DGS

(DATA GATE SYSTEM)

MANUAL

INDEX

1. Login to DGS

PK2 (public IP): http://125.234.135.55:82/

PK3 (public IP): http://27.65.197.213:82/

PKJoon (public IP) : http://203.113.151.194:82/

PKMT (public IP): http://125.234.137.172:82/

PKBT (public IP): http://125.234.106.171:82/

PKGB (public IP): http://183.81.158.136:82/

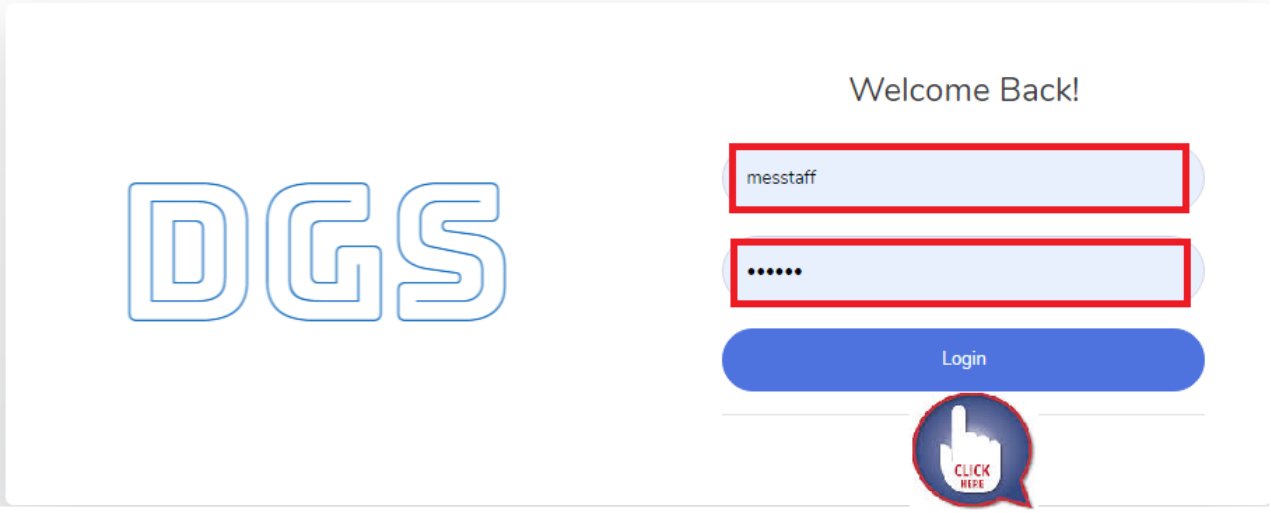
PKMM (public IP): http://43.242.135.203:82/

PKSB (public IP): http://183.81.154.206:82/

Input user: messtaff
Pass:123456

Click < Login button> to login

Using general user for login, if each factory need a private user you may send ID to ERP team for registering the right to login it.

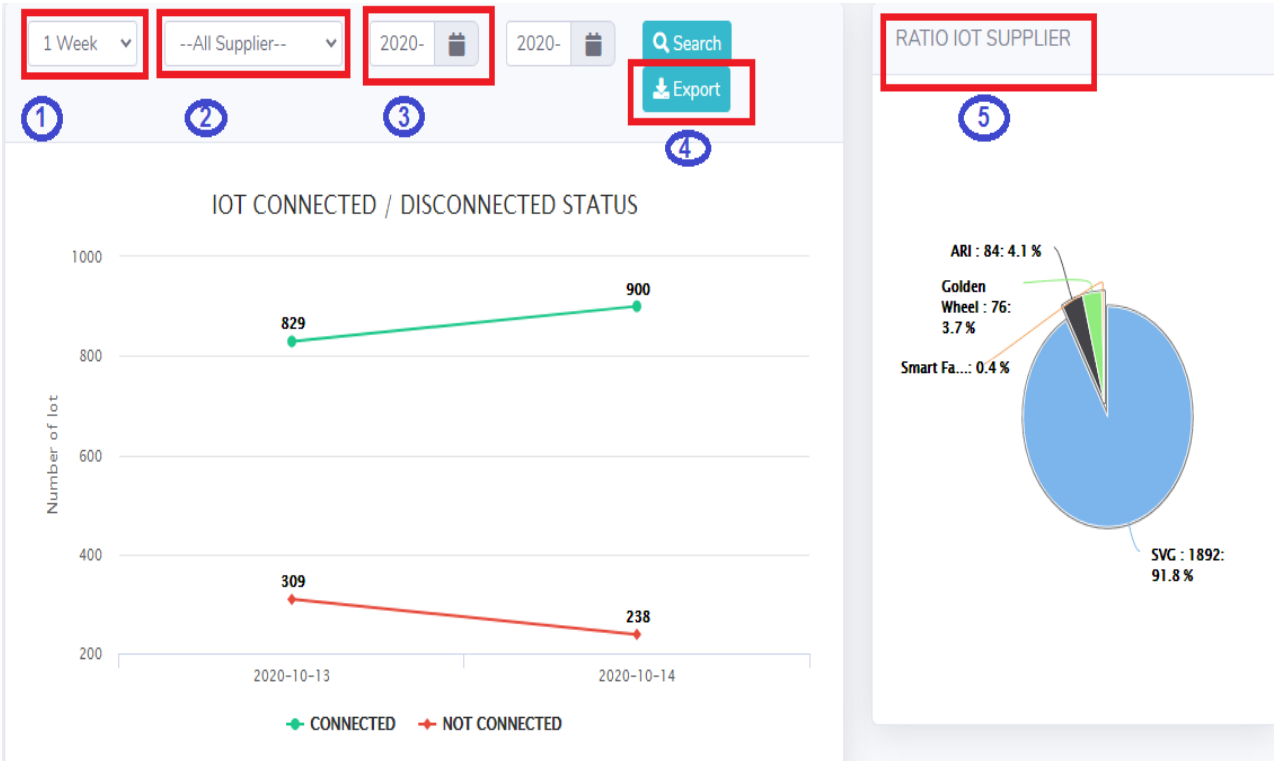


2. Dash board

***Description*: Able to show up IOT connected / disconnected status by chart.**

1. Selecting by week. The data is saved within 3 weeks
2. Selecting a specific supplier to search
3. Selecting the previous date or current date and then search it
4. Exporting excel file to see data
5. Ratio IOT is calculated as IOT supplier / sum of IOT *100%

- ***Green color showing connected quantity and red color showing disconnected quantity.***



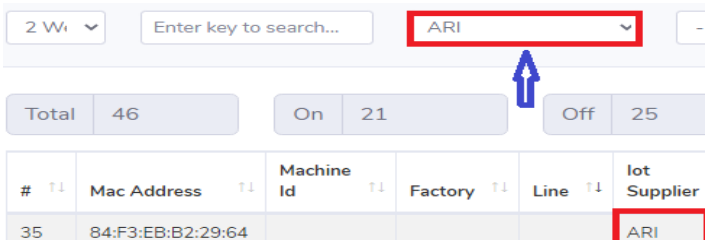
3. IOT Status

***Description*: Able to display IOT status. Those information is connected with IOT using network.**

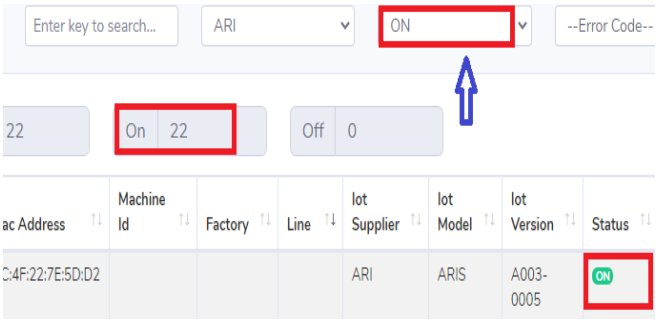
1. Selecting by week. The data is saved within 3 weeks

2. It could be searched information as Mac address, Machine ID, Factory, Line.

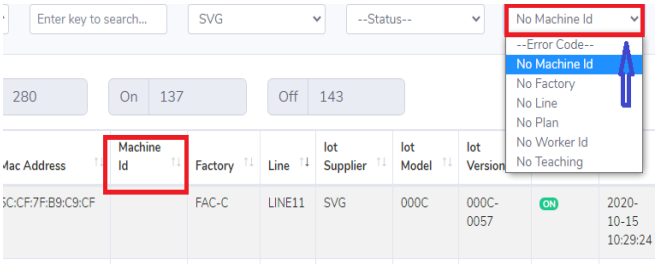
3. Selecting which supplier need to search



