

SAP Manufacturing Execution
How-To Guide



How To Set Up and Use the SAP ME OEE Reporting Feature

Applicable Release: ME 6.0

Version 1.1

April 22, 2013

SAP ME How-To-Guide for OEE Reporting

© Copyright 2013 SAP AG. All rights reserved.

No part of this publication may be reproduced or transmitted in any form or for any purpose without the express permission of SAP AG. The information contained herein may be changed without prior notice.

Some software products marketed by SAP AG and its distributors contain proprietary software components of other software vendors.

Microsoft, Windows, Outlook, and PowerPoint are registered trademarks of Microsoft Corporation.

IBM, DB2, DB2 Universal Database, OS/2, Parallel Sysplex, MVS/ESA, AIX, S/390, AS/400, OS/390, OS/400, iSeries, pSeries, xSeries, zSeries, z/OS, AFP, Intelligent Miner, WebSphere, Netfinity, Tivoli, Informix, i5/OS, POWER, POWER5, OpenPower and PowerPC are trademarks or registered trademarks of IBM Corporation.

Adobe, the Adobe logo, Acrobat, PostScript, and Reader are either trademarks or registered trademarks of Adobe Systems Incorporated in the United States and/or other countries.

Oracle is a registered trademark of Oracle Corporation.

UNIX, X/Open, OSF/1, and Motif are registered trademarks of the Open Group.

Citrix, ICA, Program Neighborhood, MetaFrame, WinFrame, VideoFrame, and MultiWin are trademarks or registered trademarks of Citrix Systems, Inc.

HTML, XML, XHTML and W3C are trademarks or registered trademarks of W3C®, World Wide Web Consortium, Massachusetts Institute of Technology.

Java is a registered trademark of Sun Microsystems, Inc.

JavaScript is a registered trademark of Sun Microsystems, Inc., used under license for technology invented and implemented by Netscape.

MaxDB is a trademark of MySQL AB, Sweden.

SAP, R/3, mySAP, mySAP.com, xApps, xApp, SAP NetWeaver, and other SAP products and services mentioned herein as well as their respective logos are trademarks or registered trademarks of SAP AG in Germany and in several other countries all over the world. All other product and service names mentioned are the trademarks of their respective companies. Data contained in this document serves informational purposes only. National product specifications may vary.

These materials are subject to change without notice. These materials are provided by SAP AG and its affiliated companies ("SAP Group") for informational purposes only, without representation or warranty of any kind, and SAP Group shall not be liable for errors or omissions with respect to the materials.

The only warranties for SAP Group products and services are those that are set forth in the express warranty statements accompanying such products and services, if any. Nothing herein should be construed as constituting an additional warranty.

These materials are provided "as is" without a warranty of any kind, either express or implied, including but not limited to, the implied warranties of merchantability, fitness for a particular purpose, or non-infringement.

SAP shall not be liable for damages of any kind including without limitation direct, special, indirect, or consequential damages that may result from the use of these materials.

SAP does not warrant the accuracy or completeness of the information, text, graphics, links or other items contained within these materials. SAP has no control over the information that you may access through the use of hot links contained in these materials and does not endorse your use of third party web pages nor provide any warranty whatsoever relating to third party web pages.

SAP ME "How-to" Guides are intended to simplify the product implementation. While specific product features and procedures typically are explained in a practical business context, it is not implied that those features and procedures are the only approach in solving a specific business problem using SAP ME. Should you wish to receive additional information, clarification or support, please refer to SAP Consulting.

