

# Scrap Reduction Options

Updated: 8/01/2022

# Introduction

By using the Vorne XLv1 hardware and the OEE Suite software, you have several methods of capturing scrap/defect information.

- **Standard** – hard-wired inputs (Vorne XLv1), no reasons
- **Standard Plus** - hard-wired inputs with program execution (specific reasons – up to 6) (Vorne XLv1)
- **Premium** – Up to 8 User Numbers to define specific scrap/defect reasons per board (Vorne XLv1)
- **Advanced** – Unlimited. Either Batch reject or scrap reasons by part type. (OEE Alert Inspection Module)

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## ***complexity indicator:***

*Green – simple*

*Yellow – complex*

*Blue – relatively simple*

*Red – very complex*

# Standard (XLv1)

- You can connect 2 or 3 inputs to the Vorne board.
- Input 1 = Total Count
- Input 2 = Reject Count or it could be Good Count and then you can specify which count should be calculated.
- Input 3 = Good Count if you have a 3<sup>rd</sup> sensor on the line.
- Does not provide ability to identify scrap reasons.

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	Other	None	Low Speed (up to 50 inputs/sec.)	0.00

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 ⓘ

Reject Count

# Standard Plus (XLv1)

- If you want to use inputs to identify scrap reason, you have up to 6, maybe 7 inputs that you could configure.
- Requires maintenance or electricians to hook up sensors or stop buttons.
- You would have to create a program for each specific reason and associate it with each input.

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	Otros	None	Low Speed (up to 50 inputs/sec.)	0.00
4	Standard	Execute Program	Falta componentes	None	Low Speed (up to 50 inputs/sec.)	0.00
5	Standard	Execute Program	Contaminacion	None	Low Speed (up to 50 inputs/sec.)	0.00
6	Standard	Execute Program	Falla Puertos	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

# Premium – Bar Code Scan (XLv1)

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.
- 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.

# Premium (BarCode)

## Reject Reason UN Mapping

Reject Reason	User Number – Shift	User Number – Job	Unique Bar Code Needed
Reject Reason A	1	11	Y
Reject Reason B	2	12	Y
Reject Reason C	3	13	Y
Reject Reason D	4	14	Y
Reject Reason E	5	15	Y
Reject Reason F	6	16	Y
Reject Reason G	7	17	Y
Reject Reason H	8	18	Y

Total Time	Tiempo Total	Time Span (mm.mm.ss)
User Number 1	Contaminacion	Number (###)
User Number 11	Contaminacion (Job)	Number (###)
User Number 12	Falla de impresion Markem (Job)	Number (###)
User Number 13	Falla de impresion WaxAuto (Job)	Number (###)
User Number 14	Falta de componentes (Job)	Number (###)
User Number 15	Problemas de sellado (Job)	Number (###)
User Number 16	Problemas de corte (Job)	Number (###)
User Number 17	Falla Puertos (Job)	Number (###)
User Number 18	Otros (Job)	Number (###)
User Number 2	Falla de impresion Markem	Number (###)

# Premium – Dashboard (XLv1)

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 assign a unique reason for each of the 8 numbers. They must be the same reason for the Shift and Job.
- Someone would need to enter the totals for each defect type before the current Job/Part ends and before the Current Shift ends.
- Requires expert level Vorne XLv1 configuration skills

# Premium (Dashboard)

## 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

Register	Name	Format
User Number 1	Contaminacion	Number (###)
User Number 11	Contaminacion (Job)	Number (###)
User Number 12	Falla de impresion Markem (Job)	Number (###)
User Number 13	Falla de impresion WaxAuto (Job)	Number (###)
User Number 14	Falta de componentes (Job)	Number (###)
User Number 15	Problemas de sellado (Job)	Number (###)
User Number 16	Problemas de corte (Job)	Number (###)
User Number 17	Falla Puertos (Job)	Number (###)
User Number 18	Otros (Job)	Number (###)
User Number 2	Falla de impresion Markem	Number (###)
User Number 21	Contaminacion Ingreso.	Number (###)
User Number 22	Falla de impresion Markem.	Number (###)
User Number 23	Falla de impresion WaxAuto.	Number (###)
User Number 24	Falta de componentes.	Number (###)
User Number 25	Problemas de sellado.	Number (###)
User Number 26	Problemas de corte.	Number (###)



