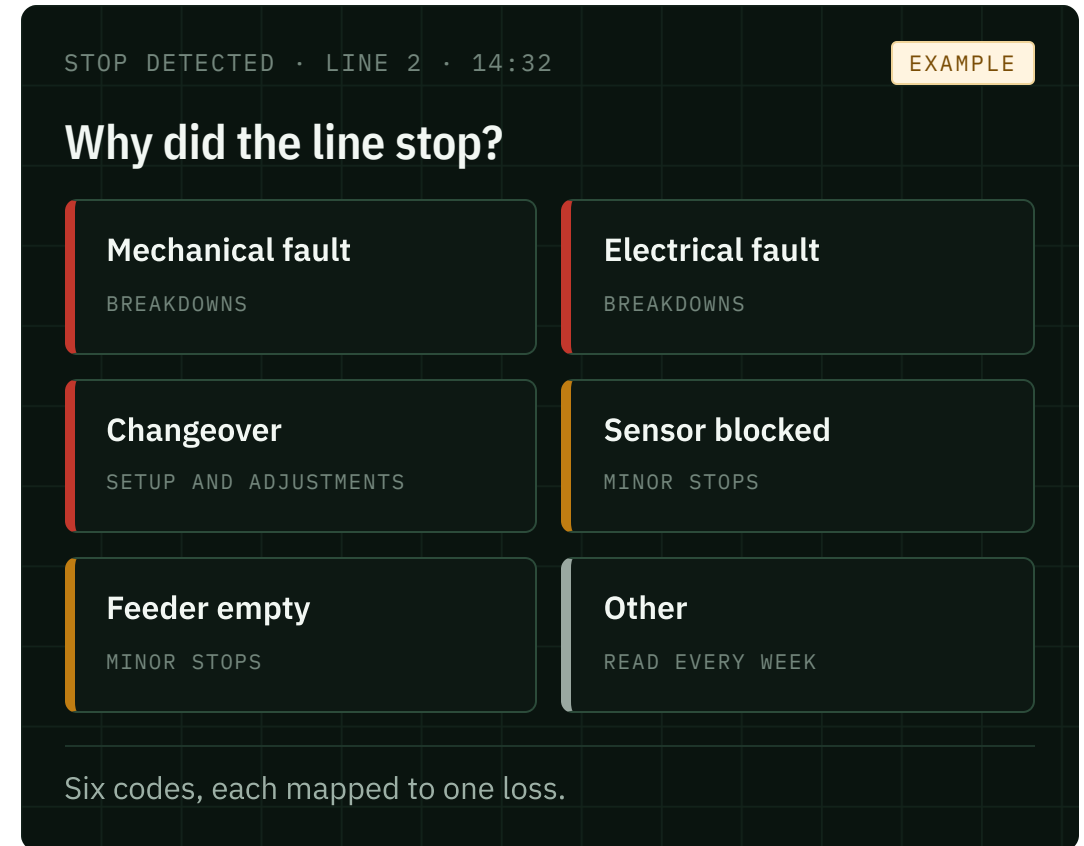


Quality from machine data, per line and shift, next to availability and performance in Fabrico.

Request a demo

Clean reason codes are few, plain and reviewed

- ☐ **Five to eight codes per line.** Give operators a long list and they pick the first one.
- ☐ **Words an operator uses.** “Feeder empty”, not “Material flow deviation”.
- ☐ **The machine detects the stop, a person adds why.** Start, end and duration never come from memory.
- ☐ **One “Other”, read every week.** Re-code it or add the missing code.
- ☐ **A review every month.** Merge codes nobody uses, split the one everyone uses.
- ☐ **Each code maps to one of the six losses,** so your Pareto rolls up to the loss tree.

