

# OEE Studio Tool Tip Job/Shift Data

Viewing Part/Job Data with associated Shift  
Requirements – Vorne XL(v1) programming  
Updated October 5, 2020

# Challenge ~

- In OEE Studio you can view data associated with specific shifts and data associated with specific parts/jobs.
  - This is due to how the Vorne XL(v1) 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(v1) 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(v1) programs:
    - Your **Part/Job Reset** program should include a command to copy the Shift ID to User String 13 (for example)
    - 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 **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 **dependency** is that you need to use **one** of **User Strings 11 – 14** that are **not** being used. (These are associated with each job.) I usually recommend User String 13.

# Changes to Vorne XL(v1)v1 Programs

The Parts module contains the set of preconfigured parts that are available for selection in the **Administer | Settings | Part** page, or when a new Job is loaded in the **Administer | Settings | Job** page. The part to use can also be configured on-the-fly in either page, but commonly used parts should be configured here for ease of use. Parts with blank Part IDs will not be available for selection.

ID	Producto	Ideal Cycle	Takt Time	Scale Factor 1	Scale Factor 2	Program to Execute
Sample Part		1.00	1.00	1.00	1.00	~Part Start No Setup
9529		11.61	11.61	2.00	1.00	~Part Start No Setup
73022		12.00	10.00	2.00	1.00	~Part Start No Setup

1

### Program Information

Select Program

Program Number

Program Name

Each Program consists of a sequence of one or more commands and their parameters. Commands can be inserted, edited, deleted, and reordered (the latter by drag-and-drop) through the user interface.

Program - ~Part Start No Setup
Production State > Save ()
Display > Play Message (Message=Part Message)
String Register > Copy (Source=Shift ID, Destination=Short String 13)
Program > Execute After Delay (Program=~Message: Restore, Timer=12, Delay=5)
Program > Execute Immediately (Program=Reset Job UN)

4

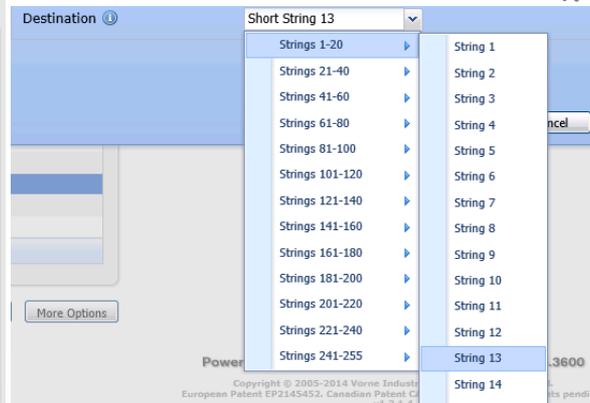
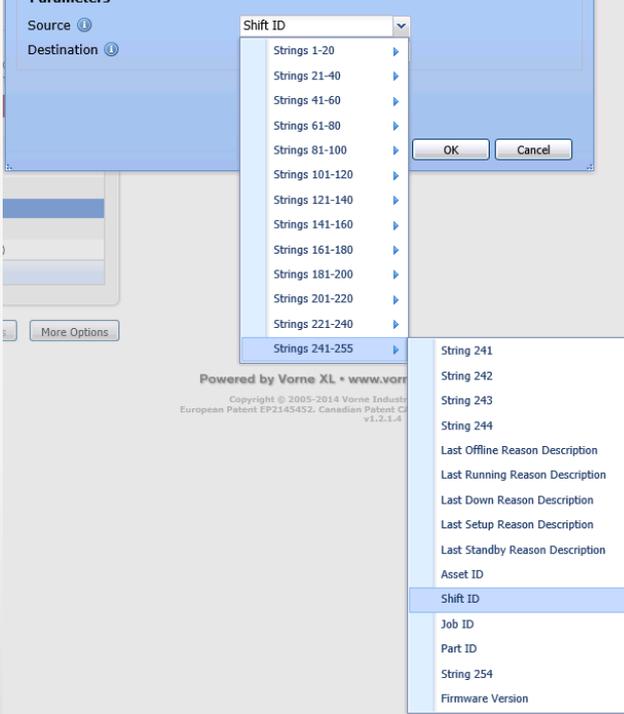
1. **Part/Job Reset** This should be whatever program you use to reset parts/jobs. This example is using a program called **~Part Start No Setup**.
2. Log into the Vorne XL(v1) as administrator.
3. Go to **Administer – Configure Device – Programs – Programs** to find the program you use to Execute when you scan a **Part** barcode.
4. Insert a new command **AFTER** the **Display > Play Message** instruction. Do not make it the last command.

