OEE Studio Release Note

Version 3.5

Deb-Tech Systems, Inc. & Production Improvement Systems Ltd.
Debbie.Olk@DebTechSystems.com
Russell@ProductionImprovement.com
847.854.3148

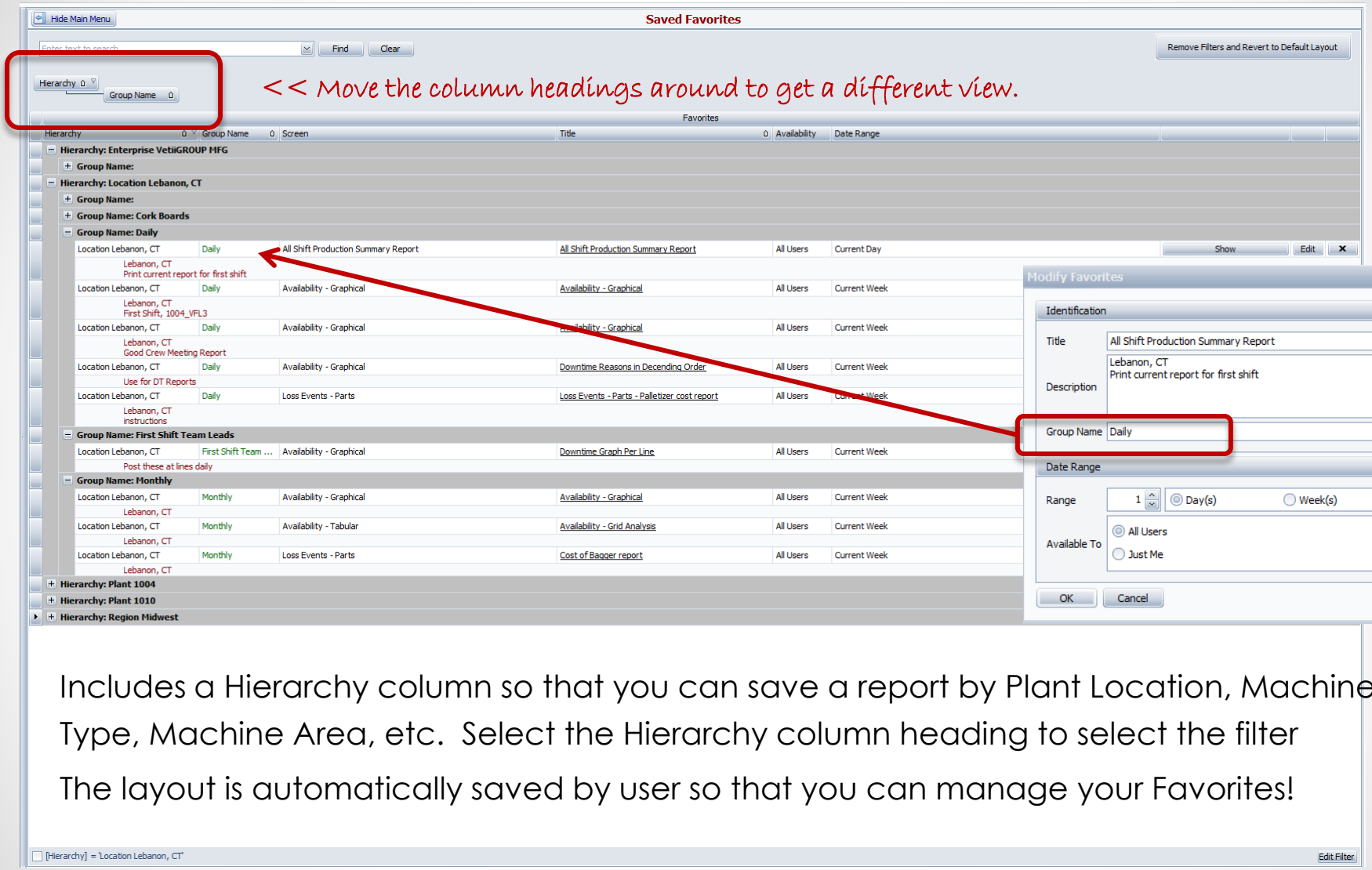
What's New in 3.5

- **Favorites Screen**
- This now has a Hierarchy column which will allow the users to filter by hierarchy (by selecting the filter icon in the column). Additionally any changes made to the layout on this screen will automatically get saved to the users profile, and applied whenever they return to the screen. There is also a "Revert to default" button at the top of the screen in case they need to reset the layout.

- **Enhancements**
- Pivot Grid drill down data on cell with double click. The pivot grid displays the highlighted field in red when the drill down is applied.
- Availability - Graphical Analysis - Bar Color for Reason 'None' = Pink.
- Added Hierarchy Grouping to the All Shift Production Report.
- Added OEE Trend chart to All Shift Production Report.
- Ability to choose the production states included in Top Losses for Shift OEE Reports, Shift Production Report, Line OEE Report.
- New Report – Shift OEE Report with Comments. Displays shift interval and production interval comments that were entered via OEE Alert.
- Added Line Production Time fields to the Availability – Tabular Analysis Pivot and Data Grids.
- Top value filtering for Pivot Grid Controls.
- Added Raw Excel format option when exporting data grids and pivot grids to Excel

- **Updated Website** – More online help - check it out!! www.oeestudio.com/toolbox.html

Favorites Screen

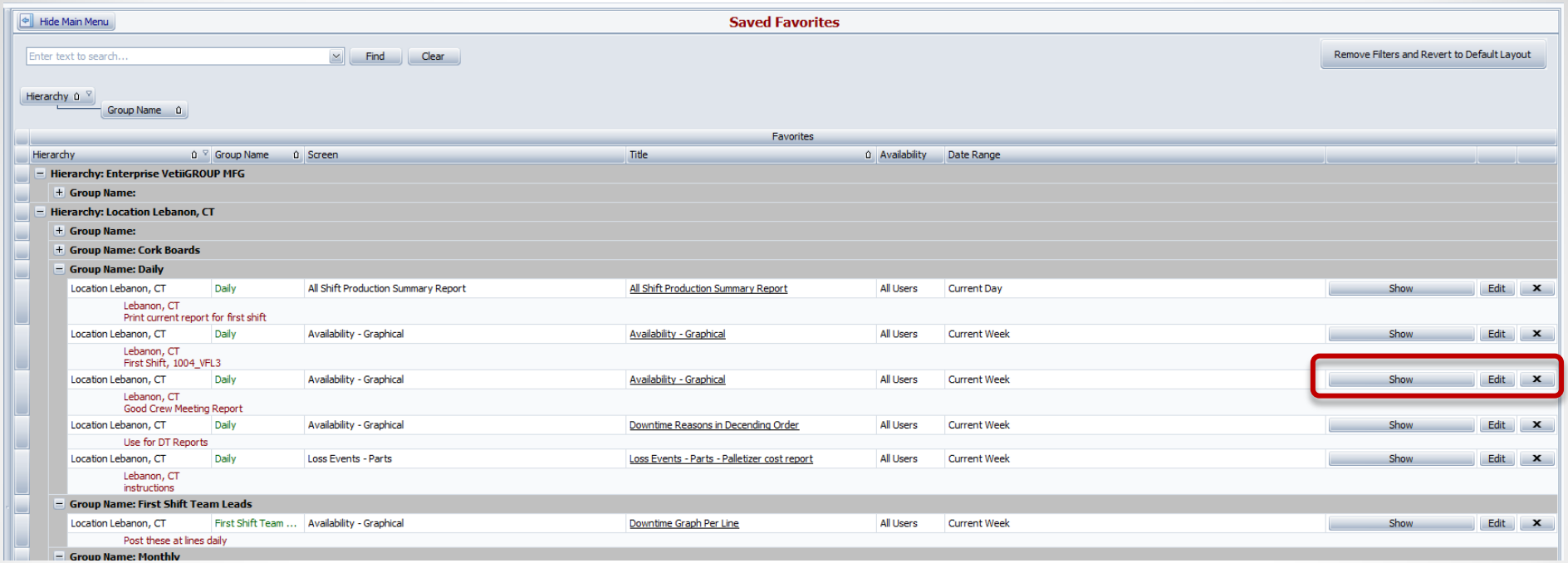


Includes a Hierarchy column so that you can save a report by Plant Location, Machine Type, Machine Area, etc. Select the Hierarchy column heading to select the filter

The layout is automatically saved by user so that you can manage your Favorites!

You can also assign reports to Groups, such as Daily, Monthly, Supervisor, etc.

Favorites Screen



Click on the Show button to launch your favorite report.

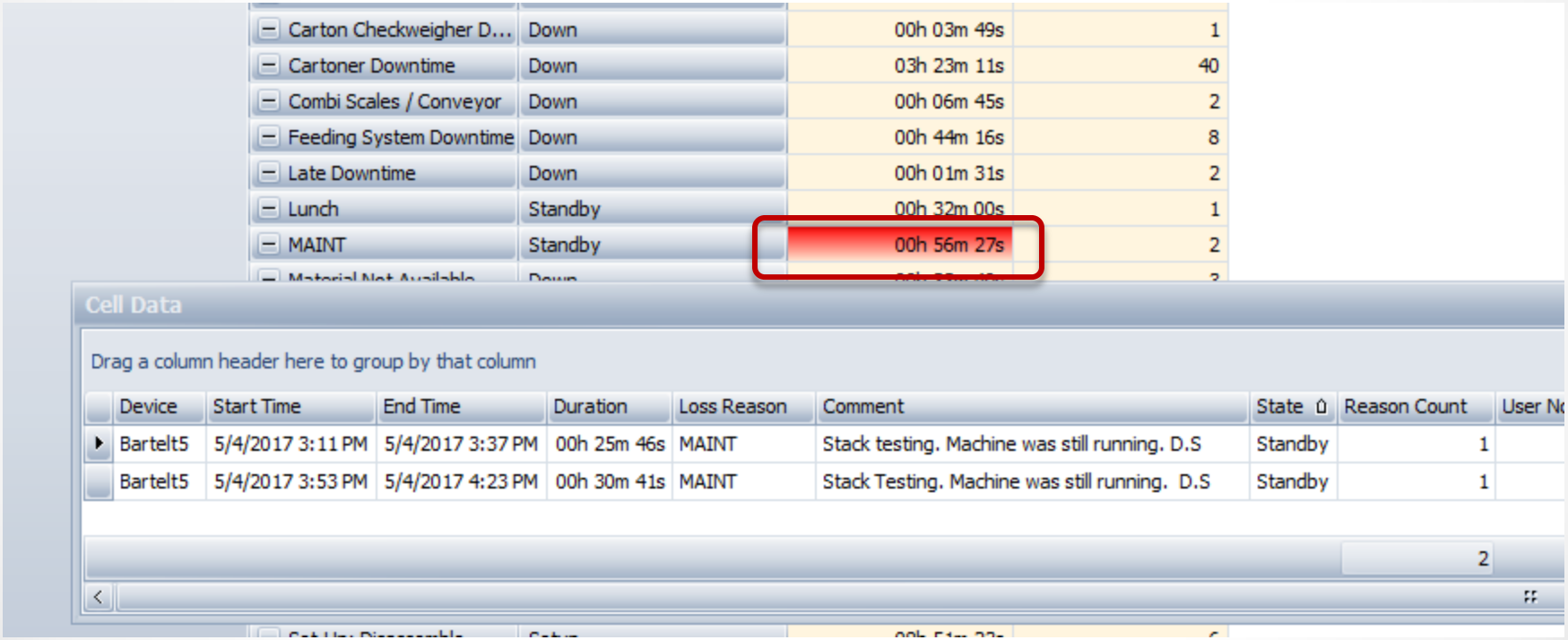
Click on the Edit button to modify the settings.

