

Point85
Overall Equipment Effectiveness (OEE) Getting Started Guide
Version 2.0.0

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INTRODUCTION

This document is a tutorial on how to get started with a minimal system to collect and display OEE data. For a description of all the capabilities offered by Point85 OEE, please refer to the *Point 85 Overall Equipment Effectiveness (OEE) User Guide*.

INSTALLATION

Prior to installing the OEE applications, a 32-bit Java 8 JRE must be installed and the JAVA_HOME environment variable set. After installation of the JRE, a database from one of the following vendors and versions (or later) must be installed:

- Microsoft SQL Server 2012 or SQL Server Express
- Oracle 12c
- MySql 8
- PostgreSQL 11

DESKTOP APPLICATIONS

The desktop applications are packaged in the oee-<version>.zip file in the OEE-Designer's dist folder. Download the oee.zip file and expand the archive into the following folder structure:

- root: oee-apps-<version>.jar (Designer, Monitor, Collector and Tester apps), oee-collector-<version>.jar (data collector in-process app), run-collector-app.bat (example Windows shell script for executing the data collector test UI), run-designer-app.bat (example Windows shell script for executing the designer application), run-monitor-app.bat (example Windows shell script for executing the monitor app), run-tester-app.bat (example Windows shell script for executing the tester application).
- config > logging: log4j.properties configuration file
- database
 - import: example CSV import files (reasons.csv and materials.csv)

- mssql: create_tables.sql, create_event_table.sql - SQL scripts to create the Microsoft SQL Server database tables
- oracle: create_tables.sql, create_event_table.sql - SQL script to create the Oracle database tables
- lib: contains oee-domain-<version>.jar domain classes plus dependent jars
- logs: empty folder to contain the Log4j and Java Service Wrapper logging files
- wrapper
 - Win
 - bin: 32-bit Tanuki Java Service Wrapper community edition (wrapper.exe), install-oe-collector.bat (Windows shell script to install the data collector as a Windows service), uninstall-oe-collector.bat (Windows shell script to uninstall the data collector Windows service), oee-collector.bat (Windows shell script to execute the wrapper as a console app)
 - conf: wrapper.conf (Java Service Wrapper configuration file)
 - lib: wrapper.dll and wrapper.jar for Java Service Wrapper
 - MacOSX
 - bin: 64-bit Tanuki Java Service Wrapper community edition (wrapper), oee-collector (OS X shell script to execute the wrapper as a console app)
 - conf: wrapper.conf (Java Service Wrapper configuration file)
 - lib: libwrapper.jnilib and wrapper.jar for Java Service Wrapper

The Java Service Wrapper wrapper.conf file requires that the following parameters be defined:

- wrapper.java.command: path to a Windows 32-bit Java 8 JRE compatible with the 32-bit Java Service Wrapper (or Unix 64-bit JRE compatible with a 64-bit Java Service Wrapper), e.g. for Windows:
 - set.JAVA_HOME=C:/jdk/jdk1.8.0_152-32/jre
 - wrapper.java.command=%JAVA_HOME%/bin/java
- program arguments for the JDBC connection string and authenticated user. For example for Microsoft SQL Server running on localhost at port 1433 and connecting to the OEE database with SQL Server authenticated user "Point85" and password "Point85":
 - wrapper.app.parameter.2=jdbc:sqlserver://localhost:1433;databaseName=OEE
 - wrapper.app.parameter.3=Point85
 - wrapper.app.parameter.4=Point85

For Oracle, the JDBC connection string would be similar to jdbc:oracle:thin:@localhost:1521:orcl SYSTEM admin

Before running any desktop applications:

- Edit the config/logging/log4j.properties file to set the location of the Point85.log file and logging levels.
- Create a database and then initialize it by executing the create_tables.sql script for SQL Server or Oracle. If using an interface table as a data source, execute the create_event_table.sql script.
- Optionally, download and install the RabbitMQ broker from <https://www.rabbitmq.com>. The monitor application now can be used for collector status updates.

DATA COLLECTOR

For your operating system (wrapper/MacOSX or wrapper/Win) under the OEE-<version> root folder, the in-process data collector can be deployed as follows:

- Edit the conf/wrapper.conf file to set JAVA_HOME and the database JDBC connection, user name and password properties (wrapper.app.parameter.2, 3 and 4)
- Execute the shell script to install the collector as a Windows service (Win/bin/install-oe-collector.bat and uninstall-oe-collector.bat), Unix daemon (MacOSX/bin/oe-collector.sh) or Windows console program (Win/bin/oe-collector.bat).

