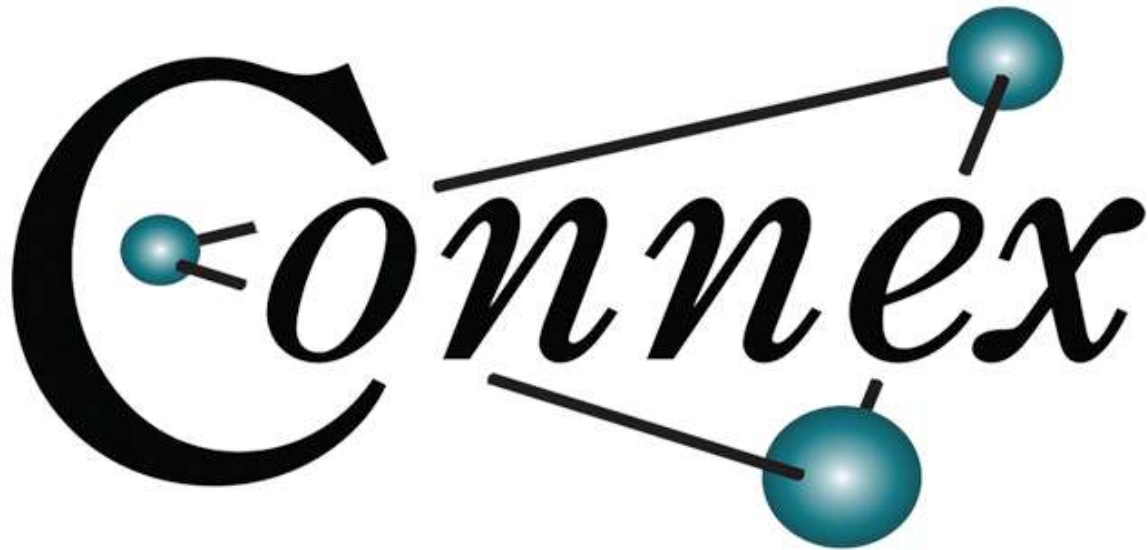


Quick Start Guide/Manual



Web-Based Enterprise Production Software



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CD 807M REV 12/16

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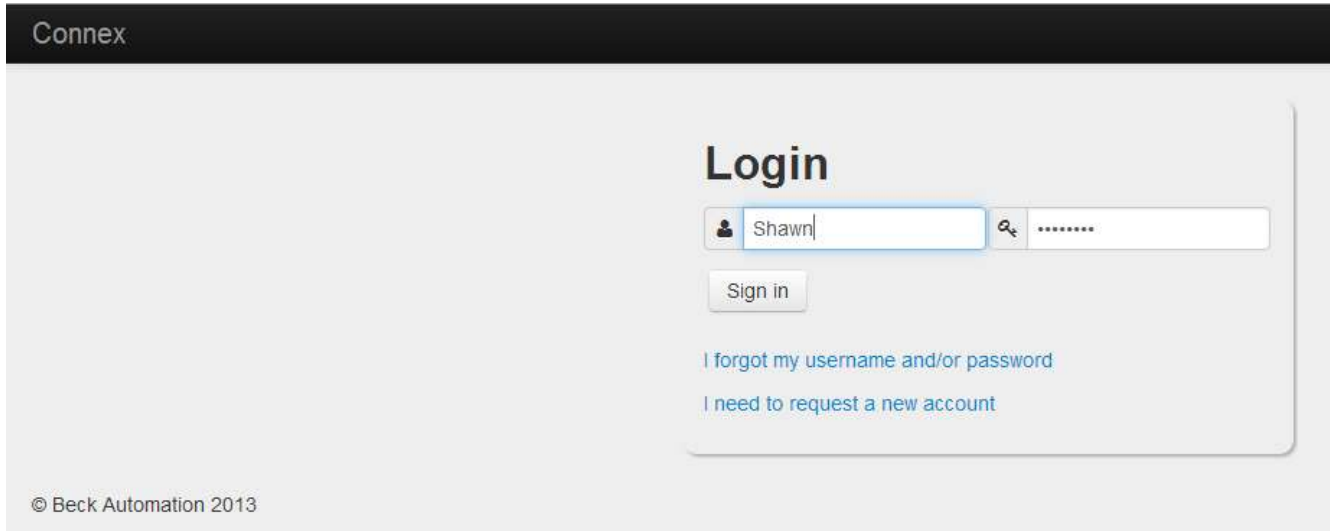
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Getting Started

Type in the IP Address of the Connexor server. We recommend either bookmarking this page or creating a shortcut on your desktop.