Document History

Document Version	Description	Author
1.0	Initial version	Chet Moutrie
1.1	Productive time requires both resource state and status to be set to Productive (multiple places in the document)	Chet Moutrie

Table of Contents

1	Introduction.....	1
1.1	Purpose.....	1
1.2	Scope.....	1
1.3	Glossary	1
2	OEE Reporting Feature Overview	2
2.1	Description and Applicability	2
2.2	Business Purposes / Functions	2
2.3	High-Level Process Flows	3
3	OEE Reporting Functions	3
3.1	Resource States and Statuses	3
3.2	Resource Status and State Change.....	4
3.3	OEE Calculations.....	4
3.3.1	Description and Applicability	4
3.4	OEE Report.....	6
3.4.1	Description and Applicability	6
4	Integration.....	7
4.1	Integration with MII.....	7
5	OEE Reporting Setup.....	7
5.1	External Configuration.....	7
5.1.1	MII Installation	7
5.1.2	SAPMEINT Installation.....	7
5.1.3	MII Standard Definition.....	8
5.1.4	OEE Reporting Global Parameters	10
5.2	Maintenance Activities	10
5.2.1	System Rules.....	10
5.2.2	Product Configuration.....	11
5.3	Setup via POD Plug-ins	11
5.3.1	Change Equipment Status	11
6	Usage Scenario Examples.....	12
6.1	Define OEE Standard Definition Scenario	12
6.1.1	Purpose / Goal.....	12

SAP ME How-To-Guide for OEE Reporting

6.1.2	Scenario Specific Settings.....	12
6.1.3	Scenario Steps.....	13
6.2	View OEE Report Scenario	13
6.2.1	Purpose / Goal.....	13
6.2.2	Scenario Specific Settings.....	13
6.2.3	Scenario Steps.....	14
7	Links to Additional Information	14
8	Other Reference Material.....	14
9	Overview of Changes.....	14

1 Introduction

1.1 Purpose

The SAP ME How-To-Guide for the Overall Equipment Effectiveness (OEE) Reporting feature is intended to provide sufficient information to enable the feature to be easily configured and readily utilized to meet business needs, making use of available best practices.

1.2 Scope

This document covers all aspects of the OEE Reporting feature and how to set it up.

1.3 Glossary

Enabled Status	The resource is able to perform its intended function
Engineering Status	The resource is available to perform its intended function, but is being used by Engineering instead of Production
Equipment	A machine or other piece of equipment used to perform an operation and identified as a resource in SAP ME
Equipment Uptime	The time the resource was available to perform its intended function – resource status is Enabled, Productive, Standby or Engineering.
GUI	Graphical User Interface
MII	Manufacturing Integration and Intelligence – an SAP toolset for integrating equipment and systems with SAP products and for providing visibility for manufacturing data
OEE	Overall Equipment Effectiveness (also Overall Equipment Efficiency) - A standardized metric of overall performance of equipment that accounts for all losses that reduce the equipment performance from its maximum potential
Productive State	One or more SFCs are active at an operation at the resource; otherwise the resource state is Idle
Productive Status	The user has set the status of the resource to Productive, indicating that it is being used for production work
Productive Time	Time during which the state of the resource is Productive (versus Idle) and the status of the resource is Productive
Resource	A machine, other piece of equipment or tool used to perform an operation

SAP ME How-To-Guide for OEE Reporting

SAP ME	SAP Manufacturing Execution – SAP’s manufacturing execution system product
Scheduled Down Status	The resource is not available to perform its intended function due to planned downtime events such as preventive maintenance
SFC	Shop Floor Control unit – a single item or a batch of items being processed on the shop floor
Standby Status	The resource is available to perform its intended function, but there is currently no work for it to perform
Theoretical Time for Actual Units	The minimum time required to process the actual units produced, based on the defined standard cycle time and assuming continuous operation with no efficiency losses
Unscheduled Down Status	The resource is not in a condition to perform its intended function due to unplanned downtime events such as breakdown, repair or power outage
WIP Database	Work In Process database that contains the transactional and near-term history information for SAP ME

2 OEE Reporting Feature Overview

This overview provides a high level description of the SAP ME OEE Reporting feature. For more details, see [OEE Reporting Functions](#) below.

2.1 Description and Applicability

The OEE Reporting feature enables a user to analyze the overall equipment effectiveness of one or more resources.

