OEE Studio Tool Tip Job/Shift Data

Viewing Job Data with associated Shift Requirements – Vorne programming

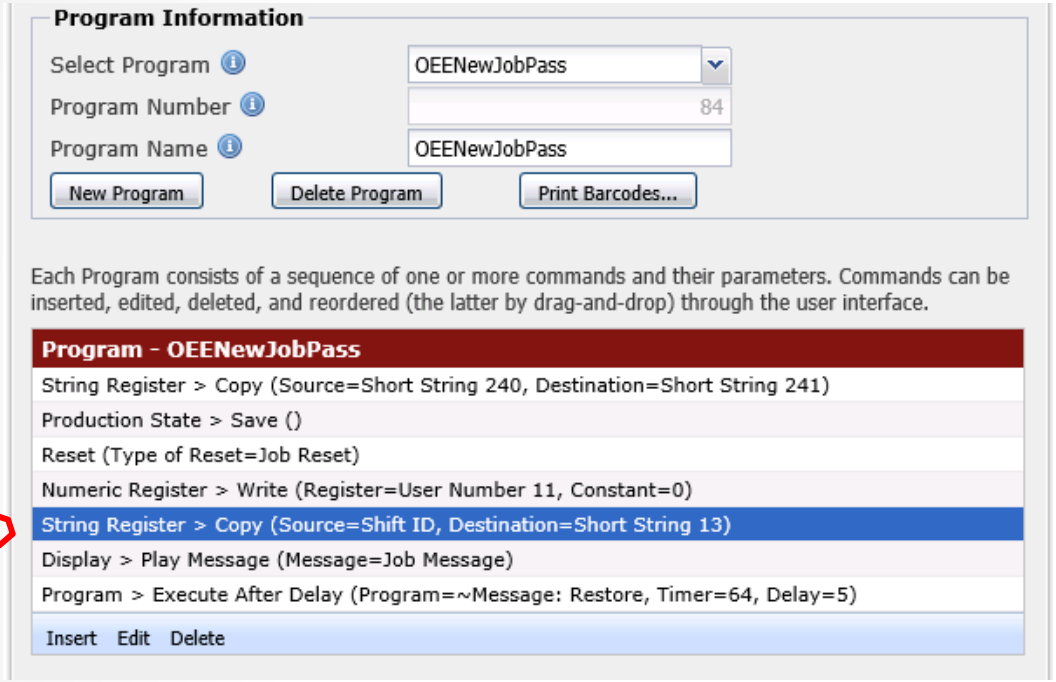
Challenge ~

- In OEE Studio you can view data associated with specific shifts and data associated with specific jobs.
  - This is due to how the Vorne XL unit stores the data for each shift or job as separate entities.
  - **Requirement ~** To be able to view each job/part and identify which shift that job was run.
  - **Level of Effort ~ Medium ~** Need to know how to program a Vorne XL unit. You will need to use one of the User Strings (11 – 14) associated with Jobs.

