

DEFECTS TUTORIAL

Defect Groups [S2388]

Report Op/Defects [S3001]

Defect Results by WO [S3003]

Summary of Defect Quantity by Defect Group [S2520]

Summary of Rework Time by Defect Group [S2592]

ONRAMP
— SOLUTIONS —

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Introduction to Defects

The **Defects** tutorial will explain how to setup, report, and review information related to Defects.

'Defects' refer to any characteristics of a manufactured item which hinder its usability for the purpose for which it was designed and manufactured.

The following screens from the **Defects [N2656]** folder will be outlined in this tutorial:

- **Defect Groups [S2388]**
- **Summary of Defect Quantity by Defect Group [S2520]**
- **Summary of Rework Time by Defect Group [S2592]**

The Defect Groups [S2388] screen is used to set up Defect Groups.

The Summary of Defect Quantity by Defect Group [S2520] screen is used to view a Summary of Defect Quantity by Defect Group, allowing for Pareto Analysis of Reported Defects.

The Summary of Rework Time by Defect Group [S2592] screen is used to view a Summary of Rework Time by Defect Group, allowing for Pareto Analysis of Reported Defects.

We will also review the following screens from the **Work Order Reporting [N1206]** folder:

- **Report Op/Defects [S3001]**
- **Defect Results by WO [3003]**

The Report Op/Defects [S3001] screen is used to Report a Quality Assurance or Non-Quality Assurance Operation, and to Report Defects.

The Defect Results by WO [S1249] screen is used to view the Defects Reported in the Report Op/Defects [S3001] screen.



Defect Groups [S2388]

The **Defect Groups [S2388]** screen is used to set up Defect Groups and Codes.

Defect Groups

Defect Group:

*Defect Group:

Defect Codes:

Code	Description	Resolution	Example
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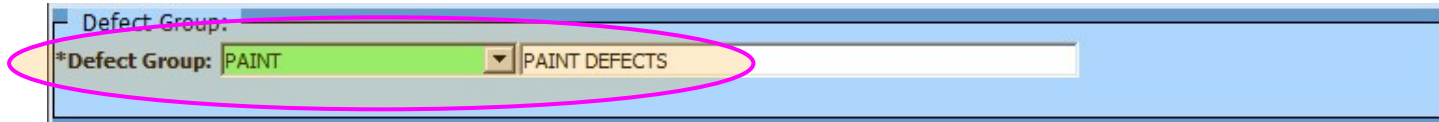
F1 for Help



Defect Groups [S2388]

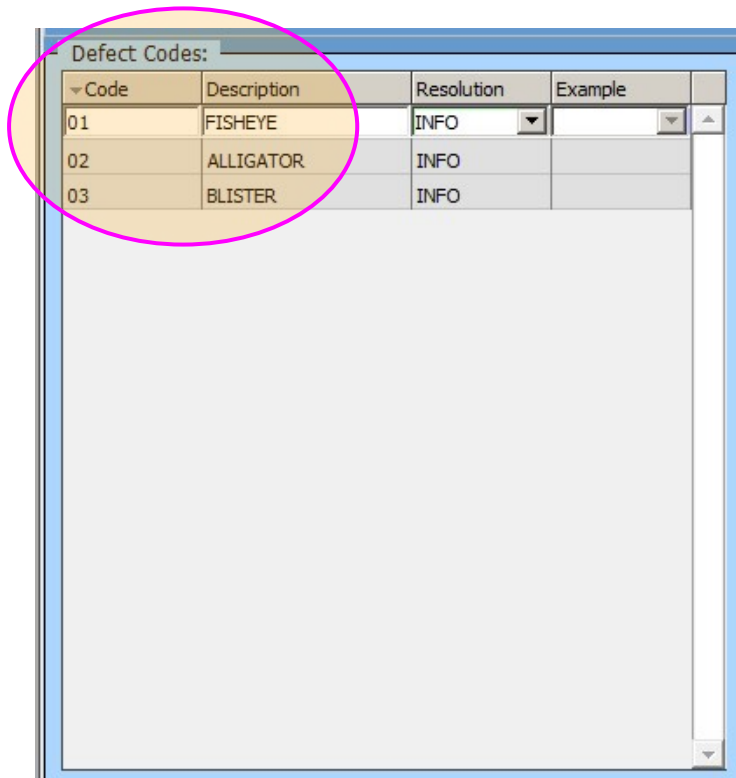
To set up a Defect Group:

1. In Add mode, enter the code that identifies the Defect Group in the **Defect Group** field. Enter a **Description** of the Defect Group in the adjacent field.



Defect Group: PAINT PAINT DEFECTS

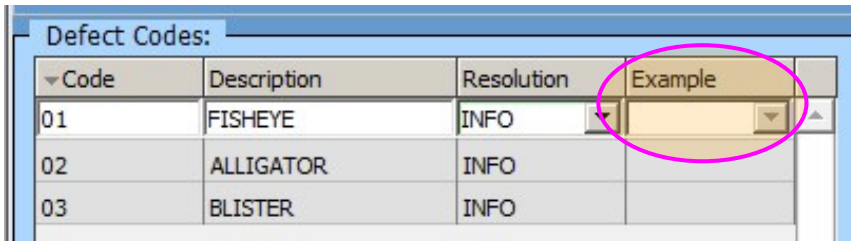
2. In the **Defect Codes** frame, Add the **Code** identifying the specific Defect, and a **Description** of that code.