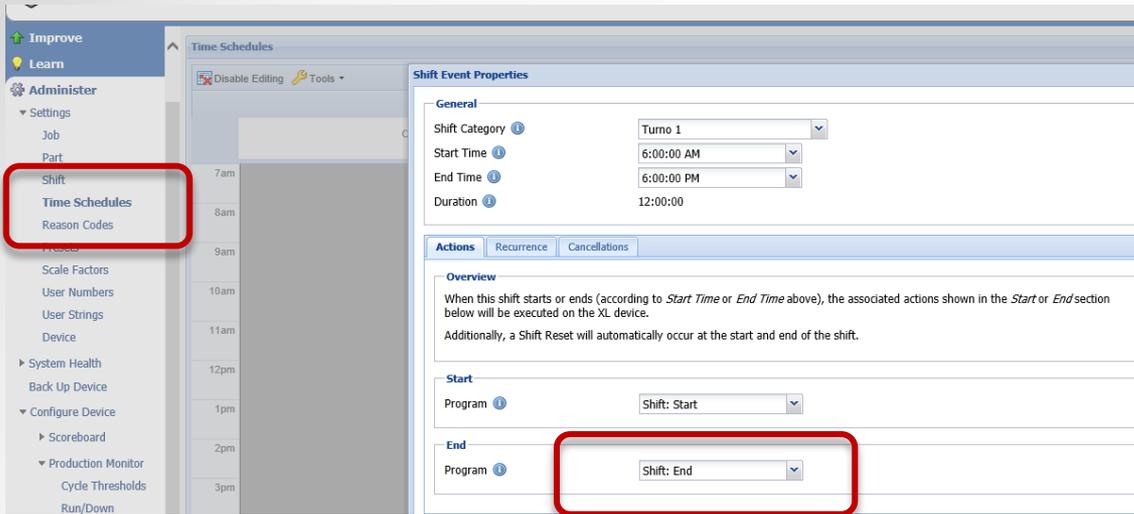
# Insert Command in “part/job reset” program

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.

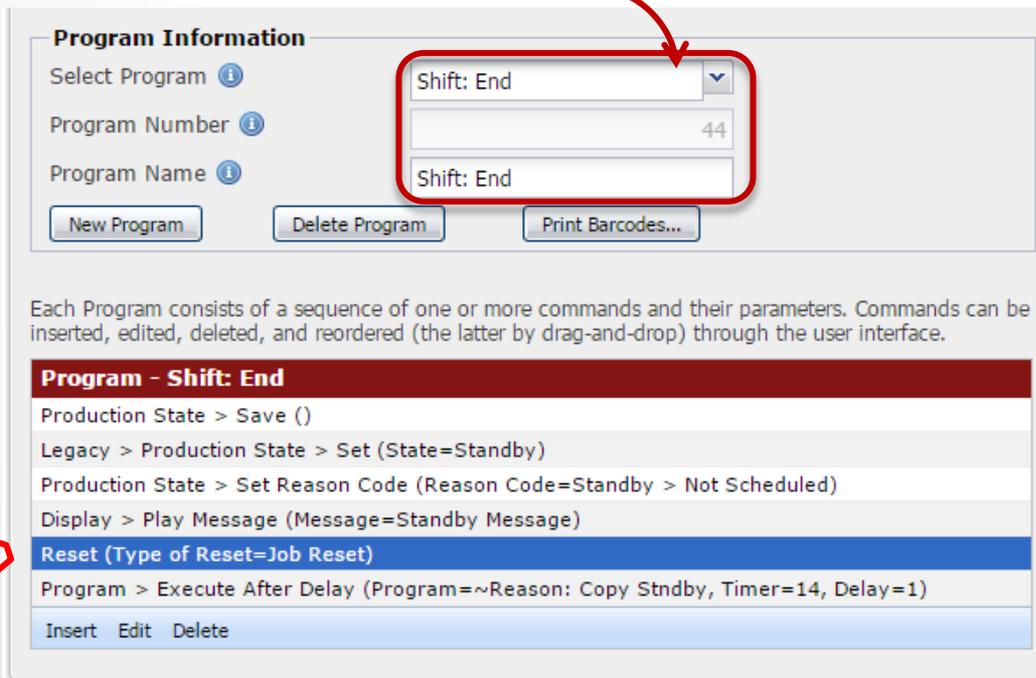
4. Click **OK** and **Accept Changes** and **OK**. We will reprogram the device after we make one more change.

