"P"artition or "R"oll Fed Partition. When the style type is a P or R, the

partition machine with a feed type of "A" or "P" will search the Set Header

Width, Length and Depth for machine limitation. The Set Length will be

compared to the Front to Back machine limits. The Set Width will be compared to the assembly machines side to side dimension and the Set depth will be compared to the machine limitations caliper min and max dimensions.

See Attached Image of a Partition Die which cuts the Slot in a Partition

(Strip).

E-B-13 Machine Attachment allows definition of Partition Dies. Estimators enters L x W x D, Long Style, Short Style, Cell Sizes and Board Code. The Spec Tab - OverRide Button on the Blank W and L houses the Cell Sizes and Total Length and Width of each Strip. The Board Code has a Caliper Thickness field in the Raw Material File. The Style File houses the Total number of Slots which will be transferred to the Qty per Adder to the Machine on the Prep/Route Tab. The field called Qty On Hand in the E-B-13 Attachments file must be equal to or greater the number of partition dies needed for the set. The total number of Partitions dies for the job are equal to the the Total Slots from the Style file. The Style file also has the will have a Machine Routing defined which picks the Machines for the estimate. When adding an estimate via the Assemble Partition Button, the program calculates the size of each partition and imports the machine rounting. After importing Machines on Route Tab, program will import Machine Attachments (E-B-13) based on each Blanks Height and Length. For each machine on Estimates Route Tab, the program will import the Adder/Dies and the Adder Qty (Number of Slots which may be for Both Partitons if 1 Form on

SET button. If program cannot find a DIE, then we will display a warning,

Partition Cannot be Made. Exact Dies and Quantity of Die will be added to the Estimate Routing Folder under the ADDER1, ADDER2 and ADDER 3 for each Form for each machine. The estimator can add or change the DIE on the Routing Folder via the OVERRIDE button. The EB13 file also has logic to modify setup and run speeds for specific Partition Dies. The Import Button on the Prep/Route Tab can be used to add or change dies. Once estimate builds rounting machines then program will import Die Attachements for P Styles. Then import Adder qty, additional setup hours and run speed reduction.