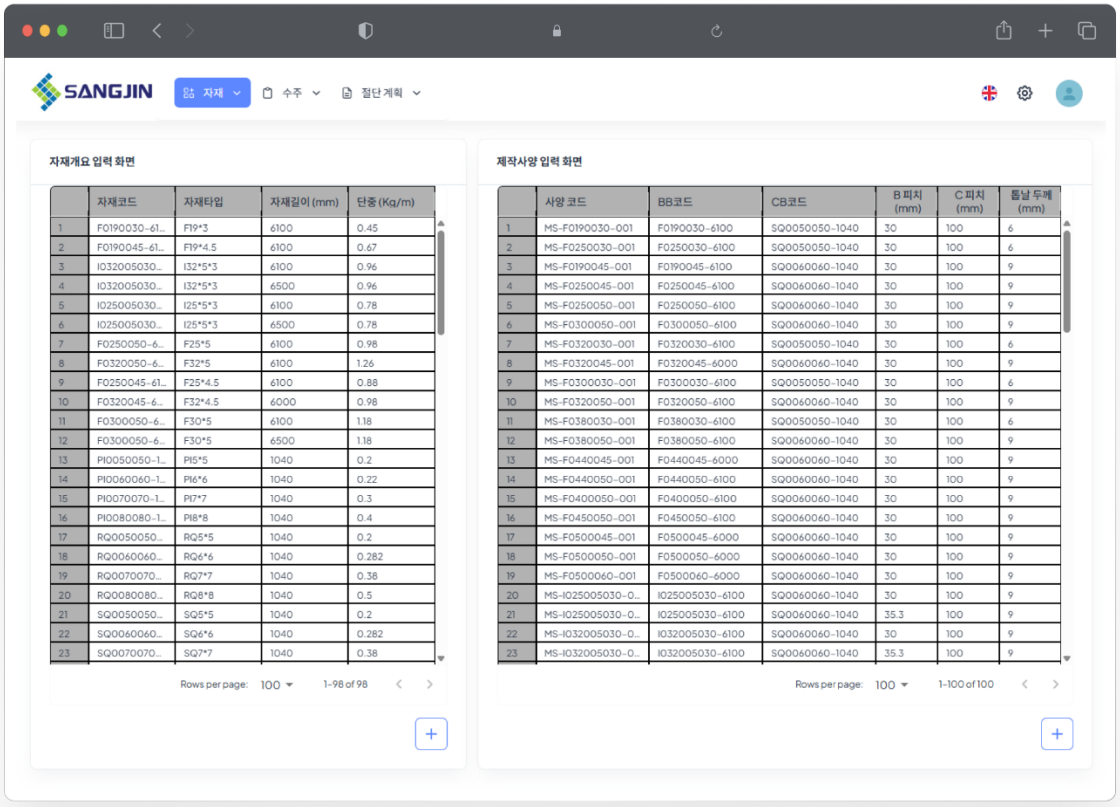
GPSS II User Guide

2025. 06



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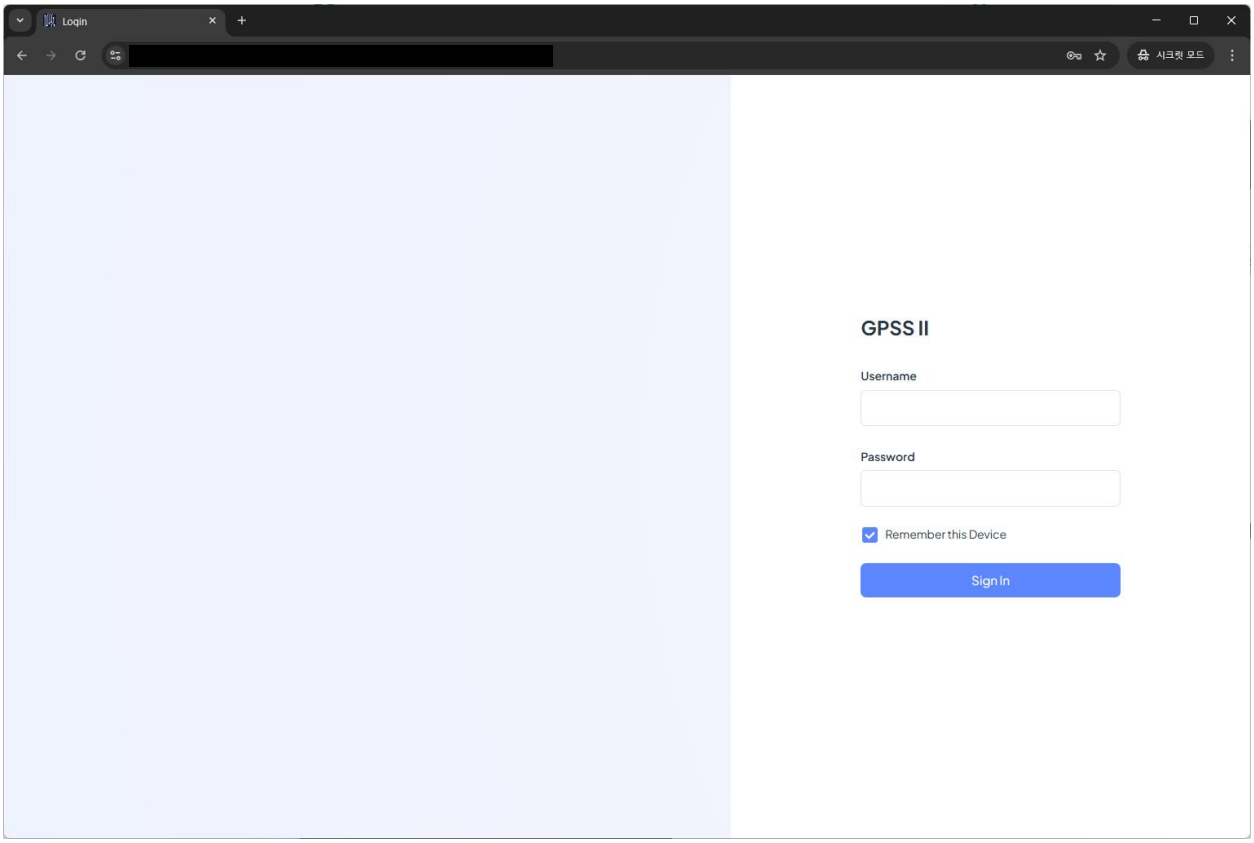
User-Interface & Usage

Login System



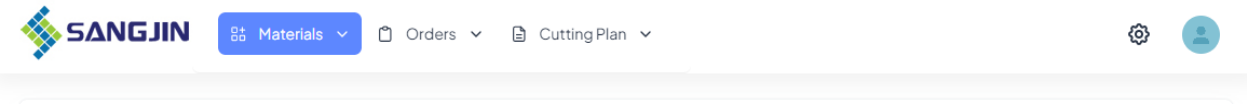
The GPSS II system is web-based and can be accessed by entering its web address into a web browser. The recommended web browsers are Google Chrome and Microsoft Edge.

Upon accessing the GPSS II system, you will see the following login window. The initial account information is as follows:

Username : YOUR_EMAIL

Password : YOUR_PASS

Navigation Pane

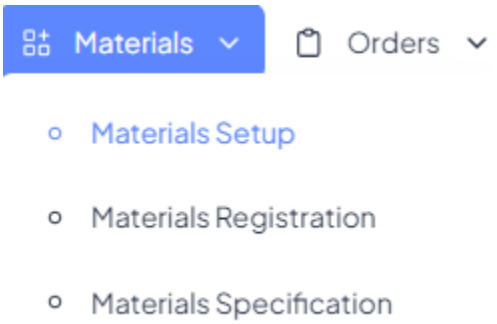


Once you've logged in, you can navigate between pages using the menus in the navigation bar at the top. The system features three main menus, each with its own set of sub-menus:

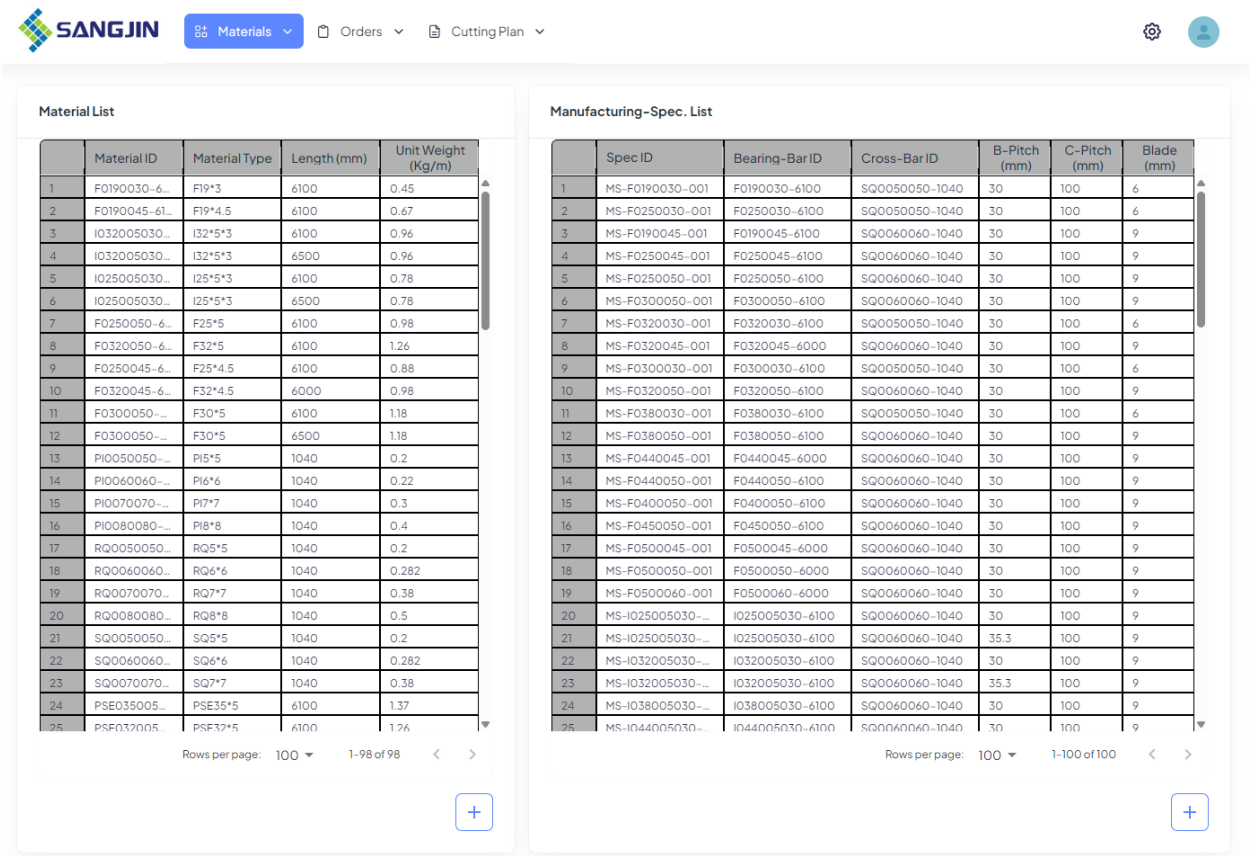
- **Materials**
  - Materials Setup
  - Materials Registration
  - Materials Specification
- **Orders**
  - Orders Management
- **Cutting Plan**
  - Default Parameters
  - Reorganize Groups
  - Generate Plan

Materials Menu

This page allows you to manage the materials required for generating cutting plans.