Code	Description	Resolution	Example
01	FISHEYE	INFO	
02	ALLIGATOR	INFO	
03	BLISTER	INFO	

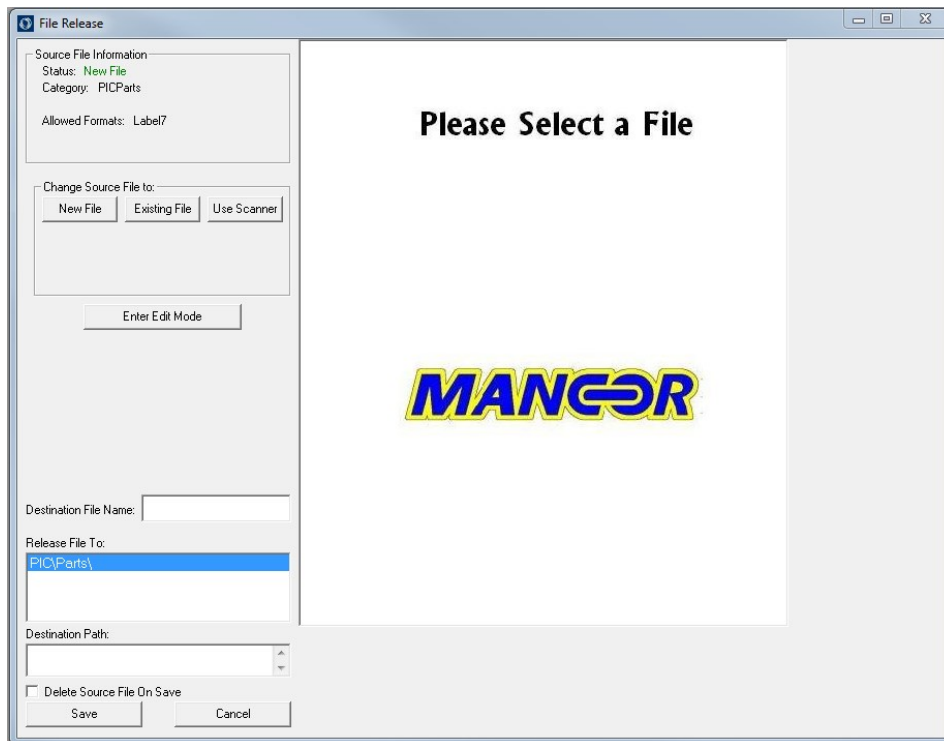
Defect Groups [S2388]

3. In **Edit** mode, click the file picker arrow to attach an **Example** image of this Defect.



Code	Description	Resolution	Example
01	FISHEYE	INFO	
02	ALLIGATOR	INFO	
03	BLISTER	INFO	

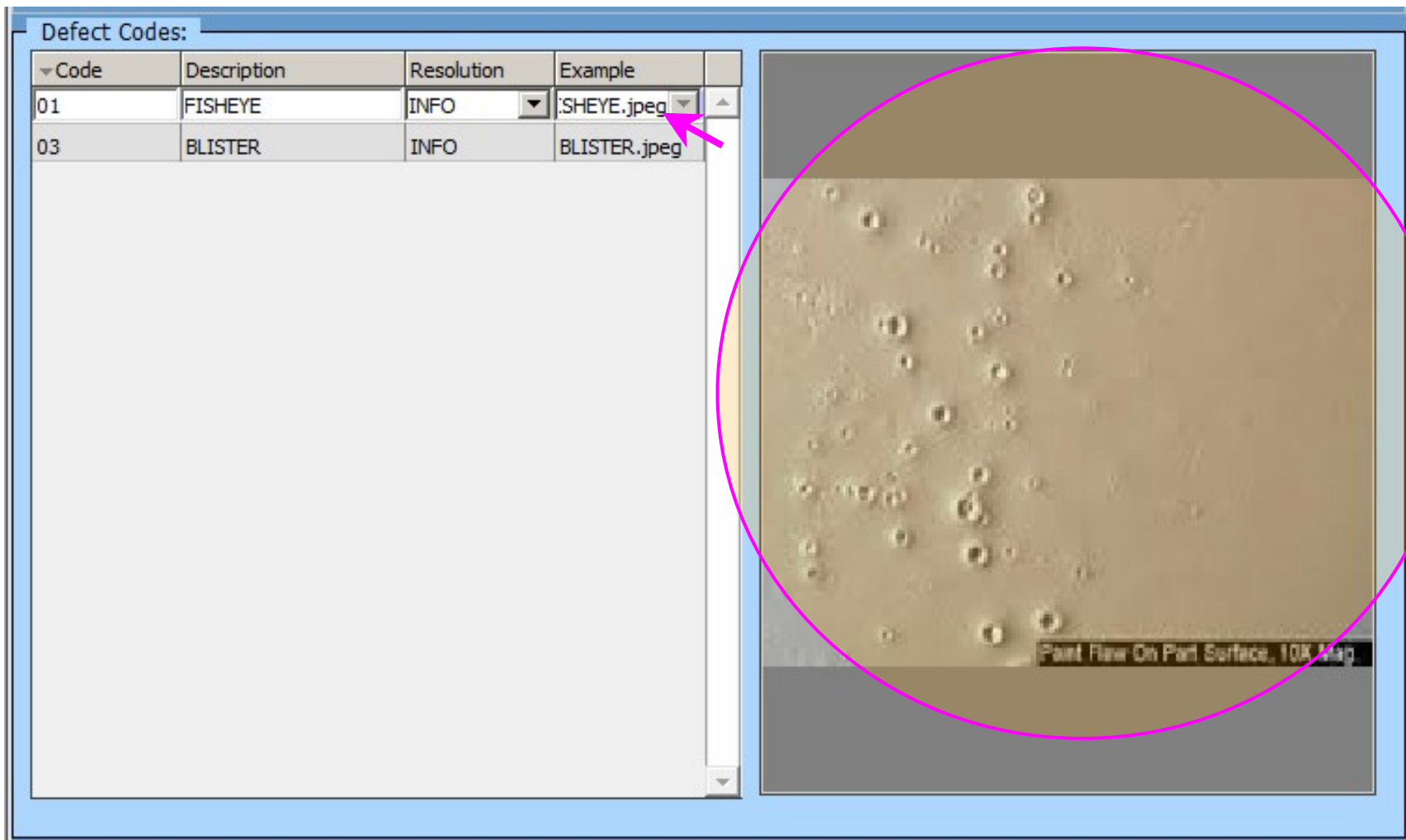
Note: This action will open the **File Release** screen. For more information on File Pickers and how to select a File, see the **OnRamp Basics - Screen Controls Tutorial**.