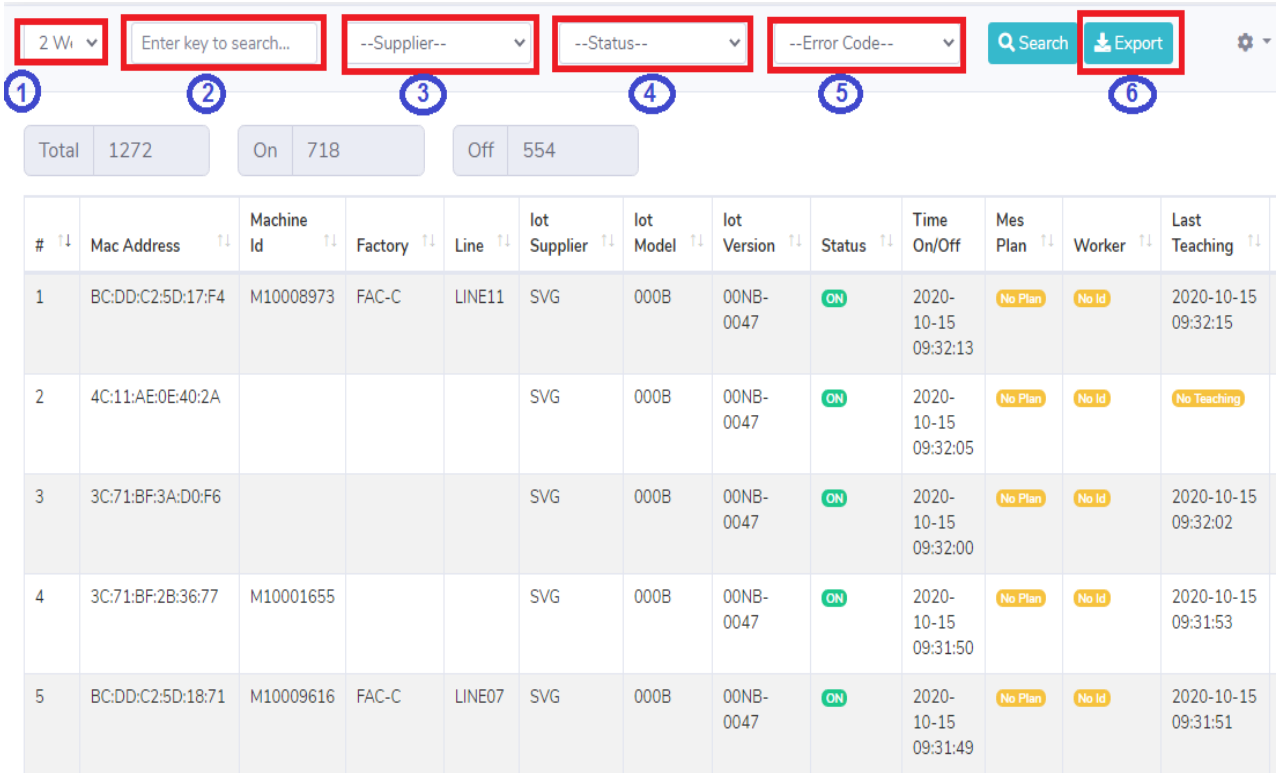
4. Selecting ON or OFF to know quantity and status



5. Selecting which error code to search



6. Export excel file



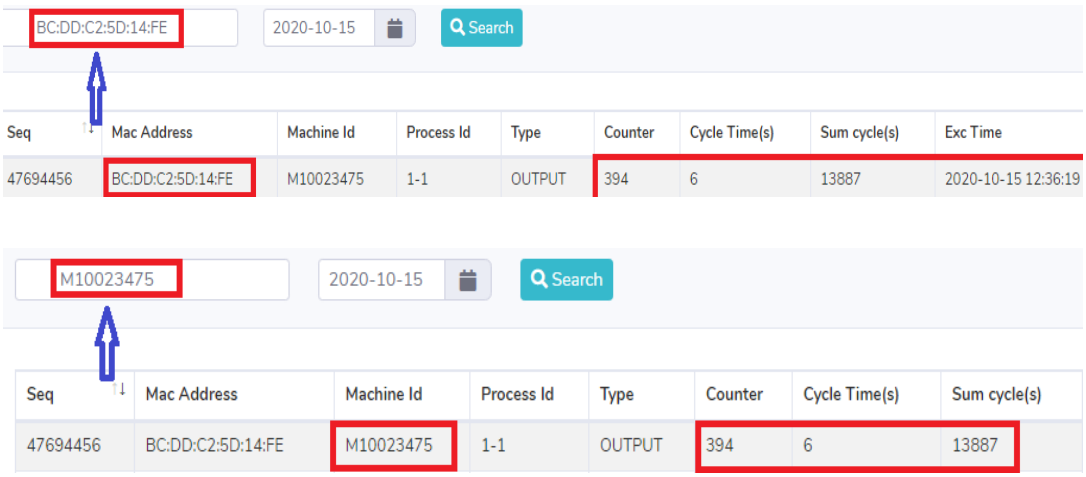
#	Mac Address	Machine Id	Factory	Line	Iot Supplier	Iot Model	Iot Version	Status	Time On/Off	Mes Plan	Worker	Last Teaching
1	BC:DD:C2:5D:17:F4	M10008973	FAC-C	LINE11	SVG	000B	00NB-0047	ON	2020-10-15 09:32:13	No Plan	No Id	2020-10-15 09:32:15
2	4C:11:AE:0E:40:2A				SVG	000B	00NB-0047	ON	2020-10-15 09:32:05	No Plan	No Id	No Teaching
3	3C:71:BF:3A:D0:F6				SVG	000B	00NB-0047	ON	2020-10-15 09:32:00	No Plan	No Id	2020-10-15 09:32:02
4	3C:71:BF:2B:36:77	M10001655			SVG	000B	00NB-0047	ON	2020-10-15 09:31:50	No Plan	No Id	2020-10-15 09:31:53
5	BC:DD:C2:5D:18:71	M10009616	FAC-C	LINE07	SVG	000B	00NB-0047	ON	2020-10-15 09:31:49	No Plan	No Id	2020-10-15 09:31:51