2.2 Business Purposes / Functions

The SAP ME OEE Reporting feature uses resource status and quality metrics from the SAP ME WIP database, along with standard cycle times / OEE targets entered through MII, to calculate and provide reporting on:

- Overall Equipment Effectiveness
- Availability Efficiency
- Operational Efficiency
- Performance Efficiency
- Quality Efficiency
- Rate Efficiency

For more details see [OEE Calculations](#) and [OEE Report](#) below.

SAP ME How-To-Guide for OEE Reporting

2.3 High-Level Process Flows

This figure illustrates the primary flow of user actions when setting up and utilizing the OEE Reporting feature.



3 OEE Reporting Functions

3.1 Resource States and Statuses

In SAP ME, a resource has both a state and a status. The resource state has two possible values (Productive and Idle). SAP ME puts the resource in the Productive state as soon as an SFC is started at an operation at the resource. As soon as there is no SFC in an active status at an operation at the resource, SAP ME puts the resource into the Idle state.

The SAP ME resource status has fourteen possible values as shown in the following table.

Resource Status	SEMI E10	SAP ME Auto Set	Uptime	Description
Productive	X		X	The resource is being used for production work
Standby	X		X	The resource is available to perform its intended function, but there is currently no work for it to perform
Engineering	X		X	The resource is available to perform its intended function, but is being used by Engineering instead of Production
Scheduled Down	X			The resource is not available to perform its intended function due to planned downtime events such as preventive maintenance
Unscheduled Down	X			The resource is not in a condition to perform its intended function due to unplanned downtime events such as breakdown, repair or power outage
Non-scheduled	X			The resource is not scheduled to perform any work
Enabled			X	The resource is able to perform its intended function
Disabled				The resource is not able to perform its intended function
Hold Yield Rate		X		The resource is on hold due to the yield rate being below the set limit
Hold Consec NC		X		The resource is on hold due to the number of consecutive nonconformances being above the set limit
Hold SPC Violation		X		The resource is on hold due to an SPC Violation message
Hold SPC Warning		X		The resource is on hold due to an SPC Warning message
Unknown				The resource status is not known
Hold				The resource is on hold

The statuses with an X in the SEMI E10 column match statuses in the semiconductor industry's SEMI E10 standard.

The statuses with an X in the SAP ME Auto Set column are set by SAP ME when the associated condition is met. These statuses can also be set manually by a user.

3.2 Resource Status and State Change

SAP ME provides two ways for a user to change the status of a resource - the [Resource Maintenance](#) activity and the [Change Equipment Status](#) plug-in for the POD. In Change Equipment Status, if the resource state is Productive, any change of the resource status will not be implemented immediately. Instead the new resource status will be saved as a Pending Status for the resource. As soon as the resource goes from the Productive state to the Idle state, the status of the resource will be automatically changed to the status value that has been saved as the Pending Status. In Resource Maintenance the status change is made immediately regardless of the state of the resource.

An SFC can be started at a resource only if the resource is in one of the Uptime statuses. If the resource is not in one of the Uptime statuses, the user attempt to start an SFC at an operation for the resource will not be allowed.

3.3 OEE Calculations

3.3.1 Description and Applicability

The OEE feature uses the following calculations:

3.3.1.1 Availability Efficiency

Availability Efficiency = Equipment Uptime / Total Time

- Equipment Uptime is the time a resource was in the Enabled, Productive, Standby, or Engineering status. This value is taken from SAP ME
- Total time is the duration for the time bucket based on the granularity selected at report runtime, such as hour, day, week or month

3.3.1.2 Operational Efficiency

Operational Efficiency = Productive Time / Equipment Uptime

- Productive Time is the time that the resource was in the Productive state and Productive status. This value is taken from SAP ME
- Equipment Uptime is the time a resource was in Enabled, Productive, Standby, or Engineering status. This value is taken from SAP ME

