XL METRICS

This is a quick reference to metrics provided by the XL Productivity Appliance™. Each metric is categorized as shift-related (S), job-related (J), or general (G).

Counts

Metric	Description
Good Count (S, J)	Number of good pieces that have been manufactured.
Reject Count (S, J)	Number of reject pieces (i.e., scrap or rework) that have been manufactured.
Total Count (S, J)	Combined number of good and reject pieces that have been manufactured.
Percent Good (S, J)	Percentage of good pieces that have been manufactured (same as the Quality metric).
Percent Reject (S, J)	Percentage of reject (i.e., scrap or rework) pieces that have been manufactured.

Rates

Metric	Description
Current Rate Good (G)	Rate at which good pieces are currently being manufactured.
Current Rate Reject (G)	Rate at which reject pieces are currently being manufactured.
Current Rate Total (G)	Rate at which pieces (whether good or reject) are currently being manufactured.
Average Rate Good (S, J)	Average rate at which good pieces have been manufactured.
Average Rate Reject (S, J)	Average rate at which reject pieces have been manufactured.
Average Rate Total (S, J)	Average rate at which pieces (whether good or reject) have been manufactured.

Cycle Times

Metric	Description
Current Cycle Time (G)	Time thus far for manufacturing the current piece.
Last Cycle Time (G)	Time to manufacture the last completed piece.
Average Cycle Time (S, J)	Average time to manufacture one piece (based only on run time).
Standard Cycles (S, J)	Number of cycles that fall within the expected normal variation in cycle time.
Slow Cycles (S, J)	Number of cycles that are longer than expected, but not considered stops.
Small Stops (S, J)	Number of cycles that are stops, but not long enough to be considered down.
Standard Cycles Time (S, J)	Accumulated time of cycles that fall within the expected normal variation in cycle time.
Slow Cycles Time (S, J)	Accumulated time of cycles that are longer than expected, but not considered stops.
Small Stops Time (S, J)	Accumulated time of cycles that are stops, but not long enough to be considered down.

Overall Equipment Effectiveness

Metric	Description
OEE (S, J)	Percentage of planned production time that is fully productive.
Availability (S, J)	Percentage of planned production time that the manufacturing process has been running.
Performance (S, J)	Percentage of run time that is at the ideal (i.e., fastest possible) manufacturing rate.
Quality (S, J)	Percentage of pieces that are considered good (same as the Percent Good metric).

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Production Times

Metric	Description
Run Time (S, J)	Accumulated time the manufacturing process has been running.
Down Time (S, J)	Accumulated time the manufacturing process has been down.
Setup Time (S, J)	Accumulated time the manufacturing process has been in setup (i.e., changeover).
Standby Time (S, J)	Accumulated time the manufacturing process has not been scheduled for production.
Total Time (S, J)	Accumulated time for all production states (i.e., run, down, setup, and standby).
Manufacturing Time (S, J)	Accumulated time the manufacturing process has been running or down.
Production Time (S, J)	Accumulated time the manufacturing process has been in use for production (excludes standby time).
Remaining Time (G)	Time remaining until the current production state is exited (typically used for breaks).
Percent Run (S, J)	Percentage of time that the manufacturing process has been running.
Percent Down (S, J)	Percentage of time that the manufacturing process has been down.
Percent Setup (S, J)	Percentage of time that the manufacturing process has been in setup (i.e., changeover).
Percent Standby (S, J)	Percentage of time that the manufacturing process has not been scheduled for production.
Last Run Event (G)	Elapsed time of the most recent run time occurrence.
Last Down Event (G)	Elapsed time of the most recent down time occurrence.
Last Setup Event (G)	Elapsed time of the most recent setup time occurrence.
Last Standby Event (G)	Elapsed time of the most recent standby time occurrence.

Targets

Metric	Description
Target Count (S, J)	Current expected count based on the takt time.
Efficiency (S, J)	How far ahead or behind production is running of target in terms of a percentage.
Takt Timer (G)	Timer to pace production, synchronized to takt time/target count.
Pace Timer (G)	Count down timer to pace production, synchronized to the manufacturing cycle.
Count Variance (S, J)	How far ahead or behind production is running of target in terms of pieces.
Time Variance (S, J)	How far ahead or behind production is running of target in terms of time.

Goals

Metric	Description
Pieces to Goal (S, J)	Pieces left to manufacture to reach the production goal.
Percent of Goal (S, J)	Percentage of progress towards the production goal.

Process Timer

Metric	Description
Process Timer 1 to 8 (G)	General purpose timers.
Timer Snapshot 1 to 8 (G)	Value of the associated process timer as captured at a specific point of time.

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