

Quality Reject Reasons by Shift or Parts

First read this [document](#) to understand how to create scrap reasons in your Vorne XLv1 boards.

(OEE Studio v5.5)

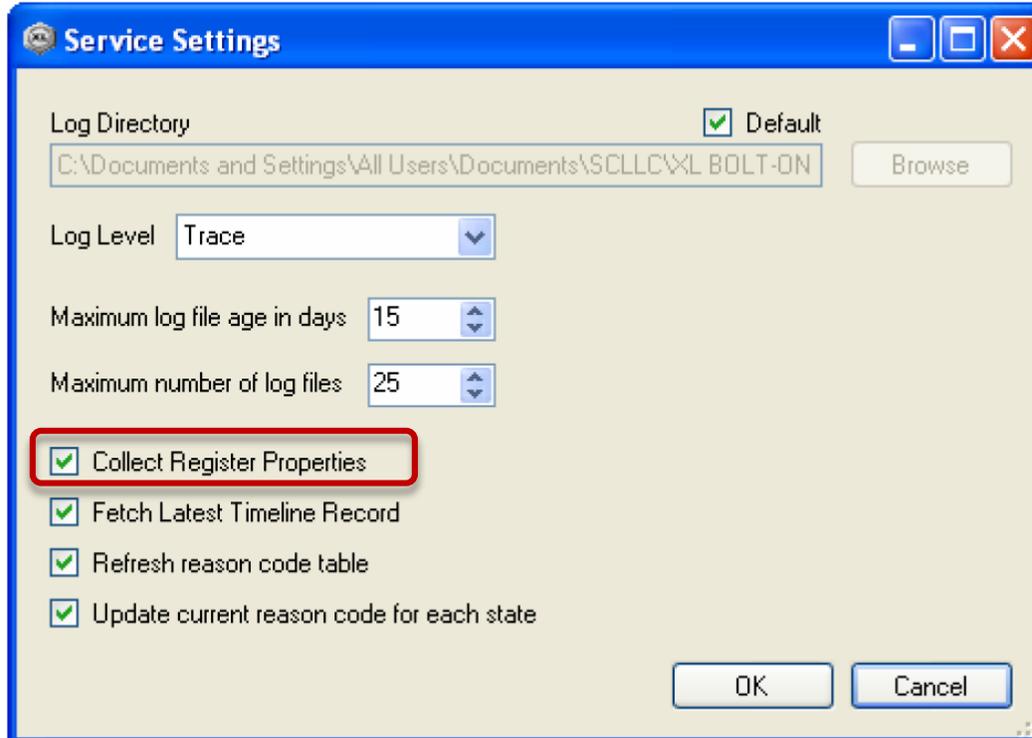
Introduction

Each Vorne XLv1 board has 8 User Numbers that get saved with each Shift and 8 User Numbers that get saved with each Job/Part.

- You can assign a unique reason for each of these 8 numbers. They must be the same reason for the Shift and the Job. You will need to identify them with the word Shift or Job respectively. For example:
 - User Number 1 would be Gluing Rejects-Shift
 - User Number 11 would be Gluing Rejects-Job
 - Click [Here](#) for the Vorne Tech Note.
 - Additionally, if you are using any of the User Numbers to store other information, this will show up in OEE Studio.
- The operator would have to scan the respective bar code each time there is a defect for that reason. It would be a count of 1 each time.
- It starts to get complex if you need to count more than one at a time.
- Requires expert level Vorne XLv1 configuration skills
- Requires the 'Collect Register Properties' to be enabled in the **XL Bolt-On Data Collector** so that this data is available in OEE Studio.

* IMPORTANT *

Quality – Reject Reasons



- By default, the '**Collect Register Properties**' option is not enabled in the XL Bolt-On Data Collector.
- This option will copy the Register Properties as you have defined them in your Vorne XLv1 boards.
- If this is not enabled and you are using the User Number registers to capture Scrap counts, the data will not show up in OEE Studio.
- You will need to contact us to get this feature enabled on your server.

