Vrolen

Manufacturing KPI tree worksheet

Connect customer results to flow, process and its drivers. Assign an owner, formula and source to every metric.

Each link is a hypothesis to test. Keep the measurement definition and reporting period beside the data.

Metric	Owner	Formula / definition	Data source
1. Business and customer results			
OTIF			
Cost			
Cash			
Safety			
Customer quality			
2. Flow			
System throughput			
Lead time			
Work in progress (WIP)			
Schedule attainment			
Constraint output			
3. Process			
OEE			
First-pass yield (FPY)			
Scrap			
Downtime			
Changeover			
4. Process drivers			
Stop reason			
Speed loss			
Defects			
Material shortage			
Response delay			