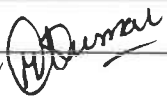
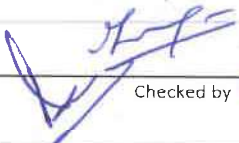


MUSASHI		RULE			B secret		OEE AND LOSS TIME DATA ENTRY AND IMPROVEMENT	
Rule No.	Issue	Rev.	Date	Page				
ISD-MS-001	01	03	Aug.2017	01 of 01				
S No.	Activity	Frequency	Responsibility	Check point				
P	<b>PLAN OR TARGET SETTING</b>							
	1.1) In case of new development , PE depp. Will provide the logical OEE & loss time target sheet of machine with new develop model & these plan value will be the target for QCD & production depp.	Before QCD 2	PE	Approved copy				
	1.2) If we maintain the actual OEE more than target for continue six month (April to September or October to March) then change the target by average of last six month OEE +1%.(need to revise the loss time target setting accordingly)	April and October	Section head (Prod.)	OEE data entry sheet				
	1.3) If machine layout ,process change, cycle time change & new model add then need to review of OEE & loss time target setting again	PCJS	Section head (Prod.)	Approved copy of PCJS				
	1.4) Need to communicate the any revision of OEE & loss time target value with ME / PE and PPC after approval of Prod. H.O.D	As per requierment	OEE controlling person	Capacity calculation				
D	<b>DATA MONITORING</b>							
	2.1)Production depp. Has to be recorded the loss time /production quantity and defect quantity in there Log book shift wise/ day wise	Every running shift	Filled by Shift Incharge & Approved by Sec. Head (Prod.)	Production Log book				
	2.2)Data entry person has to be recorded all details from Log book to OEE monitoring sheet machine wise	Every day	Data entry person	OEE data entry sheet				
	2.3)Data entry has been verified by section incharge and engineers for every machine	Daily Weekly	Shift Incharge (prod.) Section head (prod.)	Check Sheet				
C	<b>ANALYSIS</b>							
	3.1)If Actual OEE of month is less than target by 3% (OEE summery sheet target set by Depp.),we have to analyz the data and find the gap between plan loss and actual loss through WHY-WHY & PDCA FORMAT (ISF-MS-026B)	Every Month	Section Head (Prod.)	Format No.-ISF-MS-026B				
	3.2)If there are any capacity issue to fulfill the customer demand,we have to analyz the data and find the gap between plan loss and actual loss through WHY-WHY & PDCA FORMAT (ISF-MS-026B)	Every Month	Section Head (Prod.)	Format No.-ISF-MS-026B				
A	<b>IMPROVEMENT</b>							
	4.1) We need to improve the OEE by reduction of loss time through various kaizen and Countremeasure and it should be prioritze on the basis of their impact /feasibility and management approval	Every month	Section head (Prod.)	Concerned Section PRM				
	4.2)We have to implement the kaizen for unknown loss ,where actual unknown loss is more then 3%	Every Month	Section head (Prod.)	Unknown loss monitoring sheet				
Prepared by 		Checked by 		Approved by 