Stop Cause Classification Guide

OEE 1: Loss during operation (red)

The OEE 1 measure is associated with the time that the production line is scheduled to be running. In an ideal world, the OEE 1 measure would be equal to 100%, meaning that the line would simply be running at its validated speed. Several circumstances can, however, cause the line to stop or run slower than expected. These stops are unplanned and redundant in nature. Below are some examples of circumstance categories and specific stop causes:

Category	Stop Cause	Description/Comment
Machine Defects*	Malfunction of Machine-Part X	
	Re-set of Machine X	
Process Defects*	PO Missing	
	Material Missing	
	Jam at Machine X	
	Breakage of Material X	
	Print Fault	
Waiting	Consulting Expert	
	Waiting for Operator	
	Waiting for Material	
	Waiting for Maintenance	
	Maintenance in-progress	
Utilities	Power Cut	
IT	Computer Down	
	Network Issue	
Cleaning	Cleaning after Breakage	

Note: If there are many stop causes related to the specific machines/processes, it makes sense to define categories for each of those machines/processes!

OEE 2: Loss during batch changeover (yellow)

The OEE 2 measure is associated with the time that the production line is not running due to batch changeovers. These stops are planned in nature, meaning that it is anticipated that the line will regularly stop for changeover activities between batches. Below are some examples of activity categories and specific stop causes:

Category	Stop Cause	Description/Comment
Batch Changeover	Preparation of Machine X	
	Retooling of Machine X	
	Quality Check	
	Start-up Time	
Resupply	Resupply of Product X	
	Resupply of Label X	
	Resupply of Packaging X	
Cleaning	Cleaning at End of Shift	
	Weekly Cleaning	

OEE 3: Loss due to non-production activities (grey)

The OEE 3 measure is associated with the time that the production line is not running due to other activities. These stops are planned in nature, meaning that it is anticipated that the line will regularly stop for these activities to be performed. Below are some examples of activity categories and specific stop causes:

Category	Stop Cause	Description/Comment
Planned Maintenance	Preventive Maintenance	
	Auto-Maintenance	
Validation	Validation Test	
Personnel Activities	Break	
	Team Meeting	
	New Operator Training	
	Other Training	

TCU: No activity at line (blue)

The TCU measure is associated with the time that the production line is not running because there is no activity at the line. These stops are planned in nature, meaning that it is anticipated that the line will not run during these periods of time. Below are some examples of specific stop causes:

Category	Stop Cause	Description/Comment
No activity at line	Weekend	
	Holiday	
	Non-Production Time	