Materials Setup Page

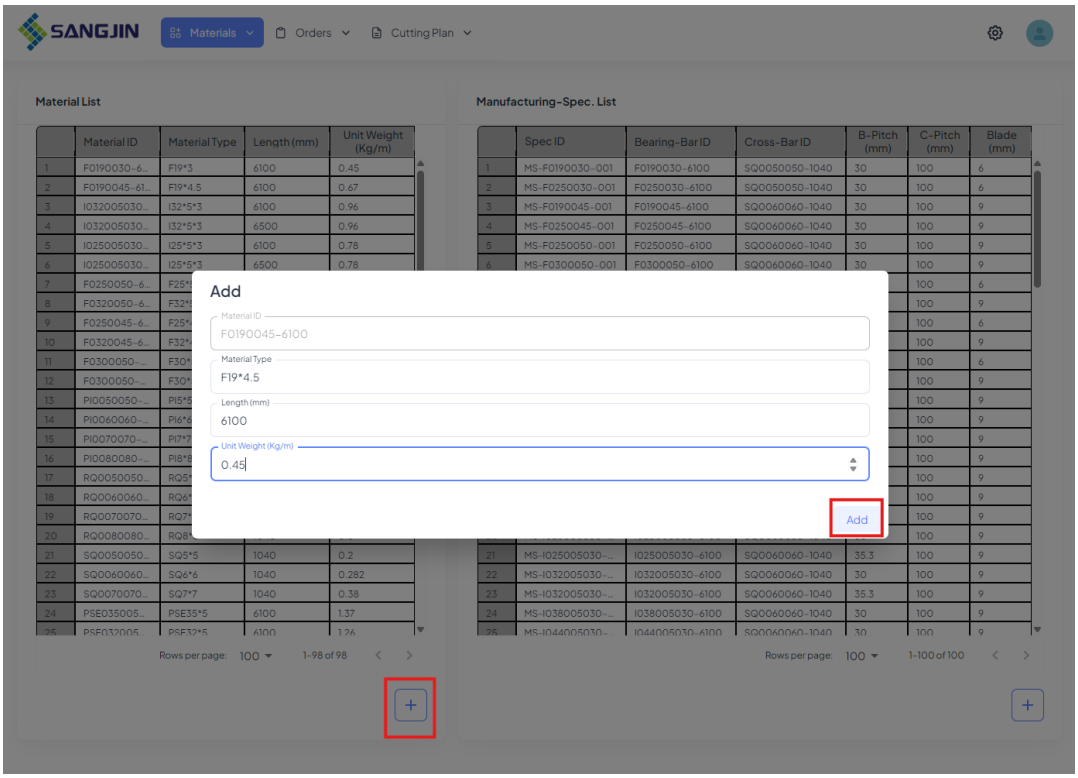


On the **left table (Material List)**, you can generate **Material IDs**. These IDs are automatically assigned based on **Material Type** and **Length**.

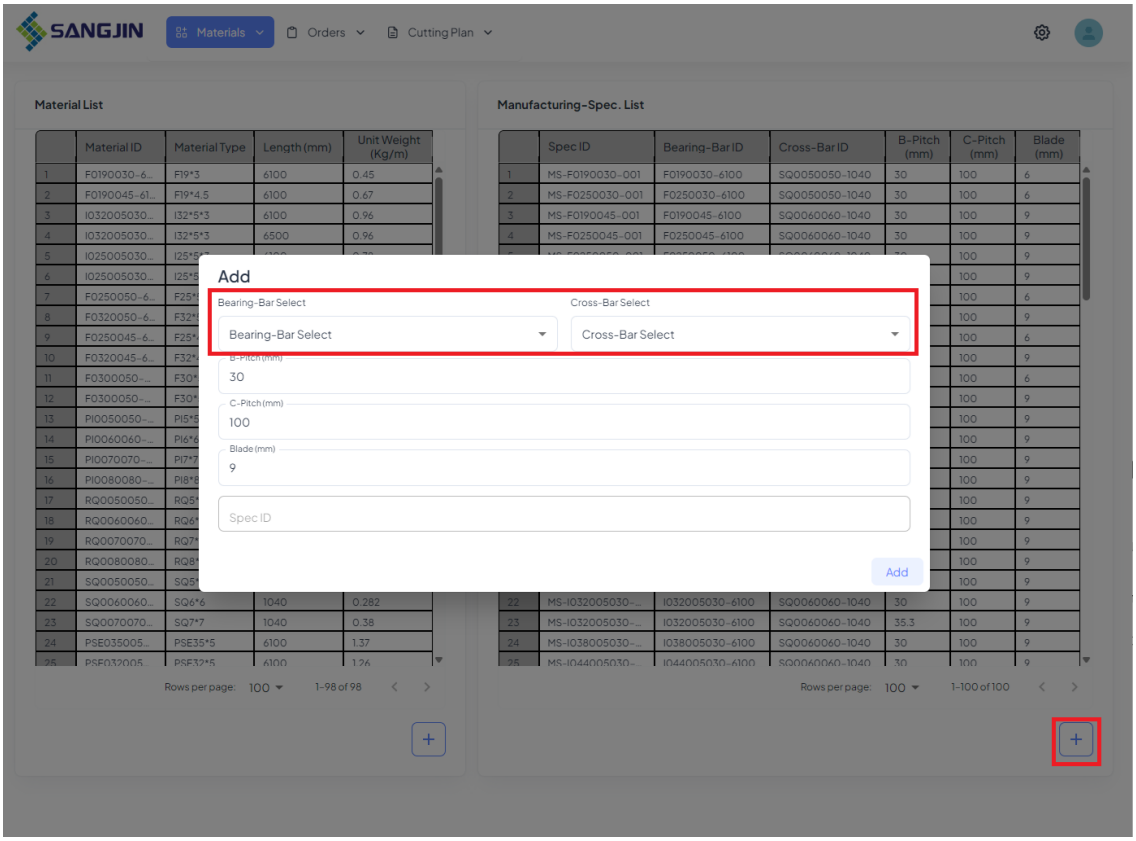
You can then combine two Material IDs from the left table to create a **Spec ID** on the **right table (Manufacturing-Spec. List)**. A Spec ID includes:

- The Material ID designated as the **Bearing-Bar**
- The Material ID designated as the **Cross-Bar**
- **Bearing Bar Pitch**
- **Cross-Bar Pitch**
- **Saw Blade Thickness**

To create a **Material ID** or generate a **Spec ID**, click the **+ button** located at the bottom of each respective table.

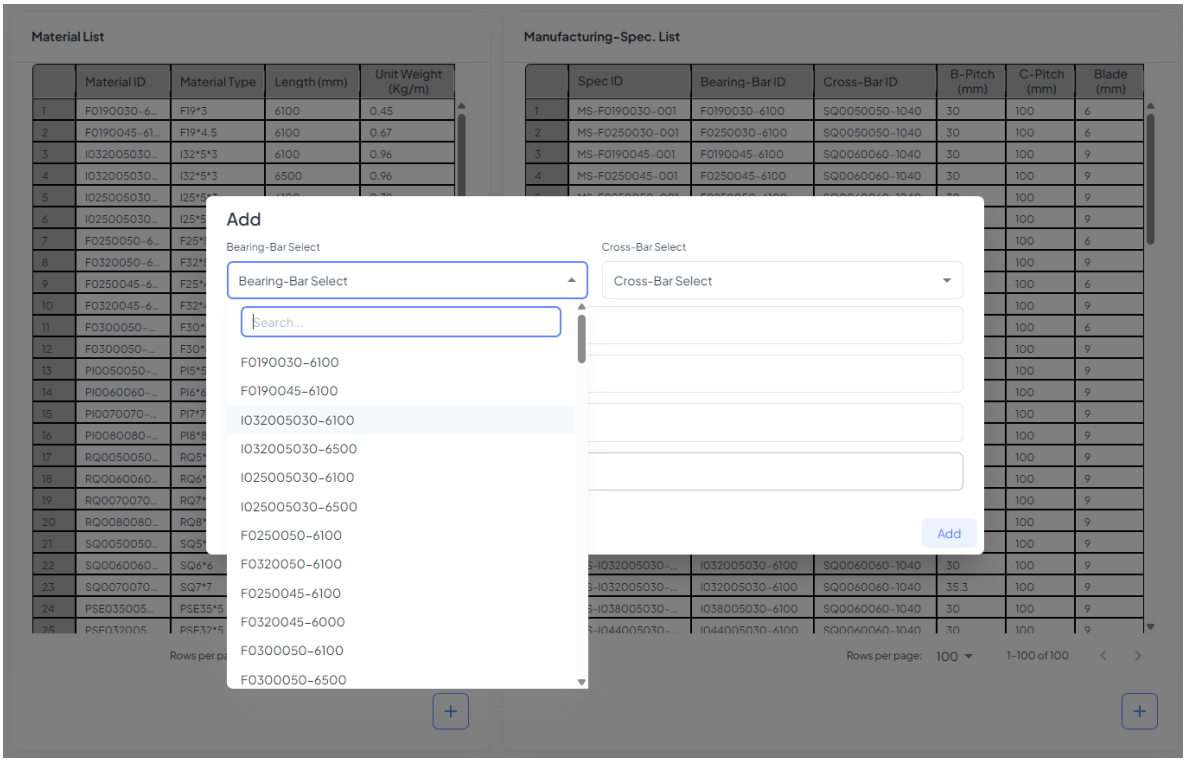


You can input the necessary values by pressing the Enter key to move to the next field. Creation is automatic when you either click the Add button or press Enter after inputting the final value.

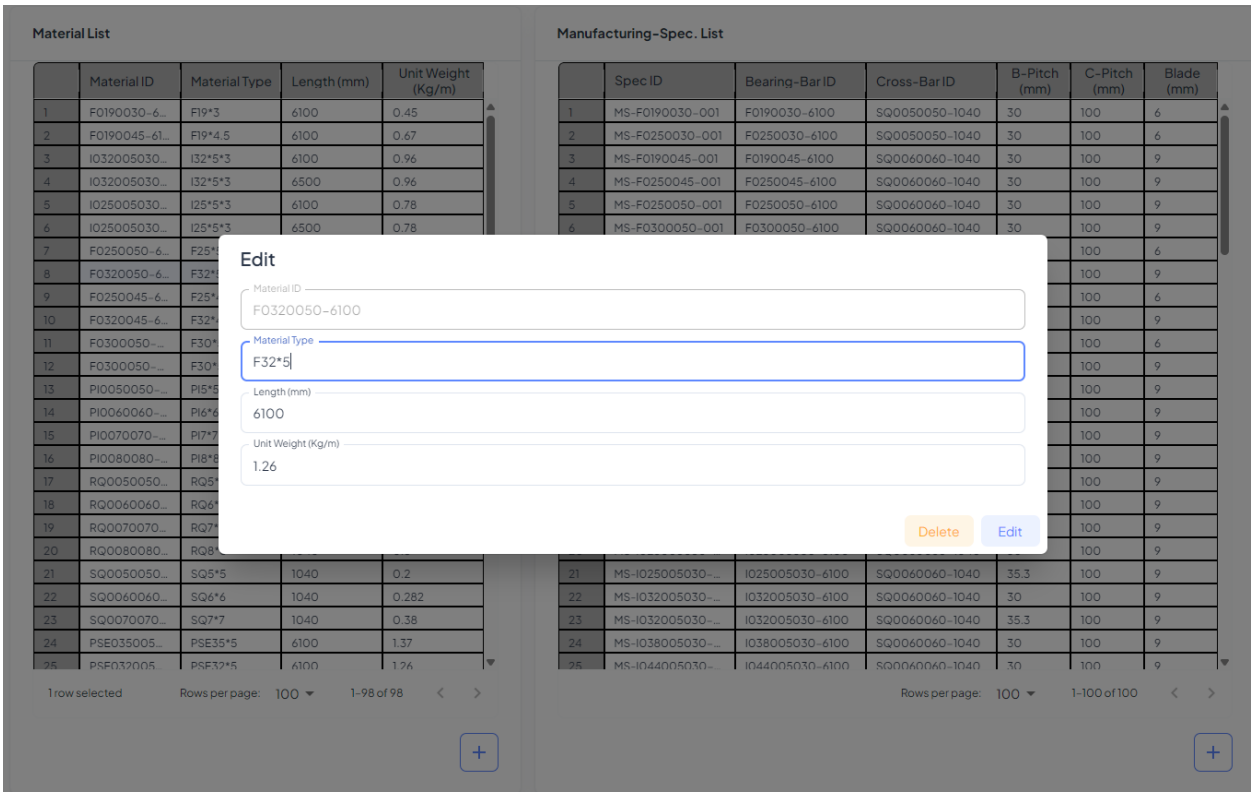


Similarly, when creating a **Spec ID**, you can define the necessary fields using the following modal window.