OPERATOR WEB APPLICATION

Download the operator web application's war file (OEE-Operator-<version>.war) in the OEE-Operations project's dist folder. The web.xml file in the war needs to be edited for the database connection information. To do this use a zip file manager application such as 7-Zip to edit WEB-INF/web.xml's jdbcConn, userName and password parameters. For example:

```
<init-param>
    <param-name>jdbcConn</param-name>
    <param-value>jdbc:sqlserver://localhost:1433;databaseName=OEE</param-value>
</init-param>
<init-param>
    <param-name>userName</param-name>
    <param-value>Point85</param-value>
</init-param>
<init-param>
    <param-name>password</param-name>
    <param-value>Point85</param-value>
</init-param>
```

For this tutorial, we will use Apache Tomcat. Install Tomcat, then run the Tomcat Web Application Manager. In the section of the web page titled “WAR file to deploy,” browse to the war file and click the Deploy button. Under the Applications section, the path will be “/OEE-Operator-<version>”.

The Point85 operator application URL is http://<host>:<port>/<war_file_name>/. If Tomcat is installed locally on the default port of 8080, the URL will be <http://localhost:8080/OEE-Operator-<version>/>.

PLANT MODEL

In the <root> intall folder, execute the run-designer-app.bat script to launch the Designer desktop application.

PHYSICAL MODEL

In this guide, we will create a single piece of equipment. In the physical model screen, click on the New button. Select EQUIPMENT as the type, enter the name and description as well as a 90 day data retention period. Click Save and answer yes to the question about creating the equipment as a top-level entity.

The screen should look similar to:

OEE Designer

New Save Refresh Delete

Dashboard

Getting Started (Getting started with OEE)

Type: EQUIPMENT

Name: Getting Started

Work Schedule

Description: Getting started with OEE

Retention (days): 90

Processed Material Data Collection

Material

Is Default Material

OEE Target (%): target OEE

Design Speed: IRR amount

Reject UOM

Clear Add Remove

Material	Description	OEE	Speed	UOM	Reject	Default
No content in table						

Click on the button to the left of the “Work Schedule” label to assign a work schedule to this equipment. Rather than creating a work schedule from scratch, we will use one of the pre-defined schedules.

In the work schedule editor, click on the Import button and select the “Manufacturing Company” schedule, then click OK. Select this schedule in the left-hand pane. The editor should look like this:

Click Done to return to the physical model editor. Select the equipment and click the Save button.

Click Done to return to the physical model editor. Select the equipment and click the Save button.

Now we are ready to define the material(s) that can be produced by this equipment. For the purposes of this guide, we will create just one material. First, click the Clear button above the list of produced materials (note, for the first material the list is empty).

With the “Processed Material” tab selected, click the button to the left of the “Material” label to launch the material editor. Click the New button, then enter the name of a material produced by this equipment, a category and description for it. Then click the Save button. The editor should similar to:

Click Done to return to the equipment editor. Check the “Is Default Material” box to indicated that this material will be assumed to be produced if an explicit setup has not been done. Enter a value for the target OEE, e.g. 85 then click the Save button.

Click Done to return to the equipment editor. Check the “Is Default Material” box to indicated that this material will be assumed to be produced if an explicit setup has not been done. Enter a value for the target OEE, e.g. 85 then click the Save button.

Click the button to the left of the “Design Speed” label to launch the unit of measure editor. Click the New button, then enter the name, symbol, category, type and description for the unit of measure of produced material. Click the Save button. The example below creates a bottle for the produced Chardonnay wine.

Edit Unit Of Measure

New Save Refresh Delete

Import ...

- wine bottles
 - bottle

Name: bottle

Symbol: btl

Category: wine bottles

Type: VOLUME

Description: A 750 ml wine bottle

CONVERSION

a x + b

1.0 btl (bottle) 0

Scalar Product or Quotient Power

No additional properties are required.

Done

Since the design speed is a rate, we need to create a quotient unit of measure where the numerator is the previously created unit, and the denominator is a time unit. Click the New button, then enter the name, symbol, category (same as before), type and description for the rate unit of measure of produced material.

Select the “Product or Quotient” tab. Select the dividend type (e.g. VOLUME), then the previously created unit (e.g. bottle). Click the “Divided By” radio button, then select TIME as the denominator type. Select “min (minute)” for the unit. Click the Save button.

