

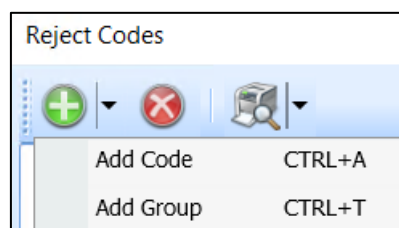
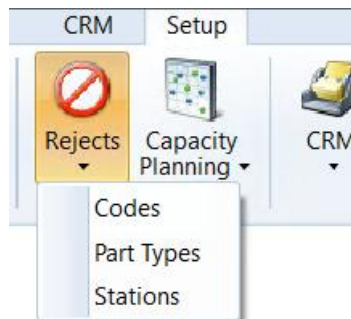
Window Reject Implementation

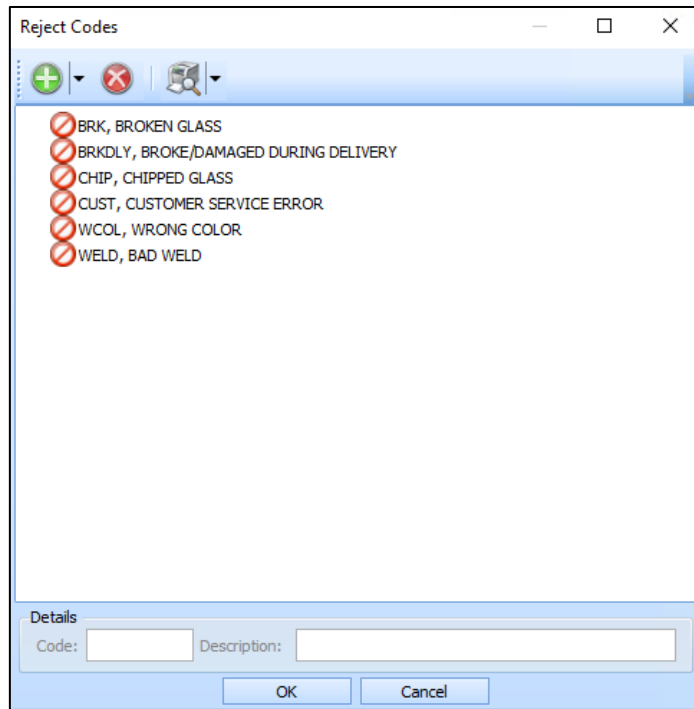
Introduction

This document will explain the best way to configure rejecting for Windows. It will cover the setup of reject codes, part types and their assignments and basic rejecting settings for Tracking Stations.

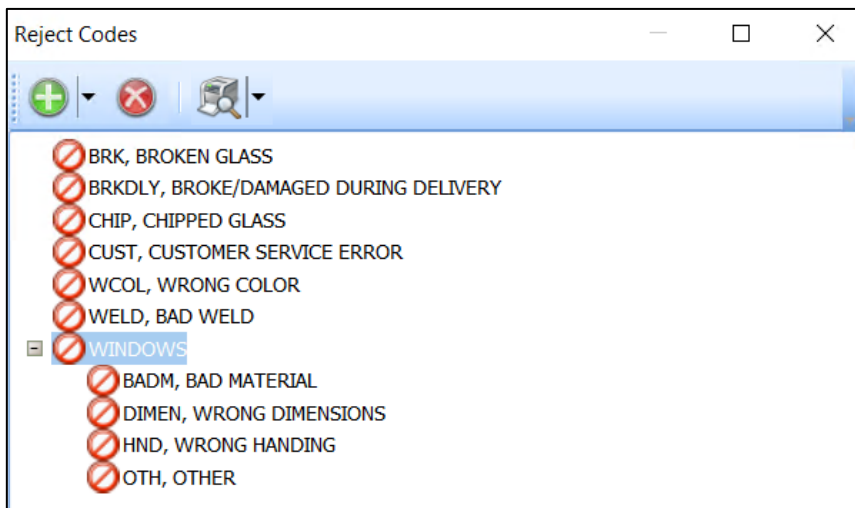
Reject Code Setup

Reject codes should be setup first before performing any configuration. These codes should be chosen carefully as these codes will be how rejects are tracked and reported. Codes can be added any time in the future as well. Reject codes can be created and managed in **Setup > Rejects > Codes**. The code is limited to 6 characters and is shorthand for the description of the code. The description is used to communicate a more detailed description of what the reject code means. (Once a code has been created, it cannot be modified)