4. Sewing machine

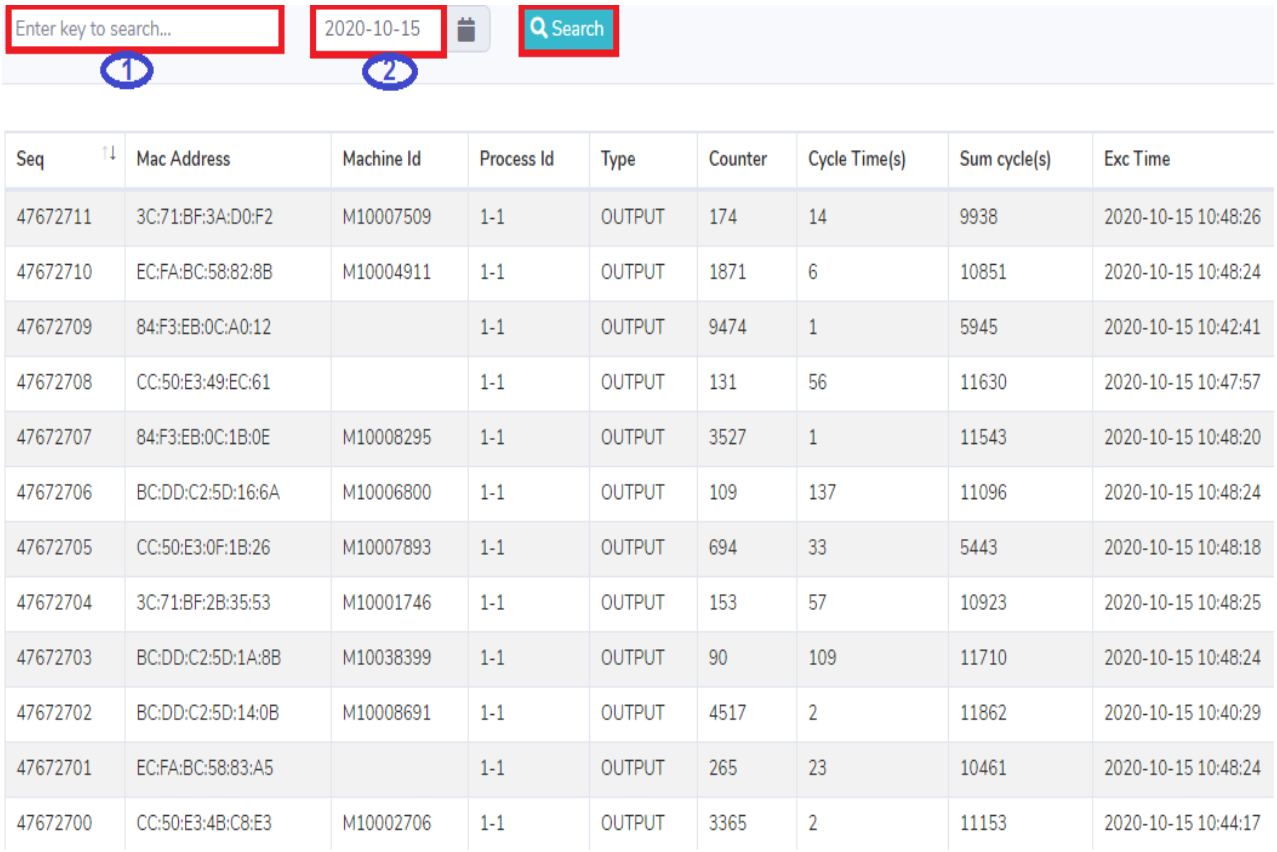
4.1 Sewing counter

***Description*: Able to display counter, cycle time, Exc time sent data to server.**

1. It could be searched by Mac address, Machine ID to see counter, cycle time.



2. Selecting current date or tracking history of previous days to see data

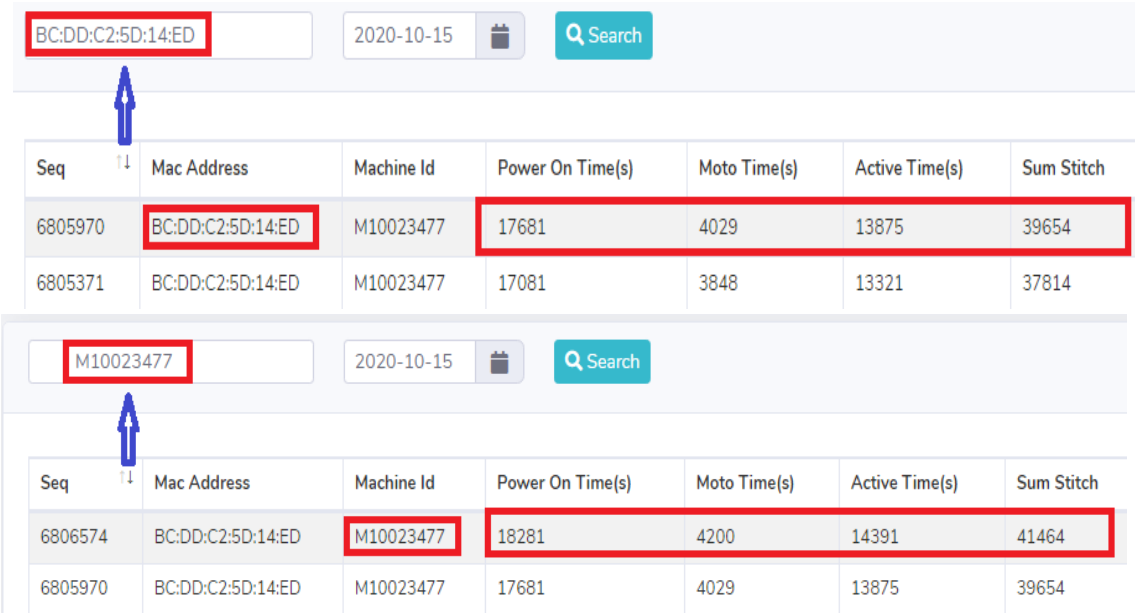


Seq	Mac Address	Machine Id	Process Id	Type	Counter	Cycle Time(s)	Sum cycle(s)	Exc Time
47672711	3C:71:BF:3A:D0:F2	M10007509	1-1	OUTPUT	174	14	9938	2020-10-15 10:48:26
47672710	EC:FA:BC:58:82:8B	M10004911	1-1	OUTPUT	1871	6	10851	2020-10-15 10:48:24
47672709	84:F3:EB:0C:A0:12		1-1	OUTPUT	9474	1	5945	2020-10-15 10:42:41
47672708	CC:50:E3:49:EC:61		1-1	OUTPUT	131	56	11630	2020-10-15 10:47:57
47672707	84:F3:EB:0C:1B:0E	M10008295	1-1	OUTPUT	3527	1	11543	2020-10-15 10:48:20
47672706	BC:DD:C2:5D:16:6A	M10006800	1-1	OUTPUT	109	137	11096	2020-10-15 10:48:24
47672705	CC:50:E3:0F:1B:26	M10007893	1-1	OUTPUT	694	33	5443	2020-10-15 10:48:18
47672704	3C:71:BF:2B:35:53	M10001746	1-1	OUTPUT	153	57	10923	2020-10-15 10:48:25
47672703	BC:DD:C2:5D:1A:8B	M10038399	1-1	OUTPUT	90	109	11710	2020-10-15 10:48:24
47672702	BC:DD:C2:5D:14:0B	M10008691	1-1	OUTPUT	4517	2	11862	2020-10-15 10:40:29
47672701	EC:FA:BC:58:83:A5		1-1	OUTPUT	265	23	10461	2020-10-15 10:48:24
47672700	CC:50:E3:4B:C8:E3	M10002706	1-1	OUTPUT	3365	2	11153	2020-10-15 10:44:17

4.2 Machine Time

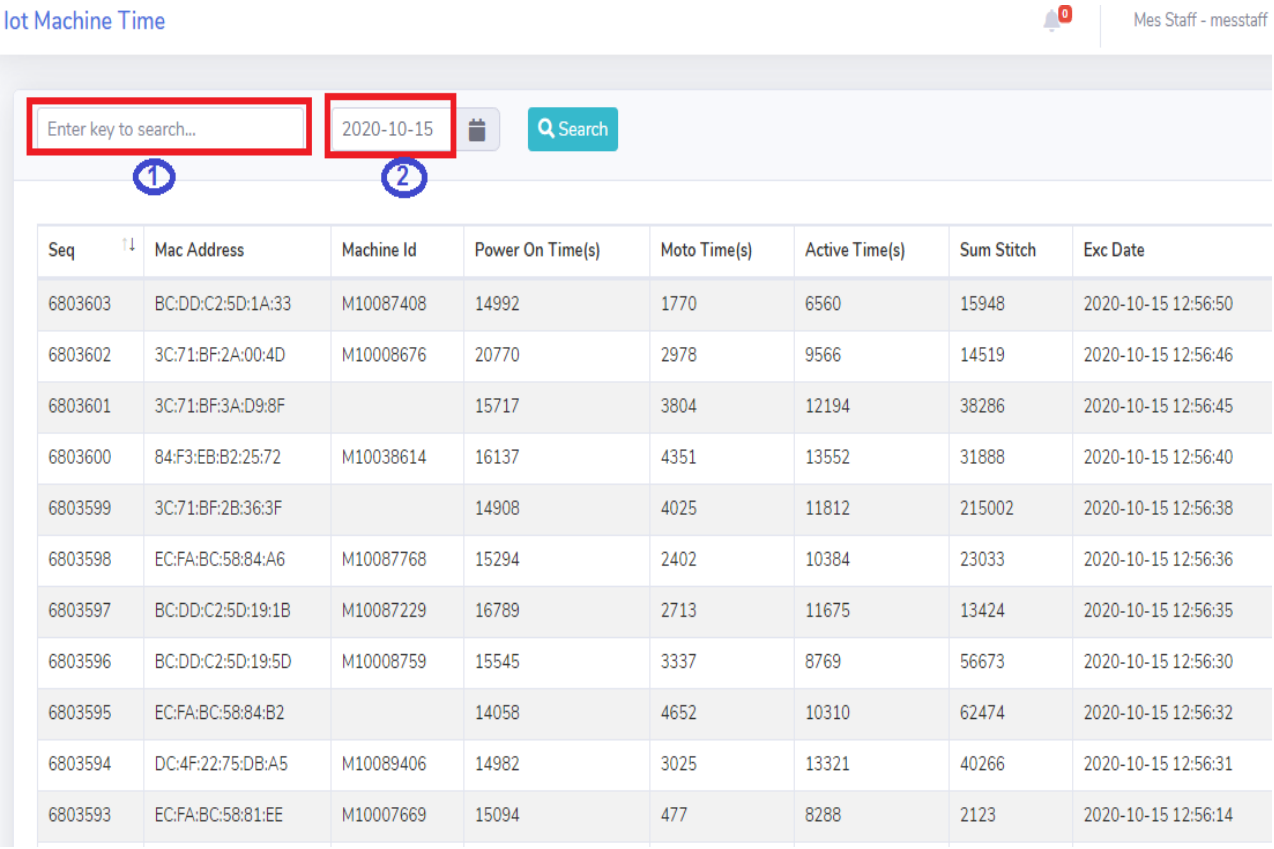
***Description*: Able to display Power time, Motor time, Active time, Sum of stitch, Exc date sent data to server.**

1. It could be searched by Mac address, Machine ID to see Power on time, Motor time, Active time, sum of stitch



2. Selecting current date or tracking history of previous days to see data

- ***Power on time:* It is calculated time when machine turned on**
- ***Motor time*: It is calculated time of operated motor**
- ***Active time:* It is real working time , including motor runtime and handling time.**
- ***Sum stitch:* It is calculated stitch total of IOT**

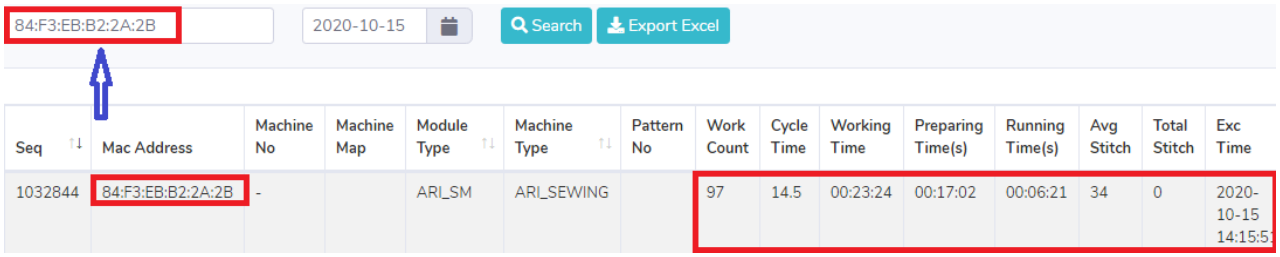


Seq	Mac Address	Machine Id	Power On Time(s)	Moto Time(s)	Active Time(s)	Sum Stitch	Exc Date
6803603	BC:DD:C2:5D:1A:33	M10087408	14992	1770	6560	15948	2020-10-15 12:56:50
6803602	3C:71:BF:2A:00:4D	M10008676	20770	2978	9566	14519	2020-10-15 12:56:46
6803601	3C:71:BF:3A:D9:8F		15717	3804	12194	38286	2020-10-15 12:56:45
6803600	84:F3:EB:B2:25:72	M10038614	16137	4351	13552	31888	2020-10-15 12:56:40
6803599	3C:71:BF:2B:36:3F		14908	4025	11812	215002	2020-10-15 12:56:38
6803598	EC:FA:BC:58:84:A6	M10087768	15294	2402	10384	23033	2020-10-15 12:56:36
6803597	BC:DD:C2:5D:19:1B	M10087229	16789	2713	11675	13424	2020-10-15 12:56:35
6803596	BC:DD:C2:5D:19:5D	M10008759	15545	3337	8769	56673	2020-10-15 12:56:30
6803595	EC:FA:BC:58:84:B2		14058	4652	10310	62474	2020-10-15 12:56:32
6803594	DC:4F:22:75:DB:A5	M10089406	14982	3025	13321	40266	2020-10-15 12:56:31
6803593	EC:FA:BC:58:81:EE	M10007669	15094	477	8288	2123	2020-10-15 12:56:14

4.3 Ari counter

***Description*: Able to display Ari data such as Work count, cycle time, working time, Preparing time, Running time, Avg stitch, Exc time.**

1. It could be searched by Mac address to see Work count, cycle time, working time, Preparing time, Running time, Avg stitch, Exc time.

