Rod Breakdown + Annealer · Process & Production

Copper rod 8.00 mm → wire 1.74 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
77.78%	87.78%	90.00%	98.45%	18.6 m/s
Provisional · quality hold	395 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Rod payoff	Drawing train	Annealer	Spooler
Cu · Ø8.00 mm	13 drafts	96.0 kW	Ø1.74 mm wire

Process parameters · DEMO-CU-174-R13

Signal	Sample reading	Reference / context
Entry / exit diameter	8.00 / 1.742 mm	8.00 / 1.740 mm
Active drawing drafts	13	13
Final capstan slip	1.8%	Trend / recipe
Annealer power	96.0 kW	Speed-linked recipe
Annealer current	2,400 A	Trend / recipe
Annealer voltage	40.0 V	Trend / recipe
Drawing emulsion	34.2 °C	Example SP 35.0 °C
Spooler dancer	51%	Example centre 50%
Wire-break events	3 / shift	Event counter
Die set identity	DS-174-13-A	Batch traceability

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	426,600
Released first-pass good	420,000
Rejected / first-pass failure	5,000
Pending quality release	1,600

Quality & traceability

Check	Sample
Diameter sample	1.742 mm
Elongation sample	29.6%
Awaiting disposition	1,600 m

Provisional · quality hold. Held output is excluded from good and kept separate from rejects.

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Rod Breakdown + Annealer · OEE & Downtime

Copper rod 8.00 mm → wire 1.74 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
77.78%	87.78%	90.00%	98.45%	18.6 m/s
Provisional · quality hold	395 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	395 / 450	87.78%
Performance	426,600 / (395 × 1,200)	90.00%
Quality	420,000 / 426,600	98.45%
OEE	A × P × Q (unrounded factors)	77.78%

Output basis: Single-wire metres. Ideal rate: 1,200 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	55.00
Speed loss	39.50
Rejected equivalent	4.17
Pending equivalent	1.33
Good equivalent	350.00

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 55 MIN

Wire-break recovery	20 min
Die / setup change	18 min
Spool handling	10 min
Cooling interruption	7 min

PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
2,100 kWh

ENERGY / ACCEPTED OUTPUT
5.00 kWh
per 1,000 m

Source: individual machine dashboards, pages 2–3. All values are synthetic examples.

Multi-wire Drawing + Annealer · Process & Production

16 copper wires · 1.74 mm → 0.40 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
80.25%	90.00%	90.00%	99.07%	28.5 m/s
Provisional · quality hold	405 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Multi-payoff	Drawing train	Annealer	Bundle take-up
16 approved lanes	22 drafts	165 kW	656,100 line-m

Process parameters · DEMO-CU-040-16W

Signal	Sample reading	Reference / context
Approved / active wires	16 / 16	16-wire recipe
Entry diameter	1.740 mm	1.740 mm
Exit diameter span	0.398-0.402 mm	Nominal 0.400 mm
Drawing drafts	22	22
Annealer power	165 kW	Speed-linked recipe
Bundle dancer	49%	Example centre 50%
Per-wire tension sample	5.8 N	Example SP 6.0 N
Drawing emulsion	34.5 °C	Example SP 35.0 °C
Wire-break events	6 / shift	Lane-level event log
Total bundle travel	656,100 m	×16 = 10,497,600 wire-m

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (wire-m)
Total produced	10,497,600
Released first-pass good	10,400,000
Rejected / first-pass failure	67,600
Pending quality release	30,000

Quality & traceability

Check	Sample
Diameter range	0.398-0.402 mm
Lane defect length	67,600 wire-m
Awaiting disposition	30,000 wire-m

Provisional · quality hold. Held output is excluded from good and kept separate from rejects.

