

# OEE Studio Release Note

## **Version 3.3**

Deb-Tech Systems, Inc. & Production Improvement Systems Ltd.

[Debbie.Olk@DebTechSystems.com](mailto:Debbie.Olk@DebTechSystems.com)

[Russell@ProductionImprovement.com](mailto:Russell@ProductionImprovement.com)

847.854.3148

# What's New in 3.3

## Enhancements

- Added ability to show / hide TEEP chart labels, including ability to store these settings when saved as a favorite. [Id #163]
- The ability to edit existing favorites. [Id #164]
- Added Group Name to the favorites screen with sorting/grouping/filtering abilities [Id #166]
- Added "Availability" to the favorites listing screen.
- Added OEE Alert comments to Shift Comparison - Grid Analysis [Id #161]
- Added OEE Alert comments to Job Comparison - Grid Analysis [Id #162]
- Include the screen name in all chart footers when exporting or printing charts [Id #165]
- Added Efficiency to the All Shift Production Report [Id #167]
- Added the ability to export and import saved grid and pivot layouts [Id #124]
- The position of the PivotGrid Field List Screen now displays larger, in side by side layout, and in the center of the screen.
- Moved the Pivot and Data Grid menu to the left side of the screen in Availability Graphical and Tabular Analysis screens for conformity with the other screens.
- The chart preview screen now allows multiple preview instances to be open.
- Add Next/Previous control to the Date Range [Id #171]

## Bug Fixes

- TEEP dashboard screen using incorrect defaults for include setup/standby.
- Trend date order incorrect in OEE Shift (By Device), OEE Part (By device), OEE Device.
- Line OEE Report summing instead of averaging (excluding zero) Takt Time, Average Cycle Time, Ideal Cycle time [Id #253]
- Shift Summary Report averaging of Takt Time, Average Cycle Time, Ideal Cycle time, Average Rate Total now excludes zero values from the averaging.
- Creating a favorite for the Line OEE Report incorrectly defaults the name to "Shift OEE Report" [Id #254]
- The report preview screen saves it's state when closing, causing problems for people who switch between single and multiple monitors.[Id #257]
- The grid and chart preview screens save their state when closing, causing problems for people who switch between single and multiple monitors. Same problem as [Id #257]
- **Updated Website** – More online help - check it out!! [www.oeestudio.com](http://www.oeestudio.com)

# TEEP Chart

The values making up the chart are displayed within their respective section. Includes the ability to select which values to display.

