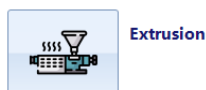


# Extrusion Reporting – Full Manual (Operator)

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## 1. View Production Order Schedule


This page will display the production order schedule for your current line ordered by Seq. Make sure your page is showing the correct line.

PVC Extrusion Production Order Schedule											
Machine : VE21		<a href="#">Select</a>		<a href="#">Refresh</a>		Last Update Time : 07/20/2022 08:38 AM					
View PI		Seq	Prod. Order#	Embossment	Thickness (mm)	Color	Produced / Order PCs	Produced / Total Pallets	PCs / Pallet	Prod. Code	Prod. Desc.
	In Production	10	RV22112-002	(BLANK)	12	White	688 / 3,520	12 / 61	58	H120AWS1	INTEPLAST SH 12MMx4'x8'(SM)1ST
	Start	30	RU22610-034	(BLANK)	6	White	414 / 1,599	9 / 22	75	H060AWS1	INTEPLAST SH 6MMx4'x8'(SM)1ST
	Start	40	RU22610-037	(BLANK)	6	White	0 / 1,599	0 / 22	75	H060AWS1	INTEPLAST SH 6MMx4'x8'(SM)1ST
	Start	60	RU22613-042	(BLANK)	6	White	75 / 1,599	1 / 22	75	H060AWS1	INTEPLAST SH 6MMx4'x8'(SM)1ST

## 2. Production Instruction

Click on the  icon to view/print production instruction.



	Start	10	RV22112-002	(BLANK)	12	White	688 / 3,520	12 / 61	58	H120AWS1	INTEPLAST SH 12MMx4"x8"(SM)1ST	End
---	-------	----	-------------	---------	----	-------	-------------	---------	----	----------	--------------------------------	-----

On this page is the detailed job jacket for this production order

PVC Extrusion Version:1.0.0.52 QAC - [PIReportPage]

Back to Previous Page

**Production Instruction**

Plant: WPKJ  
Machine: VE21  
Date: 7/20/2022 9:14:00 PM  
Order#: RV22112.002

Product Code: H120AWS1  
Product Description: INTEPLAST SH 12MMx4"x8"(SM)1ST  
Scheduled Qty (PC): 3,520  
Scheduled Wgt(LB): 171.354  
Pallets: 58  
Scheduled # of Pallets: 58  
Order Notes:  
Schedule Notes:

**FINISHED PRODUCT SPEC**

Thickness (mm): 12.5  
Width (in): 48  
Length (in): 96.19  
Color: WS - White  
Marking: X - Not required/default  
Embossing: X - (BLANK)  
Special Requirement: X - NOT REQUIRED

**INSTRUCTION**

Pallet Type: 48" x 96"  
Pallet Size: 48" x 96"  
Lumber Strip: White Lumber Film  
Product Spec Range:  
Width: 48 5/16 - 48 3/8 in  
Length: 96 1/4 - 96 1/2 in  
Thickness: 11.40 - 12.60 mm  
Diagonal: 0 - 3/16  
AL: N/A  
DA: N/A  
DA: -2.20 - 1.20  
AE: 0.00 - 2.00

**Production Instruction**

Plant: WPKJ  
Machine: VE21  
Date: 7/20/2022 9:14:00 PM  
Order#: RV22112.002

**FORMULA**


Formula Code: F04XXXV1  
Formula Item: 1


Technical Code	PHR	Estimate Usage (LB)
PCAPWS	2.01	3,378
PPHRL	100.00	167,962
PCGR	0.01	17
<b>Total:</b>	<b>102.02</b>	<b>171,354</b>

## 3. Report Production

### 3.1 Enter Order Page


- a. Click on the 'Start' button to begin reporting for that order




	Start	10	RV22112-002	(BLANK)	12	White	688 / 3,520	12 / 61	58	H120AWS1	INTEPLAST SH 12MMx4"x8"(SM)1ST	End
---	-------	----	-------------	---------	----	-------	-------------	---------	----	----------	--------------------------------	-----

- b. Enter Shift, Employee ID, and where the material is coming from.


Please Enter :

Shift : A 

Emp. ID : 124567 

Machine : VE21

☐ All Material Option

Material Input From : SI10-Silo 10 

Next Cancel

- c. Check header detail (1) on top of order page. If you need to change material input, select from the drop down for 'Material Input From' (2).