# Premium – Dashboard (XLv1)

View
Customize Page

- ▼ 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
- ▶ Real-Time KPIs
- Scoreboard
- Analyze
- Improve
- Learn
- Administer

### 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.

### 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)	3,249
Falla de impresion WaxAuto (Job)	850
Falta de componentes (Job)	430,000
Problemas de sellado (Job)	39,740
Problemas de corte (Job)	0
Falla Puertos (Job)	0
Otros (Job)	0

### KPIs

#### Shift KPIs

Conteo Total	20,848
Conteo de Buenas	20,848
Conteo de Rechazos	0

#### Job KPIs

Conteo Total	474,848
Conteo de Buenas	474,848
Conteo de Rechazos	0

# OEE Alert – Pareto View



## VISUALIZING DATA QUALITY LOSSES [N]

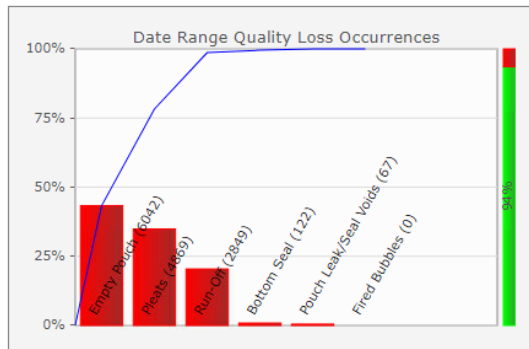
Home Views Actions Setup Info

Active filters: Date range: [Fixed: Mon Jul 27 2020 12:00:00 AM - Mon Aug 03 2020 02:30:00 PM](#), Date: [Today](#), Category: [Area:MO016\\_Hot Production](#)

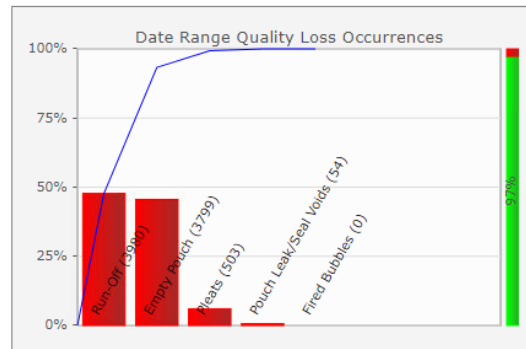
Relative loss occurrences

Total good vs. reject count ratio

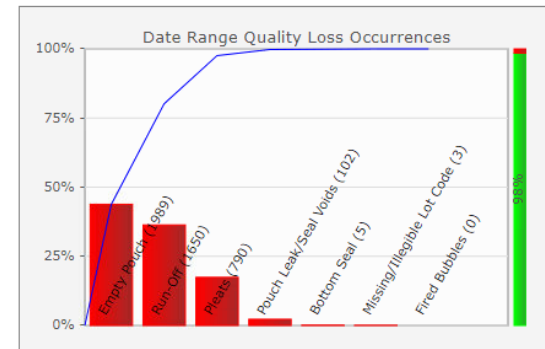
MO016AP006



MO016AP008



MO016AP009




# Inspection Module

The Non-Conforming Parts (NCP) module provides 3 modes to help with accounting for Rejects/Defects:

- **Adjust Counts.** This allows for adjusting interval counts after the fact, for instance to account for a missed job reset, needing to transfer counts to next job. This is not technically NCP, but was added at customer's request.
- **Batch Reject.** An assessment is made that part or all of the parts produced must be rejected and a reason assigned. I.e. parts are produced and monitored by the Vorne, followed by a post-production step, an acid bath, where something goes wrong.
- **Inspection.** Every part is inspected and assigned a Pass or a Fail, and reject reasons can be assigned. This allows for complex parts (multiple components) each of which can have their own reject reasons.  
Note that an inspection happens post-production and inspection might still continue after the Vorne on the line has started monitoring the next job.
- This module is an add-on to OEE Alert and is licensed. Reporting is done through OEE Alert and is not available in OEE Studio.
- This is NOT a Quality Management System (QMS).

