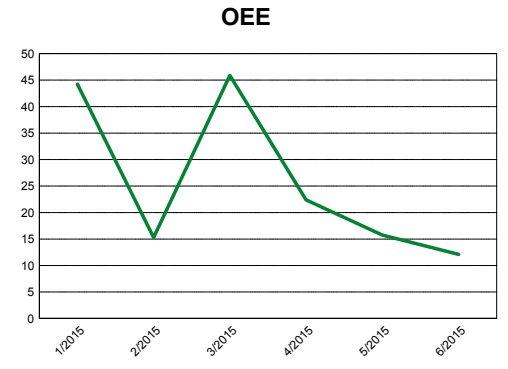
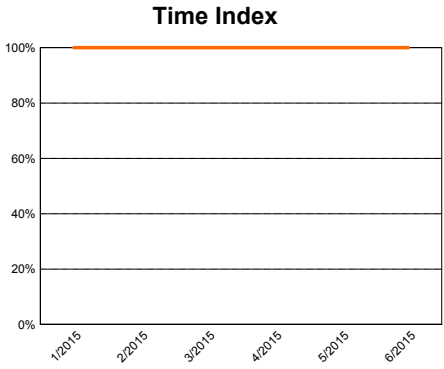
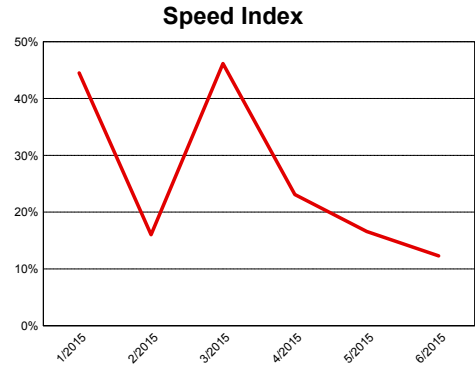
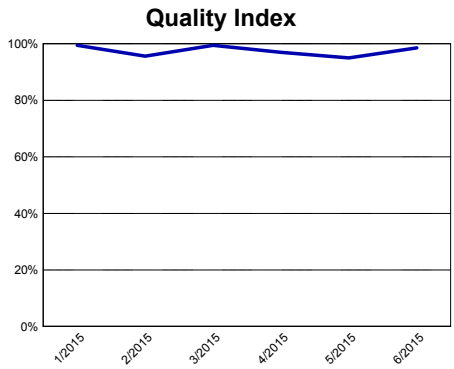


# Monthly Overall Equipment Effectiveness (OEE) Analysis

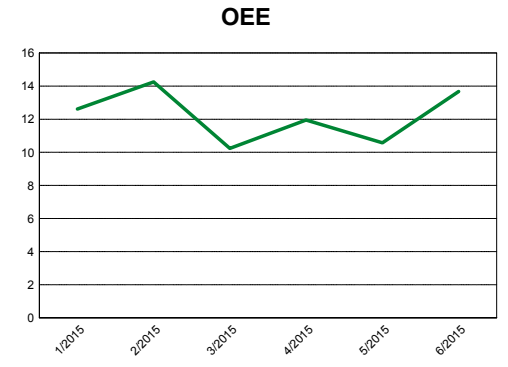
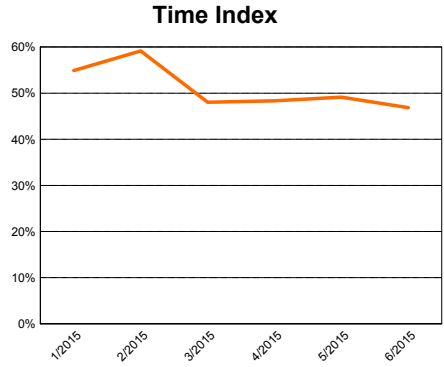
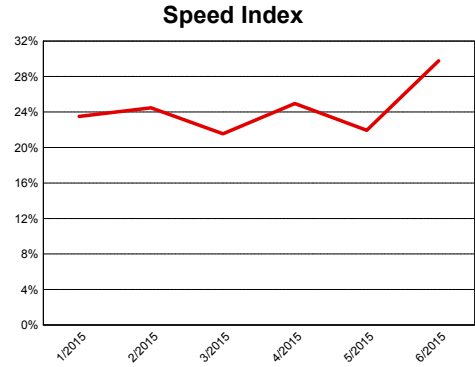
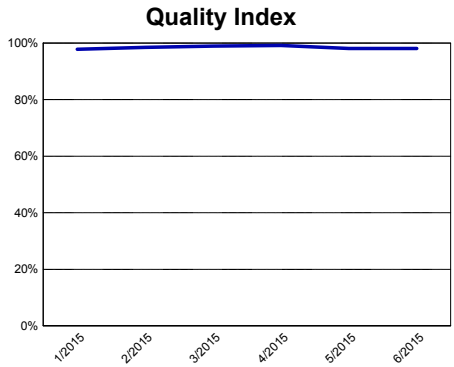
Shift Date: 1/1/2015-6/30/2015