Defect Groups [S2388]

Note: The chosen Filename will appear in the **Example** field.

4. Double-click the **Example** field to view the file in a new window. An image of the selected Defect will now appear in box next to the Defect Codes grid.

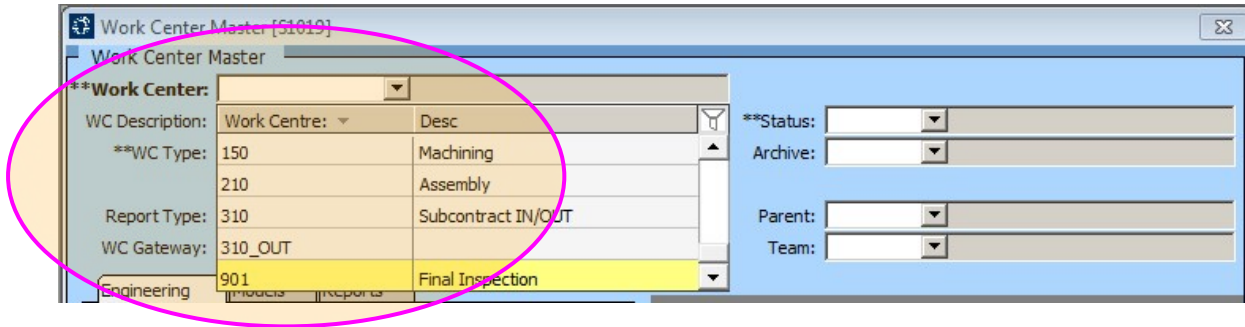


The screenshot displays a software interface with a table titled "Defect Codes:" and a large image viewer. The table has four columns: Code, Description, Resolution, and Example. The first row shows Code "01", Description "FISHEYE", Resolution "INFO", and Example "SHEYE.jpeg". The second row shows Code "03", Description "BLISTER", Resolution "INFO", and Example "BLISTER.jpeg". A pink arrow points to the "Example" field of the second row. To the right of the table is a large image viewer showing a close-up of a brown, textured surface with numerous small, circular defects. A pink circle highlights the image. At the bottom right of the image, there is a text overlay that reads "Paint Flaw On Part Surface, 10X Mag".

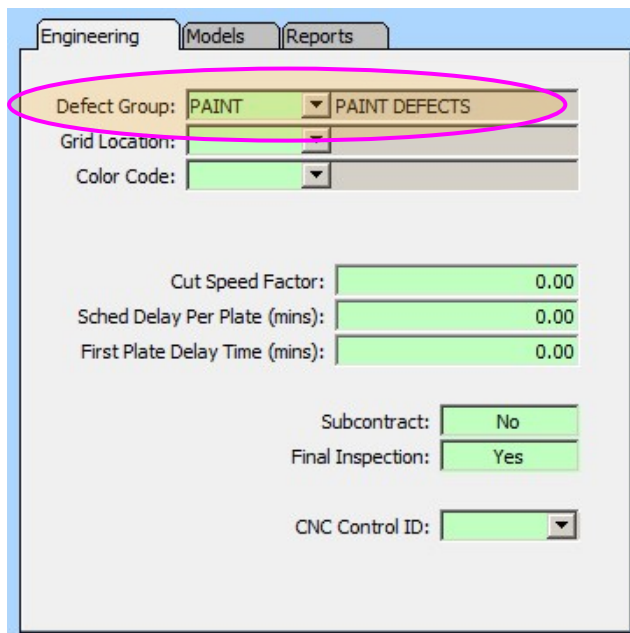
Code	Description	Resolution	Example
01	FISHEYE	INFO	SHEYE.jpeg
03	BLISTER	INFO	BLISTER.jpeg

Defect Groups [S2388]

5. Open the **Work Center Master [S1019]** screen. To set up the Defect Group you just created, select the related **Work Center** from the Combo Box.



6. In the **Engineering** tab, in Edit mode, select the **Defect Group** you just created. The Defect Group you have just created has now been set up on the Work Center Master [S1019] screen.



Report Op/Defects [S3001]

The **Report Op/Defects [S3001]** screen is used to Report a Quality Assurance or Non-Quality Assurance Operation, and to Report Defects.

Report Operation

Optional Barcode:

Oper:

Work Order:

Work Center:

WO Filename:

WC Defect Group:

Select Defect Group:

Qty Ord:

Qty Rep:

Qty Scrap:

Qty Rem:

Ttl Issued:

QA Inspect:

Nested:

Qty OK:

Comments:

Cell/Machine:

Shift:

Operator:

Report QA Operation

Report Non-QA Operation

Setup Defects Only

Defects

SUBMIT DEFECTS				
Code	Desc	Qty	Rework Mins.	Picture

ALREADY REPORTED		
Code	Qty	Rework Mins.

Comments:

Submit

F1 for Help Browse Edit Add Delete OK Cancel Print Exit



Report Op/Defects [S3001]

To Report the Operation OR to Report Defects:

1. Select the **Work Order** code.
2. Select the **Operation** ID code.
3. Select the **Work Center Defect Group**. In this case, the **PAINT** WC Defect Group has been selected.

The screenshot shows the 'Report Operation' form with the following fields and values:

- Optional Barcode: [Empty]
- Work Order: WO10012 (selected), A1001
- WO Filename: WO10012.pdf
- Qty Ord: 2
- Qty Rep: 2
- Qty Scrap: 0
- Qty Rem: 0
- Ttl Issued: 2
- QA Inspect: YES
- Nested: No
- Oper: 20 (selected), 901
- Work Center: 901, Final Inspection
- WC Defect Group: PAINT (selected), PAINT DEFECTS
- Select Defect Group: PAINT (selected), PAINT DEFECTS

A 3D model of a red metal part is displayed in the center of the form.