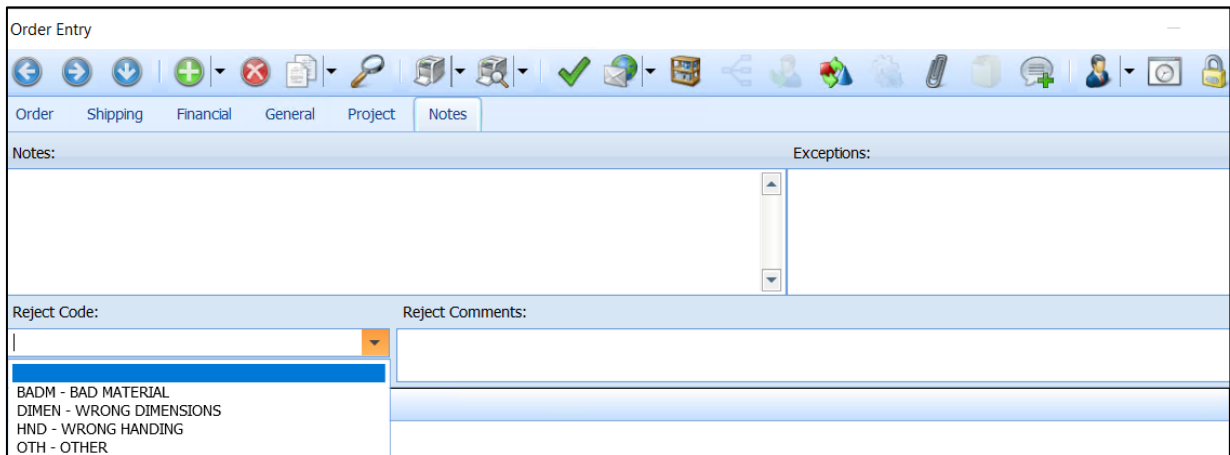


Advanced User Note: Adding reject codes to groups allows you to define what reject codes appear for each order type in order entry. In the example below, the group is "WINDOWS" and there are four reject codes that make up the group.



To accomplish this, the [OrderTypes] table in the [FVMaster] database must be customized with reject group assignments. Please contact FeneTech for help with this functionality. This is only necessary if the user wishes to display reject codes in Order Entry.

	OrderType	Description	Sequence	Flags	RejectGroup	rowguid
1	0	Quote	1	24	NULL	NULL
2	1	Order	2	15	Windows	NULL
3	2	Credit	3	0	NULL	NULL
4	3	Invoice Only	4	0	NULL	NULL
5	4	Manufacturing	5	7	NULL	NULL
6	5	Forecast	6	2	NULL	NULL
7	6	Pickup	7	4	NULL	NULL



In the example above, the “Windows” reject group is assigned to the standard order type. By assigning this group, the reject codes now appear under the “Notes” tab in Order Entry.

Part Types

Part types are used for many things throughout FeneVision®. They are used heavily when rejecting units on the floor. Part types are managed in Setup > Products > Part Types. The below image shows a standard set of reject part types for the windows industry. Please keep in mind that all the part types listed below may **not** be necessary for every implementation.

4000 – REJECTS (Part Type)

4001 – REJECT FRAME

4002 – REJECT IG (Insulated Glass)

4003 – REJECT KS (Keeper Sash)

4004 – REJECT LS (Lock Sash)

4005 – REJECT LLS (Left Lock Sash)

4006 – REJECT RLS (Right Lock Sash)

