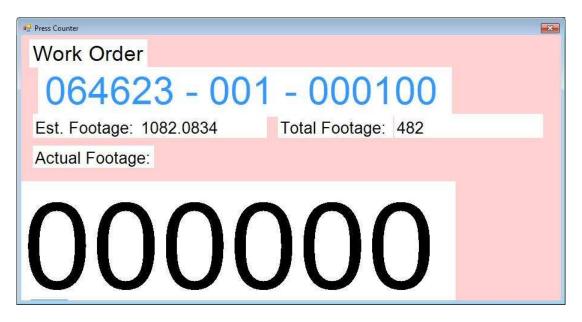
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PROCESS DOCUMENTATION AND TRAINING

On Line System > Transactions > Shop Floor Data Collection (GUI)

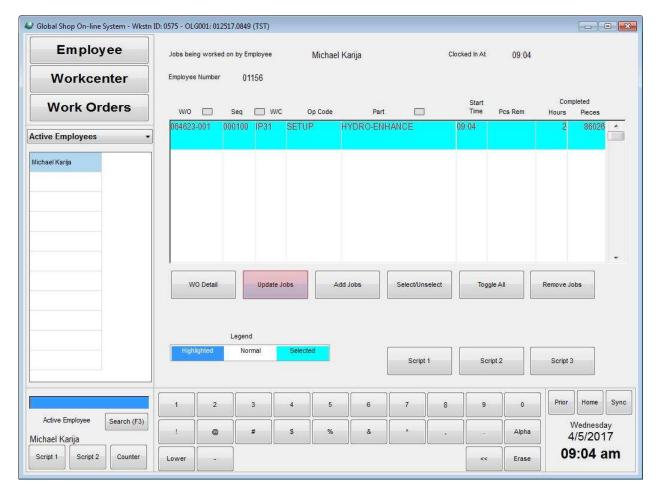
Counter Screen



This screen comes up after "start job(scanned)", it will show the estimated footage for the sequence on that job.

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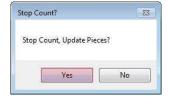
Click Update Jobs Button



When this is pressed, a message will appear on the counter to "Stop?"

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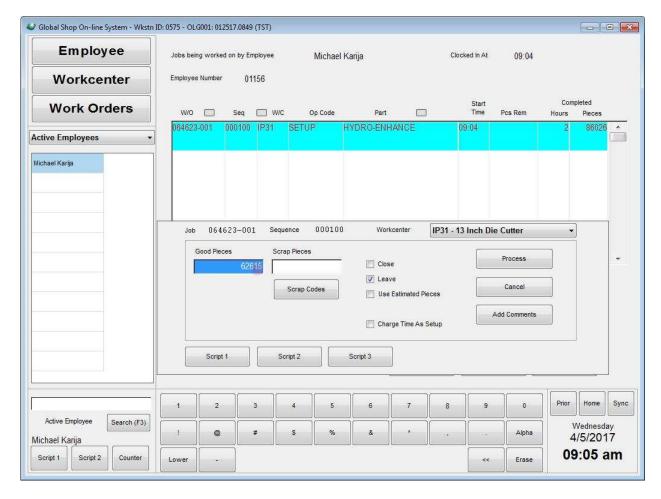
Click Yes Button



When "Yes" is clicked to stop counter, screen will close and good pieces will be calculated.

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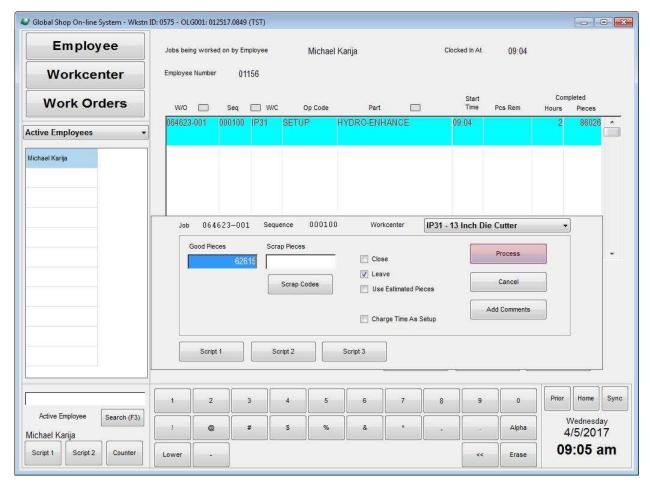
Calculate Good Pieces



When the counter calculates good pieces, it will look for an op code starting with: "LF/". A message is sent to the PLC again to get the current linear feet count, that number is multiplied by the estimated qty of raw material to-make 1 from JOB_OPERATIONS for that job, suffix, sequence.

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Click Process Button



Update job as normal.