A Spec ID is generated based on the format: 'MS – {**Bearing-Bar Material Type**} – {**Unique Identifier**}'. The unique identifier is a 3-digit integer (e.g., '001'). This identifier increases each time you create a new Spec ID that shares the same Bearing-Bar but has at least one different value for the Cross-Bar, B-Pitch, C-Pitch, or Blade.



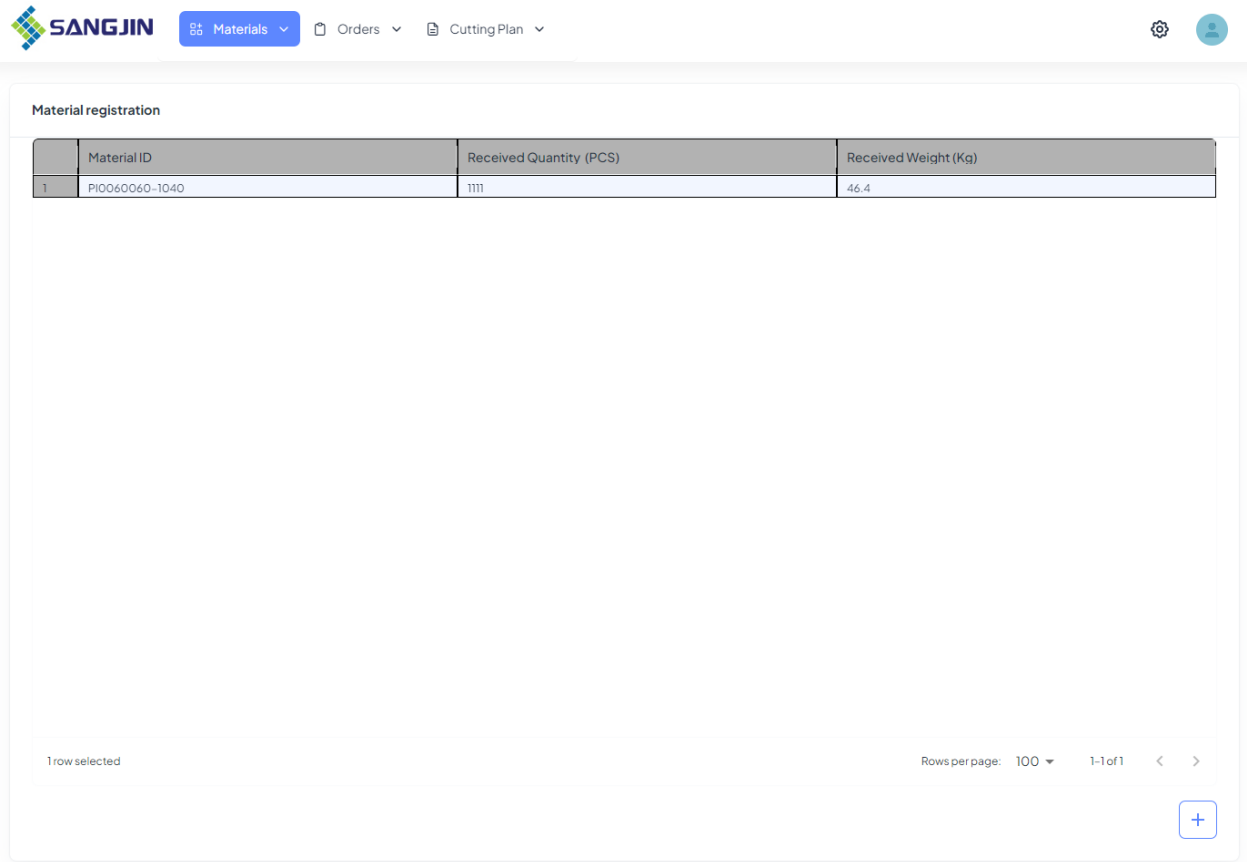
You can search for Material IDs or locate them manually to add them.



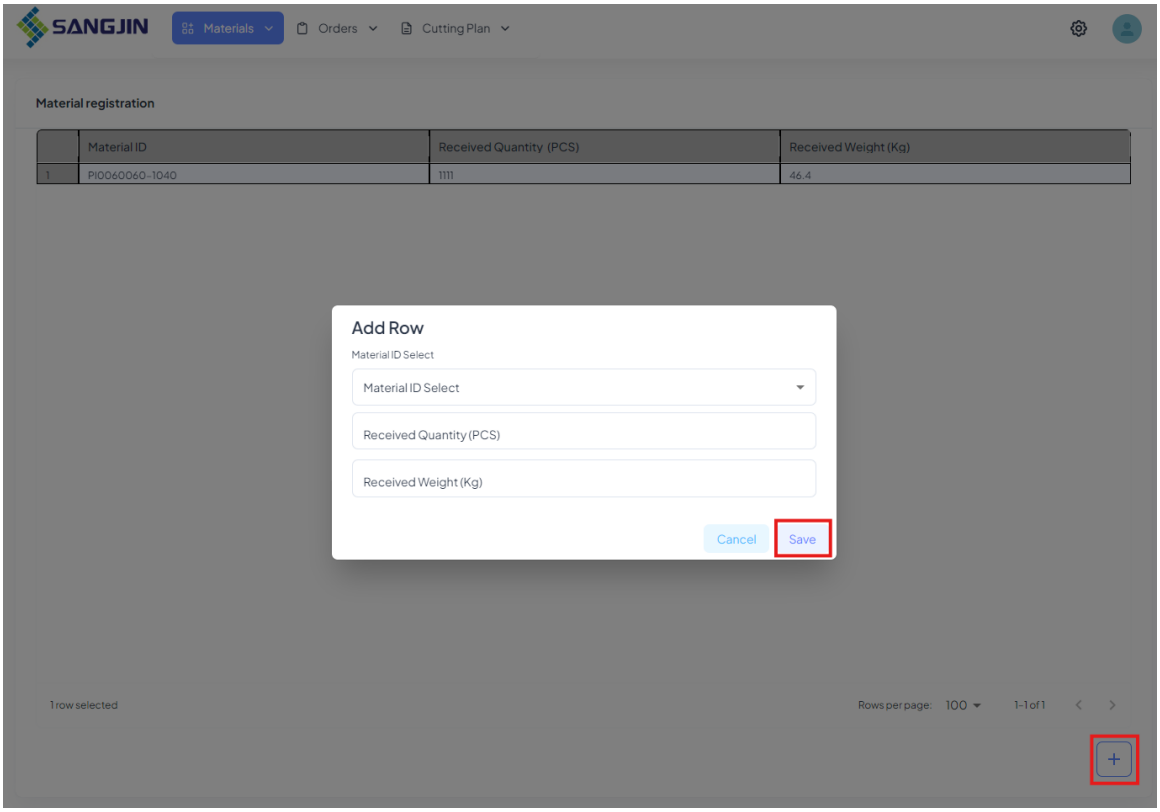
Just like creating, you can modify or delete a Material ID or Spec ID by clicking its

corresponding row. However, please note that modification and deletion are not possible if the Material ID or Spec ID is already registered in an order list or has been used to generate a cutting plan.

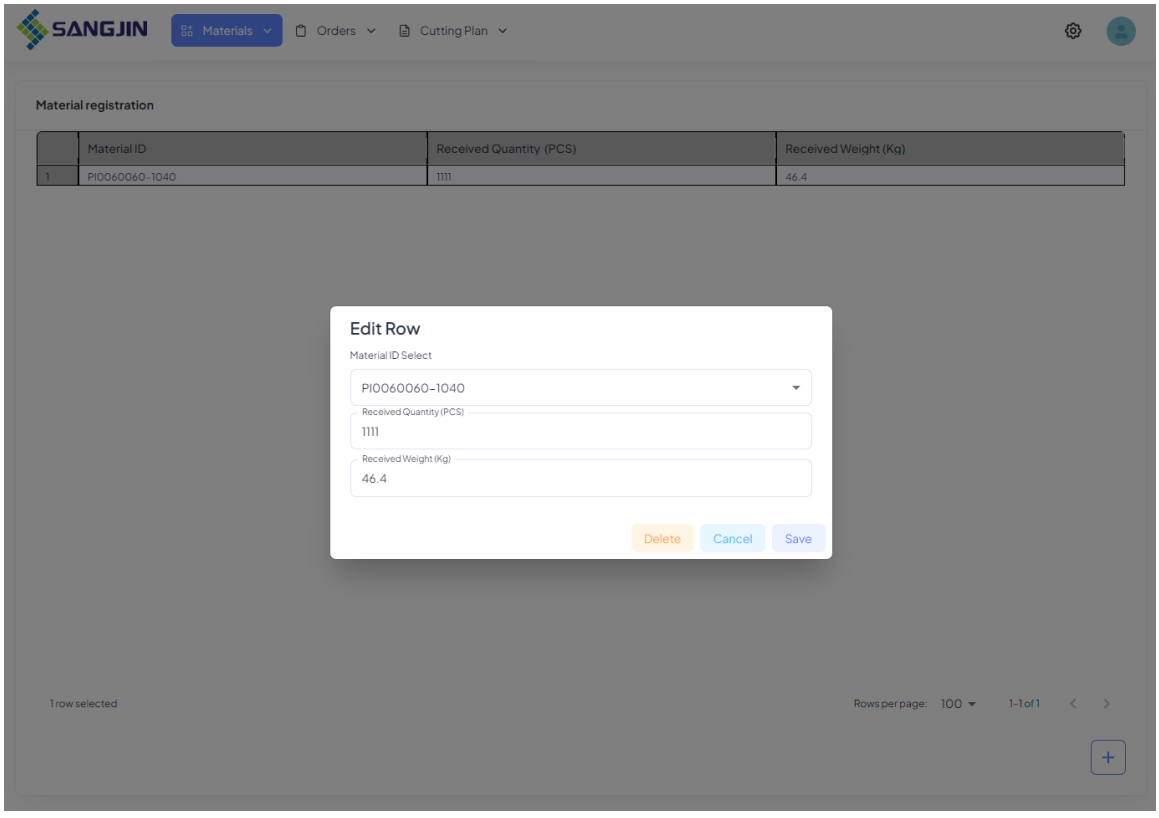
Materials Registration Page



This page helps you manage the **quantity** and **weight** of each **Material ID**.

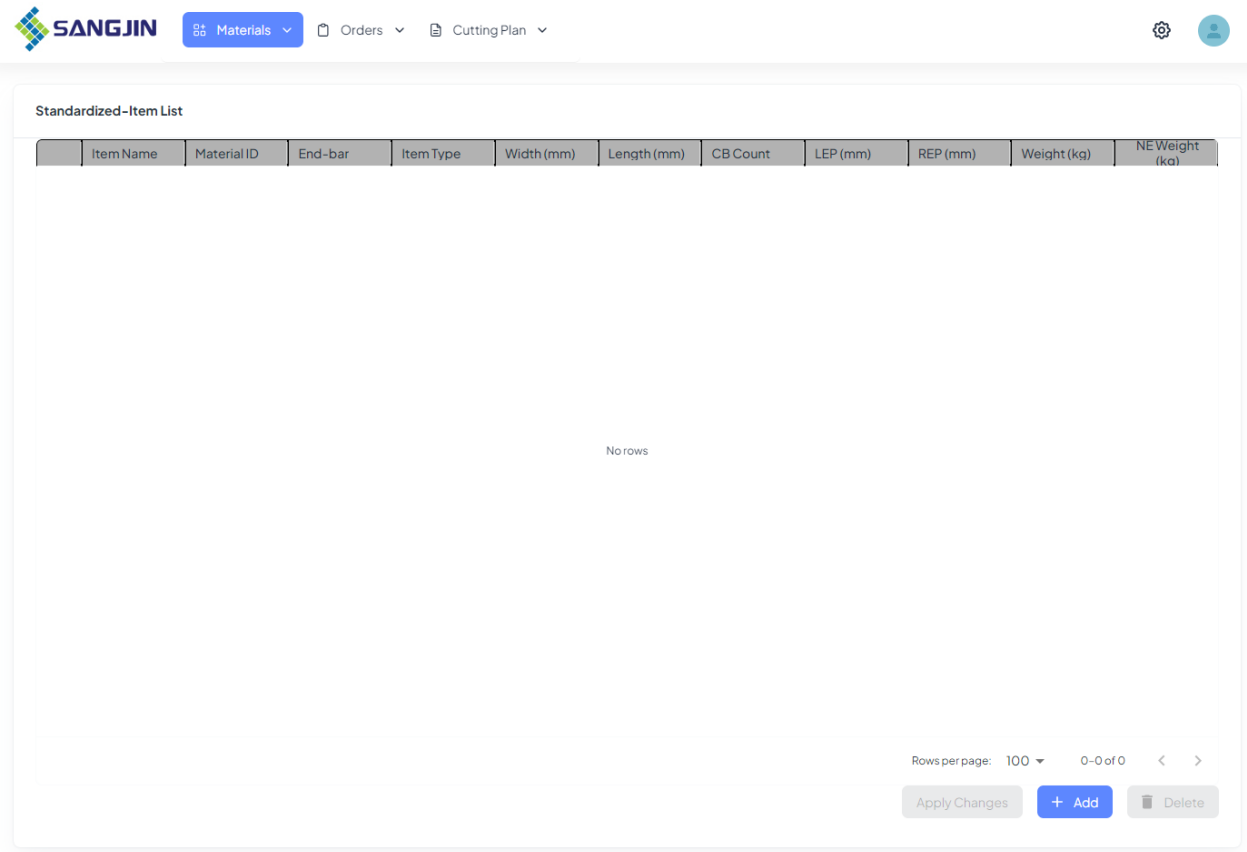


Similarly, you can add new items by clicking the + **button** at the bottom.