Click on the X button to remove the report.

Pivot Grid Drill-Down

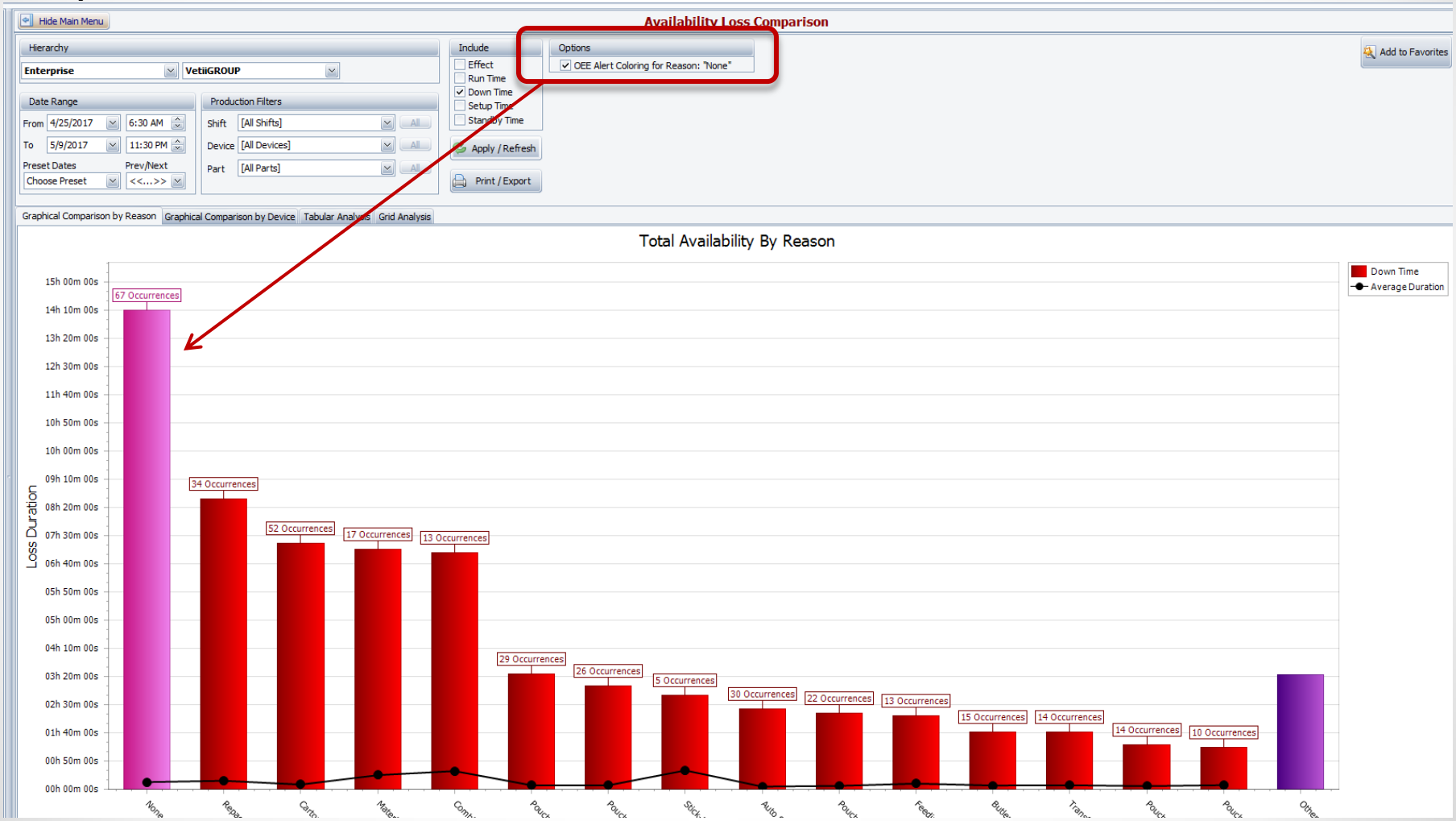
Any of the Pivot Grid screens allows you to **double-click** on a data cell to display the details associated with that cell.

Additionally, the cell will be highlighted in Red to indicate which cell you are referencing.

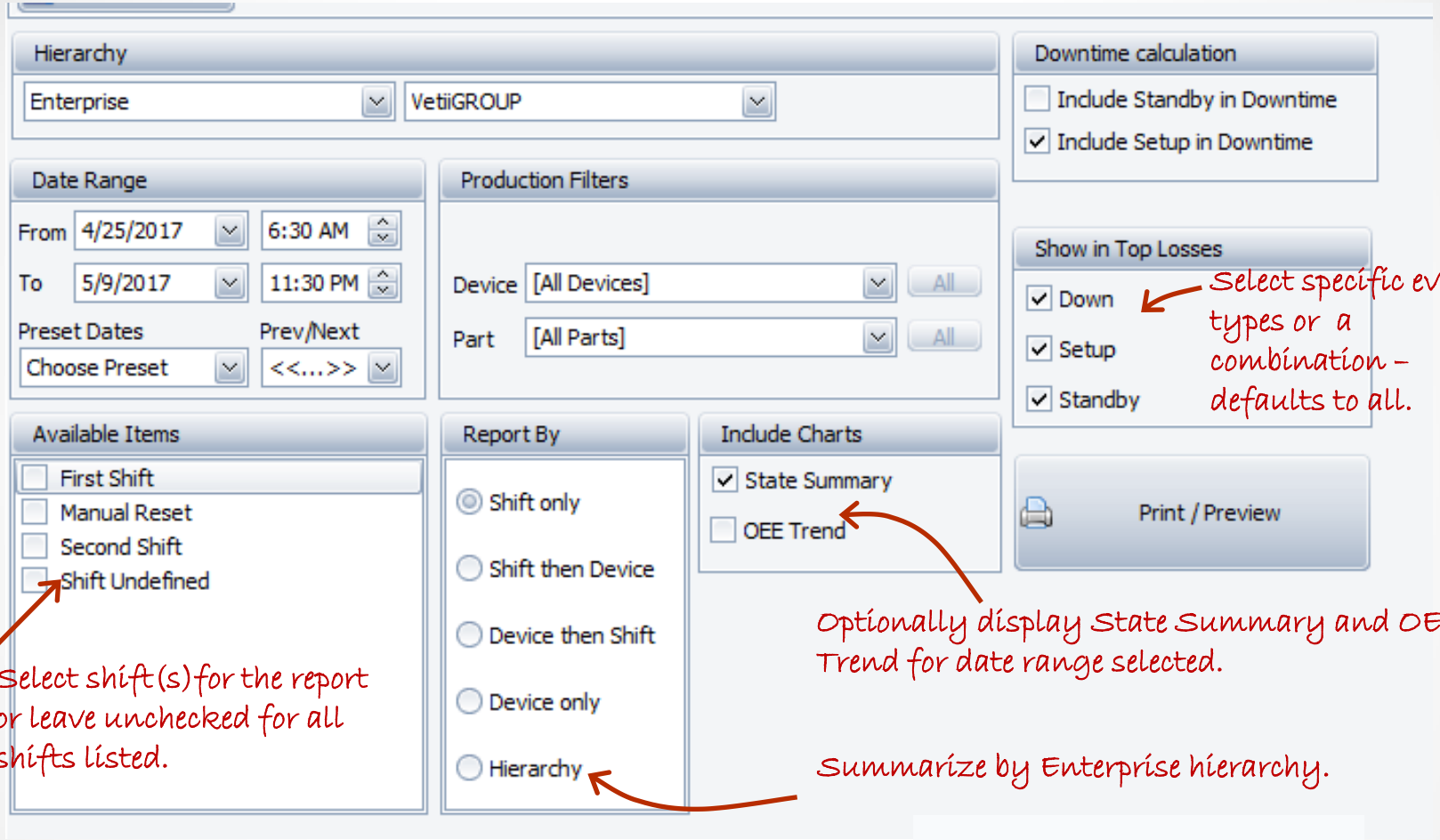


Highlight Un-Categorized Downtime

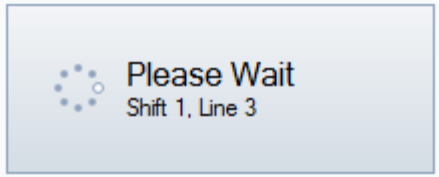
Similar to the OEE Alert Production State screen where events that are 'None' are displayed in the color pink. We have brought the same indication to OEE Studio – **Availability** – **Graphical Comparison**.



