

OEE Studio Release Note

Version 4.5

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What's New in 4.5

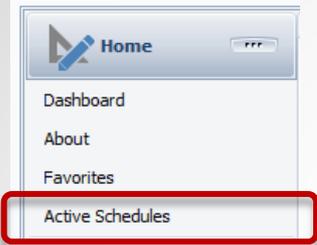
- **Enhancements**
- **NEW – Active Schedules Status dashboard** – View scheduled reports and check status of the Scheduling Service.
- **Trends – Time & Frequency Loss** – Selectable lines
- **Availability – Graphical Analysis** – Select one or more lines at a time
- **Availability – Tabular Analysis** – Dynamic charting
- **Shift Data & Job Data** – New Show Target line for the charts
- **Report – All Shift Production Summary** – provides ability to include comments, includes Good Count Bar Chart on top of OEE Trend Chart
- **Report – Shift OEE With Comments** – displays last part ran
- **Report – Line OEE** – Provides ability to select one or more lines or by hierarchy
- **Report - Top Losses** – Provides ability to print the report summarized by hierarchy selection or to provide a page per device selected.
- **Schedule & Email Reports - Improved** ability to Schedule Canned reports for emailing, more visibility into shift times and data capture times.
- **Default Settings** – saved per user. Especially useful for multiple locations, different timezones, etc.
- **Updated Website** – More online help - check it out!! www.oestudio.com/toolbox.html

Active Schedules Status Dashboard

The OEE Studio Scheduler Service is controlled by the OEE Studio Scheduler Admin application that is installed on the same server as the XL Bolt-On Data Collector. It is a windows service that is constantly running.

Because most people do not have access to their servers, we have now added the Active Schedules Dashboard so that you can easily see how your reports are scheduled and when they are expected to run.

Each scheduled report shows up as a tile on the screen.



Schedule Summary

Enter text to search... Find Clear

5/2/2019 12:55:46 PM
Thursday, May 02, 2019

Scheduling Service

Last Service Poll
Thursday, May 02, 2019 12:55:26 PM
19 seconds ago

Last Service Status Report
Thursday, May 02, 2019 12:55:25 PM
The Scheduler Service was restarted

Last Change to Schedules
Thursday, May 02, 2019 12:55:32 PM

Scheduling and Shifts

Important : Shift Times and Scheduling :

Data for reporting on a device is only available at the end of the shift. If a shift is still in progress when the schedule is run, no data will be available for that shift. Please make sure the start time, end time and schedule time are chosen appropriately.

Use the buttons for each schedule to view a summary of the recent shift times and projected schedules.

#1 - *All Shift Production Summary Report with Comments

Title: *All Shift Production Summary Report with Comments
Description: VetigROUP
Created by DebbieO 3/15/2019
Frequency: Every Week on Friday at 9:00 AM.
Date Range: Current Week
Hierarchy: Enterprise VetigROUP
Start Time: 06:30 AM
End Time: 06:30 PM
Next Run Date: Friday, 03 May 2019 09:00 AM

View Shift Times Show Projected Schedules Show Report Parameters

#2 - Shift Comment Report - First Shift - Line 5

Active Schedules Status Report Tile

#1 - *All Shift Production Summary Report with Comments ^

Title:	*All Shift Production Summary Report with Comments
Description:	VetiGROUP Created by DebbieO 3/15/2019
Frequency:	Every Week on Friday at 9:00 AM.
Date Range:	Current Week
Hierarchy:	Enterprise VetiGROUP
Start Time:	06:30 AM
End Time:	06:30 PM
Next Run Date:	Friday, 03 May 2019 09:00 AM

 View Shift Times  Show Projected Schedules  Show Report Parameters

Each Report Tile displays the information about the report.

View Shift Times – displays all the shift start and end times as well as the time the shift was captured and copied to the database.

Show Projected Schedules – displays the projected scheduling of the report based on the defined parameters.

Show Report Parameters – displays all of the options that were selected for the report.

Active Schedules Status Report – View Shift Times

Shift Start and End Times

Enterprise VetiiGROUP.

Late starting or finishing shifts are displayed in red
Late Capture Times are displayed in yellow

