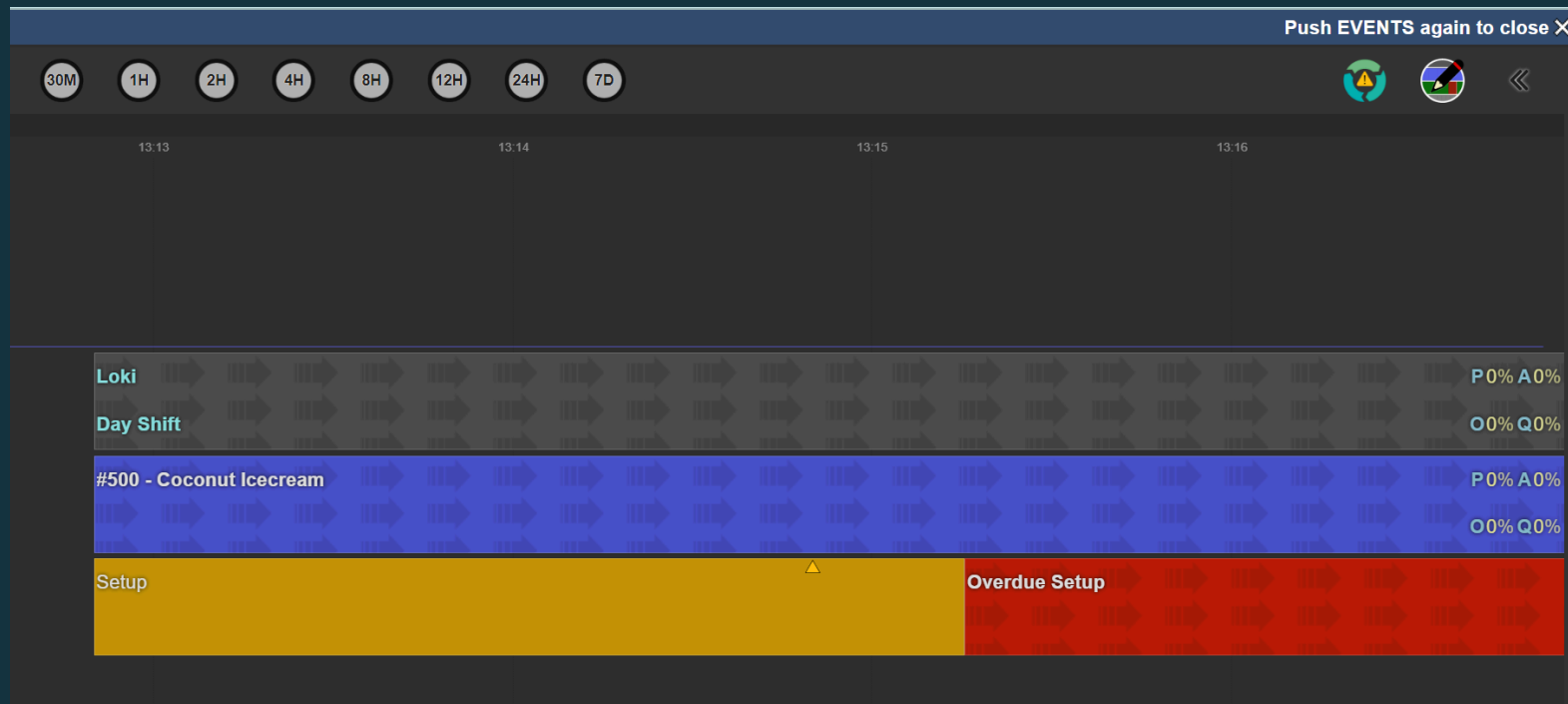


Setup Expiry

The 'Setup Expiry' solution allows you to track when a job 'Setup' exceeds a set target time. Within OFS, this can easily be achieved by using a mix of existing tools in Fusion Manager, such as the Reasons list and the API web services.

Once a setup time has expired, OFS automatically transitions to a predefined unplanned downtime reason.



What should I consider when using the Setup expiry feature?