Home

Dashboard

About

Favorites

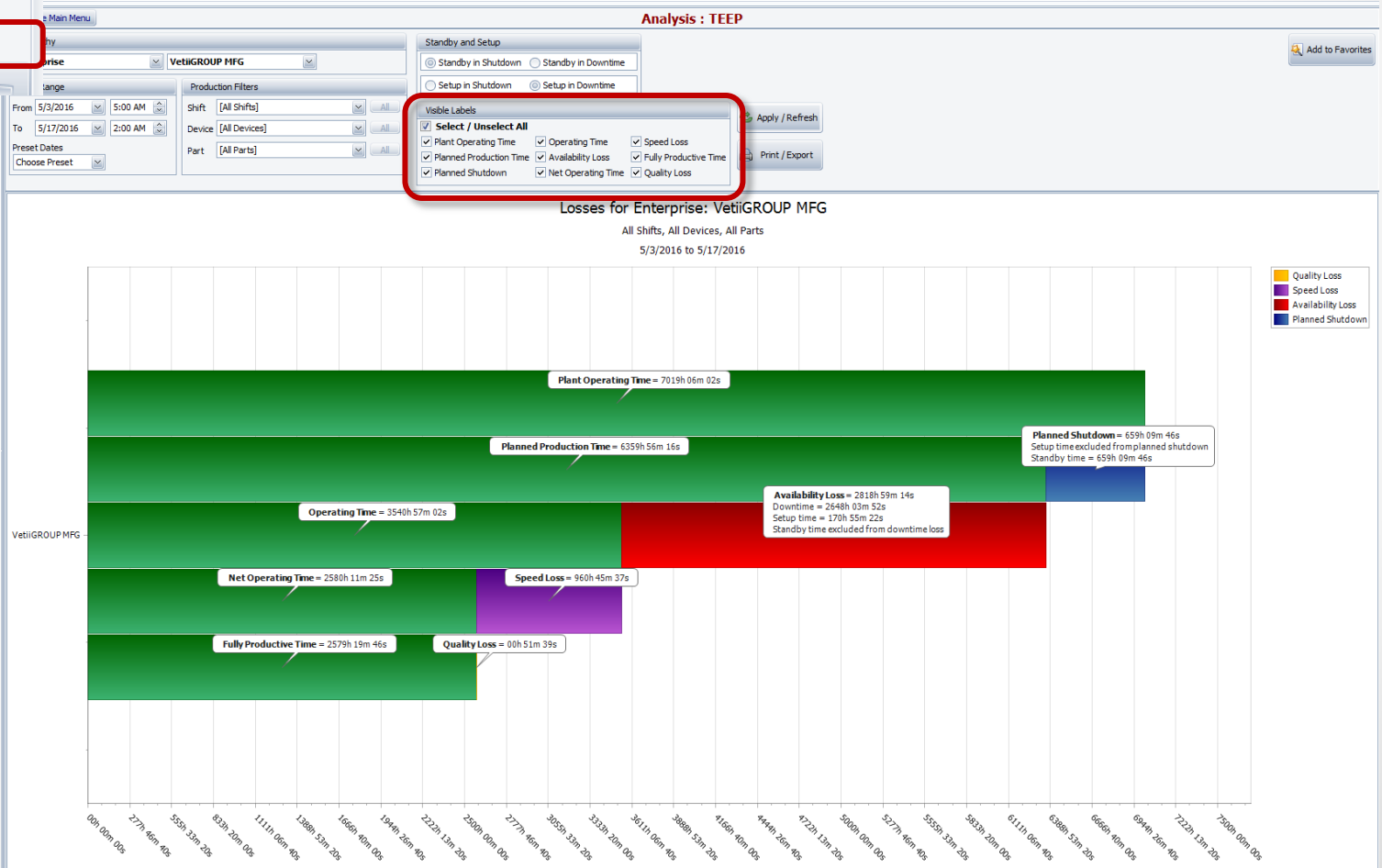
Analysis

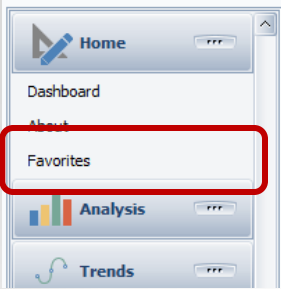
OEE

OEE Gains

OEE Losses

TEEP





# Favorites

Tree-view of all your Favorites. ~~ Searchable and can be edited or deleted

Hide Main Menu

**Saved Favorites**

Enter text to search...

Screen 0

Favorites				
Title	Group Name	Availability	Date Range	
<b>- Screen: All Shift Production Summary Report</b>				
<u>All Shift Production Summary Report</u> Lebanon, CT Print current report for first shift	Olivier	All Users	Current Day	Show Edit X
<b>- Screen: Availability - Graphical</b>				
<u>Availability - Graphical</u> Lebanon, CT	Group 1	All Users	Current Week	Show Edit X
<u>Availability - Graphical</u> Lebanon, CT First Shift, 1004_VFL3	Group 2	All Users	Current Week	Show Edit X
<u>Availability - Graphical</u> Lebanon, CT Good Crew Meeting Report	Group 1	All Users	Current Week	Show Edit X
<u>Downtime Graph Per Line</u> Post these at lines daily 2016-4-27	Group 3	All Users	Current Week	Show Edit X
<u>Downtime Reasons in Decending Order</u> Use for DT Reports	Group 3	All Users	Current Week	Show Edit X
<b>+ Screen: Availability - Tabular</b>				
<b>+ Screen: Job Analysis</b>				
<b>+ Screen: Loss Events - Parts</b>				
<b>+ Screen: Loss Pareto</b>				
<b>+ Screen: Performance Summary</b>				
<b>- Screen: Shift Analysis</b>				
<u>OEE Ranking Report by Plant</u> VetiGROUP MFG		All Users	Current Week	Show Edit X
<u>Plant Ranking OEE</u> VetiGROUP MFG		All Users	Current Week	Show Edit X
<u>Standard Shift Report</u> Standard Plant Shift Report Showing Parts Made and OEE		All Users	Current Week	Show Edit X
<u>Total time vs not scheduled time</u> 1004		All Users	Current Week	Show Edit X
<u>Total Time vs. Scheduled Time</u> Lebanon, CT 1004		All Users	Current Week	Show Edit X
<b>- Screen: Shift Summary Report</b>				
<u>Shift Summary for Cork Boards</u> Run for one line at a time. print pgs 1-2 and 7-8	Cork Boards	All Users	Current Week	Show Edit X
<u>Shift Summary Report</u> Lebanon, CT		All Users	Current Week	Show Edit X

**Standard Shift Report** Current Week

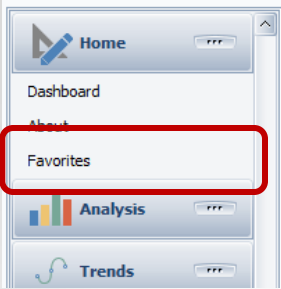
Standard Plant Shift Report Showing Parts Made and **OEE**

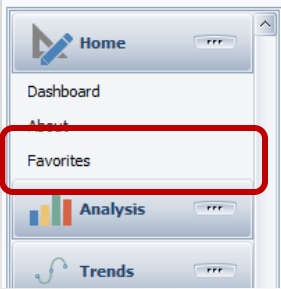
# Favorites

Edit your Favorite report, maybe to add some instruction, assign it to a Group, etc.