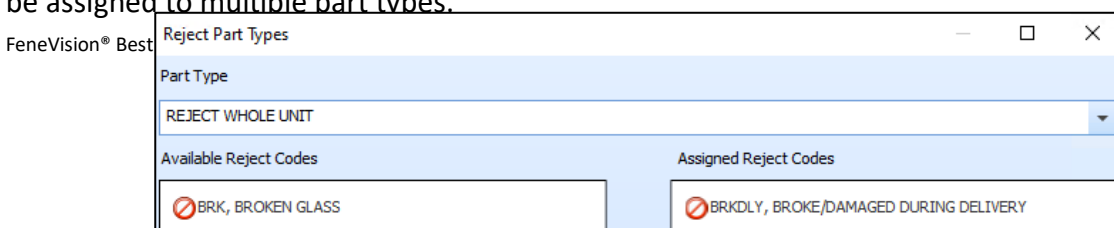
4007 – REJECT SCREEN (Reject Screen)

4008 – REJECT WHOLE UNIT (Reject Whole Window)

The ID numbers are not important but **must** be distinct. It is best practice to group these part types under a general reject part type (“REJECTS”).

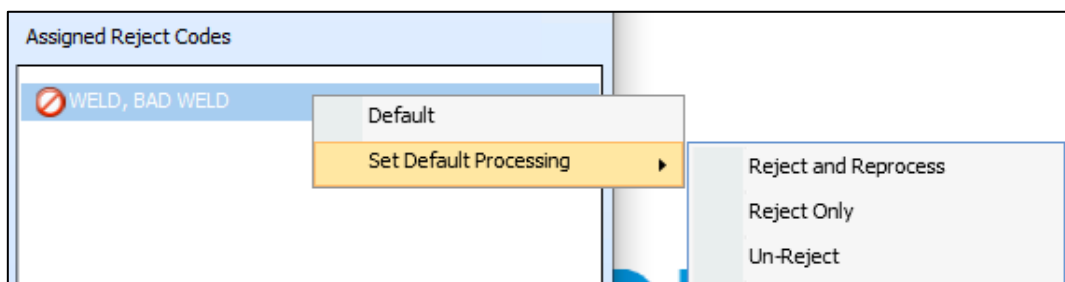
Reject Part Types

Now that you have reject codes and reject part types configured, those need to be linked together. This is done in Setup > Rejects > Part Types. From this screen, reject codes are assigned to part types. This is important as all reject codes should not be available for all reject part types. Reject codes can be assigned to multiple part types.



For example, a “BAD WELD” reject code should not be available for the “REJECT IG” part type, but instead should be assigned “REJECT WHOLE UNIT” or to the “REJECT FRAME” part type. Be selective when assigning reject codes to part types as the user can only see 4 to 5 reject codes at once and will be less willing to scroll through a long list to pick the correct code.

Once a reject code is assigned to a part type, it can be selected as the default for that part type by utilizing the right-click menu. Each reject code can also be assigned a default reject behavior. These defaults will affect the rejecting process in Tracking and Trucking.



Note: Default settings can be overridden per station as well. This will be explained below in the [Reject Stations](#) section.

Default Processing

For each reject code, you can define a default processing method that is selected when you choose a reject code in Tracking or Trucking. Each reject code can have its own default process. The same reject code can have a different default process per part type.

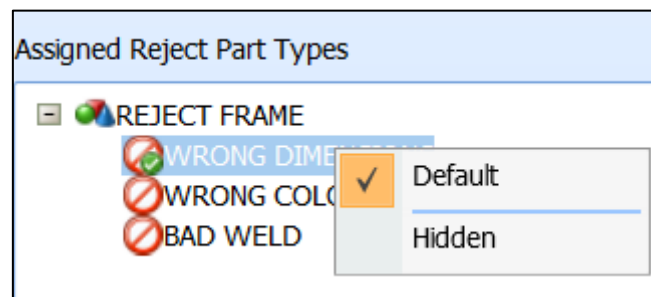
- **Reject and Reprocess** – If rejecting a finished good like an IG unit or a finished window, then the unit will be sent back into CORE to be remade as materials such as spacer and butyl must be consumed again. These units will be available to be rescheduled through the remakes screen in CORE and the office staff can determine if the unit needs to be reproduced in its

entirety or if only interface files need to be regenerated and sent to the floor. (The FeneVision Reject Monitor job must be enabled in FVPerformance)

- **Reject Only** – The unit will be rejected; however, it will continue its workflow. A practical application of this would be if the vinyl has a bad weld, but the floor worker can recut and reweld the vinyl without having to have the whole window remade. Once the vinyl is rewelded, it can then continue its original workflow.
 - a. *Note: The user does not have to un-reject and accept the window back at that station. Rather, the scan at the next station will allow the window to continue its workflow.*
- **Un-Reject** – Clears the rejecting flag. This is typically used if a unit was accidentally rejected.