Multi-wire Drawing + Annealer · OEE & Downtime

16 copper wires · 1.74 mm → 0.40 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
80.25%	90.00%	90.00%	99.07%	28.5 m/s
Provisional · quality hold	405 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	405 / 450	90.00%
Performance	10,497,600 / (405 × 28,800)	90.00%
Quality	10,400,000 / 10,497,600	99.07%
OEE	A × P × Q (unrounded factors)	80.25%

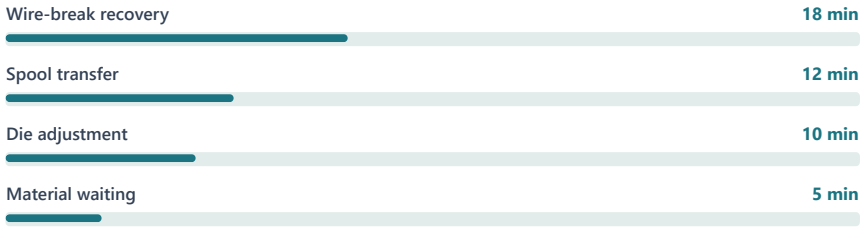
Output basis: Sum of wire-metres across 16 approved lanes. Ideal rate: 28,800 wire-m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	45.00
Speed loss	40.50
Rejected equivalent	2.35
Pending equivalent	1.04
Good equivalent	361.11

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 45 MIN



PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
1,650 kWh

ENERGY / ACCEPTED OUTPUT
0.16 kWh
per 1,000 wire-m

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Rigid Stranding Line · Process & Production

240 mm² Cu · 61 wires · 6+12+18+24 cages · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
68.89%	82.22%	85.00%	98.57%	32.0 m/min
Provisional · quality hold	370 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Payoffs + cages	Compacting	Pulling capstan	Take-up
1+6+12+18+24	Ø18.02 mm	32.0 m/min	Drum D-RST-014

Process parameters · DEMO-CU-240-61W

Signal	Sample reading	Reference / context
6-bobbin cage / lay	177.8 rpm / 180 mm	180 mm · S
12-bobbin cage / lay	145.5 rpm / 220 mm	220 mm · Z
18-bobbin cage / lay	123.1 rpm / 260 mm	260 mm · S
24-bobbin cage / lay	100.0 rpm / 320 mm	320 mm · Z
Incoming wire diameter	2.240 mm	61-wire construction
Conductor diameter	18.02 mm	Example nominal 18.00 mm
Wire tension range	43-47 N	Example SP 45 N
Capstan pulling load	8.2 kN	Trend / recipe
Take-up dancer	50%	Example centre 50%
Wire-break events	2 / shift	Cage / bobbin log

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	12,580
Released first-pass good	12,400
Rejected / first-pass failure	140
Pending quality release	40

Quality & traceability

Check	Sample
Conductor diameter	18.02 mm
Lay records	4 layer records
Awaiting lab release	40 m

Provisional · quality hold. Held output is excluded from good and kept separate from rejects.

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Rigid Stranding Line · OEE & Downtime

240 mm² Cu · 61 wires · 6+12+18+24 cages · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
68.89%	82.22%	85.00%	98.57%	32.0 m/min
Provisional · quality hold	370 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	370 / 450	82.22%
Performance	12,580 / (370 × 40)	85.00%
Quality	12,400 / 12,580	98.57%
OEE	A × P × Q (unrounded factors)	68.89%

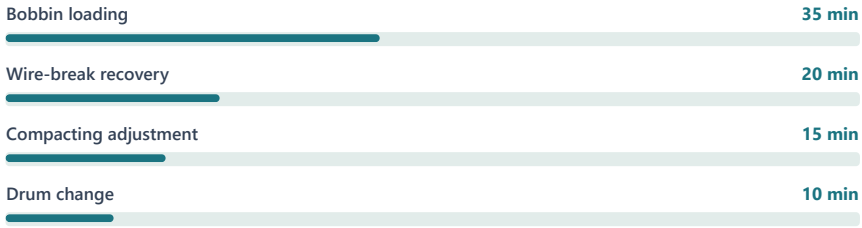
Output basis: Finished conductor axial length. Ideal rate: 40 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	80.00
Speed loss	55.50
Rejected equivalent	3.50
Pending equivalent	1.00
Good equivalent	310.00