Group Name can be used to organize favorites for specific people, groups, teams, etc.

To change or make a new Group Name just start typing. New Group Names will then be added to the drop-down list.

A screenshot of the 'Modify Favorites' dialog box. It has a title bar with a close button. The 'Identification' section contains a 'Title' field with 'Downtime Graph Per Line', a 'Description' text area with 'Post these at lines daily', and a 'Group Name' dropdown menu currently showing 'Group 3'. The 'Date Range' section has a 'Range' field set to '1', radio buttons for 'Day(s)' and 'Week(s)' (with 'Week(s)' selected), and an 'Available To' section with radio buttons for 'All Users' (selected) and 'Just Me'. 'OK' and 'Cancel' buttons are at the bottom.A screenshot of the 'Modify Favorites' dialog box, identical to the one on the left but with the 'Group Name' dropdown menu now showing 'First Shift Team Leads'. A red arrow points from the 'Group 3' dropdown in the left screenshot to the 'First Shift Team Leads' dropdown in this screenshot. The rest of the dialog box content is the same.



# Favorites

You can move the Group Name column heading to the left and sort each section by Group Name.

A screenshot of a software interface titled 'Saved Favorites'. It features a search bar at the top with 'Enter text to search...' and 'Find' and 'Clear' buttons. Below is a 'Screen' dropdown menu. The main area is a table with two columns: 'Group Name' and 'Title'. The 'Group Name' column header is highlighted with a red rounded rectangle. The table is organized into sections: 'Screen: All Shift Production Summary Report', 'Screen: Availability - Graphical', and 'Screen: Availability - Tabular'. Each section contains multiple rows with data for Group Name and Title. The 'Group Name' column is currently sorted by the 'Title' column.

Group Name	Title
<b>Screen: All Shift Production Summary Report</b>	
Olivier	All Shift Production Summary Report
Lebanon, CT	Print current report for first shift
<b>Screen: Availability - Graphical</b>	
First Shift Team Leads	Downtime Graph Per Line
Post these at lines daily	
Group 1	Availability - Graphical
Lebanon, CT	
Group 1	Availability - Graphical
Lebanon, CT	Good Crew Meeting Report
Group 2	Availability - Graphical
Lebanon, CT	First Shift, 1004_VFL3
Group 3	Downtime Reasons in Decending Order
Use for DT Reports	
<b>Screen: Availability - Tabular</b>	
	DT Reasons By Plant for MW Region
Sorted by duration	
	Plant 1010 Production State By Line
Plant 1010 Production State By Line	
	Daily Production Report - Lebanon
1004	
1004_VFL5	
	Downtime Losses - by plant = 'None'

# Shift Comments

Select the Shift record in OEE Alert – Actions – Set Comment.  
Enter your comments and click the Save button.

The comments will then appear in OEE Studio.

Home Views Filters Actions Setup Info

Active filters: Date range: Year-To-Date, Date: Today, Category: Location:Lebanon, CT

Select Category: Location:Lebanon, CT Asset: 1004\_VFL5 05/11/2016

Select Category, Asset and Date, then click on a timeline event, shift or job to provide context for your comment, or to update reason text (events only)

Shift ID: First Shift Start time: Wed May 11 2016 06:00

Include Event Timeline   
Include Audit Info

Comment:

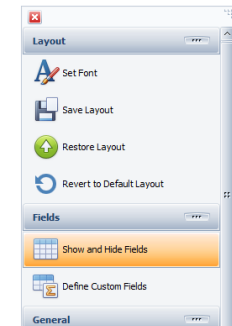
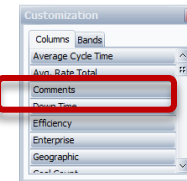
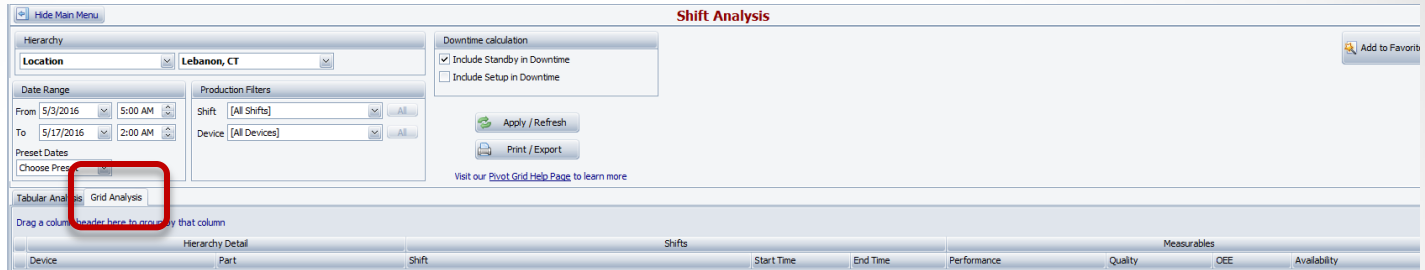
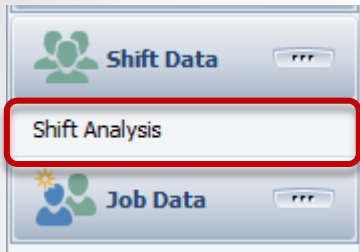
save

