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Moduline Fraisa: Open points- and todo-list


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1.1	Batch report PDF File	ps		2022 08 12	2022 08 17
1.1.1	Translations	ps		2022 08 12	2022 08 17
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1.1.6	What is "Loading ID" and "Unloading ID"	ps		2022 08 12	2022 08 17
1.1.7	Missing value and non-uniform spelling	ps		2022 08 12	2022 08 17
1.1.8	Unclear information "Pump Flow" in batch report Conductivity is missing on the batch report	ps		2022 08 12	2022 08 17
1.1.9	Missing order information	ps		2022 08 12	2022 08 17
1.1.10	Fraisa logo on batch report	ps		2022 08 12	2022 08 17
1.2	Batch report CSV File	ps		2022 08 12	2022 08 17
1.3	Adding of bar code references is not possible	ps		2022 08 12	2022 08 17
1.4	Saving batch report PDF-files and CSV-Files on customer network	ps		2022 08 12	2022 08 17
2	ToDo List				
2.1	Entering and changing of loading information	ps		2022 08 12	2022 08 17

Company	Name	Function	Date	Signature	Initials
Fraisa	Simon Portmann	project engineer	21.07.2022		ps
JKS					

		Title	OpenPoint- and ToDo-list Moduline 12ML
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1 Open points


1.1 Batch report PDF File

1.1.1 Translations

Batch report must be in user language, German.

Please translate batch report texts to German as follows. (All additional information's on this translated batch report example are described in the following chapters 1.1.2 to 1.1.10)






Maschine:		Moduline	
Name:	12ML	Seite:	1 von 1
Software:	V1.2.0	Datum:	Montag, 11. Juli 2022

Chargen Nummer:	829
Start Zeit:	Montag, 11. Juli 2022 13:56:02
End Zeit:	Montag, 11. Juli 2022 14:55:57
Rezept Nummer:	1
Rezept Name:	Feinreinigung HM
Ladestation:	1
Entladestation:	1
Benutzer:	Amsonic
Korbnummer:	16

Programmablauf						Körbe seit Badwechsel			60
	Station	Resultat	Sequenz Rezept	Effektive Zeit [s]	Temperatur [°C]	Ultraschall unten Leistung [%]	Ultraschall Seite Leistung [%]	Leitwert [µS/cm]	Durchfluss Pumpe [l/Min]
13:56:02	1-US Reinigung	OK	1 - Pos 2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Reinigung	OK	1 - Pos 4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Spülen Wasser enthärtet	OK	1 - Pos 5	180.00	27.90	-	-	-	-
14:13:08	5-US Reinigung	OK	1 - Pos 6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-Spülen Osmosewasser	OK	1 - Pos 7	236.00	30.00	-	-	-	-
14:27:37	7-Spülen VE-Wasser	OK	1 - Pos 8	321.00	51.40	-	-	-	-
14:34:37	8-Spülen VE-Wasser	OK	1 - Pos 9	319.00	54.00	-	-	-	-
14:42:49	9-Heissluft Trocknen	OK	1 - Pos 10	312.00	102.50	-	-	-	-
14:49:39	10- Heissluft Trocknen	NOK	1 - Pos 11	300.00	60.00	-	-	-	-
14:55:57	11- Heissluft Trocknen	OK	1 - Pos 12	300.00	104.60	-	-	-	-

Aufträge				
Nummer	Palette A	Palette B	Palette C	Palette D
1	Abcd	cdef	sdfsdf	Sdfsdf
2	Edfg	Adfgdfgsdfg		Vdhfgh
3	Sdfaf	Fffff		Fdff
4	sddd	Fdg		
5	Dfgsdfg			
6	Abcd	cdef	sdfsdf	Sdfsdf
7	Edfg	Adfgdfgsdfg		Vdhfgh
8	Sdfaf	Fffff		Fdff