Print Date: 7/9/2015 2:09:07PM

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE	Page: 1
<b>340-Indigo Labor</b>									
<b>3400-HP Indigo 5600 1 side</b>									
January 2015	47.61	127,858	127,083	47.61	0.99	0.44	1.00	44%	
February 2015	39.45	39,635	37,885	39.45	0.96	0.16	1.00	15%	
March 2015	63.42	176,558	175,567	63.42	0.99	0.46	1.00	46%	
April 2015	28.69	41,011	39,763	28.69	0.97	0.23	1.00	22%	
May 2015	27.88	29,217	27,747	27.88	0.95	0.17	1.00	16%	
June 2015	35.08	26,245	25,847	35.08	0.98	0.12	1.00	12%	
<b>Totals</b>	<b>242.13</b>	<b>874,416</b>	<b>433,892</b>	<b>242.13</b>	<b>0.98</b>	<b>0.30</b>	<b>1.00</b>	<b>29.87%</b>	



<b>3400-HP Indigo 5600 2 sides</b>									
January 2015	153.89	60,923	59,561	84.48	0.98	0.24	0.55	13%	
February 2015	154.62	68,190	67,141	91.45	0.98	0.24	0.59	14%	
March 2015	159.60	50,071	49,535	76.65	0.99	0.22	0.48	10%	
April 2015	123.17	44,932	44,545	59.51	0.99	0.25	0.48	12%	
May 2015	131.25	43,260	42,431	64.47	0.98	0.22	0.49	11%	
June 2015	164.07	69,987	68,635	76.87	0.98	0.30	0.47	14%	
<b>Totals</b>	<b>886.60</b>	<b>669,211</b>	<b>331,848</b>	<b>453.42</b>	<b>0.98</b>	<b>0.24</b>	<b>0.51</b>	<b>12.48%</b>	