Hide Main Menu Help

Shift Reject Reasons

Quality

Summary

Reject Reasons

Shifts

Parts

Quality Help

Enterprise Area Location

Reason Count Shift

Shift D...	Device	Reject Reason	First Shift	Third S...	Grand ...	
4/26/2022	900	Feed Rejects - Shift	10		10	
		MR Rejects - Shift	190		190	
		Run Rejects - Shift	135		135	
		Running Average Rate RPH	10,232		10,232	
		900 Total		10,567		10,567
4/27/2022	900	Feed Rejects - Shift		70	70	
		MR Rejects - Shift		128	128	
		Run Rejects - Shift		595	595	
		Running Average Rate RPH		9,061	9,061	
		900 Total		9,854		9,854
4/28/2022	900	Feed Rejects - Shift	30	110	140	
		MR Rejects - Shift	350	159	509	
		Run Rejects - Shift	313	170	483	
		Running Average Rate RPH	9,608	9,312	18,920	
		900 Total		10,301	9,751	20,052
5/2/2022	900	MR Rejects - Shift		416	416	
		Run Rejects - Shift		50	50	
		Running Average Rate RPH		9,021	9,021	
		900 Total		9,487		9,487
		917	Running Average Rate RPH	9,234	9,096	18,330
5/2/2022		9,234	18,583	27,817		
5/3/2022	900	Feed Rejects - Shift	25		25	
		MR Rejects - Shift	216		216	
		Run Rejects - Shift	218		218	
		Running Average Rate RPH	9,492		9,492	
		900 Total		9,951		9,951
917	917	Run Rejects - Shift	379	554	933	
		Running Average Rate RPH	10,408	8,003	18,411	
		917 Total	10,787	8,557	19,344	

Reject Reason

Feed Rejects - Shift

MR Rejects - Shift

Run Rejects - Shift

Running Average Rate RPH

Reload Data

Best Fit

Order

Show Field List

Show Prefilter

Filter by Top Values

PivotGrid Prefilter

And

[Reject Reason] Contains Reject

OK Cancel Apply

Reject Reasons - Shifts

You may need to filter the Reject Reasons if you are using the User Numbers to store other data.

You can do this by right-clicking on the Reject Reason column heading and select Show Prefilter.

<< Set the Prefilter query as shown here.

Chart your data

- Using the new enhanced charting feature, you can chart your data.



Reject Reasons - Grid Analysis

Tabular Analysis | **Grid Analysis**

Device

Shifts			Measurables				
Shift	Start Time	End Time	Total Reject Count	Good Count	Total Count	Device	Enter
Device: MO016ap004 OEE : , Performance : , Quality : , Availability :							
Shift X	9/28/2021 7:00:01...	9/28/2021 5:30:...	140	22,103	22,243	MO016ap004	

Reject Reasons

Reject Count	% of Total	Reason
81	57.9%	Empty Pouch
47	33.6%	Pleats
7	5.0%	Run-Off/Top Seal
4	2.9%	Double Bubble
1	0.7%	Missing/Light Nitrate
Total: 140		

Drill down by Shift or Part to see which Reject Reasons are the % of Total Reject count.

Hide Main Menu Help

Part Reject Reasons

Hierarchy: Area Printers

Date Range: From 4/25/2022 11:00 PM To 5/9/2022 11:00 PM

Production Filters: Device [All Devices] Part [All Parts]

Apply / Refresh Print / Export

Tabular Analysis Grid Analysis

Enterprise Area Location

Reason Count Part

Job Date	Device	Reject Reason	17341	24375	39299	41995	42004	48172	52522	52523	52531
4/27/2022	900	Feed Rejects - Job								40	30
		MR Rejects - Job								50	78
		Run Rejects - Job								140	66
		900 Total								230	174
4/28/2022	900	Feed Rejects - Job		20			60				20
		MR Rejects - Job		220			107				52
		Run Rejects - Job		300			75				39
		900 Total		540			242				111
5/2/2022	917	Not Applicable									
5/3/2022	900	Feed Rejects - Job			5	20					
		MR Rejects - Job			216	416					
		Run Rejects - Job			25	243					
		900 Total			246	679					
5/3/2022	917	Run Rejects - Job									
5/4/2022	900	Feed Rejects - Job					50	20			
		MR Rejects - Job					151	96			
		Run Rejects - Job					275	187			
		900 Total					476	303			
5/5/2022	917	Run Rejects - Job									
Grand Total			540	246	679	242	476	303	230	111	174

Reject Reasons - Parts

Reject Reasons by Parts behaves the same way as the Shifts screens.

You can move the data around on the Pivot Grid and then chart the results.

Deb-Tech Systems, Inc. & Production Improvement Systems Ltd.

Debbie.Olk@DebTechSystems.com

Russell@ProductionImprovement.com

1-800.975.3181 ext. 2