Stop cause registration

Stop cause registration - Scanning a barcode automatically registers the associated stop cause in the Factbird cloud software.

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Prepare a list of barcodes associated with stop causes

- Prepare and print out a stop cause list that will be placed by the barcode scanner.
 - Template is available by Factbird in a separate Word document.
 - New barcodes can be generated for free from a websites e.g. https://barcode.tec-it.com/en/

Material Shortage Waiting for Forklift	(97)00001
Mactine Falure Press/Die Adjustment	(97)00002
Bresk Paid lunch	(97)00003
Break Scheduled Break	(97)00004
Product ChangOver Coil change	(97)00005
Product ChangOver Die Change	(67)00006
Product ChangOver Scrap/Parts Changeout (*Changing Bins)	(97)00007

Print out a stop cause list

Configure Stop Mapping in Factbird software

- Log in to Factbird Software and go to your line.
- Click the three dots, "Main sensor settings".



• Go to "STOPS MAPPING" tab

Manage sensor settir	ngs							xelisti (lis
BASIC INFORMATION SENSOR SETUP	Create unique mappings between PLC messages and stop cause Dray your mouse over the headers to see an explanation. Clicking the + kon will imme detect the mapping. Search by tag, value and stop cause	es ediately save the mapping, and cl	icking the delete icon will immediately					Q
SPEEDS	Mapping tag 🛛	Value @	Stop cause @	Priority @	Look back	Look forward @		
STOPS	New	Nev	None	1.#	0	0	~]
STOPS MAPPING	12345678abcde-Machine1Stop	m	Deleted Stop Cause	1	10	10	1	ĩ
LINE SETUP	12345678abcde-Machine1Stop	1	Power failure - Machines	1	10	10	1	•
ALARMS								

- 1. In "Mapping tag", type the tag name provided by Factbird. e.g. <uuid>-]C1 where uuid is the id of the device and C1 is the type of barcode to be send.
- 2. Set "Value" to the barcode value you have printed out for a given stop cause. e.g. 9700001
- 3. In the "Stop cause" drop down, find and select the stop cause you want to apply when the barcode is scanned. (If you have not created stop causes, please first create stop causes on "REGISTER STOPS" page in the Factbird software.)
- 4. In the "Priority", default is 1 on all. This means there is no priority on some stop causes over others. If you choose to set a stop cause priority higher than 1, this stop cause will overwrite the existing registered stop cause.
- 5. Look back/Look forward: when a barcode is scanned, the Factbird system looks for stops within the range of the value. e.g. in case "Look back" is set 30, within 30 seconds after the line/machine restarts, the stop needs to be registered by scanning a barcode. If there is no stop in the past 30 seconds, the scanned stop cause will be discarded.
- 6. Finally press the check mark (\checkmark) to save the configuration for your first barcode.
- 7. Perform the above actions for each new barcode you want to trigger stop causes with.

Splitting stops:

"Split stop" in "Priority" drop down:

By default, only the first barcode scanned will be applied to the stop (unless a higher priority stop is scanned). When "Split Stop" is activated, scanning that stop cause will instead divide the ongoing stop and apply this new stop cause to the remaining duration of the stop.

Example of splitting a stop: an ongoing stop is registered as "cleaning," and now the second cause, "lunch break," needs to be registered.

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Reference

• Editing a registered stop (incorrectly registered or missed due to not being scanned within the defined time threshold) can be manually corrected in the Factbird software. It cannot be rectified using barcode scanning.