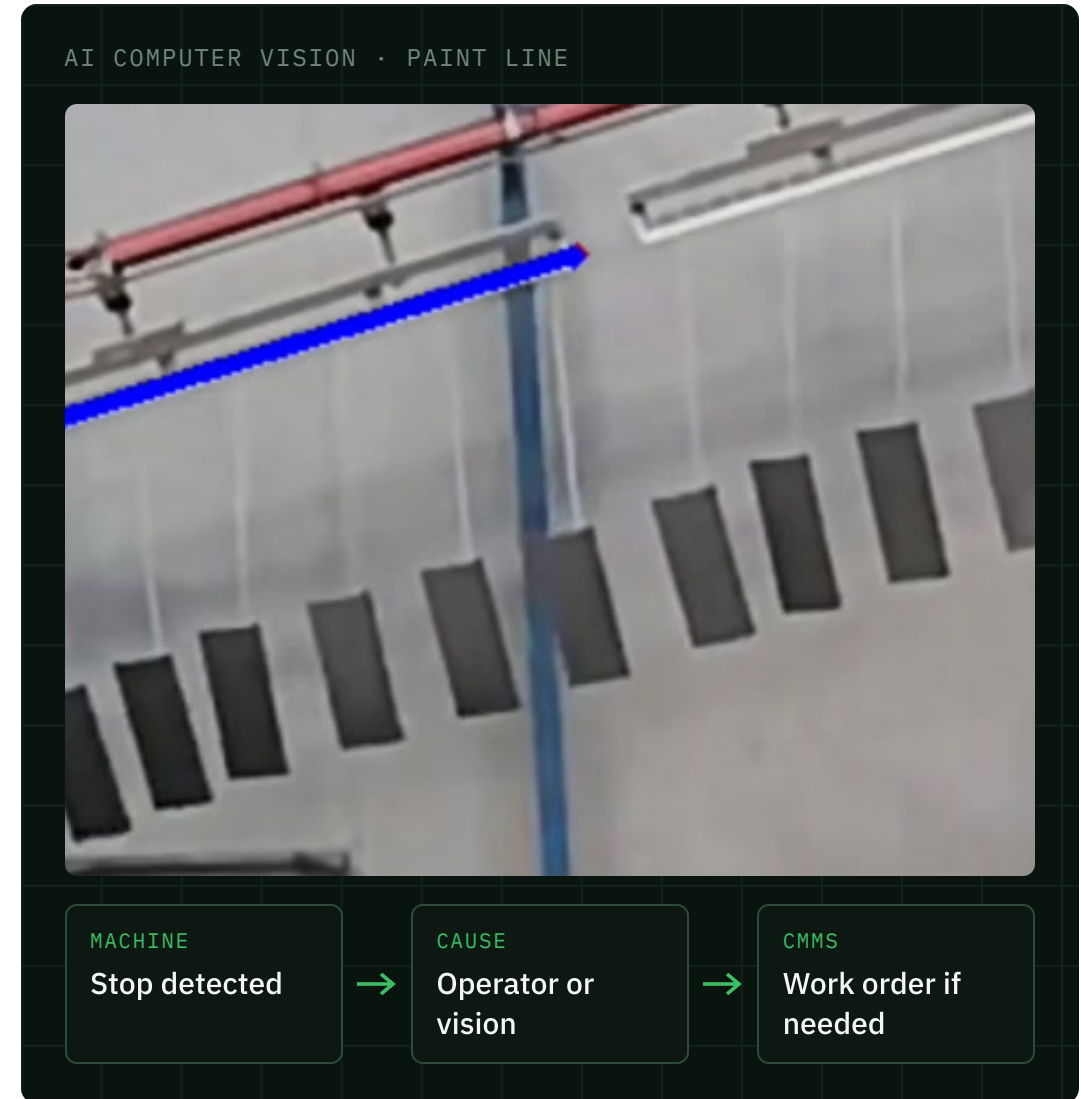


Run this field guide on machine data

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 can become a maintenance work order** in the same system
- ✓ **Web, iOS and Android apps**, with a multi-language UI

[Request a demo](#)





NEXT STEP

Put a cause on every stop

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