

Scrap Control via Vorne XLv1 Entry Dashboard

This document assumes that you know how to configure the Vorne XLv1 boards.

Introduction

The user has requested the ability to enter amounts more than one for up to 8 reject reasons. They requested a 'Scrap' dashboard for operator entry.

- There are 8 User Numbers for each Shift (UN 1 – 8)
- There are 8 User Numbers for each Job (UN 11-18)
- These User Numbers are saved in the event of a power failure.
- Recommend to use UN 21-28 for the Scrap Input registers.
- Then execute the related Program for the Scrap number and it will do all the math to update the Reject Count for the Shift, Reject Count for the current Job and the associated UNs for the shift and job.
- Need to make sure that the Shift Start program resets the Shift UN.
- Need to make sure the 'Job Start' (whatever is used) program resets the Job UN.

Reject Reason UN Mapping

| Reject Reason | User Number – Shift | User Number – Job | User Number – Value Entry |
|-----------------|---------------------|-------------------|---------------------------|
| Reject Reason A | 1 | 11 | 21 |
| Reject Reason B | 2 | 12 | 22 |
| Reject Reason C | 3 | 13 | 23 |
| Reject Reason D | 4 | 14 | 24 |
| Reject Reason E | 5 | 15 | 25 |
| Reject Reason F | 6 | 16 | 26 |
| Reject Reason G | 7 | 17 | 27 |
| Reject Reason H | 8 | 18 | 28 |

Scrap Dashboard

Customize Page

Ingresar Scrap Total por razon

Enter the total amount of scrap for each Scrap Reason.

| | |
|----------------------------|---|
| Contaminacion Ingreso | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion WaxAuto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Click the Save Settings button when you are done.
Next Step - Click the associated Execute Button to apply the values.

Update Reject Count

Scrap Control

Shift Scrap

| | |
|-----------------------------|---|
| Contaminacion | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion Wax Auto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Job/Part Scrap

| | |
|----------------------------------|---|
| Contaminacion (Job) | 0 |
| Falla de impresion Markem (Job) | 0 |
| Falla de impresion WaxAuto (Job) | 0 |
| Falta de componentes (Job) | 0 |
| Problemas de sellado (Job) | 0 |
| Problemas de corte (Job) | 0 |
| Falla Puertos (Job) | 0 |
| Otros (Job) | 0 |

KPIs

Shift KPIs

| | |
|--------------------|-------|
| Conteo Total | 4,888 |
| Conteo de Buenas | 4,888 |
| Conteo de Rechazos | 0 |

Job KPIs

| | |
|--------------------|-------|
| Conteo Total | 4,888 |
| Conteo de Buenas | 4,888 |
| Conteo de Rechazos | 0 |

View

- ▼ Dashboards
- Producción
- Scrap
- Page 3
- Page 4
- Page 5
- Page 6
- Page 7
- Page 8
- Page 9
- Page 10
- Page 11
- Page 12
- Page 13
- Page 14
- Page 15
- Bench Test
- All Production

Step 1 – Update Register Properties

Because the register properties are being used to convert to Spanish, you will need to remove some of the registers that are not translated, such as Scale Factors and Timer Snapshots

Register Properties

The Register Properties page can be used to rename and change the default display format of up to 100 registers. Modifications are applied globally. To modify properties for a register, first add it, and then modify its properties. To return a register to its factory settings remove it from this page.

| Register | Name | Format |
|---------------------|----------------------------|-------------------------------------------|
| Asset ID | ID Dispositivo | No Conversion |
| Availability | Disponibilidad | Percentage (##.##%) |
| Average Cycle Time | Tiempo Promedio de Ciclo | Time Span (SSSS.ss) |
| Average Rate Good | Tasa Promedio de Buenas | Rate per Hour (#,### RPH) |
| Average Rate Reject | Tasa Promedio de Rechazos | Rate per Hour (#,### RPH) |
| Average Rate Total | Tasa Promedio de Totales | Rate per Hour (#,### RPH) |
| Count Variance | Varianza de Conteo | Number (#,###) |
| Current Cycle Time | Ciclo de Tiempo Actual | Time Span (SSSS.ss) |
| Current Rate Good | Tasa Actual de Buenas | Rate per Hour (#,### RPH) |
| Current Rate Reject | Tasa Actual de Rechazos | Rate per Hour (#,### RPH) |
| Current Rate Total | Tasa Actual de Totales | Rate per Hour (#,### RPH) |
| Date Time | Fecha / Hora | Date Time (Month DD, YYYY HH:MM:SS AM/PM) |
| Down Time | Tiempo Muerto | Time Span (HH:MM:SS) |
| Efficiency | Eficiencia | Percentage (##.##%) |
| Event Down Time | Evento de Tiempo Muerto | Time Span (HH:MM:SS) |
| Event Run Time | Evento Tiempo de Ejecucion | Time Span (HH:MM:SS) |

Add Register Remove Register

Remove Timer Snapshots 3-5 and all of the Scale Factor registers.

Register Properties

The Register Properties page can be used to rename and change the default display format of up to 100 registers. Modifications are applied globally. To modify properties for a register, first add it, and then modify its properties. To return a register to its factory settings remove it from this page.

| Register | Name | Format |
|----------------------|----------------------------|----------------------|
| Slow Cycles Time | Tiempos de Ciclo Lentos | Time Span (mm:mm:ss) |
| Small Stops | Pequeos Paros | Number (###) |
| Small Stops Time | Tiempo de Pequeos Paros | Time Span (HH:MM:SS) |
| Standard Cycles | Ciclos Estndares | Number (###) |
| Standard Cycles Time | Tiempo de Ciclo Estndar | Time Span (HH:MM:SS) |
| Standby Time | Tiempo de Standby | Time Span (HH:MM:SS) |
| Target Count | Conteo para la Meta | Number (###) |
| Time Variance | Varianza de Tiempo | Time Span (HH:MM:SS) |
| Timer Snapshot 1 | Latch Down Message Trigger | Time Span (SSSS.ss) |
| Timer Snapshot 2 | Down Reason Scanned Flag | Time Span (SSSS.ss) |
| Timer Snapshot 3 | Run Flag | Time Span (SSSS.ss) |
| Timer Snapshot 4 | Latch Down Message Timer | Time Span (SSSS.ss) |
| Timer Snapshot 5 | Setup Remaining Time | Time Span (MM:SS) |
| Total Count | Conteo Total | Number (###) |
| Total Time | Tiempo Total | Time Span (HH:MM:SS) |
| User Number 1 | Contaminacion | Number (###) |
| User Number 11 | Contaminacion (1st) | Number (###) |

Add Register Remove Register

Step 1 – Update Register Properties

First check to see if the scrap reasons have been mapped in the Register Properties page. If not, then you will need to add them using the Add Register.