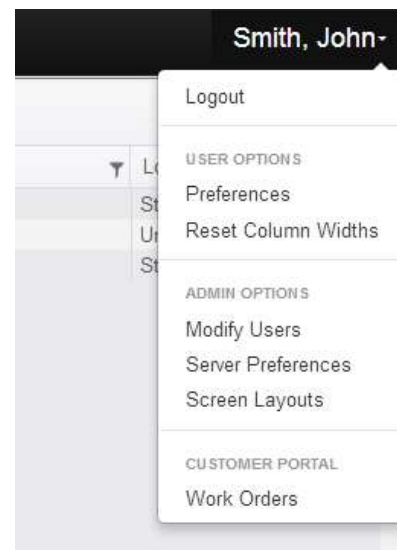


Enter the unique username and password received from the administrator.



Setups

Connex can be customized for each user via the setups menu. Access this menu by clicking on the username on the top right of any page. It is divided into User Options that every user can customize and Admin Options that only the system administrator can edit.



User Options

Preferences

This screen appears the first time a new user logs into Connex. It can also be accessed at any time by clicking on the username on the upper right side of the screen. It includes several options:

- **General Information:** User's first and last name.
- **Contact information:** User's e-mail, phone number and address.
- **Login:** Username and password.
- **Preferences:**
 - Default Page: Initial page that loads upon login.
 - Length Unit: Preferred units of measure to display for length.
 - Density Unit: Preferred unit to display for density.
 - Confirm Delete: Requires a pop-up to appear to confirm before lines can be deleted.
 - Show Edit Lock: Allows user to lock and unlock data for editing. If this feature is enabled, pages will default to being locked and must be manually unlocked before they can be edited.

The screenshot shows a web-based preferences window titled "PREFERENCES". It includes a login section with fields for "Username" (containing "admin") and "Password", and a "Save Login Information" button. Below the login section is a "Preferences" section with three dropdown menus: "Default Page" (set to "Status"), "Length Unit" (set to "Decimal Inches"), and "Density Unit" (set to "Pounds per Foot"). There are also two checked checkboxes: "Confirm Delete" and "Show Edit Lock". At the bottom of the preferences section are "Save Preferences" and "Save All" buttons.

Reset Column Widths

You can adjust column widths on any screen by placing the mouse pointer over the edge of a column, holding the left mouse key, and dragging to the desired width. The reset column widths option resets the column widths back to their default setting.

Admin Options

Modify Users

An administrator must first set up a user with a unique username and password before they can access Connex. The administrator can then specify the user's specific roles and permissions.

The screenshot shows the 'Users' management page in the Connex application. At the top, there's a navigation bar with 'Connex' logo, 'Users' (highlighted), and other menu items like 'Program', 'Definitions', 'Inventory', 'Reports', and 'Help'. A user profile 'Smith, John' is shown in the top right. Below the navigation bar, there are buttons for 'Create User', 'Delete User', 'Edit Roles', 'Send user to ERP', 'Lock', 'Filter', and 'Updates' (with a count of 0). A form for adding a new user is visible, with fields for 'Name' and 'Location'. Below this, there's a table listing existing users. The first user is 'admin' with first name 'John' and last name 'Smith'. The table has columns for User Name, Password, First Name, Last Name, Email, Phone, Customer, Location, and Tax Rate.

User Name	Password	First Name	Last Name	Email	Phone	Customer	Location	Tax Rate
admin		John	Smith	johnsmith@beckau...	(314) 576-9736	false	Beck Automation	Undefined

To add a new user, select the Create User button and enter the user's information into the fields. Select "true" in the customer field if the user is a customer, otherwise select "false." To set the permissions of the user, highlight the user's name and click the Edit Roles button.

The 'Edit Roles' dialog box is shown, allowing the user to select permissions for the 'admin' user. The dialog has a title bar 'Edit Roles' and a close button. The main content area is titled 'Check the permissions you want this user to have.' and contains two columns of checkboxes. The left column is 'User Roles' and the right column is 'User Permissions'. The 'User Roles' column has a tree structure with expandable folders: 'Program' (expanded), 'Jobs' (expanded), 'Parts' (expanded), 'Definition' (expanded), 'Machines' (expanded), 'Coils' (expanded), 'Profiles' (expanded), 'Materials' (expanded), 'Delay Reasons' (expanded), 'Locations' (expanded), and 'Reports' (expanded). The 'User Permissions' column has a list of checkboxes: 'Administrative Privileges', 'Operator Roles', 'Print Bundle Ticket', 'Manual Import', 'Recall From Controller', 'Can Get Setups', 'Can Get Jobs', 'Can Get Parts', 'Can Get Tools', 'Send To Controller', 'Can Send Setups', 'Can Send Jobs', 'Can Send Parts', and 'Can Send Tools'. A 'Save' button is located at the bottom right of the dialog.