The example below creates a rate of bottles per minute for the produced Chardonnay wine:

Edit Unit Of Measure

New Save Refresh Delete Import ...

- wine bottles
 - bottle
 - bottles per minute**

Name: bottles per minute

Symbol: bpm

Category: wine bottles

Type: VELOCITY

Description: 750 ml wine bottles produced per minute.

CONVERSION

a x + b

1.0 bpm (bottles per minute) 0

Scalar Product or Quotient Power

Type: VOLUME Unit: btl (bottle)

☐ Multiplied By ☒ Divided By

Type: TIME Unit: min (minute)

Done

Select the rate unit of measure, then click the Done button to return to the equipment editor.

The rate symbol will be displayed to the right of the design speed value. Enter the design speed, e.g. 10.

Click on the button to the left of the “Reject UOM” label to re-launch the unit of measure editor.

Choose the previously created scalar unit, e.g. “bottle”, then click the Done button to return to the equipment editor.

Click the Add button to add this material to the list of materials produced by this equipment (in our case, it is the first and only one). Click the Save button. The equipment editor should look similar to:

The screenshot shows the OEE Designer application window. On the left is a sidebar with a 'Dashboard' button and a 'Getting Started (Getting started with OEE)' button. The main area is divided into two tabs: 'Processed Material' and 'Data Collection'. The 'Data Collection' tab is active, showing a form for configuring data collection for a specific material.

Equipment Configuration:

- Type: EQUIPMENT
- Name: Getting Started
- Work Schedule: Manufacturing Company
- Description: Getting started with OEE
- Retention (days): 90

Data Collection Configuration:

- Material: Chardonnay Wine
- Description: Our best Chardonnay
- Is Default Material: ☒
- OEE Target (%): 85
- Design Speed: 10 bpm
- Reject UOM: btl

Buttons: Clear, Update, Remove

Material	Description	OEE	Speed	UOM	Reject	Default
Chardonnay Wine	Our best Chardonnay	85	10	bpm	btl	true

DEFINING DATA COLLECTION

Now we will define how the availability and production OEE data is collected. For the purpose of this guide, assume that the provider will make a web service call to the embedded HTTP server.

In the equipment editor, select the previously created equipment, then click on “Data Collection” tab. Click on the button to the left of the “Collector Host” label to launch the data collector editor.

Click New. Enter a name, host IP address (not “localhost”) and description. Set the current state to READY. For the purposes of this tutorial, leave the RabbitMQ properties blank. Click Save. The editor should look like:

The screenshot shows the 'Edit Collector Configurations' dialog box. It has a 'Choose Saved' dropdown menu set to 'My computer'. Below this is a section titled 'or edit a collector configuration' with several input fields and buttons.

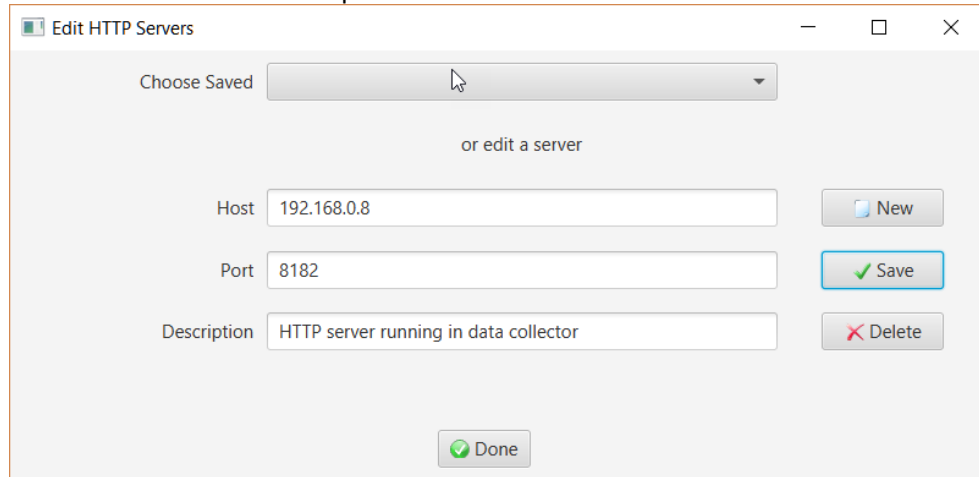
Collector Configuration:

- Name: My computer
- Host: 192.168.0.8
- Description: Getting started data collector
- RMQ Broker Host/IP: Enter RMQ broker host name or IP address
- RMQ Broker Port: Enter RMQ broker port
- RMQ User Name:
- RMQ User Password:
- Current State: READY

Buttons: New, Save, Delete, Done

Click the Done button to return to the equipment editor. Select this data collector in the combobox. In the “Resolver For” combobox, select AVAILABILITY. This will be the first resolver created. For the source type, select “HTTP”.