If the Add Register option is grayed out, you will need to remove some other register properties.

▼ Configure Device

▼ Scoreboard

▶ Production Monitor

▶ Inputs and Outputs

▶ Communication

▶ Programs

▼ Web Page Interface

Page Visibility

Register Properties

Register Properties

The Register Properties page can be used to rename and change the default display format of up to 100 registers. Modifications are applied globally. To modify properties for a register from this page.

| Register ⓘ ▲ | Name ⓘ |
|----------------|----------------------------------|
| Total Count | Conteo Total |
| Total Time | Tiempo Total |
| User Number 1 | Contaminacion |
| User Number 11 | Contaminacion (Job) |
| User Number 12 | Falla de impresion Markem (Job) |
| User Number 13 | Falla de impresion WaxAuto (Job) |
| User Number 14 | Falta de componentes (Job) |
| User Number 15 | Problemas de sellado (Job) |
| User Number 16 | Problemas de corte (Job) |
| User Number 17 | Falla Puertos (Job) |
| User Number 18 | Otros (Job) |
| User Number 2 | Falla de impresion Markem |
| User Number 21 | Contaminacion Ingreso |
| User Number 22 | Falla de impresion Markem |
| User Number 23 | Falla de impresion WaxAuto |
| User Number 24 | Falta de componentes |

Add Register ▼ Remove Register

Add User Numbers 21 - 28

These User Numbers will match the associated Shift and Job/Part User Numbers.

It is recommended that you include a period symbol at the end of each name to make them unique.

Click the Save button when you are finished.

Register Properties

The Register Properties page can be used to rename and change the default display format of up to 100 registers. Modifications are applied to its factory settings remove it from this page.

| Register ⓘ ▲ | Name ⓘ |
|----------------|------------------------------|
| User Number 18 | Utros (Job) |
| User Number 2 | Falla de impresion Markem |
| User Number 21 | Contaminacion Ingreso. |
| User Number 22 | Falla de impresion Markem. |
| User Number 23 | Falla de impresion WaxAuto. |
| User Number 24 | Falta de componentes. |
| User Number 25 | Problemas de sellado. |
| User Number 26 | Problemas de corte. |
| User Number 27 | Falla Puertos. |
| User Number 28 | Otros. |
| User Number 3 | Falla de impresion Wax Auto. |

Step 2 – Create the Scrap Programs

- You will need to create a program for each of your scrap reasons.
- It is optional if you don't want to update the Reject Counter. You may just want to capture scrap that does not affect producing a part.

Check the Inputs and Counts

The Scrap Programs will be updating the Reject Counter so we need to make sure that the device is not already doing that. In this instance there is only one sensor for Total Count.








- Administer
 - Settings
 - System Health
 - Back Up Device
 - Configure Device
 - Scoreboard
 - Production Monitor
 - Cycle Thresholds
 - Run/Down Detection
 - Counts**
 - Rates
 - OEE
 - Target Counter
 - Goals
 - Process Timers
 - Production Times
 - Jobs
 - Parts
 - Reasons
 - Non-Production Time
 - Inputs and Outputs
 - Standard Inputs**
 - Expansion Inputs
 - Relay Outputs

The Counts module tracks production output in terms of total, good and reject counts. Production counters are typically driven by digital inputs, which are configured in the **Administer | Configure Device | Inputs and Outputs | Standard Inputs** page.

Calculated Counter

Good Count

Standard Inputs are discrete (digital) inputs that are included with every XL device. They can be used to drive production counters or to trigger programs for execution. Programs are created in the **Administer | Configure Device | Programs | Programs** page and enable you to tailor the operation of XL to your specific application. The primary function of each input can be configured as desired; however for correct OEE Performance calculations, Input 1 must be configured as 'Count Up (Total)'.

| Input  | Logic Level  | Primary Function  | Execute on Active  | Execute on Inactive  | Debounce  | Inhibit  |
|-----------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|
| 1 | Standard | Count Up (Total) | None | None | Low Speed (up to 50 inputs/sec.) | 8.50 |
| 2 | Standard | Count Up (Good) | None | None | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 3 | Standard | Execute Program | State: Set Setup | State: Set Auto Run | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 4 | Standard | Execute Program | State: Set Standby | State: Set Auto Run | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 5 | Standard | Input Not Used | None | None | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 6 | Standard | Execute Program | Reset: Master | None | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 7 | Standard | Input Not Used | None | None | Low Speed (up to 50 inputs/sec.) | 0.00 |
| 8 | Standard | Input Not Used | None | None | Low Speed (up to 50 inputs/sec.) | 0.00 |

Scrap Programs – 1 for each scrap type

Recommendation is to put a number followed by the scrap reason following the number mapping.

Program Information

Select Program ⓘ

Program Number ⓘ

Program Name ⓘ

- 1Contaminacion
- 2Falla de Markem
- 3Falla de Wax Auto
- 4Falta de componente
- 5Problemas sellado
- 6Problemas corte
- 7Falla Puertos
- 8Otros
- Aseo de linea

Each Program consists of a sequence of commands and their parameters. Commands can be inserted, edited, deleted, and reordered through the user interface.

Program - 1Contaminacion

Programs are used to customize the operation of the XL device by selecting and configuring sequences of high-level commands. There are dozens of commands to choose from, including commands for working with numeric and string registers, performing mathematical operations, controlling the visual display screen, etc. Programs can be triggered by a wide range of events, including device power-up, inputs, production state changes, presets, and time schedules. Triggers are configured in the **Administer | Configure Device | Programs | Triggers** section.

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 - 1Contaminacion

Numeric Register > Math (Source for First Operand=User Number 21, Operation=Plus, ...)

Numeric Register > Math (Source for First Operand=User Number 21, Operation=Plus, ...)

Numeric Register > Math (Source for First Operand=User Number 21, Operation=Plus, ...)

Numeric Register > Math (Source for First Operand=User Number 21, Operation=Plus, ...)

Numeric Register > Write (Register=User Number 21, Constant=0)

Command 1 – Add value in UN 21 to the Reject Count Whole for the Shift.

Command Configuration

Command

Select Command ⓘ Numeric Register > Math ▼

Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand ⓘ User Number 21 ▼

Operation ⓘ Plus ▼

Source for Second Operand ⓘ Reject Count Whole (Shift) ▼

Destination for Result ⓘ Reject Count Whole (Shift) ▼

OK Cancel

Command 2 – Add the value in UN 21 to the Reject Count Whole for the Job.

