Rework

03/10/2024 11:25 am BST

It is sometime necessary to do rework on an item that is in a workflow. There are three ways of recording rework time:

1. Rework managed through pre-defined flows as described in the scenarios below.
2. Using the toggle rework functionality for ad hoc rework which can be toggled at any operation without defining any additional flows.
3. Retrospective work that was opened for rework.

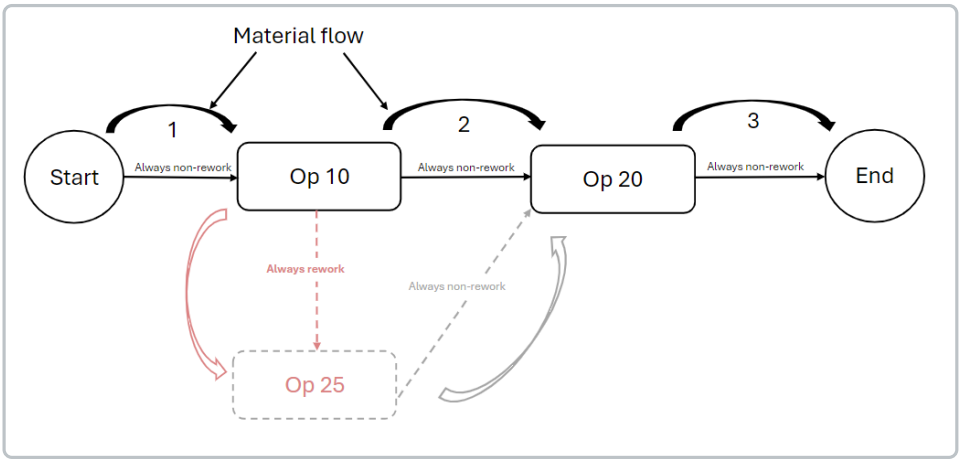
When someone is working on an operation, that work is either defined as non-rework or rework. Whether it is non-rework or rework is controlled by the settings of the flows into the nodes. There are three settings:

- Always non-rework
- Always rework
- Auto (could be non-rework or rework)

Here are some examples of flows for non-rework and rework scenarios:

Non-rework

This flow does not contain any rework.



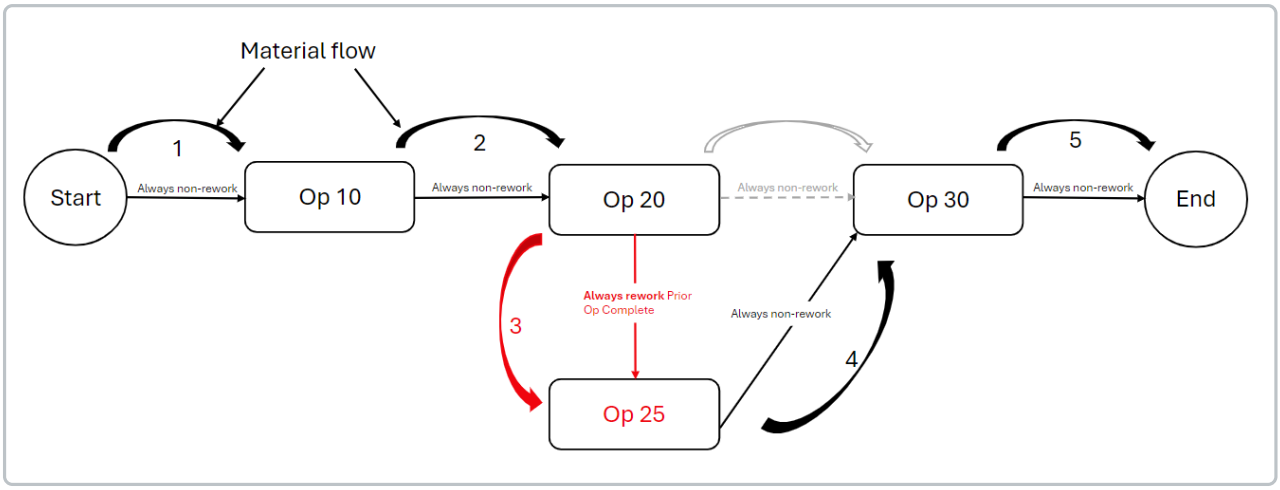
The faded flows and operations represent rework scenarios that are discussed in detail below.

