

# OEEStudio

## Using Reason Codes Responsibly

This Tool-Tip will guide you through some ideas for creating Reason codes in the Vorne XLv1™ for reporting purposes.

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# Smart Reason Codes

- The most common method of capturing reasons for production events is through the use of **Reason Codes** in the Vorne XLv1™ device.
- For **Downtime** Reasons, it is a good idea to code your downtime reasons in the Vorne XLv1 by the type of breakdown – i.e. BR = breakdown, MS = Minor Stop, QA = Quality and so on. Then in the BR category, you can add another type such as BR MECH or BR ELEC and so on. Or you can add the asset that caused the failure – such as BR Capper, BR Labels, etc.
- **Keep it Simple, yet Smart!!** Keep in mind that reason codes can be up to 24 characters. When displayed on the Vorne XLv1 scoreboard, only the first 16 characters are displayed.
- The following pages will provide examples of what other customers have done for their **Smart Reason Codes**.

# Defining Reason Codes

- When you are getting ready to develop your Reason Code list, sit back and take a look at the **TYPES** of reasons that you have or want to have.
- What are they – Breakdown, Equipment, Quality, Mechanical, Setup, Manpower, Defect, Waiting, etc.
- Start by defining **CATEGORIES** of reason codes.
- Then start putting actual reason codes within those categories.
- You should start to see a pattern and could probably reduce the number of codes or use them more in a **Smart** way.

# Category Examples

- Some examples of categories could be:

<b>Reason Category</b>	<b>Possible Coding</b>	<b>Reason Category</b>	<b>Possible Coding</b>
Breakdown	BR, BK, BD	Standby	STB
Setup	SU	Changeover	CO
Planned	PL	Adjustment	ADJ
Minor Stop	MS	Quality	QA, QC
Short Stop	SS	Numbers (ERP)	1500, 5000, 1600
Lack of Personnel	LP	Maintenance	Maint, MT
Defect	DF	5S	5S
Waiting	WA	Equipment	EQ, EQP

# Breakdown

- Think about what types of Breakdowns there could be.
- Could other portions of the line cause a breakdown?
- Some examples of Breakdown could be:

Reason Code	Reason Code
BR Seamer Action	BK-Filler
BR Seamer Discharge	BK-Printer
BR Palletizer	BK-Case Packer
BR Support Packaging	BK-Chiller
BR Convey Elevator	BK-Chiller Jam
BR Convey Overhead	BK-Chiller Push Arm
MS Winder	BK-Capper
MS Winder Ballup	BK-Taper
MS Smart Saw	BK-Line Plug Tank

# Setup ~ Changeover

- Think about what tasks happen when you **Changeover** a product or **Setup** the line for a new product.
- Some examples of Setup or Changeover could be:

Reason Code
SU-Tools In
SU-Tools Out
SU-First Good
SU-Coil Change
CO-Height
CO-New Product
CO-Clean In Place
CO-Same Product

# Numbers

- Some examples of Numbers which correlate to your ERP system could be:

Reason Code
1220 Preventive Maint
1600 Palletizer
1600 Pallet Dispenser
1600 Elevator
1600 Row Pusher
1600 Case Packer
2100 Conveyor
1540 Bag Coder
0150 Lunch
0160 Break

# Using Smart Codes in OEE Studio

Now that you have created your Smart Reason Codes and are using them, you can filter your reports by the Smart Code.

👍 Would you like some help with defining your Smart Codes?

Please feel free to send us an email or call!