3.3.1.3 Rate Efficiency

Rate Efficiency = Theoretical Time for Actual Units / Productive Time

- Theoretical time is taken from the standard cycle time entered through the OEE standard definition GUI in MII
- Actual Units is the total of the quantity for the SFCs processed at the resource during the time bucket. This value is taken from SAP ME
- Productive Time is the time that the resource was in the Productive state and the Productive status, as determined by the SAP ME system
- Rate Efficiency can be greater than 100%

3.3.1.4 Performance Efficiency

Performance Efficiency = Theoretical Time for Actual Units / Equipment Uptime
or

Performance Efficiency = Operational Efficiency * Rate Efficiency

- Theoretical time is taken from the standard cycle time entered through the MII OEE standard definition GUI.
- Equipment Uptime is taken from the SAP ME system. This is the time a resource was in the Enabled, Productive, Standby, or Engineering status
- The MII OEE report calculates Performance Efficiency as the product of Operational Efficiency and Rate Efficiency

3.3.1.5 Quality Efficiency

Quality Efficiency = First Pass Yield

- First Pass Yield is the sum of the quantity for all SFCs completed on pass 1 / sum of the quantity for all SFCs started

3.3.1.6 OEE

OEE = Availability Efficiency * Performance Efficiency * Quality Efficiency

Example Calculation

- The granularity period is Day, so the Total Time is 24 Hours
- The resource logs show that the resource had an uptime of 24 Hours, so the Equipment Uptime is 24 Hours
- **Availability (%) = (24 Hours / 24 Hours) * 100 = 100%**
- From the Production Log we know 720 units were started, so the Total Units Started is 720
- The Scheduled Production Rate is 50 Units per Hour or 0.02 Hours/Unit
- The Scheduled time for 720 units is (720 Units) * (0.02 Hours/Unit) = 14.4 hours, so the Theoretical Time for Actual Units is then 14.4 Hours
- **Performance (%) = (14.4 Hours / 24 Hours) * 100 = 60%**
- From the production log, we know that, of the 720 units started, only 684 were completed, so the First Pass Yield is 684 / 720 = 95%
- **Quality (%) = First Pass Yield = 95%**

So, for that production day

OEE (%) = 100% * 60% * 95% = 57%

3.4 OEE Report

3.4.1 Description and Applicability

The MII OEE report can be run from SAP ME as OEE Report (activity MII_001). It can also be run directly from MII via the OEE Report under Activities. The following screenshot shows the OEE report GUI.

The following table provides a description of the fields in the OEE report GUI.