Expand All Collapse All

Device Shift

Start Time	End Time	Capture Time
Device: Bartelt5		
Shift: First Shift		
1/16/2019 6:30:01 AM	1/16/2019 2:50:01 PM	1/16/2019 2:49:45 PM
1/17/2019 6:30:01 AM	1/17/2019 2:50:01 PM	1/17/2019 2:49:45 PM
1/18/2019 6:30:01 AM	1/18/2019 2:50:01 PM	1/18/2019 2:49:45 PM
1/21/2019 6:30:01 AM	1/21/2019 2:50:01 PM	1/21/2019 2:49:45 PM
1/22/2019 6:30:01 AM	1/22/2019 2:50:01 PM	1/22/2019 2:49:45 PM
1/23/2019 6:30:01 AM	1/23/2019 2:50:01 PM	1/23/2019 2:49:45 PM
1/24/2019 6:30:01 AM	1/24/2019 2:50:01 PM	1/24/2019 2:49:45 PM
1/25/2019 6:30:01 AM	1/25/2019 2:50:01 PM	1/25/2019 2:49:45 PM
1/28/2019 6:30:01 AM	1/28/2019 2:50:01 PM	1/28/2019 2:49:45 PM
1/29/2019 6:30:01 AM	1/29/2019 2:50:01 PM	1/29/2019 2:49:45 PM
1/30/2019 6:30:01 AM	1/30/2019 2:50:01 PM	1/30/2019 2:49:45 PM
Shift: Second Shift		
Shift: Third Shift		
Device: Bartelt6		
Shift: First Shift		
1/16/2019 6:30:00 AM	1/16/2019 2:50:00 PM	1/16/2019 2:51:45 PM
1/17/2019 6:30:00 AM	1/17/2019 2:50:00 PM	1/17/2019 2:51:45 PM
1/18/2019 6:30:00 AM	1/18/2019 2:50:00 PM	1/18/2019 2:51:45 PM
1/21/2019 6:30:00 AM	1/21/2019 2:50:00 PM	1/21/2019 2:51:45 PM
1/22/2019 6:30:00 AM	1/22/2019 2:50:00 PM	1/22/2019 2:51:45 PM
1/23/2019 6:30:00 AM	1/23/2019 2:50:00 PM	1/23/2019 2:52:45 PM
1/24/2019 6:30:00 AM	1/24/2019 2:50:00 PM	1/24/2019 2:52:45 PM

Close

It is **VERY IMPORTANT** to understand how your shift start and end times have been scheduled in each Vorne XL v1 device.

As the example to the left shows for the First Shift, the shift Start and End times are always 1 second after the whole shift time.

This 1 second will impact how the report will bring back data. Therefore, when you select the report parameters for the start and end, it is recommended that you add 1 minute to the report end time.

(Please see this tool tip for more details ~ **Scheduling Reports:**

<http://oeestudio.com/images/Scheduler/OEEStudio-ScheduleReportsToBeEmailed.pdf>

The **Capture Time** is also important. In the first instance it shows that the data was copied from the device to the database a couple of seconds before the shift end time. As long as it shows up in this screen, it will show up in the report.

If the Capture Time is highlighted in Yellow, it means that the data copied from the device was harvested after the shift ended. This could be due to network issues. If this happens on a consistent basis, then you need to make sure you schedule the report in the timeframe after the Capture Time.

Active Schedules Status – Show Report Parameters

Favorite Scheduling Parameters [X]

Date Range: Current Day
Date Values: From 5/2/2019 6:30:00 AM To 5/2/2019 2:51:00 PM

Hierarchy: Enterprise
Hierarchy Value: VetiiGROUP
Device: Bartelt5
Down Time Include Standby: Yes
Down Time Include Setup: No
Selected Shifts: First Shift
Production OEE Show Run State: No
Production OEE Show Down State: Yes
Production OEE Show Setup State: No
Production OEE Show Standby State: No
Line OEE Report Level: 0
Favorite Stored Title: Shift Comment Report - First Shift - Line 5
Favorite Stored Description: VetiiGROUP
Bartelt5
Created by DebbieO 4/29/2019

OK

The Show Report Parameters button displays all of the parameters that were selected for the given report.

Take note that the Date Range To: is 1 minute after the actual Shift End time.

Hierarchy
Enterprise [v] VetiiGROUP [v]

Date Range
From 5/2/2019 [v] 6:30 AM [v]
To 5/2/2019 [v] 2:51 PM [v]
Preset Dates Choose Preset [v] Prev/Next <<...>> [v]

Available Items
 1st Shift
 1st Shift 12 Hrs
 1st Shift Friday
 2nd Shift 12 Hrs
 2nd Shift Friday
 First Shift

Show in Top Losses
 Running
 Down
 Setup
 Standby

Devices
Bartelt5 [v] All

Print / Preview

View Shift Times

Active Schedules Status – Show Projected Schedules

The screenshot displays the 'Projected Scheduling' window, which is divided into two main sections: 'Projected Scheduling Details' and 'Schedule Options'.

Projected Scheduling Details: This section lists four projected report runs. Each entry includes the 'Report Run Date', the 'Range Selected' (1 Day(s)), the 'Start Date' (6:30 AM), the 'End Date' (2:51 PM), and the report content: 'Enterprise VetiiGROUP', 'Bartelt5', and 'First Shift'. The first entry is highlighted with a red box, and a red arrow points from it to the 'Daily Scheduled Report' section in the 'Schedule Options' panel.

Schedule Options: This panel contains several configuration options:

- Schedule to Run Report Every:** Radio buttons for Day (selected), Week, Month, and Not Scheduled.
- Time Filters:** A section for 'Date Range : One Day' with a note: 'These are the **time values used to generate the report content** (not the time that the report will run). Please make sure that these take the shift times into account. See "**Shift Times and Scheduling**" below.' It includes 'Start Time' (6:30:00 AM) and 'End Time' (2:51:00 PM) dropdown menus.
- Single Day Reporting:** Radio buttons for 'Full Day (Start Date is the day before the End Date)' and 'Current Day (Start Date and End Date are on the same day)' (selected).