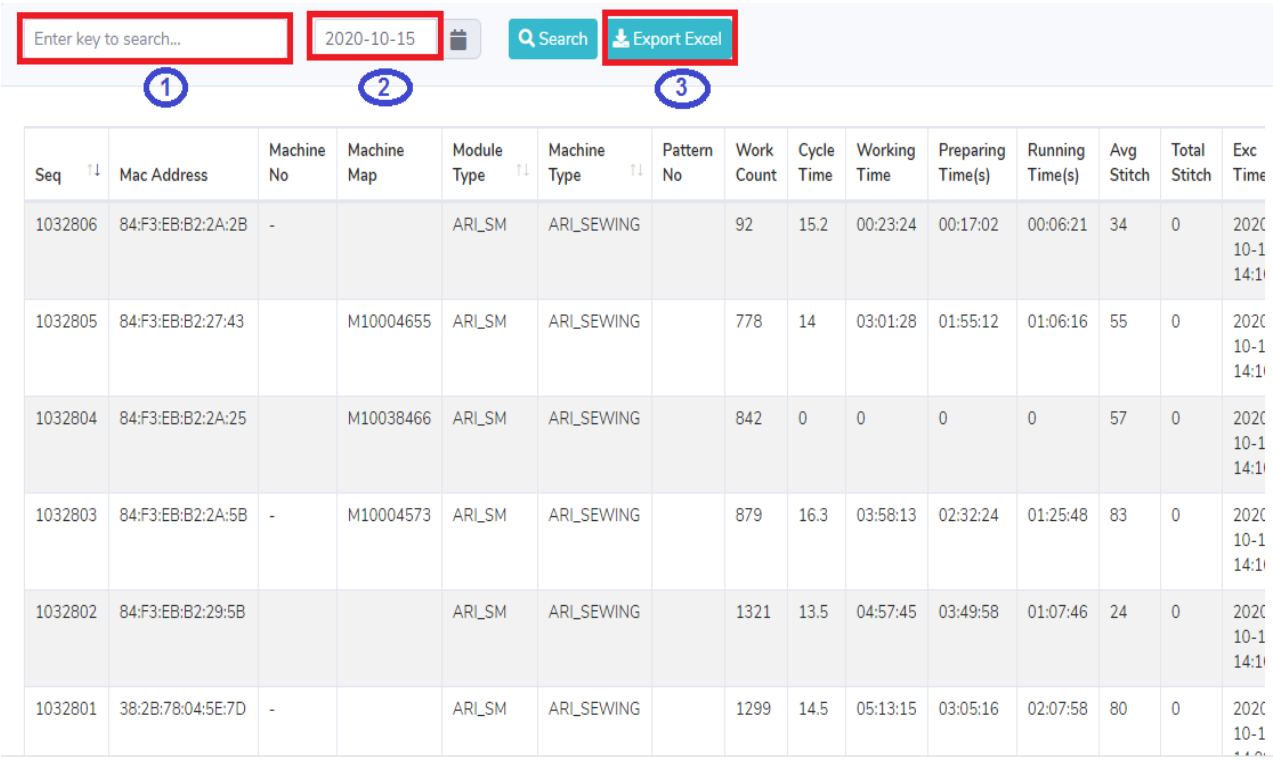


Seq	Mac Address	Machine No	Machine Map	Module Type	Machine Type	Pattern No	Work Count	Cycle Time	Working Time	Preparing Time(s)	Running Time(s)	Avg Stitch	Total Stitch	Exc Time
1032844	84:F3:EB:B2:2A:2B	-		ARI_SM	ARI_SEWING		97	14.5	00:23:24	00:17:02	00:06:21	34	0	2020-10-15 14:15:5

2. Selecting current date or tracking history of previous days to see data

- ***Working time/ Active time:*** ***It is calculated time when worker start working***
- ***Preparing time/(Handle time):*** ***It is calculated time prepare material***
- ***Running time/ motor time:*** ***It is calculated time of operated motor***

3. Export excel file to see data



Seq	Mac Address	Machine No	Machine Map	Module Type	Machine Type	Pattern No	Work Count	Cycle Time	Working Time	Preparing Time(s)	Running Time(s)	Avg Stitch	Total Stitch	Exc Time
1032806	84:F3:EB:B2:2A:2B	-		ARI_SM	ARI_SEWING		92	15.2	00:23:24	00:17:02	00:06:21	34	0	202(10-1 14:1(
1032805	84:F3:EB:B2:27:43		M10004655	ARI_SM	ARI_SEWING		778	14	03:01:28	01:55:12	01:06:16	55	0	202(10-1 14:1(
1032804	84:F3:EB:B2:2A:25		M10038466	ARI_SM	ARI_SEWING		842	0	0	0	0	57	0	202(10-1 14:1(
1032803	84:F3:EB:B2:2A:5B	-	M10004573	ARI_SM	ARI_SEWING		879	16.3	03:58:13	02:32:24	01:25:48	83	0	202(10-1 14:1(
1032802	84:F3:EB:B2:29:5B			ARI_SM	ARI_SEWING		1321	13.5	04:57:45	03:49:58	01:07:46	24	0	202(10-1 14:1(
1032801	38:2B:78:04:5E:7D	-		ARI_SM	ARI_SEWING		1299	14.5	05:13:15	03:05:16	02:07:58	80	0	202(10-1

5. Non-sewing config

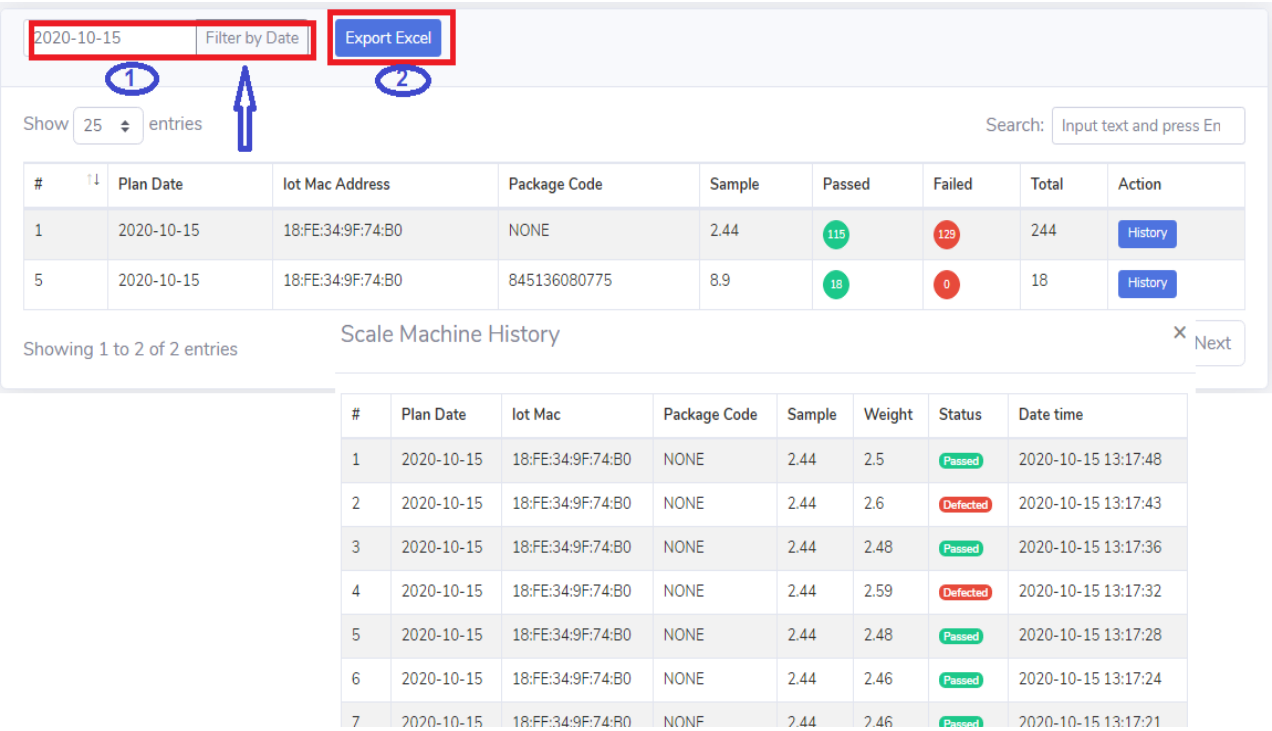
5. 1 Warehouse Data : Not yet usage

5.2 Scale machine

***Description*: Able to display Scale IOT data such as Package code (Barcode No), Weight sample, Passed/failed quantity & status, output, date time.**

