**Conditions for Idle**

-> No batch made but machine is on

- Current and Voltage > 0A, 0V

- Energy Rate = 0

**Conditions for Downtime**

-> Malfunction or Repair that causes the machine to be switched off

- Current and voltage = 0A, 0V

**Conditions for Working**

- Current and Voltage > 0A, 0V

- Energy Rate > 0

**Conditions for Batch to have finished**

- In Idle Mode

- No water flow after 5min

**Conditions for 1 beverage to be completed in a batch**

- In Working Mode

- No water flow after 5s

-------------------------------------------------------------**OEE**-------------------------------------------------------------

**Availability Calculation**

Run Time = Working Duration

Planned Production Time = Run Time + Idle Duration + Downtime Duration

Availability = Run Time / Planned Production Time [Set by operator at the start of each day]

**Performance Calculation**

Performance = (No. of Item per Batch \* Min Time per Item \* Total Batch Count) / Run Time

**Quality Calculation (KIV)**

Quality = Good Count / Total Count

**OEE Calculation**

OEE Score = Availability \* Performance \* Quality