Command Configuration

Command

Select Command ? Numeric Register > Math ▼

Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand ? User Number 21 ▼

Operation ? Plus ▼



Source for Second Operand ? Reject Count Whole (Job) ▼

Destination for Result ? Reject Count Whole (Job) ▼

Command 3 – Add the value in UN 21 to UN 1 (reject reason for the shift)



Command Configuration



Command



Select Command  Numeric Register > Math 



Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand  User Number 21 

Operation  Plus 

Source for Second Operand  User Number 1 

Destination for Result  User Number 1 

Command 4 – Add the value in UN 21 to UN 11 (reject reason for the job)

Command Configuration

Command

Select Command ⓘ

Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand ⓘ

Operation ⓘ

Source for Second Operand ⓘ

Destination for Result ⓘ

Command 5 – Zero the value in UN 21

Command Configuration ✕

Command
Select Command ⓘ

Description
The Numeric Register > Write command is used to write a constant value (the number specified in this command) to the specified numeric register.

Parameters
Register ⓘ
Constant ⓘ

Continue creating the remaining Scrap Programs

To make the next program, copy the first one and so on.

New Program

Program Information

Program Number ⓘ 143

Program Name ⓘ 2Falla de Mark

Program Content

Program Content enables a new program to be created as blank or as a copy of an existing program.

Create a blank program

Make a copy of

Make a Selection...

- 1Contaminacion
- 2Falla de Markem
- 3Falla de Wax Auto
- 4Falta de componente
- 5Problemas sellado
- 6Problemas corte

OK Cancel

This shows the mapping using UN 22, UN 2 and UN 12

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 - 2Falla de Markem

- Numeric Register > Math (Source for First Operand=User Number 22, Operation=Plus, ...)
- Numeric Register > Math (Source for First Operand=User Number 22, Operation=Plus, ...)
- Numeric Register > Math (Source for First Operand=User Number 22, Operation=Plus, ...)
- Numeric Register > Math (Source for First Operand=User Number 22, Operation=Plus, ...)
- Numeric Register > Write (Register=User Number 22, Constant=0)

Command Configuration

Command

Select Command ⓘ

Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand ⓘ

Operation ⓘ

Source for Second Operand ⓘ

Destination for Result ⓘ

Command Configuration

Command

Select Command ⓘ

Description

The Numeric Register > Math command performs a mathematical operation using two numeric registers (or a numeric register and a constant value) as operands, and stores the result in the specified numeric register. Eight Arithmetic registers are available to temporarily hold intermediate calculation results, enabling complex calculations to be built from a sequence of math commands. All of the calculations use floating point arithmetic with fifteen digits of precision; however, when results are stored to numeric variables, only the whole number portion is retained.

Source for First Operand ⓘ

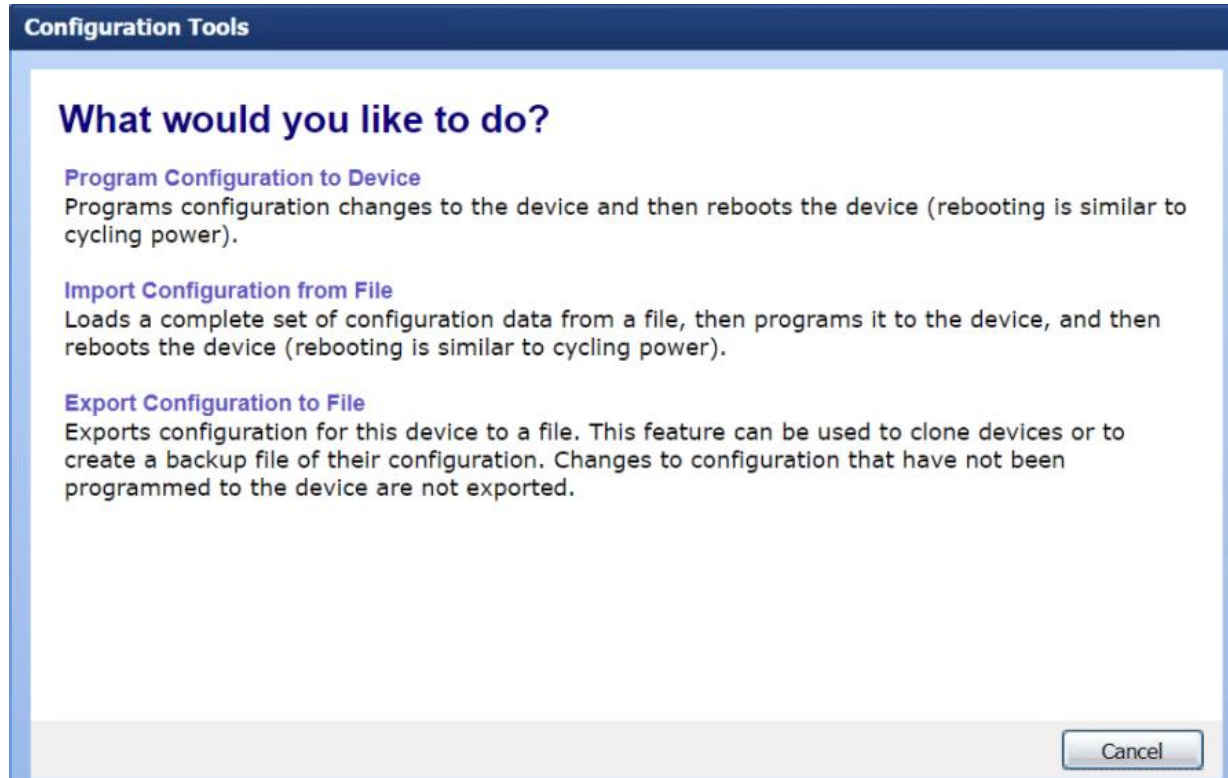
Operation ⓘ

Source for Second Operand ⓘ

Destination for Result ⓘ

Step 3 – Program Configuration to Device

After making the New Programs you must program configure to the device.

