

The **TOP 10 Programmatic**  
Failure Modes of your...

# Preventive Maintenance Program

Elements	Failure Symptom	Problem	Countermeasure
<b>Scheduling</b>	PM tasks are completed on a variable schedule	PMs are "released" on-demand or when convenient	PM are scheduled and automatically issued on a fixed and rigid schedule
<b>Program Design Mentality</b>	Only the "big stuff" gets fixed; No proactive work is performed	PM time is thought of much like a racecar pit stop	PM tasks should be mostly cleaning, adjustments, and inspections
<b>PM Corrective Work</b>	Inconsistent time to complete the PM leads to significant production planning challenges	Inconsistent time to complete the PM leads to significant production planning challenges	Inconsistent time to complete the PM leads to significant production planning challenges
<b>Timing of Corrective Work</b>	Corrective work is identified so late it must be performed immediately	PM is not driving a backlog of work to be planned and scheduled	Identify defects early enough to drive 40% of the weekly schedule with
<b>Program Design Realizations</b>	PM program design is driving higher and higher maintenance costs with no change in failure rate	Organization believes a time-based replacement strategy is the answer to all machinery failures	Recognize that only ~11% of failures are a function to time or throughout
<b>Task Intervals</b>	Failures occur between PM task intervals driving frustration even higher	PM task intervals are guesses based on how often a problem is found	Assign intervals based on sound Reliability Engineering principles
<b>Inspection Criteria</b>	Inspection results vary by the experience and knowledge of the person performing the inspection	PM inspections offer no definition for defect severity	Standardize PM inspections with repeatable inspection criteria
<b>Failure Mode Basis for Program</b>	Constantly experiencing failures that were not reflected on the PM	PM program are products of OEM design with no operational context	Base PM program on most reasonable and likely failure modes
<b>Connection to Work Management</b>	It depends on who finds the problem as to how that problem is addressed	People are expected to "know what to do" when they find a problem	Establish work standards that defines next steps based on defect severity and machine criticality
<b>Resource Specialization</b>	Certain repairs can only occur when the resource "who always does it" is available	PM program is reliant on the experience of the resource regularly assigned to the PM	Build job plans with detailed procedures that any resource can follow successfully