## 3.2 Report Pallet

- (1) Click on 'New Pallet' on the left side of order page  
(2) Once a pallet is produced, to create a pallet ID, click on 'Report Production'

Once pallet ID is created, it will appear in the log in the 'Pallet List' on bottom of page. Take pallet to Weigh Station.

## 3.3 Weigh Station



Weight Station  
Application

- a. Put pallet on scale. Click on 'Search by Machine'

b. Select the Product Type

Search Machine Type

Back to Main Page

Free Foam

Decking

Siding

Moulding

c. Choose the Line # and click on 'Select'. The Pallet ID to be weighed will appear in the table below.

PVC Weight Station QAC version: 1.0.0.39

Machine Type: Free Foam

Back to Search Machine

Machine: VE21 Select

Pallet #	Create Time	PCs	Product Code	Description
VF220720E21A001	07/20/2022 22:36 PM	58	H120AWS1	INTEPLAST SH 12MMx4'x8'(SM)1ST

d. Click on that Pallet #

→

Pallet #	Create Time	PCs	Product Code	Description
VF220720E21A001	07/20/2022 22:36 PM	58	H120AWS1	INTEPLAST SH 12MMx4'x8'(SM)1ST

e. Weigh Whole Pallet

- (1) Click on 'Get Weight'. (Note: Gross Weight can be manually entered as well)
- (2) Manually enter the Tare Weight for just the pallet weight itself (not including weight of product)
- (3) Select # of labels you need, then click on 'Print' to print the labels

Weight Station

Pallet #: VF220720E21A001 Back

Product Code: H120AWS1

Description: INTEPLAST SH 12MMx4'x8'(SM)1ST

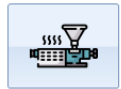
PCs: 58

Gross Weight: 0.00 1 Get Weight

Tare Weight: 0.00 2

2 Copies 3 Print

## 4. Report Scrap



Extrusion  
Application

- (1) Click on 'Scrap' on the left side of order page
- (2) Fill out the Scrap Code, Scrap Reason (if applicable), Note, Estimated Weight. Click on 'Scrap Submit' when complete. The created scrap will appear in the 'Scrap List' on the bottom of page.

Extrusion - Shift: A, User : 124567

Machine : VE21 Order #: RV22112-002 Produced / Scheduled PC : 746 / 3,520 Instruction : In Production

Material Input From : SI10-Silo 10 ☐ All Material Option Produced / Total Pallets : 13 / 61

Prod. Code Dimension Color Balance Need Pallets : 48  
H120AWS1 12mm x 48" x 96" White PCs / Pallet : 58

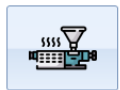
Description: INTEPLAST SH 12MMx4x8(SM)1ST Quality Check

**1** New Pallet **2** Scrap Code :  Note :  Est. Weight :  0

**1** Scrap Scrap Reason :  Scrap Submit

Down Time Scrap List

## 5. Report Down Time



Extrusion  
Application

- To **START** the clock for Down Time, click on 'Down Time Start'.

Extrusion - Shift: A, User : 124567

Machine : VE21 Order #: RV22112-002 Produced / Scheduled PC : 746 / 3,520 Instruction :

Material Input From : SI10-Silo 10 ☐ All Material Option Produced / Total Pallets : 13 / 61

Prod. Code Dimension Color Balance Need Pallets : 48  
H120AWS1 12mm x 48" x 96" White PCs / Pallet : 58

Description: INTEPLAST SH 12MMx4x8(SM)1ST

**2** Down Time Start Down Time End

**1** Down Time 07/20/2022 24 Hrs 07/20/2022 24 Hrs 0 Total Minutes

Down time list under VE21

The Line's Status will be changed to 'In Down Time' in the header on the top of the page.