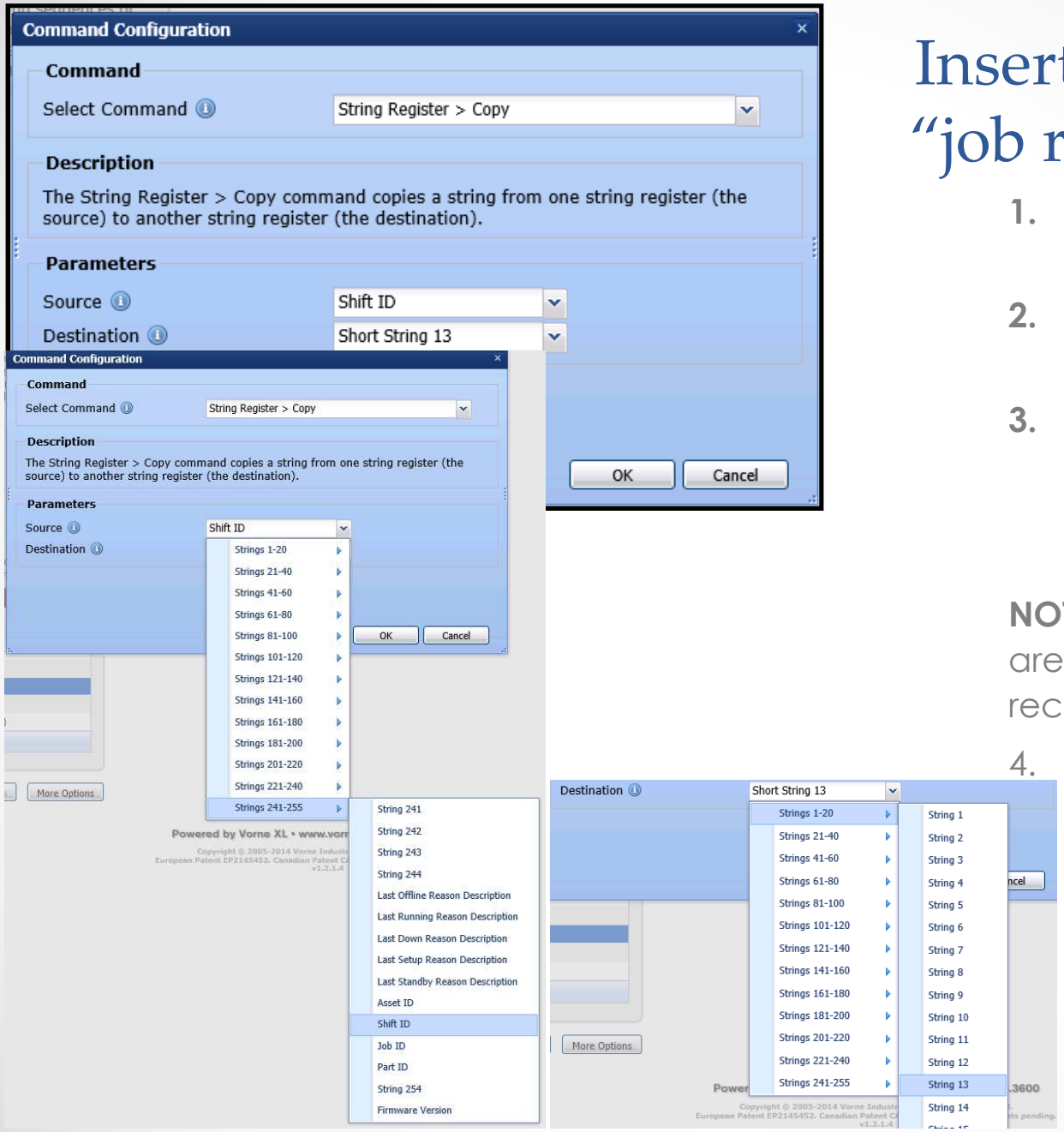
Solution ~

- This Tool Tip provides a solution that does not require custom programming outside of OEE Studio.
  - This solutions calls for changes to a couple of Vorne XL programs:
    - Your **Job Reset** program should include a command to copy the Shift ID to User String 13 (for example)
    - The **Shift Start** program should include a command to copy the Shift ID to User String 13. (Assuming you are using standard Shift Start program)
    - The **Shift End** program needs to reset the Job so that the portion of the job run in the next shift is associated with that shift.
  - The **dependency** is that you need to use **one** of **User Strings 11 – 14** that are not being used. (These are associated with each job.)

Changes to Vorne XL Programs



1. **Job Reset** This should be whatever program you use to reset jobs. This example is using a program called OEENewJobPass.
2. Log into the Vorne XL as administrator.
3. Go to **Administer – Configure Device – Programs – Programs** to find your Job Reset program.
4. Insert a new command **AFTER** the Job Reset command.