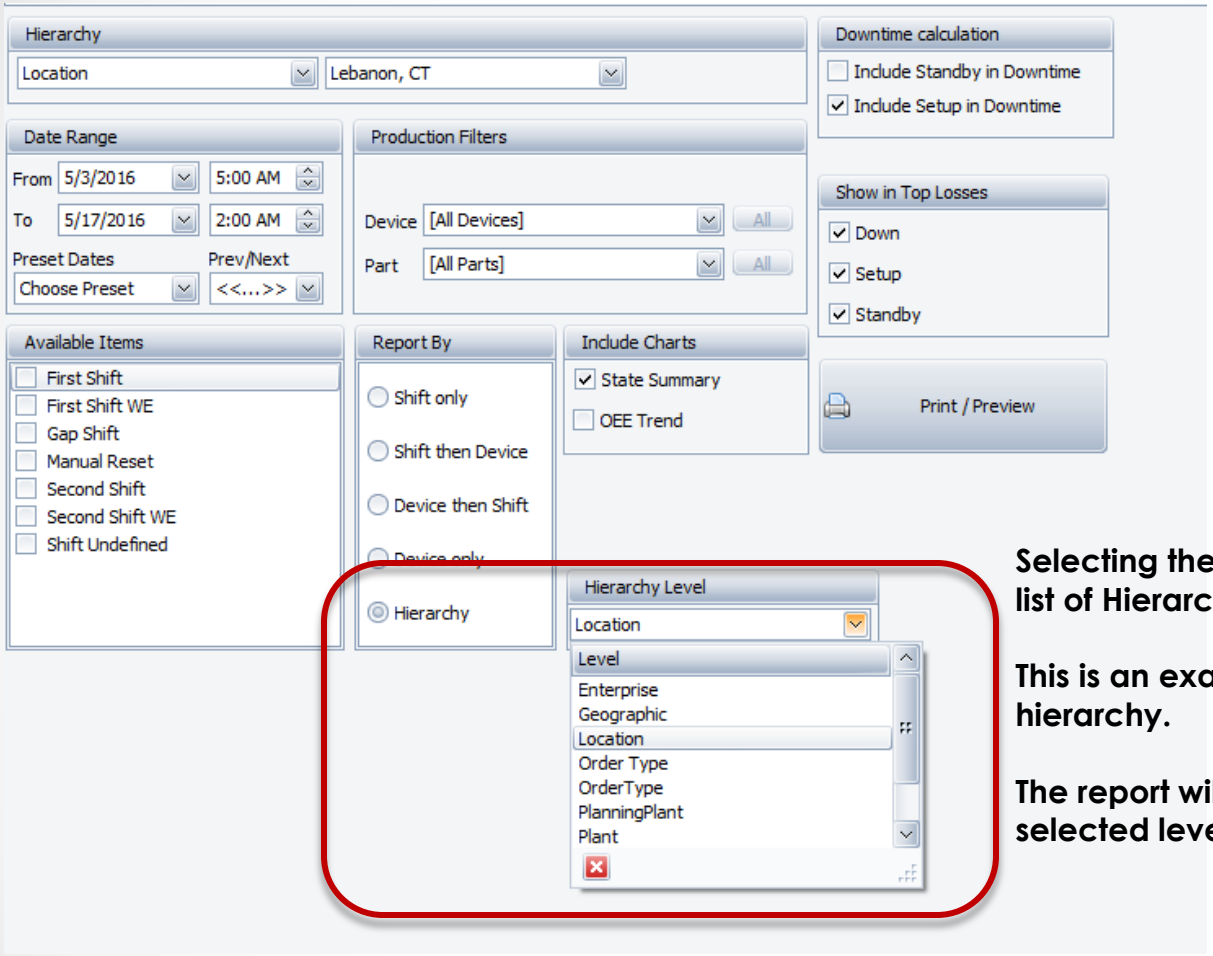
Reports – All Shift Production - More Options



After you click on the Print/Preview button, the Please Wait display will show you which lines and shifts are being processed.



Reports – All Shift Production - Hierarchy

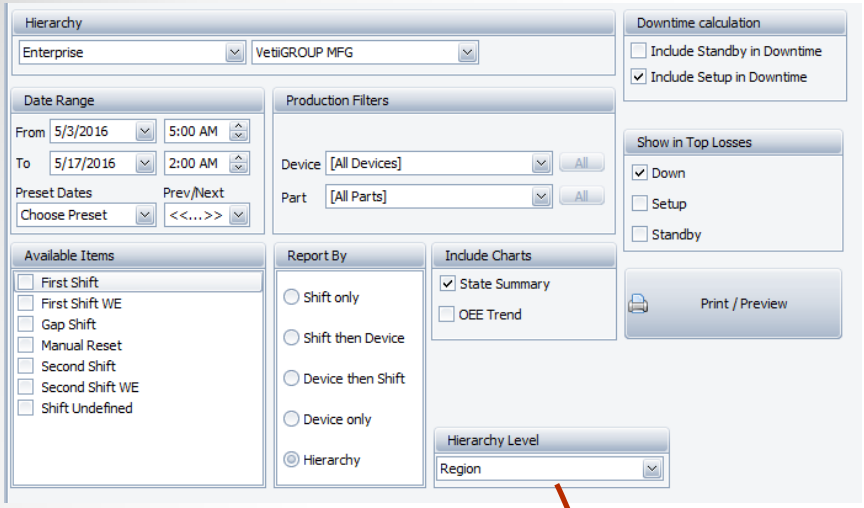


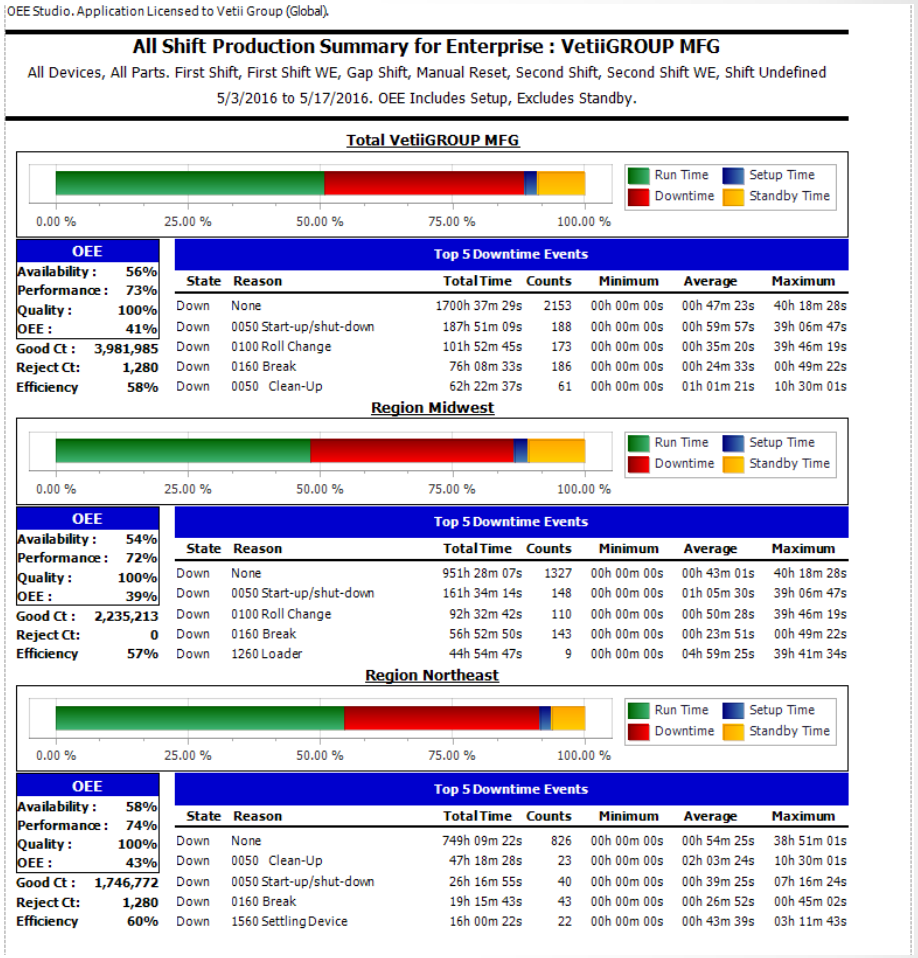
Selecting the Hierarchy Level provides the list of Hierarchy properties for your system.

This is an example of a customer's hierarchy.

The report will be summarized at the selected level.

Reports – All Shift Production - Hierarchy





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

All Shift Production Summary for Enterprise : VetiiGROUP MFG

All Devices, All Parts. First Shift, First Shift WE, Gap Shift, Manual Reset, Second Shift, Second Shift WE, Shift Undefined

5/3/2016 to 5/17/2016. OEE Includes Setup, Excludes Standby.

Total VetiiGROUP MFG

Run Time | Setup Time | Downtime | Standby Time

0.00 % 25.00 % 50.00 % 75.00 % 100.00 %

OEE	
Availability :	56%
Performance :	73%
Quality :	100%
OEE :	41%
Good Ct :	3,981,985
Reject Ct:	1,280
Efficiency	58%

Top 5 Downtime Events

State	Reason	Total Time	Counts	Minimum	Average	Maximum
Down	None	1700h 37m 29s	2153	00h 00m 00s	00h 47m 23s	40h 18m 28s
Down	0050 Start-up/shut-down	187h 51m 09s	188	00h 00m 00s	00h 59m 57s	39h 06m 47s
Down	0100 Roll Change	101h 52m 45s	173	00h 00m 00s	00h 35m 20s	39h 46m 19s
Down	0160 Break	76h 08m 33s	186	00h 00m 00s	00h 24m 33s	00h 49m 22s
Down	0050 Clean-Up	62h 22m 37s	61	00h 00m 00s	01h 01m 21s	10h 30m 01s

Region Midwest

Run Time | Setup Time | Downtime | Standby Time

0.00 % 25.00 % 50.00 % 75.00 % 100.00 %

OEE	
Availability :	54%
Performance :	72%
Quality :	100%
OEE :	39%
Good Ct :	2,235,213
Reject Ct:	0
Efficiency	57%

Top 5 Downtime Events

State	Reason	Total Time	Counts	Minimum	Average	Maximum
Down	None	951h 28m 07s	1327	00h 00m 00s	00h 43m 01s	40h 18m 28s
Down	0050 Start-up/shut-down	161h 34m 14s	148	00h 00m 00s	01h 05m 30s	39h 06m 47s
Down	0100 Roll Change	92h 32m 42s	110	00h 00m 00s	00h 50m 28s	39h 46m 19s
Down	0160 Break	56h 52m 50s	143	00h 00m 00s	00h 23m 51s	00h 49m 22s
Down	1260 Loader	44h 54m 47s	9	00h 00m 00s	04h 59m 25s	39h 41m 34s