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 80 MIN



PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
620 kWh

ENERGY / ACCEPTED OUTPUT
50.00 kWh
per 1,000 m

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Steel Wire Armouring Line · Process & Production

SWA 64 × 2.00 mm · cable under armour Ø45 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
71.70%	86.67%	84.00%	98.49%	12.6 m/min
Provisional · quality hold	390 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Cable payoff	Armouring cage	Closing + haul-off	Take-up
Ø45.0 mm input	64 steel wires	350 mm lay · Z	Ø49.04 mm output

Process parameters · DEMO-SWA-64-200

Signal	Sample reading	Reference / context
Armouring head speed	36.0 rpm	12.6 m/min / 0.350 m
Armour lay length	350 mm	Example nominal 350 mm
Lay direction	Z	Recipe Z
Loaded / required wires	64 / 64	64-wire recipe
Steel wire diameter	2.00 mm	Example nominal 2.00 mm
Under-armour diameter	45.00 mm	Example nominal 45.00 mm
Over-armour diameter	49.04 mm	Example nominal 49.00 mm
Wire tension range	38-42 N	Example SP 40 N
Haul-off pulling load	6.4 kN	Trend / recipe
Wire-break events	2 / shift	Bobbin-level event log

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	4,914
Released first-pass good	4,840
Rejected / first-pass failure	50
Pending quality release	24

Quality & traceability

Check	Sample
Lay sample	350 mm
Armour inspection	50 m rejected
Awaiting inspection	24 m

Provisional · quality hold. Held output is excluded from good and kept separate from rejects.

Steel Wire Armouring Line · OEE & Downtime

SWA 64 × 2.00 mm · cable under armour Ø45 mm · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
71.70%	86.67%	84.00%	98.49%	12.6 m/min
Provisional · quality hold	390 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	390 / 450	86.67%
Performance	4,914 / (390 × 15)	84.00%
Quality	4,840 / 4,914	98.49%
OEE	A × P × Q (unrounded factors)	71.70%

Output basis: Finished armoured cable axial length. Ideal rate: 15 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	60.00
Speed loss	62.40
Rejected equivalent	3.33
Pending equivalent	1.60
Good equivalent	322.67

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 60 MIN

Armour bobbin loading	25 min
Wire-break recovery	15 min
Lay / closing adjustment	12 min
Take-up change	8 min

PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
390 kWh

ENERGY / ACCEPTED OUTPUT
80.58 kWh
per 1,000 m

Source: individual machine dashboards, pages 8–9. All values are synthetic examples.

Insulating Line · Process & Production

Cu conductor / PVC insulation · Illustrative data · No live machine connection · Demo shift 08:00–16:00

Simatech Automation · Industry 4.0 Digitalisation

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
79.20%	88.89%	90.00%	99.00%	116.0 m/min
Quality release complete in sample	400 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Pay-off	Extrusion	Cooling + gauge	Take-up
Tension 420 N	Screw 65 rpm	OD 15.60 mm	116 m/min

Process parameters · DEMO-INS-120-PVC

Signal	Sample reading	Reference / context
Current line speed	116 m/min	Recipe ideal: 120 m/min
Conductor diameter	13.00 mm	Product recipe
Finished diameter	15.60 mm	Gauge measurement
Mean / minimum wall	1.30 / 1.25 mm	Recipe limits required
Extruder screw speed	65 rpm	Recipe dependent
Head melt temperature	176 °C	Illustrative actual only
Melt pressure	178 bar	Illustrative actual only
Cooling-water return	28 °C	Illustrative actual only
Spark-event count	3 this shift	Map events to cable length
Pay-off tension	420 N	Illustrative actual only

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	43,200
Released first-pass good	42,768
Rejected / first-pass failure	432
Pending quality release	0

Quality & traceability

Check	Sample
Diameter + wall	Recipe check logged
Spark defects	Length disposition logged
First-pass rejects	432 m

Quality release complete in sample. Held output is excluded from good and kept separate from rejects.