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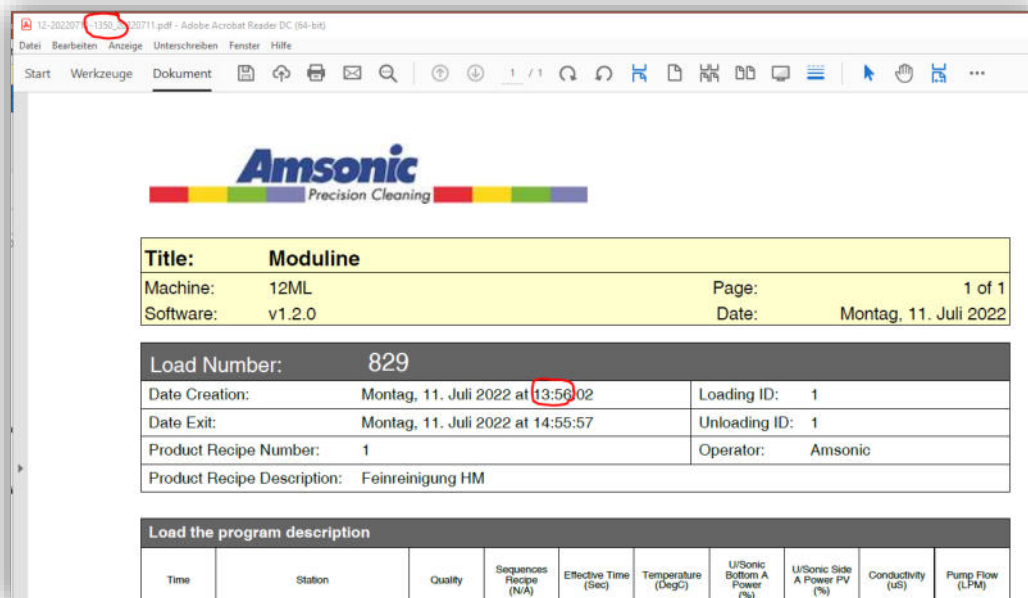
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1.1.2 Change of file name

In the reason of finding batch reports on the file system, it is not opportune to have first the basket number in the file name.

- Actual: "Basket number"- "Date"- "Time"- "Date".pdf e.g.: 12-20220711-1350_20220711.pdf
New: "Date"- "Time"- "Basket number".pdf e.g.: 20220711-1350_12.pdf
- Is there any reason for the second date in the actual file name? 12-20220711-1350_20220711.pdf
- What is the difference between the file name-time and the "Date Creation"-time?
Why is it not the same time?


Please inform the customer.



Title: Moduline	
Machine: 12ML	Page: 1 of 1
Software: v1.2.0	Date: Montag, 11. Juli 2022

Load Number: 829	
Date Creation: Montag, 11. Juli 2022 at 13:56:02	Loading ID: 1
Date Exit: Montag, 11. Juli 2022 at 14:55:57	Unloading ID: 1
Product Recipe Number: 1	Operator: Amsonic
Product Recipe Description: Feinreinigung HM	


Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power PV (%)	Conductivity (uS)	Pump Flow (LPM)

		Title	OpenPoint- and ToDo-list Moduline 12ML
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1.1.3 Add number of baskets since the last bath-change as on HMI

Please add the number of baskets since the last bath-change to the batch report:

Title: Moduline			
Machine:	12ML	Page:	1 of 1
Software:	v1.2.0	Date:	Montag, 11. Juli 2022
Load Number:	829	Number of baskets:	60
Date Creation:	Montag, 11. Juli 2022 at 13:56:02	Loading ID:	1
Date Exit:	Montag, 11. Juli 2022 at 14:55:57	Unloading ID:	1
Product Recipe Number:	1	Operator:	Amsonic
Product Recipe Description: Feinreinigung HM			



The HMI interface shows a 'Korb Menge' (Basket Quantity) field with the value '60' highlighted by a red box. A red arrow points from this field to the 'Number of baskets' field in the batch report above. Other controls include 'Zurücksetzen' (Reset), 'AUS' (Off), and status indicators for 'Hauptsystem ON', 'Vorbereitung ON', 'Grundstellung ON', and 'Auto Start OFF'.

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1.1.4 Batch times


The time column of the station list of the batch report seems to display the start times of each station.

So, the “Date Exit:” time of the basket cannot be the same time as the start time of station 11, because the basket was in this station 11 during station 11 process time.

Please write the effective “Date Exit:”-time instead.