PVC Extrusion Version:1.0.0.52 QAC - [Extrusion Production]

Extrusion - Shift: A, User : 124567

Machine : VE21 Order #: RV22112-002 Produced / Scheduled PC : 746 / 3,520 Instruction : In DownTime

Material Input From : SI10-Silo 10 ☐ All Material Option Produced / Total Pallets : 13 / 61

Prod. Code Dimension Color Balance Need Pallets : 48  
H120AWS1 12mm x 48" x 96" White PCs / Pallet : 58

Description: INTEPLAST SH 12MMx4x8(SM)1ST

Quality Check Back Refresh

Switch User End Order

Shift Checkout Next Order

- To **STOP** the clock for Down Time, click on 'Down Time End'. The system will automatically calculate the total minutes.

Extrusion - Shift: A, User : 124567

Machine : VE21 Order #: RV22112-002 Produced / Scheduled PC : 746 / 3,520 Instruction :

Material Input From : SI10-Silo 10 ☐ All Material Option Produced / Total Pallets : 13 / 61

Prod. Code Dimension Color Balance Need Pallets : 48  
H120AWS1 12mm x 48" x 96" White PCs / Pallet : 58

Description: INTEPLAST SH 12MMx4x8(SM)1ST

Down Time Start Down Time End

Down Time 07/20/2022 24 Hrs 07/20/2022 24 Hrs 0 Total Minutes

Down time list under VE21

## 6. Inline QC Check



- a. Click on 'Quality Check' every hour to perform a quality check on the product

PVC Extrusion Version: 1.0.0.60 QAC - [Extrusion Production]

Extrusion - Shift: A, User: 1111111

Machine: VE21 Order #: RU22610-037 Produced / Scheduled PC: 300 / 1,599

Material Input From: SI10-Silo 10 ☐ All Material Option Produced / Total Pallets: 4 / 22

Prod. Code H060AWS1 Dimension 6mm x 48" x 96" Color White Balance Need Pallets: 18

Description: INTEPLAST SH 6MMx4x8(SM)1ST PCs / Pallet: 75

Buttons: In Production, Back, Refresh, Switch User, End Order, Quality Check (highlighted), Shift Checkout, Next Order

- b. Click on the applicable check whether you're an operator, supervisor or audit. (Supervisor & Audit will need to input Employee ID)

PVC Extrusion Version: 1.0.0.60 QAC - [Free Foam In-Line Quality Check]

Extrusion - Shift: A, User: 1111111

Free Foam In-Line Quality Check

Shift	Line	Date	Order No.	Prod Code	Formulation
A	VE21	7/24/2022	RU22610-037	H060AWS1	

Buttons: Operator Check, Supervisor Check, QC Audit Check (all highlighted), Back

QC In-Line Log

Check Type	Report Date	Status	Section 1 (0")	Section 2 (4")	Section 3 (8")	Section 4 (12")	Section 5 (16")	Section 6 (20")	Section 7 (24")	Section 8 (28")	Section 9 (32")	Section 10 (36")	Section 11 (40")	Section 12 (44")	Section 13 (48")	Section 14 (52")	Section 15 (56")
O	7/22/2022 3:23:16 PM	PASS	6.00	6.00	6.00	6.00	6.00	6.00	6.00	6.30	5.74	6.00	6.00	6.00	6.00	6.12	

- c. Start inputting the measurements. If the value is or is not within tolerance, it will indicate this with a or . Once complete, click on 'Next' to move to next section.

PVC Extrusion Version: 1.0.0.60 QAC - [RadForm1]

Free Foam - Operator Check - 1111111 - A -

Please measure every 4 inches:

Sheet Thickness (mm):

Zone	Thickness (mm)	Status
Zone 1 (0")	6	
Zone 2 (4")	6.1	
Zone 3 (8")	6.2	
Zone 4 (12")	6.3	
Zone 5 (16")	5.9	
Zone 6 (20")	5.8	
Zone 7 (24")	6	
Zone 8 (28")	5.7	
Zone 9 (32")	5.8	
Zone 10 (36")	5.71	
Zone 11 (40")	6.11	
Zone 12 (44")	6.25	
Zone 13 (48")	6.31	
Zone 14 (52")		
Zone 15 (56")		
Zone 16 (60")		

Length (in): 110 1/8

Width (in): 40 1/4

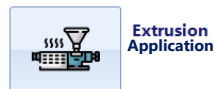
Diagonal (in): 1/16

Buttons: Back, Next

- d. Indicate the surface quality check. Once complete, click 'Confirm'

- e. Once values are confirmed, system will indicate whether this Quality Check has passed inspection. If quality check has failed, please inform the supervisor to determine next step.