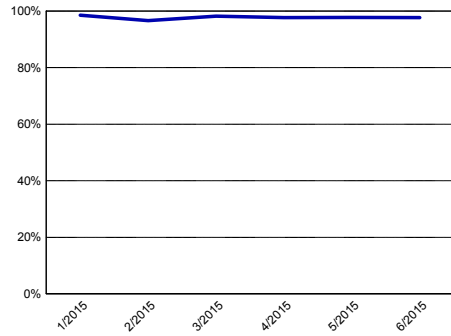
**360-Kodak DI Labor**

**3600-Kodak DI**

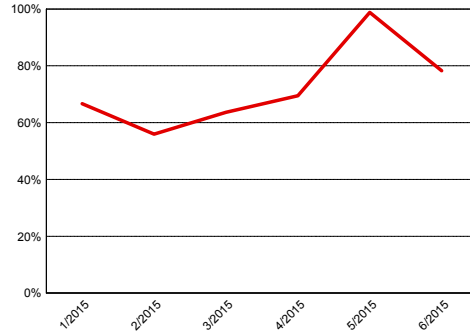
Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	86.07	158,572	156,222	52.12	0.99	0.67	0.61	40%
February 2015	133.03	200,526	193,701	77.03	0.97	0.56	0.58	31%
March 2015	143.89	271,278	266,324	93.06	0.98	0.64	0.65	40%
April 2015	81.49	153,383	149,773	47.96	0.98	0.69	0.59	40%
May 2015	35.91	89,050	87,040	19.59	0.98	0.99	0.55	53%
June 2015	49.71	110,350	107,800	30.61	0.98	0.78	0.62	47%

<b>Totals</b>	<b>530.11</b>	<b>983,159</b>	<b>960,860</b>	<b>320.37</b>	<b>0.98</b>	<b>0.67</b>	<b>0.60</b>	<b>39.39%</b>
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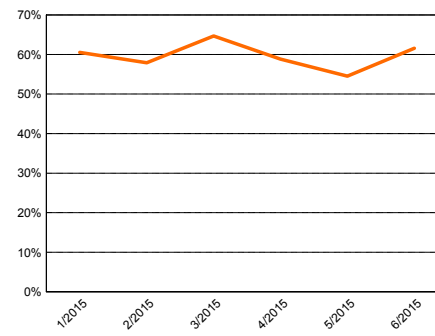
**Quality Index**



**Speed Index**



**Time Index**



**OEE**

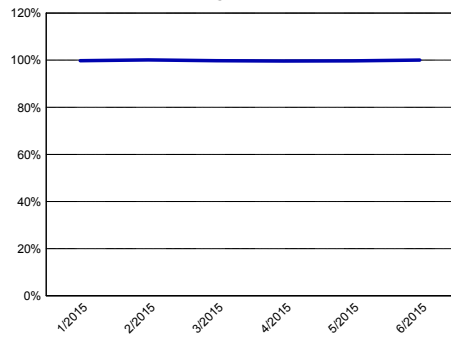


**400-Man Roland Labor**

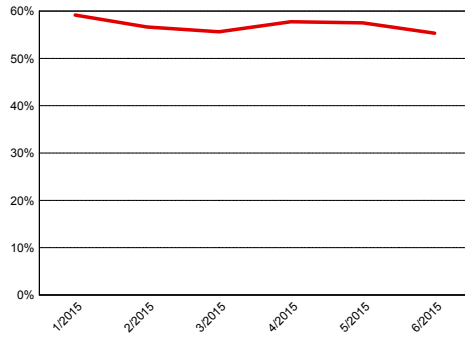
**4000-Man Roland 500**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	300.08	883,594	881,323	93.18	1.00	0.59	0.31	18%
February 2015	428.79	1,062,905	1,063,620	117.46	1.00	0.57	0.27	16%
March 2015	687.47	1,980,111	1,975,073	222.10	1.00	0.56	0.32	18%
April 2015	292.84	919,530	915,897	99.17	1.00	0.58	0.34	19%
May 2015	377.59	1,207,568	1,203,609	130.85	1.00	0.58	0.35	20%
June 2015	483.13	1,218,738	1,219,251	137.87	1.00	0.55	0.29	16%
<b>Totals</b>	<b>2,569.90</b>	<b>7,272,446</b>	<b>7,258,773</b>	<b>800.64</b>	<b>1.00</b>	<b>0.57</b>	<b>0.31</b>	<b>17.63%</b>