Region Northeast

Run Time | Setup Time | Downtime | Standby Time

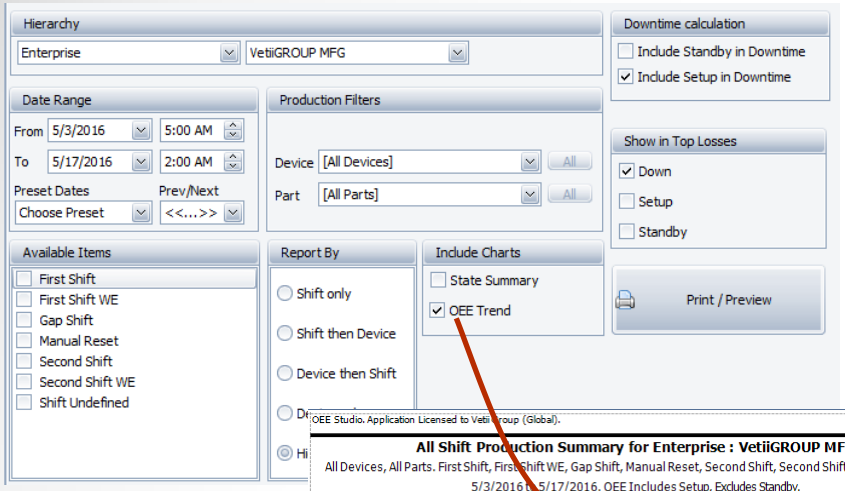
0.00 % 25.00 % 50.00 % 75.00 % 100.00 %

OEE	
Availability :	58%
Performance :	74%
Quality :	100%
OEE :	43%
Good Ct :	1,746,772
Reject Ct:	1,280
Efficiency	60%

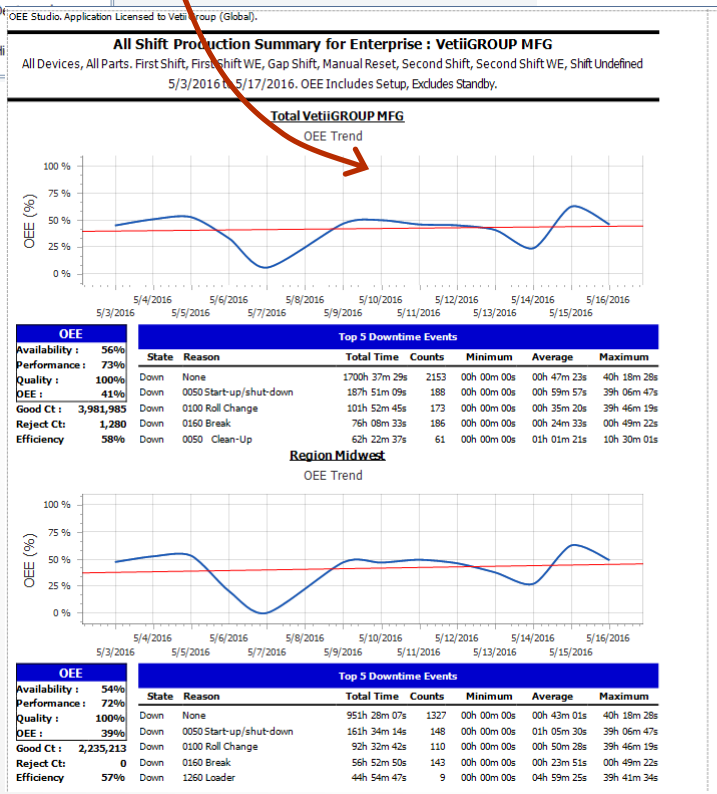
Top 5 Downtime Events

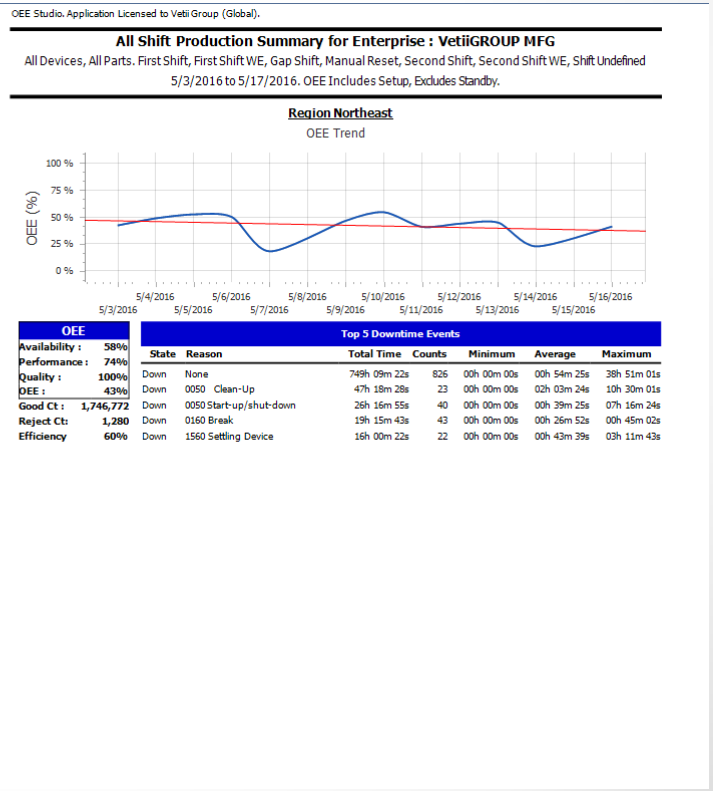
State	Reason	Total Time	Counts	Minimum	Average	Maximum
Down	None	749h 09m 22s	826	00h 00m 00s	00h 54m 25s	38h 51m 01s
Down	0050 Clean-Up	47h 18m 28s	23	00h 00m 00s	02h 03m 24s	10h 30m 01s
Down	0050 Start-up/shut-down	26h 16m 55s	40	00h 00m 00s	00h 39m 25s	07h 16m 24s
Down	0160 Break	19h 15m 43s	43	00h 00m 00s	00h 26m 52s	00h 45m 02s
Down	1560 Settling Device	16h 00m 22s	22	00h 00m 00s	00h 43m 39s	03h 11m 43s

Reports – All Shift Production - OEE Trend

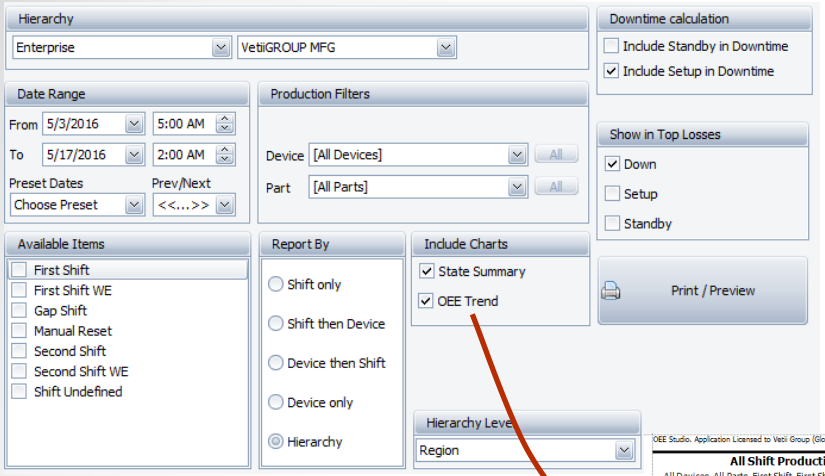


Optionally select to display the OEE Trend for the selected date range.

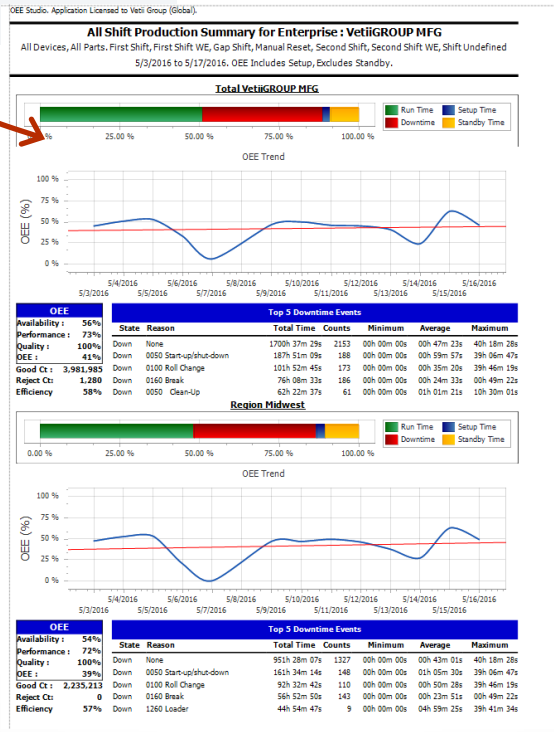


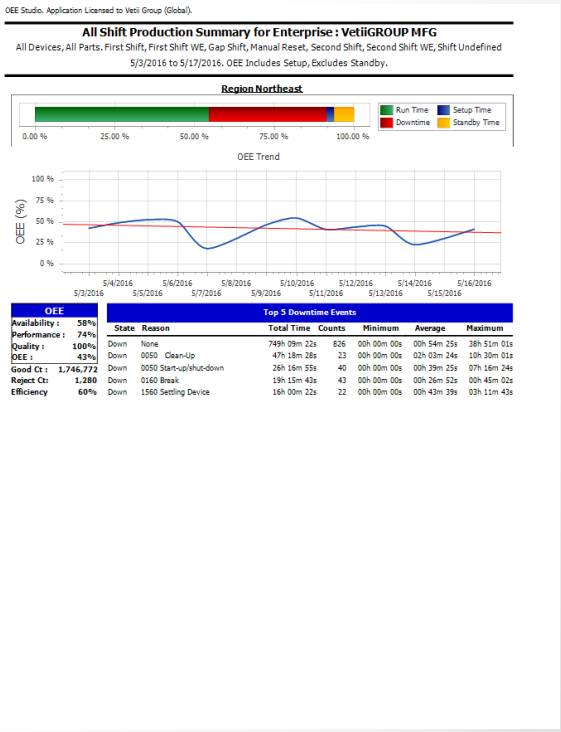


Reports – All Shift Production



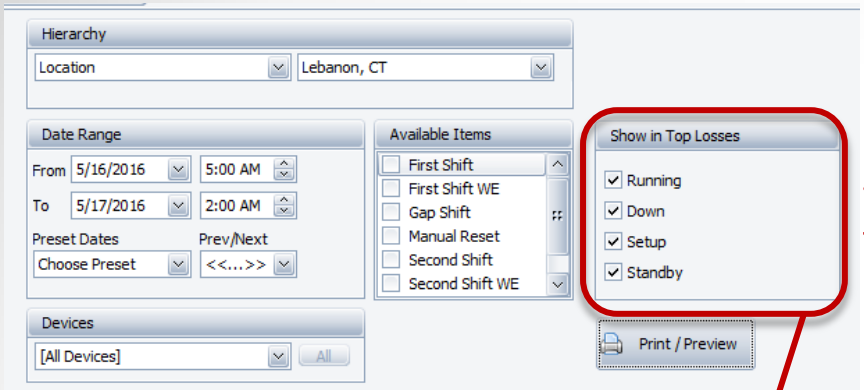
Select both charts for a comprehensive view of your plant.