Tabular Analysis Grid Analysis

Drag a column header here to group by that column

Hierarchy Detail		Shifts				OEE	Perform
Device	Part	Shift	Start Time	End Time	Comments		
1004_VFL5	88559410	First Shift	5/3/2016 6:00 AM	5/3/2016 4:30 PM		81.8	
1004_VFL5	88559410	Second Shift	5/3/2016 4:30 PM	5/4/2016 4:30 AM		79.2	
1004_VFL5	88559410	Gap Shift	5/4/2016 4:30 AM	5/4/2016 6:00 AM		6.2	
1004_VFL5	88652180	First Shift	5/4/2016 6:00 AM	5/4/2016 4:30 PM		75.8	
1004_VFL5	88652180	Second Shift	5/4/2016 4:30 PM	5/5/2016 4:30 AM		93.6	
1004_VFL5	88452570	First Shift	5/5/2016 6:00 AM	5/5/2016 4:30 PM		77.9	
1004_VFL5	88452570	Second Shift	5/5/2016 4:30 PM	5/6/2016 4:30 AM		98.9	
1004_VFL5	88552180	First Shift	5/6/2016 6:00 AM	5/6/2016 4:30 PM		85.5	
1004_VFL5	88552180	Second Shift	5/6/2016 4:30 PM	5/7/2016 4:30 AM		84.2	
1004_VFL5	88652180	First Shift WE	5/7/2016 6:00 AM	5/7/2016 2:30 PM		69.8	
1004_VFL5	88652180	Gap Shift	5/7/2016 2:30 PM	5/8/2016 2:30 PM		61.0	
1004_VFL5	88652180	First Shift	5/9/2016 6:00 AM	5/9/2016 4:30 PM		3.8	
1004_VFL5	88452180	Second Shift	5/9/2016 4:30 PM	5/10/2016 4:30 AM		81.5	
1004_VFL5	88459410	First Shift	5/10/2016 6:00 AM	5/10/2016 4:30 PM		77.8	
1004_VFL5	88552180	Second Shift	5/10/2016 4:30 PM	5/11/2016 4:30 AM		93.6	
1004_VFL5	88552180	First Shift	5/11/2016 6:00 AM	5/11/2016 4:30 PM	This is the shift comment for May 11, 2016	84.6	
1004_VFL5	88552180	Second Shift	5/11/2016 4:30 PM	5/12/2016 4:30 AM	This is the shift comment for May 11, 2016 2nd shift	88.8	
1004_VFL5	88552180	First Shift	5/12/2016 6:00 AM	5/12/2016 4:30 PM		99.0	
1004_VFL5	88552180	Second Shift	5/12/2016 4:30 PM	5/13/2016 4:30 AM		89.9	
1004_VFL5	88559410	First Shift	5/13/2016 6:00 AM	5/13/2016 4:30 PM		89.9	
1004_VFL5	88559410	Second Shift	5/13/2016 4:30 PM	5/14/2016 4:30 AM		76.1	
1004_VFL5	88659410	First Shift WE	5/14/2016 6:00 AM	5/14/2016 2:30 PM		77.9	
1004_VFL5	88459410	First Shift	5/16/2016 6:00 AM	5/16/2016 4:30 PM		82.2	

# Shift Comments from OEE Alert



To review the comments by shift, select Shift Data – Shift Analysis – Grid Analysis.  
Click on the drop-down for Printing, Exporting, Field Selection and Layout Settings.  
Click on Show and Hide Fields.  
Drag the Comments field to the data row.



# VISUALIZING DATA COMMENTS

OEEAL

# Job Comments

Select the Job record in OEE Alert – Actions – Set Comment.  
Enter your comments and click the Save button.  
The comments will then appear in OEE Studio.

Home Views Filters Actions Setup Info Welco

Active filters: Date range: Year-To-Date, Date: Today, Category: Location:Lebanon\_CT

Select Category: Location:Lebanon, CT Asset: 1004\_VFL5 05/11/2016

Select Category, Asset and Date, then click on a timeline event, shift or job to provide context for your comment, or to update reason text (events only).

