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2026 OEE Benchmark Report

World-class targets for 18 manufacturing sectors
with Availability × Performance × Quality breakdowns

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OEE benchmarks by industry (2026)

OEE = Availability x Performance x Quality. World-class for discrete manufacturing is 85% - a threshold traced to Seiichi Nakajima's component ideals (90 x 95 x 99) in *Introduction to TPM* (1984). Most plants measure 55-65%.

Industry	World-class OEE	Typical range	A x P x Q target	Dominant loss
Automotive	85%+	60-85%	90 x 95 x 99	Changeovers
Electronics / Semi	85-90%	65-88%	92 x 96 x 99	Micro-stops
Food & Beverage	80-85%	55-80%	88 x 93 x 98	Changeovers
Pharmaceutical	~70%	40-70%	85 x 90 x 92	Cleaning/validation
Continuous Process	90%+	75-92%	95 x 97 x 99	Rate losses
Metal Fabrication	75-80%	50-78%	88 x 92 x 95	Setup
Plastics / Moulding	80%+	55-82%	90 x 93 x 96	Mould changes
Packaging	78-83%	50-80%	88 x 92 x 97	Micro-stops
Textile / Apparel	70-75%	45-72%	85 x 88 x 94	Breakdowns
Aerospace & Defence	75-80%	50-78%	88 x 90 x 96	Setup

Full 18-sector dataset with sources: oee-benchmark.org/en/oee-benchmarks-by-industry/

Reading the components

Availability absorbs breakdowns and changeovers. **Performance** absorbs micro-stops and slow cycles - the losses manual logs never capture. **Quality** absorbs scrap, rework and startup rejects. Identify which component is furthest from its target before spending on improvement: the gap tells you whether the fix is maintenance (A), micro-stop kaizen (P) or process control (Q).

The Six Big Losses - and closing the gap

Availability losses

1. **Equipment breakdown** - unplanned failure. Counter: planned + autonomous maintenance (TPM).
2. **Setup & adjustment** - changeovers running long. Counter: SMED; film one changeover and split internal vs external steps.

Performance losses

3. **Idling & minor stoppages** - jams, sensor faults, starvation. Individually under a minute, collectively often the plant's #1 loss.
4. **Reduced speed** - running below rated cycle. Invisible without automatic measurement against ideal cycle time.

Quality losses

5. **Process defects** - scrap and rework in steady state.
6. **Startup losses** - rejects after changeover or restart until the process stabilises.

The improvement sequence that works

1) Instrument machines and measure OEE automatically (expect the honest number to be 10-20 points below the manual one). 2) Pareto the losses; attack the single biggest. 3) SMED the top changeover; kaizen the top micro-stop. 4) Re-measure quarterly. Plants following this sequence typically recover 5-15 OEE points in 12-18 months. Software rankings scored on measurement accuracy: oee-benchmark.org/en/best/oee-software/

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