Daily Scheduled Report: A sub-section within 'Schedule Options' showing 'Run Report Every Day at 2:55:00 PM' with a dropdown arrow.

A 'Close' button is located at the bottom center of the window.

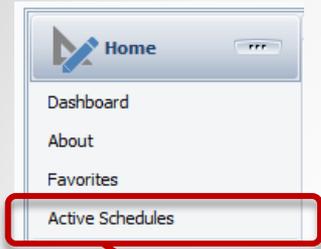
Use this screen to verify that the report is correctly scheduled.

Active Schedules Status Dashboard

If you feel that you are not receiving report emails, you can check the status of the Scheduler Service through the Active Schedules Dashboard.

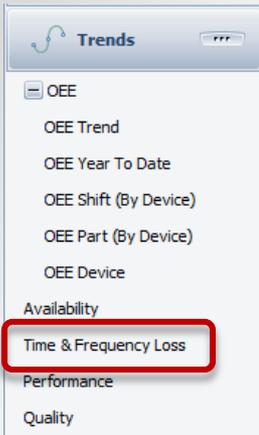
You will see that the Report Tiles are no longer displayed and there is a notice that the Scheduler Service was stopped.

There are any number of reasons why this could happen. Please contact the support team to assist in getting the Service started.



A screenshot of the 'Active Schedules Status Dashboard'. The page title is 'Schedule Summary'. The top right has a search bar with 'Enter text to search...', 'Find', and 'Clear' buttons. The main content area is divided into several sections. The first section is titled 'Scheduling Service' and contains three sub-sections: 'Last Service Poll' (Thursday, May 02, 2019 1:41:53 PM) with a red message 'over an hour ago. Scheduler is likely stopped or unavailable'; 'Last Service Status Report' (Thursday, May 02, 2019 1:41:53 PM) stating 'The Scheduler Service was stopped'; and 'Last Change to Schedules' stating 'Scheduling is empty or inactive'. This entire 'Scheduling Service' section is circled in red. Below it is a section titled 'Scheduling and Shifts' with a sub-section 'Important : Shift Times and Scheduling :'. This section contains text about data reporting and shift times, and instructions to use buttons for schedule summaries.

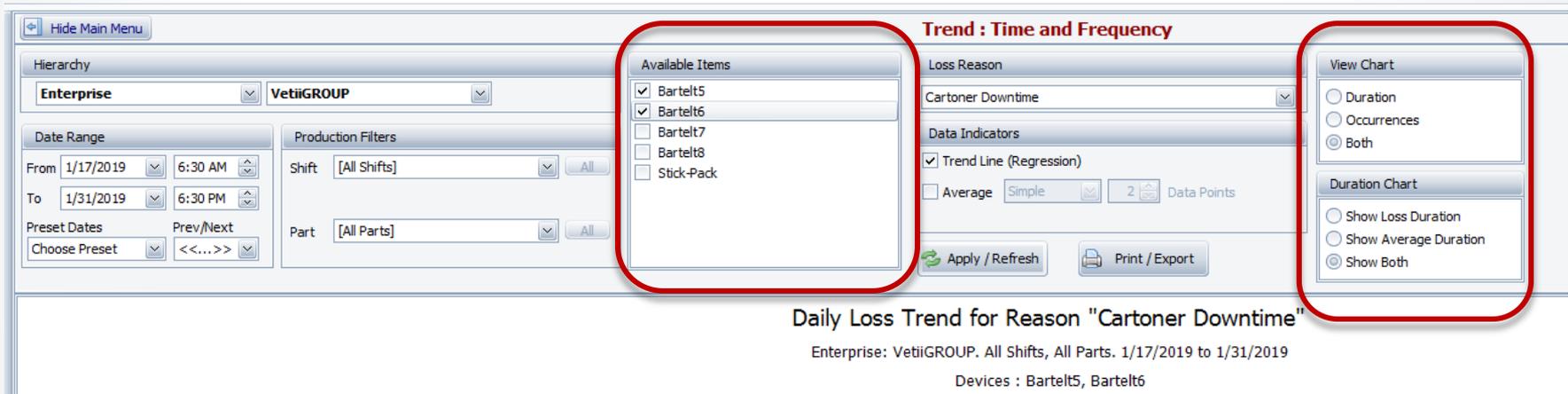
Trends – Time & Frequency Loss Charts



Optional selectors to view one or more Devices.

Optional selectors to view specific Trends and Durations.

The next couple of pages will show the differences.