Job ID: EG BLACK 2CF - 88552180 Start time: Wed May 11 2016 12:19 Include Event Timeline  
Include Audit Info

Comment: This is another comment for this part.

save

Second Shift EG BLACK 2CF - 88552180 Gap Shift EG BLACK 2CF HYP0 BLK 2CF CH - 88552570 First Shift EG BLACK 2CF - 88552180 Second Shift EG BLACK 2CF HYP0 RED 2CF CH - 88-EG BLACK 2CF - 88552180

Job Comparison

Hierarchy: Location Lebanon, CT

Date Range: From 5/3/2016 5:00 AM To 5/17/2016 2:00 AM

Production Filters: Device [All Devices] Part [All Parts]

Downtime calculation:  Include Standby in Downtime  Include Setup in Downtime

Apply / Refresh Print / Export

Visit our [Pivot Grid Help Page](#) to learn more

Tabular Analysis Grid Analysis

Drag a column header here to group by that column

Hierarchy Detail			Jobs			
Device	Part	Job Name	Comments	End Time	Start Time	OEE
1004_VFL5	88552180	EG BLACK 2CF		5/6/2016 4:30 PM	5/6/2016 1:48 PM	90,3
1004_VFL5	88552180	EG BLACK 2CF		5/7/2016 4:30 AM	5/6/2016 4:30 PM	84,2
1004_VFL5	88552180	EG BLACK 2CF		5/7/2016 8:59 AM	5/7/2016 6:00 AM	72,2
1004_VFL1	88552180	EG BLACK 2CF		5/9/2016 2:52 PM	5/9/2016 9:29 AM	43,2
1004_VFL5	88552180	EG BLACK 2CF		5/9/2016 11:57 PM	5/9/2016 5:48 PM	86,0
1004_VFL1	88552180	EG BLACK 2CF		5/10/2016 2:44 AM	5/10/2016 1:24 AM	51,0
1004_VFL5	88552180	EG BLACK 2CF	This is a comment for 88552180 May 10th.	5/11/2016 6:43:30 AM	5/10/2016 9:52 PM	90,1
1004_VFL5	88552180	EG BLACK 2CF	This is the comment for 88552180	5/11/2016 6:7:07 AM	5/11/2016 6:00 AM	94,5
1004_VFL5	88552180	EG BLACK 2CF	This is another comment for this part.	5/11/2016 6:4:30 PM	5/11/2016 12:19 PM	91,1
1004_VFL5	88552180	EG BLACK 2CF		5/11/2016 6:05 PM	5/11/2016 4:30 PM	84,3
1004_VFL5	88552180	EG BLACK 2CF		5/12/2016 4:30 AM	5/11/2016 8:32 PM	89,0
1004_VFL5	88552180	EG BLACK 2CF		5/12/2016 4:30 PM	5/12/2016 6:00 AM	99,0
1004_VFL5	88552180	EG BLACK 2CF		5/13/2016 4:30 AM	5/12/2016 4:30 PM	89,9
1004_VFL5	88552180	EG BLACK 2CF		5/13/2016 9:44 AM	5/13/2016 6:00 AM	92,9

# Job Comments from OEE Alert



Hide Main Menu

**Shift Analysis**

Location: Lebanon, CT

Date Range: From 5/3/2016 5:00 AM To 5/17/2016 2:00 AM

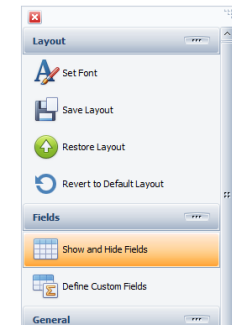
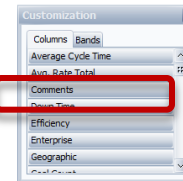
Production Filters: Shift [All Shifts] Device [All Devices]

Downtime calculation:  Include Standby in Downtime  Include Setup in Downtime

Apply / Refresh  
Print / Export

Tabular Analysis: Grid Analysis

Device	Part	Shift	Start Time	End Time	Performance	Quality	OEE	Availability
--------	------	-------	------------	----------	-------------	---------	-----	--------------



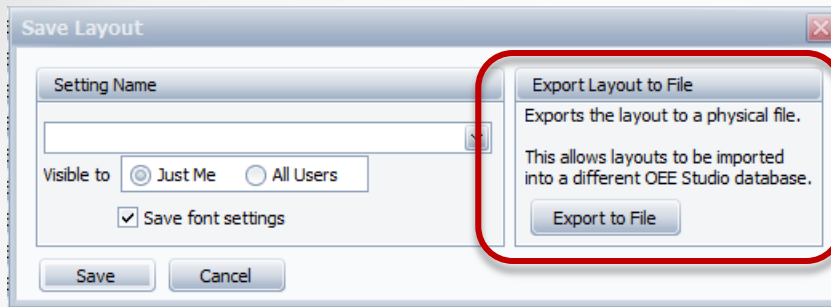
To review the comments by shift, select Job Data – Job Comparison – Grid Analysis.  
Click on the drop-down for Printing, Exporting, Field Selection and Layout Settings.  
Click on Show and Hide Fields.  
Drag the Comments field to the data row.