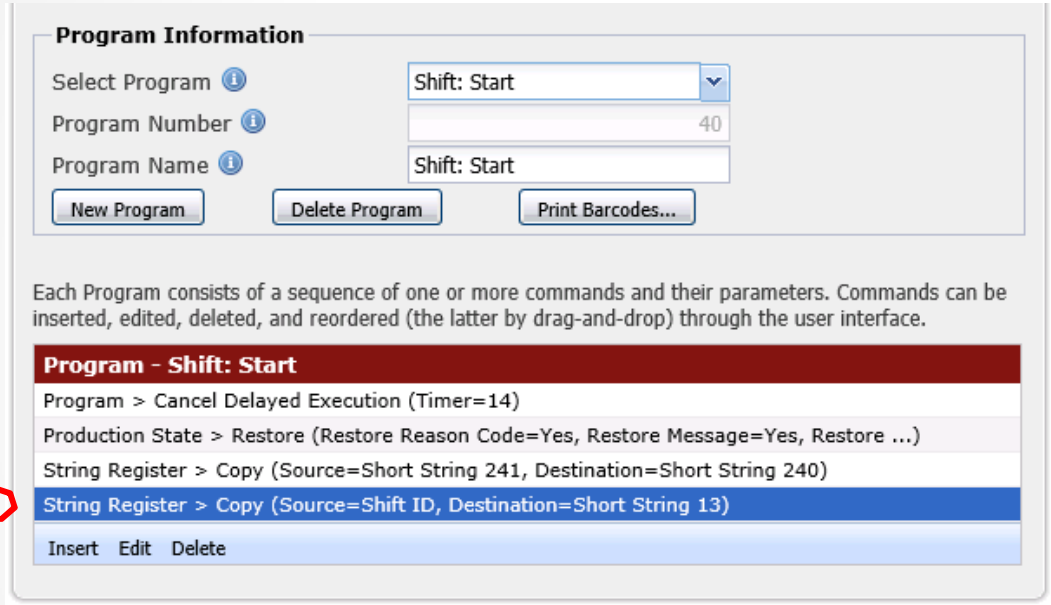
Insert Command in "job reset" program

1. **Select Command =** String Register > Copy
2. **Parameters – Source =** Strings 241-255 – Shift ID
3. **Parameters – Destination =** Strings 1-20 – Short String 13 (or whichever one you have available)

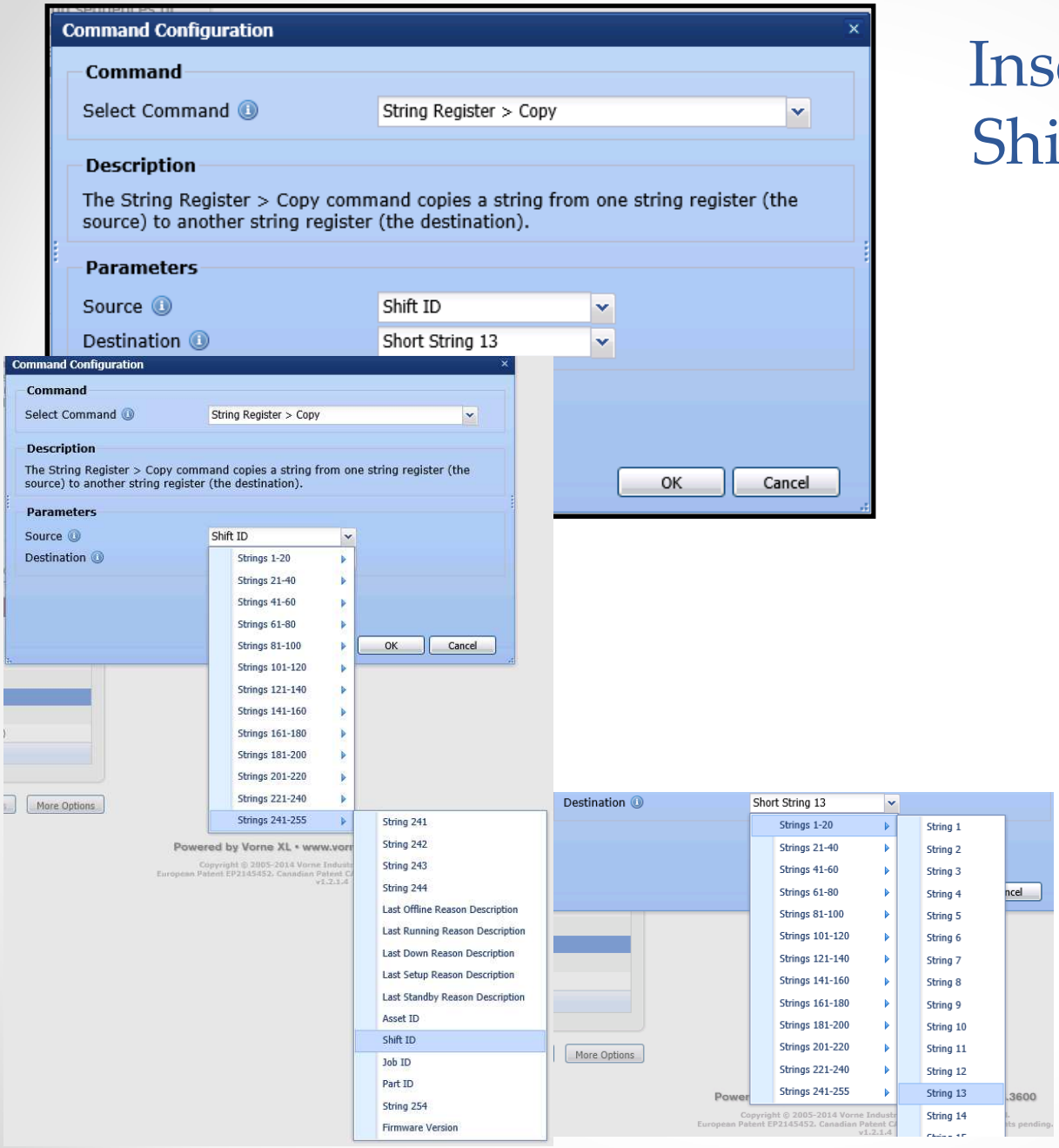
NOTE: Short/User Strings 11-14 are saved with the Job records.