What the Setup expires to:

- A predefined Unplanned Downtime reason? or,
- To an 'Unallocated' downtime?

Conditions:

- When does the expiry occur, e.g. offset 30 mins from the start of Setup

Note:

- *If a new shift or job is started during a setup, the counter will reset.*
- *When OFS transitions out of setup into another downtime or running, the counter will also reset.*

Configuration 1. Create the Downtime Reason

Create the Unplanned Downtime reason in your Reason List in Fusion Manager.

In this example, we will create an 'Overdue Setup' unplanned downtime.

Ensure you select 'Setup' in the group.

The screenshot shows the 'Manage Reasons' interface. The left sidebar lists categories: Tray Packer (12), Stacking (12), Packer (3), Labeller (3), Applicator (3), Planned Activities (2), and Setup Expiry (1). The 'Setup Expiry' category is selected. The main area shows the 'Edit Reason' form for 'Setup Expiry'. The table below has columns: Name, Downtime Type, and Group. The row for 'Overdue Setup' is highlighted with a red box, showing 'Unplanned' as the Downtime Type and 'Downtime, Setup' as the Group.

Name	Downtime Type	Group
Overdue Setup	Unplanned	Downtime, Setup

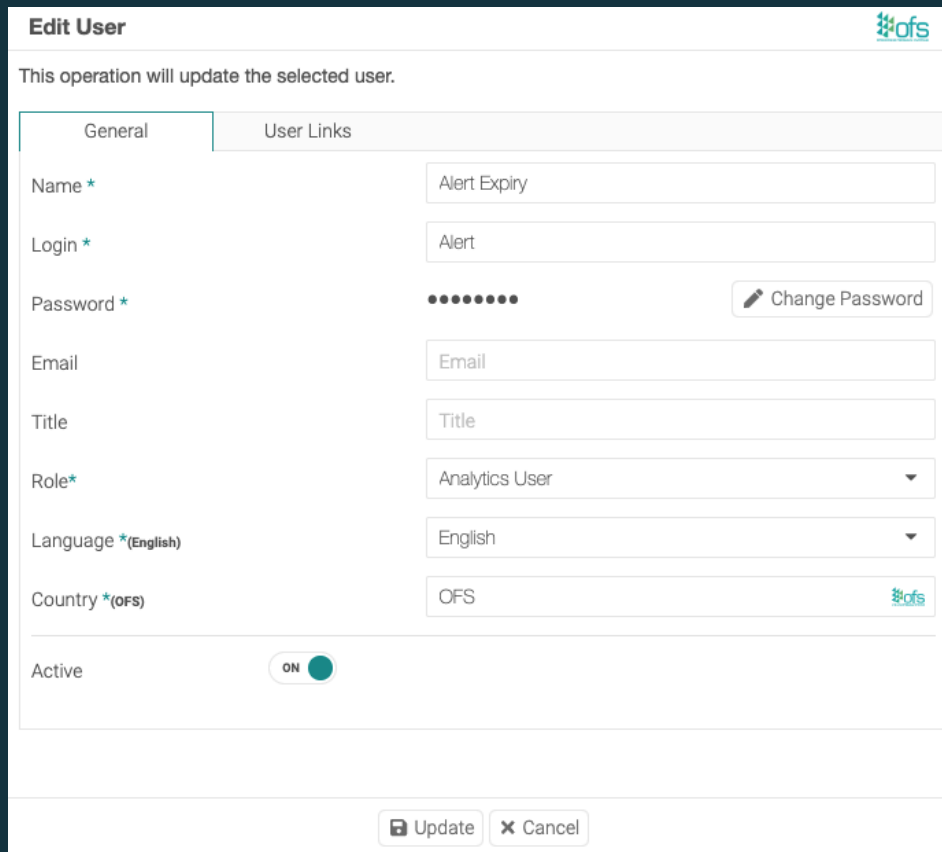
Remember to assign your new reason to a line in 'Reasons Assignment'!