## 7. User Actions



### 7.1 Shift Checkout (7:00-7:30)

- a. At end of the shift, click on 'Shift Checkout' (Only between 7:00-7:30) to get a summary of this shift's report.

- b. Enter the estimated number of pieces will be produced until end of shift (7:30).

- c. Print a copy for supervisor's review.

PVC Extrusion Version:1.0.0.60 QAC - [Check Out Report]

Machine : VE21 Shift : A Date : 07/24/2022 Search **Print** Back

**Shift Production Report** Print: 07/24/2022 07:14 AM

Report Date: 07/24/2022 Shift: A  
Machine: VE21 Operator: 1111111, 1234567

Shift Summary					
Total Pallets	Total PCs	Total Weight (LB)	Total Prod. Time (min)	Total Down Time (min)	Total Scrap (LB)
6	330	11,355.30	247	0	0.00

Subtotals			
Order#	From Last (PCs)	To Next (PCs)	
RU22610-037	20	0	
RU22613-042	0	30	

Shift Order					
Order#	Customer	Prod. Code	Prod. Description	Total Pallets	Total Weight (LB)
RU22613-042	Integrat	HD5000051	INTEPLAST SH 6MMx4x8(SM)1ST	4	7,770.00
				228	7,770.00
				171	0
				0	0.00
#	Pallet	PCs	Weight (LB)	Prod. Time (min)	Full Pallet Weight (LB)
1	VF226124214054	20	462.00	66	2960.00
2	VF226124214056	60	2,577.40	117	2060.00
3	VF226124214055	75	2,610.00	60	2610.00
4	VF226124214055	75	2,600.00	62	2600.00

Order# RU22613-042					
Customer	Prod. Code	Prod. Description	Total Pallets	Total Weight (LB)	Total Scrap (LB)
Integrat	HD5000051	INTEPLAST SH 6MMx4x8(SM)1ST	2	3,885.00	0.00
			75	0	0.00
#	Pallet	PCs	Weight (LB)	Prod. Time (min)	Full Pallet Weight (LB)
1	VF226124214057	75	2,610.00	60	2610.00
2	VF226124214056	30	978.00	16	960.00

Review By: \_\_\_\_\_ Approved By: \_\_\_\_\_ Page 1

## 7.2 Switch User (Change Employee on same line)

Anytime there is a switch in users, you need to input new Employee ID.

- a. Click on 'Switch User' to change to another employee on this line

PVC Extrusion Version:1.0.0.60 QAC - [Extrusion Production]

Extrusion - Shift: A, User: 1111111

Machine: VE21 Order #: RU22610-037 Produced / Scheduled PC: 300 / 1,599 Instruction:

Material Input From: SI10-Silo 10 ☐ All Material Option Produced / Total Pallets: 4 / 22 Balance Need Pallets: 18

Prod. Code Dimension Color  
H06AWS1 6mm x 48" x 96" White

PCs / Pallet: 75 Description: INTEPLAST SH 6MMx4x8(SM)1ST

**In Production** Back Refresh **Switch User** End Order

Quality Check Shift Checkout Next Order

- b. Input the shift, new employee ID, and confirm material input

Please Enter:

Shift: A

Emp. ID: 124567

Machine: VE21

☐ All Material Option

Material Input From: SI10-Silo 10

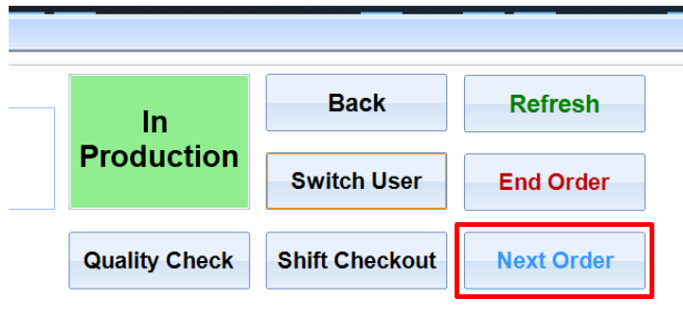
Next Cancel



## 7.3 Next order (Move on to next order on schedule)

This is to move on to next order on the schedule

- a. Click on 'Next Order' when you are ready to move on to the next order on the schedule