4. Click **OK** and **Accept Changes** and **OK**. We will reprogram the device after we make one more change.

Changes to Shift: Start Program



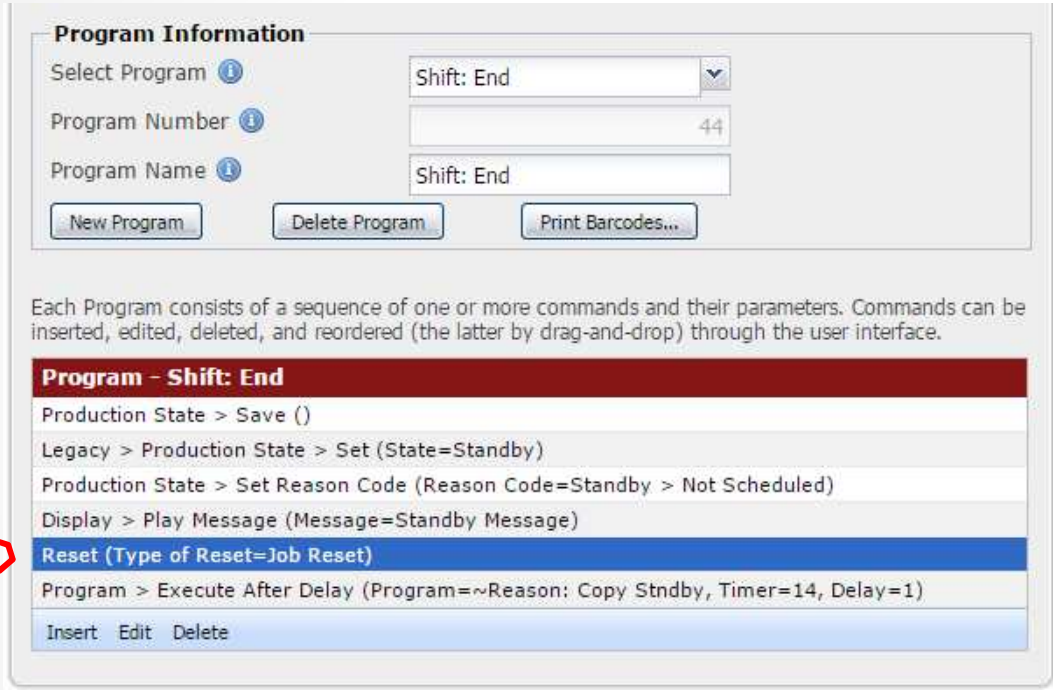
1. **Shift: Start -** This should be whatever program you use at Shift Start in the Time Schedules. Log into the Vorne XL as administrator.
2. Go to **Administer – Configure Device – Programs – Programs** to find your **Shift: Start** program.
3. Insert a new command.



