

# SAMPLES: DIGITAL WORK INSTRUCTIONS WITH PROCESS CONTROL & DATA COLLECTION

## CLEAN & SANITIZE DRAINS

The screenshot shows a digital work instruction interface for the task "Clean & Sanitize Drains". The interface includes a header with "eFlex SYSTEMS Example Work Instructions", a user greeting "Welcome Terry\_Guire", and a "PART STATUS: Good" indicator. The main content area is divided into four numbered steps:

- Step 1:** "Spray to force debris into inner basket" (Image shows a person spraying a drain cover).
- Step 2:** "Dump inner basket into trash" (Image shows a person dumping debris from a basket into a red trash bin).
- Step 3:** "Spray baskets inside & out" (Image shows a person spraying a metal basket).
- Step 4:** "Replace baskets. Pour bleach into baskets & drain. Cover drain" (Image shows a person pouring bleach into a basket and covering a drain).

On the right side, there is a circular timer showing "6:16" (Actual Time) and "05:00s" (Target Time). Below the timer are buttons for "REJECT PART", "STOP", and "HOLD". On the left side, there are buttons for "OK" and "REJECT TASK". The bottom of the interface shows "Powered by eFlex Systems © 2019. Version 7.0.20190220-471s" and navigation options like "OOE", "GO OFFLINE", and "NOTES".

## INSPECT EQUIPMENT TO SEE IF PARTS MUST BE REPLACED

The screenshot shows a digital work instruction interface for the task "Inspect Bottle Grippers". The interface includes a header with "eFlex SYSTEMS Example Work Instructions", a user greeting "Welcome Terry\_Guire", and a "PART STATUS: Good" indicator. The main content area features three images illustrating inspection points:

- Image 1:** Shows a gripper arm with a red "X" and the text "BENT ARM: Leads to misfeeds & jams".
- Image 2:** Shows a gripper on a bottle with a red "X" and the text "HEAVILY WORN: When gripper no longer wraps around bottle but only touches sides, bottle can come out easily as Filler rotates & bottle fills".
- Image 3:** Shows a gripper on a bottle with a red "X" and a yellow callout box that says "Gripper may be worn but should curve around to hold bottle on both sides".

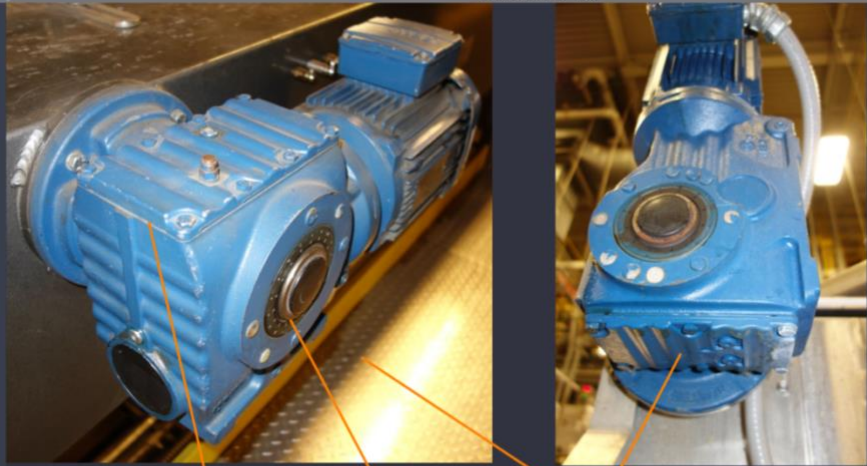
On the right side, there is a circular timer showing "5:48" (Actual Time) and "05:00s" (Target Time). Below the timer are buttons for "REJECT PART", "STOP", and "HOLD". On the left side, there are buttons for "OK" and "REJECT TASK". The bottom of the interface shows "Powered by eFlex Systems © 2019. Version 7.0.20190220-471s" and navigation options like "OOE", "GO OFFLINE", and "NOTES".

## CLEAN & SANITIZE DRAINS

eFlex SYSTEMS Example Work Instructions >Welcome Terry\_Guire

STEP 14 / 21 MODEL: 1 SERIAL NUMBER: e5 PART STATUS: Good

DESCRIPTION  
Check Gearboxes for Leakage



OK  
REJECT TASK

Oil not leaking from seals  
Oil not dripping out of bearing  
No drops of oil on underside, or on floor