Select all the permissions you would like the user to have. It is recommended that all users have permission to view everything. If they don't have the ability to view, any screens with this information on it will be invisible to that user.

Server Preferences

Server Preferences set up global items for all users. These preferences are separated into three tabs: General, Notifications and ERP Connections.

General

This tab determines how long jobs or coils will remain on their screen after they are completed or depleted. This can be measured in minutes, days, or hours, determined by the drop-down menu to the right. Setting this field to "0" means jobs or coils must be manually deleted. This window also defines the location for import and export files, what information will be imported/exported, and how this information will be arranged. Please refer to the Import/Export Specifications document for guidance.

The screenshot shows the 'SERVER PREFERENCES' window with the 'General' tab selected. The 'Connex Preferences' section includes: 'Delete Completed Jobs After: 1 Days', 'Delete Depleted Coils After: 0 Minutes', 'Export Production Records' (unchecked), 'Auto Import' (checked), 'Import File Name: import.csv', 'Export File Name: DataX.csv', 'Import Header' (J:JOB,SCHEDULE,MATERIAL,PROFILE,USER 1,USER 2; B: BATCH,QUANTITY,LENGTH,USER 1), and 'Export Header' (empty). A 'Save' button is at the bottom.

Notifications

This tab sets up notifications that automatically send an e-mail when a job's status changes. To add a new notification:

1. Click "Add New," then select "new notification" from the drop-down menu.
2. Click "Edit Selected."
3. Enter a notification name that will appear in the notification drop-down once it's been saved.
4. Check the appropriate box for when to send the notification.
5. Enter a recipient to send the notification to. This can be a user defined on the Users screen, an e-mail address, or a user-defined field (UDF) that contains an e-mail address.
6. Create a subject and body for the e-mail. You can use Macros to pull Job information such as Job number or Status into the body or subject of the notification. To insert a macro into a field, begin typing in the data you would like reported in the notification.

The screenshot shows the 'SERVER PREFERENCES' window with the 'Notifications' tab selected. It features buttons for 'New notification', 'Edit Selected', 'Add New', 'Delete', and 'Save'. The 'Notifications Settings' section includes: 'Notification Name: Job Completion', 'Alert When Status Changes To: Complete' (checked), 'Recipients: {udf3}', 'Subject: Job {job} is {status}', and 'Notification Body' (This message is to inform you that your order {udf2} is now {status} and ready for pickup/delivery. Regards, Beck Automation).

A menu will pop up below the field with the appropriate macro title. Select that title to enter the macro into the field.

7. Save the notification. Once saved, this notification can be edited or deleted by returning to the server preferences options.

ERP Connections

ERP Connections are used with work orders and QB-Elite. Contact Beck Automation for more information about this feature.

Screen Layouts

This setting is used to arrange columns on the various screens and add user-defined fields to jobs and batches. The different screens that can be customized are arranged as tabs across the top of the screen.

Several different actions are available on this screen:

1. Rearrange column order: Select the column's title and drag it to the desired position with your mouse.
2. Add or remove a column: Check or uncheck the box next to the column name. You cannot remove bolded columns.
3. Edit the name of a user-defined column: Select the name and type the new name in the box that appears at the bottom of the screen. Then click "Rename UDF."
4. Attach a source to a user-defined column (i.e. Profile Description, Material Density, Material Description, etc.): Highlight the column you wish to attach a source to and click "Attach Source."
5. Click save to apply your changes, or click default to reset all columns back to default settings.

Connex layouts Program ▾ Definitions ▾ Inventory ▾ R

- Bold Fields are Required
- Drag fields up or down to reorder in view

Jobs	Batches	Coils	Status	Work Orders	Work Orders Items	Coil Forecast
Job						
Status						
Profile						
Material						
Machine						
<input checked="" type="checkbox"/> Location						
<input checked="" type="checkbox"/> Scheduled Date						
<input checked="" type="checkbox"/> Priority						
<input checked="" type="checkbox"/> Gauge						
<input checked="" type="checkbox"/> Weight						
<input type="checkbox"/> UDF3						
<input type="checkbox"/> UDF4						
<input type="checkbox"/> UDF5						
<input type="checkbox"/> UDF6						
<input type="checkbox"/> UDF7						
<input type="checkbox"/> UDF8						
<input type="checkbox"/> UDF9						
<input type="checkbox"/> UDF10						

Default Save

General Navigation


You can access different pages by selecting the desired option from the drop-down menus at the top of the screen. Below is a brief summary of the different dropdown menus and their pages.