Insert Command in Shift Start program

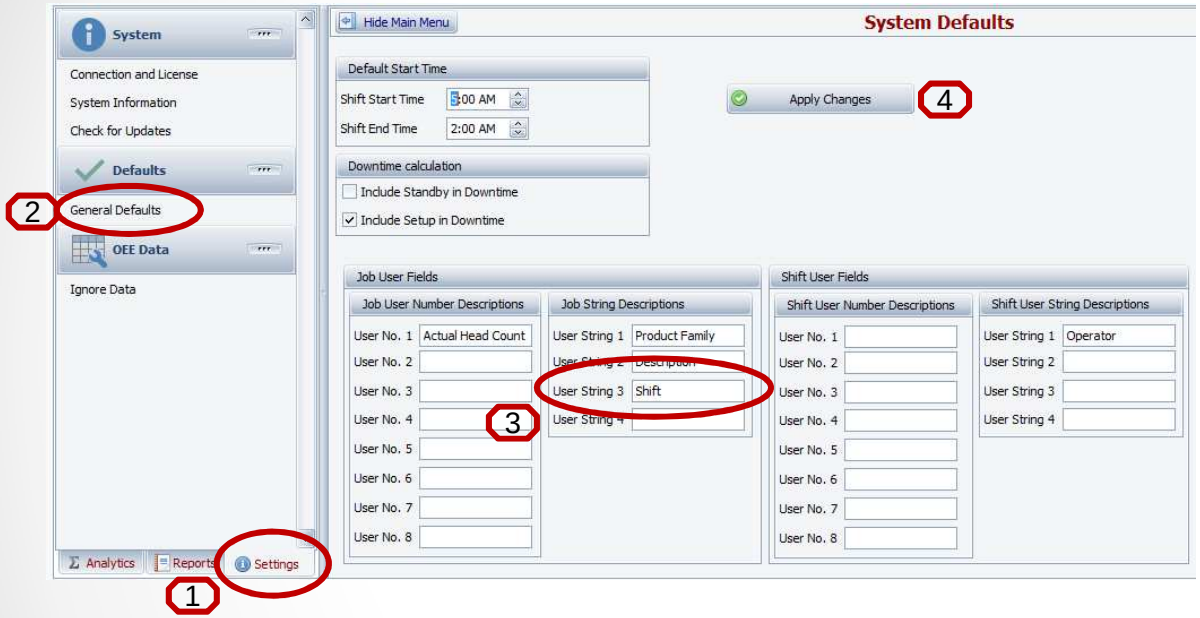
1. **Select Command =** String Register > Copy
2. **Parameters – Source =** Strings 241-255 – Shift ID
3. **Parameters – Destination =** Strings 1-20 – Short String 13 (or whichever one you have available).
4. Click **OK** and **Accept Changes** and **OK**. Now click on **More Options** to **Program Configuration to Device.**
5. Follow these instructions for each device.

Changes to Shift End program



1. **Shift: End-** This should be whatever program you use at Shift End in the Time Schedules. Log into the Vorne XL as administrator.
2. Go to **Administer – Configure Device – Programs – Programs** to find your **Shift: End** program.
3. Insert a **Reset – Job Reset** command.
4. Click **OK** and **Accept Changes** and **OK**. Now click on **More Options** to **Program Configuration to Device.**
5. Follow these instructions for each device.