Load Number: 829	
Date Creation:	Montag, 11. Juli 2022 at 13:56:02
Date Exit:	Montag, 11. Juli 2022 at 14:55:57
Product Recipe Number:	1
Product Recipe Description:	Feinreinigung HM
Loading ID:	1
Unloading ID:	1
Operator:	Amsonic

Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power PV (%)	Conductivity (uS)	Pump Flow (LPM)
13:56:02	1-US Cleaning	GOOD	1 Pos2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Cleaning	GOOD	1 pos4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Softened Water Rinsing	GOOD	1 Pos5	180.00	27.90	-	-	-	-
14:13:08	5-US Cleaning	GOOD	1pos6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-RO Rinsing	GOOD	1 pos7	236.00	30.00	-	-	-	-
14:27:37	7-DI Rinsing	GOOD	1 pos8	321.00	51.40	-	-	-	-
14:34:37	8-DI Rinsing	GOOD	1 pos9	319.00	54.00	-	-	-	-
14:42:49	9-Hot Air Drying	GOOD	1 pos10	312.00	102.50	-	-	-	-
14:49:39	10-Hot Air Drying	GOOD		300.00	102.00	-	-	-	-
14:55:57	11-Hot Air Drying	GOOD	1 pos 12	300.00	104.60	-	-	-	-

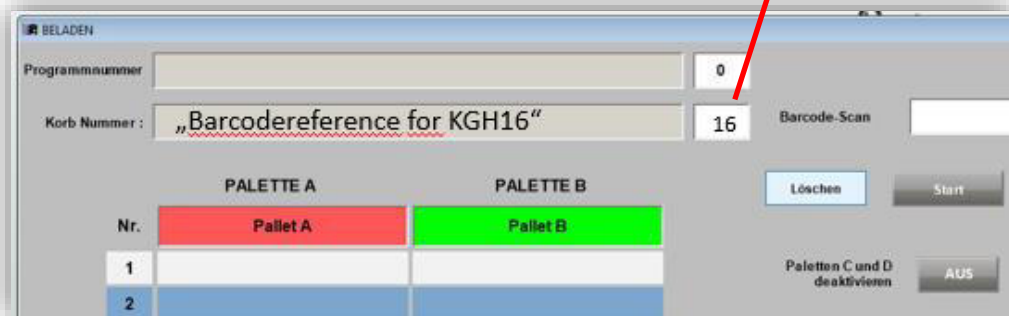
		Title	OpenPoint- and ToDo-list Moduline 12ML
		Project name	Fraisa
		Equipment-N°	980000006522
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1.1.5 Add used basket number to the batch report


There is no information about the used basket in the batch report.

Please add this information.

Title: Moduline	
Machine: 12ML	Page: 1 of 1
Software: v1.2.0	Date: Montag, 11. Juli 2022
Load Number: 829	
Date Creation: Montag, 11. Juli 2022 at 13:56:02	Loading ID: 1
Date Exit: Montag, 11. Juli 2022 at 14:55:57	Unloading ID: 1
Product Recipe Number: 1	Operator: Amsonic
Product Recipe Description: Feinreinigung HM	Basket number: 16



The screenshot shows the 'BELADEN' (Load) screen of the machine control interface. It includes fields for 'Programmnummer' (Program number) and 'Korb Nummer' (Basket number). The 'Korb Nummer' field contains the text '„Barcodereference for KGH16“' and the number '16'. There are also buttons for 'Barcode-Scan', 'Löschen' (Delete), 'Start', and 'AUS' (Off). The interface is divided into sections for 'PALETTE A' and 'PALETTE B', each with a table of 'Nr.' (Number) and 'Pallet A'/'Pallet B'.


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1.1.6 What is “Loading ID” and “Unloading ID”

The Unloading ID does not match with the output conveyor numbers!?

Please add correct conveyor number.


Title: Moduline			
Machine:	12ML	Page:	1 of 1
Software:	v1.2.0	Date:	Montag, 11. Juli 2022
Load Number: 829			
Date Creation:	Montag, 11. Juli 2022 at 13:56:02	Loading ID:	1
Date Exit:	Montag, 11. Juli 2022 at 14:55:57	Unloading ID:	1
Product Recipe Number:	1	Operator:	Amsonic
Product Recipe Description:	Feinreinigung HM		

		Title	OpenPoint- and ToDo-list Moduline 12ML
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1.1.7 Unclear information “Pump Flow” in batch report

Please inform customer which sensor and which unit this value has.

Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power PV (%)	Conductivity (uS)	Pump Flow (LPM)
13:56:02	1-US Cleaning	GOOD	1 pos2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Cleaning	GOOD	1 pos4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Softened Water Rinsing	GOOD	1 Pos5	180.00	27.90	-	-	-	-
14:13:08	5-US Cleaning	GOOD	1pos6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-RO Rinsing	GOOD	1 pos7	236.00	30.00	-	-	-	-
14:27:37	7-DI Rinsing	GOOD	1 pos8	321.00	51.40	-	-	-	-
14:34:37	8-DI Rinsing	GOOD	1 pos9	319.00	54.00	-	-	-	-
14:42:49	9-Hot Air Drying	GOOD	1 pos10	312.00	102.50	-	-	-	-
14:49:39	10-Hot Air Drying	GOOD	1 pos11	300.00	102.00	-	-	-	-
14:55:57	11-Hot Air Drying	GOOD	1 pos 12	300.00	104.60	-	-	-	-

		Title	OpenPoint- and ToDo-list Moduline 12ML
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1.1.8 Conductivity is missing on the batch report


There is no conductivity information displayed on the batch report.

Please add conductivity information on each station with a conductivity sensor.

Title: Moduline	
Machine: 12ML	Page: 1 of 1
Software: v1.2.0	Date: Montag, 11. Juli 2022

Load Number: 829	
Date Creation: Montag, 11. Juli 2022 at 13:56:02	Loading ID: 1
Date Exit: Montag, 11. Juli 2022 at 14:55:57	Unloading ID: 1
Product Recipe Number: 1	Operator: Amsonic
Product Recipe Description: Feinreinigung HM	


Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power PV (%)	Conductivity (uS)	Pump Flow (LPM)
13:56:02	1-US Cleaning	GOOD	1 Pos2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Cleaning	GOOD	1 pos4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Softened Water Rinsing	GOOD	1 Pos5	180.00	27.90	-	-	-	-
14:13:08	5-US Cleaning	GOOD	1pos6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-RO Rinsing	GOOD	1 pos7	236.00	30.00	-	-	-	-
14:27:37	7-DI Rinsing	GOOD	1 pos8	321.00	51.40	-	-	-	-
14:34:37	8-DI Rinsing	GOOD	1 pos9	319.00	54.00	-	-	-	-
14:42:49	9-Hot Air Drying	GOOD	1 pos10	312.00	102.50	-	-	-	-
14:49:39	10-Hot Air Drying	GOOD		300.00	102.00	-	-	-	-
14:55:57	11-Hot Air Drying	GOOD	1 pos 12	300.00	104.60	-	-	-	-

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1.1.9 Missing order information

The information of the content of pallets is missing.

Please add order information:




Title: Moduline	
Machine: 12ML	Page: 1 of 1
Software: v1.2.0	Date: Montag, 11. Juli 2022

Load Number: 829
Date Creation: Montag, 11. Juli 2022 at 13:56:02
Loading ID: 1
Date Exit: Montag, 11. Juli 2022 at 14:55:57
Unloading ID: 1
Product Recipe Number: 1
Operator: Amsonic
Product Recipe Description: Feinreinigung HM

Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power P/ (%)	Conductivity (uS)	Pump Flow (LPM)
13:56:02	1-US Cleaning	GOOD	1 Pos2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Cleaning	GOOD	1 pos4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Softened Water Rinsing	GOOD	1 Pos5	180.00	27.90	-	-	-	-
14:13:08	5-US Cleaning	GOOD	1pos6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-RO Rinsing	GOOD	1 pos7	236.00	30.00	-	-	-	-
14:27:37	7-DI Rinsing	GOOD	1 pos8	321.00	51.40	-	-	-	-
14:34:37	8-DI Rinsing	GOOD	1 pos9	319.00	54.00	-	-	-	-
14:42:49	9-Hot Air Drying	GOOD	1 pos10	312.00	102.50	-	-	-	-
14:49:39	10-Hot Air Drying	GOOD		300.00	102.00	-	-	-	-
14:55:57	11-Hot Air Drying	GOOD	1 pos 12	300.00	104.60	-	-	-	-

Orders				
Nb	PALLET A	PALLET B	PALLET C	PALLET D
1	Abcd	cdef	sdfsdf	Sdfsdf
2	Edfg	Adfgdfgasdfg		Vdhfgh
3	Sdfaf	Fffff		Fdff
4	sddd	Fdg		
5	Dfgsdfg			
6				
7				
8				


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1.1.10 Fraisa logo on batch report

The customer wishes its logo to be placed on the batch report.

Please add the logo. See files “1.1.10 Fraisa Logo xxxxx” and use which one fits.