Tab Heading	Selection	Description
Status	N/A	Shows a real-time snapshot of each machine. You can access this screen by clicking the Connex icon at the top left corner of the screen (see page 10).
Program	Jobs	View, add, edit, schedule, send and recall jobs (see page 11).
	Parts	View, add, and edit parts (see page 6).
	Folder Parts	View, add, and edit folder parts (see page 20).
	Manual Import	A window will pop up allowing you to manually select files to import into Connex.
Definitions	Locations	View, add, and edit machine locations (see page 21).
	Connexor Servers	View Connexor servers (see page 22).
	Machines	View, add, and edit machines. Separated into definitions, setups, and tools (see page 23).
	Delay Reason	View, add, and edit delay reasons (see page 27).
	Profiles	View, add, and edit profiles (see page 28).
	Materials	View, add, and edit materials (see page 30).
	Folder Materials	View, add, and edit folder materials (see page 31).
Inventory	Coils	View, add, and edit coils. This screen keeps current usage and totals of coils that have been entered in this screen and ran on the Beck Controller (see page 32).
	Staged Coils	Stage coils to run at each machine. This page shows a list of jobs and materials required (see page 34).
	Coil Forecast	Displays a list of all materials in Connex along with the total footage in stock, required footage based on jobs currently in Connex, and what the remaining footage will be when jobs are completed (see page 35).

Reports	Report Builder	Run customized reports based on specific criteria (see page 36).
	Production	Creates a production report based on predefined criteria set up by Beck.
	Coil	Creates a coil report based on predefined criteria set up by Beck.
	Scrap	Creates a scrap report based on predefined criteria set up by Beck.
	Downtime	Creates a downtime report based on predefined criteria set up by Beck.

Status Page

The status page displays the different machines and their current status. Access this page by clicking the Connex icon at the upper left-hand corner of the screen.

<div>  Status Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ Smith, John ▾ </div>									
Machine	Location	Status	Downtime/Upt...	Velocity	Job	Batch	Quantity	Done	
S2 Test	Undefined	Running	13 seconds ↑	95 FPM	1	2	10	5	
Connexor Test	Undefined	Offline	18 hours 52 minute...	0 FPM				0	
Phoenix	Undefined	Halted	69 hours 50 minute...	0 FPM				5	
Rollformer	Undefined	Offline	167 hours 7 minute...	0 FPM				0	
Central States	Undefined	Halted	310 hours 32 minut...	0 FPM				0	
JP	Undefined	Offline	44 hours 23 minute...	0 FPM				0	

Columns

Column	Description
Machine	Name of machine, defined on machine definitions screen (See page 23).
Location	Machine's location, defined on machine definitions screen.
Status	<ul style="list-style-type: none"> Offline: Machine is not currently connected to Connex. Halted: Machine is connected but not currently running. Running: Machine is currently running a batch.
Downtime/Uptime	Displays accumulated downtime if the machine is currently halted or offline, or uptime if the machine is running.
Velocity	Current line velocity of a running machine.
Job	Job name of currently running job, if machine is running.
Batch	Batch number of currently running batch, if machine is running.
Quantity	Total quantity of currently running batch, if machine is running.
Done	Number of completed pieces in currently running batch.


















Jobs Screen

The jobs screen allows you to view, edit, schedule, send, import and recall jobs. A job is a group of any number of items with a common profile and material. Access this screen by clicking on Program and selecting Jobs from the drop-down.



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Job Keys

	Creates a new job.
	Copies selected job.
	Deletes selected job.
	Expands selected job so its batches are visible.
	Collapses selected jobs.
	Sends selected jobs to the controller designated in the "Machine" column. (Status will be changed to "At Machine.")
	Recalls selected jobs from the controller back to Connex. (Status will be changed to "Ready.")
	Sets selected jobs to top priority. For example, if the existing jobs are prioritized as 1-10 and you prioritize 3 new jobs, #1-10 will become #4-13.
	Prints bundle tickets for selected jobs or batches. A bundle ticket printer must be connected to the Connexor PC for this feature to work.