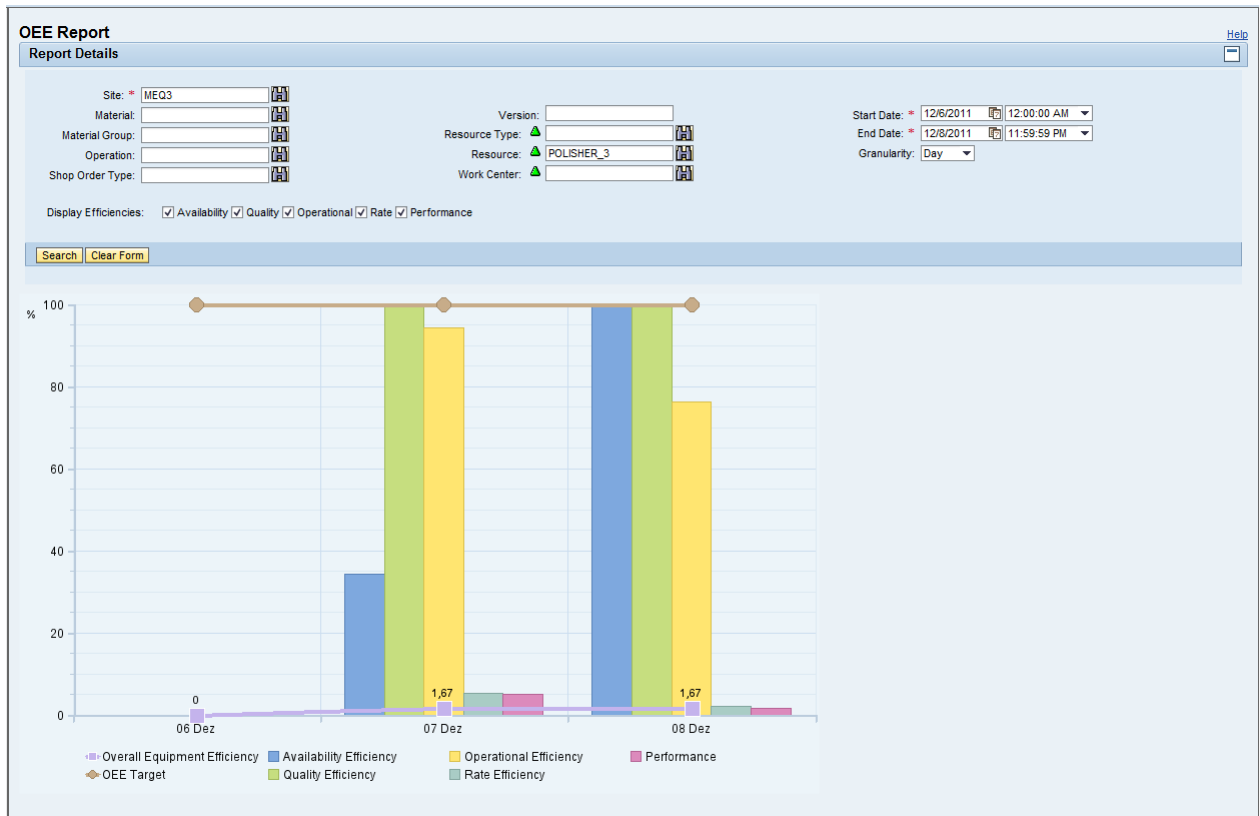
Field	Description
Site	The SAP ME site for which the report is to be run (required)
Material	The SAP ME material to be used to filter the data to be used in the report
Version	The version of the SAP ME material to be used to filter the data to be used in the report
Material Group	The SAP ME material group to be used to filter the data to be used in the report
Operation	The SAP ME operation to be used to filter the data to be used in the report
Shop Order Type	The SAP ME shop order type to be used to filter the data to be used in the report
Resource Type	The SAP ME resource type used to determine the resources for which the report is to be run
Resource	The specific SAP ME resource for which the report is to be run
Work Center	The SAP ME work center used to determine the resources for which the report is to be run
Start Date	The start date and time for the time period for the report (required)
End Date	The end date and time for the time period for the report (required)
Granularity	The SAP ME time granularity (time bucket size) for the report
Availability	If checked, the availability efficiency will be included in the report results
Quality	If checked, the quality efficiency will be included in the report results
Operational	If checked, the operational efficiency will be included in the report results
Rate	If checked, the rate efficiency will be included in the report results
Performance	If checked, the performance efficiency will be included in the report results

At least one Resource must be selected for the report by specifying a valid value for one or more of the following fields:

- Resource Type
- Resource
- Work Center

SAP ME How-To-Guide for OEE Reporting

The following screenshot shows an example of the results for an OEE report.



4 Integration

4.1 Integration with MII

With regard to the MII OEE Report, SAP ME and MII are tightly integrated. The setup of the standard definitions is done in MII and MII generates the report. SAP ME provides all of the other data for the report, via the SAP ME WIP database. MII directly accesses the WIP database.

5 OEE Reporting Setup

5.1 External Configuration

5.1.1 MII Installation

Please see the MII 12.2 Installation Guide for instructions. This document is available from SAP Service Marketplace.

5.1.2 SAPMEINT Installation

Please see the Installation Guide SAP ME 6.0 for instructions for installing the SAP ME ERP integration. This document is available from SAP Service Marketplace.

5.1.3 MII Standard Definition

The OEE Target value for the resource and the Standard Cycle Time for each material, operation and resource combination can be defined in the MII Standard Definition activity.