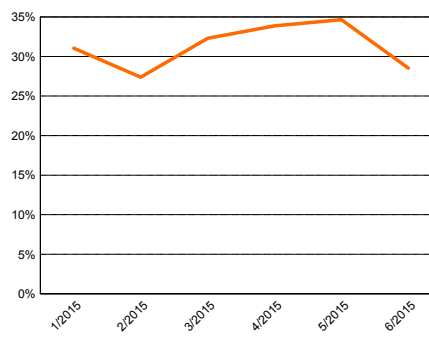
**Quality Index**



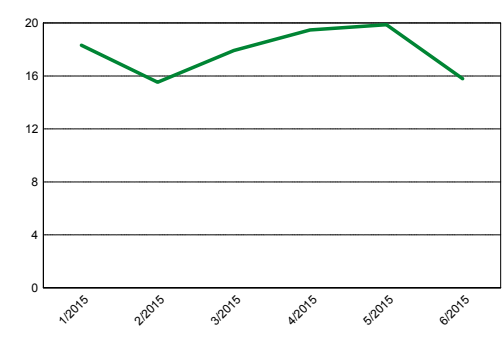
**Speed Index**



**Time Index**



**OEE**

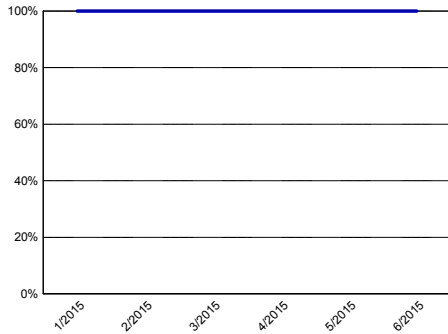


**500-Folding Carton Cnstr Labo**

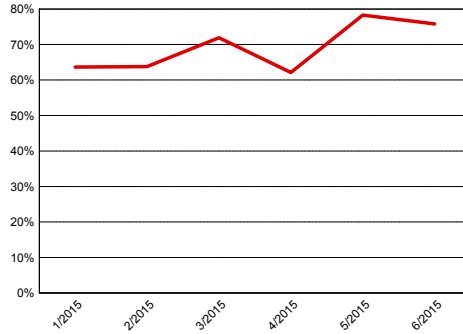
**5030-Sanwa Diecutter**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	126.15	299,946	299,946	67.89	1.00	0.64	0.54	34%
February 2015	93.20	187,573	187,573	42.50	1.00	0.64	0.46	29%
March 2015	210.84	683,671	683,671	136.42	1.00	0.72	0.65	47%
April 2015	94.25	174,213	174,213	40.50	1.00	0.62	0.43	27%
May 2015	134.65	450,840	450,840	82.80	1.00	0.78	0.61	48%
June 2015	146.09	465,500	465,500	88.10	1.00	0.76	0.60	46%
<b>Totals</b>	<b>805.19</b>	<b>2,261,743</b>	<b>2,261,743</b>	<b>458.20</b>	<b>1.00</b>	<b>0.71</b>	<b>0.57</b>	<b>40.38%</b>

