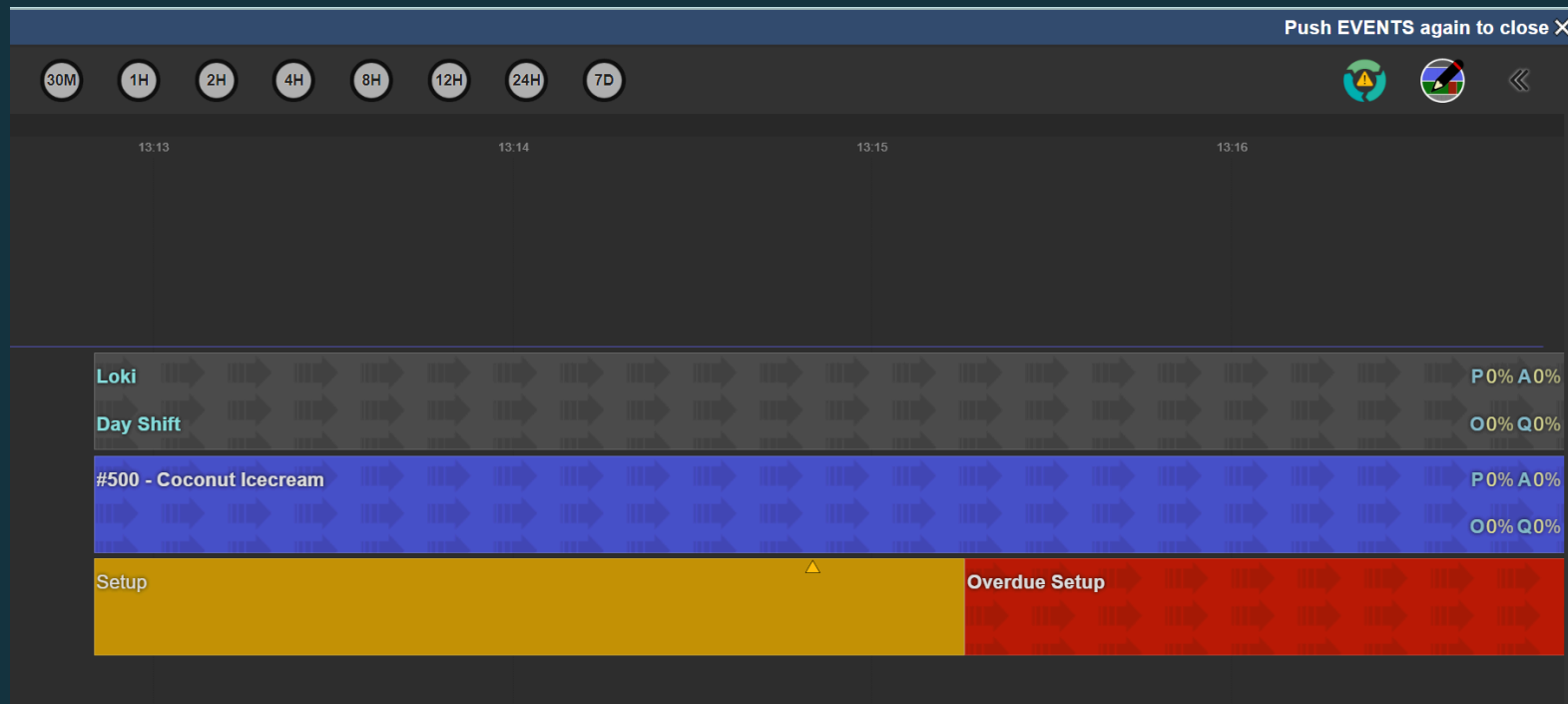


Setup Expiry

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

1a) Create the Unplanned Downtime reason in your Reason List in Fusion Manager.

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

1b) Ensure you select 'Setup' in the group.

The screenshot displays the 'Manage Reasons' interface. On the left, under 'Categories & Reasons', the 'Setup Expiry' category is selected and highlighted with a red box. The main area shows the 'Edit Reason' form for 'Overdue Setup', which is also highlighted with a red box. The 'Downtime Type' is 'Unplanned' and the 'Group' is 'Downtime, Setup'.