4. To Report the Operation, select the Quantity to Report (**Qty OK**) and input any **Comments** regarding this Report.
 5. Select the **Cell/Machine, Shift,** and **Operator**.
 6. Click the **Report QA Operation** button OR the **Report Non-QA Operation** button.
- Note: Depending on the Operation you have selected, only one of these buttons will be available to you.

The screenshot shows the bottom section of the 'Report Operation' form with the following fields and values:

- Qty OK: 0
- Comments: [Empty]
- Cell/Machine: [Empty]
- Shift: [Empty]
- Operator: [Empty]
- Report QA Operation: [Button]
- Report Non-QA Operation: [Button]
- Setup Defects Only: [Button]

A pink arrow points to the 'Report QA Operation' button.

Report Op/Defects [S3001]

7. To Report Defects without Reporting the Operation, ignore steps 4-6. Click the **Setup Defects Only** button.

Qty OK: 0
Comments:
Cell/Machine:
Shift:
Operator:

Report QA Operation:
Report Non-QA Operation
Setup Defects Only

Note: The Defects from the Group you created on the Defect Groups [S2388] screen will not be set up in the **Defects** frame.

8. In Edit mode, input the **Quantity** of Defects you would like to Report for each Defect.
9. Input the **Rework Minutes** for each Defect.
10. Use the File Picker under the **Picture** column to attach a new image file, if necessary.
11. Input any **Comments** regarding this Defects Report.

Defects

SUBMIT DEFECTS				
Code	Desc	Qty	Rework Mins.	Picture
01	FISHEYE	4	20	
03	BLISTER	2	10	

ALREADY REPORTED		
Code	Qty	Rework Mins.
01	3	3
03	2	0
03	13	0

Comments:

Submit

Report Op/Defects [S3001]


12. Click the **Submit** button to Submit these Defects.

Defects


SUBMIT DEFECTS				
Code	Desc	Qty	Rework Mins.	Picture
01	FISHEYE	4	20	
03	BLISTER	2	10	

ALREADY REPORTED			
Code	Qty	Rework Mins.	
01	3	3	▲
03	4	10	
01	4	20	▼

Comments:



Submit



Defect Results by WO [S3003]

The **Defect Results by WO [S3003]** screen gives a detailed view of the Defects Reported in the Report Op/Defects [S3001] screen.

Defect Results by WO [S3003]

Operation Defect Results

Defect Group: <ALL> Select All Records Date From: 11/16/2015 To: 12/14/2015

Work Order: <ALL> Select All Records

Work Order	Part	Oper.	Qty	Date	Timestamp	Group	Code	Code Desc.
WO10012	A1001	20	13	11/24/2015	11/24/2015 8:28:25 AM	PAINT	03	BLISTER
WO10012	A1001	20	1	11/24/2015	11/24/2015 8:28:12 AM	PAINT	01	FISHEYE
WO10012	A1001	20	1	11/24/2015	11/24/2015 8:27:56 AM	PAINT	01	FISHEYE

Picture:

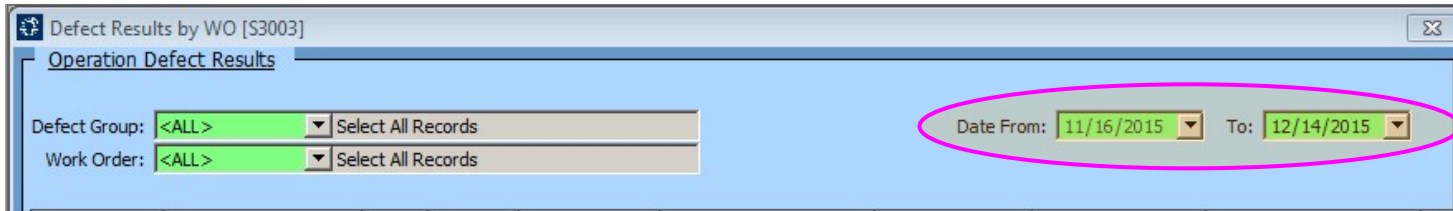
Comments:

F1 for Help Browse Edit Add Delete OK Cancel Print Exit

Defect Results by WO [S3003]

To view the Defects Reported on the Report Op/Defects [S3001] screen:

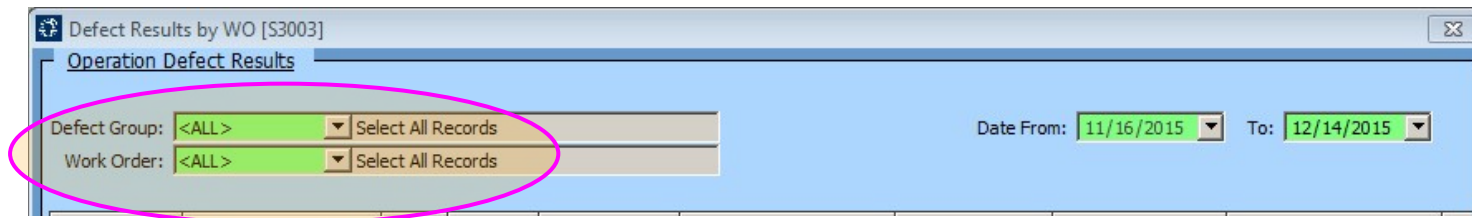
1. Select the date range to be viewed using the **Date From** and **To** Date Pickers.