*Gearboxes not from Filler area but illustrate correct condition*

5:37  
ACTUAL TIME  
05 M 00 S  
TARGET TIME  
REJECT PART  
STOP  
HOLD

Powered by eFlex Systems © 2019. Version 7.0.20190520-471s

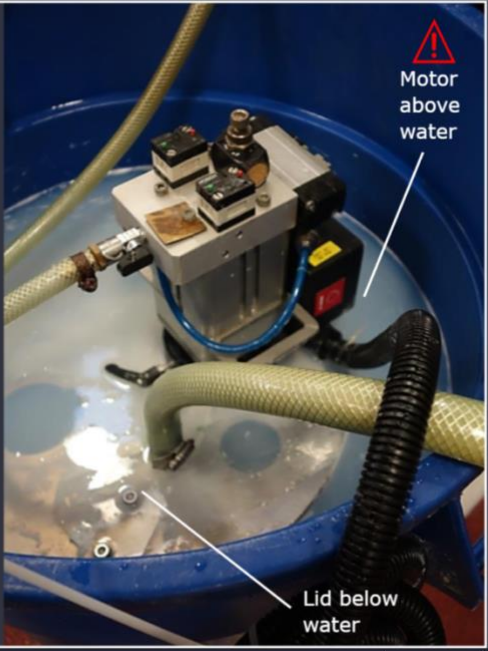
OEE GO OFFLINE NOTES

## SOAK PUMP DURING EQUIPMENT CLEANING


eFlex SYSTEMS Example Work Instructions Welcome Terry\_Guire

STEP 3 / 21 MODEL: 1 SERIAL NUMBER: e5 PART STATUS: Good

DESCRIPTION  
Soak Pump  
COUNTDOWN 3600  
3591



1. Fill glue bucket with hot water

2.  Place pump into bucket, lid side down, without submerging motor

3. Turn pump on

Motor above water  
Lid below water

OK  
REJECT TASK

1:08  
ACTUAL TIME  
05 M 00 S  
TARGET TIME  
REJECT PART  
STOP  
HOLD

Powered by eFlex Systems © 2019. Version 7.0.20190520-471s

OEE GO OFFLINE NOTES

## EQUIPMENT SETUP DURING MACHINING OPERATION

The screenshot shows the eFlex Systems software interface for a machining operation. The top bar includes the eFlex logo, 'Example Work Instructions', 'Welcome Terry\_Guire', and navigation icons. The main area displays 'STEP 6 / 21', 'MODEL: 1', 'SERIAL NUMBER: e5', and 'PART STATUS: Good'. The description is 'Center Slot at Tip of Part'. A central video frame shows a drill bit being used on a part, with a yellow box highlighting the tip and a yellow callout box stating: 'If slot not centered at tip of part, result = scrap!'. A circular timer on the right shows '238' and 'ACTUAL TIME 05\_M 00\_S TARGET TIME'. Below the timer are buttons for 'REJECT PART', 'STOP', and 'HOLD'. At the bottom left are 'OK' and 'REJECT TASK' buttons. The bottom status bar includes 'Powered by eFlex Systems © 2019. Version 7.0.20190520-471s', 'OEE', 'GO OFFLINE', and 'NOTES'.

## ALIGNMENT OF PRODUCT PRIOR TO MEASUREMENT – MEDICAL DEVICE PRODUCT

The screenshot shows the eFlex Systems software interface for a medical device product. The top bar includes the eFlex logo, 'Example Work Instructions', 'Welcome Terry\_Guire', and navigation icons. The main area displays 'STEP 10 / 21', 'MODEL: 1', 'SERIAL NUMBER: e5', and 'PART STATUS: Good'. The description is 'Align U-Shaped Balloons'. A central video frame shows two views of a U-shaped balloon in an alignment holder. The left view is marked with a green checkmark and a green box stating: '"U" is downward toward alignment holder'. The right view is marked with a red X and a red box stating: '"U" curves to either side'. A circular timer on the right shows '359' and 'ACTUAL TIME 05\_M 00\_S TARGET TIME'. Below the timer are buttons for 'REJECT PART', 'STOP', and 'HOLD'. At the bottom left are 'OK' and 'REJECT TASK' buttons. The bottom status bar includes 'Powered by eFlex Systems © 2019. Version 7.0.20190520-471s', 'OEE', 'GO OFFLINE', and 'NOTES'.

## ADJUSTMENT OF MAGAZINE IN PACKAGING MACHINE

The screenshot shows the eFlex Systems software interface for a task titled "Carton Wheel Adjustment". The interface includes a top navigation bar with the eFlex logo, "Example Work Instructions", and user information "Welcome Terry\_Guire". The main content area features a video feed of a machine component with two callouts: "1 Loosen/Tighten to allow wheel position adjustment" and "2 When wheel set correctly, this sensor is only halfway blocked (as shown)". On the left, the step counter shows "1 / 21" and the description "Carton Wheel Adjustment". On the right, a circular timer displays "119" with "ACTUAL TIME 05\_M 00\_S" and "TARGET TIME". Below the timer are buttons for "REJECT PART", "STOP", and "HOLD". At the bottom, there are buttons for "OK" and "REJECT TASK", and a status bar with "OEE", "GO OFFLINE", and "NOTES".

## ASSEMBLY OF FEED HOPPER IN PHARMACEUTICAL

The screenshot shows the eFlex Systems software interface for a task titled "Assemble Feed Hopper". The interface includes a top navigation bar with the eFlex logo, "Example Work Instructions", and user information "Welcome Terry\_Guire". The main content area features a sequence of five numbered images illustrating the assembly steps: "1 Install feed screw", "2 Install rear hopper seal", "3 Install feed hopper", "4 Clamp feed hopper", and "5 Insert feed screw". On the left, the step counter shows "13 / 21" and the description "Assemble Feed Hopper". On the right, a circular timer displays "506" with "ACTUAL TIME 05\_M 00\_S" and "TARGET TIME". Below the timer are buttons for "REJECT PART", "STOP", and "HOLD". At the bottom, there are buttons for "OK" and "REJECT TASK", and a status bar with "OEE", "GO OFFLINE", and "NOTES".