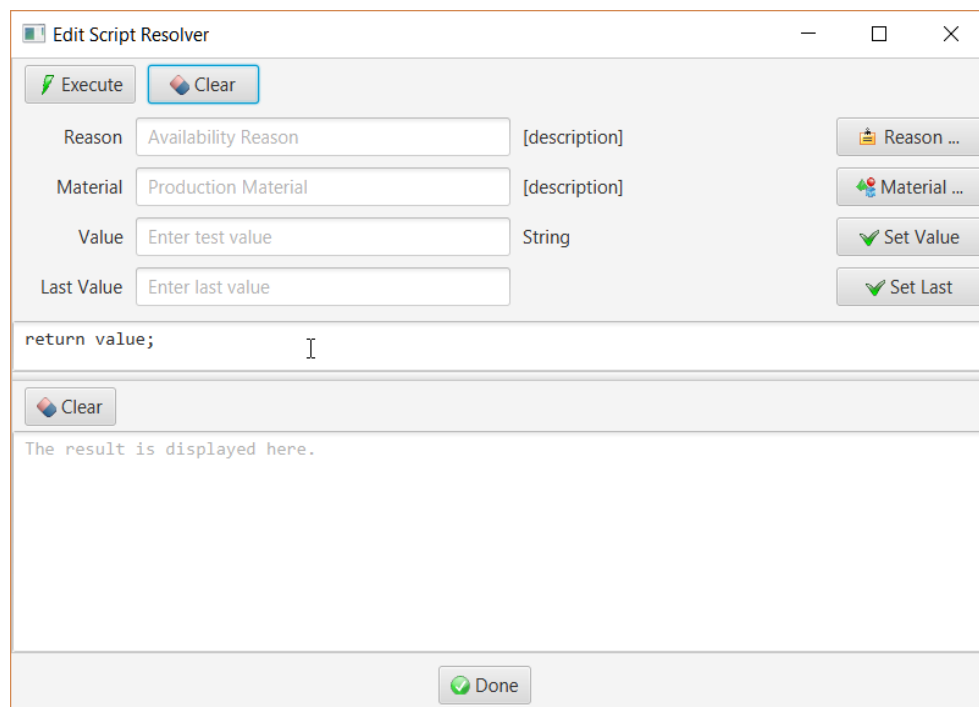
Click on the button to the left of the “Source Id” label to launch the HTTP server editor. For the purposes of this tutorial, we will define just one HTTP server on the same machine that the data collector will run. Click the New button, then fill in the host IP address (not “localhost”), port and a description. Port 8182 is the embedded HTTP server’s default port. Click the Save button. The editor should look like this:



The 'Edit HTTP Servers' dialog box is shown. It has a title bar with a green icon, a minus button, a maximize button, and a close button. The main area contains a 'Choose Saved' dropdown menu with a mouse cursor over it. Below this is the text 'or edit a server'. There are three input fields: 'Host' with the value '192.168.0.8', 'Port' with the value '8182', and 'Description' with the value 'HTTP server running in data collector'. To the right of these fields are three buttons: 'New' (with a blue plus icon), 'Save' (with a green checkmark icon), and 'Delete' (with a red X icon). At the bottom center is a 'Done' button with a green checkmark icon.

Click the Done button to return to the equipment editor. The source id and server fields will be updated with the data type indicated a a string.

Click on the button to the left of the “Script” label to launch the JavaScript editor. The editor will look like this:



The 'Edit Script Resolver' dialog box is shown. It has a title bar with a green icon, a minus button, a maximize button, and a close button. The main area contains an 'Execute' button with a green lightning bolt icon and a 'Clear' button with a blue diamond icon. Below these are four input fields: 'Reason' with the value 'Availability Reason' and a '[description]' label, 'Material' with the value 'Production Material' and a '[description]' label, 'Value' with the value 'Enter test value' and a 'String' label, and 'Last Value' with the value 'Enter last value'. To the right of these fields are four buttons: 'Reason ...' (with a folder icon), 'Material ...' (with a globe icon), 'Set Value' (with a green checkmark icon), and 'Set Last' (with a green checkmark icon). Below these fields is a text area containing the code 'return value;' with a cursor. Below the text area is a 'Clear' button with a blue diamond icon. At the bottom center is a 'Done' button with a green checkmark icon.