If you want to **modify or delete** a created item, you can do so by clicking its corresponding row, as shown in the image.

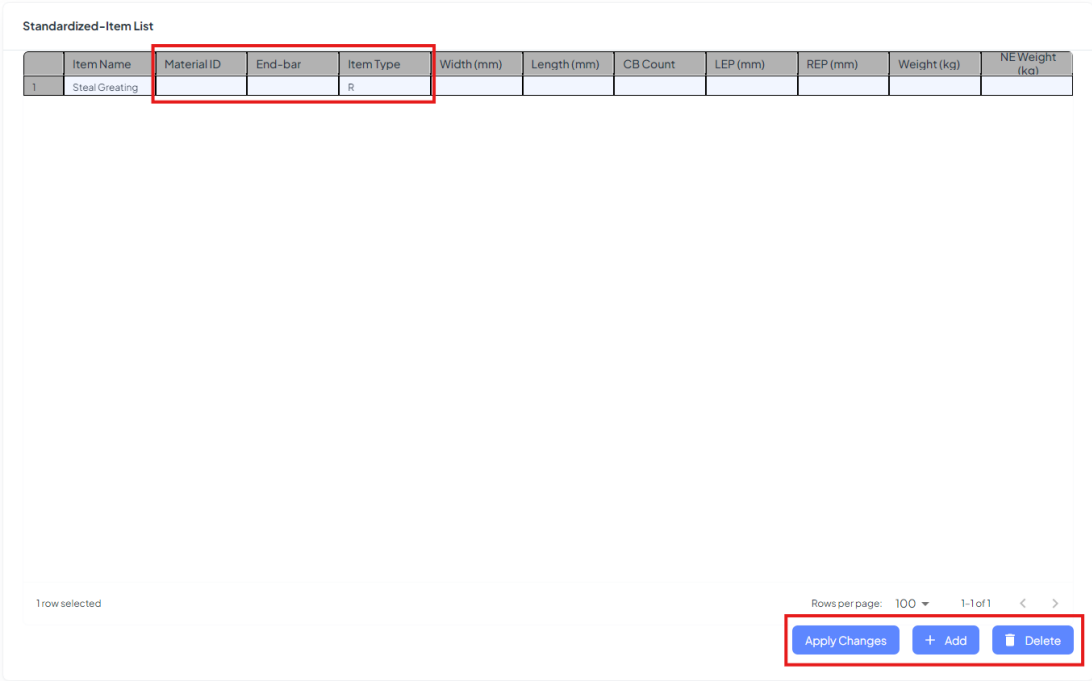
Materials Specification Page



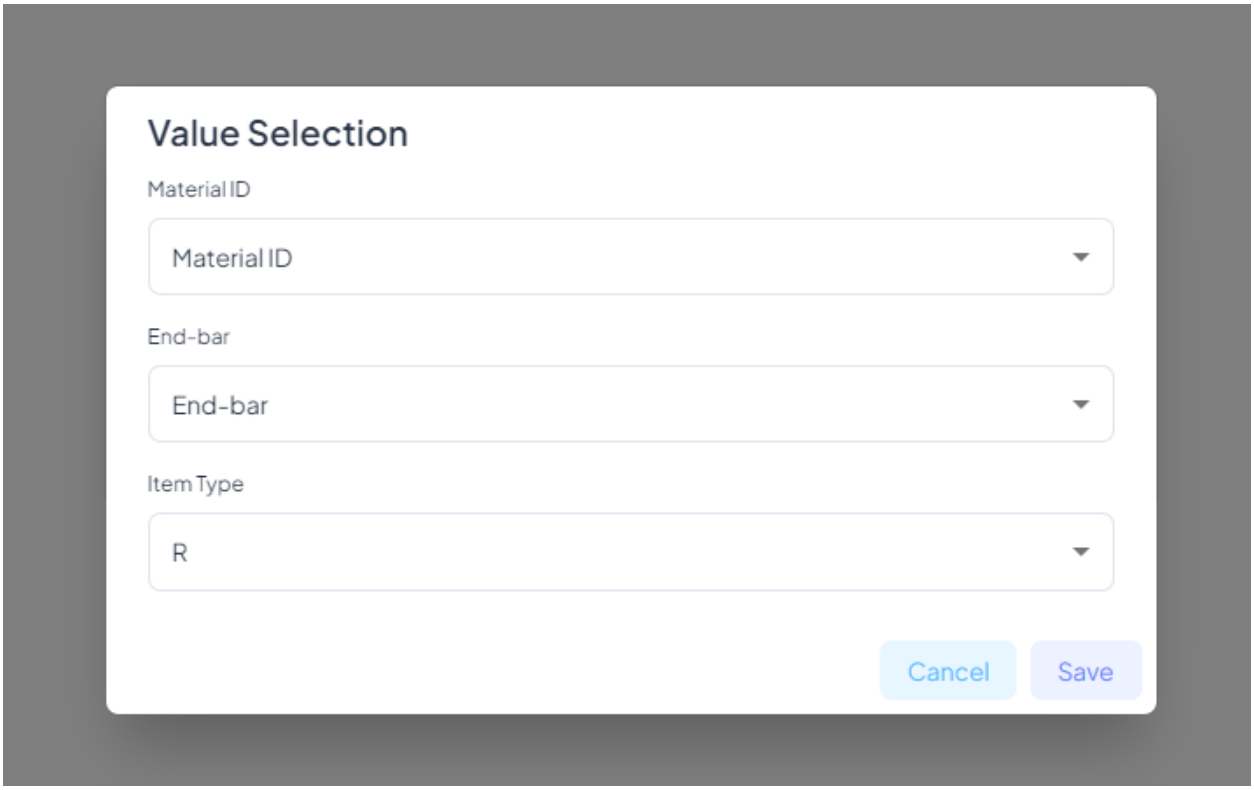
This page allows you to create **Item Names**, which are the standard for materials.

Here's an explanation of each button:

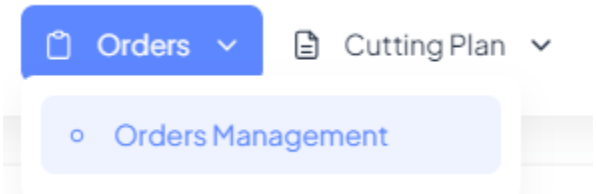
- **Apply Changes**: This button applies the changes made to your Item list. Your modifications won't be saved to the server until you click this button. It will only become active if there's at least one change.
- **Add**: Clicking this button adds a new cell to the table. Initially, the cell will be blank, and you can either type directly into it or import from a list.
- **Delete**: This button deletes the selected cell. It's disabled by default if no cell is selected.



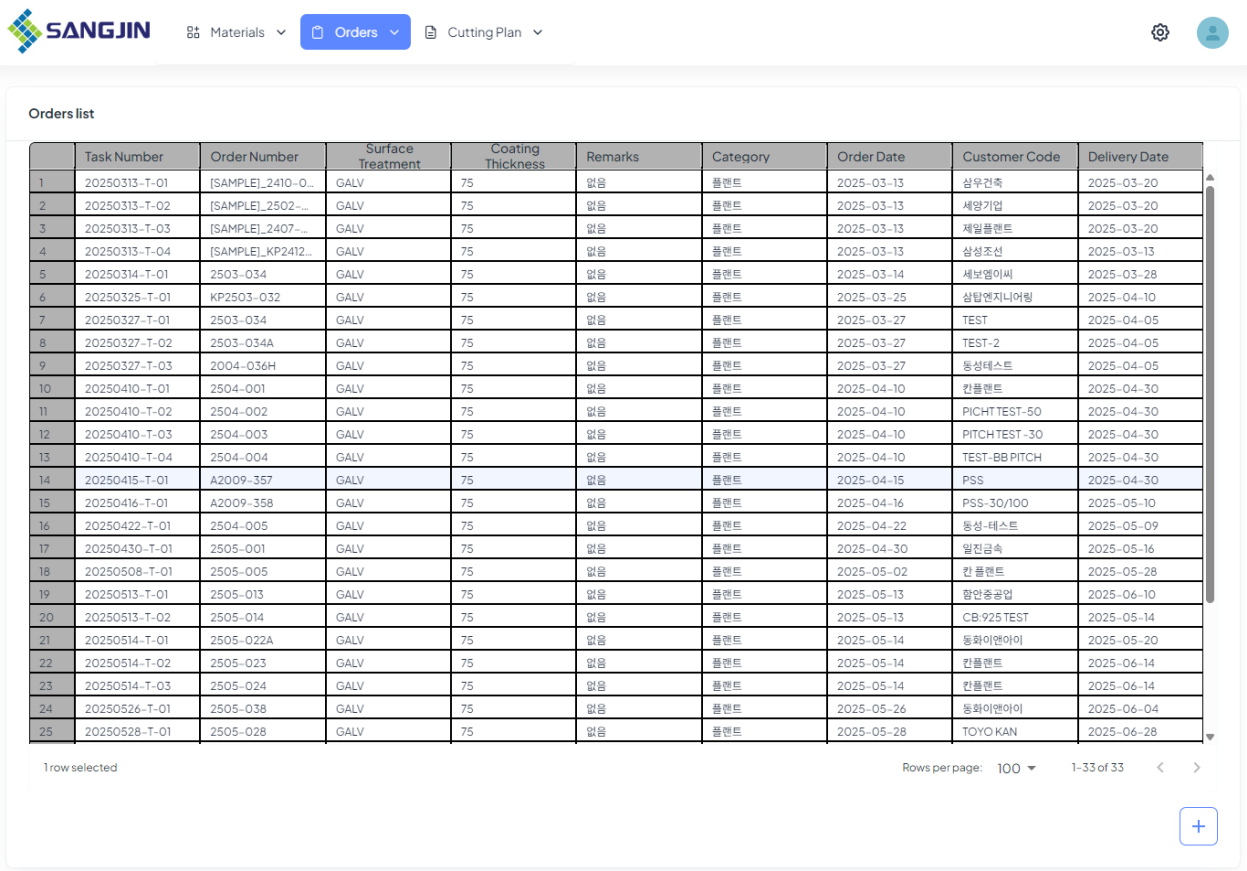
When adding an item, fields with a **red border** (Material ID, End-bar, Item Type) can be selected from the modal window, while the remaining fields allow for direct input.