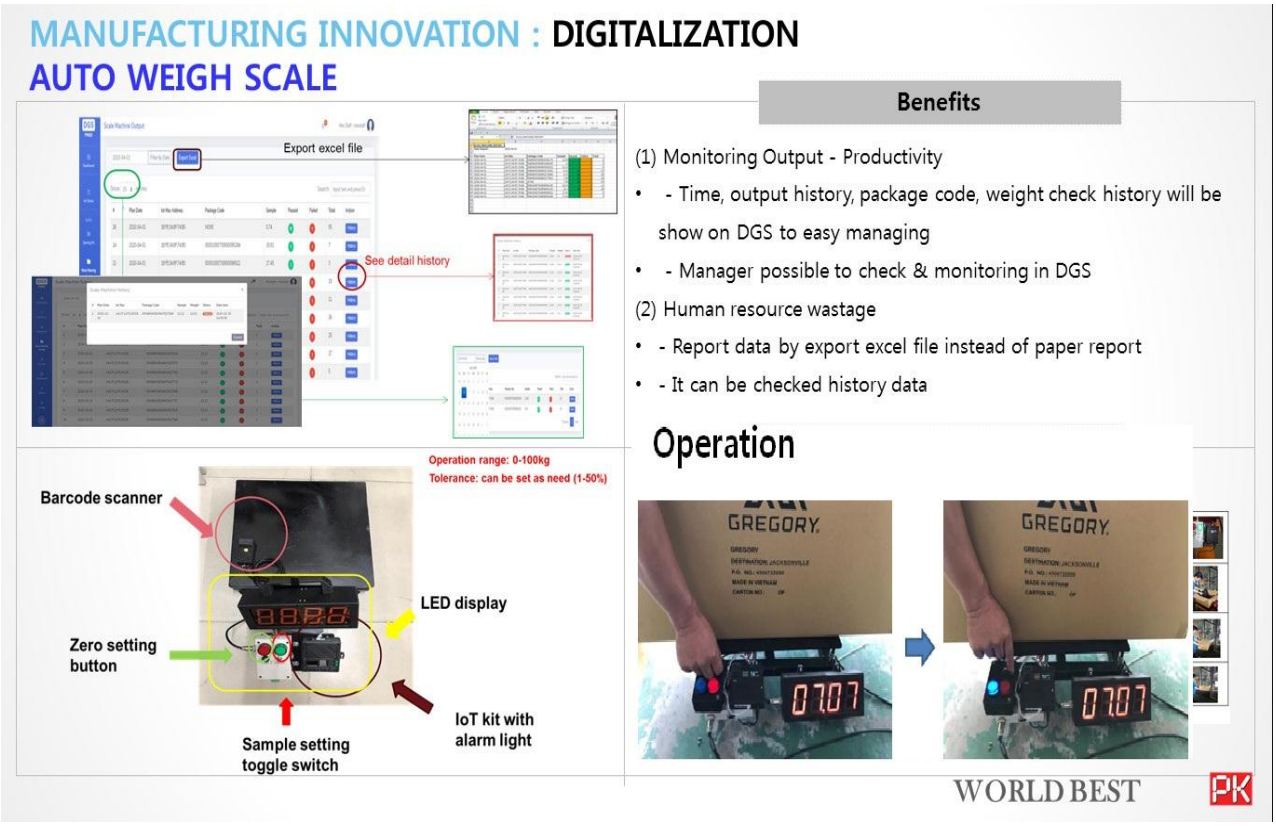
1. Choosing current date or tracking history of previous days to see data

2. Export excel file to see data



- ***Illustration:***

The worker collect the carton box and put it into the weight pan for weighting, If blue light is passed, red light is failed, Using barcode scanner to check the package code. Then data will be sent to DGS server.

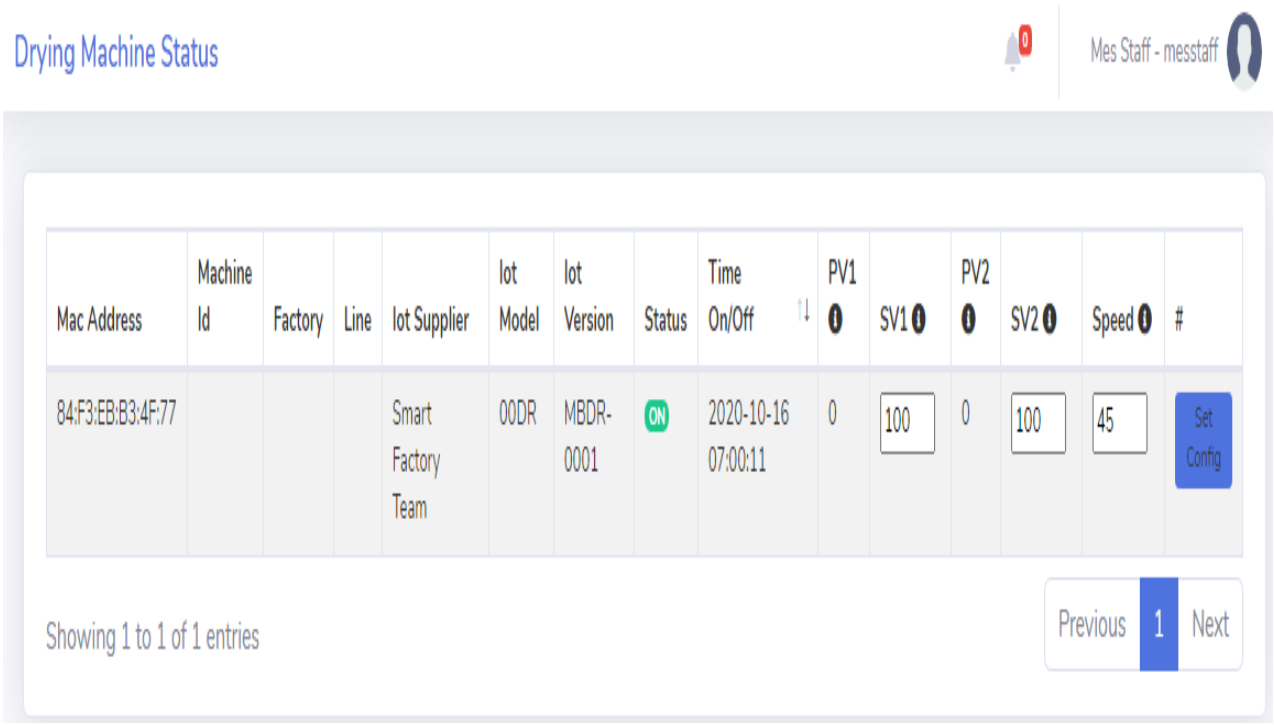


5.3 Dry machine

- It possible set value, speed of conveyor sent it to DGS and contrary DGS send it to machine in order to correct sample.

  Pv1 & Pv2 : Process value 1 & process value 2

  Sv1 & Sv2: set value & set value 2



- ***Illustration:***

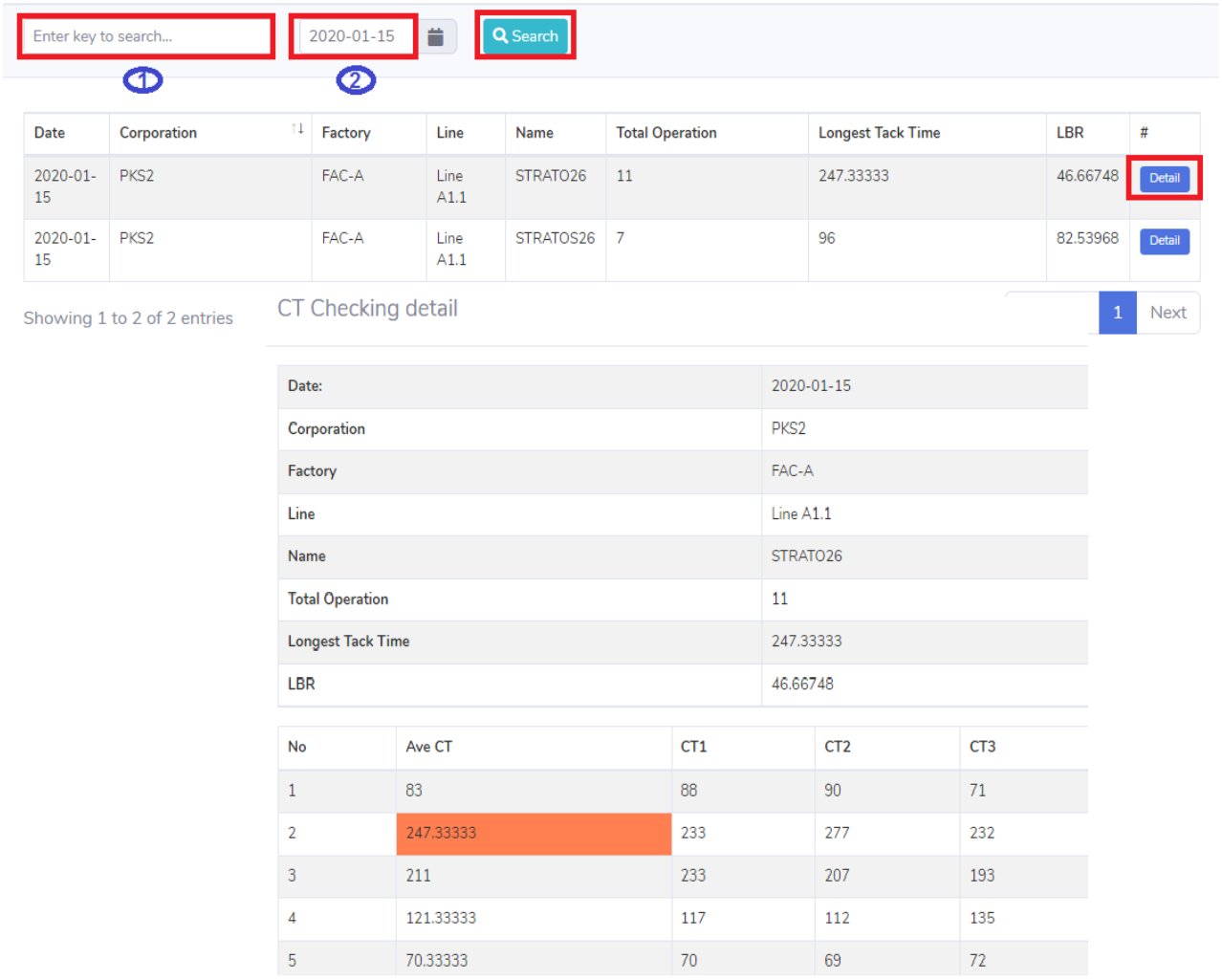
Applied dry machine in KBT, using SFT IOT to send data to DGS