We will define two availability reasons now. Click on the Reason... button to launch the availability reason editor. Click the New button and enter “Running” as the reason name. Choose a loss category of “Value Adding” (i.e. no loss) and enter a description. Click the Save button and answer “yes” to create a top-level reason. Repeat these steps for a reason of “Unplanned” with a loss category of “Unplanned Downtime.” The reason editor should look like this:

The 'Edit Reason' dialog box is shown. It features a left sidebar with a list of reasons: 'Running (Running normally)' and 'Unplanned (Equipment fault)'. The main area on the right displays the details for the selected reason, 'Unplanned'. The 'Name' field is set to 'Unplanned', the 'Loss Category' is 'Unplanned Downtime', and the 'Description' is 'Equipment fault'. At the top of the dialog are buttons for 'New', 'Save', 'Refresh', and 'Delete'. A 'Done' button is located at the bottom center.

Select the “Running” reason, then click the Done button to return to the script editor. The “Running” reason will appear in the text box next to the reason label. Cut and paste this reason into the Value field, then click the Set Value button. Finally click the Execute button to run the script with “Running” as the input value. The output Running reason will be displayed at the bottom of the editor.

The script editor should look like this now:

The 'Edit Script Resolver' dialog box is shown. It has a top section with 'Execute' and 'Clear' buttons. Below these are input fields for 'Reason' (set to 'Running'), 'Material' (set to 'Production Material'), 'Value' (set to 'Running'), and 'Last Value' (set to 'Enter last value'). To the right of these fields are buttons for 'Reason ...', 'Material ...', 'Set Value', and 'Set Last'. The main area contains a text box with the code 'return value;'. At the bottom, there is a 'Clear' button and a text box showing the output: 'Running, Running normally, Loss: Value Adding'. A 'Done' button is located at the bottom center.

Click Done to accept the default script that just passes the input availability reason name as the output reason name and return to the equipment editor.

At this point, we have fully defined an HTTP script resolver (it is not necessary to set the update period for such a resolver). Click the Add button to add this availability resolver as the first one for this equipment. Then click the Save button.

The data collection tab should now display the single availability resolver:

TypeEQUIPMENT

NameGetting Started

Work ScheduleManufacturing Company

DescriptionGetting started with OEE

Retention (days)90

Processed Material

Data Collection

Collector HostData collector host machine

Resolver ForType of resolver

Source TypeData source type

Source IdUnique identifier of data value

ServerServer identifier

Data Type

Script

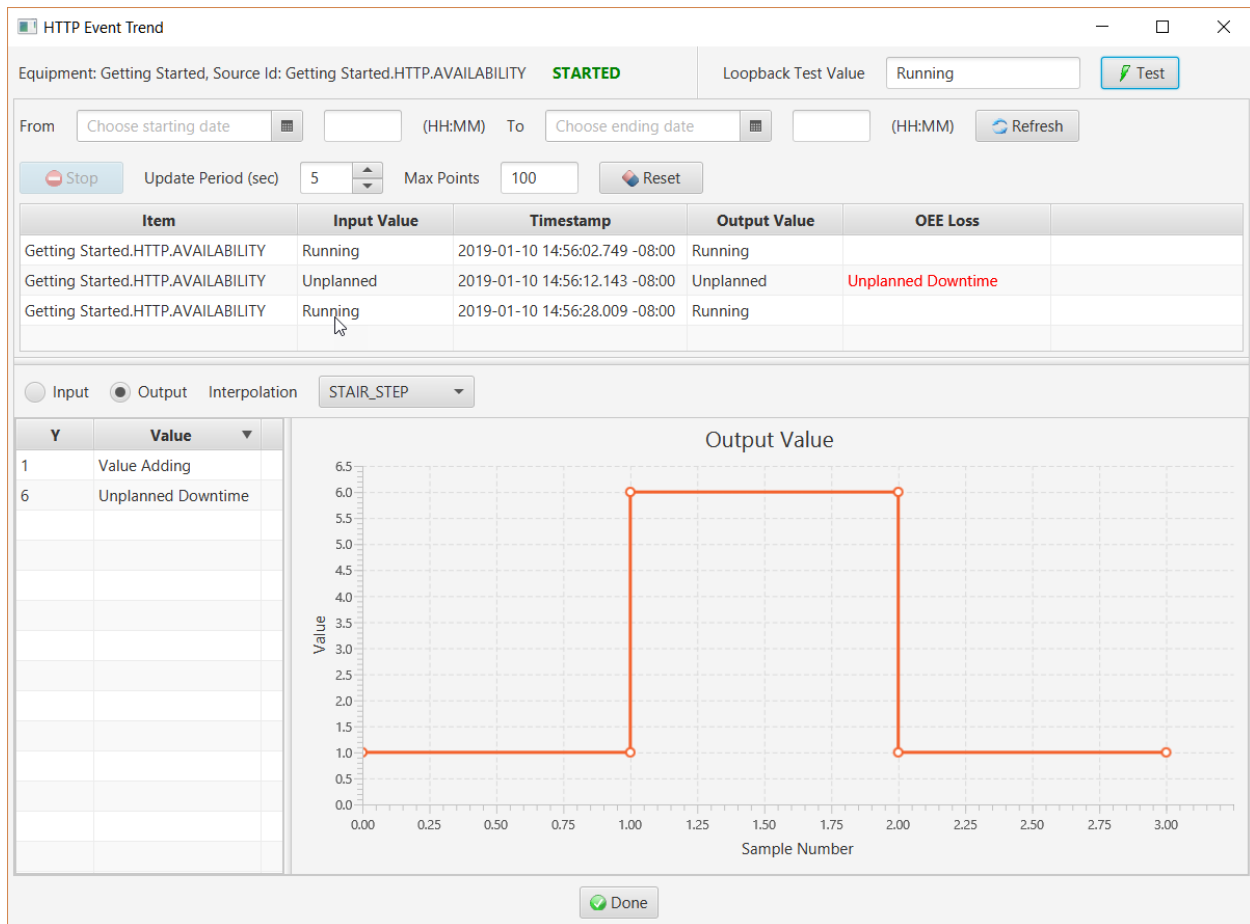
Update (msec)

ClearAddRemoveWatch ...

Collector	Resolver Type	Data Source	Server	Source Id	Data Ty...	Update	Script
My computer	AVAILABILITY	HTTP	192.168.0.8:8182	Getting Started.HTTP.AVAILABILITY	String		return value;

In order to test this resolver in a historical trend chart, select it in the table and click the Watch button to launch the trend dialog. Select “Output” and interpolation type STAIR_STEP.

Enter “Running” as the loopback test value and click the Test button. The first data point will appear. Enter “Unplanned” as the test value and click the Test button. The second data point will appear. Repeat for “Running” again. The trend dialog should look like this:



Next, define an HTTP resolver for good production (PROD_GOOD) and one for reject production (PROD_REJECT) counts by following steps similar to the availability resolver above. Finally define a material setup HTTP resolver (MATL_CHANGE).

These new resolvers will look like this when completed:

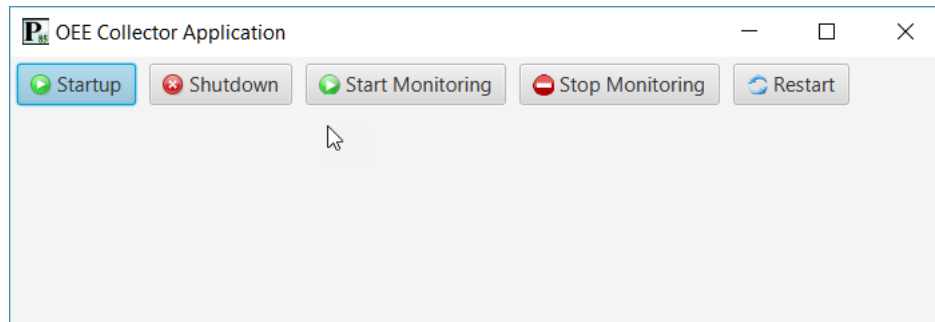
Collector	Resolver Type	Data Source	Server	Source Id	Data Type	Update	Script
My computer	PROD_REJECT	HTTP	192.168.0.8:8182	Getting Started.HTTP.PROD_REJECT	String	5000	return value;
My computer	MATL_CHANGE	HTTP	192.168.0.8:8182	Getting Started.HTTP.MATL_CHANGE	String		return value;
My computer	AVAILABILITY	HTTP	192.168.0.8:8182	Getting Started.HTTP.AVAILABILITY	String		return value;
My computer	PROD_GOOD	HTTP	192.168.0.8:8182	Getting Started.HTTP.PROD_GOOD	String	5000	return value;

The production count and material setup resolvers can be tested in the trend chart similar to the availability chart.