Configuration 2. Create a new user

Create a new, dedicated user in Fusion Manager with 'Analytics User' permissions

2a) Navigate to the 'Users & Operators' tab

2b) Create a Name, Login, and Password. Then, set the Role as an 'Analytics User'



Edit User 

This operation will update the selected user.

General | User Links

Name *

Login *


Password *

Email

Title

Role*

Language *(English)

Country *(OFS) 

Active

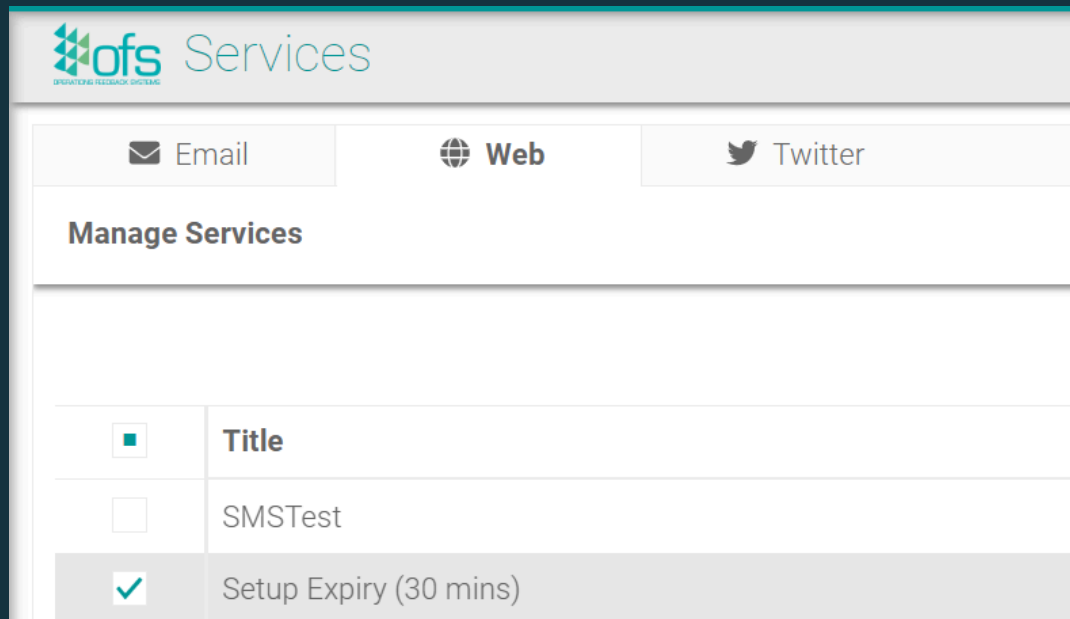
Configuration 3. Create a Web 'Service'

NOTE: You will need one WEB service per Unplanned Downtime reason.

3a) Navigate to the 'Services' tab

3b) Click 'Web'

3c) Create a new Alert e.g. Setup Expiry (30mins)



The screenshot shows the 'ofs Services' interface. At the top, there is a header with the 'ofs' logo and the text 'Services'. Below the header, there are three tabs: 'Email', 'Web', and 'Twitter'. The 'Web' tab is selected. Underneath the tabs, there is a section titled 'Manage Services'. Below this section, there is a table with the following content:


<input type="checkbox"/>	Title
<input type="checkbox"/>	SMSTest
<input checked="" type="checkbox"/>	Setup Expiry (30 mins)


3d) In the URL, enter the following with your OFS information:


`https://customer.ofsexpress.com/WorkcentreID/server/control/downtime/allocate/@reasoncode`

- **Customer** is the name of your organisation
- If your OFS is on a server, you will instead replace the **customer.ofsexpress.com** with the IP address.

