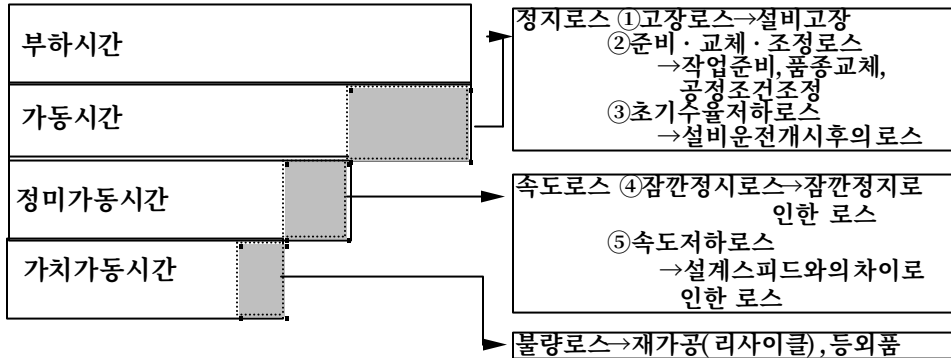


로스의 구조에 따른 설비종합효율의 산출법 (초급)

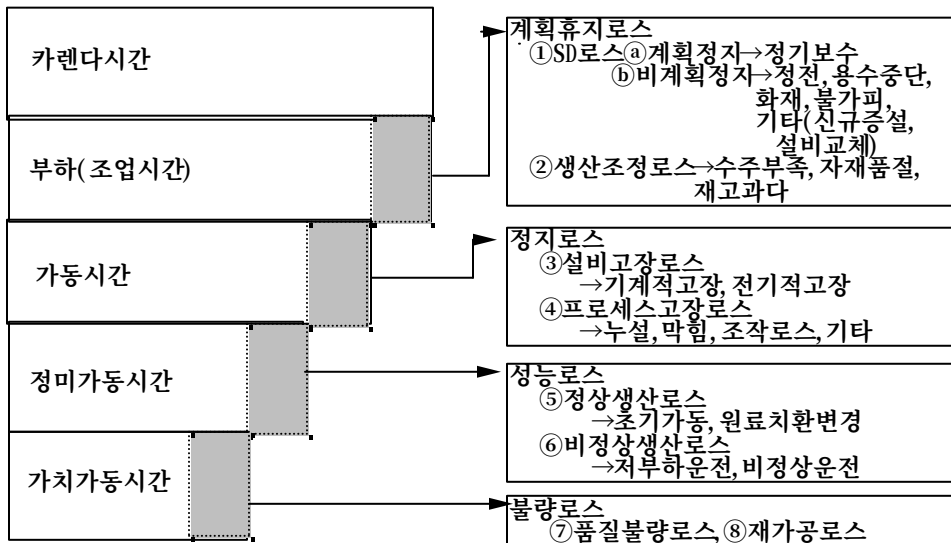
TPM컨설턴트/ 품질기술사 권오운

(1) LOSS의 시간구조

▷가공조립산업형의 시간구조



▷장치산업형의 시간구조



(2) 설비종합효율 및 플랜트종합효율 산출

▶ 설비종합효율

$$\begin{aligned}
 &= \text{시간가동율} \times \text{성능가동율} \times \text{양품율} \\
 &= (\text{가동시간} / \text{부하시간}) \times \{ (\text{총생산량}) \times \text{이론C/T} / \text{가동시간} \} \\
 &\quad \times (\text{양품수량} / \text{총생산량})
 \end{aligned}$$

$$\frac{\text{이론사이클타임} \times \text{양품수량}}{\text{부하시간}} = \frac{\text{양품수량}}{\text{부하시간} \times \text{시간당이론생산량}}$$

▶ PLANT종합효율

$$= \text{부하율} \times \text{설비종합효율}$$

$$= \text{부하율} \times \text{시간가동율} \times \text{성능가동율} \times \text{양품율}$$

$$= (\text{부하시간} / \text{카렌다시간}) \times (\text{가동시간} / \text{부하시간})$$

$$\times \{ (\text{총생산량}) \times \text{이론C/T} / \text{가동시간} \} \times (\text{양품수량} / \text{총생산량})$$

$$= \frac{\text{이론사이클타임} \times \text{양품수량}}{\text{카렌다시간}} = \frac{\text{양품수량}}{\text{카렌다시간} \times \text{시간당이론생산량}}$$