TESTING DATA COLLECTION

Besides displaying input and output values in a trend chart in the Designer application, a collector test application and HTTP/Messaging test application can be used. On the computer with the data collector that is defined for the four resolvers above (e.g. 192.168.0.8), execute the run-collector-app.bat shell

script in the root folder. The collector UI will appear. Click the Startup button. When the collector is ready, the other four buttons will be enabled:



Now, execute the run-tester-app.bat shell script. The HTTP and messaging test application will appear. For this tutorial, we will only use the HTTP capabilities.

In the Host:Port combobox, select the previously defined HTTP server. Next, click the "HTTP Get Entities" button to display the physical model with the single piece of equipment and then select it. In the "Source Id" combobox, select the material change id. Select the Material tab and click the "HTTP Get Materials". Select the previously created wine material. The test client should look like this:

The screenshot shows a window titled "HTTP and Messaging Test Client". It has two main sections: "HTTP" and "MESSAGING".
HTTP Section:
- Buttons: "Reset", "Post", "RMQ", "JMS".
- Host:Port: 192.168.0.8:8182
- Source Id: Getting Started.HTTP.MATL_CHANGE
- Value: Chardonnay Wine
MESSAGING Section:
- Buttons: "Send".
- Broker: (empty)
- Source Id: (empty)
- Value: Chardonnay Wine
HTTP Get Entities:
- Button: "HTTP Get Entities".
- Table:

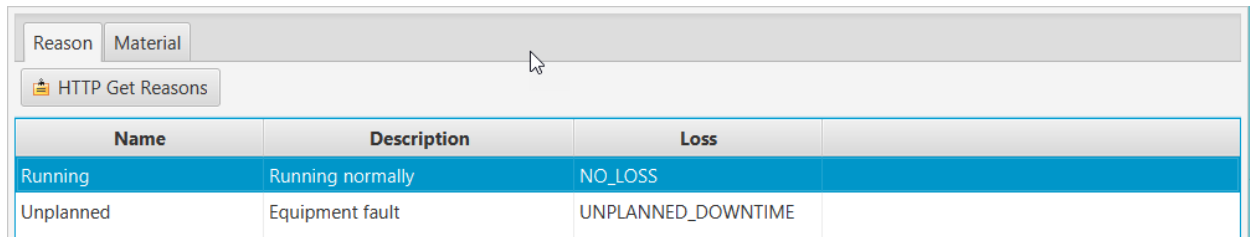
Name	Description	Level
Getting Started	Getting started with OEE	EQUIPMENT

Material Section:
- Tabs: "Reason", "Material".
- Button: "HTTP Get Materials".
- Table:

Name	Description	Category
Chardonnay Wine	Our best Chardonnay	Wines

Click the Post button to make a material change request to the collector's HTTP server. A material setup will be recorded in the database.

Now, select the Reason tab and click the “HTTP Get Reasons” button to display the availability reasons:



The screenshot shows a web interface with two tabs: 'Reason' and 'Material'. The 'Reason' tab is active. Below the tabs is a button labeled 'HTTP Get Reasons' with a small icon. Below the button is a table with four columns: 'Name', 'Description', 'Loss', and an empty column. The table contains two rows: 'Running' with 'Running normally' and 'NO_LOSS', and 'Unplanned' with 'Equipment fault' and 'UNPLANNED_DOWNTIME'.

Name	Description	Loss	
Running	Running normally	NO_LOSS	
Unplanned	Equipment fault	UNPLANNED_DOWNTIME	

Select the Running reason. Select the availability source id. Click the Post button to make an equipment availability request to the collector’s HTTP server for a Running reason. Repeat this for the Unplanned reason.

Now, select the good production source id and enter a numerical value in the “Value” field. Repeat for the reject source id.