Name	Downtime Type	Group
Overdue Setup	Unplanned	Downtime, Setup

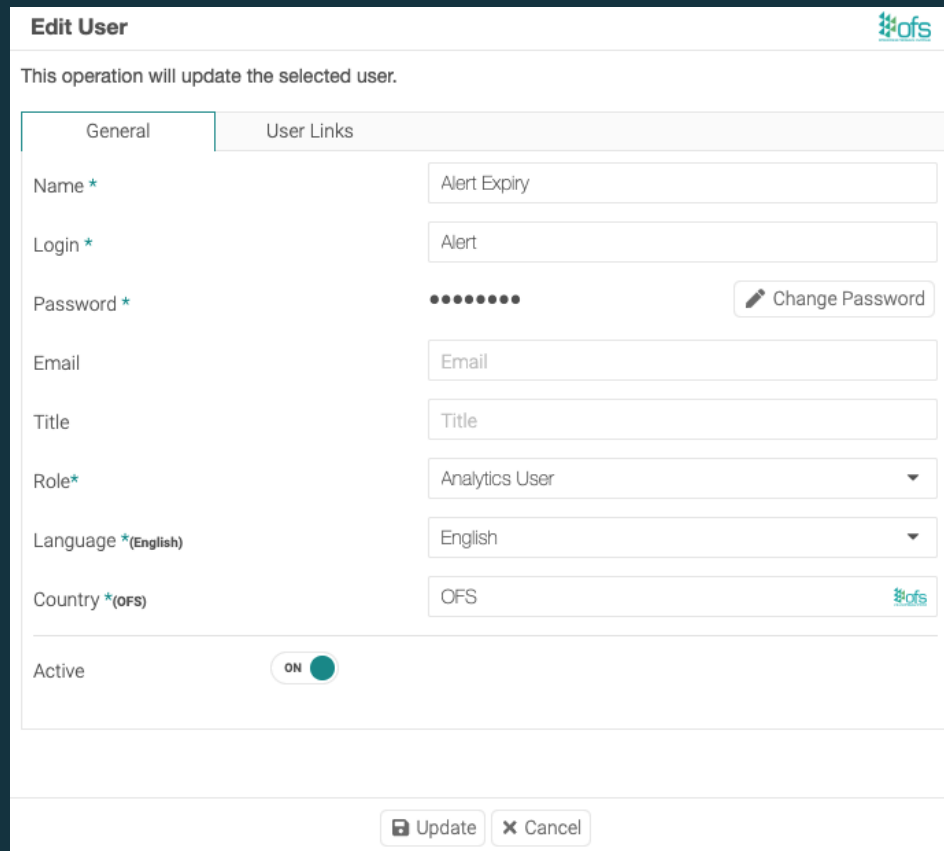
1c) Assign your new reason to a line in 'Reasons Assignment'


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 * [Change Password](#)

Email

Title

Role*

Language *(English)

Country *(ofs) 

Active ☒

[Update](#) [Cancel](#)

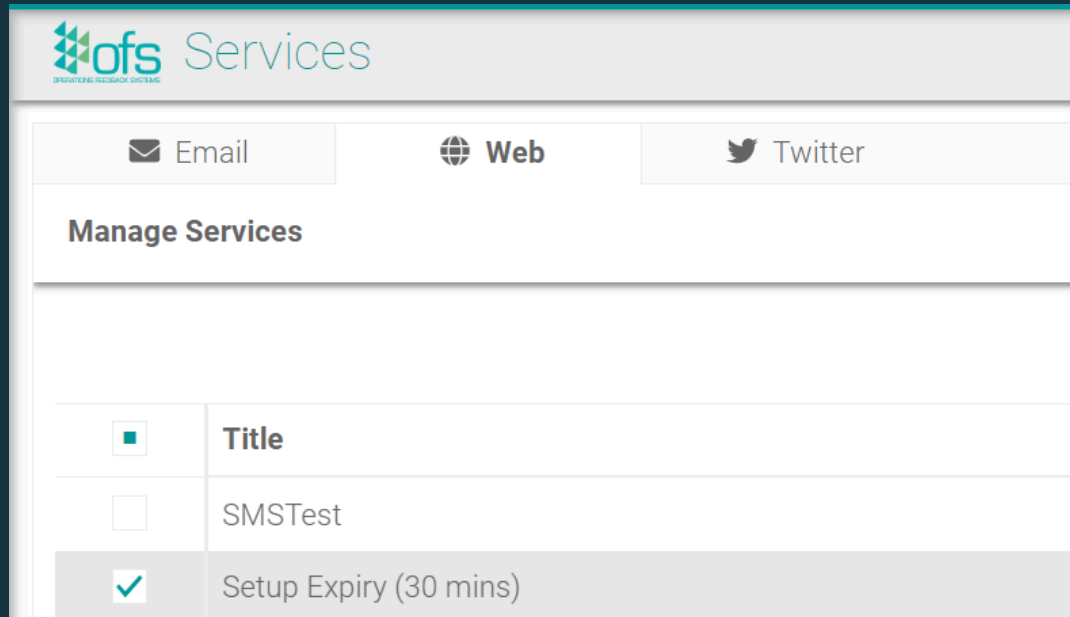
Configuration 3. Create a Web 'Service'