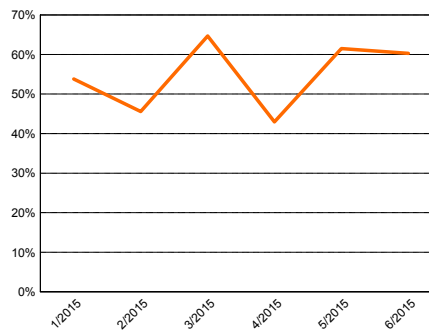
**Quality Index**



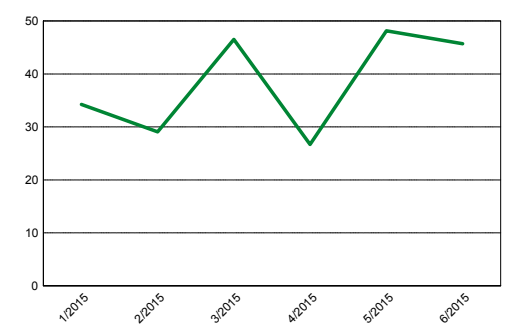
**Speed Index**



**Time Index**



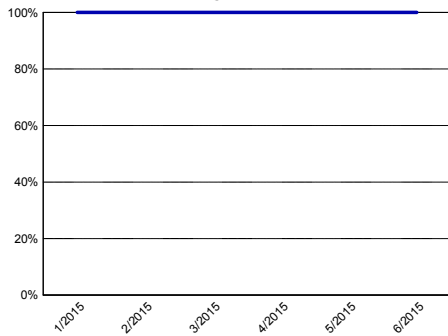
**OEE**



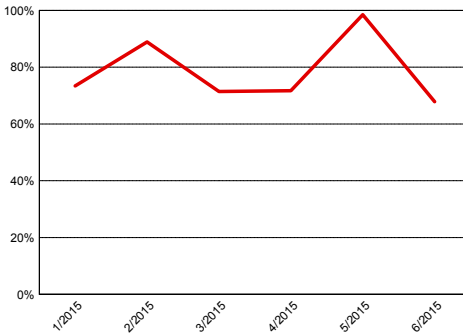
**5050-Heidelberg Easy Gluer**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	125.30	772,379	772,379	88.63	1.00	0.73	0.71	52%
February 2015	71.55	430,198	430,198	40.82	1.00	0.89	0.57	51%
March 2015	197.90	1,178,704	1,178,704	138.81	1.00	0.71	0.70	50%
April 2015	70.06	454,572	454,572	53.34	1.00	0.72	0.76	55%
May 2015	125.12	1,064,441	1,064,441	90.78	1.00	0.98	0.73	71%
June 2015	186.53	795,380	795,380	99.75	1.00	0.68	0.53	36%
<b>Totals</b>	<b>776.47</b>	<b>4,695,674</b>	<b>4,695,674</b>	<b>512.14</b>	<b>1.00</b>	<b>0.77</b>	<b>0.66</b>	<b>50.97%</b>

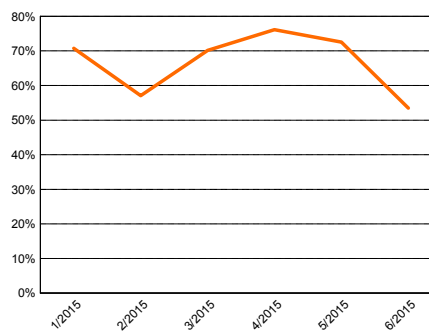
**Quality Index**



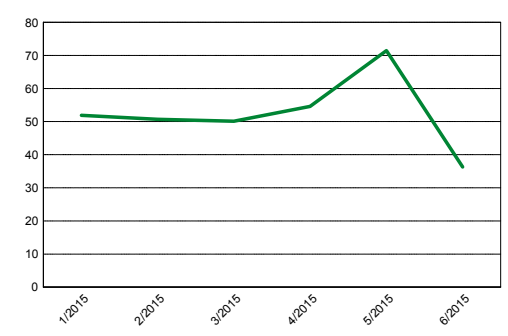
**Speed Index**



**Time Index**



**OEE**



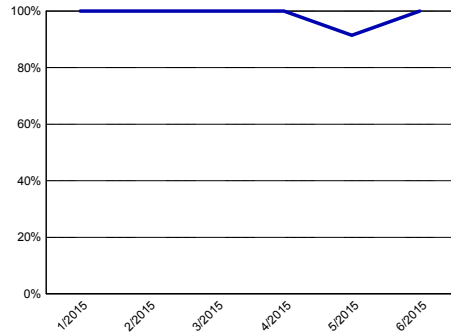
**600-Blumer Labor**

**6000-Blumer**

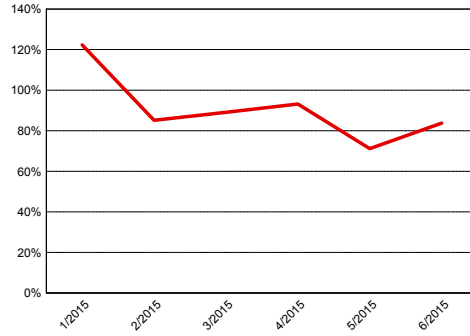
Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	60.37	30,534,000	30,534,000	41.66	1.00	1.22	0.69	84%
February 2015	44.61	12,917,000	12,917,000	25.29	1.00	0.85	0.57	48%
March 2015	82.45	25,562,000	25,561,000	47.89	1.00	0.89	0.58	52%
April 2015	101.67	32,896,501	32,896,501	58.92	1.00	0.93	0.58	54%
May 2015	55.49	13,724,000	12,549,000	29.46	0.91	0.71	0.53	35%
June 2015	134.99	40,726,000	40,725,000	81.22	1.00	0.84	0.60	50%