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Insulating Line · OEE & Downtime

Cu conductor / PVC insulation · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
79.20%	88.89%	90.00%	99.00%	116.0 m/min
Quality release complete in sample	400 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	400 / 450	88.89%
Performance	43,200 / (400 × 120)	90.00%
Quality	42,768 / 43,200	99.00%
OEE	A × P × Q (unrounded factors)	79.20%

Output basis: Axial metres of insulated core. Ideal rate: 120 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	50.00
Speed loss	40.00
Rejected equivalent	3.60
Pending equivalent	0.00
Good equivalent	356.40

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 50 MIN



PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
560 kWh

ENERGY / ACCEPTED OUTPUT
13.09 kWh
per 1,000 m

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Sheathing Line · Process & Production

Multicore LV cable / PVC oversheath · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
76.27%	86.67%	88.89%	99.00%	42.5 m/min
Quality release complete in sample	390 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Pay-off	Sheath extrusion	Cooling + marking	Portal take-up
Core OD 30.00 mm	Screw 42 rpm	OD 34.80 mm	42.5 m/min

Process parameters · DEMO-SHE-35-PVC

Signal	Sample reading	Reference / context
Current line speed	42.5 m/min	Recipe ideal: 45 m/min
Cable core diameter	30.00 mm	Before sheathing
Finished diameter	34.80 mm	Gauge measurement
Mean / minimum wall	2.40 / 2.32 mm	Recipe limits required
Extruder screw speed	42 rpm	Recipe dependent
Head melt temperature	174 °C	Illustrative actual only
Melt pressure	165 bar	Illustrative actual only
Cooling-water return	29 °C	Illustrative actual only
Marker verification	Batch + metre mark	Camera / operator record
Haul-off traction load	61 %	Drive diagnostic

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	15,600
Released first-pass good	15,444
Rejected / first-pass failure	156
Pending quality release	0

Quality & traceability

Check	Sample
Sheath wall + OD	Recipe check logged
Print verification	Sample inspected
First-pass rejects	156 m

Quality release complete in sample. Held output is excluded from good and kept separate from rejects.

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Sheathing Line · OEE & Downtime

Multicore LV cable / PVC oversheath · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
76.27%	86.67%	88.89%	99.00%	42.5 m/min
Quality release complete in sample	390 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	390 / 450	86.67%
Performance	15,600 / (390 × 45)	88.89%
Quality	15,444 / 15,600	99.00%
OEE	A × P × Q (unrounded factors)	76.27%

Output basis: Axial metres of sheathed cable. Ideal rate: 45 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	60.00
Speed loss	43.33
Rejected equivalent	3.47
Pending equivalent	0.00
Good equivalent	343.20

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 60 MIN

Drum changes	24 min
Die / head cleaning	18 min
Feed interruption	10 min
Marker correction	8 min

PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
890 kWh

ENERGY / ACCEPTED OUTPUT
57.63 kWh
per 1,000 m

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Drum Twister · Process & Production

Three-core power cable / laying-up · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
70.37%	80.00%	88.89%	98.96%	11.4 m/min
Quality release complete in sample	360 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Core pay-offs	Closing + taping	Caterpillar	Rotating take-up
3 active cores	Lay 600 mm	11.4 m/min	Rotor 19 rpm

Process parameters · DEMO-DT-3C-600Z

Signal	Sample reading	Reference / context
Current axial speed	11.4 m/min	Recipe ideal: 12 m/min
Lay length / direction	600 mm / Z	Demo product recipe
Take-up rotor speed	19 rpm	Demo: one twist/rev
Core tension 1 / 2 / 3	1.20 / 1.18 / 1.21 kN	Illustrative actual only
Tape-head speed	228 rpm	50 mm axial pitch
Caterpillar load	57 %	Drive diagnostic
Traverse position	840 mm	From drum left flange
Drum fill estimate	67 %	Capacity model required
Laid-up diameter	52.0 mm	Gauge / inspection
Tension spread	0.03 kN	Maximum minus minimum

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	3,840
Released first-pass good	3,800
Rejected / first-pass failure	40
Pending quality release	0

Quality & traceability

Check	Sample
Lay + core sequence	Sample inspected
Tape + surface	Sample inspected
First-pass rejects	40 m

Quality release complete in sample. Held output is excluded from good and kept separate from rejects.