5.4 CT checking

***Description*: Able to display information such as Date, Factory, line, styles, Operation, Longest tack time, Line balance, Ave Cycle time.**

1. It could be search information

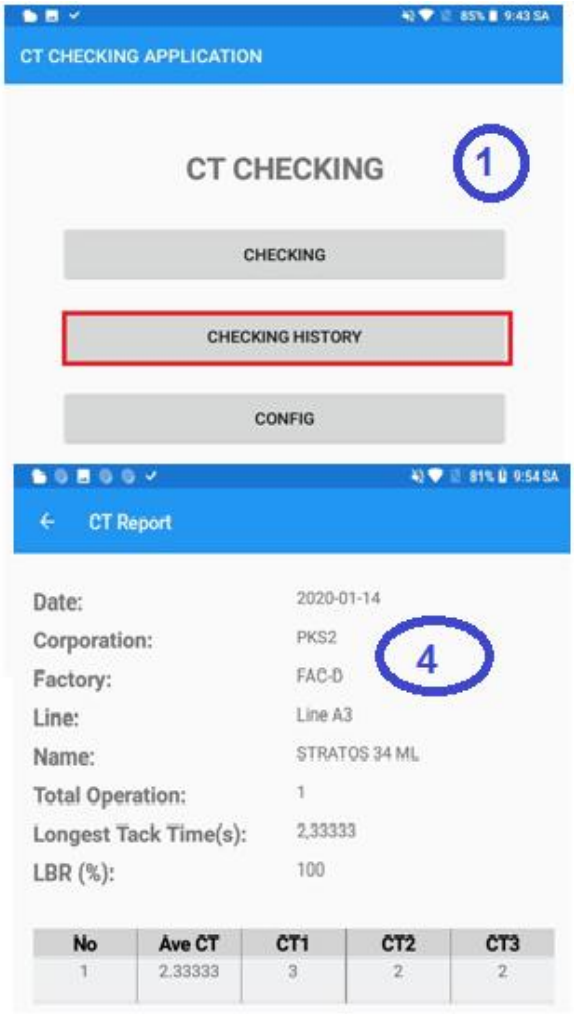
2. Selecting current date or tracking history of previous days to see data

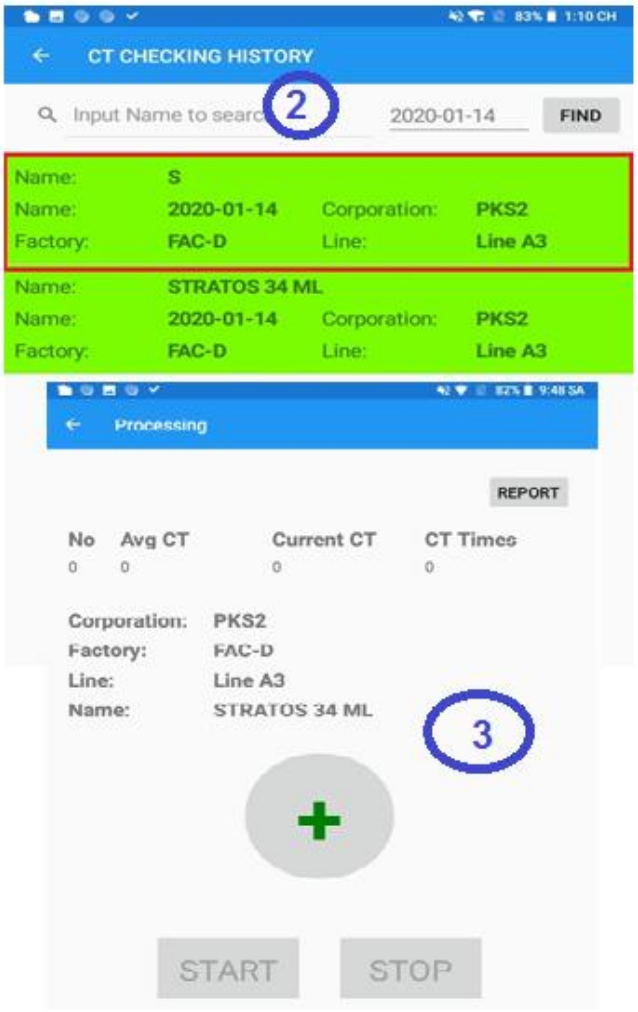


- ***Illustration:***

Using App for checking Cycle time and send data to DGS. According to this result above . we can calculate line balance as:

LBR = Sum of operation time / (Longest operation time * Total operation) x 100



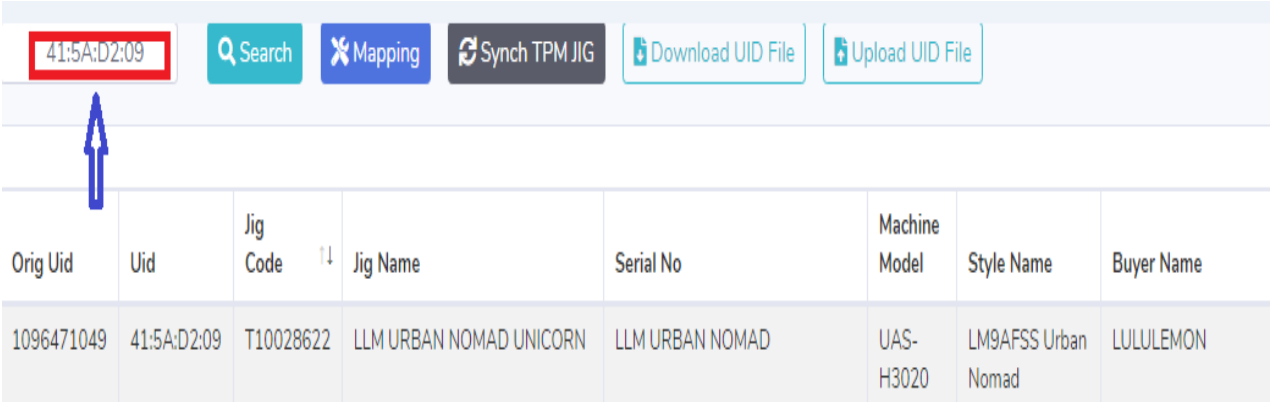


5.5 Heat Temperature: Not yet usage

6. Jig tool

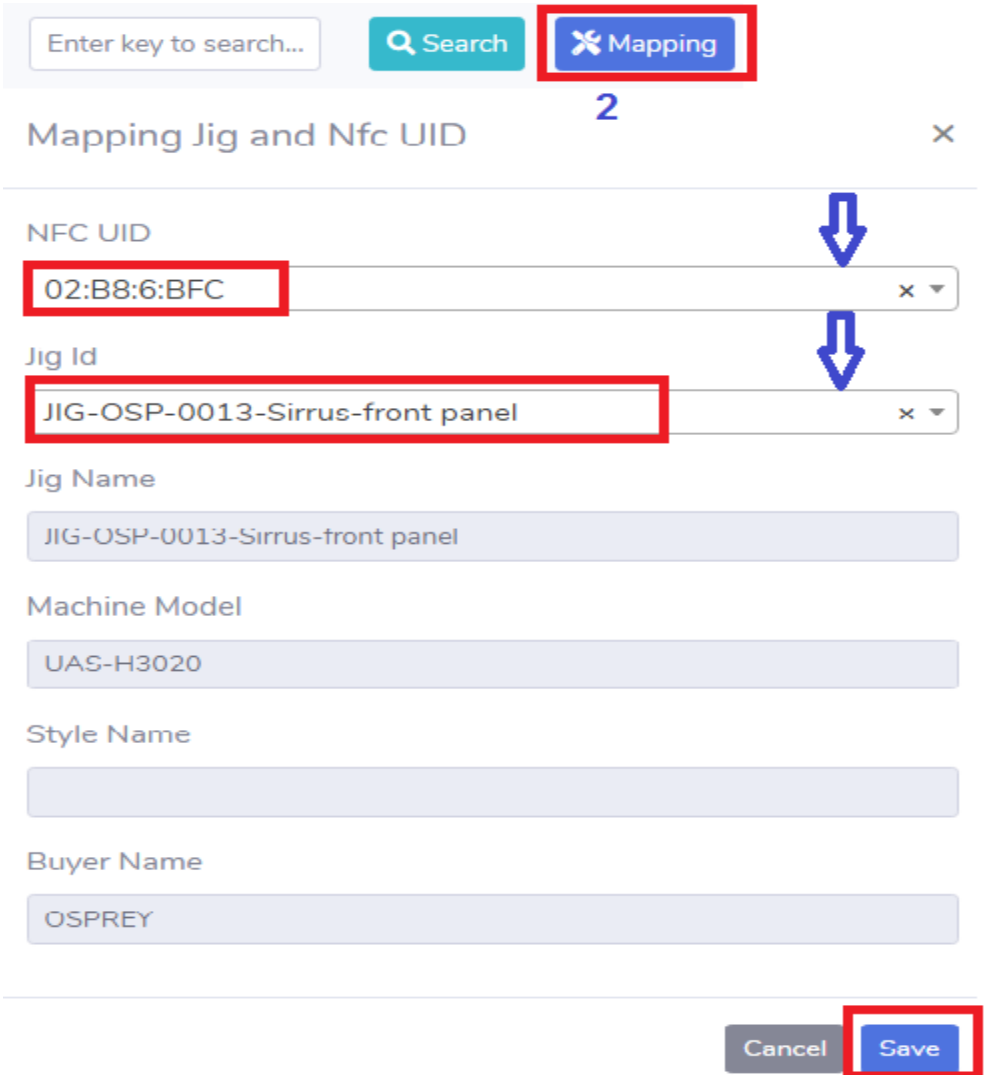
***Description*: Able to mapping UID with Jig code information in order to download pattern from TPM using NFC (UID).**