 Weight	Displays the job number, total weight, total length and lift point for each selected job or batch.
 Set Machine	Assigns selected jobs to a designated machine.
 Print	Prints all selected jobs to a local printer.
Estimate	Estimates the amount of time it will take to complete jobs of your choosing. You may set it to estimate the time for all jobs, or only for jobs of a certain name, material, or profile.
 Unlock	If the show edit lock feature is turned on, this key will unlock the screen for editing. See page 4.
 Lock	If the show edit lock feature is turn on, this key will lock the screen so the information cannot be edited. See page 4.
Updates 0	Click on this key to refresh the screen and see new data added by other users.
 Create Batch	Creates a new batch for the selected job.
 Copy Batch	Copies selected batches.
 Delete Batch	Deletes selected batches.
 Prioritize Batches	Sets the selected batches to top priority in the run order field. Batches will be run in the order of their priority.
 Ticket	Prints a bundle ticket for selected batches.
 Weight	Displays the total weight, total length, and lift point for selected batches.
 Move Up	Moves selected item up.
 Move Down	Moves selected item down.
 Scan	Scan a barcode to automatically scroll to the batch that contains that barcode item.
 Complete	If the "Ghost Controller" feature is turned on, this button will allow users to auto-complete a job. This will allow the user to enter quantity complete, coil used, and scrap associated with the Job/Line item. This will in return create a Production Record that can later be viewed in Reports (see page 36).
 Filter	Turns the database filter view on or off (see page 14).
 Set Batch	Sets all selected batches to a name of your choosing.

Programming New Jobs or Batches

1. Click on  at the top of the page.
2. Edit the job name.
3. The status field has five options. Once the job has been sent to the controller, this field cannot be edited and will update automatically.
 - Ready: Job is ready to be sent to a controller and ran.
 - Hold: Job will not be produced.
 - Scheduled: Job will be sent to machine at time set in the scheduled date column.
 - At Machine: Job has been sent to the machine and is ready to run.
 - Completed: Job has been completed.
4. Choose the job's profile from the drop-down list. Profiles must first be programmed on the Profiles page (see page 28).
5. Choose the job's material from the drop-down list. Materials must first be programmed on the Materials page (see page 30).
6. Select the machine you want to run this job on, or leave as undefined.
7. Enter a scheduled time if you want the job to automatically be downloaded to the selected machine at a specific time.
8. Once the job's information has been entered, a new line will be created under the job heading. Enter the first batch's number on this line. Note: Batch numbers are used for bundling purposes. Multiple line items can have the same batch number.
9. Enter the number of pieces for this batch.
10. Enter the length of the pieces. If the part has tool 1 (shear tool) defined, length will fill in automatically.
11. Choose which part you are going to run. Select "Shear Only" for items that do not get punched. Parts must first be programmed on the Parts page (see page 6).
12. Pressing enter on the keyboard at the end of the line will create a new batch, or you can use the  button to add as many batches as needed for the job.

Downloading Jobs

There are three ways to send jobs to the controller:


1. Highlight the jobs and click . Jobs may be sent in advance, allowing the operator to run them in any order.
2. Jobs may be automatically sent to the machine at a specified day and time. To do this, set the desired date and time in the scheduled date column.
3. If you are interested in prioritizing jobs and allowing the operator to request the highest priority job, please contact Beck Automation.

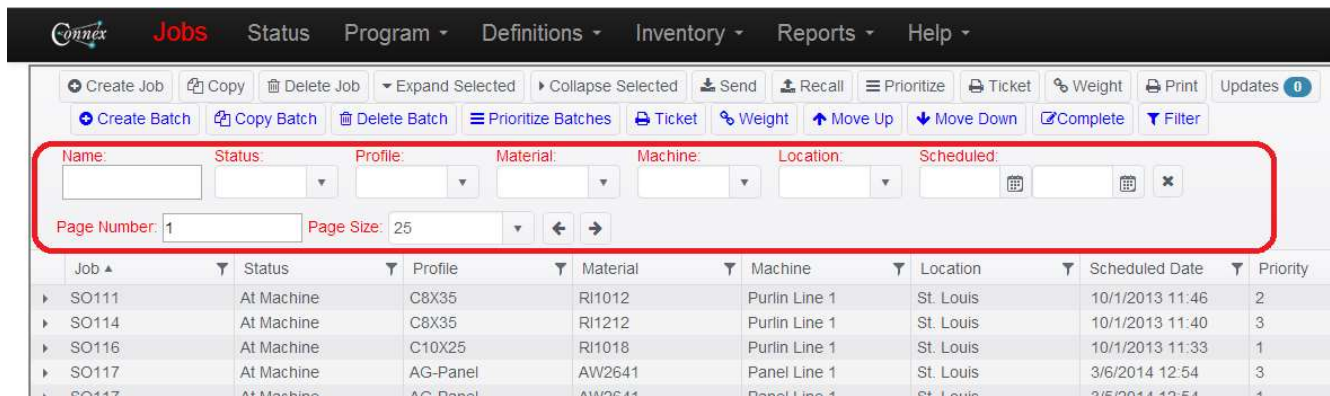
Filtering

Filtering allows you to modify your display to only show items with certain parameters. There are many pages that offer this option. You can choose to filter the entire database or just to filter data shown on the page. Below is an example of how to use filtering on the Jobs page.