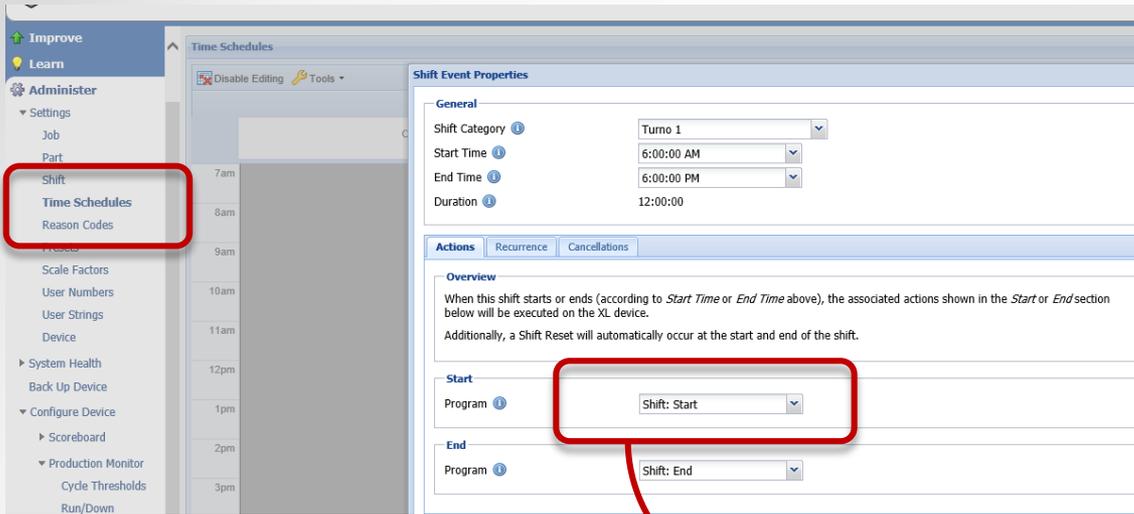




# Changes to Shift End program

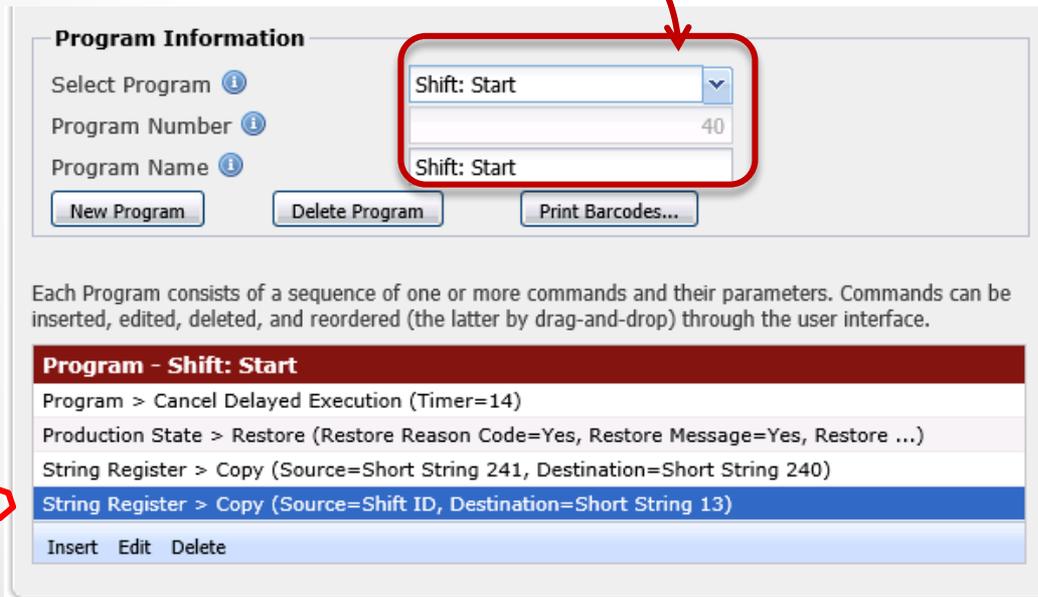
1. **Shift: End-** This should be whatever program you use at Shift End in the **Time Schedules**. Log into the Vorne XL(v1) as administrator.
2. Go to **Administer – Configure Device – Programs – Programs** to find your **Shift: End** program.
3. Insert a **Reset – Job Reset** command.
4. Click **OK** and **Accept Changes** and **OK**. Now click on **More Options to Program Configuration to Device**.
5. Follow these instructions for each device.