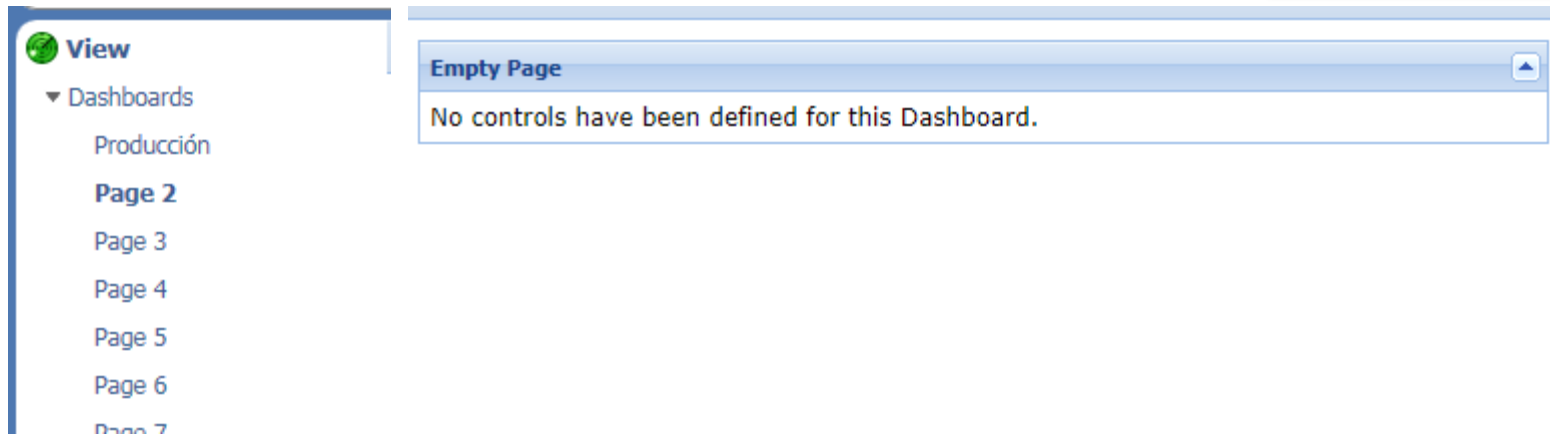
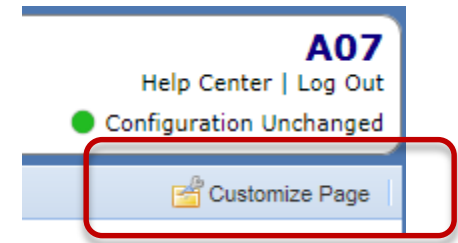


Step 4 – Create the Dashboard

- The Scrap Dashboard will consist of the following:
 - User Entry Control
 - Update Reject Count Control – Program Execution buttons
 - Scrap Control view of the Shift and Job/Part Scrap reasons
 - Simple Shift and Job KPI Control

Expand Dashboards and click on Page 2 or the next available Page

Click on **Customize Page** to start building the Dashboard >>



Configure Page Properties

Page Properties Add Control Save Page

Page Properties [X]

Page Name:

Page Layout:

1 Column 2 Columns 3 Columns

 | | |

OK Cancel

Add Control – Form Control

Everywhere™ Create the Scrap Entry Control

Form Control Properties

Form Controls are used to create data entry forms with optional inline instructions to assist whoever enters data. Use 'Add Line' to add a Register, a block of Fixed Text (such as instructions), a Section Heading (to organize the form), or a Blank Line. Use 'Remove Line' to permanently remove the selected line. Drag and drop lines to rearrange their order. Use 'Line Properties' on the right-hand side to configure properties associated with the selected line.

Title: Ingresar Scrap Total por razon

| Name | Value |
|--------------|---------------------------------------------|
| Text Content | Enter the total amount of scrap for each... |

Add Control menu items:

- KPI Control
- Form Control**
- Preset Form Control
- Program Executor Control

Ingresar Scrap Total por razon

Enter the total amount of scrap for each Scrap Reason.

| | |
|----------------------------|---|
| Contaminacion Ingreso | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion WaxAuto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Click the Save Settings button when you are done.
Next Step - Click the associated Execute Button to apply the values.

Buttons: Save Settings, Cancel Changes

Annotations:

- Fixed Text** (points to the instruction text in the form)
- Registers – User Numbers 21 - 28** (points to the list of scrap reasons)
- Fixed Text** (points to the instruction text at the bottom of the form)

Add Control – Program Executor

Everywhere™

The 'Program Executor Control Properties' dialog box is shown with the following details:

- Title:** Update Reject Count
- Lines:** A list of eight '--- Program Execution Button ---' items.
- Line Properties:** A table with the following data:

| Name | Value |
|--------------|--------------------------------|
| Program Name | 1Contaminacion |
| Button Text | Execute -Contaminacion Ingreso |
- Buttons:** 'Add Line' and 'Remove Line' buttons are visible at the bottom left.

The 'Add Control' menu is shown with the following options:

- KPI Control
- Form Control
- Preset Form Control
- Program Executor Control** (highlighted with a red box)

The 'Update Reject Count' dialog box displays a vertical list of buttons:

- Execute -Contaminacion Ingreso
- Execute -Falla de Markem Ingreso
- Execute 3Falla de Wax Auto
- Execute 4Falta de componente
- Execute 5Problemas sellado
- Execute 6Problemas corte
- Execute 7Falla Puertos
- Execute 8Otros

Add Control – KPI Control

Everywhere™

The screenshot shows the 'Add Control' dialog box in a software application. The 'Add Control' menu is open, showing the following options:

- KPI Control (highlighted with a red box)
- Form Control
- Preset Form Control
- Program Executor Control

The 'KPI Control Properties' dialog box is also visible, showing the following information:

KPI Control Properties

KPI Controls are used to show register values, with the values automatically updated in real-time. Use 'Add Line' to add a Register, a block of Fixed Text (such as commentation), a Section Heading (to organize the form), or a Blank Line. Use 'Remove Line' to permanently remove the selected line. Drag and drop lines to rearrange their order. Use 'Line Properties' on the right-hand side to configure properties associated with the selected line.

Title: KPIs

Lines

- Section Heading ---
- Conteo Total (Shift)
- Conteo de Buenas (Shift)
- Conteo de Rechazos (Shift)
- Blank Line ---
- Section Heading ---
- Conteo Total (Job)
- Conteo de Buenas (Job)
- Conteo de Rechazos (Job)

Line Properties

| Name | Value |
|-----------------|------------|
| Section Heading | Shift KPIs |

Preview:

KPIs

Shift KPIs

| | |
|--------------------|-------|
| Conteo Total | 6,816 |
| Conteo de Buenas | 5,856 |
| Conteo de Rechazos | 960 |

Job KPIs

| | |
|--------------------|-----|
| Conteo Total | 154 |
| Conteo de Buenas | 142 |
| Conteo de Rechazos | 12 |

Add Control – KPI Control

Everywhere™

KPI Control Properties

KPI Controls are used to show register values, with the values automatically updated in real-time. Use 'Add Line' to add a Register, a block of Fixed Text (such as commentation), a Section Heading (to organize the form), or a Blank Line. Use 'Remove Line' to permanently remove the selected line. Drag and drop lines to rearrange their order. Use 'Line Properties' on the right-hand side to configure properties associated with the selected line.