Filter Entire Database

The filter view bar outlined in red below allows users to query the entire database for the


selected information. This view can be displayed or hidden by clicking the  button. Enter the parameter you'd like to filter by in the desired fields, leaving the ones that don't matter blank. Once the filters are set, you can then select the number of items to display on each page. Pre-defined page sizes of 25, 50, 75, & 100 automatically appear in the drop-down, but you can enter any number you want. Press enter to display the filtered results. The "x" button on the filter view bar will clear any currently applied filters.

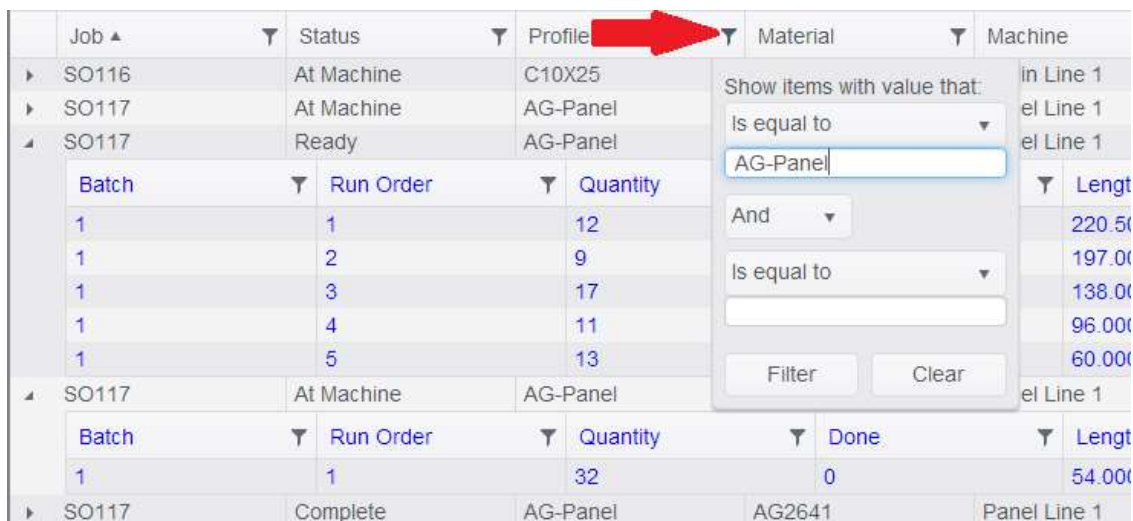


The screenshot shows the Connex Jobs page with a filter bar outlined in red. The filter bar includes fields for Name, Status, Profile, Material, Machine, Location, and Scheduled. Below these fields are Page Number and Page Size dropdowns. The filter bar also includes a Filter button and an 'x' button to clear filters.

Job	Status	Profile	Material	Machine	Location	Scheduled Date	Priority
SO111	At Machine	C8X35	RI1012	Purlin Line 1	St. Louis	10/1/2013 11:46	2
SO114	At Machine	C8X35	RI1212	Purlin Line 1	St. Louis	10/1/2013 11:40	3
SO116	At Machine	C10X25	RI1018	Purlin Line 1	St. Louis	10/1/2013 11:33	1
SO117	At Machine	AG-Panel	AW2641	Panel Line 1	St. Louis	3/6/2014 12:54	3
SO117	At Machine	AG-Panel	AW2641	Panel Line 1	St. Louis	3/6/2014 12:54	1

Filter Page Data

You can filter information currently shown on the page by clicking on the  icon located in each column. Multiple filters and filter rules can be applied to each filter.



The screenshot shows the Connex Jobs page with a filter applied to the Material column. The filter bar is outlined in red. The filter bar includes fields for Name, Status, Profile, Material, Machine, Location, and Scheduled. Below these fields are Page Number and Page Size dropdowns. The filter bar also includes a Filter button and an 'x' button to clear filters.

Job	Status	Profile	Material	Machine
SO116	At Machine	C10X25		in Line 1
SO117	At Machine	AG-Panel		el Line 1
SO117	Ready	AG-Panel		el Line 1
	Batch	Run Order	Quantity	Length
	1	1	12	220.50
	1	2	9	197.00
	1	3	17	138.00
	1	4	11	96.00
	1	5	13	60.00
SO117	At Machine	AG-Panel		el Line 1
	Batch	Run Order	Quantity	Done
	1	1	32	0
SO117	Complete	AG-Panel	AG2641	Panel Line 1



Parts

The parts screen allows you to view, edit and create parts and their operations. Access by clicking on Program and selecting Parts from the drop-down. Parts define the punch locations for an item. Each part consists of operations, which include an operation number (this may simply be a press number on lines without gags), a location for the operation, and a reference for that location.