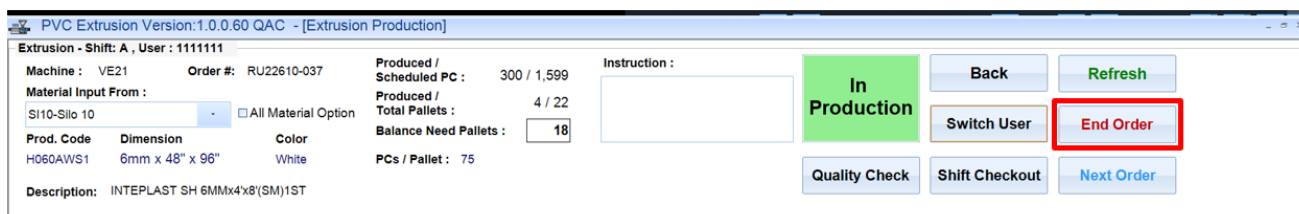


## 7.4 End Order (Remove from Schedule List)

This is to remove order from the schedule. Scheduler will review this action to decide whether to confirm ending this order or put back on the schedule.

There are 2 ways to end an order on the floor:

- a. Line's production order page: Click on 'End' next to the order you would like to end
- b. Production Order Detail Page: Click on 'End Order' to end this production order

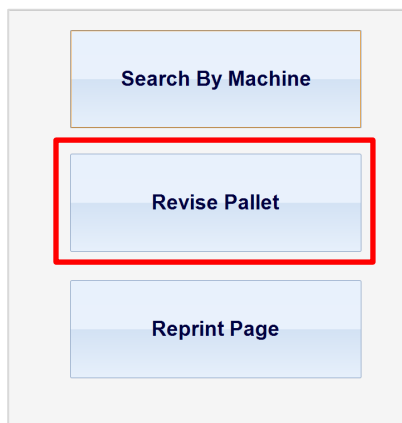


## 8. Weigh Station Functions



### 8.1 Revise Pallet

- a. Click on 'Revise Pallet'



- b. Enter or Scan in Pallet #, then click 'Search'. Pallet Details will appear in box below.

Search Pallet

Pallet # :	VF220720E21A001	Search	Back
Pallet# :	VF220720E21A001		
Order# :	RV22112-002		Clear
Product Code :	H120AWS1		
Description :	INTEPLAST SH 12MMx4'x8'(SM)1ST		Go Revise
PCs :	58		
Weight :	2600.00		Delete
• Net Weight :	2600.00		

- c. Click on 'Go Revise'

	Clear
ST	Go Revise
	Delete

- d. Both gross weight and tare can be revised

Revise Pallet

Pallet # :	VF220720E21A001	Back
Product Code :	H120AWS1	
Description :	INTEPLAST SH 12MMx4'x8'(SM)1ST	
PCs :	58	
Gross Weight :	2600.00	Get Weight
Tare Weight :	0.00	
2	Copies	Update & Print

## 8.2 Reprint Label

- a. Click on 'Reprint Pallet'

Search By Machine

Revise Pallet

Reprint Page

- b. Fill in the header info to filter down by Machine, Shift, or the Pallet # itself.

Reprint Label

By Machine :

By Shift :

By Pallet # :

2

Copies

Back

Pallet #	Create Time	PCs	Gross Weight	Net Weight	Product Code	Description	Print
VF220720E21A001	07/20/2022 22:36 PM	58	2600.00	2600.00	H120AWS1	INTEPLAST SH 12MMx4'x8'(SM)1ST	Print
VF220719E63B004A	07/19/2022 19:30 PM	19	359.86	346.56	K120XEN2	WOLF FA12' BLACK-WALNUT-A (T987)	Print
VW220719E27A001A	07/19/2022 17:54 PM	12	1790.28	1790.28	H190EWS2	WIP -- FF SHEET 19MM 4'x16' (2XSM) 3RD WHITE	Print

- c. Find the label and click on 'Print'

VF220720E21A001	07/20/2022 22:36 PM	58	2600.00	2600.00	H120AWS1	INTEPLAST SH 12MMx4'x8'(SM)1ST	Print
-----------------	---------------------	----	---------	---------	----------	--------------------------------	-------