

PROCESS DOCUMENTATION AND TRAINING

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

Counter Screen



Press Counter

Work Order

064623 - 001 - 000100

Est. Footage: 1082.0834 Total Footage: 482

Actual Footage:

000000

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

Click Update Jobs Button

[illegible]

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

Click Yes Button



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

Calculate Good Pieces

Global Shop On-line System - Wkstn ID: 0575 - OLG001: 012517.0849 (TST)

Employee Jobs being worked on by Employee Michael Karja Clocked In At 09:04

Workcenter Employee Number 01156

Work Orders

Active Employees

Michael Karja

W/O	Seq	W/C	Op Code	Part	Start Time	Pcs Rem	Completed Hours	Pieces
064623-001	000100	IP31	SETUP	HYDRO-ENHANCE	09:04		2	86026

Job 064623-001 Sequence 000100 Workcenter IP31 - 13 Inch Die Cutter

Good Pieces 62615 Scrap Pieces

Scrap Codes

☐ Close ☒ Leave ☐ Use Estimated Pieces ☐ Charge Time As Setup

Process Cancel Add Comments

Script 1 Script 2 Script 3

Active Employee Search (F3)

Michael Karja

Script 1 Script 2 Counter

1 2 3 4 5 6 7 8 9 0

! @ # \$ % & * , . Alpha

Lower Erase

Prior Home Sync

Wednesday 4/5/2017 09:05 am

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.

Click Process Button

Global Shop On-line System - Wkstn ID: 0575 - OLG001: 012517.0849 (TST)

Employee

Jobs being worked on by Employee: Michael Karja

Clocked In At: 09:04

Employee Number: 01156

Workcenter

Work Orders

Active Employees: Michael Karja

W/O	Seq	W/C	Op Code	Part	Start Time	Pcs Rem	Completed Hours	Pieces
064623-001	000100	IP31	SETUP	HYDRO-ENHANCE	09:04		2	86026

Job: 064623-001 Sequence: 000100 Workcenter: IP31 - 13 Inch Die Cutter

Good Pieces: 62615

Scrap Pieces:

Scrap Codes:

☐ Close

☒ Leave

☐ Use Estimated Pieces

☐ Charge Time As Setup

Process

Cancel

Add Comments

Script 1 Script 2 Script 3

Active Employee: Michael Karja

Search (F3)

Script 1 Script 2 Counter

1 2 3 4 5 6 7 8 9 0

! @ # \$ % & * , . Alpha

Lower

Priority Home Sync

Wednesday 4/5/2017 09:05 am

Update job as normal.