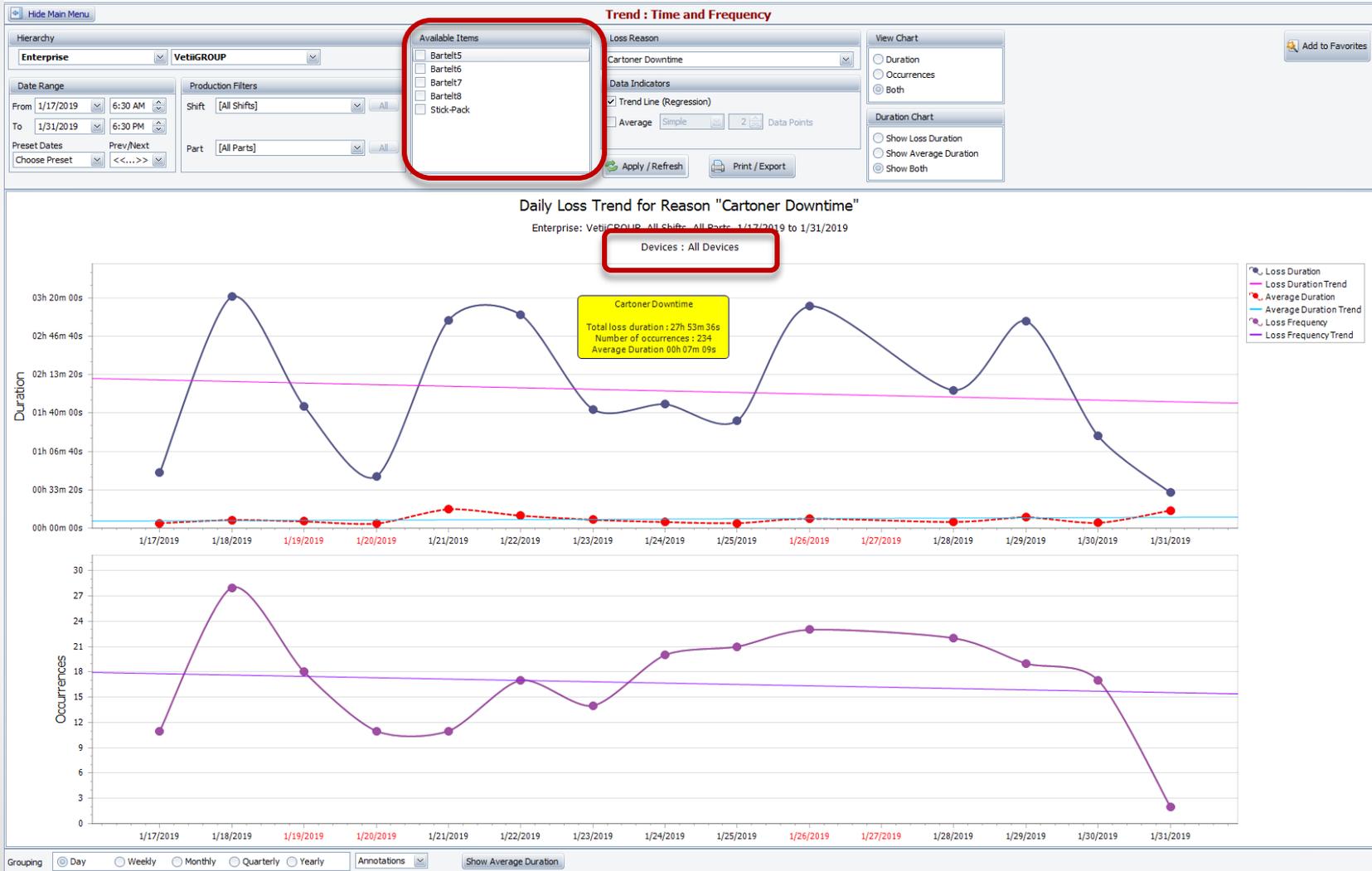


There are three option boxes.

- **NEW - Available Items** – provides the ability to select one or more devices.
- **View Chart** is used to select which Chart you want to see.
- **Duration Chart** is used to select which trend lines to see in the Duration Chart. More information about these views can be found here ~

<http://oeestudio.com/images/TrendReports/OEEStudio-Trends-TimeFrequencyLossCharts.pdf>

Trends – Time & Frequency Loss - All Devices



Trends – Time & Frequency Loss - Selected Devices

Hide Main Menu

Hierarchy: Enterprise | VetiiGROUP

Date Range: From 1/17/2019 6:30 AM To 1/31/2019 6:30 PM

Production Filters: Shift [All Shifts] Part [All Parts]

Available Items:

- Bartelt5
- Bartelt6
- Bartelt7
- Bartelt8
- Stick-Pack

Trend: Time and Frequency

Loss Reason: Cartoner Downtime

Data Indicators:

- Trend Line (Regression)
- Average

View Chart:

- Duration
- Occurrences
- Both

Duration Chart:

- Show Loss Duration
- Show Average Duration
- Show Both

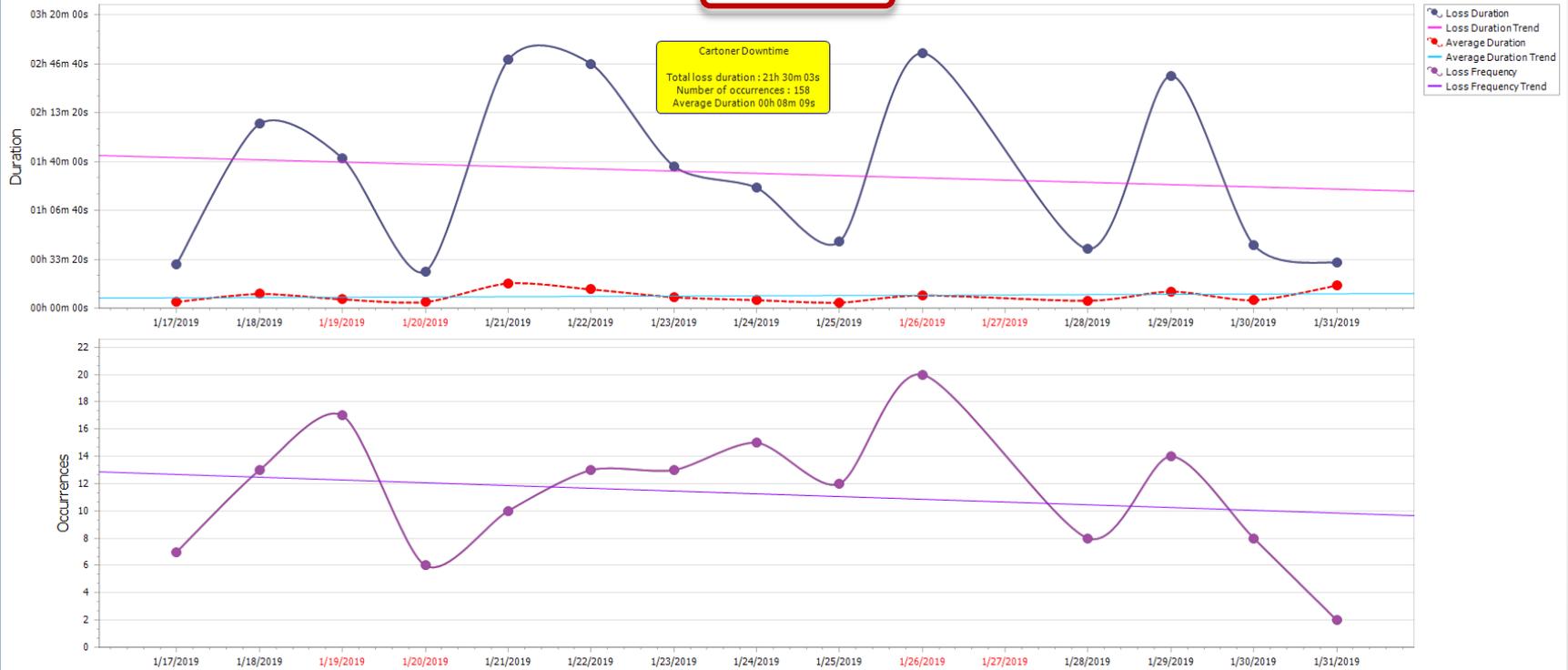
Buttons: Apply / Refresh, Print / Export, Add to Favorites

Daily Loss Trend for Reason "Cartoner Downtime"

Enterprise: VetiiGROUP | All Shifts, All Parts: 1/17/2019 to 1/31/2019

Devices : Bartelt5, Bartelt6

Cartoner Downtime
 Total loss duration : 21h 30m 03s
 Number of occurrences : 158
 Average Duration 00h 08m 09s



Grouping: Day Weekly Monthly Quarterly Yearly

Annotations: Show Average Duration

Availability – Graphical Analysis - Graphical Comparison

Optionally include specific devices. Unchecked defaults to All Devices.



Availability – Tabular Analysis - Charting

Availability

- Analysis
 - Graphical Analysis
 - Tabular Analysis**
 - Loss Events
 - Shifts
 - Parts
 - State Comparison

Availability Loss Comparison

Hide Main Menu

Enterprise: VetIGROUP

Date Range: From 1/17/2019 6:30 AM To 1/31/2019 6:30 PM

Production Filters: Shift [All Shifts] Part [All Parts]

Include Devices:

- Bartelt5
- Bartelt6
- Bartelt7
- Bartelt8
- Stick-Pack

Include:

- Effect
- Run Time
- Down Time
- Setup Time
- Standby Time

Options:

- OEE Alert Coloring for Reason: "None"

