

IFA AUDIT: OEE INFORMATION

INFORMATION: Information is the foundation and starting point of IFA. Excellent information is a precondition for effective decision-making. Mark each of the following ten (10) characteristics that you practice consistently with a “Yes”.

Characteristic	Description	Y/N
Constraint is Monitored	Information is captured for the constraint (bottleneck) of the process. Focusing improvement efforts on the constraint ensures optimal use of resources and is the fastest route to improved productivity.	
Ideal Cycle Times are Accurate	Accurate (verified) Ideal Cycle Times are available for all parts and represent the maximum theoretical speed of the process (NOT ‘budget’ or ‘standard’ speeds that are slower than the maximum).	
Reasons are Captured	Reasons are captured for all planned and unplanned stops. Reasons are simple (no more than 20 or 30), accurate (automated capture of duration), and insightful (periodically reviewed for relevance).	
Six Big Losses are Tracked	The Six Big Losses (Setups, Breakdowns, Slow Cycles, Small Stops, Startup Rejects, and Production Rejects) are all tracked for a comprehensive understanding of lost productivity.	
Top Losses are Reported	Top Loss reports are available for arbitrary time periods, shifts, and parts. Top Loss reports are an important way to identify the smallest set of improvement actions that will yield the biggest results.	
SMART Goals are Communicated	SMART (Specific, Measurable, Achievable, Realistic, and Time-Specific) goals are communicated to the plant-floor (e.g., targets for OEE, Down Time, Changeover Time, Cycle Time, and/or Good Pieces).	
Information is Real-Time	Information is real-time, enabling proactive responses by employees. In other words, employees have the information they need when they need it to “win their shift”.	
Information is Accurate	Information (e.g., piece counts, production times, and stop reasons) is periodically audited to verify that it is accurate (and relevant).	
Standards are Documented	Standards for OEE calculations are documented and applied to ensure consistency. For example, there is a standard for whether changeovers, planned maintenance and/or breaks are included in planned production time.	
Training is Formalized	There is a formal training program to ensure that all employees understand OEE and the associated losses. Operators and supervisors can explain how they can affect and improve the metrics used in their area.	

Total up your “Yes” answers and enter your score. Then brainstorm and write down ideas for improvement.

Score



Like a chain, IFA is only as strong as its weakest link. All three factors (Information, Focus, and Action) must be present and in balance to achieve optimal Results. Score all three IFA factors to see which part of your process most needs improvement.