The screenshot shows the 'Defect Results by WO [S3003]' window. The title bar includes a refresh icon and a close button. Below the title bar is the section 'Operation Defect Results'. There are two rows of controls: 'Defect Group: <ALL>' and 'Work Order: <ALL>', each with a dropdown arrow and a 'Select All Records' button. To the right, there are two date pickers: 'Date From: 11/16/2015' and 'To: 12/14/2015'. A pink oval highlights these two date pickers.

Note: The **Operation Defects Results** can be filtered by Defect Group and/or Work Order.

2. To filter, select the **Defect Group** and/or **Work Order** from the drop-down menu, or select to view <ALL>.



The screenshot shows the same 'Defect Results by WO [S3003]' window. In this view, the 'Defect Group: <ALL>' and 'Work Order: <ALL>' dropdown menus are highlighted with a pink oval. The date pickers remain visible on the right side of the window.

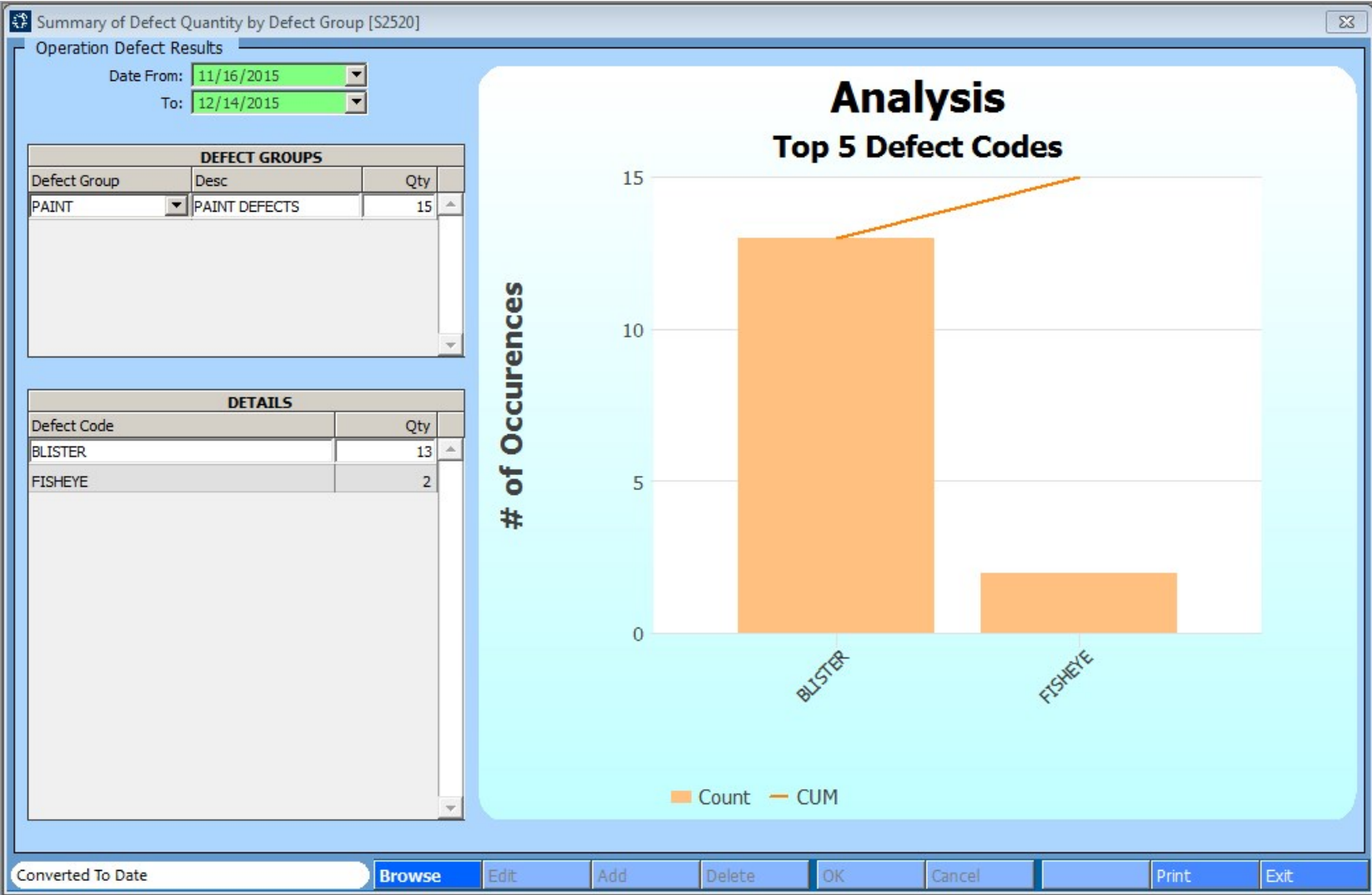
Defect Results by WO [S3003]

Note: The Operation Defect Results grid displays all aspects of the Defects you have reported, including the **Work Order** ID code, the **Part** ID number, the **Operation** ID number, the **Quantity** Reported, the **Date** and **Timestamp** of the Report, the Defect **Group** ID, the Defect **Code**, and the Defect **Code Description**.

Work Order	Part	Oper.	Qty	Date	Timestamp	Group	Code	Code Desc.	
WO10012	A1001	20	13	11/24/2015	11/24/2015 8:28:25 AM	PAINT	03	BLISTER	
WO10012	A1001	20	1	11/24/2015	11/24/2015 8:28:12 AM	PAINT	01	FISHEYE	
WO10012	A1001	20	1	11/24/2015	11/24/2015 8:27:56 AM	PAINT	01	FISHEYE	

Summary of Defect Quantity by Defect Group [S2520]

The **Summary of Defect Quantity by Defect Group [S2520]** screen allows for Pareto Analysis of Reported Defects.