DATA COLLECTOR

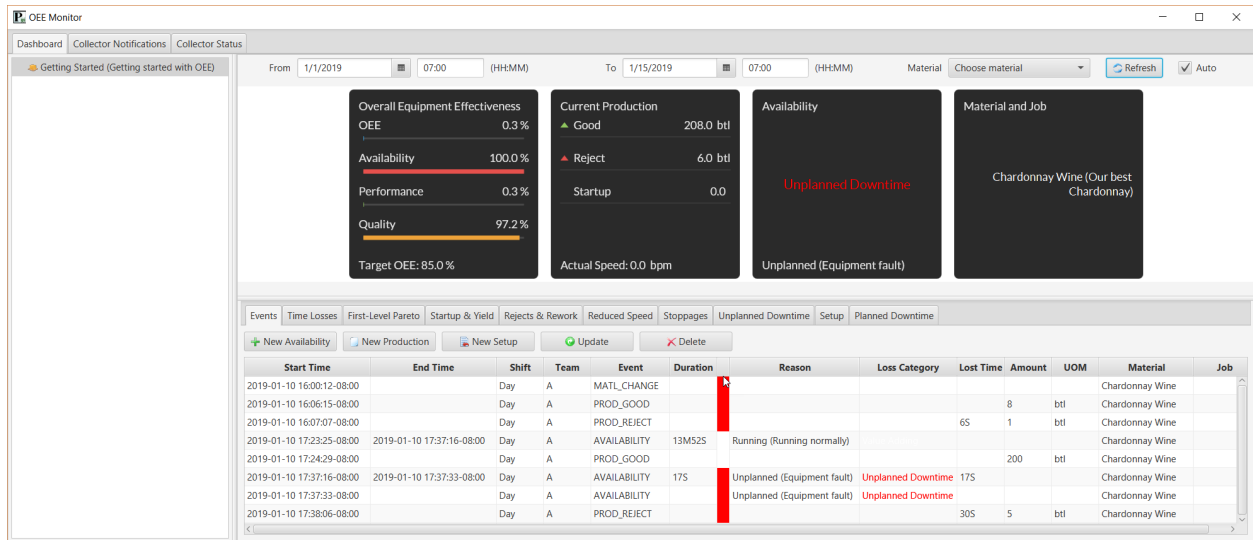
The data collector is a Windows service or Unix daemon and runs on the computer configured with a collector (in our case 192.168.0.8).

For the purposes of this tutorial, we will run the collector as a Windows console application. Execute `<root>/wrapper/Win/bin/oeecollector.bat` shell script. The logging output will appear in the console window.

Now, execute the `run-tester-app.bat` shell script. The HTTP and messaging test application will appear. Follow the steps above to send requests to the collector.

MONITOR

The Monitor is a desktop application with an OEE dashboard. The dashboard is also accessible from the Designer’s equipment editor. To launch the Monitor, execute `<root>/run-monitor-app.bat` shell script. Select the equipment of interest in the left-hand panel. Enter a date and time-of-day range when the data from this tutorial was collected, then click the Refresh button. Select the “Events” tab. The Monitor’s dashboard will display OEE information from this data. For example:



If the RabbitMQ message broker is installed, the monitor will update based on equipment events and status messages sent by the data collectors. Without a message broker, polling of the database is enabled by checking the “Auto” checkbox to update the OEE dashboard.

WEB APPLICATION

Browse to the URL where the Point85 web app is installed, then select the equipment configured above. Select the Availability/Rate tab, and click the “By Event” radio button. Select “Running” as the reason in the table below and enter the event date and time of day:

Name	Description	Loss Category
Running	Running normally	Value Adding
Unplanned	Equipment fault	Unplanned Downtime

Click the Record button to save this availability event to the database.

Select the Production tab, and click the “Summarized” radio button. Select “Startup & Yield” as the production type and enter the quantity. Enter the beginning and ending date and time of day (e.g. an entire shift) for the summarized startup and yield production counts:

Plant Entities

Getting Started (Getting started with OEE)

Point 85 Operations

MATERIAL Chardonnay Wine Our best Chardonnay JOB ABC

Availability/RateProductionJob/Material

Production *

By EventSummarized

Production Type *

GoodReject and ReworkStartup and Yield

Quantity *btlReason

10

From Time *To Time *

1/11/19 07:00 AM1/11/19 03:00 PM

Record

Click the Record button to save this production event to the database.

Select the Job/Material tab, and enter the material being produced for a job number and changeover time. The web page should look similar to:

Plant Entities

Getting Started (Getting started with OEE)

Point 85 Operations

MATERIAL Chardonnay Wine Our best Chardonnay JOB ABC

Availability/RateProductionJob/Material

Material *Job

Chardonnay WineABC

Changeover Time *

1/11/19 11:18 AM

Record

Material

Name	Description
Wines	Category
Chardonnay Wine	Our best Chardonnay

Click the Record button to save this job change to the database.