Orders Menu

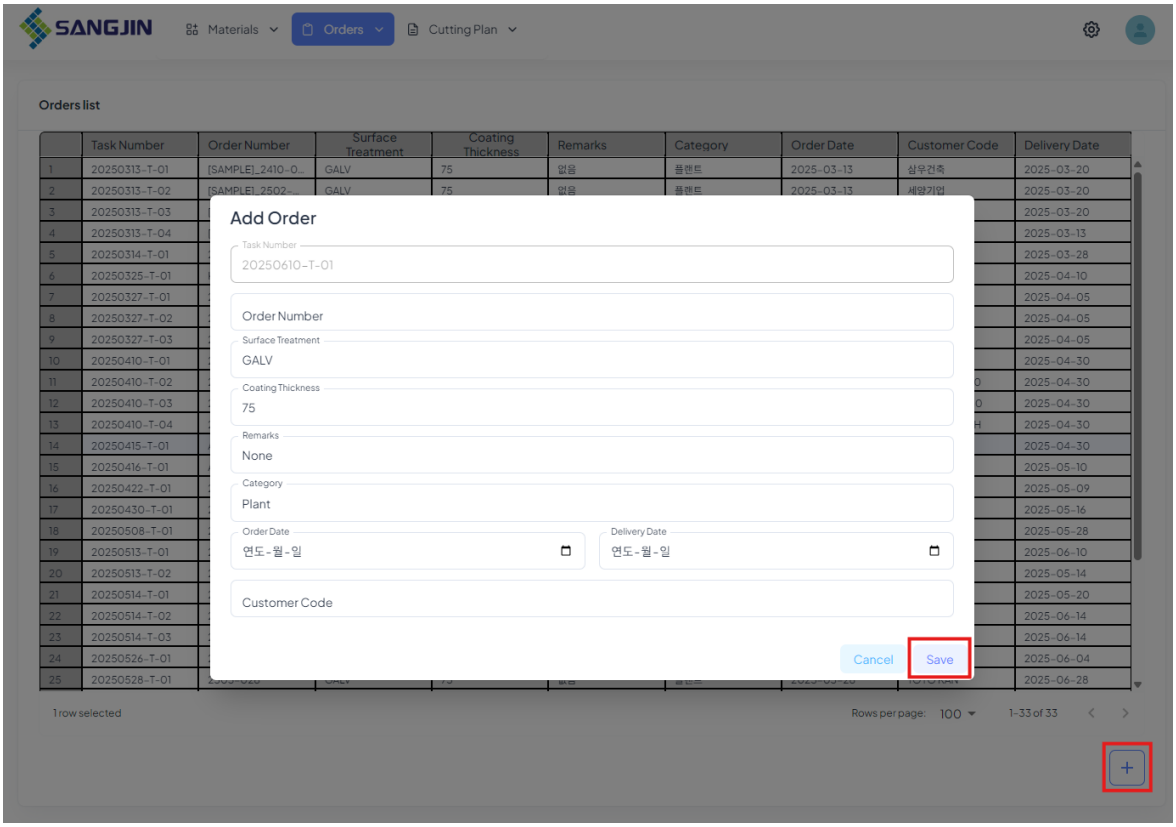


This page allows you to **manage your order list**.

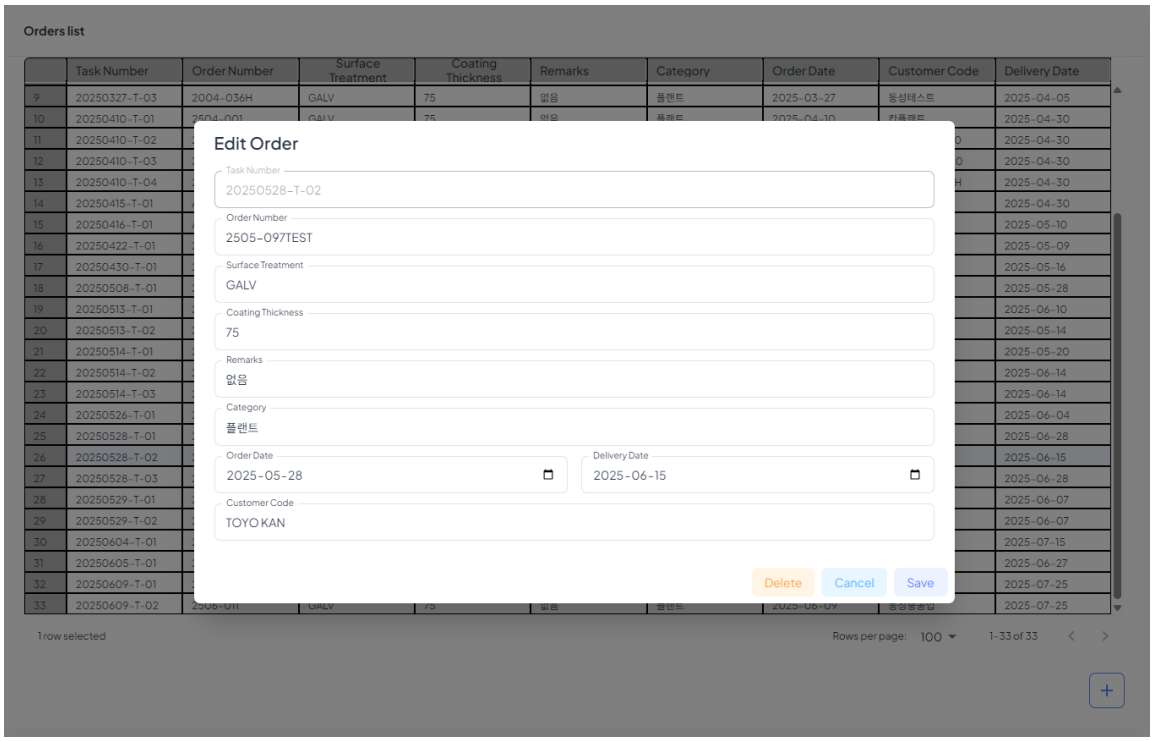


	Task Number	Order Number	Surface Treatment	Coating Thickness	Remarks	Category	Order Date	Customer Code	Delivery Date
1	20250313-T-01	[SAMPLE]_2410-0...	GALV	75	없음	플랜트	2025-03-13	삼우건축	2025-03-20
2	20250313-T-02	[SAMPLE]_2502-...	GALV	75	없음	플랜트	2025-03-13	세양기업	2025-03-20
3	20250313-T-03	[SAMPLE]_2407-...	GALV	75	없음	플랜트	2025-03-13	제일플랜트	2025-03-20
4	20250313-T-04	[SAMPLE]_KP2412...	GALV	75	없음	플랜트	2025-03-13	삼성조선	2025-03-13
5	20250314-T-01	2503-034	GALV	75	없음	플랜트	2025-03-14	세보엠이씨	2025-03-28
6	20250325-T-01	KP2503-032	GALV	75	없음	플랜트	2025-03-25	삼탑엔지니어링	2025-04-10
7	20250327-T-01	2503-034	GALV	75	없음	플랜트	2025-03-27	TEST	2025-04-05
8	20250327-T-02	2503-034A	GALV	75	없음	플랜트	2025-03-27	TEST-2	2025-04-05
9	20250327-T-03	2004-036H	GALV	75	없음	플랜트	2025-03-27	동성테스트	2025-04-05
10	20250410-T-01	2504-001	GALV	75	없음	플랜트	2025-04-10	칸플랜트	2025-04-30
11	20250410-T-02	2504-002	GALV	75	없음	플랜트	2025-04-10	PICHT TEST-50	2025-04-30
12	20250410-T-03	2504-003	GALV	75	없음	플랜트	2025-04-10	PITCH TEST-30	2025-04-30
13	20250410-T-04	2504-004	GALV	75	없음	플랜트	2025-04-10	TEST-BB PITCH	2025-04-30
14	20250415-T-01	A2009-357	GALV	75	없음	플랜트	2025-04-15	PSS	2025-04-30
15	20250416-T-01	A2009-358	GALV	75	없음	플랜트	2025-04-16	PSS-30/100	2025-05-10
16	20250422-T-01	2504-005	GALV	75	없음	플랜트	2025-04-22	동성-테스트	2025-05-09
17	20250430-T-01	2505-001	GALV	75	없음	플랜트	2025-04-30	일진금속	2025-05-16
18	20250508-T-01	2505-005	GALV	75	없음	플랜트	2025-05-02	칸 플랜트	2025-05-28
19	20250513-T-01	2505-013	GALV	75	없음	플랜트	2025-05-13	함안중공업	2025-06-10
20	20250513-T-02	2505-014	GALV	75	없음	플랜트	2025-05-13	CB:925 TEST	2025-05-14
21	20250514-T-01	2505-022A	GALV	75	없음	플랜트	2025-05-14	동화이앤이이	2025-05-20
22	20250514-T-02	2505-023	GALV	75	없음	플랜트	2025-05-14	칸플랜트	2025-06-14
23	20250514-T-03	2505-024	GALV	75	없음	플랜트	2025-05-14	칸플랜트	2025-06-14
24	20250526-T-01	2505-038	GALV	75	없음	플랜트	2025-05-26	동화이앤이이	2025-06-04
25	20250528-T-01	2505-028	GALV	75	없음	플랜트	2025-05-28	TOYO KAN	2025-06-28

You can **create, modify, or delete** orders directly within the **Orders list table**.

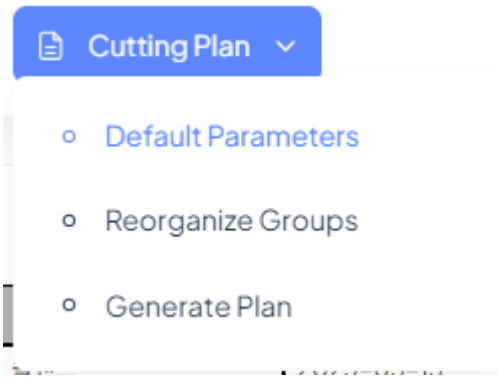


The Task Number is automatically generated. It follows the format ‘YYYMMDD-T-{2-digit integer}’. The 2-digit integer increments by one for each order were created on the same day.



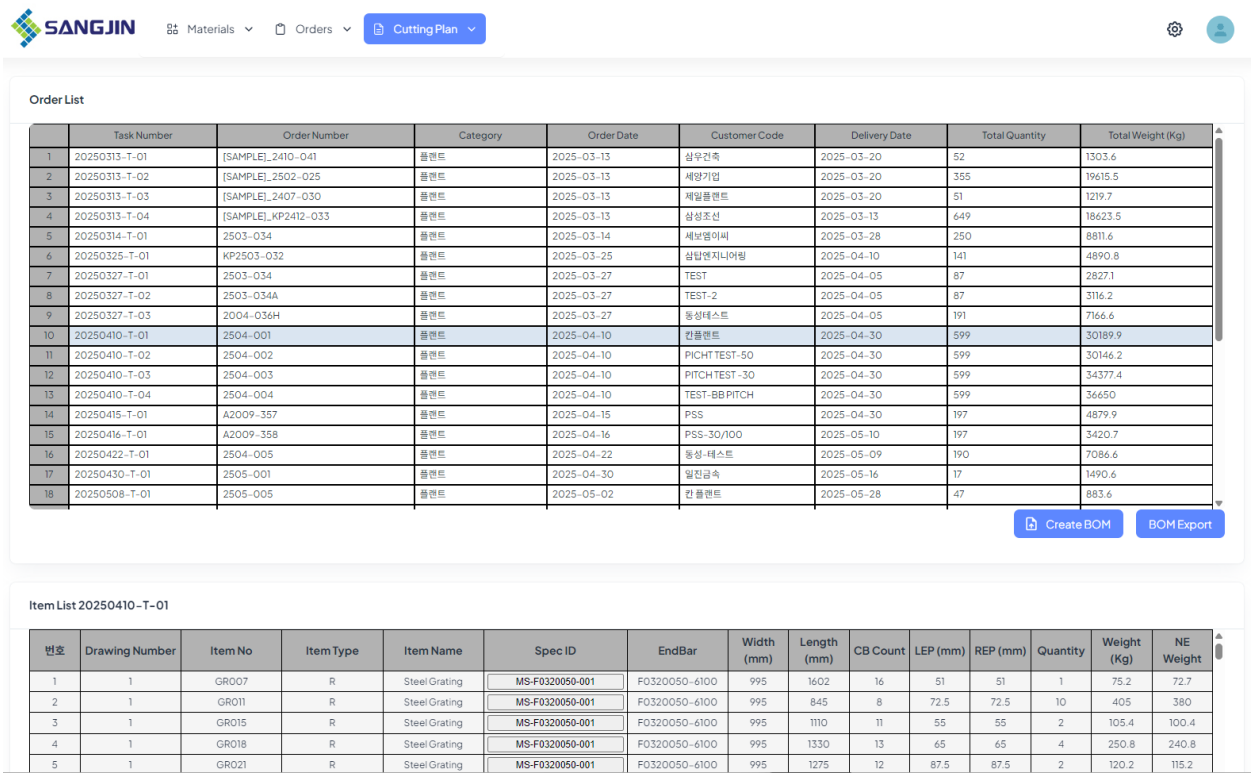
If you want to modify or delete an order, simply click on its row to proceed with the changes or removal. However, please note that modification and deletion are not possible if a cutting plan has already been generated for that order.

