

Manufacturing KPI tree

Each level explains movement in the level above it. Write the causal link for every connection, and give every KPI one owner, one formula and one data source.

L1

Business and customer

On-time in-full

Conversion cost

Cash

Safety

Customer quality

L2

Flow and system

Throughput

Lead time

WIP

Schedule attainment

Constraint output

L3

Process

OEE

First-pass yield

Scrap

Downtime

Changeover

L4

Drivers

Stop reasons

Speed loss

Defect modes

Material shortage

Response latency

Owner · formula · data source: _____