1. It could be searched by IUD, Jig code to see data mapping from TPM.



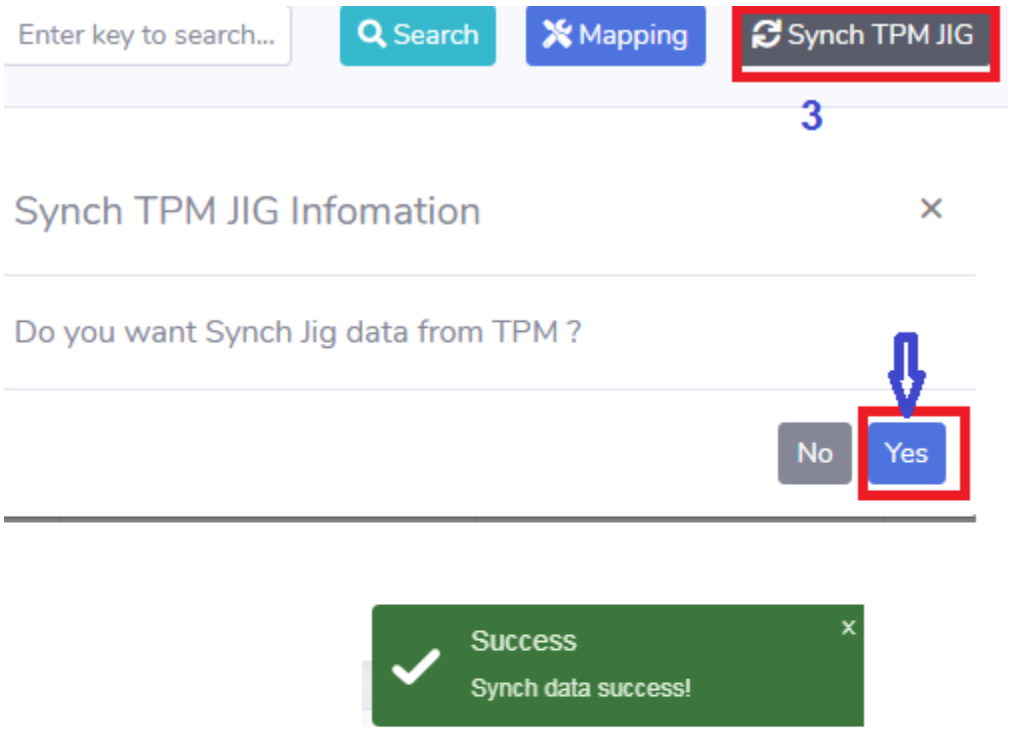
2. Jig tool ➔ Mapping ➔ Mapping Jig & UID

Selecting which UID mapping with Jig ID, Then “save”

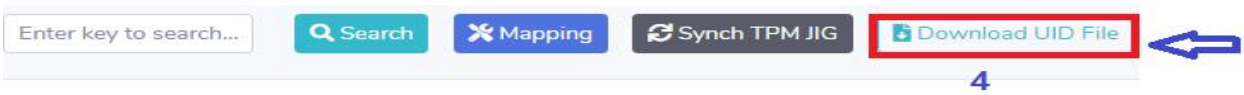


3. Jig tool ➔ Synch TPM Jig

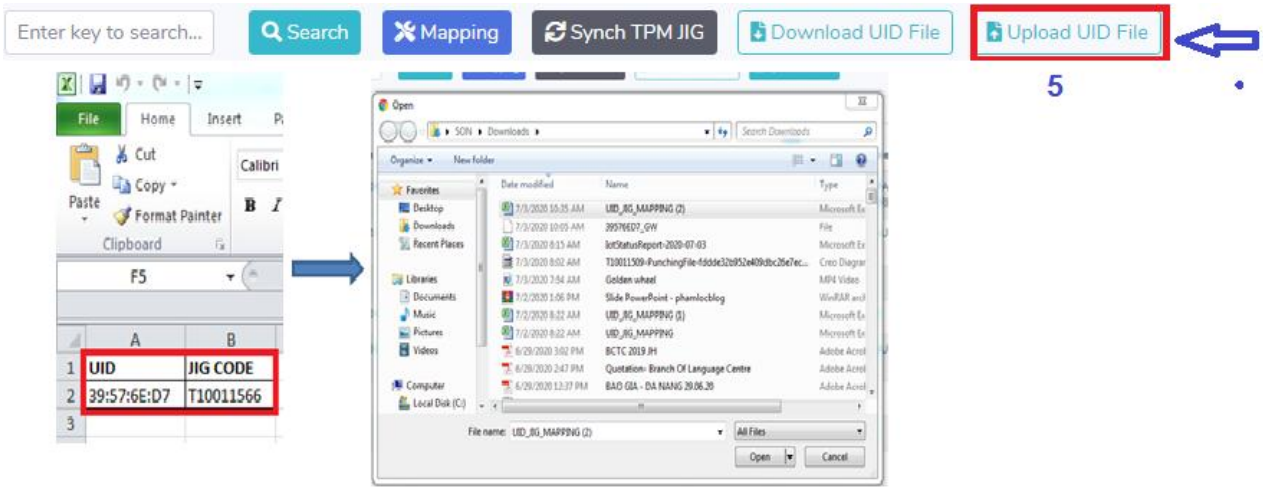
Click Synch TPM button to confirm “yes” for linking data of punching file from TPM, and see “synch data success”