Title: Scrap Control

Lines

- Section Heading ---
- Contaminacion
- Falla de impresion Markem
- Falla de impresion Wax Auto
- Falta de componentes
- Problemas de sellado
- Problemas de corte
- Falla Puertos
- Otros
- Blank Line ---
- Section Heading ---
- Contaminacion (Job)
- Falla de impresion Markem (Job)
- Falla de impresion WaxAuto (Job)
- Falta de componentes (Job)
- Problemas de sellado (Job)
- Problemas de corte (Job)
- Falla Puertos (Job)
- Otros (Job)

Line Properties

| Name | Value |
|-----------------|-------------|
| Section Heading | Shift Scrap |

Add Control

- KPI Control**
- Form Control
- Preset Form Control
- Program Executor Control

Scrap Control

Shift Scrap

| | |
|-----------------------------|---|
| Contaminacion | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion Wax Auto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Job/Part Scrap

| | |
|----------------------------------|---|
| Contaminacion (Job) | 0 |
| Falla de impresion Markem (Job) | 0 |
| Falla de impresion WaxAuto (Job) | 0 |
| Falta de componentes (Job) | 0 |
| Problemas de sellado (Job) | 0 |
| Problemas de corte (Job) | 0 |
| Falla Puertos (Job) | 0 |
| Otros (Job) | 0 |

Add Line | Remove Line

Save the Page and Exit!

A07
Help Center | Log Out
● Configuration Unchanged
Exit Customization

Page Properties Add Control Save Page

Ingresar Scrap Total por razon

Enter the total amount of scrap for each Scrap Reason.

| | |
|----------------------------|---|
| Contaminacion Ingreso | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion WaxAuto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Click the Save Settings button when you are done.
Next Step - Click the associated Execute Button to apply the values.

Save Settings Cancel Changes

Update Reject Count

Execute -Contaminacion Ingreso

Execute -Falla de Markem Ingreso

Execute 3Falla de Wax Auto

Execute 4Falta de componente

Execute 5Problemas sellado

Execute 6Problemas corte

Execute 7Falla Puertos

Execute 8Otros

Scrap Control

Shift Scrap

| | |
|-----------------------------|---|
| Contaminacion | 0 |
| Falla de impresion Markem | 0 |
| Falla de impresion Wax Auto | 0 |
| Falta de componentes | 0 |
| Problemas de sellado | 0 |
| Problemas de corte | 0 |
| Falla Puertos | 0 |
| Otros | 0 |

Job/Part Scrap

| | |
|----------------------------------|---|
| Contaminacion (Job) | 0 |
| Falla de impresion Markem (Job) | 0 |
| Falla de impresion WaxAuto (Job) | 0 |
| Falta de componentes (Job) | 0 |
| Problemas de sellado (Job) | 0 |
| Problemas de corte (Job) | 0 |
| Falla Puertos (Job) | 0 |
| Otros (Job) | 0 |

KPIs

Shift KPIs

| | |
|--------------------|-------|
| Conteo Total | 6,864 |
| Conteo de Buenas | 5,904 |
| Conteo de Rechazos | 960 |

Job KPIs

| | |
|--------------------|-----|
| Conteo Total | 202 |
| Conteo de Buenas | 190 |
| Conteo de Rechazos | 12 |

Dashboard with values in Reject Entry fields. Click Save Settings.

Ingresar Scrap Total por razon

Enter the total amount of scrap for each Scrap Reason.

| | | |
|------------------------------|----------------------|---|
| Contaminacion Ingreso ⓘ | <input type="text"/> | 1 |
| Falla de impresion Markem ⓘ | <input type="text"/> | 2 |
| Falla de impresion WaxAuto ⓘ | <input type="text"/> | 3 |
| Falta de componentes ⓘ | <input type="text"/> | 4 |
| Problemas de sellado ⓘ | <input type="text"/> | 5 |
| Problemas de corte ⓘ | <input type="text"/> | 6 |
| Falla Puertos ⓘ | <input type="text"/> | 7 |
| Otros ⓘ | <input type="text"/> | 8 |

Click the Save Settings button when you are done.

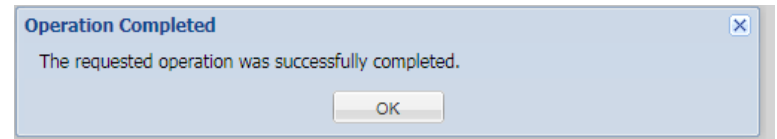
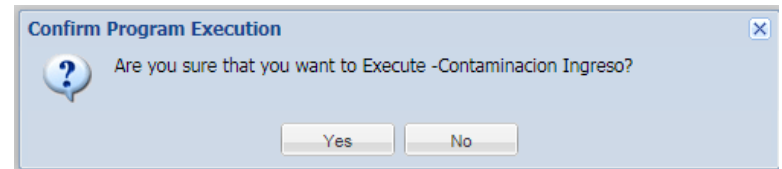
Next Step - Click the associated Execute Button to apply the values.

Click the Save Settings button when you are done.

Next Step - Click the associated Execute Button to apply the values.

The changes were saved successfully.

The associated Execute buttons need to be pressed.



Values are now updated.

| Scrap Control | |
|----------------------------------|---|
| Shift Scrap | |
| Contaminacion | 1 |
| Falla de impresion Markem | 2 |
| Falla de impresion Wax Auto | 3 |
| Falta de componentes | 4 |
| Problemas de sellado | 5 |
| Problemas de corte | 6 |
| Falla Puertos | 7 |
| Otros | 8 |
| Job/Part Scrap | |
| Contaminacion (Job) | 1 |
| Falla de impresion Markem (Job) | 2 |
| Falla de impresion WaxAuto (Job) | 3 |
| Falta de componentes (Job) | 4 |
| Problemas de sellado (Job) | 5 |
| Problemas de corte (Job) | 6 |
| Falla Puertos (Job) | 7 |
| Otros (Job) | 8 |

Refresh the screen to see that the entry values are zero.



Ingresar Scrap Total por razon

Enter the total amount of scrap for each Scrap Reason.

| | |
|-------------------------------|--------------------------------|
| Contaminacion Ingreso. ⓘ | <input type="text" value="0"/> |
| Falla de impresion Markem. ⓘ | <input type="text" value="0"/> |
| Falla de impresion WaxAuto. ⓘ | <input type="text" value="0"/> |
| Falta de componentes. ⓘ | <input type="text" value="0"/> |
| Problemas de sellado. ⓘ | <input type="text" value="0"/> |
| Problemas de corte. ⓘ | <input type="text" value="0"/> |
| Falla Puertos. ⓘ | <input type="text" value="0"/> |
| Otros. ⓘ | <input type="text" value="0"/> |

Click the Save Settings button when you are done.