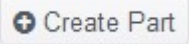
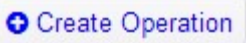

The screenshot shows the Connex software interface for the 'Parts' screen. At the top, there is a navigation bar with 'Parts' highlighted, and other options like 'Status', 'Program', 'Definitions', 'Inventory', 'Reports', and 'Help'. A user name 'Smith, John' is visible in the top right. Below the navigation bar, there is a toolbar with buttons for 'Create Part', 'Copy', 'Delete Part', 'Expand Selected', 'Collapse Selected', 'Preview Part', and 'Updates'. There are also buttons for 'Create Operation', 'Copy Operation', 'Delete Operation', and 'Filter'. Below the toolbar, there are input fields for 'Part Type', 'Name', and 'Description'. A 'Page Number' field shows '1' and a 'Page Size' dropdown shows '25'. The main area displays a list of parts. The first part is '9513EC-7' with a description '6 PUNCH'. It has 12 operations listed with columns for 'Operation', 'Position', 'Reference', and 'Y-Position'. The operations are numbered 4 through 15, with positions ranging from 1.750 in to 29.750 in, and references like 'Leading Edge' and 'Trailing Edge'. The Y-Position values are 2.000 in and -2.000 in. Below the list, there are links for '9475DJ-2-3' and '9502 EC-1'. At the bottom left, it says '© Beck Automation 2014'.

Parts Keys

	Creates a new part.
	Copies selected part.
	Deletes selected part.
	Expands selected part so its tools are visible.
	Collapses selected parts.
	Displays the pattern of punches as they will appear on the part.
	Click on this key to refresh the screen and see new data added by other users.
	Creates a new operation in the selected part.
	Copies selected operation.

	Deletes selected operation.
	Turns database filter view on or off. See page 14.

Creating a New Part

1. Click on 
2. Enter the name of the part.
3. The description is optional unless you have a part printer. Then this field is for programming the print message.
4. A line for the first operation will automatically be created under the new part. Enter the desired press number, press position (x-axis), the reference point for the press location, and the Y-Position (if applicable).
5. For additional operations in that part, enter/tab through to the next line, or click 
6. Repeat the above steps for each part. The copy operation button will make entering similar parts much faster.
7. Clicking  will display the punch pattern as you can expect it to appear on the part. Clicking on each hole will give you detailed information on the operation, location, reference and Y-Position.



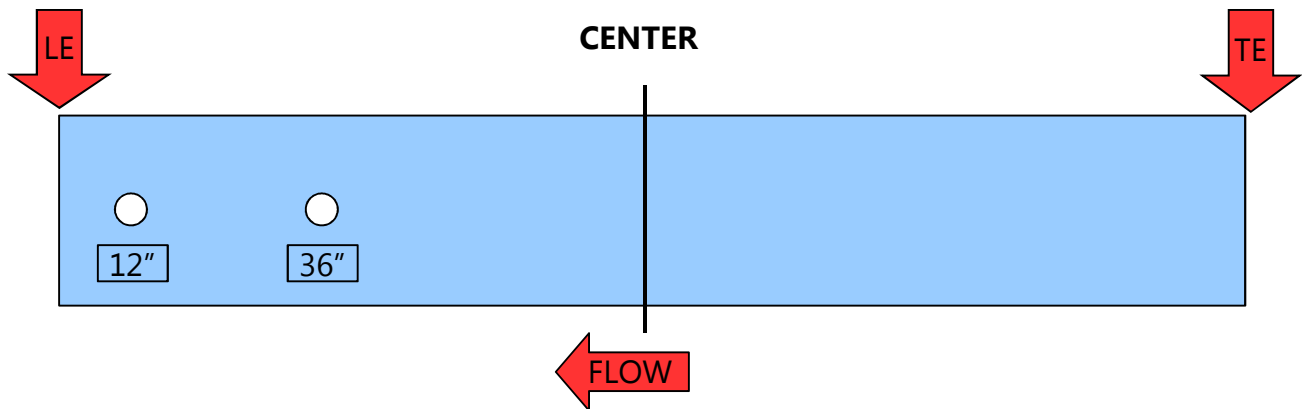
Punch Reference Definitions

The punch locations for each part can be determined from one of several reference points that are defined in the "Reference" column on the parts screen.