# Export Saved Layouts

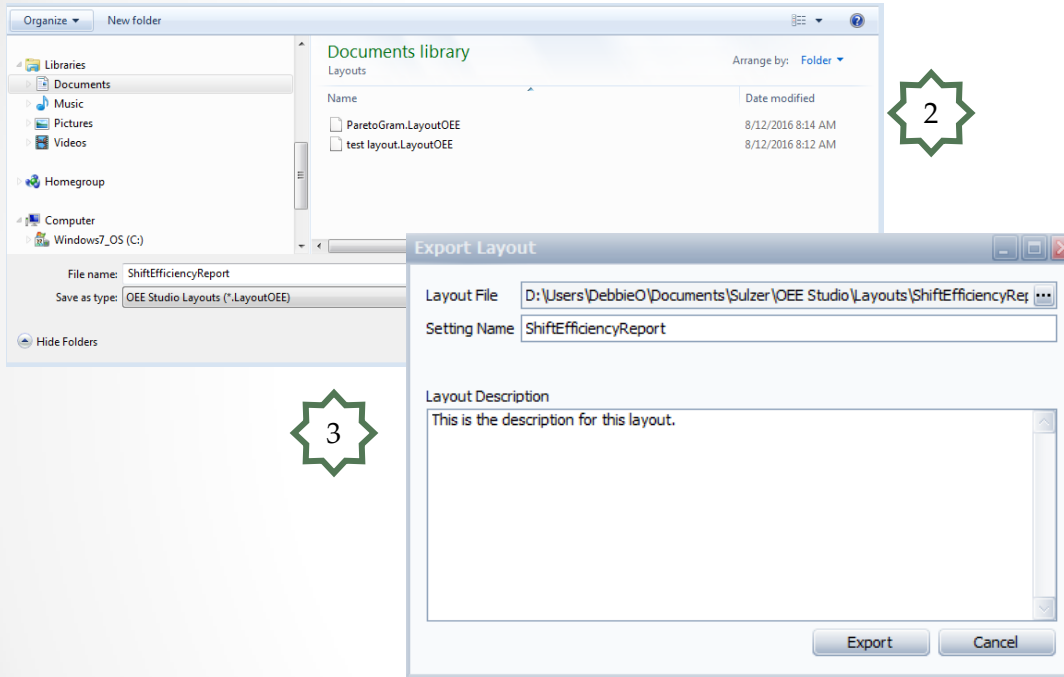
Provides the ability to share report layouts between different OEE Studio users. This is specific to companies that have multiple databases and want to share reports.

It will also be used by us to share report layouts with all OEE Studio users!!

1

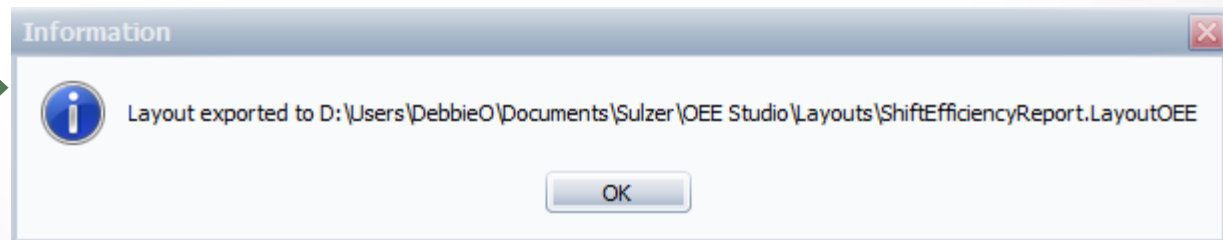


2



3

4



# Import Saved Layouts

Importing a Saved Layout will import the layout to the section of OEE Studio in which it was saved.

For example, a Shift Data saved layout will be imported to the Shift Data portion of OEE Studio.

1

2

3

4

5

Layout Name	Public	Delete
test export	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
OEE ParetoSuperBowl	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Full Day Production Report By Shift v2 2014_10_23	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Shift Production ReportV3	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Shift Production ReportV2	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Full Day Production Report By Shift	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Shift Production Report	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
test3	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
test2	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Pareto Gram	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Name	Date modified
AVGSetupbyNBRParts.LayoutOEE	9/30/2016 9
ParetoGram.LayoutOEE	8/12/2016 8
ShiftEfficiencyReport.LayoutOEE	9/29/2016 3
test layout.LayoutOEE	8/12/2016 8

Layout Name	Public	Delete
Analysis	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Production Report - By Part V1	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
12345	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Report	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Production Report - By Partv2	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Production Report - By Part	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Part Cycles	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
AverageSetup	<input type="checkbox"/>	<input checked="" type="checkbox"/>

# PivotGrid Field List

## Understanding the layout

The image shows the SAP PivotGrid Field List and Layout panels. The Field List panel on the right contains a list of fields categorized into Filter Area, Row Area, Column Area, and Data Area. The Layout panel on the left provides options for font, layout, and fields. The main PivotGrid area displays a table with columns for Enterprise, Geographic, Location, Order Type, OrderType, PlanningPlant, Plant, Region, and Type, and rows for Availability, OEE, Performance, and Quality across two shifts.