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's a header with the 'ofs' logo and the word 'Services'. Below the header, there are three tabs: 'Email', 'Web', and 'Twitter'. The 'Web' tab is currently selected. Under the 'Web' tab, there's a section titled 'Manage Services'. Below this, there's a table with two columns: a checkbox column and a 'Title' column. The table contains three rows: a header row, a row for 'SMSTest' with an unchecked checkbox, and a row for 'Setup Expiry (30 mins)' with a checked checkbox.

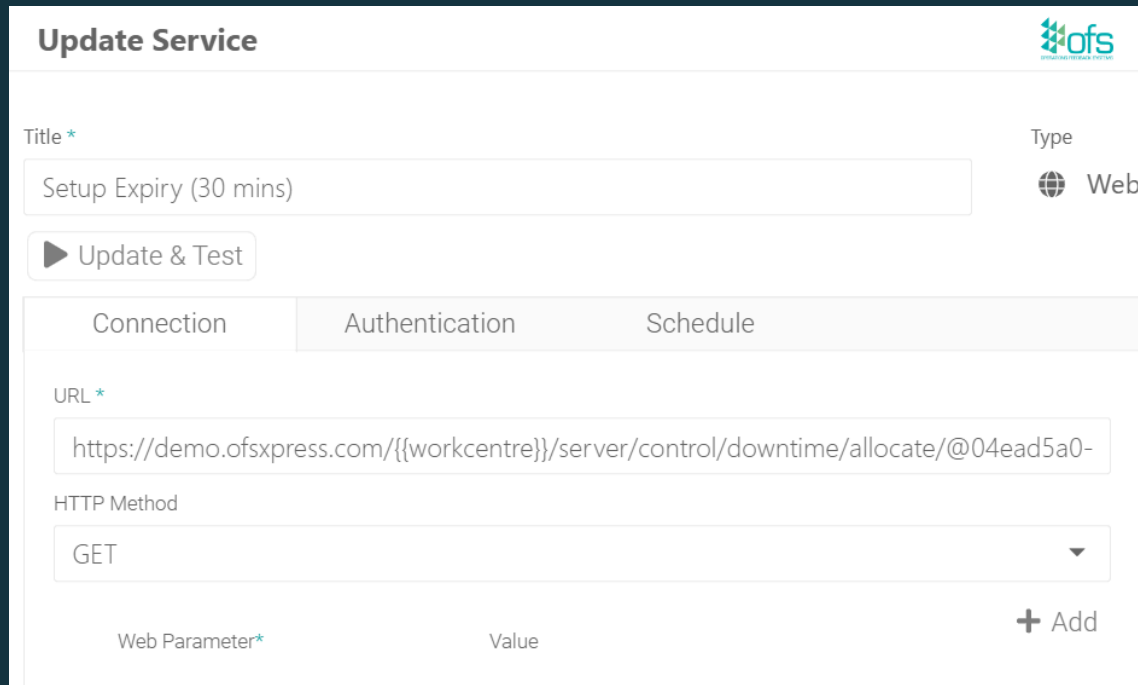
	Title
<input type="checkbox"/>	SMSTest
<input checked="" type="checkbox"/>	Setup Expiry (30 mins)

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

`https://customer.ofsxpess.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.ofsxpess.com** with the IP address.