Cutting Plan Menu

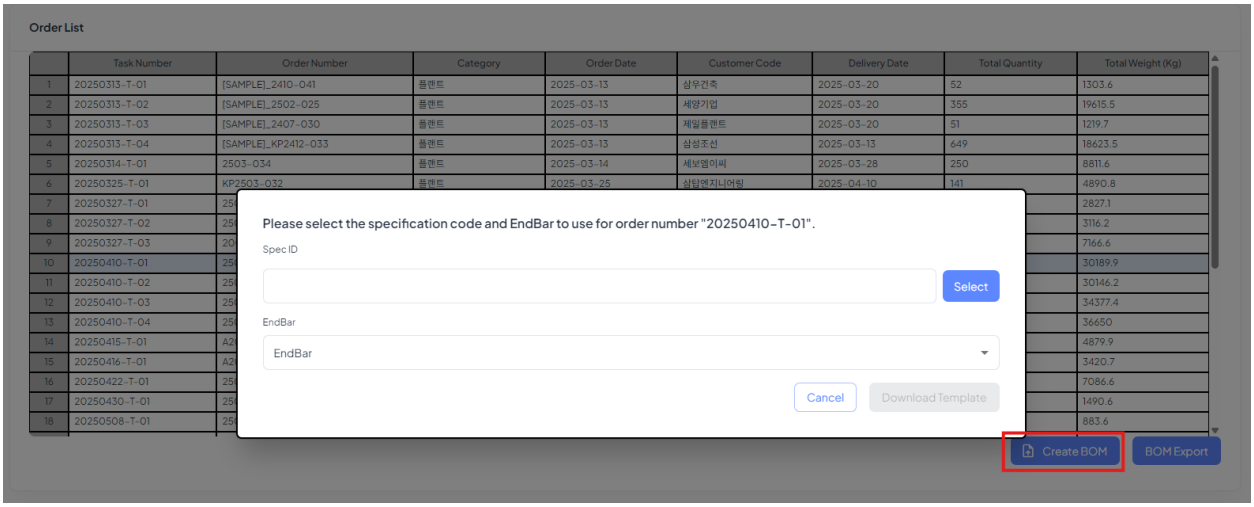


This page allows you to **add and group item lists to orders** for cutting plan generation. You can also **create cutting plans** and view **work orders** here.

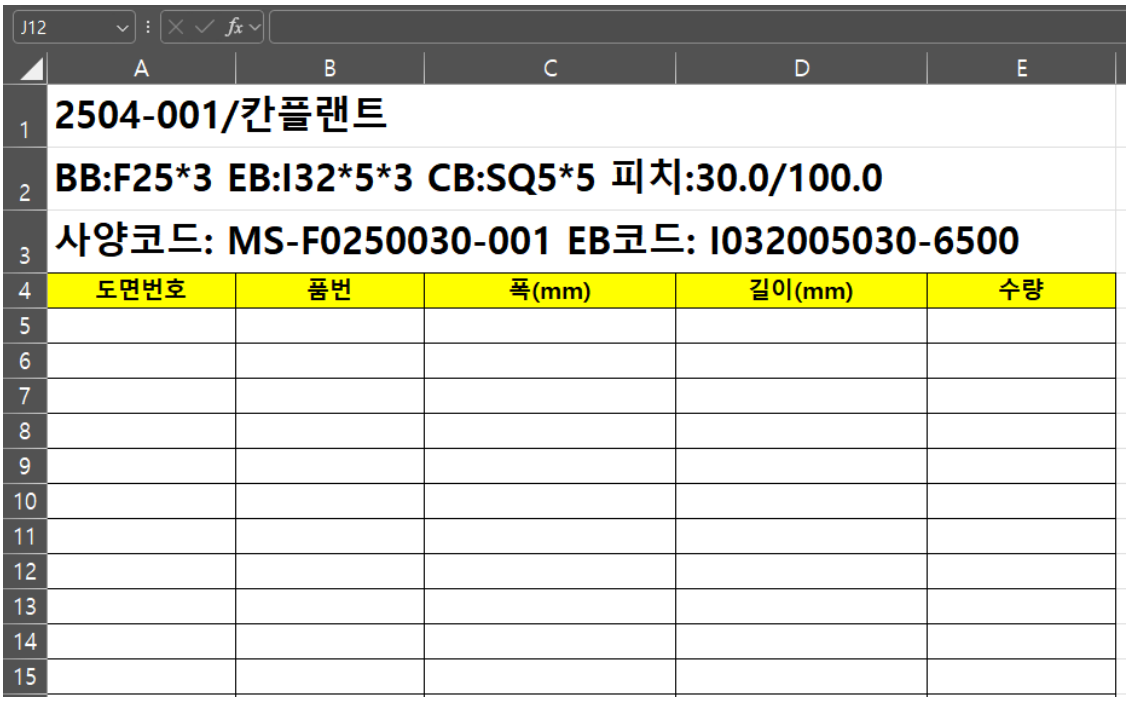
Default Parameters Page



This page features two lists. The **Order List** (top table) displays the orders you've created. From here, you can also generate a **BOM File** for bulk upload or download the currently saved BOM as an Excel file. The **Item List** (bottom table), identified by its Task Number, allows you to add or delete detailed items for the selected order.

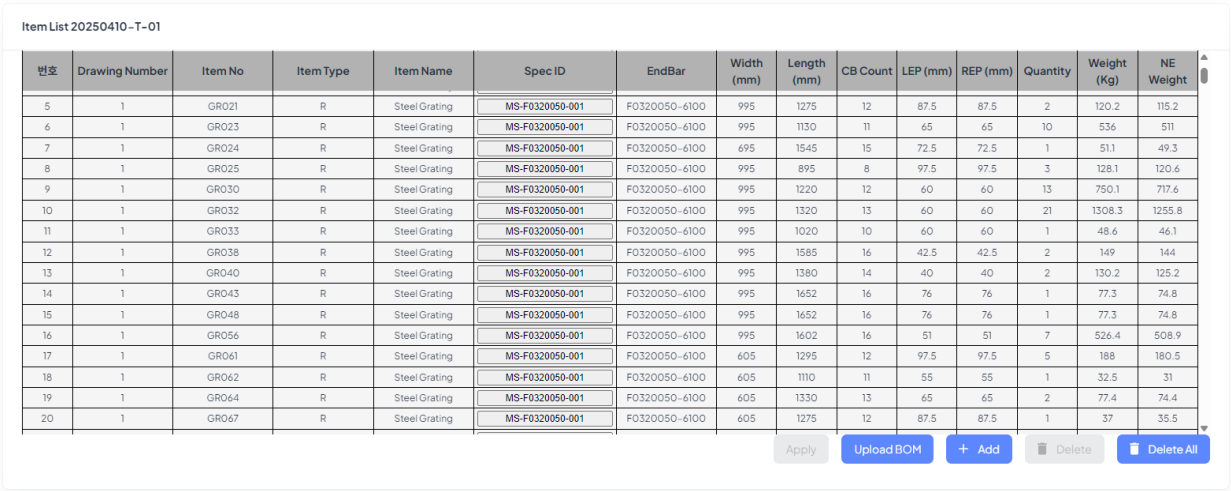


- Create BOM : You can create an **Excel template for bulk uploads**. This template allows you to specify the **Spec ID** and **EndBar type**.
- BOM Export : You can download the **currently generated orders** in an Excel format.



	A	B	C	D	E
1	2504-001/칸플랜트				
2	BB:F25*3 EB:I32*5*3 CB:SQ5*5 피치:30.0/100.0				
3	사양코드: MS-F0250030-001 EB코드: I032005030-6500				
4	도면번호	품번	폭(mm)	길이(mm)	수량
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					

After downloading the Excel file, you can input your desired data into it and then **bulk upload** it using the bottom table.



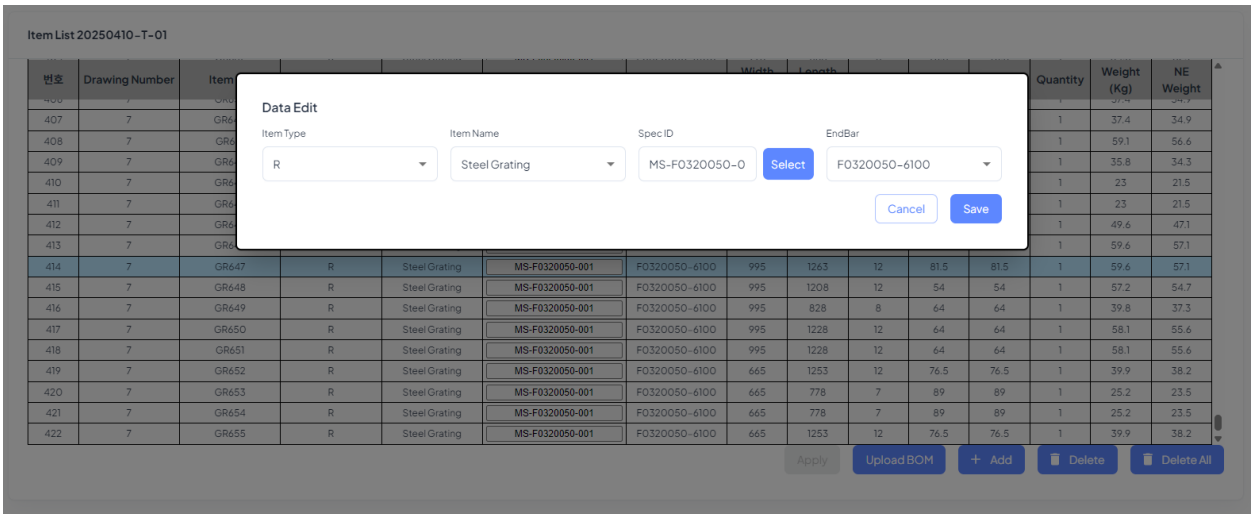
Item List 20250410-T-01

번호	Drawing Number	Item No	Item Type	Item Name	Spec ID	EndBar	Width (mm)	Length (mm)	CB Count	LEP (mm)	REP (mm)	Quantity	Weight (Kg)	NE Weight
5	1	GR021	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1275	12	87.5	87.5	2	120.2	115.2
6	1	GR023	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1130	11	65	65	10	536	511
7	1	GR024	R	Steel Grating	MS-F0320050-001	F0320050-6100	695	1545	15	72.5	72.5	1	51.1	49.3
8	1	GR025	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	895	8	97.5	97.5	3	128.1	120.6
9	1	GR030	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1220	12	60	60	13	750.1	717.6
10	1	GR032	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1320	13	60	60	21	1308.3	1255.8
11	1	GR033	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1020	10	60	60	1	48.6	46.1
12	1	GR038	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1585	16	42.5	42.5	2	149	144
13	1	GR040	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1380	14	40	40	2	130.2	125.2
14	1	GR043	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1652	16	76	76	1	77.3	74.8
15	1	GR048	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1652	16	76	76	1	77.3	74.8
16	1	GR056	R	Steel Grating	MS-F0320050-001	F0320050-6100	995	1602	16	51	51	7	526.4	508.9
17	1	GR061	R	Steel Grating	MS-F0320050-001	F0320050-6100	605	1295	12	97.5	97.5	5	188	180.5
18	1	GR062	R	Steel Grating	MS-F0320050-001	F0320050-6100	605	1110	11	55	55	1	32.5	31
19	1	GR064	R	Steel Grating	MS-F0320050-001	F0320050-6100	605	1330	13	65	65	2	77.4	74.4
20	1	GR067	R	Steel Grating	MS-F0320050-001	F0320050-6100	605	1275	12	87.5	87.5	1	37	35.5

Apply | Upload BOM | + Add | Delete | Delete All

- Apply: Applies all changes.