**PivotGrid Field List:**

- Filter Area:** Enterprise, Geographic, Location, Order Type, OrderType, PlanningPlant, Plant
- Row Area:** Device
- Column Area:** Availability, OEE, Performance, Quality
- Data Area:** Availability, OEE, Performance, Quality

**Layout Panel:**

- Layout:** Set Font, Save Layout, Restore Layout, Revert to Default Layout
- Fields:** Show and Hide Fields, Define Custom Fields
- General:** Print / Export

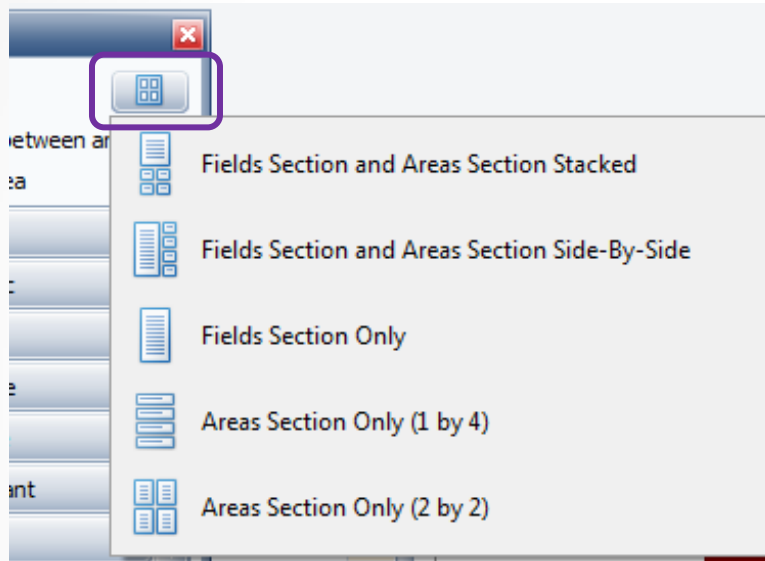
**PivotGrid Table:**

Device	First Shift				Second Shift			
	Availability	OEE	Performance	Quality	Availability	OEE	Performance	Quality
1004_VFL4	85.7	45.3	52.9	100.0	78.4	37.8	48.2	100.0
1004_VFL5	81.6	76.4	93.9	99.7	91.6	87.3	95.9	99.4
Grand Total	83.6	61.0	73.1	99.8	85.0	62.5	73.9	99.6

This detailed view of the PivotGrid table shows annotations for the different areas. A green box highlights the Filter Area (Enterprise, Geographic, Location, Order Type, OrderType, PlanningPlant, Plant, Region, Type). A blue box highlights the Column Area (Availability, OEE, Performance, Quality). A red box highlights the Row Area (Device). An orange box highlights the Data Area (Availability, OEE, Performance, Quality).

Based on customer request, we have auto-expanded the PivotGrid Field List so that you can see all of the data elements.

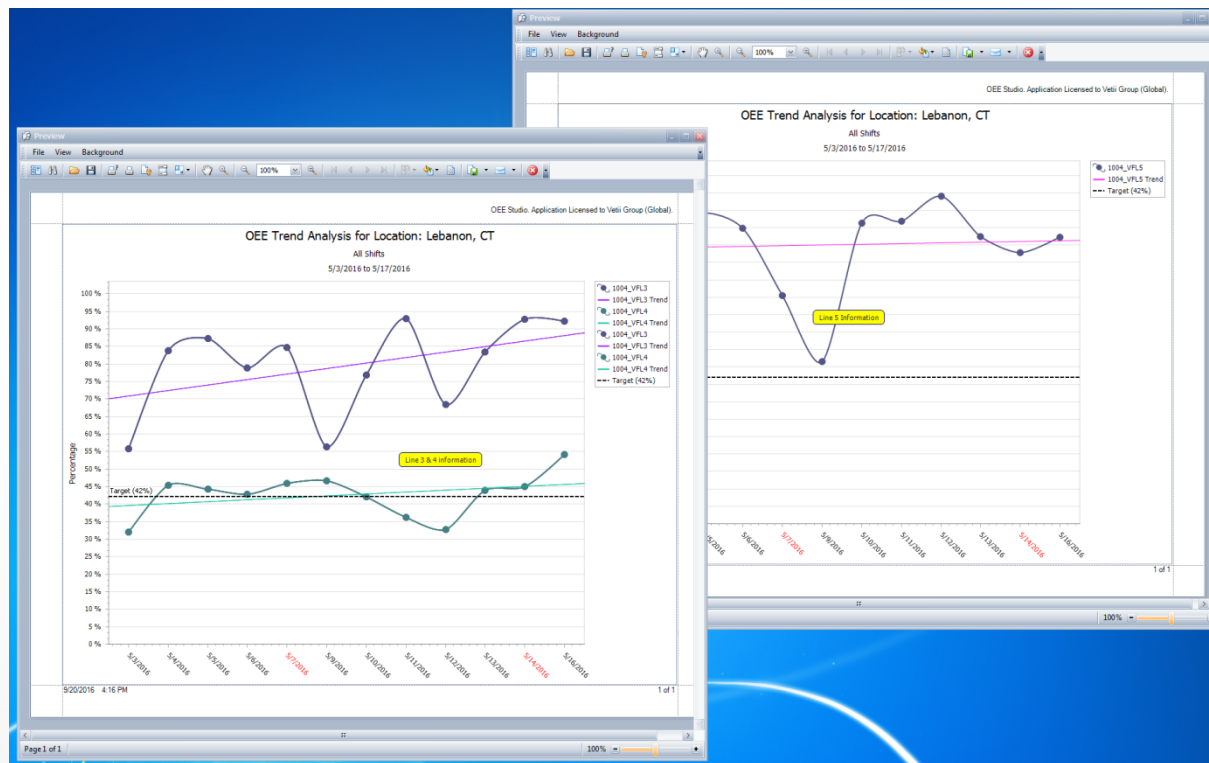
# PivotGrid Field List Different Layouts



