

Real-Time OEE Rollout Playbook: 30-60-90 Days

A day-by-day plan to go from a blind line to live floor visibility that changes decisions — with alerting, operator adoption and KPI cadence.

The premise

Real-time OEE monitoring earns trust by showing value in weeks, not quarters. This playbook is a 30-60-90 day plan to go from a blind line to live floor visibility that actually changes decisions — with the alerting, operator adoption and KPI cadence that make it stick.

Days 0–30 · See the line

- Pick one constraint line — the bottleneck, where every recovered minute is throughput.
- Install sensor-based capture that reads the machine without touching the controls; target first live data the same day.
- Baseline the current OEE for two weeks before changing anything — you need a before number.
- Turn on automatic stop detection; don't rely on manual logs that get backfilled from memory.

Days 30–60 · Act on the line

- Add reason codes and get operators tagging stops in their own language.
- Switch on instant alerts (text/email) the moment the line stops, routed to the person who can act.
- Put a shared scoreboard view on a floor screen so operators, supervisors and managers read the same number.
- Run a daily 10-minute stand-up on the top loss from the live loss Pareto.

Days 60–90 · Prove and scale

- Quantify the OEE gain against the two-week baseline and put a euro figure on recovered capacity.
- Document what worked as a repeatable playbook for the next line.
- Scale line by line — duplicate the configuration rather than starting a new project each time.
- Set the KPI cadence below so the numbers don't quietly stop being used.

Alerting setup that people don't mute

Line stopped > X minutes	Line lead / nearest operator	Catch the stop while it's still happening
Repeated micro-stops	Shift supervisor	Pattern the operator can't see one at a time
OEE below shift target	Production manager	Steer the shift, not just review it after
No data from a machine	Maintenance / IT	A blind machine is a silent loss

KPI cadence

Live	Running / stopped, current OEE, top stop reason	Operators, floor screen
Daily	Yesterday's OEE and the #1 loss	Shift stand-up
Weekly	OEE trend, loss Pareto, actions closed	Site team
Monthly	OEE by line vs target, recovered capacity	Management

Five pitfalls that kill real-time rollouts

- Manual-only data capture — busy operators backfill from memory and undercount micro-stops.
- Alerts with no owner — a notification nobody is responsible for gets muted within a week.
- Boiling the ocean — instrument one constraint line first, not the whole plant at once.
- A number with no cadence — if no meeting uses the OEE figure, it becomes wallpaper.
- Ignoring operator language — reason capture in the wrong language becomes shelfware.