- Upload BOM: Uploads the Bill of Materials you previously created.
- Add: Adds a single item.
- Delete: Deletes the selected item.
- Delete All: Deletes all items within the current order.



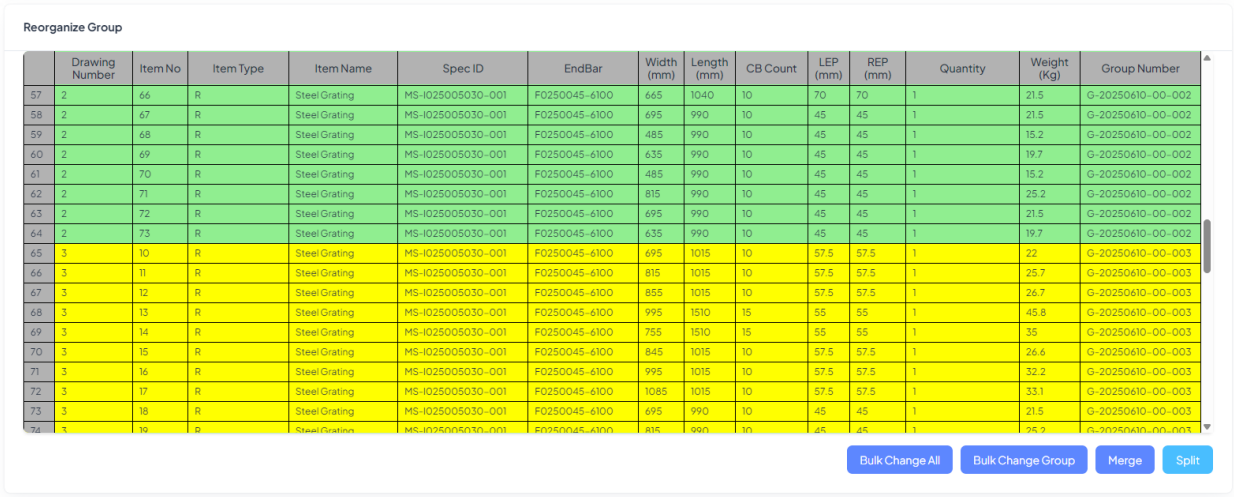
If you want to **modify an item**, you can either **double-click the cell** or press **Enter**.

Reorganize Groups Page

This page allows you to **merge or split items** within an order based on their **Drawing Number**.

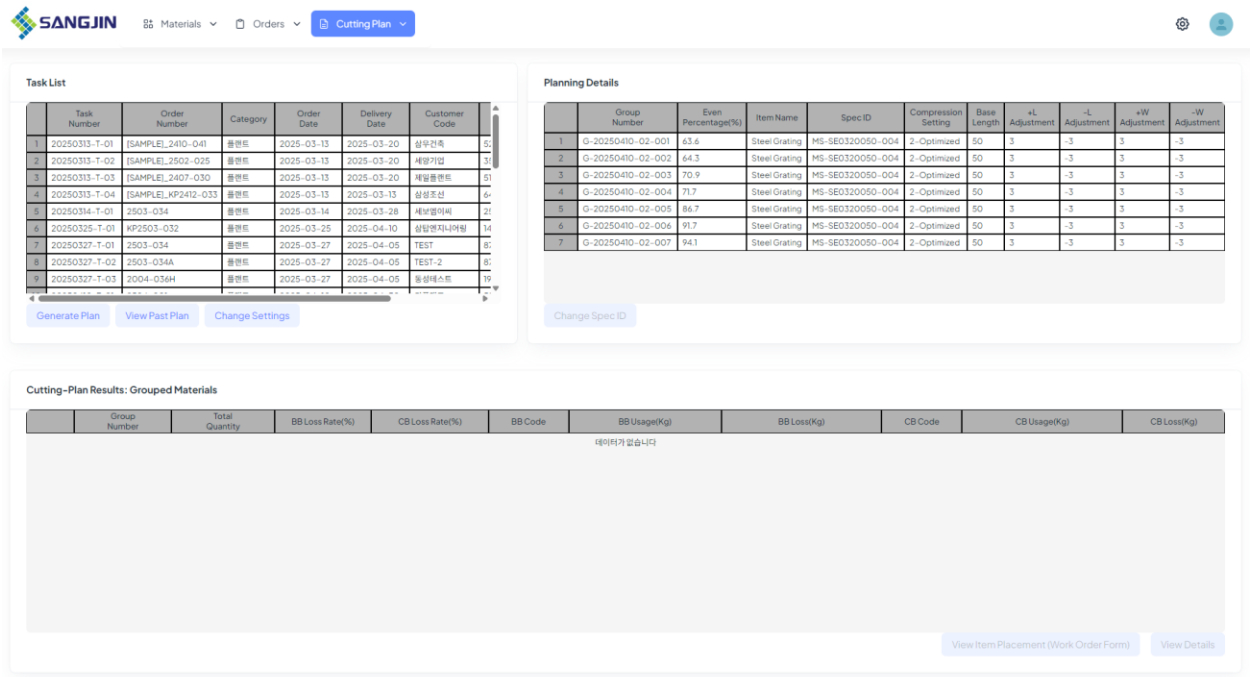
You can select multiple items with the same **Drawing Number** by holding **Ctrl** and clicking.

When selected, the rows will alternate between green and yellow.



- **Bulk Change All**: Changes the **Spec ID** for all items in the current order.
- **Bulk Change Group**: Changes the **Spec ID** for the selected groups.
- **Merge**: Combines the selected groups into a single group.
- **Split**: Restores merged groups back to their original, individual states.

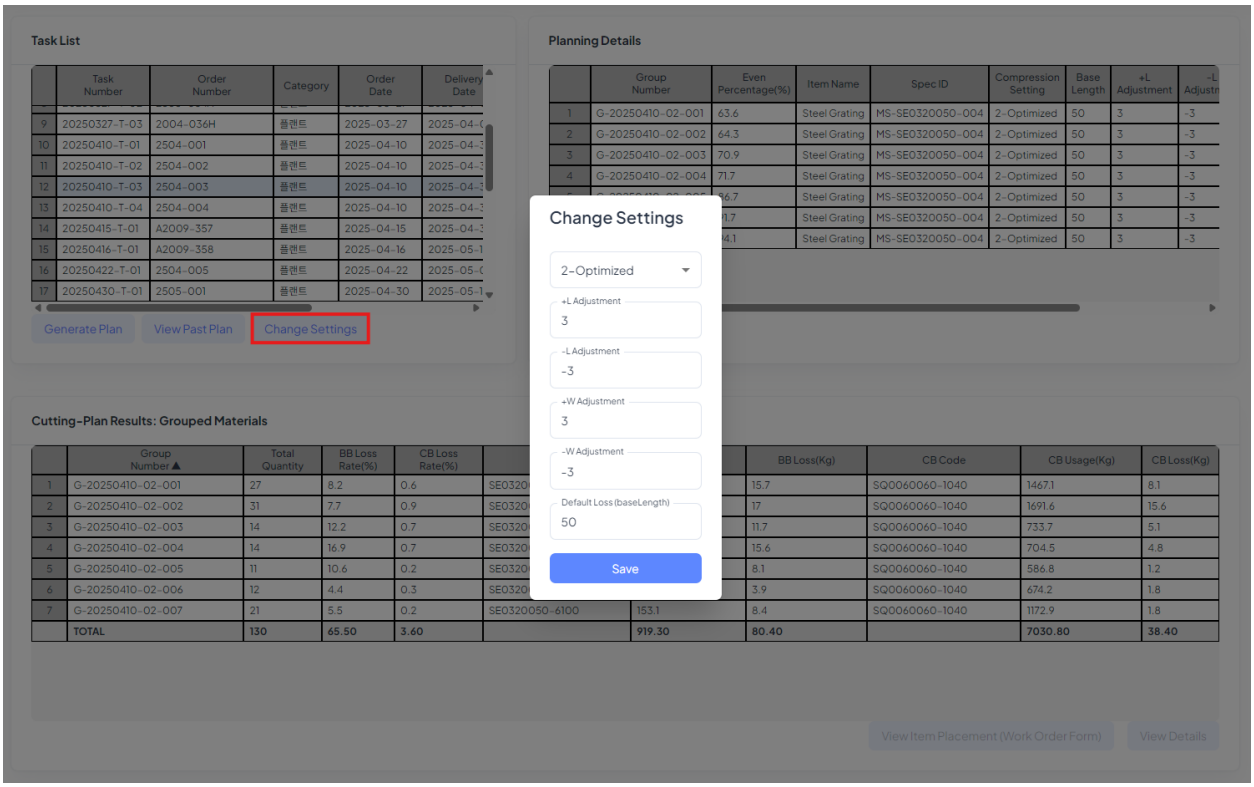
Generate Plan Page

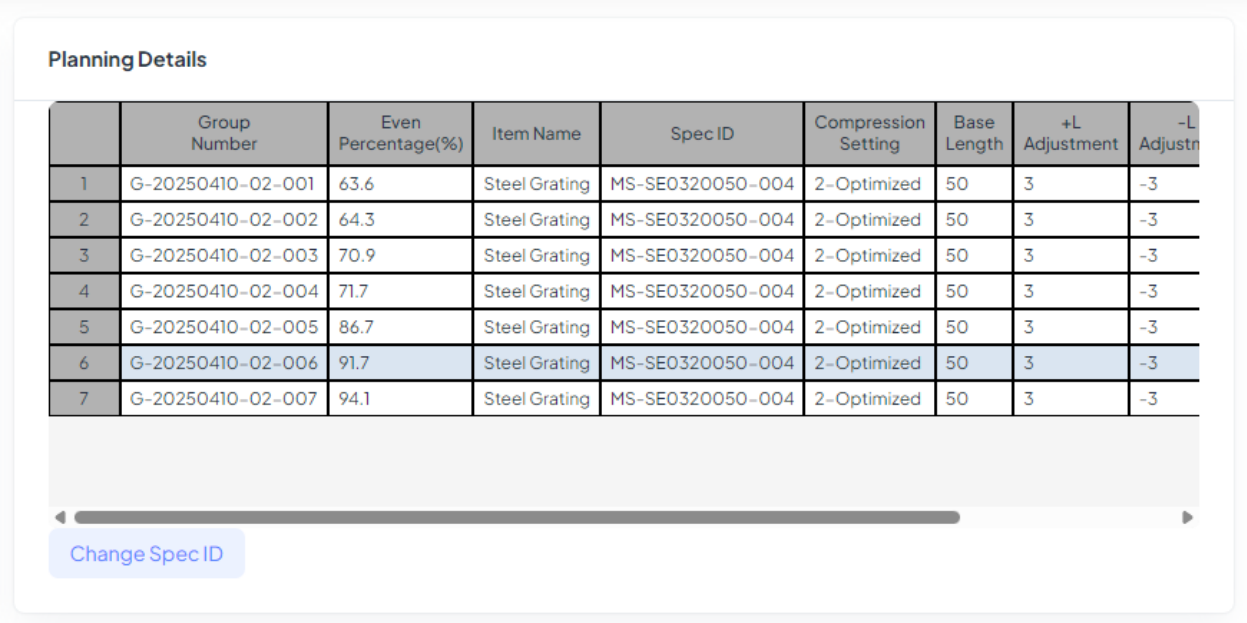


This page allows you to **generate cutting plans** for orders.