# Advanced – Adjust Counts

## OEE Alert



VISUALIZING DATA ADJUST COUNTS

OEEALERT)))

Home Views Filters Actions Setup Info Google News Welcome Karel!

Active filters: Date range: [Year-To-Date](#), Date: [Wed Sep 23, 2015](#), Category: [Location:Algonquin\\_IL](#)

Lines:  Parts:  Job dates:

Current Counts	Adjusted Counts
Good: <input type="text" value="75027.350802704"/>	Good: <input type="text"/>
Reject: <input type="text" value="11477.39222"/>	Reject: <input type="text"/>
Total: <input type="text" value="86504.743022704"/>	Total: <input type="text"/>
Quality: <input type="text" value="86.7%"/>	Quality: <input type="text"/>

Adjust Reject and Good - Total count unmodified  Adjust Good only - Reject count unmodified  Adjust Raw Counts

Enter discarded count (+/-):

If reject reasons are not critical, but job counts need to be updated (for instance, a job reset was issued too late and parts are assigned to the wrong job), this screen allows adjusting counts.

For jobs still active in the Vorne, the Vorne counts are updated as well.

# Advanced – Batch Reject

## OEE Alert

### VISUALIZING DATA BATCH REJECT

OEE

Home Views Actions Setup Info

Active filters: Date range: [Fixed: Mon Aug 03 2020 12:00:00 AM - Tue Aug 04 2020 04:30:00 PM](#), Date: [Mon, 03 Aug, 2020](#), Device: [CRI01SCDA07](#)

Line: CRI01SCDA07 Part ID: 73022  
Job ID: sin trabajo Interval #: 314  
Start Time: Mon Aug 03 2020 06:00

SYMPTOM: Save

#### Defect Reasons

part components - 73022

Largo incorrecto

Caidas al suelo

Canula derretida

Diametro interno peq.

Curva deforme

#### Batch Rejects

Enter Reject Count

Submit

#### job Summary

0 Rejects, 4462 Good

Defect Reason Count

The batch reject screen allows rejecting groups of parts, with specific reasons. It can be configured to adjust counts or only record defects.

# Advanced – By Component or Part Type OEE Alert

VISUALIZING DATA INSPECTION

OEEALERT)))

Home Views Filters Actions Setup Info Google News Welcome Karell

Active filters: Date range: Year-To-Date, Date: Wed Sep 23, 2015, Category: Location:Algonquin, IL

Line: Vome181 Part ID: Exhaust B

Interval: Second Shift Interval #: 5310

Start Time: Mon Sep 21 2015 15:08

**Components**

1-MBR-STRG,DR	2-MBR-STRG,AS
3-BRKT-SIDE,DR	4-BRKT-SIDE,AS
5-BRKT-COLUM,RR	BRKT-COLUM,FR
BRKT-RENIF,COLUM	BRKT-IMPACT
BRKT-A/BAG	BRKT-INST UPR,AS
BRKT-INST AS,LH	BRKT-INST AS,LWR
BRKT-AUDIO,UPR	BRKT-AUDIO,LWR
BRKT-HOOD,LOCK	BRKT-POST_PATCH
BRKT-KEYLESS	BRKT-POST
BRKT-KNEE DR,UPR	BRKT-KNEE DR,LWR
BRKT-INST STAY, LH	BRKT-H/VAC,LWR
BRKT-H/VAC UPR,LH	BRKT-H/VAC UPR,RH
BRKT-BLOWER	BRKT-G/BOX
BRKT-GROUND	BRKT-BCM,RH

**Defect Reasons**

Bracket Bent	Off Location Weld	Weld Porosity	Weld Blow Through
Nut Threads	Nut Missing	Bolt Threads	Bolt Missing
Missing Weld	Short Weld		

**Count Summary**

Defect Reason	Count	Lock
Off Location Weld	2	<input checked="" type="checkbox"/>
Nut Missing	1	<input type="checkbox"/>
Short Weld	1	<input type="checkbox"/>

**Fail (1)**

**Pass (0)**

Record defect types by component (or inspection points)  
Option to fail or pass, or pass with signaled (non-critical) defects.