Points relevant for this scenario (*numbers relate to the material flows in the diagram*):

2 - For flow 2, Op 10 is going to be complete and Op 20 will always be non-rework.

Rework (scenario 1)

In this scenario, the rework flow was initiated at Op 20.



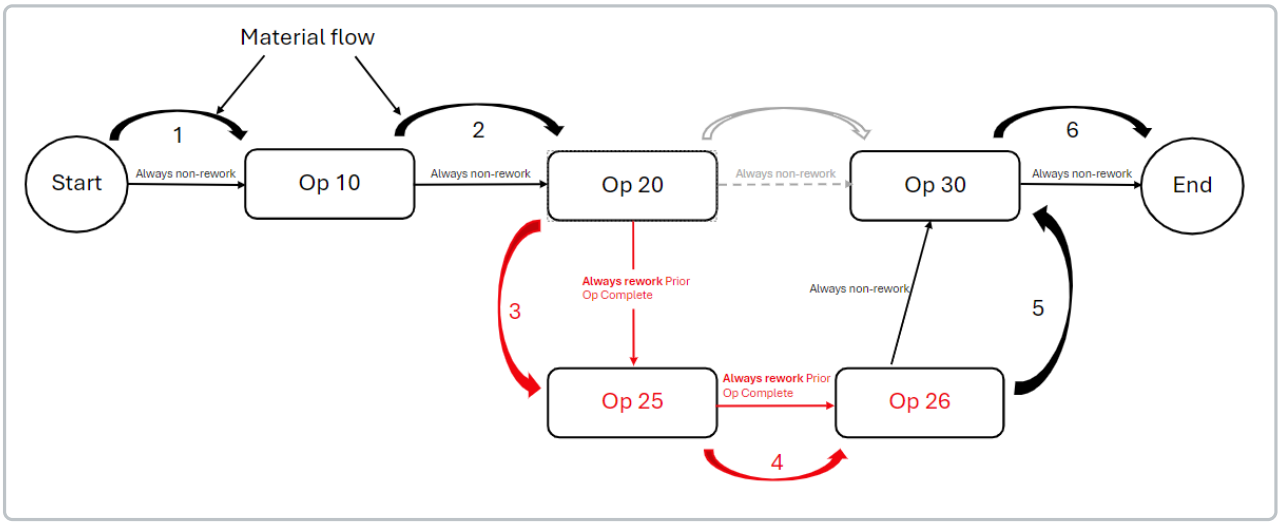
Points relevant for this scenario (*numbers relate to the material flows in the diagram*):

3 - Failure at Op 20. When we flow down 3, we will always be starting rework. Op 20 will always be complete because we proceed from rework (Op 25) to Op 30 and never return to Op 20.

4 - Although Op 25 was rework, when we go down flow 4 we will not return to Op 25 so it's complete and Op 30 is always going to be non-rework.

Rework (scenario 2)

In this scenario, two operations are required within the rework flow.

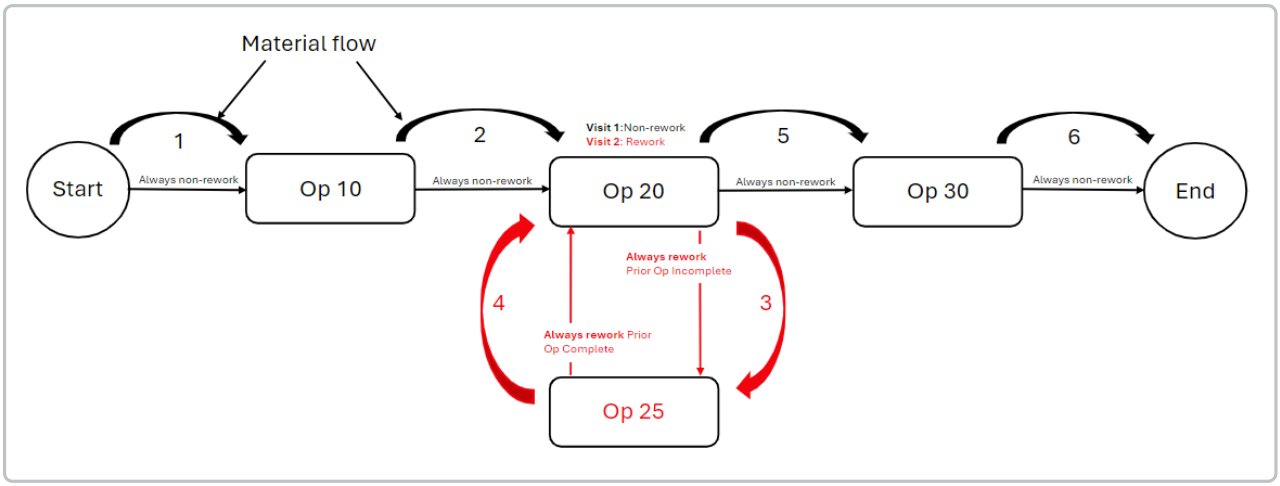


Points relevant for this scenario (*numbers relate to the material flows in the diagram*):