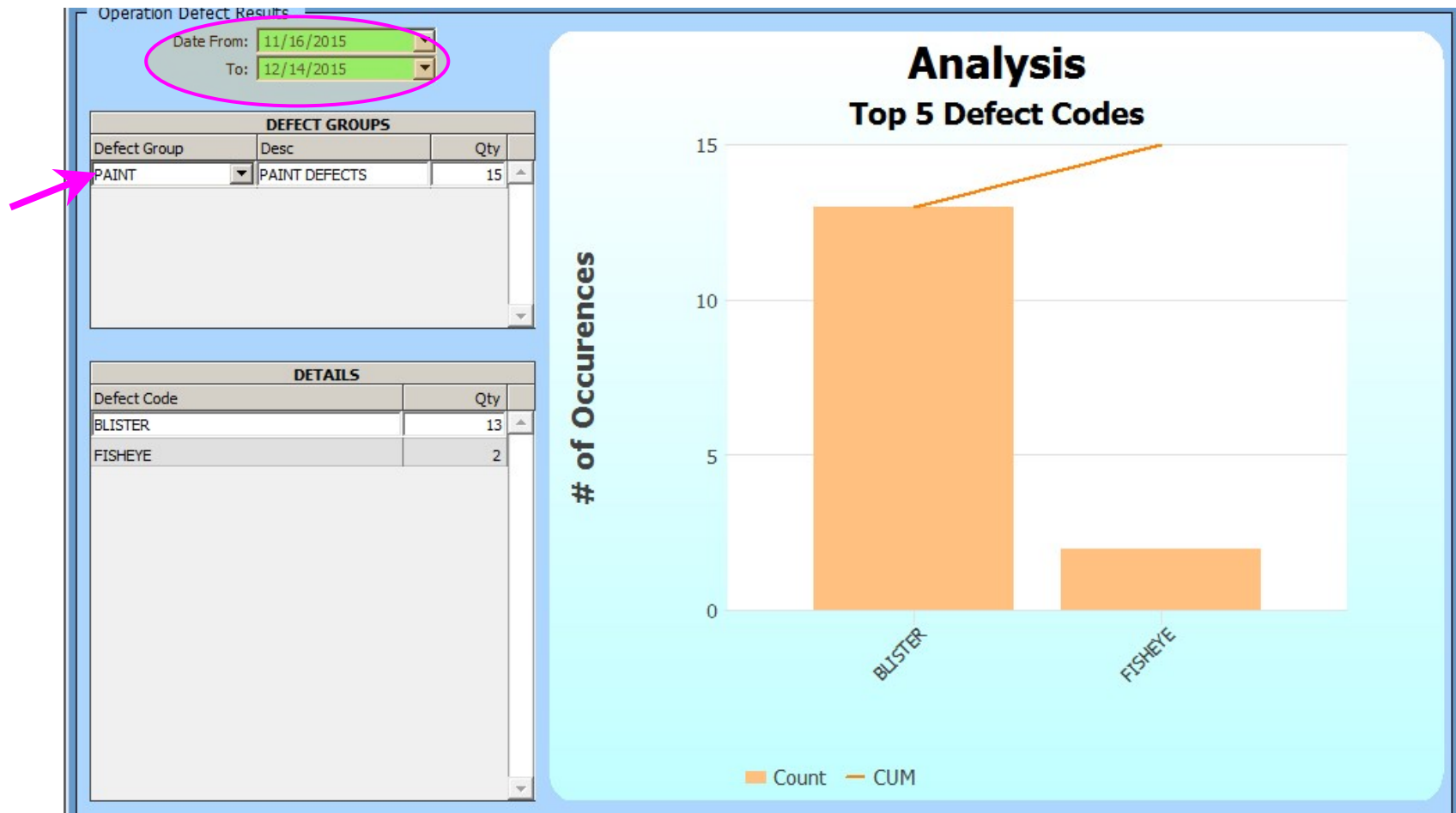
Summary of Defect Quantity by Defect Group [S2520]

To view a Summary of Defect Quantity by Defect Group:

1. Select the date range using the **Date From** and **To** Date Pickers.

Note: The **Defect Groups** grid displays each Defect Group. In this case, only one Defect Group has been created.