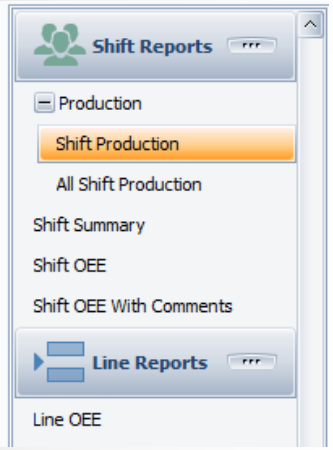


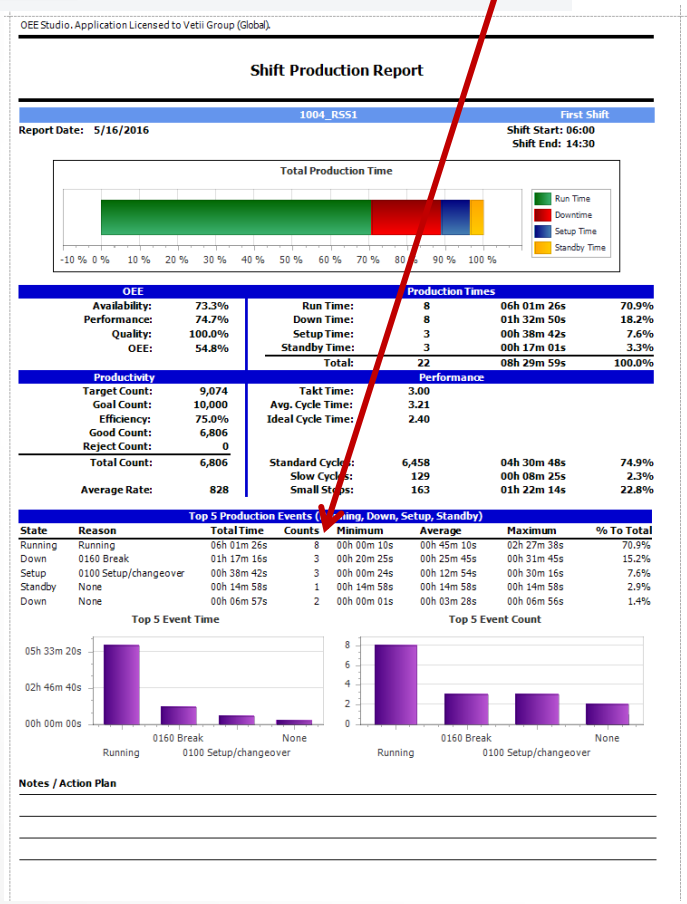


Daily Shift Production Report

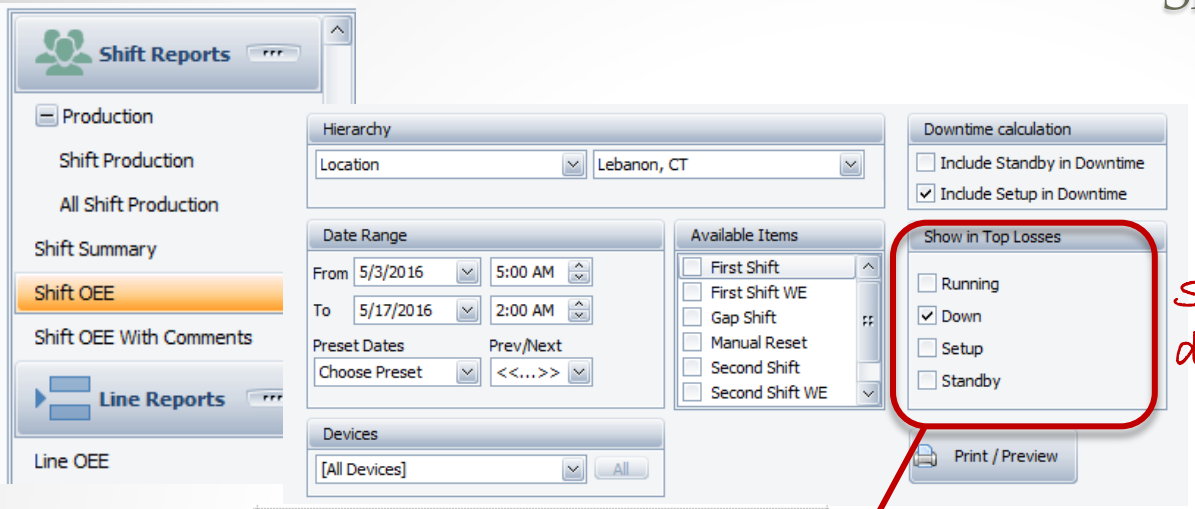
Select which types of losses to display on the report.



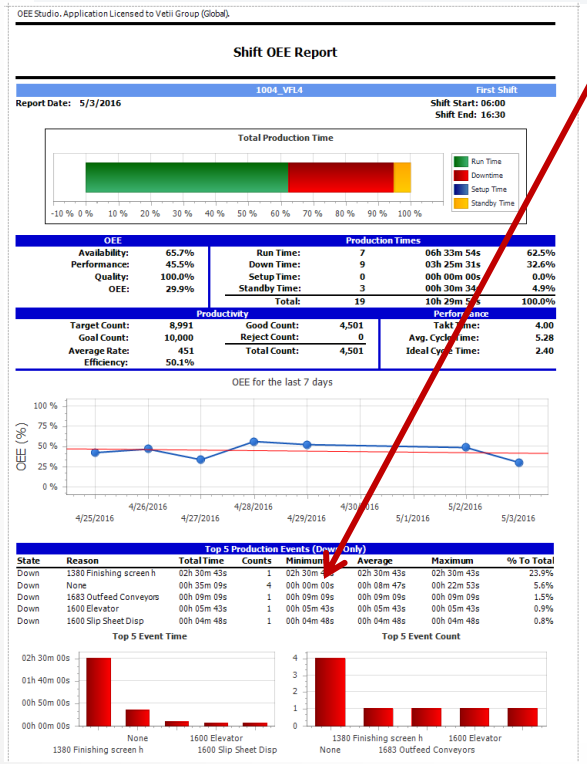




Shift OEE Report

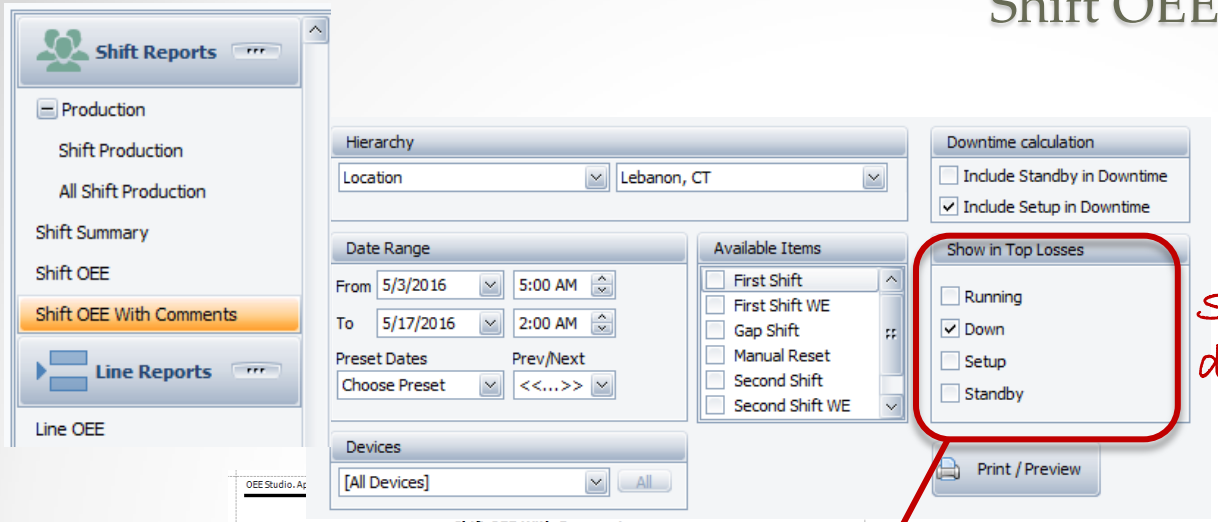


Select which types of losses to display on the report.