Buttons: Apply / Refresh, Print / Export, Add to Favorites

Navigation: Tabular Analysis (selected), Grid Analysis

Select multiple values to chart information

Enterprise	Location	Type	Duration (Sum)	Reason Count
Grand Total				
Device	Loss Reason	State	Duration (Sum)	Reason Count
Bartelt6	Butler Downtime	Down	01h 20m 49s	19
Bartelt6	Carton Checkweigher D...	Down	00h 03m 26s	1
Bartelt6	Cartoner Downtime	Down	11h 36m 25s	101
Bartelt6	Combi Scales / Conveyor	Down	00h 03m 05s	1
Bartelt6	Conditioner Downtime	Down	03h 21m 25s	33
Bartelt6	Defective Material	Down	00h 08m 53s	1
Bartelt6	Feeding System Downtime	Down	04h 38m 34s	51
Bartelt6	Late Downtime	Down	00h 11m 42s	14
Bartelt6	Material Not Available	Down	00h 18m 27s	2
Bartelt6	None	Down	01h 38m 13s	27
Bartelt6	Pickoff Assembly	Down	01h 09m 01s	6
Bartelt6	Pouch Checkweigher Do...	Down	01h 13m 10s	14
Bartelt6	Pouching Fill Heads	Down	00h 27m 27s	6
Bartelt6	Pouching Knives	Down	00h 45m 07s	6
Bartelt6	Pouching Machine Down	Down	03h 56m 31s	38
Bartelt6	Pouching Seal Bars	Down	00h 12m 48s	3
Bartelt6	Repack	Down	06h 29m 13s	37
Bartelt6	Rework	Down	02h 41m 57s	16
Bartelt6	X-ray Downtime	Down	00h 30m 26s	7
Bartelt6 Total			40h 46m 39s	383

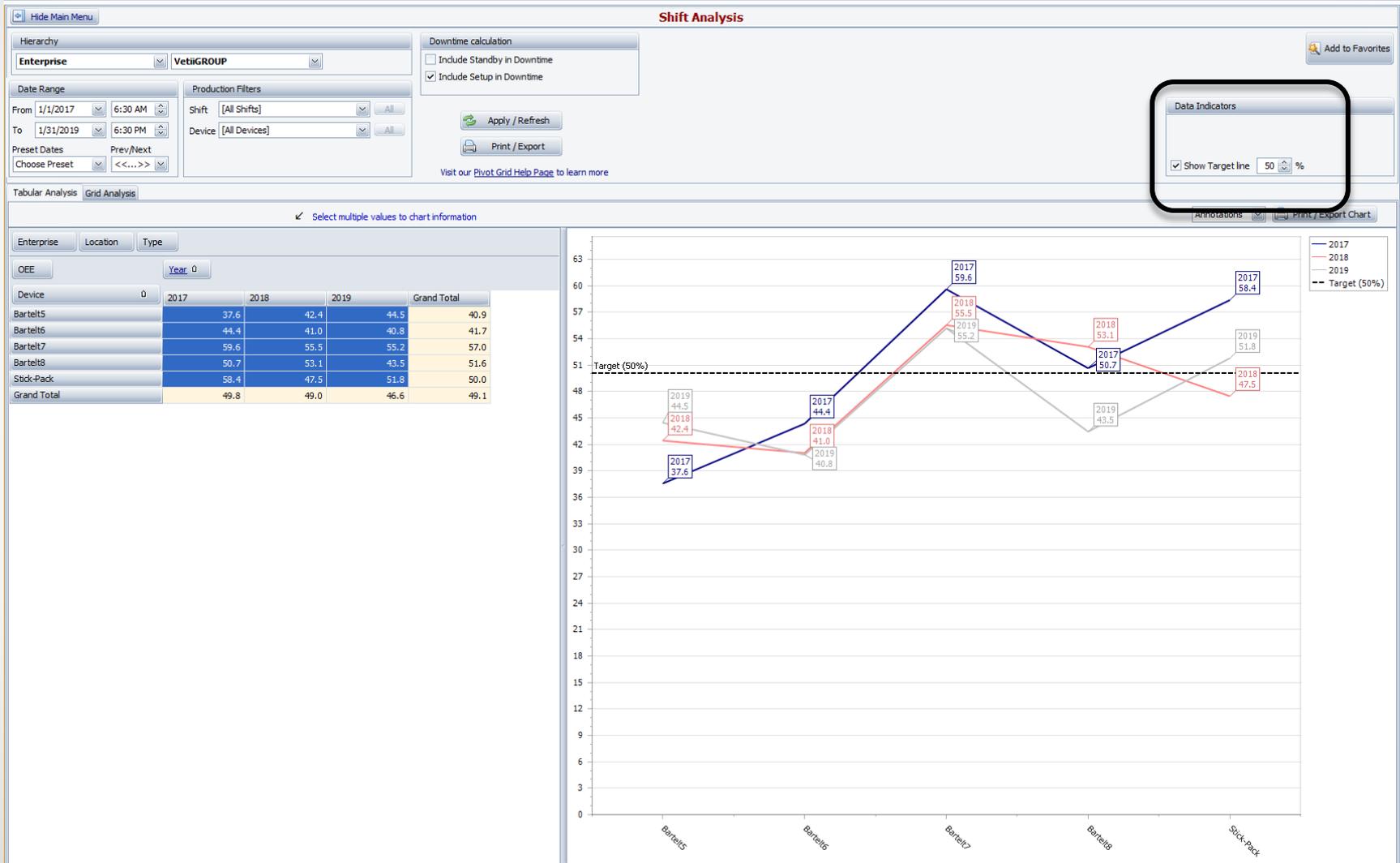
Annotations: Print / Export Chart

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

Charting Options

Shift Data & Job Data – Show Target Line

Set the target! Select the Show Target Line and adjust the percentage to view the trend.