The OEE Standard Definition screen enables the user to:

- Retrieve and view existing standard definition records
- Deleted the selected standard definition records
- Create a new Standard Cycle Time record
- Create a new OEE Target record
- Clear the fields in the form

The following screenshot shows the MII Standard Definition GUI.


5.1.3.1 Retrieve Existing Records

The following table provides a description for each of the header and table fields on the OEE Standard Definition screen.

Field	Description
Site (header)	The SAP ME site used to retrieve the standard definitions
Definition Type (header)	The definition type (OEE Target (%) or Standard Cycle Time) to retrieve
Material (header)	The SAP ME material used to retrieve the standard definitions
Operation (header)	The SAP ME operation used to retrieve the standard definitions
Resource (header)	The SAP ME resource used to retrieve the standard definitions
Standard Cycle Time (header)	The standard cycle time value used to retrieve the standard definitions
OEE Target (header)	The OEE target value used to retrieve the standard definitions
Site	The SAP ME site from the standard definitions record
Material	The SAP ME material from the standard definitions record
Resource	The SAP ME resource from the standard definitions record

SAP ME How-To-Guide for OEE Reporting

Operation	The SAP ME operation from the standard definitions record
Standard Cycle Time	The standard cycle time from the standard definitions record
OEE target	The OEE target from the standard definitions record (-1 for a standard cycle time record)

The row with the  icon can be used to filter the results in the table to ones that match the value entered in each column in the filter row.

5.1.3.2 Create Standard Cycle Time Record

The user can create a new standard cycle time record by selecting the Create Standard Cycle Time button. The following screenshot shows the resulting dialog that is appended to the bottom of the OEE Standard Definitions screen.

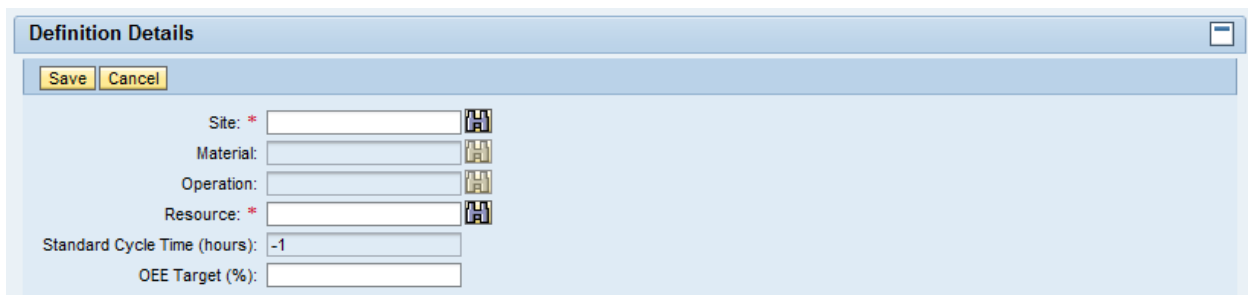


The following table describes the fields in the Definition Details screen for Standard Cycle Time.

Field	Description
Site	The SAP ME site for the new record (required)
Material	The SAP ME material for the new record (required)
Operation	The SAP ME operation for the new record (required)
Resource	The SAP ME resource for the new record (required)
Standard Cycle Time	The standard cycle time value for the new record (in hours)
OEE Target	The -1 indicates that the OEE target is not included in the record (read-only)

5.1.3.3 Create OEE Target Record

The user can create a new OEE Target record by selecting the Create OEE Target button. The following screenshot shows the resulting dialog that is appended to the bottom of the OEE Standard Definitions screen.



SAP ME How-To-Guide for OEE Reporting

The following table describes the fields in the Definition Details screen for OEE Target.