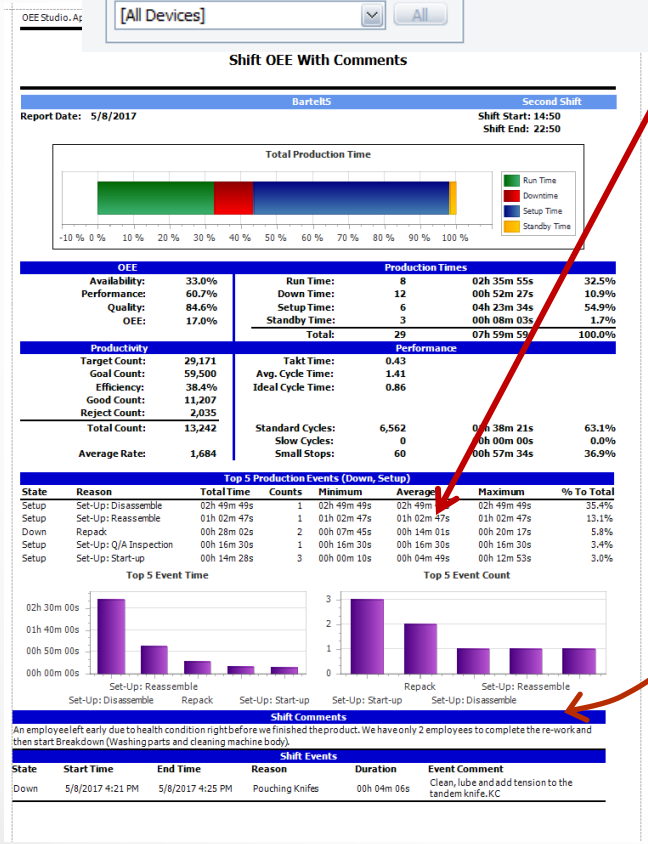


Provides a 1-page summary of each shifts, by line for each date in the given date range.

Shift OEE Report with Comments



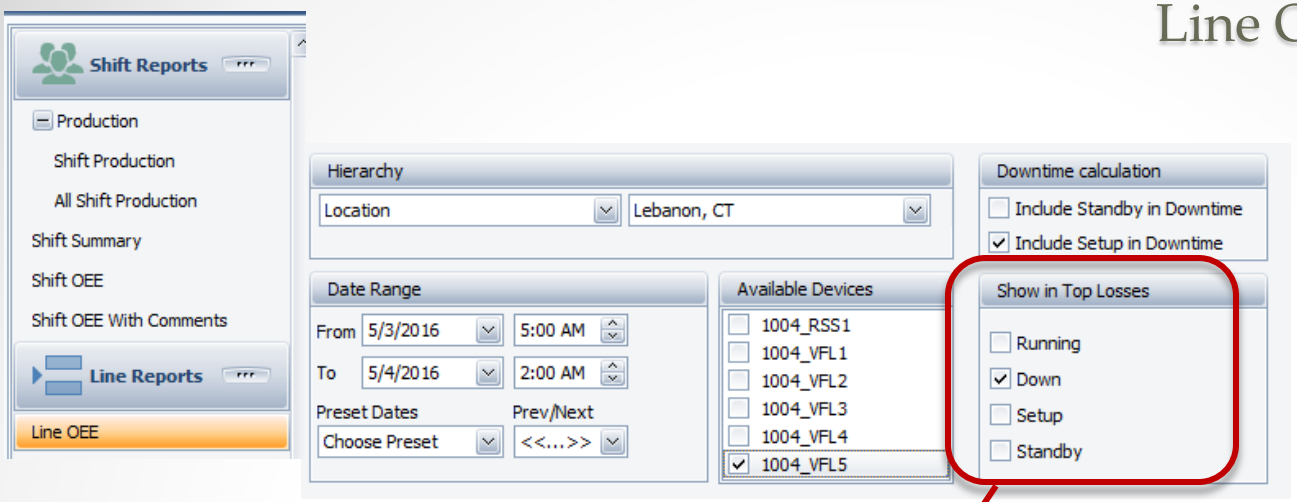
Select which types of losses to display on the report.

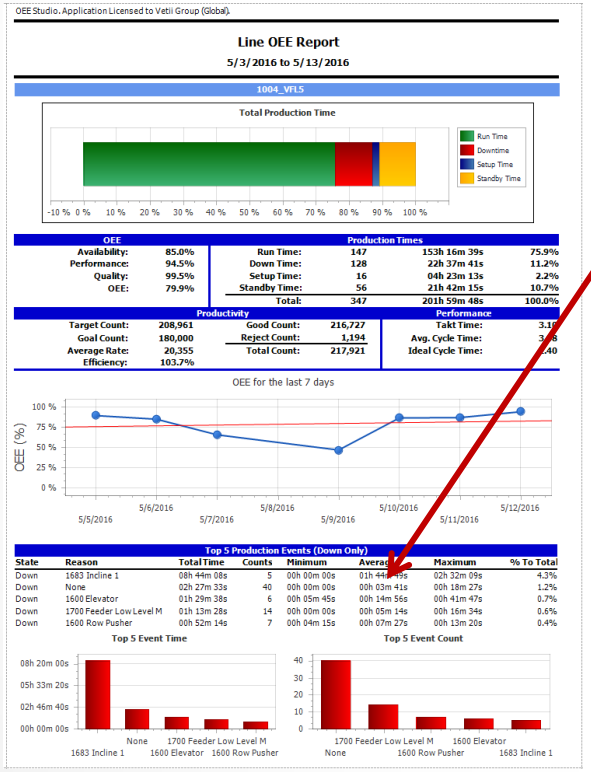


Provides a 1-page summary of each shifts, by line for each date in the given date range.

This report will also display any **comments** that were added for any production events and the associated shift interval – through OEE Alert.

Line OEE Report

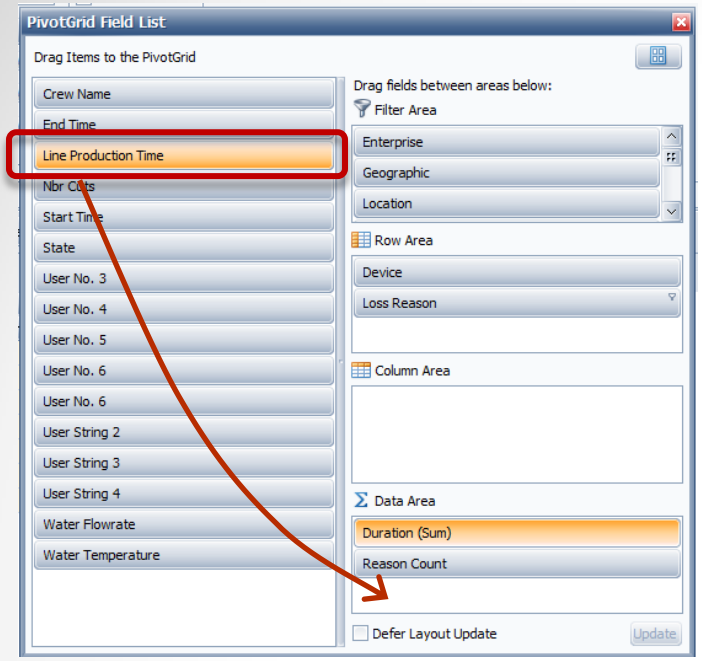


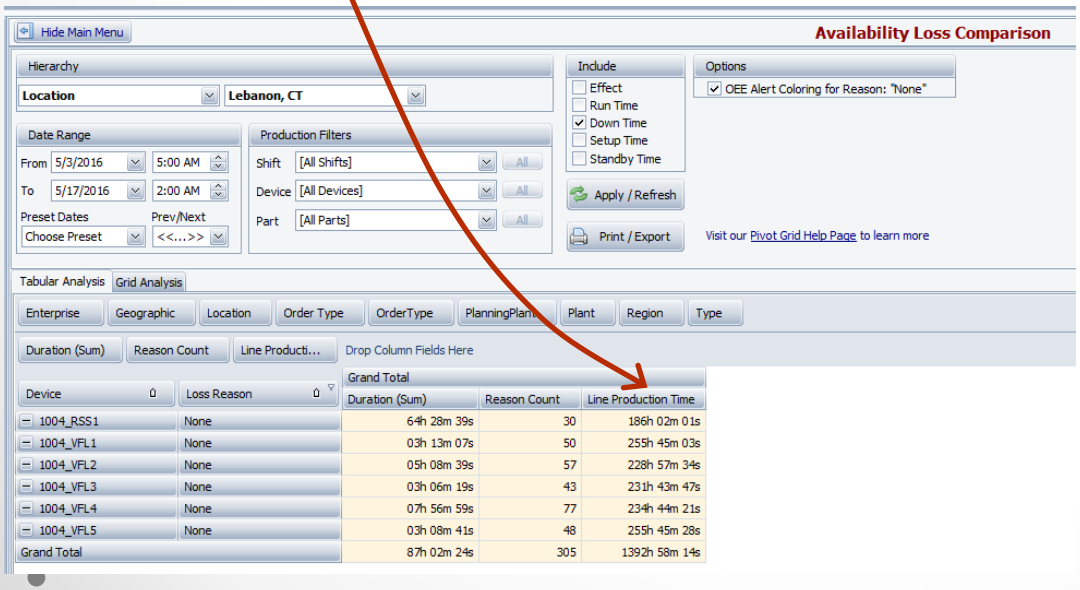


Select which types of losses to display on the report.

Provides a 1-page summary of each selected line for the selected date range.

Analyze Loss Percentage to Total Production Time





Let's say we wanted to see the percentage of Loss Reason 'None' to total Production Time by Line. **Total Production Time** includes all Run, Down, Setup and Standby Time.

There is a new data element called '**Line Production Time**'.