Reports – All Shift Production

Optional Report capabilities

The screenshot displays the 'All Shift Production Reporting' interface. The left sidebar shows navigation options, with 'All Shift Production' highlighted in a red box. The main area contains several configuration panels. The 'Charting' panel is highlighted with a red box, and a red arrow points from the 'Show Good Count' checkbox to the handwritten text below.

When selecting OEE Trend, the Show Good Count option is available.

Reports - Loss Reports – Top Losses

Optional Report capabilities

Shift Reports

- Production
 - Shift Production
 - All Shift Production
 - Shift Summary
 - Shift OEE
 - Shift OEE With Comments
- Line Reports
- Line OEE
- Loss Reports
- Top Losses

Hide Main Menu

Enterprise VetiGROUP

Date Range: To 1/31/2019

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

Options: OEE Alert Coloring for Reason: "None"

Report as: Summarized single page report Separate page per device

Include: Down Time Setup Time Standby Time

View Shift Times

Print / Preview

Choose your Loss Types

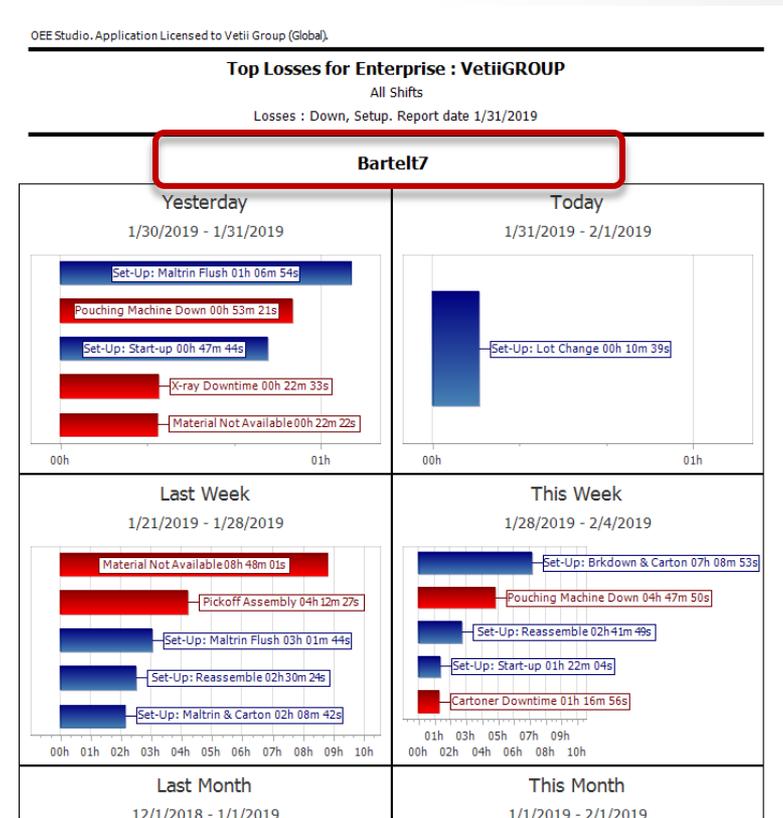
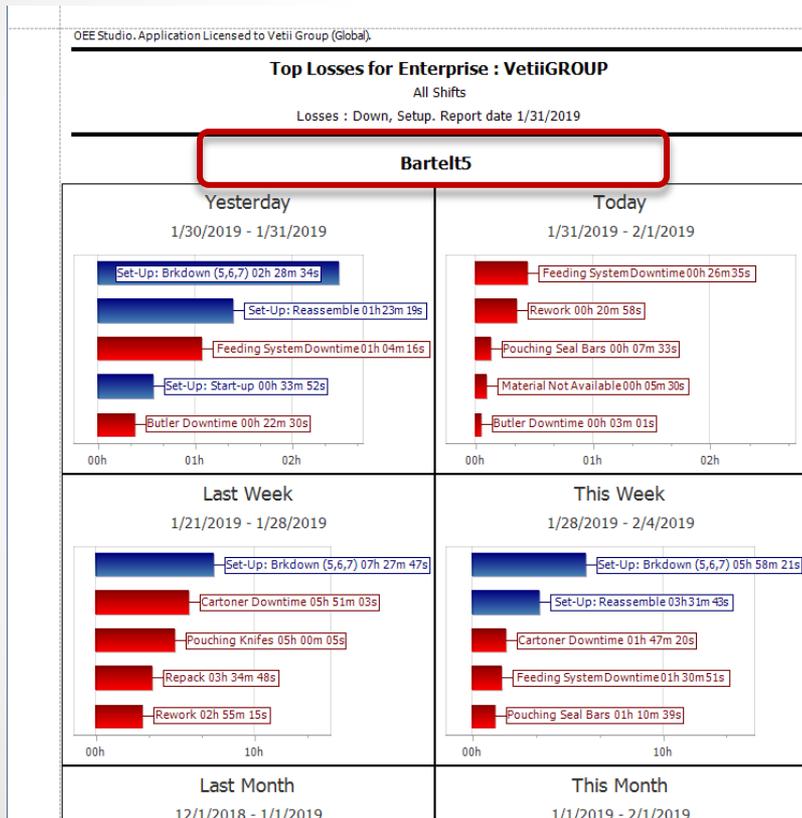
Review the top losses (Down, Setup, Standby) over time, comparing today, yesterday, this week, last week, this month and last month.