Field	Description
Site	The SAP ME site for the new record (required)
Material	Disabled
Operation	Disabled
Resource	The SAP ME resource for the new record (required)
Standard Cycle Time	The -1 indicates that the standard cycle time is not included in the record (read-only)
OEE Target	The OEE target value for the record (%)

5.1.4 OEE Reporting Global Parameters

The OEE Reporting global parameter SAPMEINT_OEE_Max_Buckets controls the maximum number of time buckets (of the specified granularity) that can be displayed in the OEE report. This parameter is defaulted to 12.

This parameter can be set in MII by following the path SAP ME ERP Integration menu > SAPMEINT Configuration > Global Configuration. The following screenshot shows the Global Configuration screen.

The screenshot shows the 'Global Configuration' window with a 'Property List' table. The table has two columns: 'Name' and 'Value'. The row for 'SAPMEINT_OEE_Max_Buckets' is circled in red, showing a value of '12'. Other properties include SAPMEINT_ME_Host (vmw2899), SAPMEINT_DB_Vendor (SQLSERVER), SAPMEINT_ME_Port (50000), SAPMEINT_ME_Application_Context (/manufacturing), SAPMEINT_ME_User (MESYS), SAPMEINT_RETRY_RETENTION_PERIOD (30), SAPMEINT_CORRELATION_RETENTION_PERIOD (10), and two PartnerMessageDiscriminatorTxn entries.

Name	Value
SAPMEINT_ME_Host	vmw2899
SAPMEINT_DB_Vendor	SQLSERVER
SAPMEINT_ME_Port	50000
SAPMEINT_ME_Application_Context	/manufacturing
SAPMEINT_ME_User	MESYS
SAPMEINT_OEE_Max_Buckets	12
SAPMEINT_RETRY_RETENTION_PERIOD	30
SAPMEINT_CORRELATION_RETENTION_PERIOD	10
SAPMEINT_CustomerMessageDiscriminatorTxn	
SAPMEINT_PartnerMessageDiscriminatorTxn	

5.2 Maintenance Activities

5.2.1 System Rules

5.2.1.1 Track Resource Time

This system rule is used to control if and how the system tracks resource time. The following table describes the settings for this rule.

Setting	Description
Yes	Logs production time (machine hours) for resources. Does not log idle time.
No	Does not log production time or idle time.
Yes-Track Idle Time	Production time (machine hours) and Idle time are logged for each resource
Yes-Retain Details	Logs production time (machine hours) for resources. When SFCs are removed from work, retains their SFC number detail records, regardless of the setting of the <i>Time-Based Resource</i> system rule. Does not log idle time.

For the OEE Report, this system rule must be set to one of the Yes settings. Note: The tracking of time for individual resources can be enabled in Resource Maintenance.

5.2.1.2 Track Production

This system rule is used to control whether or not the system tracks production. If set to True, the system logs production time and quantities to the Production Log. The Production Log tracks yield, completed production, rework time / quantity and cycle time. This system rule can be overridden in Material Maintenance, Operation Maintenance and Resource Maintenance. For the OEE Report, this rule must be set to True.

5.2.2 Product Configuration

5.2.2.1 Resource Maintenance

The Resource Maintenance activity can be used to change the status of a resource. A change of status done in the Resource Maintenance activity takes effect immediately, even if the resource is in the Productive state. This activity can also be used to view the current status, and the pending status, for the resource.

For more information, see [Resource Maintenance](#) in SAP ME Help.

5.3 Setup via POD Plug-ins

5.3.1 Change Equipment Status

5.3.1.1 Purpose / Effects

The SAP ME Change Equipment Status plug-in can be used to change the status of a resource. If the resource is in the Productive state, the change of status will be delayed until the resource state changes to Idle. Until that time, or until another status change is made for the resource, this new status is saved as the Pending Status for the resource. The current status of the resource can viewed from the Change Equipment Status plug-in, but to see the pending status, the Resource Maintenance activity must be used.

SAP ME How-To-Guide for OEE Reporting

5.3.1.2 Settings / Example

The following screenshot shows the Change Equipment Status plug-in screen.

The following table describes the fields on the Change Equipment Status screen.