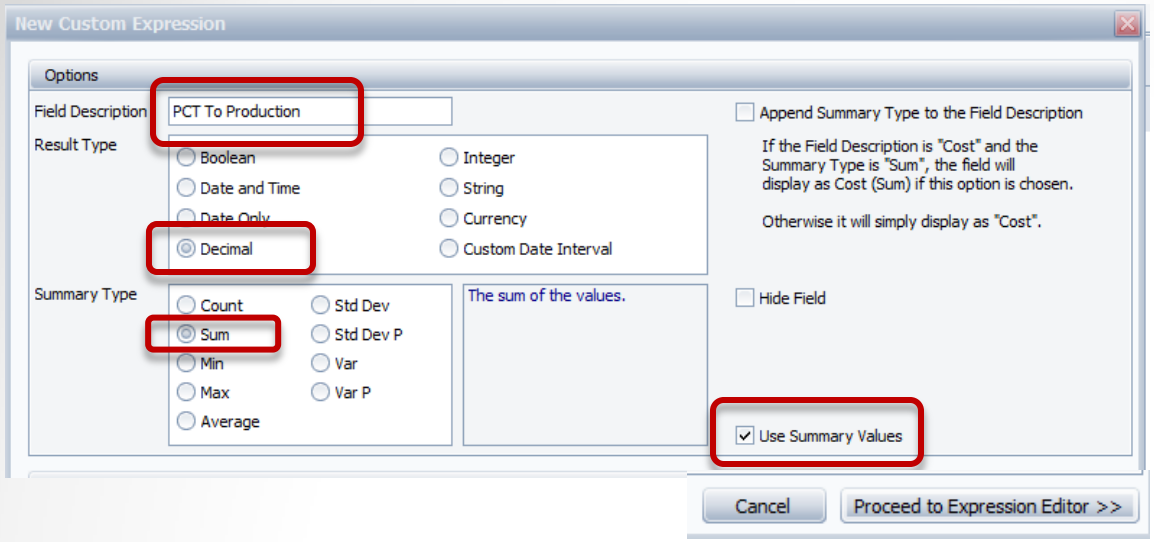
This data element will display the amount of production time that was available for the line, for the **date range** selected.

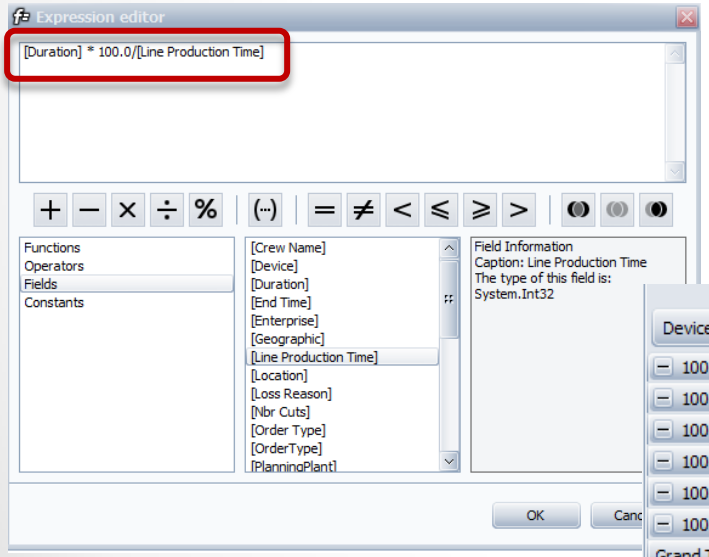
Drag the data element to the **Data Area** of the Field List.

Analyze Loss Percentage to Total Production Time

We then filter the screen to display only the ‘None’ Reasons.

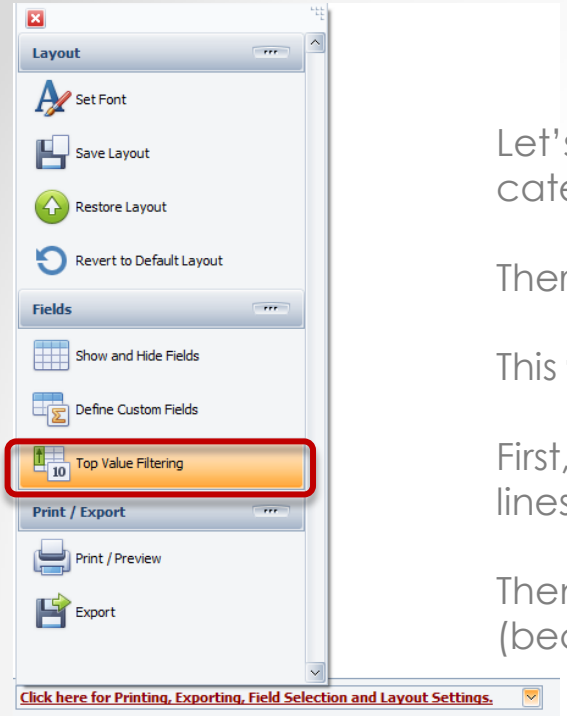
Next we create a custom field to calculate the Percentage of the loss to total production time.





Device	Loss Reason	Grand Total Duration (Sum)	Grand Total Reason Count	Grand Total Line Production Time	Grand Total PCT To Production
1004_RSS1	None	64h 28m 39s	30	186h 02m 01s	34.66
1004_VFL1	None	03h 13m 07s	50	255h 45m 03s	1.26
1004_VFL2	None	05h 08m 39s	57	228h 57m 34s	2.25
1004_VFL3	None	03h 06m 19s	43	231h 43m 47s	1.34
1004_VFL4	None	07h 56m 59s	77	234h 44m 21s	3.39
1004_VFL5	None	03h 08m 41s	48	255h 45m 28s	1.23
Grand Total		87h 02m 24s	305	1392h 58m 14s	6.25

Finding the Top ‘x’ Values



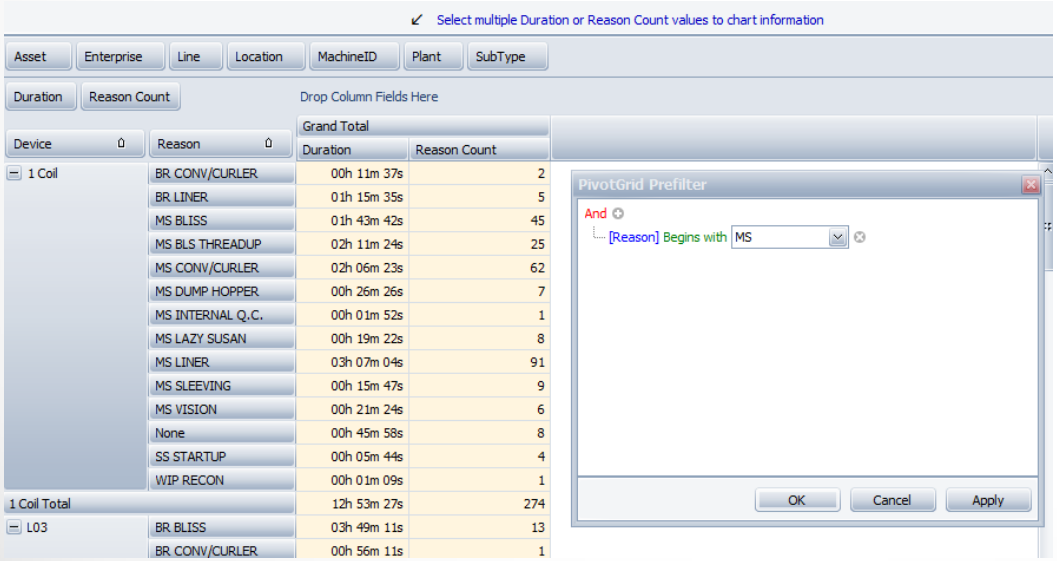
Let’s say we want to find the Top 3 downtime reasons for a specific category of downtime, by line.

There is a new **function** called **Top Value Filtering**.

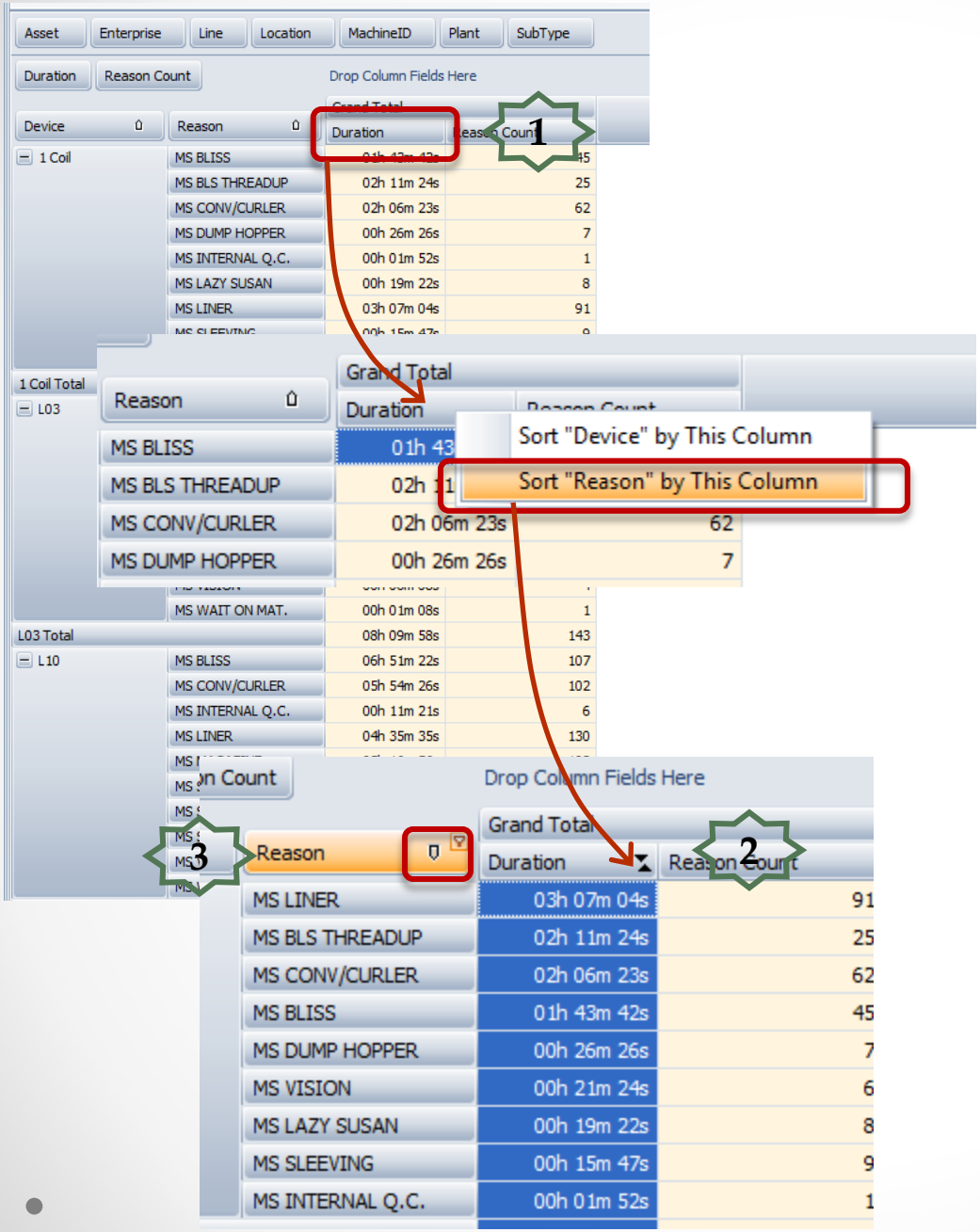
This **function** is available in the any of the pivot grids.