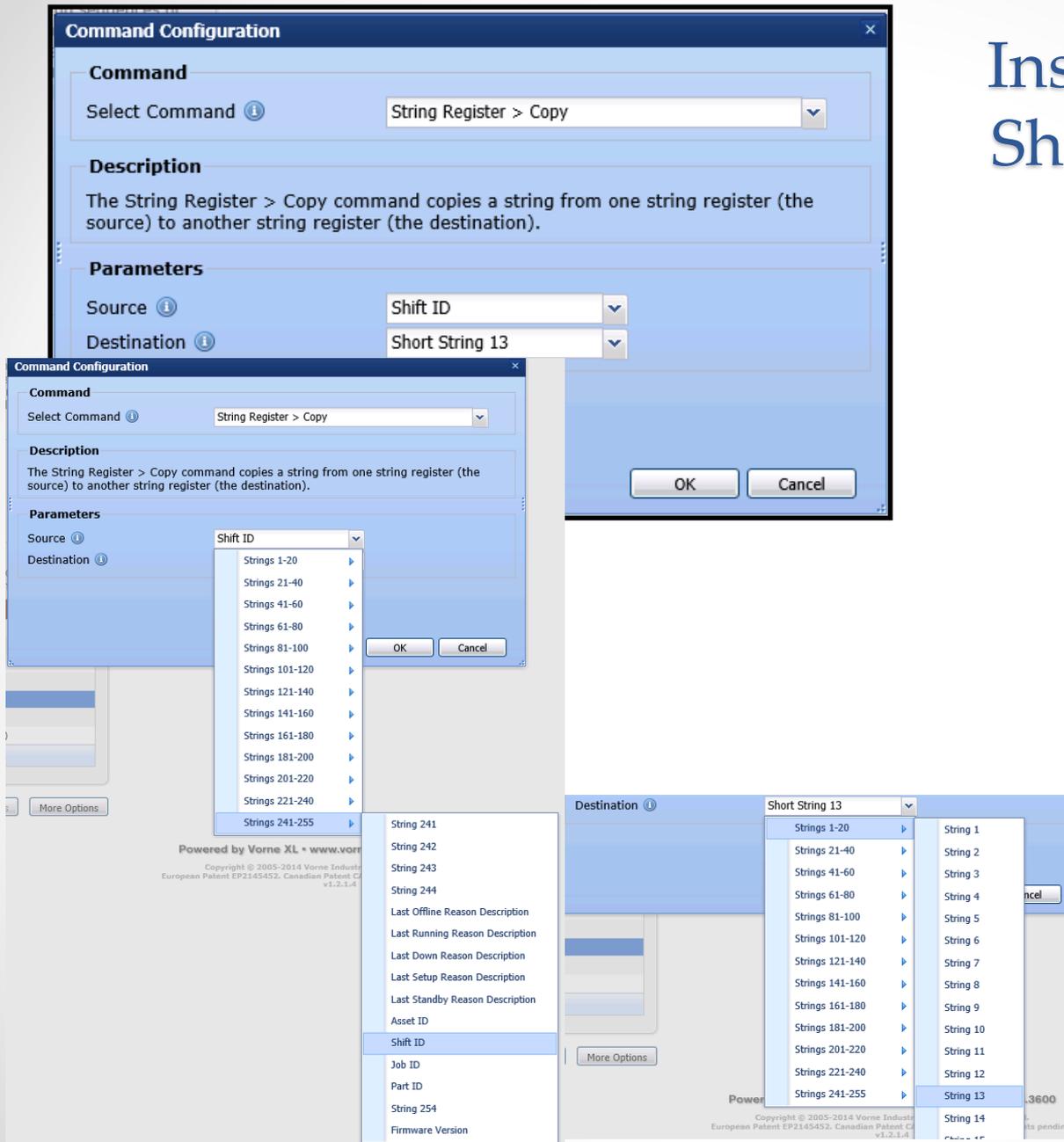
# Changes to Shift: Start Program

1. **Shift: Start** - This should be whatever program you use at Shift Start in the Time Schedules. Log into the Vorne XL(v1) as administrator.
2. Go to **Administer – Configure Device – Programs – Programs** to find your **Shift: Start** program.
3. Insert a new command to copy the current Shift ID to User String 13.