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




The screenshot shows a web interface titled "Update Service" with the OFS logo in the top right corner. The interface includes a "Title" field with the value "Setup Expiry (30 mins)" and a "Type" dropdown set to "Web". Below these is an "Update & Test" button. A tabbed interface shows three tabs: "Connection", "Authentication", and "Schedule". The "Connection" tab is active, displaying a "URL" field with the value `https://demo.ofsxpess.com/{{workcentre}}/server/control/downtime/allocate/@04ead5a0-` and an "HTTP Method" dropdown set to "GET". At the bottom, there is a table for "Web Parameter" and "Value" with an "Add" button.

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.


Update Service



Title *

Alert Expiry - CIP (45mins)

Type

 Web


▶ Update & Test

Connection


Authentication

Schedule

Basic Auth

ON 

Pre-emptive Auth


 OFF


User Name

Alert

Password

.....

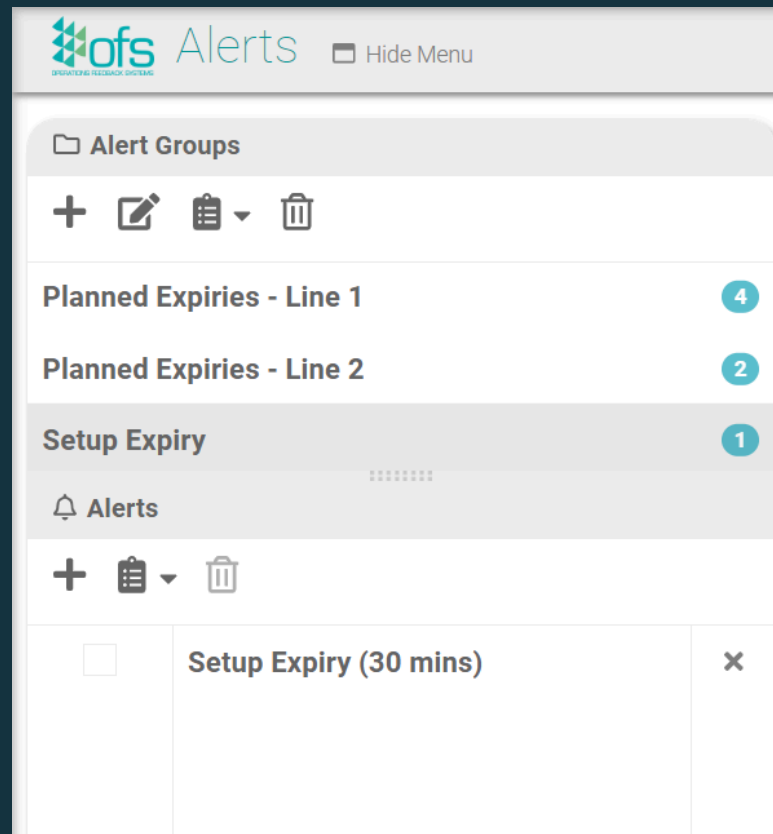
 Update

 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.



Configuration 5. Create the Trigger

Create a new trigger in the 'Machine State' trigger:


Setup Expiry (30 mins) ✕

General

Workflow

Form

Triggers

Edit Triggers  Hide Menu

Total Time Or Count

0

Job

0

Shift

0

Machine State

1

Relay

0

Edit Machine State Trigger

Machine St...

Licence

Group Adjacent Spans within J...


Reason or Categ...

On St...

On E...

Conditio...

0



Setup : After 30 minutes : 1 service : (1 line)


Setup

✓

Licenced

✓

3



- 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'

Update Machine State Trigger

This operation will modify the selected Machine State Trigger.

Setup : After 30 minutes : 1 service : (1 line)

General Conditional Expression **OFF**

Machine State

- ☐ Running
- ☐ Running Slow
- ☒ Setup

☒ Group Adjacent Spans within Jobs

☒ On Start ☒ On End ☒ Offset

☒ Repeat Repeat Offset and Repeat Units 30 minutes

Lines Filling Line x

Services Setup Expiry (30 mins) x

Reason or Category **OFF**

Update Cancel

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