Example: `http://10.123.456.78/WorkcentreID/server/control/downtime/allocate/@reasoncode`

Update Service 


Title * Type  Web



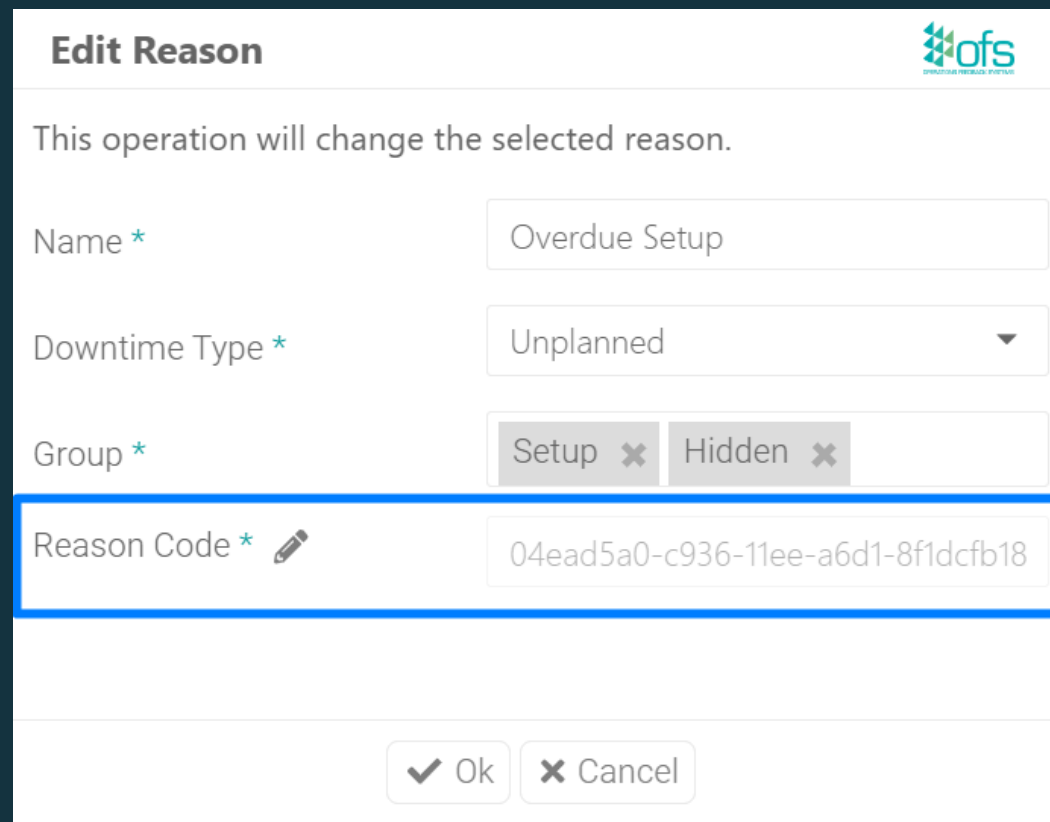
Connection Authentication Schedule


URL *

HTTP Method

Web Parameter* Value 

- **WorkcentreID** is the OFS Line identifier e.g. OFS001.
 - Please find this unique identifier in Fusion Manager or on the console page URL.
 - For multiple lines, use {{workcentre}} instead of the workcentreID.
- **Reason Code** is found in the unplanned reason created in config 1.




Edit Reason 

This operation will change the selected reason.

Name *


Downtime Type *


Group *


Reason Code * 

3e) On the 'Authentication' tab, enter the details from the newly created 'Alerts' account.

The screenshot shows the 'Update Service' configuration page for an alert service. The page has a header with the title 'Update Service' and the 'ofs' logo. Below the header, there is a 'Title *' field containing 'Alert Expiry - CIP (45mins)' and a 'Type' dropdown menu set to 'Web'. A 'Update & Test' button is located below the title field. The main content area is divided into three tabs: 'Connection', 'Authentication', and 'Schedule'. The 'Authentication' tab is currently selected. Under the 'Authentication' tab, there are two toggle switches: 'Basic Auth' (set to 'ON') and 'Pre-emptive Auth' (set to 'OFF'). Below these toggles, there are three input fields: 'User Name' containing 'Alert', 'Password' (masked with dots), and an empty field. At the bottom of the page, there are two buttons: 'Update' and 'Cancel'.