4 - For flow 4 we know that Op 26 is always going to be rework and Op 25 is going to always going to be complete.

Rework (scenario 3)

After rework is completed, you return to the same operation.



Points relevant for this scenario (*numbers relate to the material flows in the diagram*):

3 - Failure at Op 20. For flow 3, Op 25 will always be rework and Op 20 is incomplete because the flow always returns to Op 20.

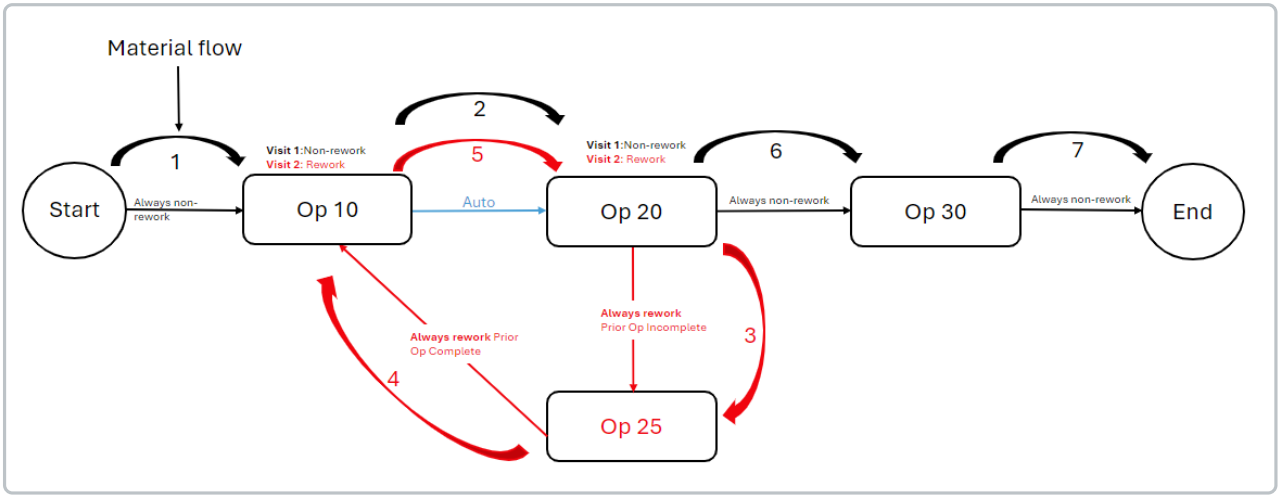
4 - On flow 4, Op 20 will always be rework and Op 25 will always be complete.

5 - Flow 5 will never be rework.

Auto (non-rework/rework)

Auto sets the rework status based on where the item has come from and whether you are repeating the operation.

Some operations need to be repeated after rework was completed. Auto evaluates the visits to the operations to determine if it's non-rework or rework. If the Op 10 visit was non-rework, then Op 20 will be non-rework and vice-versa. The diagram describes the two possible flows.



Auto: Work going through Op 10 and Op 20 could be non-rework (the black flow) or rework (the red flow).

The settings of the flows into Op 10 and Op 20 determine if it's non-rework or rework.

Points relevant for this scenario (*numbers relate to the material flows in the diagram*):

2 - The first visit at Op 20 (flow 2) will always be non-rework.

3 - Failure at Op 20 will trigger the *Always rework - Prior Op Incomplete* flow to create a rework visit at Op 25.

4 - Op 25 is always completed and flow 4 triggers a second visit at Op 10 which is rework - *Always rework - Prior Op Complete*.

5 - Flow 5 triggers a second visit to Op 20 which is flagged as a rework visit. Flow 5's rework setting is configured as "Auto" which means that the rework flag is carried forward because the visit to Op 10 we are flowing from was rework.

6 - Completing the rework visit at Op 20 completes the rework and Op 30 is always non-rework.