Title: Moduline	
Machine: 12ML	Page: 1 of 1
Software: v1.2.0	Date: Montag, 11. Juli 2022

Load Number: 829	
Date Creation: Montag, 11. Juli 2022 at 13:56:02	Loading ID: 1
Date Exit: Montag, 11. Juli 2022 at 14:55:57	Unloading ID: 1
Product Recipe Number: 1	Operator: Amsonic
Product Recipe Description: Feinreinigung HM	

Load the program description									
Time	Station	Quality	Sequences Recipe (N/A)	Effective Time (Sec)	Temperature (DegC)	U/Sonic Bottom A Power (%)	U/Sonic Side A Power (V) (%)	Conductivity (uS)	Pump Flow (LPM)
13:56:02	1-US Cleaning	GOOD	1 Pos2	311.00	61.00	99.00	100.00	-	0.05
14:02:36	3-US Cleaning	GOOD	1 pos4	300.00	65.20	100.00	100.00	-	0.04
14:11:41	4-Softened Water Rinsing	GOOD	1 Pos5	180.00	27.90	-	-	-	-
14:13:08	5-US Cleaning	GOOD	1pos6	300.00	51.00	100.00	100.00	-	0.03
14:21:12	6-RO Rinsing	GOOD	1 pos7	235.00	30.00	-	-	-	-
14:27:37	7-DI Rinsing	GOOD	1 pos8	321.00	51.40	-	-	-	-
14:34:37	8-DI Rinsing	GOOD	1 pos9	319.00	54.00	-	-	-	-
14:42:49	9-Hot Air Drying	GOOD	1 pos10	312.00	102.50	-	-	-	-
14:49:39	10-Hot Air Drying	GOOD		300.00	102.00	-	-	-	-
14:55:57	11-Hot Air Drying	GOOD	1 pos 12	300.00	104.60	-	-	-	-

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1.2 Batch report CSV File

The CSV Batch report file must include at least all information as now it is realized.

If there are any more information's in the PDF Batch report file than in the CSV Batch report file, this information's must be added to the CSV File.

Please add information's to CSV that are available in PDF but not in CSV.

1.3 Adding of bar code references is not possible

Customer cannot add or assign bar codes.

See video "1.3 Bar code reference does not work.mp4"

- Is this due to an incompatible machine state?
- How is the procedure to add bar code references?

Please inform customer how to do it or rectify entering procedure.

1.4 Saving batch report PDF-files and CSV-Files on customer network

Customer wishes to save PDF and CSV files of batch reports on two places:

- Local on the IPC as actual done
- On a server directory of the customer.


Customer has now realized that the logged user of the 12ML can save files on its server directory.

There are the following two paths prepared:

\\scfsafsv01.fraisalan.ch\daten\Fraisa_Diverses\Amsonic_Batchreports\PDF
\\scfsafsv01.fraisalan.ch\daten\Fraisa_Diverses\Amsonic_Batchreports\CSV

Please implement the saving of the files on a second path.

The first and the second path may be programmed fix in the control program.

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2 ToDo List

2.1 Entering and changing of loading information

First, the actual way to enter loading information with the bar code reader must remain as is.

Second, customer must have the possibilities to:

- a. Select any desired field of the loading information's at any time of entering the information.
 - I. Wash program
 - II. Basket numbers
 - III. Order names
- b. Enter, delete, or change the content of the selected field in a free choice of
 - I. Touch screen keyboard/keypad and selection list
 - II. Connected keyboard and mouse
 - III. Bar code reader, by monitoring the validity of the scanned bar code:
 - i. Program bar codes may only be scanned to the program number field
 - ii. Basket number bar codes may only be scanned to the basket number field
 - iii. Order names may only be scanned to the order name fields
- c. Automatically field selection
 - I. After entering the program number, the basket number field is automatically selected to enter/change/delete information
 - II. After entering the basket number field, the first free order number field of Pallet A is selected to enter/change/delete information. If Pallet A is full, the next pallet is checked, and so on. If no free order information field is available, no other field is selected.
 - III. After the automatic field selection, the user may select any other field to work on it, as described on point a.) above.

Please add the features to manage loading information as described.

For this changes, Amsonic will order your quotations "Quotation No.: 20220100-QUO-01_R01" points 2 and 3.

Fraisa has provided a PowerPoint file with their idea, how to manage loading information.

See file "2.1 Entering loading information.pptx"