

Final Assembly Productivity Report

Item	Model	Update (date)	Line No	Takt time (s)	Output (max) (pc)	Prod (max) (%)	Output at 100% Prod	Ob time (hr/unit)	Current worker (person)	Output (actual) (pc)	Prod (actual) (%)
1	LKD-30D	4-Oct	2A	26	138	76.6	181	0.083	15	100	55.3
2	LDP-6030DHG	4-Oct	3A	30	120	79.5	151	0.106	16	80	53.0
3	LIP-6812D	4-Oct	4A	30	120	84.0	143	0.105	15	80	56.0
4	LIP-6830D	9-Oct	4A	30	120	88.8	135	0.111	15	80	59.2
5	LVP-1900URL	3-Oct	1A	24	150	86.4	174	0.121	21	100	57.6
6	GT-7191	9-Oct	1B	24	150	83.4	180	0.089	16	120	66.8
7	GT-8502	10-Oct	1B	24	150	98.4	152	0.105	16	96	63.0
Overall productivity				26.9	135.5	85.3	159.3	0.103	16.3	93.7	58.7

Overall Equipment Effectiveness (OEE)

Item	Building	Area/ Line	Current/ baseline data				Remark
			Availability rate %	Performance rate %	Quality rate %	OEE rate %	
1	A	SMD1	78.28	91.11	95.00	71.32	- AR&PR from 1-15 Oct 07.
2	A	SMD2	70.82	90.12	95.00	63.82	- AR&PR from 1-15 Oct 07.
3	A	SMD3	78.17	94.64	95.00	73.98	- AR&PR from 1-15 Oct 07.
4	A	AI	25.00	90.00	97.00	22.50	- Est AR for the past one month
5	A	AI	50.00	90.00	97.00	45.00	- Est AR for the past one month
6	A	AI	60.00	90.00	97.00	54.00	- Est AR for the past one month
7	A	PCB1	0.00	90.00	90.00	0.00	- Est AR for the past one month
8	A	PCB2	20.00	90.00	90.00	16.20	- Est AR for the past one month
9	A	PCB3	40.00	90.00	90.00	32.40	- Est AR for the past one month
10	A	PCB4	60.00	90.00	90.00	48.60	- Est AR for the past one month
11	B	SMD4	84.92	88.62	95.00	71.49	- AR&PR from 1-15 Oct 07.
12	B	SMD5	74.31	92.27	95.00	65.14	- AR&PR from 1-15 Oct 07.
13	B	AI	0.00	90.00	97.00	0.00	- Failed for year (no plan to repair)
14	B	AI	40.00	90.00	97.00	34.92	- Est AR for the past one month
15	B	AI	50.00	90.00	97.00	43.65	- Est AR for the past one month
16	B	PCB5	0.00	90.00	90.00	0.00	- Est AR for the past one month
17	B	PCB6	80.00	90.00	90.00	64.80	- Est AR for the past one month
18	B	PCB7	80.00	90.00	85.00	61.20	- Est AR for the past one month
Optimization			49.53	90.38	93.44	41.83	
		SMD (5)	77.30	91.35	95.00	67.08	
		AI (6)	37.50	90.00	97.00	32.74	
		PCB (7)	40.00	90.00	89.29	32.14	