Options to just print a summarized single page report based on the Hierarchy and Production Filters to the left.
Or, print a separate page per selected device.

Report as: Summarized single page report Separate page per device

Devices: Bartelt5 Bartelt6 Bartelt7 Bartelt8 Stick-Pack

Top Losses Reports – separate Page per Selected Device



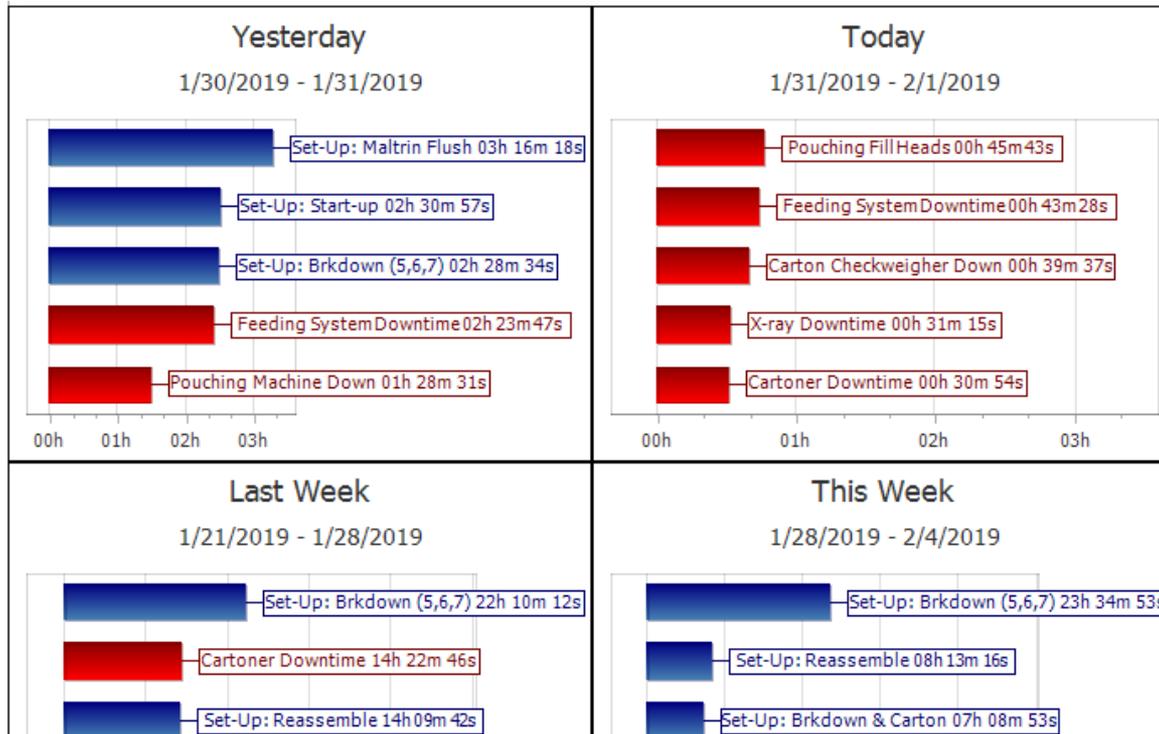
Top Losses Reports – Summarized Single Page

OEE Studio. Application Licensed to Vetii Group (Global).

Top Losses for Enterprise : VetiiGROUP

All Shifts, All Devices

Losses : Down, Setup. Report date 1/31/2019



OEE Studio v 4.5

In order to support the Vorne v1.3.x firmware, you must upgrade to the latest

XL Bolt-on Data Collector version 1.8.9.5

<http://www.sulzerconsulting.com/downloads/vorne/XL Bolt-On Data Collector.zip>

Version 4.x of OEE Studio supports all versions of Vorne XL device v1.x firmware.

Smart Installation

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

If you have questions or need assistance, please contact either
Debbie Olk (OEE Studio, OEE Alert, ERP integration)

Debbie.olk@debtechsystems.com

or

Jim Sulzer (XL Bolt-On Data Collector)

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OEE Studio, OEE Alert and XL Bolt-On Data Collector are part of the Marketing brand of

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