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
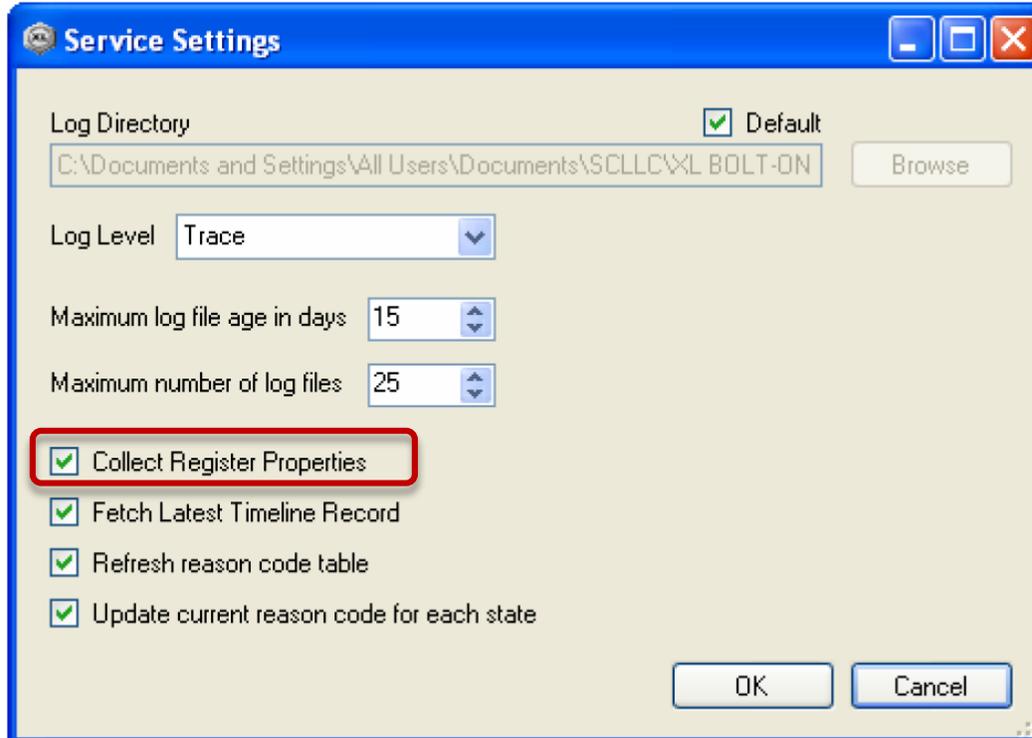
- By default, the '**Collect Register Properties**' option is not enabled in the XL Bolt-On Data Collector.

- 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

Hierarchy
Area | Printers

Date Range
From 4/25/2022 11:00 PM
To 5/9/2022 11:00 PM
Preset Dates **Prev/Next**
Choose Preset <<...>>

Production Filters
Shift [All Shifts] All
Device [All Devices] All

Apply / Refresh

Print / Export

Tabular Analysis | Grid Analysis

Enterprise | Area | Location

Reason Count

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	Run Rejects - Shift	379	554	933
		Running Average Rate RPH	10,408	8,003	18,411
	917 Total		10,787	8,557	19,344

Shift ⇕

Reject Reas...

Feed Reject
MR Rejects
Run Rejects
Running Ave

Reload Data
Best Fit
Order
Show Field List
Show Prefilter
Filter by Top Values

Feed Reject
MR Rejects - Shift

Quality

Summary

☐ Reject Reasons

Shifts

Parts

Quality Help

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.

PivotGrid Prefilter

And ⊕
   [Reject Reason] Contains Reject

OK | Cancel | Apply

<< 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

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

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.

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