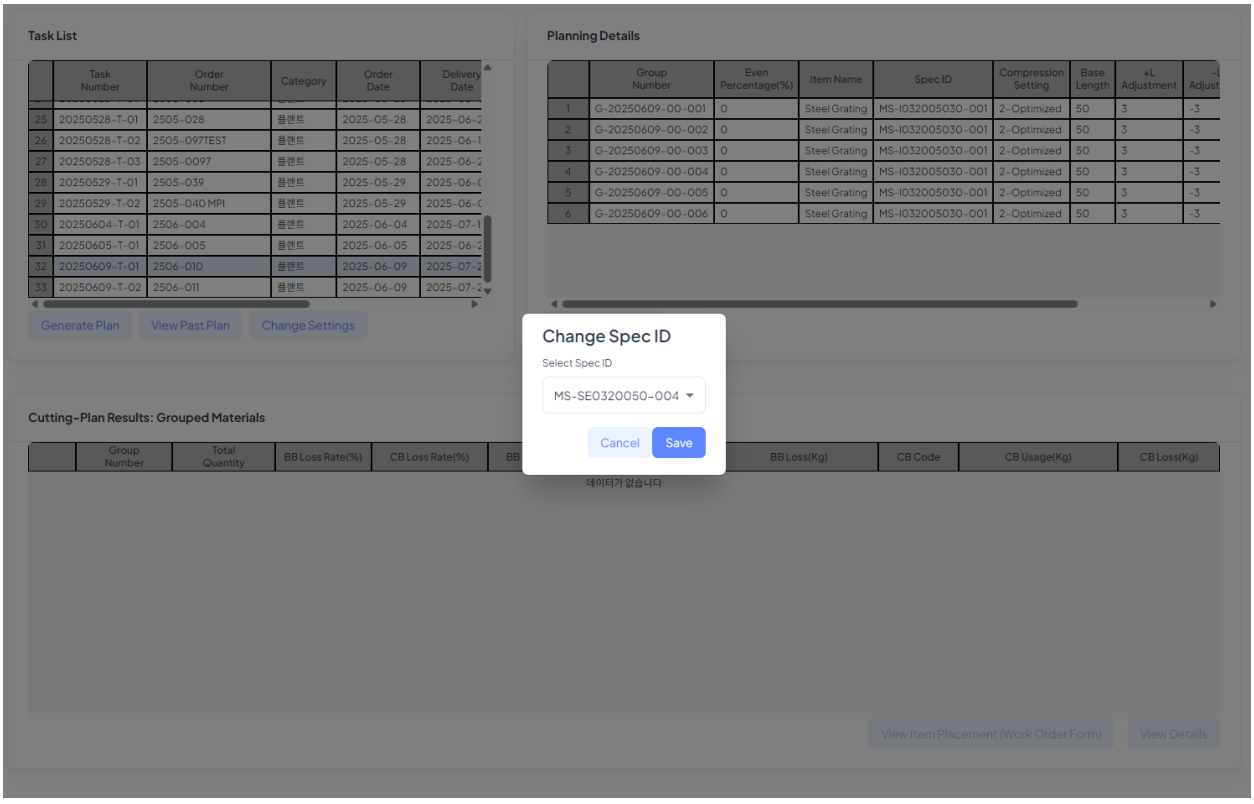
The top-left table displays your **current orders**.

- **Generate Plan**: This creates a cutting plan for the currently selected order. This process will take longer with a higher number of assigned items and generated groups.
- **View Past Plan**: You can view previously created cutting plans here.
- **Change Settings**: This allows you to modify the options for generating cutting plans.

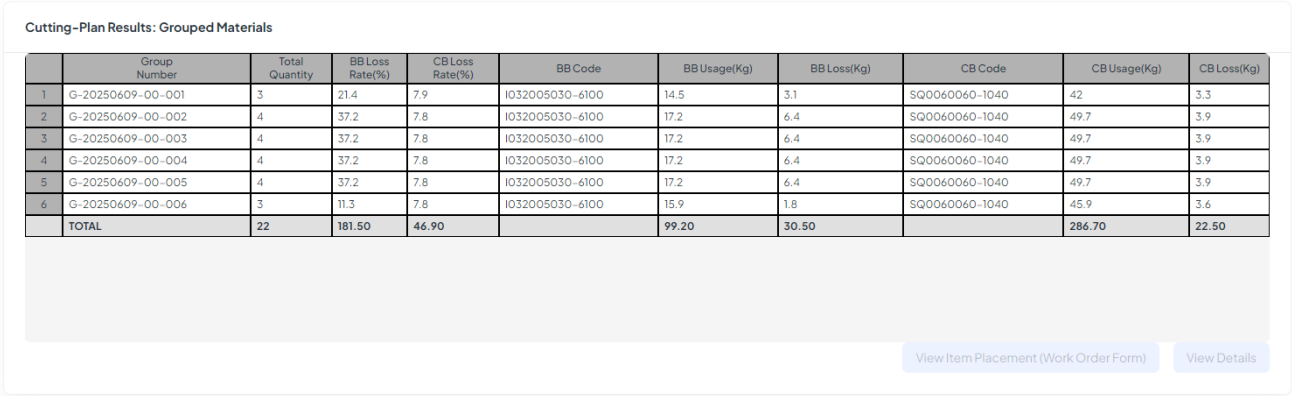




The top-right table allows you to **change the Spec ID by group**. This enables you to compare with **Past Plans** to see which Spec ID results in less material loss.



The **Spec IDs** you can select here must share the same **BB code** and **CB code**, but can have different lengths.



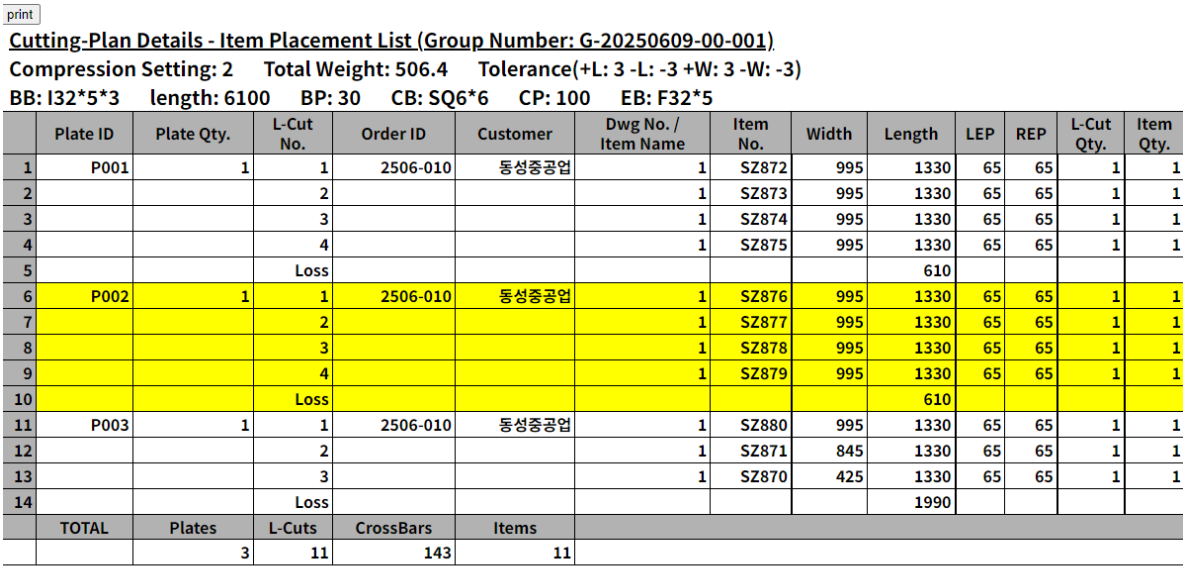
Cutting-Plan Results: Grouped Materials

	Group Number	Total Quantity	BB Loss Rate(%)	CB Loss Rate(%)	BB Code	BB Usage(Kg)	BB Loss(Kg)	CB Code	CB Usage(Kg)	CB Loss(Kg)
1	G-20250609-00-001	3	21.4	7.9	I032005030-6100	14.5	3.1	SQ0060060-1040	42	3.3
2	G-20250609-00-002	4	37.2	7.8	I032005030-6100	17.2	6.4	SQ0060060-1040	49.7	3.9
3	G-20250609-00-003	4	37.2	7.8	I032005030-6100	17.2	6.4	SQ0060060-1040	49.7	3.9
4	G-20250609-00-004	4	37.2	7.8	I032005030-6100	17.2	6.4	SQ0060060-1040	49.7	3.9
5	G-20250609-00-005	4	37.2	7.8	I032005030-6100	17.2	6.4	SQ0060060-1040	49.7	3.9
6	G-20250609-00-006	3	11.3	7.8	I032005030-6100	15.9	1.8	SQ0060060-1040	45.9	3.6
	TOTAL	22	181.50	46.90		99.20	30.50		286.70	22.50

View Item Placement (Work Order Form) View Details

The bottom table displays the **generated cutting plan**. When you click on a group, two buttons will become active:

- **View Item Placement (Work Order Form)**: This opens the work order form for the selected group in a new window.



print

Cutting-Plan Details - Item Placement List (Group Number: G-20250609-00-001)

Compression Setting: 2 Total Weight: 506.4 Tolerance(+L: 3 -L: -3 +W: 3 -W: -3)

BB: I32*5*3 length: 6100 BP: 30 CB: SQ6*6 CP: 100 EB: F32*5

	Plate ID	Plate Qty.	L-Cut No.	Order ID	Customer	Dwg No. / Item Name	Item No.	Width	Length	LEP	REP	L-Cut Qty.	Item Qty.
1	P001	1	1	2506-010	동성중공업	1	SZ872	995	1330	65	65	1	1
2			2			1	SZ873	995	1330	65	65	1	1
3			3			1	SZ874	995	1330	65	65	1	1
4			4			1	SZ875	995	1330	65	65	1	1
5			Loss						610				
6	P002	1	1	2506-010	동성중공업	1	SZ876	995	1330	65	65	1	1
7			2			1	SZ877	995	1330	65	65	1	1
8			3			1	SZ878	995	1330	65	65	1	1
9			4			1	SZ879	995	1330	65	65	1	1
10			Loss						610				
11	P003	1	1	2506-010	동성중공업	1	SZ880	995	1330	65	65	1	1
12			2			1	SZ871	845	1330	65	65	1	1
13			3			1	SZ870	425	1330	65	65	1	1
14			Loss						1990				
	TOTAL	Plates	L-Cuts	CrossBars	Items								
		3	11	143	11								

- **View Details**: This allows you to view the layout of the selected group in 3D.

Plate No.: P001

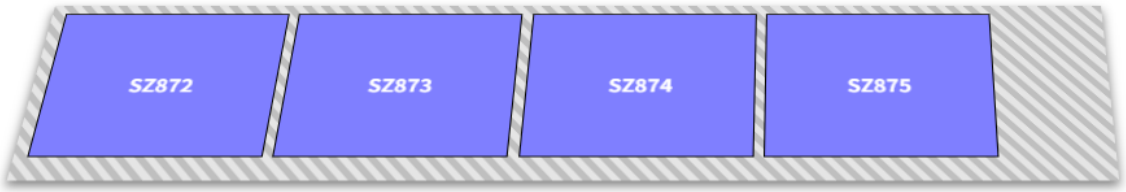


Plate No.: P002

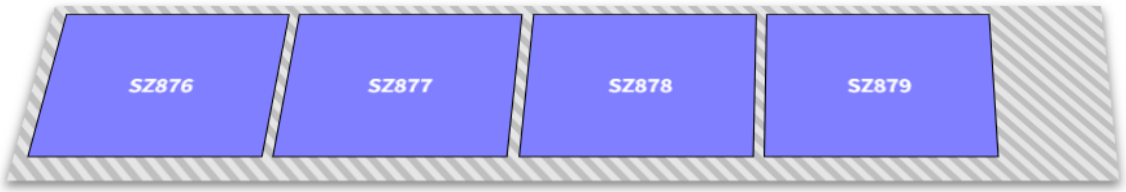
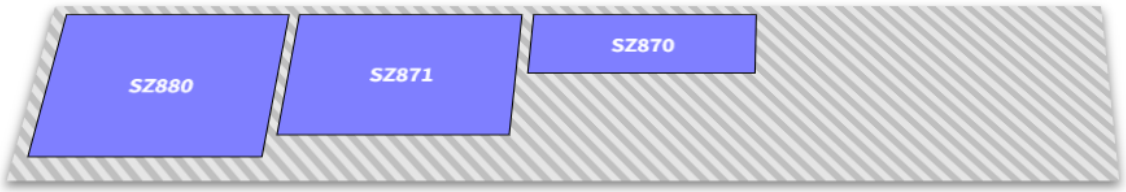



Plate No.: P003