Update Service 

Title * Type  Web



 Update & Test

Connection Authentication Schedule

Basic Auth ON Pre-emptive Auth OFF

User Name

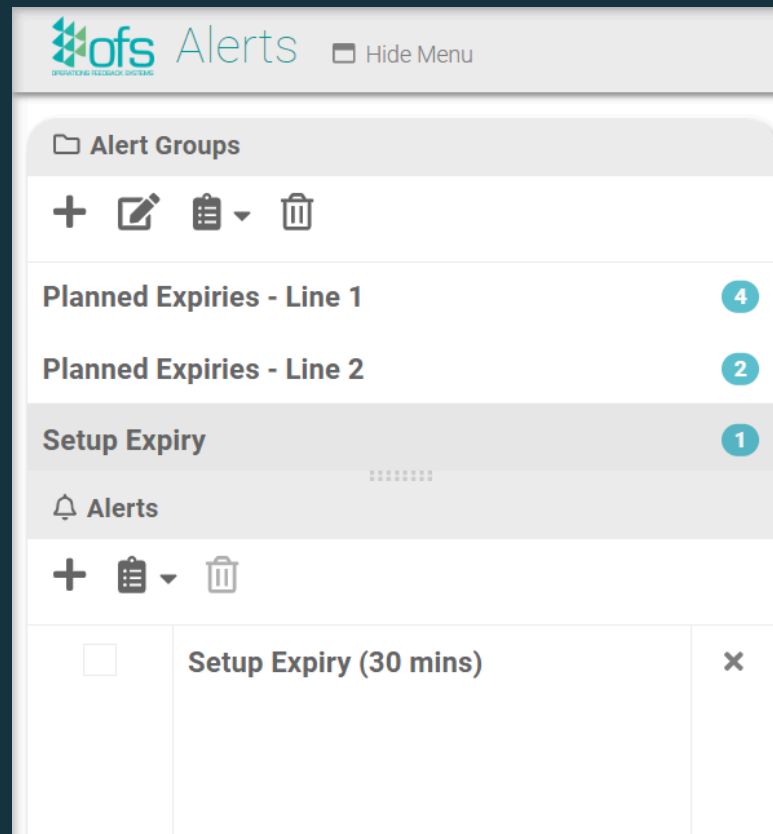
Password

 Update  Cancel

Configuration 4. Create a new Alert

Create a new 'Alert' in the 'Alerts & Flow' tab in Fusion Manager. We strongly suggest creating dedicated 'Alert Groups' to group your Planned Activity Overtime 'Alerts', in a way that makes sense for your OFS setup.

Additionally, make sure the Groups and Alerts are descriptive.



a) In Machine State, tick 'Setup'

b) Toggle on 'Group Adjacent Spans within Jobs'

c) Toggle on 'Offset' and enter in target time.
Set the Units e.g. minutes

d) Select the Lines

e) Select the 'Service'

The screenshot shows the 'Update Machine State Trigger' configuration window. The title bar includes the 'ofs' logo. Below the title, a message states: 'This operation will modify the selected Machine State Trigger.' The main configuration area is titled 'Setup : After 30 minutes : 1 service : (1 line)'. It features a 'General' tab and a 'Conditional Expression' toggle set to 'OFF'. Under 'Machine State', the 'Setup' option is selected with a checkmark. To the right, the 'Group Adjacent Spans within Jobs' toggle is turned 'ON'. Below this, the 'Offset' toggle is also turned 'ON', with a text input field containing '30' and a dropdown menu set to 'minutes'. At the bottom, the 'Lines' section contains 'Filling Line' and the 'Services' section contains 'Setup Expiry (30 mins)'. At the very bottom, there are 'Update' and 'Cancel' buttons.

In our example, the service 'Setup Expiry (30 mins)' will be activated after Setup has surpassed 30 minutes.

Use Case

While this feature can be used for Setup overtime, Planned Downtime can also be tracked during the JOB. Thus, tracking Planned Activity Overtime. This document can be found in our Customer Portal.

Questions or issues?

Please reach out to us at support@ofsystems.com