Next Step - Click the associated Execute Button to apply the values.

Step 5 – Reset Shift User Numbers

Configure Device | Programs | Triggers section

Program Information

Select Program ⓘ Shift: Start

Program Number ⓘ 40

Program Name ⓘ Shift: Start

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 - Shift: Start | |
|------------------------|--------------------------------------------------------------------------------------------------------------------------------|
| Program > | Cancel Delayed Execution (Timer=14) |
| Production State > | Restore (Restore Reason Code=Yes, Restore Message=Yes, Restore ...) |
| String Register > | Copy (Source=Short String 241, Destination=Short String 240) |
| String Register > | Copy (Source=Shift ID, Destination=Short String 13) << Insert command to copy current Shift ID to User String 13 for the Job. |
| Program > | Execute Immediately (Program=Reset Shift UN) << Command to Execute Reset Shift UN – this is factory default. It sets UN1-8 = 0 |

Insert Edit Delete

<< Insert command to copy current Shift ID to User String 13 for the Job.
<< Command to Execute Reset Shift UN – this is factory default. It sets UN1-8 = 0

Step 6 – Identify which program is executed when you scan the Part Barcode

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 |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |
| | 1.00 | 1.00 | 1.00 | 1.00 | None |

Page 1 of 25 | Export Table | Import Table | Print Barcodes...

Insert the command to Reset Job UN

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) << Insert command to copy current Shift ID to User String 13 for the Job.

Program > Execute After Delay (Program=~Message: Restore, Timer=12, Delay=5)

Program > Execute Immediately (Program=Reset Job UN) << Command to Execute Reset Job UN – this is factory default. It sets UN11-18 = 0

Insert Edit Delete

Step 7 – Update Register Properties

Register Properties

The Register Properties page can be used to rename and change the default display format of up to 100 registers. Modifications are applied globally. To modify properties for a register, first add properties. To return a register to its factory settings remove it from this page.

| Register | Name | Format |
|----------------------|------------------------|---------------|
| Short User String 1 | Usuario String Corto 1 | No Conversion |
| Short User String 11 | ID operador | No Conversion |
| Short User String 13 | Turno | No Conversion |
| Short User String 2 | Usuario String Corto 2 | No Conversion |

Change the register properties for Short User String 13 to be either Shift or Turno. Whichever language you want to use.

Step 8 – Insert a command to Reset Job at Shift End

Programs are used to customize the operation of the XL device by selecting and configuring sequences of high-level commands. There are dozens of commands to choose from, including commands for working with numeric and string registers, performing mathematical operations, controlling the visual display screen, etc. Programs can be triggered by a wide range of events, including device power-up, inputs, production state changes, presets, and time schedules. Triggers are configured in the **Administer | Configure Device | Programs | Triggers** section.

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 - Shift: End

String Register > Copy (Source=Short String 240, Destination=Short String 241)

Production State > Save ()

Legacy > Production State > Set (State=Standby)

Production State > Set Reason Code (Reason Code=Standby > Sin Demanda)

Display > Play Message (Message=Standby Message)

Reset (Type of Reset=Job Reset) << This will reset the current Job for the current Shift. It just zeroes out the Counts.

Program > Execute After Delay (Program=~Reason: Copy Stndby, Timer=14, Delay=1)

Insert Edit Delete

Step – 9 Standby – no part/no job

Programs are used to customize the operation of the XL device by selecting and configuring sequences of high-level commands. There are dozens of commands to choose from, including commands for working with numeric and string registers, performing mathematical operations, controlling the visual display screen, etc. Programs can be triggered by a wide range of events, including device power-up, inputs, production state changes, presets, and time schedules. Triggers are configured in the **Administer | Configure Device | Programs | Triggers** section.

Program Information

| | | |
|--------------------------------------------|-----------------------------------------------|--------------------------------------------------|
| Select Program ? | <input type="text" value="Sin Demanda"/> | |
| Program Number ? | <input type="text" value="87"/> | |
| Program Name ? | <input type="text" value="Sin Demanda"/> | |
| <input type="button" value="New Program"/> | <input type="button" value="Delete Program"/> | <input type="button" value="Print Barcodes..."/> |

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 - Sin Demanda

Production State > Set (State=Standby, Split Events=Yes)
Production State > Set Reason Code (Reason Code=Standby > Sin Demanda)
Display > Play Message (Message=Sin Demanda)
String Register > Write to Short String (Register=Job ID, Text=sin trabajo)
String Register > Write to Short String (Register=Part ID, Text=sin parte)
Output > Turn On or Off (Output Number=Output 1, Output State=Off)
Program > Execute After Delay (Program=~Reason: Copy Stndby, Timer=14, Delay=1)
Program > Cancel Delayed Execution (Timer=17)