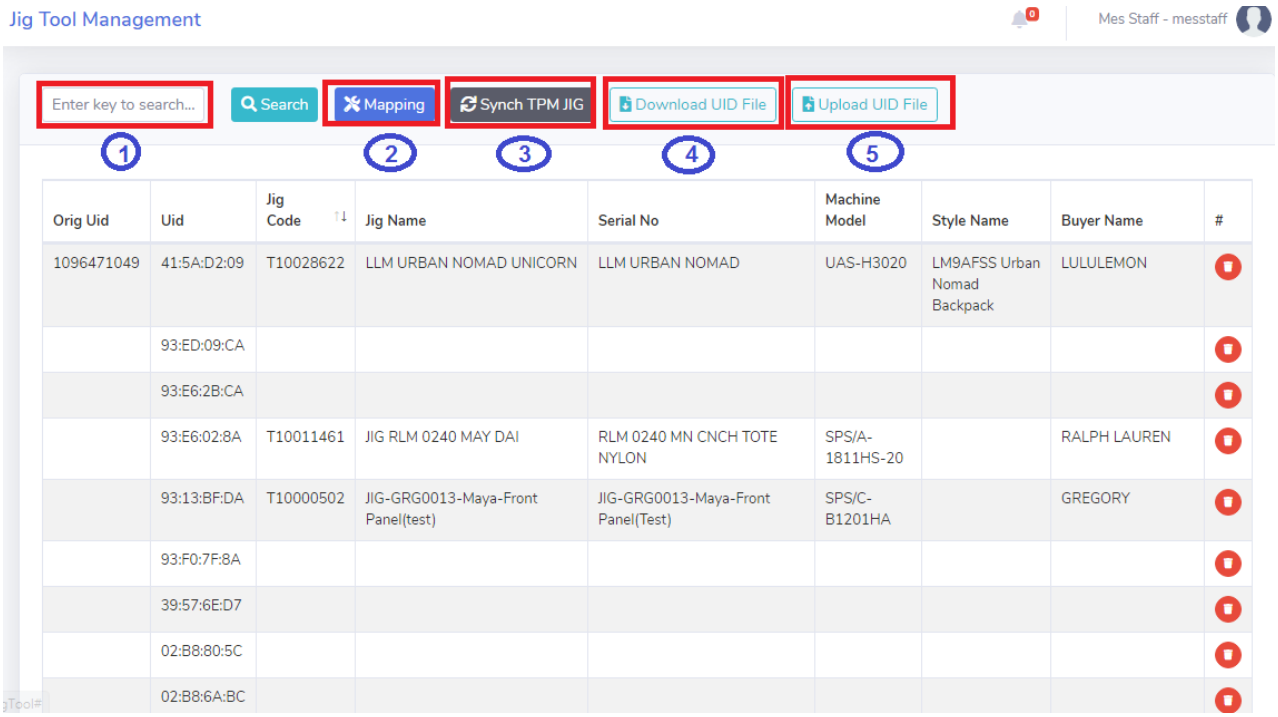


4. Jig tool ➔ download file to fill up UID & Jig code



5. Jig tool ➔ upload file to fill up UID & Jig code





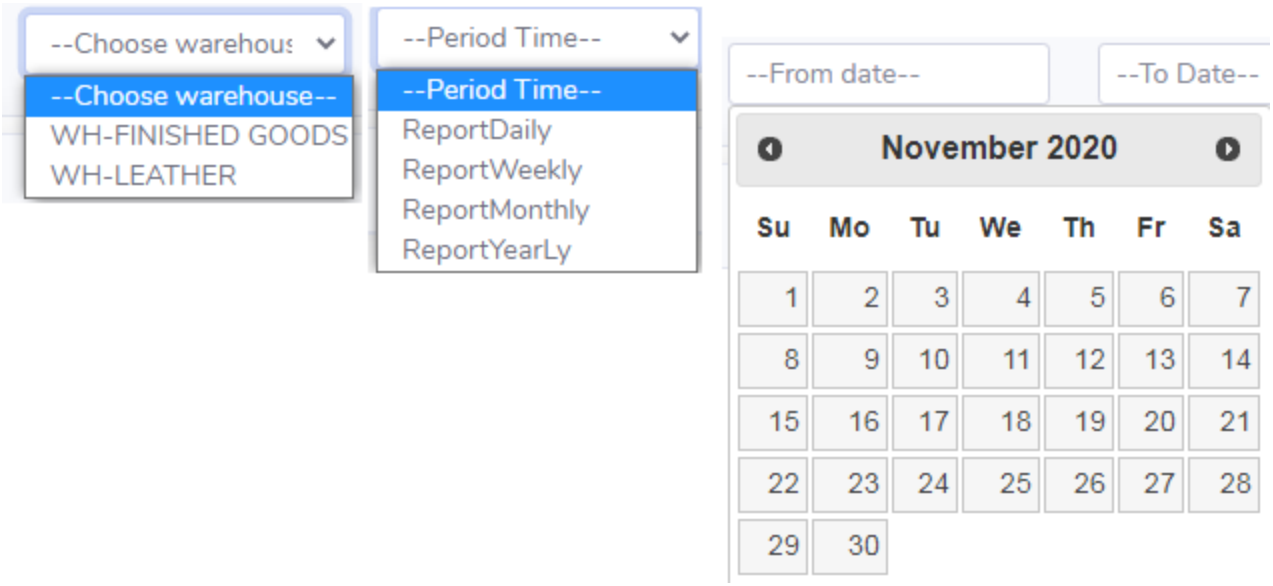
7. Warehouse

Description: **Warehouse monitoring to show up temperature and humidity status**

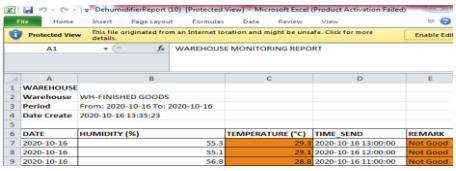
1. 2. 3. Selecting warehouse, Period time, date

It possible to select history data of previous dates

It can record data by hour, daily, weekly, monthly.



4. Export excel file

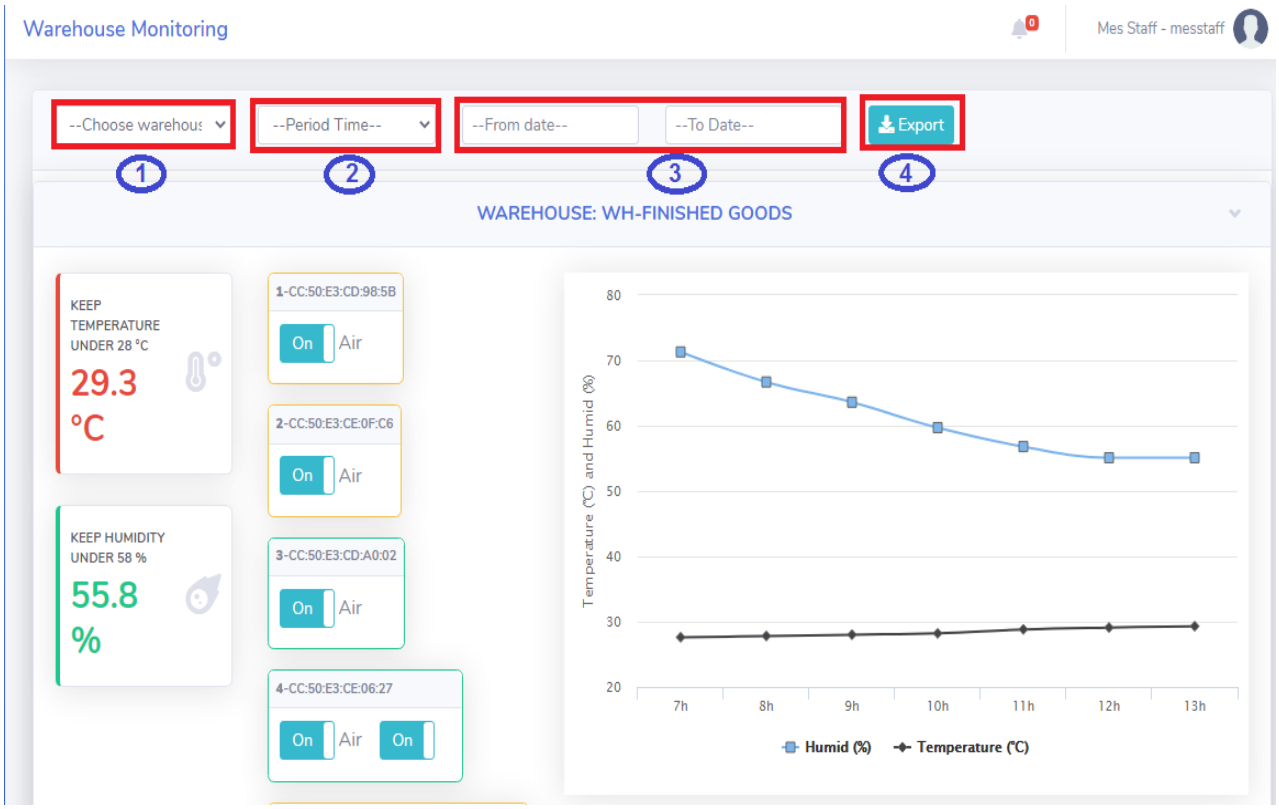


- ***Setting range:***

Maximum: 28°C for Temp, 58% for Humid

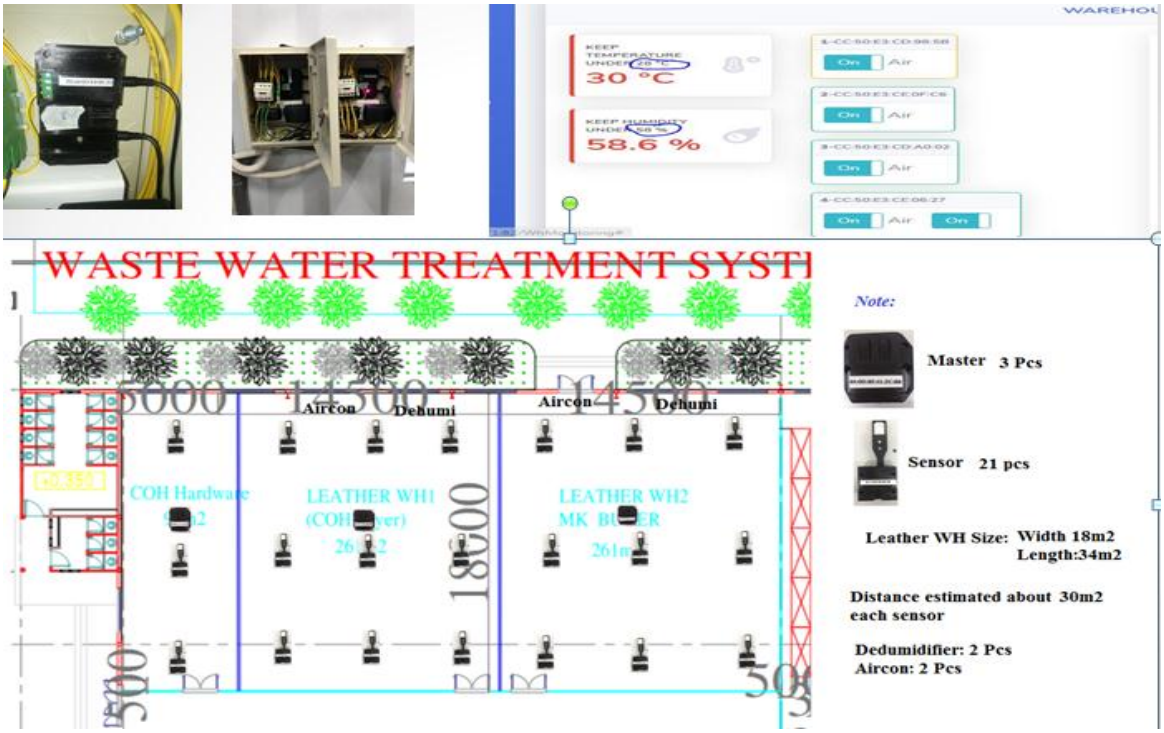
Meaning:

When temp/hum reaches to 28°C/>58% => Dehumidifier will be automatically turn on.



➢ ***Illustration:***

Sensor, master is set up in warehouse area to control ON/OFF temperature and humidity machine , using wifi to collect data and sending to DGS.



8. Utilities

This function in order to mapping Machine ID and Mac address

1. 2. 3. Download file, then fill up Machine ID, then choose file and upload.