# 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.



# 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**.

The screenshot shows the 'System Defaults' configuration window. The interface includes a left-hand navigation pane with 'System', 'Defaults', 'OEE Data', and 'Ignore Data' sections. The 'Defaults' section is expanded to show 'General Defaults'. The main area is titled 'System Defaults' and contains several sections: 'Default Start Time' with 'Shift Start Time' set to 5:00 AM and 'Shift End Time' set to 2:00 AM; 'Downtime calculation' with checkboxes for 'Include Standby in Downtime' (unchecked) and 'Include Setup in Downtime' (checked); 'Job User Fields' and 'Shift User Fields' sections, each with a table of user fields. The 'Job User Fields' table has columns for 'Job User Number Descriptions' and 'Job String Descriptions'. The 'Shift User Fields' table has columns for 'Shift User Number Descriptions' and 'Shift User String Descriptions'. Red circles with numbers 1 through 4 highlight the following elements: 1. The 'Settings' tab in the bottom navigation bar. 2. The 'General Defaults' option in the left navigation pane. 3. The 'User String 3' field in the 'Job String Descriptions' table, which contains the text 'Shift'. 4. The 'Apply Changes' button in the top right of the main configuration area.

Job User Fields		Shift User Fields	
Job User Number Descriptions	Job String Descriptions	Shift User Number Descriptions	Shift User String Descriptions
User No. 1 Actual Head Count	User String 1 Product Family	User No. 1	User String 1 Operator
User No. 2	User String 2 Description	User No. 2	User String 2
User No. 3	User String 3 Shift	User No. 3	User String 3
User No. 4	User String 4	User No. 4	User String 4
User No. 5		User No. 5	
User No. 6		User No. 6	
User No. 7		User No. 7	
User No. 8		User No. 8	

# 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!

Tabular Analysis Grid Analysis

Select multiple values to chart information Print / Export Chart

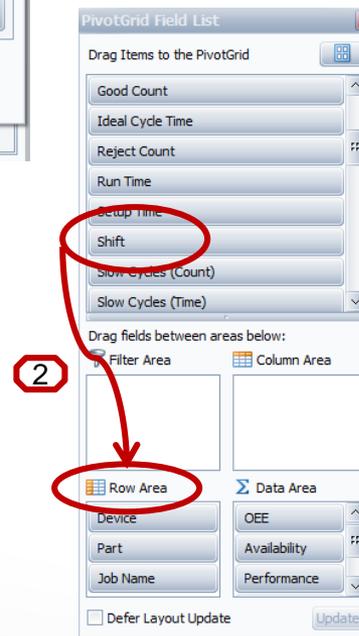
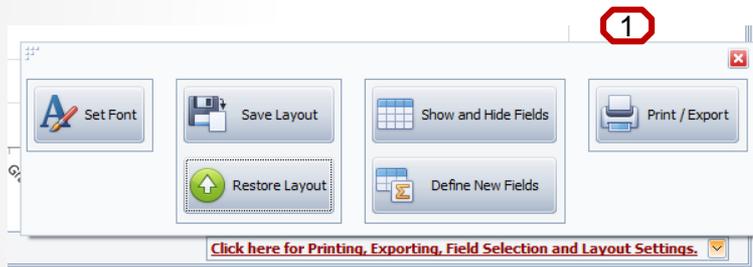
Drop Filter Fields Here

OEE	Total Count	Good Count	Total Time	Run Time	Down Time	Efficiency
1004_RSS1	First Shift	72078500	10/15/2014 7:47:51 AM	10/15/2014 7:51:58 AM		
			10/15/2014 7:51:59 AM	10/15/2014 9:39:16 AM		
			10/15/2014 9:39:16 AM	10/15/2014 12:10:24 PM		
			10/15/2014 12:10:26 PM	10/15/2014 2:13:22 PM		
			10/15/2014 2:13:22 PM	10/15/2014 3:30:00 PM		
72078500 Total						
			10/15/2014 7:00:01 AM	10/15/2014 7:04:58 AM		
			10/15/2014 7:04:58 AM	10/15/2014 7:10:33 AM		
			10/15/2014 7:10:33 AM	10/15/2014 7:47:51 AM		
74978500 Total						
First Shift Total						

Drop Column Fields Here

Grand Total	OEE	Total Count	Good Count
	28.3	7	7
	41.3	240	240
	52.8	429	429
	59.8	395	395
	61.0	251	251
	53.1	1,322	1,322
	0.0	1	1
	14.8	5	5
	16.2	32	32
	14.3	38	38
	49.5	1,360	1,360

Click here for Printing, Exporting, Field Selection and Layout Settings.



# OEE Studio

Check out our website for other Tool Tips

[www.ocestudio.com](http://www.ocestudio.com)

OEE Studio supports all versions of Vorne XL v1 device firmware.

Smart Installation

<http://www.ocestudio.com/installs/release/v4/setup/InstallOEEStudio.exe>

If you have questions or need assistance, please contact either  
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