Totals	479.57	156,359,501	155,182,501	284.43	0.99	0.91	0.59	53.60%
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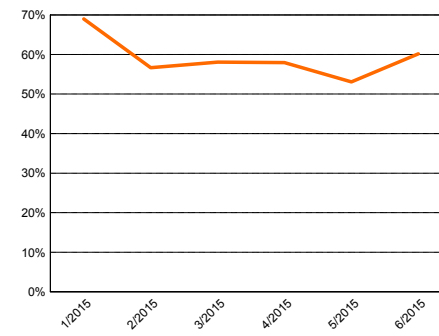
**Quality Index**



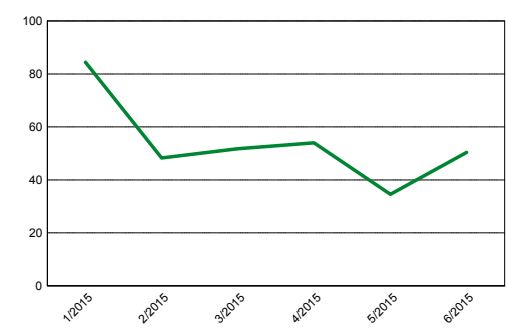
**Speed Index**



**Time Index**



**OEE**

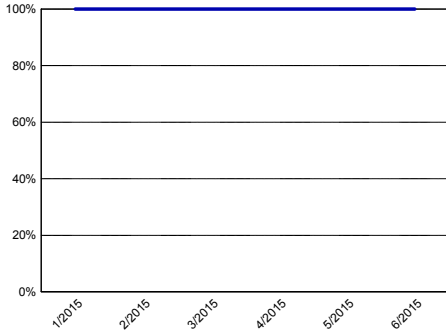


**700-Finishing Labor**

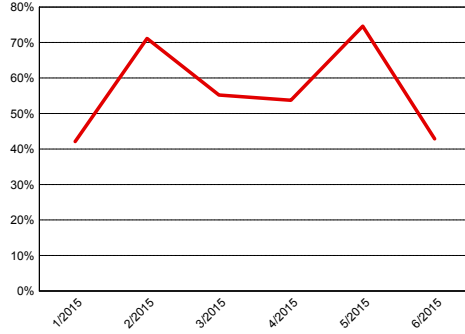
**7400-Stahl Folder**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	74.18	187,922	187,922	46.23	1.00	0.42	0.62	26%
February 2015	110.49	451,965	451,965	64.88	1.00	0.71	0.59	42%
March 2015	86.40	227,086	227,086	42.12	1.00	0.55	0.49	27%
April 2015	158.74	538,399	538,399	101.05	1.00	0.54	0.64	34%
May 2015	84.74	391,583	391,583	53.21	1.00	0.75	0.63	47%
June 2015	112.80	211,863	211,863	51.75	1.00	0.43	0.46	20%
<b>Totals</b>	<b>627.35</b>	<b>2,008,818</b>	<b>2,008,818</b>	<b>359.23</b>	<b>1.00</b>	<b>0.57</b>	<b>0.57</b>	<b>32.68%</b>

