OEE Studio

Tool Tip
How to calculate Parts Per Hour and Parts Per Labor Hour

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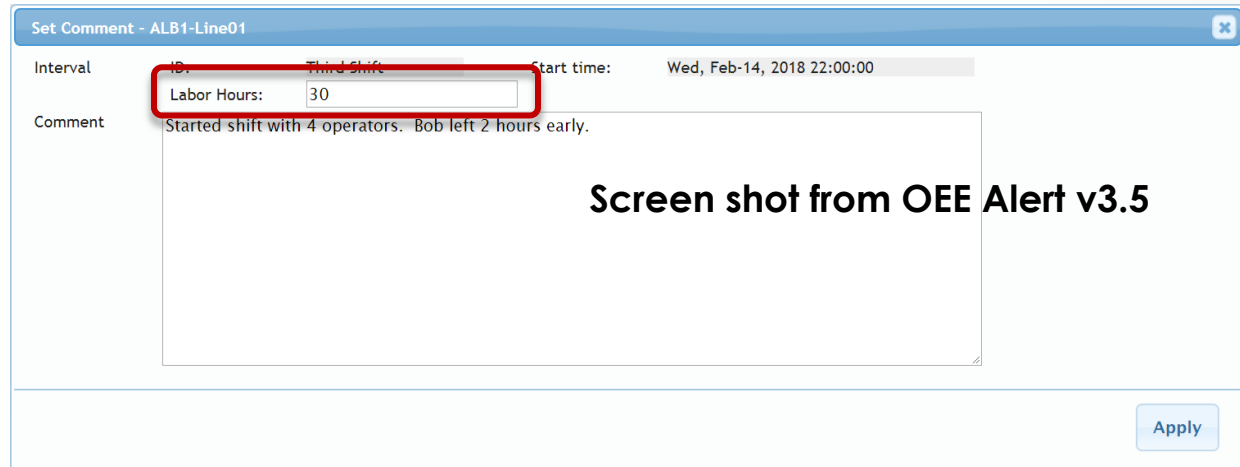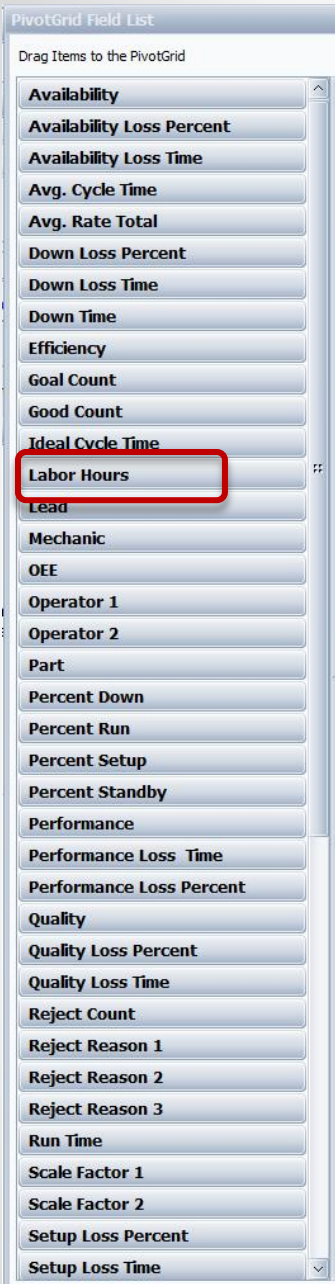Russell@ProductionImprovement.com

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Tool Tip

This **Tool Tip** will show you how to create 2 **Custom Fields** to calculate Parts Per Hour and Parts Per Labor Hour.

- Requires OEE Alert to capture Labor Hours.

New Data Elements from OEE Alert

Screen shot from OEE Alert v3.5

In OEE Alert v3.5, you can enter Labor Hours for each Shift and or Job. This data is then saved with the Shift record and or the Job record.

You can use this value to calculate Parts Per Labor Hour (PPLH).

Calculate Parts Per Hour & Parts Per Labor Hour

Create 2 Custom Defined Fields. (http://oeestudio.com/navigation.html)

New Custom Expression

Options

Field Description: PPH

Result Type:
- ○ Boolean
- ○ Date and Time
- ○ Date Only
- ● Decimal
- ○ Integer
- ○ String
- ○ Currency
- ○ Custom Date Interval

☐ Append Summary Type to the Field Description

If the Field Description is "Cost" and the Summary Type is "Sum", the field will display as Cost (Sum) if this option is chosen.

Otherwise it will simply display as "Cost".

Summary Type:
- ○ Count
- ● Sum
- ○ Min
- ○ Max
- ○ Average
- ○ Std Dev
- ○ Std Dev P
- ○ Var
- ○ Var P

The sum of the values.

☐ Hide Field

☑ Use Summary Values

Expression editor

IIf([Avg. Cycle Time] = 0, 0, 3600 / [Avg. Cycle Time])

New Custom Expression

Options

Field Description: PPLH

Result Type:
- ○ Boolean
- ○ Date and Time
- ○ Date Only
- ● Decimal
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The sum of the values.

☐ Hide Field

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Expression editor

Iif([Avg. Cycle Time] = 0, 0, 3600 / [Avg. Cycle Time] / [Labor Hours])

	Shift		Start Time		End Time		Grand Total					
							Labor Hours	Avg. Cycle Time	PPH	Total Count	Run Time	PPLH
1-Line03	⊟ Third Shift		2/14/2018 11:00 PM		2/15/2018 7:00 AM		30.0	0.37	9,729.73	59,821	05h 46m 21s	324.32

OEE Studio

Check out our website for other Tool Tips

www.oeestudio.com

OEE Studio supports all versions of Vorne XL v1 device firmware.

Smart Installation

http://www.oeestudio.com/installs/release/v4/setup/InstallOEEStudio.exe

If you have questions or need assistance, please contact either

Debbie Olk (OEE Studio, OEE Alert or custom reports)

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