Reject Tracking Stations

To reject at a Tracking station, reject part types must be assigned. This is done in Setup > Rejects > Stations. The assigned reject part types will determine which types the user can use at that station and thus which reject codes. Once assigned, part types and their corresponding reject codes can be defaulted using a right mouse click. As noted above, these defaults take precedence over Reject Part Types settings. Reject codes can also be hidden. This can be useful if a part type is used for multiple stations, but some of the reject codes should not be visible at both stations.



Standard Reject Station Part Types

Below are some example Window tracking stations and part types that are generally assigned.

Insulated Glass

Assigned Part Type(s): IG Unit part type (e.g., "REJECT IG")

Welding

Note: This is historically not a common tracking station, but when it is included these are the recommended part type assignments.

The unit has not been assembled yet, so sub-assemblies of the unit can be rejected.

Assigned Part Type(s): Vinyl part types (e.g., “REJECT KS”, “REJECT LS”, “REJECT FRAME”)

Glazing/Finishing or Trucking Station

The unit has been assembled, so the entire window can be rejected.

Assigned Part Type(s): Finished unit part type (e.g., “REJECT WHOLE UNIT”)

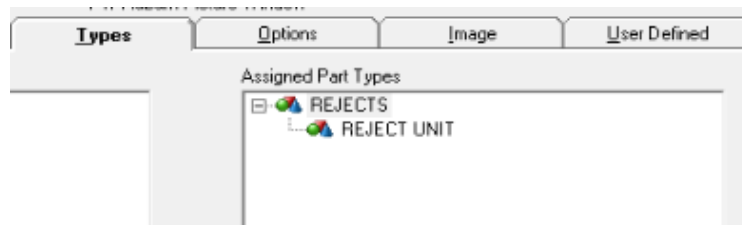
Part Setup

Part type assignment is done via Part Setup location in Setup > Products > Parts. These assignments are a crucial piece of configuration. There are several levels of the bill of material that require part type assignments.

Ordered Units

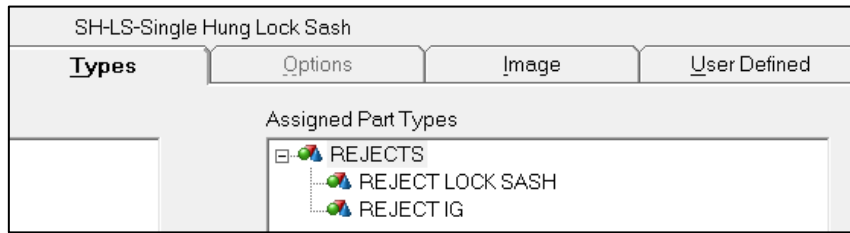
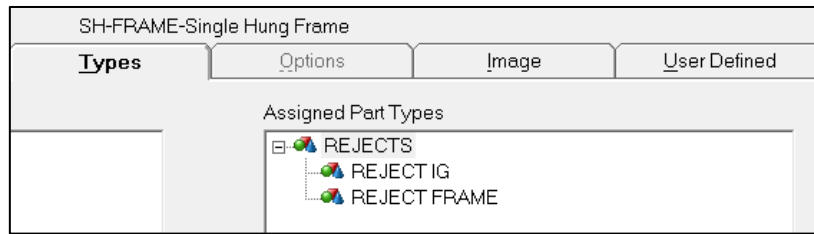
This level includes all window types in a standard configuration (i.e. Single Hung, Picture Window, Casement, etc.). Any parts using the main parts as a substitute part should have the same part type assignments.

The **REJECT UNIT** part type should be assigned at this top level.