First, we are going to display the list of Down Time reasons for all of our lines.

Then we are going to filter for those reasons that begin with MS (because we use reason codes responsibly ~ [Click Here to learn more]



Finding the Top ‘x’ Values



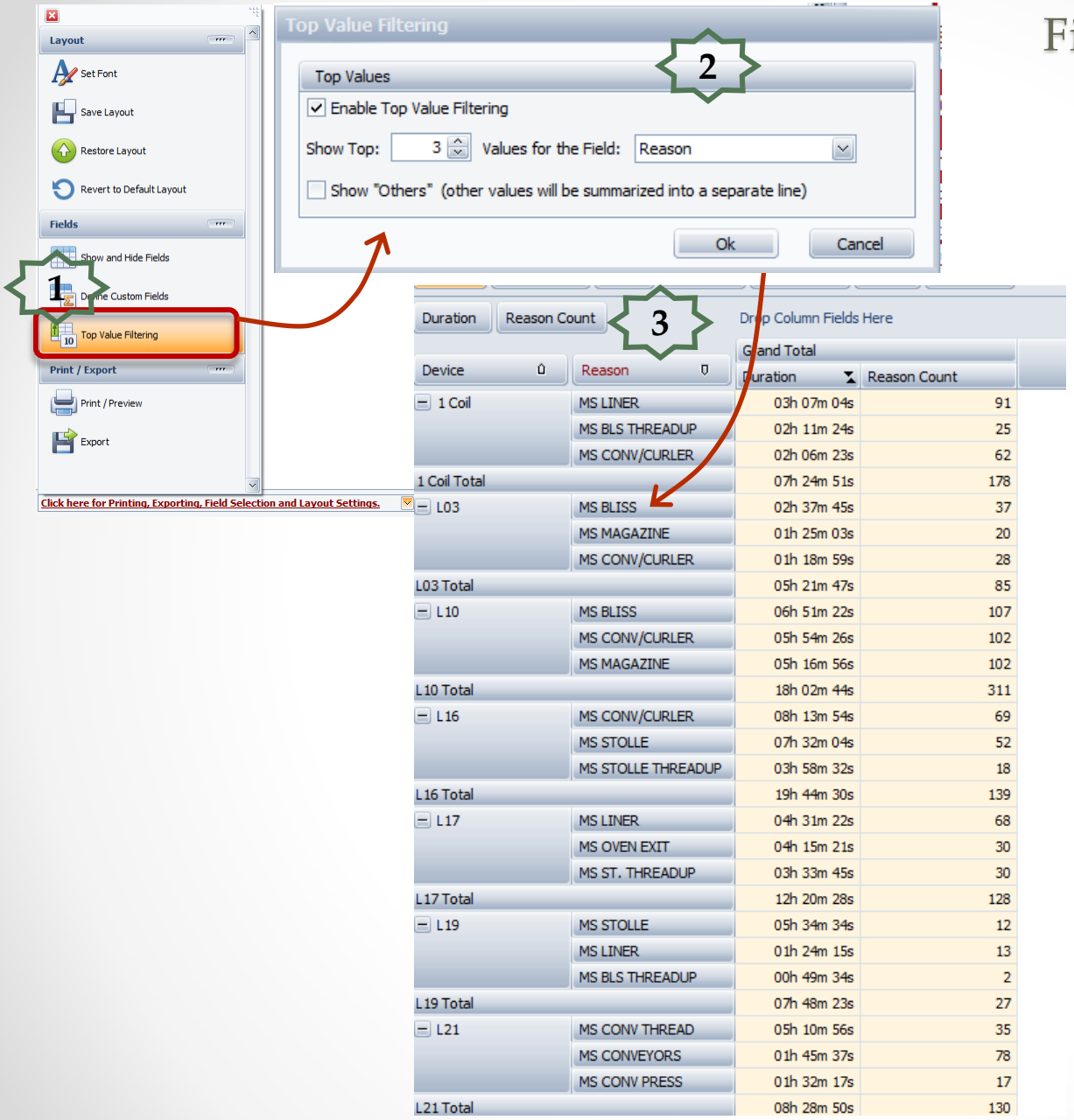
Next, we need to sort the durations largest to smallest.

1. Right-mouse click on the **Duration** Column and select Sort “***Reason” by This Column***”.

2. It will display the up/down arrows to indicate sorting.

3. Next, click on the arrow on the **Reason** column heading to sort highest to lowest durations.

Finding the Top 'x' Values

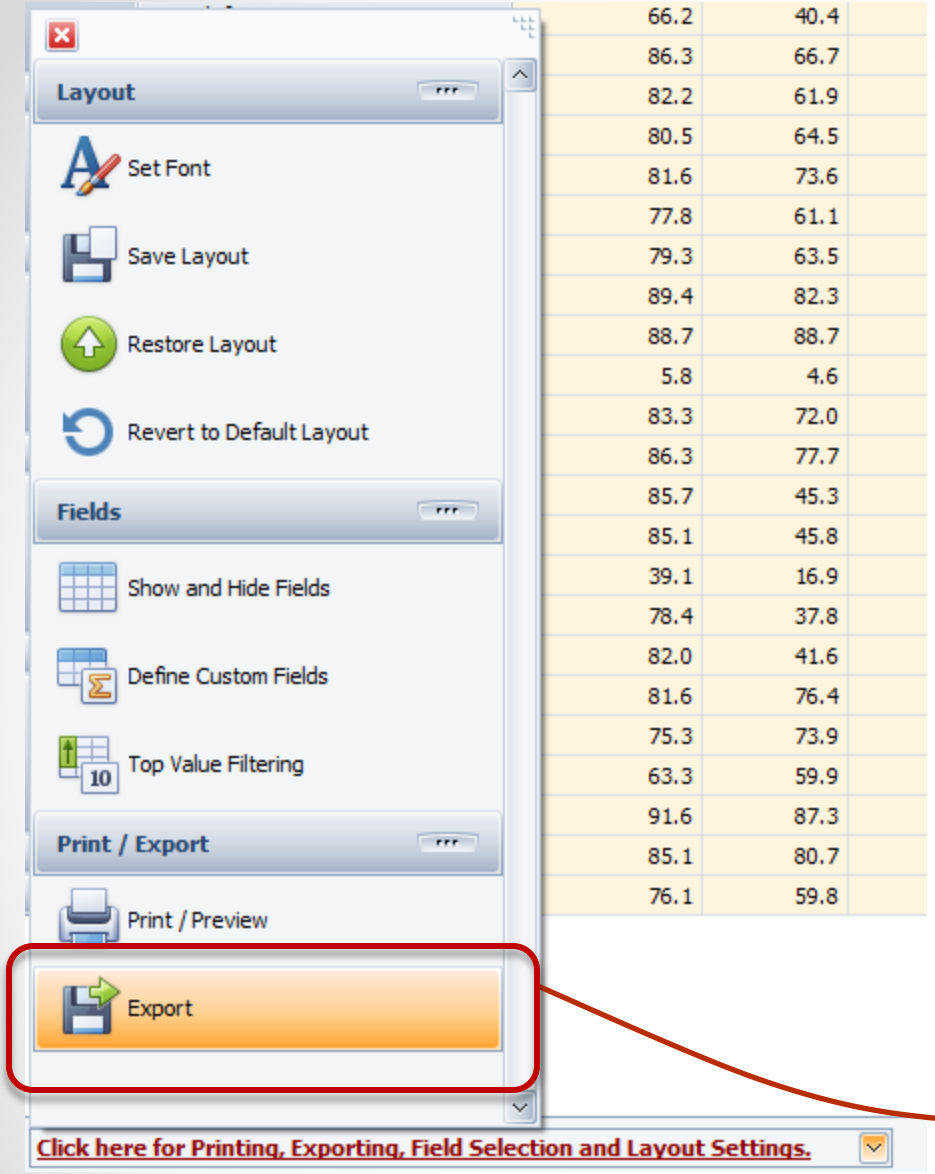


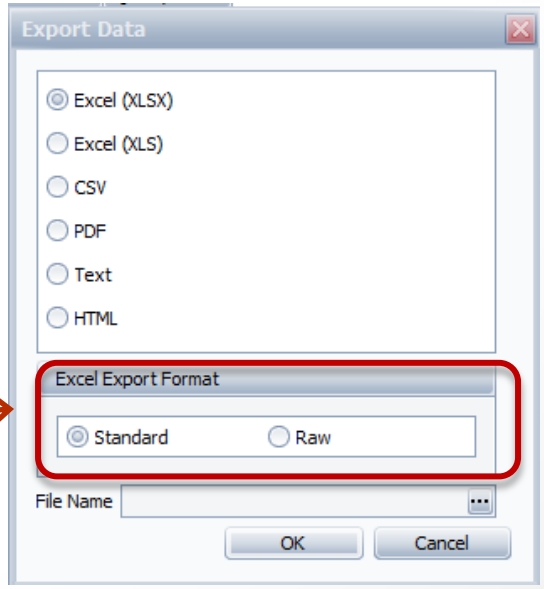
1. Choose '**Top Value Filtering**' menu option.
2. Select what you want to filter and click 'OK' button.
3. Now you have the Top 3 losses that begin with 'MS' for each line.

Excel Export – Raw Format

To Export raw data to MS Excel select the **Export** option from the '***Click here for Printing, Exporting, Field Selection and Layout Settings***' drop-down.

Selecting the Raw option will allow you to export the data without cell merge, report headers or footers, etc. to MS Excel.





OEE Studio v 3.5

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 3.5 of OEE Studio supports all versions of Vorne XL device v1.x 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, ERP integration, or custom reports)
Debbie.olk@debtechsystems.com
or
Jim Sulzer (XL Bolt-On Data Collector).
jim@sulzerconsulting.com

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)

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

Vetii | GROUP