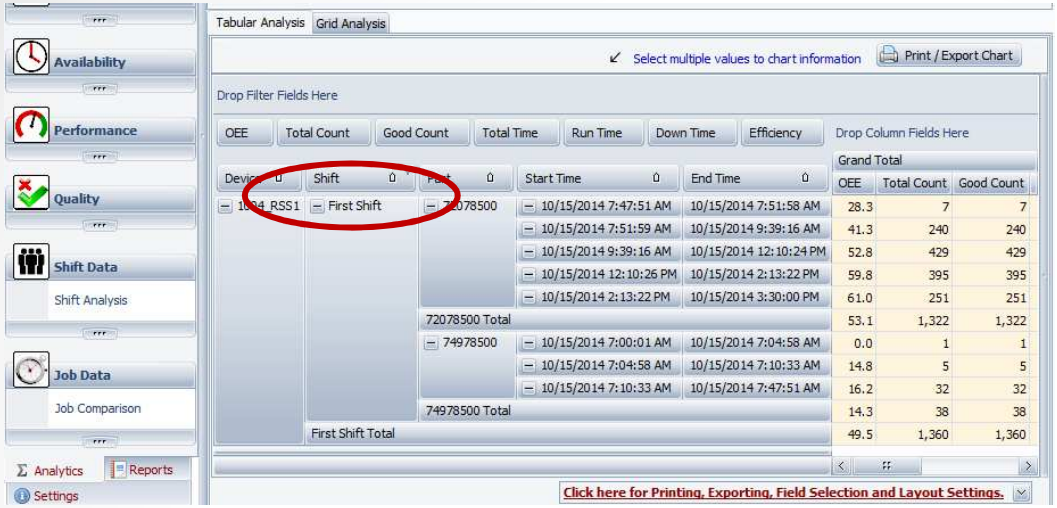
OEE Studio – Default Settings

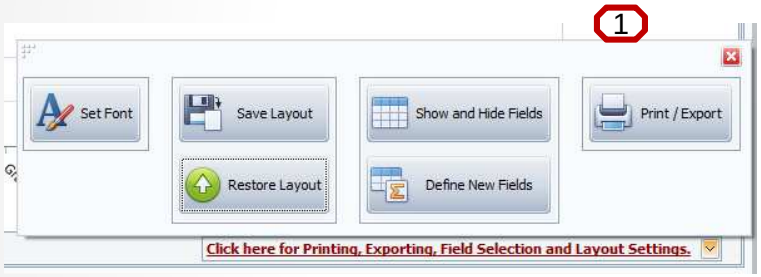


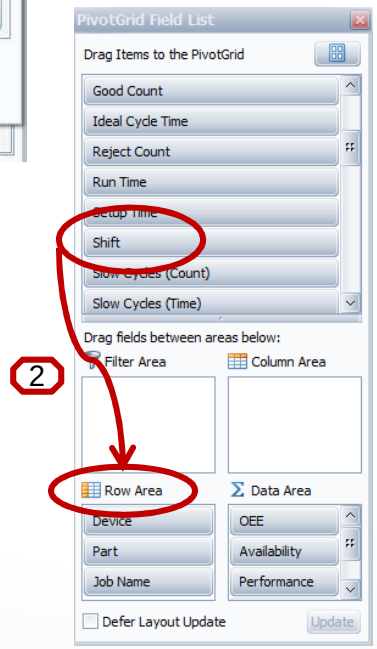
Now we need to label this field so that we can use it in our Ad Hoc Job reports.

1. Go to the **Settings** tab.
2. Select the **Defaults – General Defaults.**
3. Enter the name of the field for **User String 3** in the **Job User Fields.**
4. Click on **Apply Changes.**

OEE Studio – Job Comparison ad-hoc reporting







On the Analytics tab, expand Job Data and click on Job Comparison.

1. Expand the **Click here for Printing**…. and select Show and Hide Fields.
2. Find the field called '**Shift**' and drag it to the **Row Area**.
3. Select the rest of the data you want to see and enjoy your new report.
4. Don't forget to save your report Layout!

Not all data is equal ~

- Your reporting needs are unique to your environment and requirements:
  - How you use your Vorne XL devices may include special customization which could include the use of User Strings and User Numbers, custom calculations or unique production states (Down, Setup & Standby).
  - May require customized reporting solutions.

Contact Us

- As the Vorne Authorized Reporting Consultants, we provide customized reporting solutions, including working with data from your ERP/MRP systems.

- In addition to customized reporting, we provide support and customization for the OEE Studio reporting software (designed specifically for the data captured from the Vorne XL devices).

Debbie Olk, CSM

Deb-Tech Systems, Inc. ~ Algonquin, Illinois ~ 847.854.3148 (o) ~
Debbie.Olk@debtechsystems.com

DebTechSystems.com