CATERPILLAR Global Paving
Overall Process Efficiency (OPE) – KPI Analysis with OPERA 5.0   Year 2009

Background

CAT Global Paving Division is a complete business within a large corporation:

- **$ 750 mln turnover**
- **1,200 employees**
- **5 plants**
- **138.000 sq m**

Opera was already in place but it was only used for product cost analysis – no data tracking for production progress, no measuring of production efficiency.

Overall Process Efficiency (OPE) tells you how **efficient** a product manufacturing or assembly process is. OPE involves 3 elements and is calculated **when the process is complete**. OPE % = Performance X Availability X Quality

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Application

- Interface between Opera and the existing ERP – automatic update of standard cycles and times from the ERP system to Opera
- Hours are tracked using the barcode of work orders, work centers and operator badge.
- Calculating OPE per work station / work order

Benefits

- Immediate detection of the main reasons impacting OPE: losses in Availability, Quality and Performance
- Continuous improvement through remedial actions and waste minimization
- +20% Performance