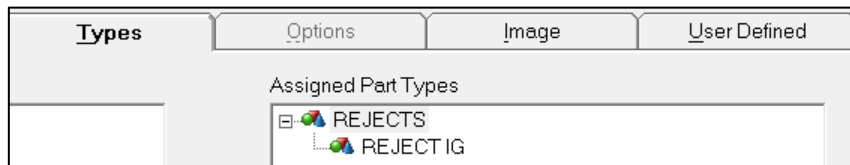
Frame and Sash Parts

The frame, lock sash and keeper sash should have their respective part types assigned and IG part types assigned. For example, the “SH-FRAME” subassembly should have the **REJECT FRAME** and **REJECT IG** part type assigned. The lock sash in a single hung should have the **REJECT LOCK SASH and REJECT IG** part type assigned. The reason the “SH-FRAME” and “SH-LS” need the reject IG part type is because rejecting works by looking down the bill of material to find matching part types.



IG Parts

Generally, the IG subassembly is shared across the system, so a single part type will handle of the IG rejecting. The “REJECT IG” part type needs to be assigned to all of the different IG parts.

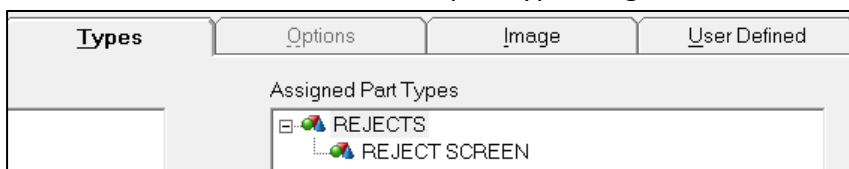


In the example above, the part type is assigned to the actual IG part (i.e. IG-CLCL-DS-A). This part is what is dragged into the IG label definition.

Note: IG rejecting can vary based on system configuration –please make sure to discuss with your project manager or reach out to Fenetech support.

Screen Parts

The screen parts will have the “REJECT SCREEN” part type assigned.



Tracking and Trucking Settings

This section will outline typical tracking station settings relating to rejecting of windows and IG units.

IG Station

The IG can be rejected at this station. Master and parent key rejecting is enabled because it allows the user to scan an IG and the system will know where the IG is in the BOM. For example, if you would scan the lock sash IG in a single hung the system would know to grab the correct IG based on SUMP.

Type: Tracking Station

Mode: Part Updating Mode

Reject All Sub-Assemblies: No

Enable Master and Parent Key Rejecting: Yes

Enable Reject Only: Yes

Welding Station

Note: This is historically not a common tracking station, but when it is included these are the settings.

The settings listed below are recommended for the welding station that is generally in the middle of the production line.

Type: Tracking Station

Mode: Ordered Part Updating

Reject All Sub-Assemblies: Yes

Enable Reject Only: Yes

Glazing or Finishing Station

These settings are recommended for a finishing or glazing station that is typically at the end of the product line.

Type: Tracking Station

Mode: Ordered Part Updating

Reject All Sub-Assemblies: Yes

Enable Reject Only: Yes

Trucking Station

No extra settings are required at the trucking station for rejecting

Additional Notes

1. Some interfaces (such as WinIG) require a more specific reject configuration that is not covered in this document. Please reach out to your PM or FeneTech for more specific details.
2. **Logon Required - Rejecting** – Anyone with a FeneVision® logon will be allowed to reject when this mode is on. There are no permissions that can be set for this.

Testing

1. A suggested test case would be to create an order with a few windows and release it to production and use a tracking station listed above to reject the whole unit. Confirm that you can “Reject and Reprocess” the unit.

- Verify that the status on the “Schedule Batch Detail” report in BI shows as “Reprocessing” with the reject code that was selected at the tracking station.
 - Open the “Remakes” screen in CORE and verify that you see the rejected unit listed.
2. Another testing scenario would be to use a different window from the order created above and utilize the “Reject Only” functionality.
 - Confirm that the status changes to “Rejected” on the “Schedule Batch Detail” report in BI.
 - Verify that the window can be scanned at another tracking station once the issue with the window has been corrected.

Troubleshooting/ FAQ

1. If you are not seeing any reject part types at a Tracking/Trucking station.
 - **Confirm part types are assigned to the specific part that is being scanned at the station**
 - **Verify that reject part types are assigned to the proper stations**
2. After rejecting and processing, the schedule is not showing up in the “Remakes” screen.
 - **Verify the FeneVision Reject Monitor job is enabled in FVPerformance**