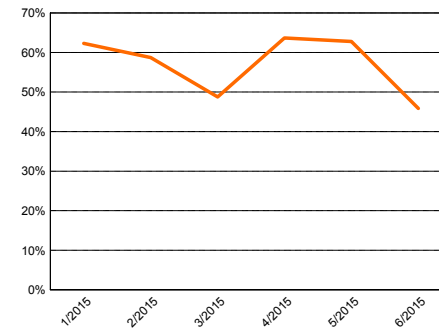
**Quality Index**



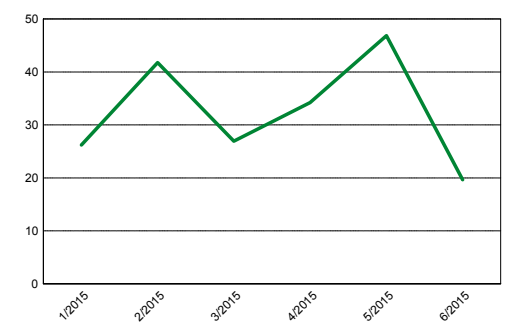
**Speed Index**



**Time Index**



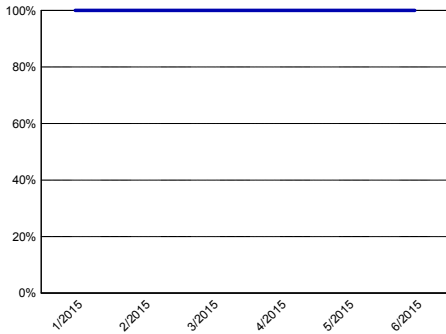
**OEE**



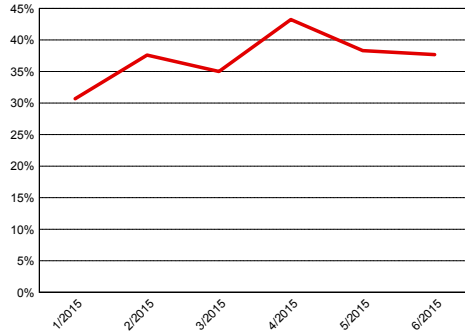
**7450-Muller Martini Saddle Stitcher**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	11.05	16,084	16,084	6.68	1.00	0.31	0.60	19%
February 2015	20.58	32,990	32,990	11.13	1.00	0.38	0.54	20%
March 2015	11.20	17,621	17,621	6.47	1.00	0.35	0.58	20%
April 2015	18.38	47,282	47,282	13.75	1.00	0.43	0.75	32%
May 2015	23.28	45,107	45,107	14.80	1.00	0.38	0.64	24%
June 2015	9.10	12,834	12,834	4.38	1.00	0.38	0.48	18%
<b>Totals</b>	<b>93.60</b>	<b>171,918</b>	<b>171,918</b>	<b>57.21</b>	<b>1.00</b>	<b>0.38</b>	<b>0.61</b>	<b>23.25%</b>