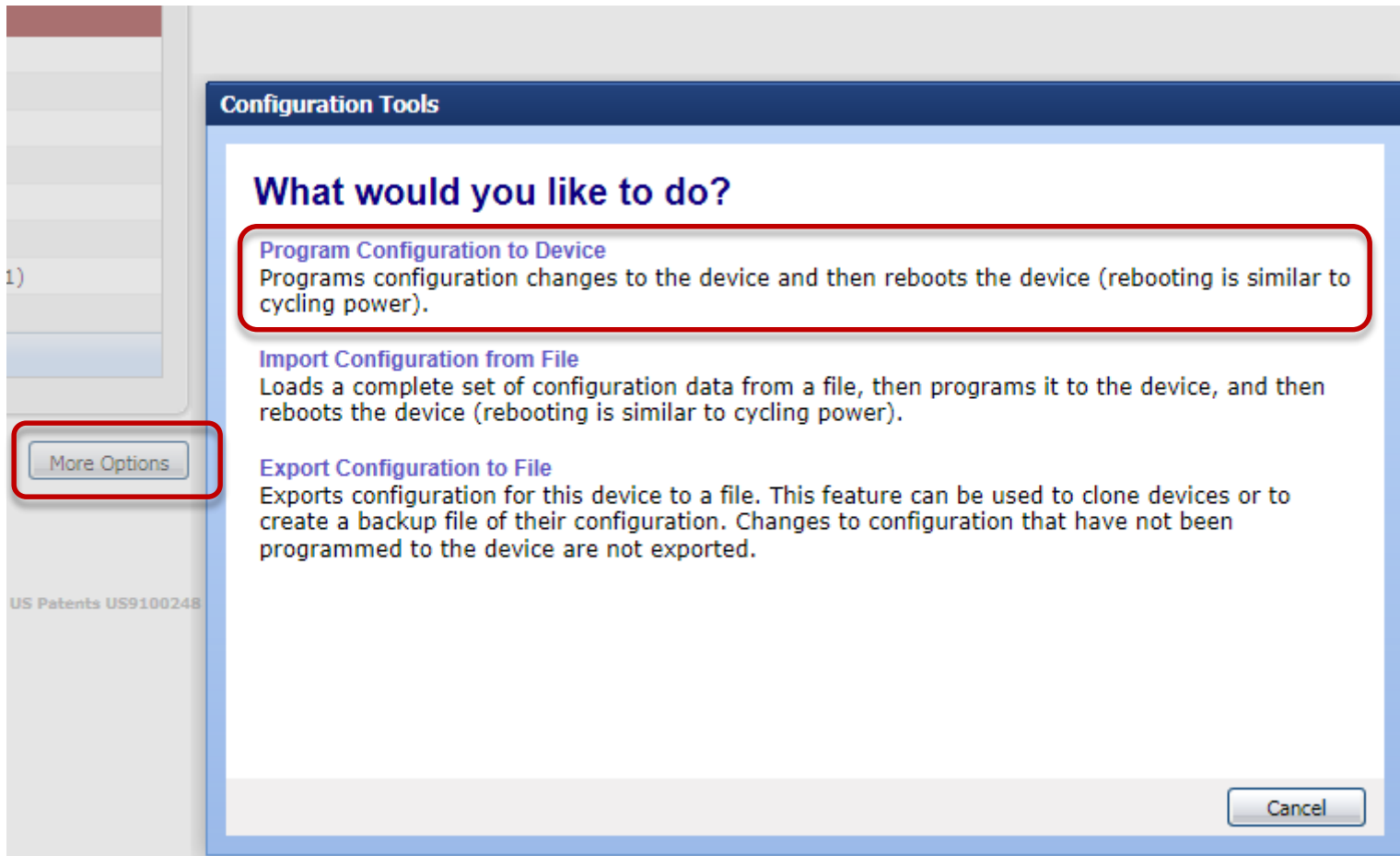
Insert Edit Delete

When the line is in Standby for an extended period of time, it is recommended that you change the Job ID and Part ID to indication No Job/No Part.

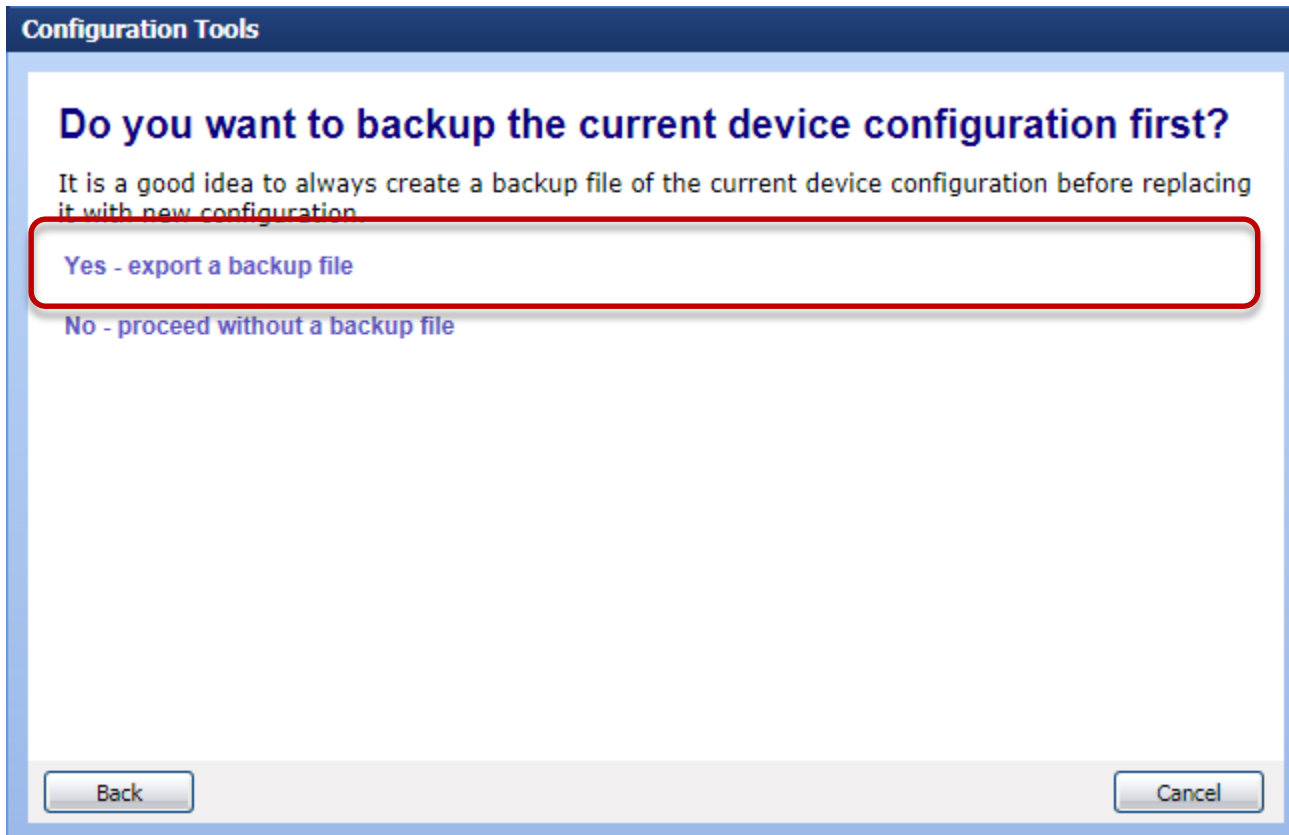
The reason being that the extended standby time does not affect the Job/Part OEE Calculations.

<< Insert the 2 commands to Write 'No Job' to the Job ID and 'No Part' to the Part ID