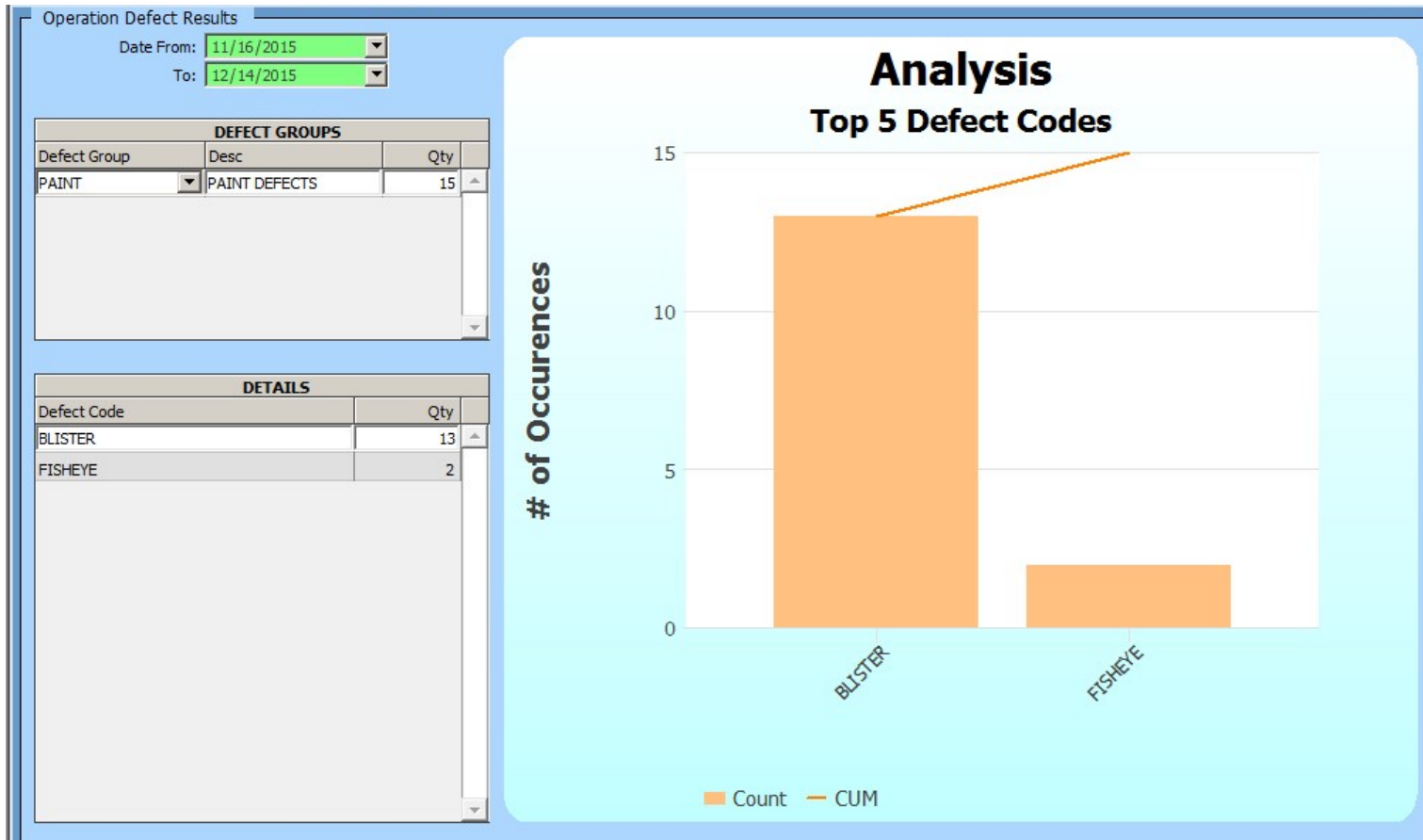
The **Details** grid displays the **Quantity** of each Defect in the selected Defect Group. If there are several Groups in the Defect Groups grid, click to select the Defect Group that you would like to view in the Details grid.



Summary of Defect Group Quantity by Defect Group [S2520]

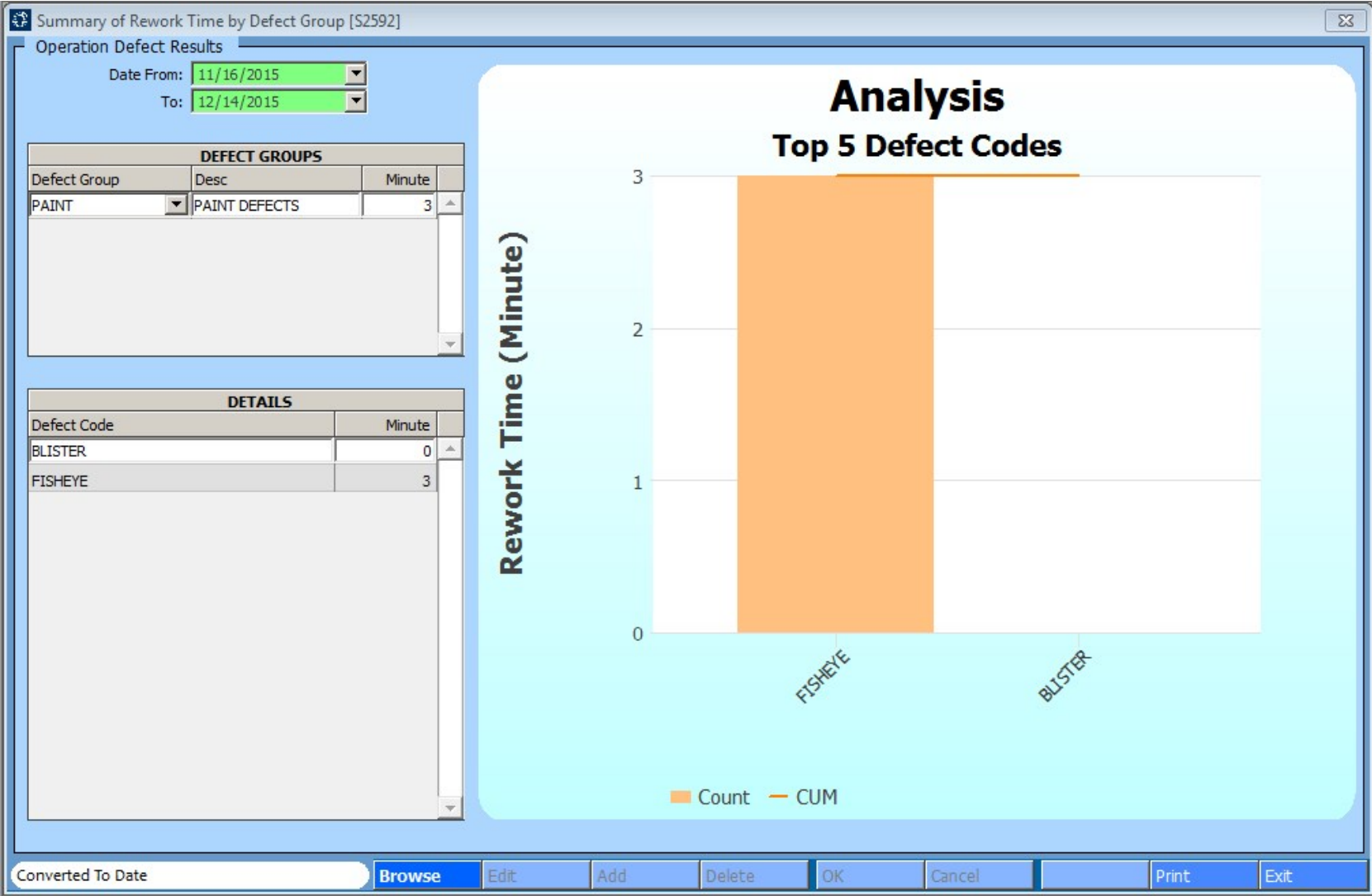
The **Analysis** graph allows a Pareto Analysis of the **Top 5 Defect Codes** for the selected Defect Group. In this case, there is only one Defect Group to choose from (**PAINT**), and only two Defect Codes within that Group (**BLISTER** and **FISHEYE**).