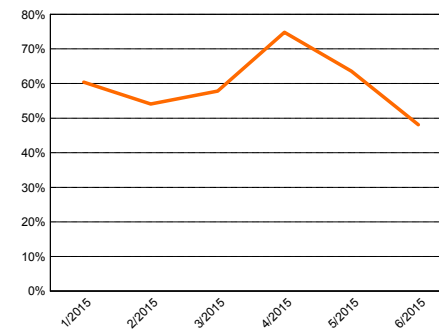
**Quality Index**



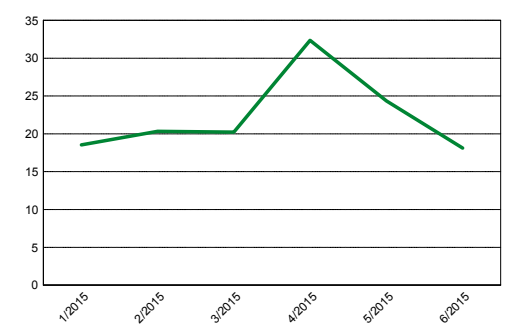
**Speed Index**



**Time Index**

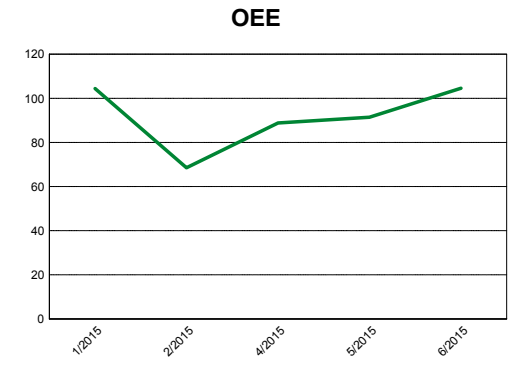
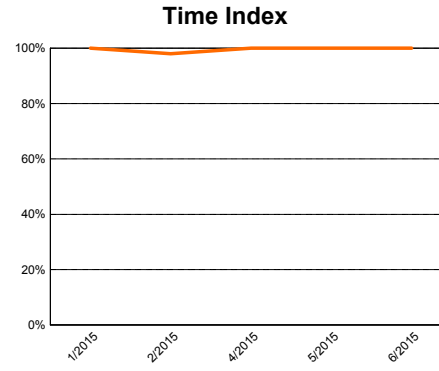
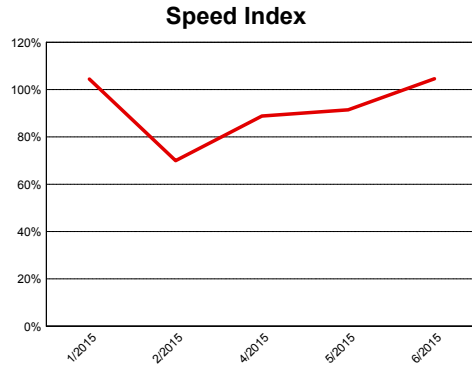
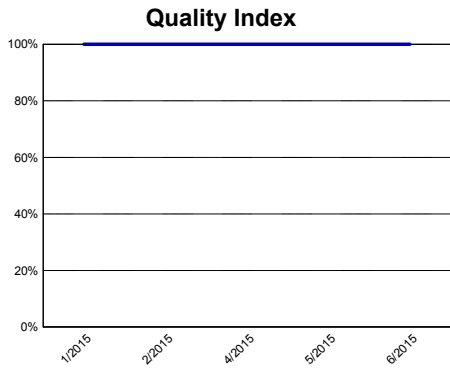


**OEE**



**7500-Setmaster Collator**

Date	Total Hours	Gross Count	Net Count	Production Time	Quality Index	Speed Index	Time Index	OEE
January 2015	9.38	9,800	9,800	9.38	1.00	1.04	1.00	104%
February 2015	32.07	21,973	21,973	31.42	1.00	0.70	0.98	69%
April 2015	17.34	15,399	15,399	17.34	1.00	0.89	1.00	89%
May 2015	5.26	4,806	4,806	5.26	1.00	0.91	1.00	91%
June 2015	8.40	8,780	8,780	8.40	1.00	1.05	1.00	105%
<b>Totals</b>	<b>72.45</b>	<b>60,758</b>	<b>60,758</b>	<b>71.80</b>	<b>1.00</b>	<b>0.85</b>	<b>0.99</b>	<b>83.87%</b>



**7550-Horizon Perfect Binder**

January 2015	26.95	1,600	1,600	7.18	1.00	0.19	0.27	5%
February 2015	30.47	6,362	6,362	10.90	1.00	0.49	0.36	18%
March 2015	29.38	4,271	4,271	12.26	1.00	0.30	0.42	12%
April 2015	33.09	6,256	6,256	12.73	1.00	0.42	0.38	16%
May 2015	24.77	3,188	3,188	6.49	1.00	0.42	0.26	11%
June 2015	28.29	4,095	4,095	9.12	1.00	0.38	0.32	12%
<b>Totals</b>	<b>172.95</b>	<b>25,772</b>	<b>25,772</b>	<b>58.69</b>	<b>1.00</b>	<b>0.37</b>	<b>0.34</b>	<b>12.63%</b>