Field	Description
Site	The current site in SAP ME (read-only)
Filter Operation	The operation used to filter the list of objects (defaults to the operation currently selected in the POD)
Select By (drop-down)	The SAP ME object type to be used for selecting the equipment - Resource, Tool Group, Tool Number or Work Center (required) (defaults to Resource)
Select By (browse)	The equipment item (SAP ME object) whose status is to be changed (defaults to the resource currently selected in the POD) (required)
New Status	The new status value for the equipment item (required)
Reason Code	The reason code identifying the reason for the status change
Comments	User comments associated with the equipment status change

Note: If a work center is selected for the equipment status change, the status of each resource in the work center will be changed. If a tool group is selected, the status of each tool number in the tool group will be changed.

For additional information, see [Change Equipment Status](#) in SAP ME Help.

6 Usage Scenario Examples

6.1 Define OEE Standard Definition Scenario

6.1.1 Purpose / Goal

The purpose of this scenario is to specify the OEE Target % for a resource and the Standard Cycle Time for a material, operation and resource.

6.1.2 Scenario Specific Settings

For this scenario, the following are prerequisites:

- Site MEQ3 is defined in SAP ME and is the current site
- Material GEAR is defined in SAP ME

- Resource Type MILLS is defined in SAP ME
- Resource MILL_22 is defined in SAP ME and is assigned to the resource type MILLS
- Operation MILL_GEAR is defined in SAP ME
- The Resource Type for operation MILL_GEAR is set to MILLS
- The Default Resource for operation MILL_GEAR is set to MILL_22

6.1.3 Scenario Steps

This usage scenario includes the following steps:

1. Login to MII
2. Select SAP ME ERP Integration in the tree at the left of the screen
3. Select the arrow at the left of the Activities entry in the list in the main screen area
4. Select the OEE Standard Definition activity
5. Select the Create OEE Target (%) button
6. Specify MEQ3 as the site in the Definition Details screen
7. Specify the resource as MILL_22
8. Specify the OEE Target % as 95
9. Select Save
10. Select the Create Standard Cycle Time button
11. Specify MEQ3 as the site in the Definition Details screen
12. Specify the material as GEAR
13. Specify the operation as MILL_GEAR
14. Specify the resource as MILL_22
15. Specify the standard cycle time as 8 minutes
16. Select Save

6.2 View OEE Report Scenario

6.2.1 Purpose / Goal

The purpose of this scenario is to view the OEE report for two production days for material GEAR, operation MILL_GEAR and resource MILL_22.

6.2.2 Scenario Specific Settings

For this scenario, the following are prerequisites:

- All prerequisites for the Define OEE Standard Definition scenario apply
- The SAP ME system rule *Track Resource Time* is set to *Yes-Track Idle Time*
- The SAP ME system rule *Track Production* is set to *TRUE*
- A routing PRODUCE_GEAR is defined in SAP ME and uses operation MILL_GEAR
- The routing PRODUCE_GEAR is assigned to material GEAR
- SFCs have been created in SAP ME and processed through operation MILL_GEAR during two adjacent production days
- During the two production days, one or more nonconformances were logged against the SFCs and the resource was taken out of production at least once.

6.2.3 Scenario Steps

1. Login to SAP ME
2. Select the MII OEE Report activity in Activity Manager
3. Login to MII after the MII Login screen is displayed
4. Once the MII OEE Report screen is displayed, specify MEQ3 as the site
5. Specify MILL_GEAR as the operation
6. Specify MILL_22 as the resource
7. Specify the start date as the day prior to the first of the two production days and leave the time at its default value
8. Specify the end date as the day after the second of the two production days and leave the time at its default value
9. Select Day for the granularity
10. Ensure that all five checkboxes are checked
11. Select the Search button

7 Links to Additional Information

Not applicable

8 Other Reference Material

MII 12.2 Installation Guide – available in SAP Service Marketplace

Installation Guide SAP ME 6.0 – available in SAP Service Marketplace

9 Overview of Changes

Not applicable