- The X factor of the graph is the Description of the Top 5 Defect Code.
- The Y factor of the graph is the **# of Occurances**.
- The thick lines indicate the **Count** and the thin line indicates the **Count Unit of Measurement**.



Summary of Rework Time by Defect Group [S2592]

The **Summary of Rework Time by Defect Group [S2592]** screen, like the Summary of Defect Quantity by Defect Group [S2520] screen, allows for Pareto Analysis of Reported Defects.



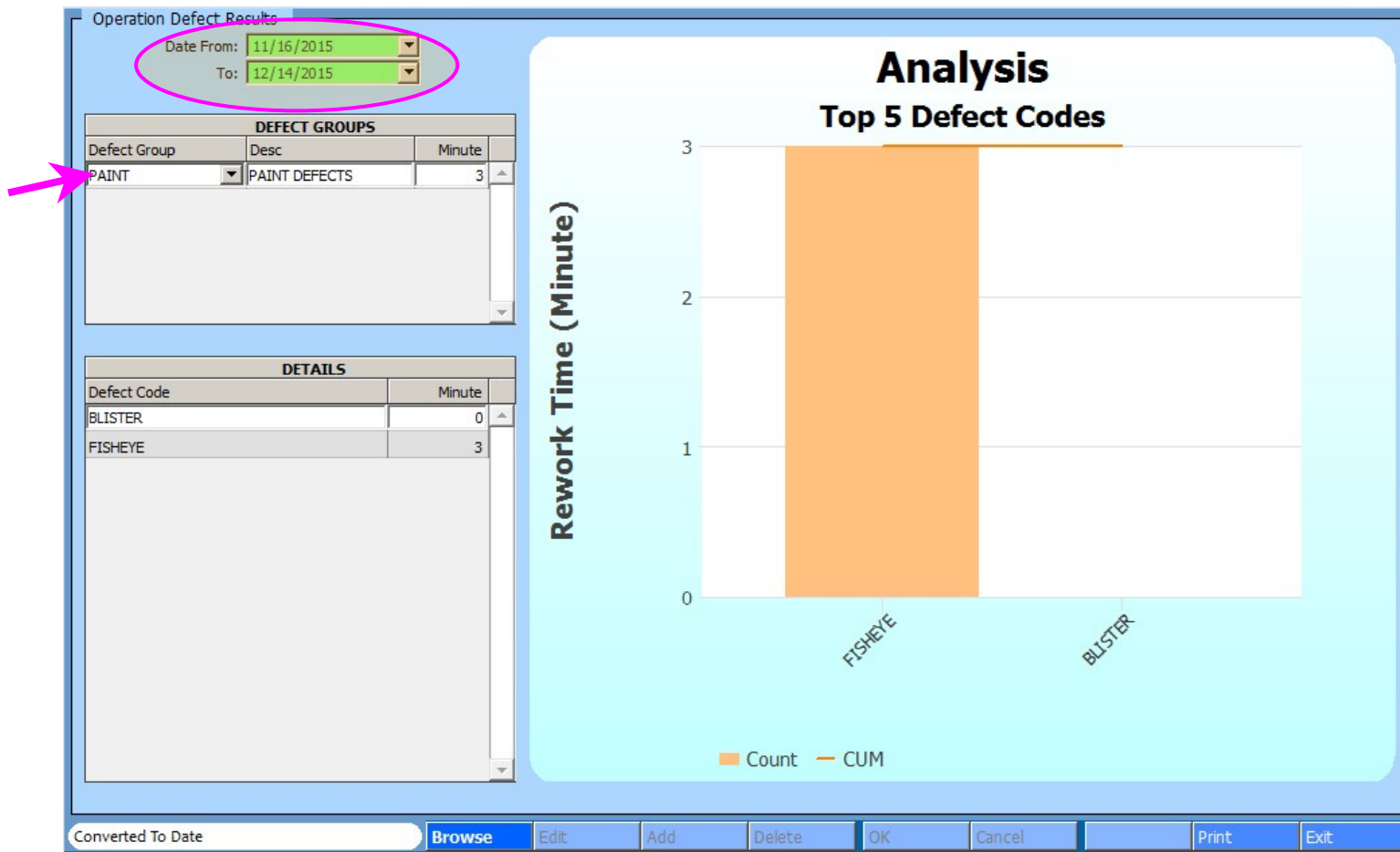
Summary of Rework Time by Defect Group [S2592]

To view a Summary of Rework Time by Defect Group:

1. Select the date range using the **Date From** and **To** Date Pickers.

Note: The **Defect Groups** grid displays each Defect Group. In this case, only one Defect Group has been created.

The **Details** grid displays the number of Rework **Minutes** taken by each Defect in the selected Defect Group. If there are several Groups in the Defect Groups grid, click to select the Defect Group that you would like to view in the Details grid.



Summary of Rework Time by Defect Group [S2592]

The **Analysis** graph allows a Pareto Analysis of the **Top 5 Defect Codes** for the selected Defect Group. In this case, there is only one Defect Group to choose from (**PAINT**), and only two Defect Codes within that Group (**BLISTER** and **FISHEYE**).

- The X factor of the graph is the Description of the Top 5 Defect Code.
- The Y factor of the graph is the **Rework Time (Minutes)**.
- The thick lines indicate the **Count** and the thin line indicates the **Count Unit of Measurement**.

