16.06.2021

**OEE calculations in Smart System:**

**We use the below DIN standard for calculating the OEE.**

**Timeline

Description automatically generated**

Please note below points:

1. The changeover is split in 2 parts. Standard time and excess time. The standard time is removed from theoretical time. The excess time is removed from Planned production time to arrive Gross operating time.
2. Minor time (fault / manual stop) is below 5 minutes.
3. Shift report and live shift dashboard the OEE will be different from final OEE in batch / Output report. The reason for this is, the standard changeover time is divided between all the shift where the Changeover was done.