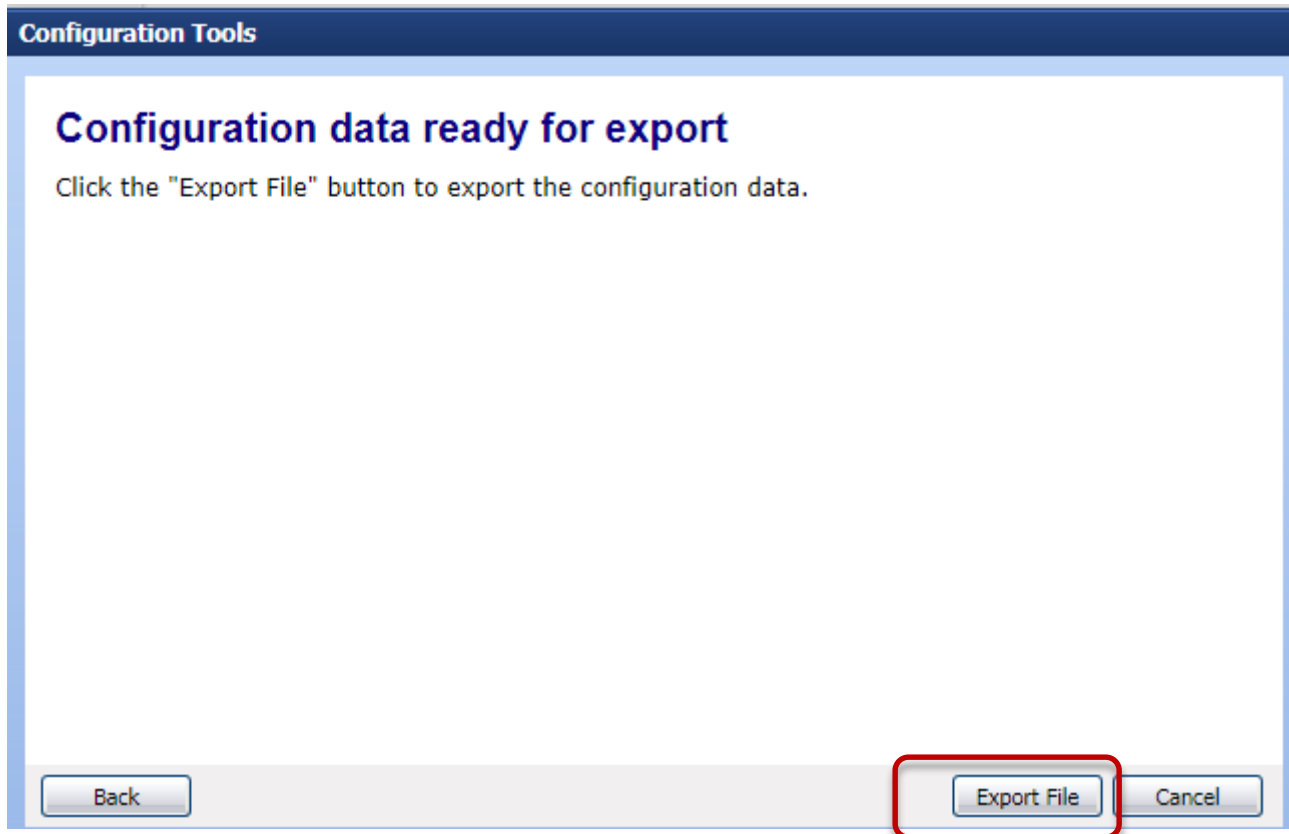
Final Step – Program Configuration to Device



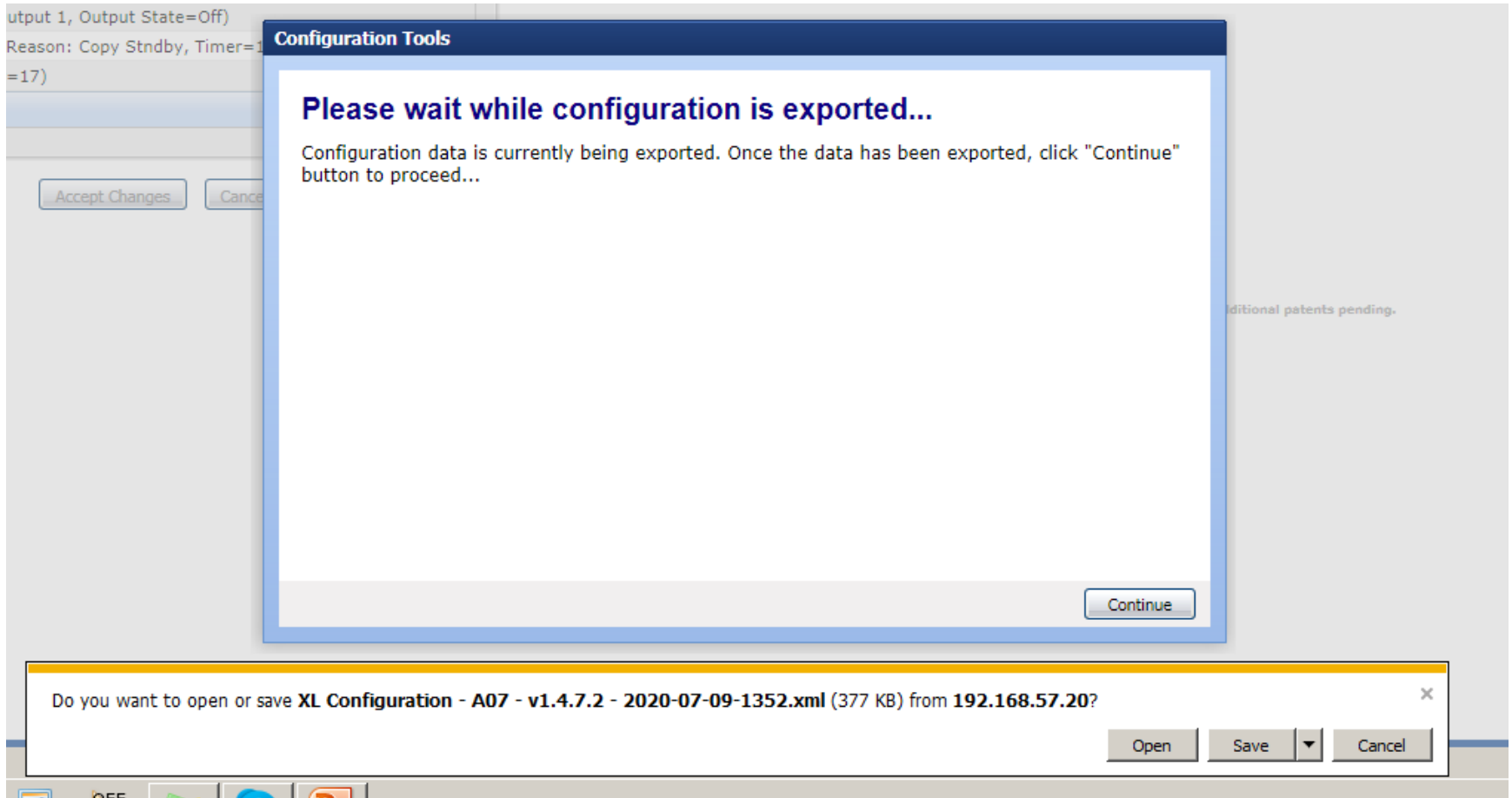
Final Step – Program Configuration to Device



Final Step – Program Configuration to Device



Final Step – Program Configuration to Device



Final Step – Program Configuration to Device