The icons next to each selection indicates how the PivotGrid Field List will be displayed.

# Multiple Charts visible at the same time

You now have the ability to have more than one chart previewed on the screen. This way you can make one annotation for the current chart, click Print/Preview and move the preview out of the way. Then you can create another chart and create a new annotation and click Print/Preview again and then both charts are visible on the same screen.



# Previous/Next Button

The screenshot shows a software interface with a 'Date Range' section and a 'Production Filters' section. The 'Date Range' section includes 'From' (5/9/2016) and 'To' (5/17/2016) fields, along with 'Preset Dates' and 'Prev/Next' options. The 'Production Filters' section includes 'Shift' ([All Shifts]) and 'Device' (1004\_VFL5) fields. A 'Previous / Next' dialog box is open, displaying navigation buttons and a calendar for May 2016. The calendar shows the current date (May 17) highlighted in blue.

SU	MO	TU	WE	TH	FR	SA
1	2	3	4	5	6	7
8	9	10	11	12	13	14
15	16	17	18	19	20	21
22	23	24	25	26	27	28
29	30	31	1	2	3	4
5	6	7	8	9	10	11

The **Prev/Next** drop-down provides the ability to adjust the calendar dates by Day, Week or Month so that you don't have to manually change the From and To dates.

It also displays the current date selection so that you get a good visual as to your date range.



# OEE Studio v 3.3

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

**XL Bolt-on Data Collector version 1.8.3**

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

**Version 3.3 of OEE Studio supports all versions of Vorne XL device firmware.**

Smart Installation

<http://oeestudio.com/installs/release/v3/setup/InstallOEEStudio.exe>

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

Debbie.olk@debtechsystems.com

or

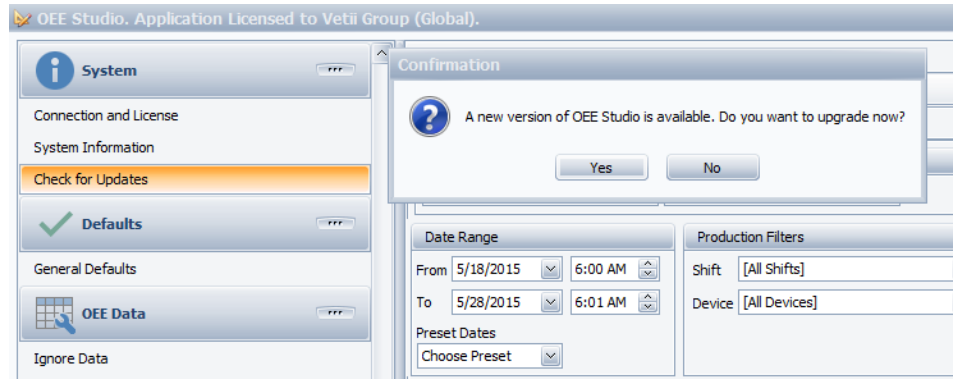
Jim Sulzer (XL Bolt-On Data Collector).

jim@sulzerconsulting.com

# OEE Studio v3.3

OEE Studio version 3.3 is available for upgrade.

If you have an older version that was manually installed, please uninstall that version of OEE Audit before installing this version of OEE Studio. This can be determined by looking at the bottom right of the OEE Audit software.



## Smart Installation

<http://oestudio.com/installs/release/v3/setup/InstallOEEStudio.exe>

- The OEE Studio installation manual is available for downloading on our new website – <http://www.oestudio.com/toolbox.html>

# Contact Us

- As the Vorne Authorized Reporting Consultants, we provide customized reporting solutions, including working with data from your ERP/MRP systems.
- In addition to customized reporting, we provide support and customization for the **OEE Studio** reporting software (designed specifically for the data captured from the Vorne XL devices).
- We also provide sales, support and customization for **OEE Alert**. ([www.OEEAlert.com](http://www.OEEAlert.com))

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

**Vetii | GROUP**