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Drum Twister · OEE & Downtime

Three-core power cable / laying-up · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
70.37%	80.00%	88.89%	98.96%	11.4 m/min
Quality release complete in sample	360 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	360 / 450	80.00%
Performance	3,840 / (360 × 12)	88.89%
Quality	3,800 / 3,840	98.96%
OEE	A × P × Q (unrounded factors)	70.37%

Output basis: Axial metres of laid-up cable. Ideal rate: 12 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	90.00
Speed loss	40.00
Rejected equivalent	3.33
Pending equivalent	0.00
Good equivalent	316.67

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 90 MIN

Pay-off drum changes	38 min
Take-up drum handling	26 min
Taping intervention	16 min
Drive trip response	10 min

PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
240 kWh

ENERGY / ACCEPTED OUTPUT
63.16 kWh
per 1,000 m

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CCV Line · Process & Production

MV XLPE insulated core / triple extrusion · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
70.56%	84.44%	90.00%	92.84%	18.8 m/min
Provisional · quality hold	380 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

Preheat + extrusion	Catenary curing	Cooling + haul-off	Take-up + QC
3 layers	8 zones monitored	18.8 m/min	300 m pending

Process parameters · DEMO-CCV-240-XLPE

Signal	Sample reading	Reference / context
Current line speed	18.8 m/min	Recipe ideal: 20 m/min
Conductor diameter	17.80 mm	Illustrative product
Screen / XLPE / screen	0.70 / 5.50 / 0.80 mm	Mean layer thicknesses
Finished diameter	31.80 mm	X-ray gauge
Minimum XLPE wall	5.35 mm	Approved recipe limit
Catenary position error	+4 mm	From recipe centreline
Curing temperatures	8 channels logged	Validated recipe only
Nitrogen pressure	Tag to be mapped	Validated recipe only
Material traceability	3 compound lots	Link to drum identity
Offline quality release	300 m on hold	OEE provisional

All readings and recipe values shown are illustrative.

Production disposition

Disposition	Quantity (m)
Total produced	6,840
Released first-pass good	6,350
Rejected / first-pass failure	190
Pending quality release	300

Quality & traceability

Check	Sample
Layer geometry	Gauge record logged
Offline batch tests	300 m pending release
First-pass rejects	190 m

Provisional · quality hold. Held output is excluded from good and kept separate from rejects.

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CCV Line · OEE & Downtime

MV XLPE insulated core / triple extrusion · Illustrative data · No live machine connection · Demo shift 08:00–16:00

OEE	AVAILABILITY	PERFORMANCE	QUALITY	LINE SPEED
70.56%	84.44%	90.00%	92.84%	18.8 m/min
Provisional · quality hold	380 / 450 planned min	Whole-run output basis	Released first-pass good / total	Illustrative last sample

480 shift minutes − 30 not scheduled = 450 planned production minutes.

Calculation audit

Factor	Calculation	Result
Availability	380 / 450	84.44%
Performance	6,840 / (380 × 20)	90.00%
Quality	6,350 / 6,840	92.84%
OEE	A × P × Q (unrounded factors)	70.56%

Output basis: Finished insulated-core axial length. Ideal rate: 20 m/min.

450 planned minutes accounted for

Allocation	Minutes
Stop time	70.00
Speed loss	38.00
Rejected equivalent	9.50
Pending equivalent	15.00
Good equivalent	317.50

Rejected, pending and good are equivalent ideal-production minutes, not measured stop durations.

DOWNTIME BY REASON · 70 MIN



PRODUCTION BASIS & ENERGY

SHIFT ELECTRICITY
1,650 kWh

ENERGY / ACCEPTED OUTPUT
259.84 kWh
per 1,000 m

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