Leading Edge (LE)

Measures the punch location from the leading edge of the part. Below is an example of a 120" part programmed in Connex and where the holes will be punched on the part:

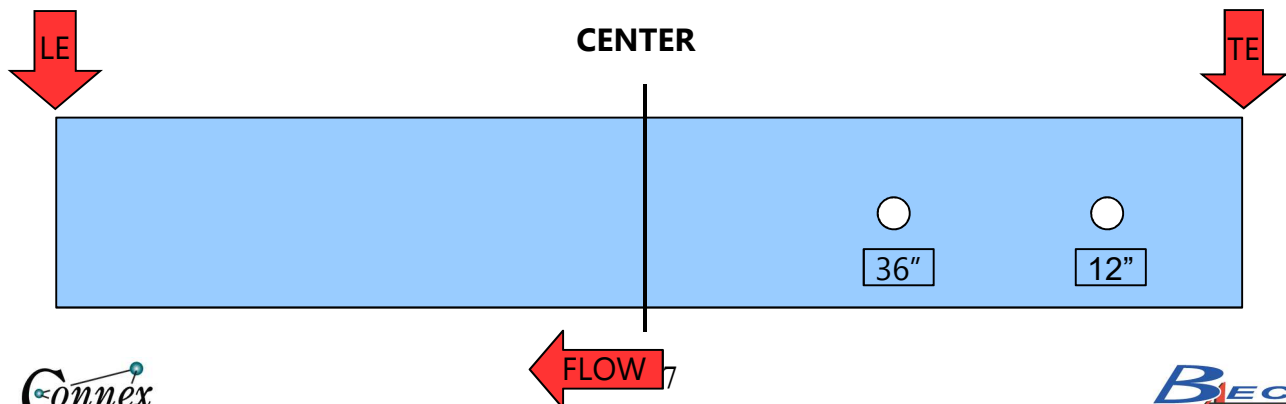
Operation	Position	Reference
2	12.000 inches	Leading Edge
2	36.000 inches	Leading Edge



Trailing Edge (TE)

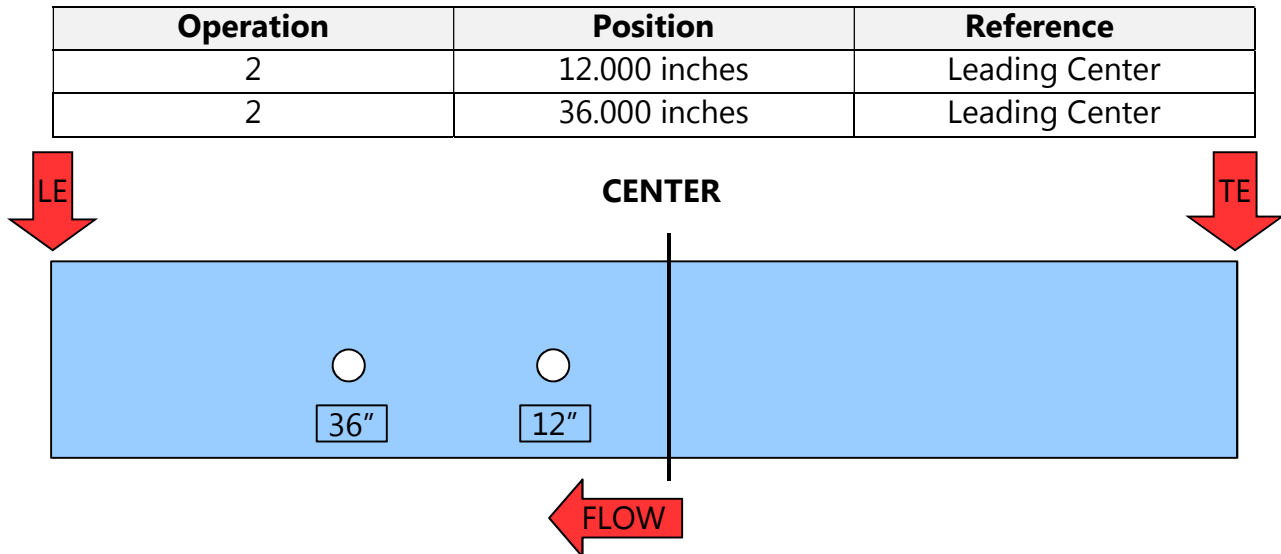
Measures the punch location from the trailing edge of the part. Below is an example of the same length part programmed in Connex and where the holes will be punched on the part:

Operation	Position	Reference
2	12.000 inches	Trailing Edge
2	36.000 inches	Trailing Edge



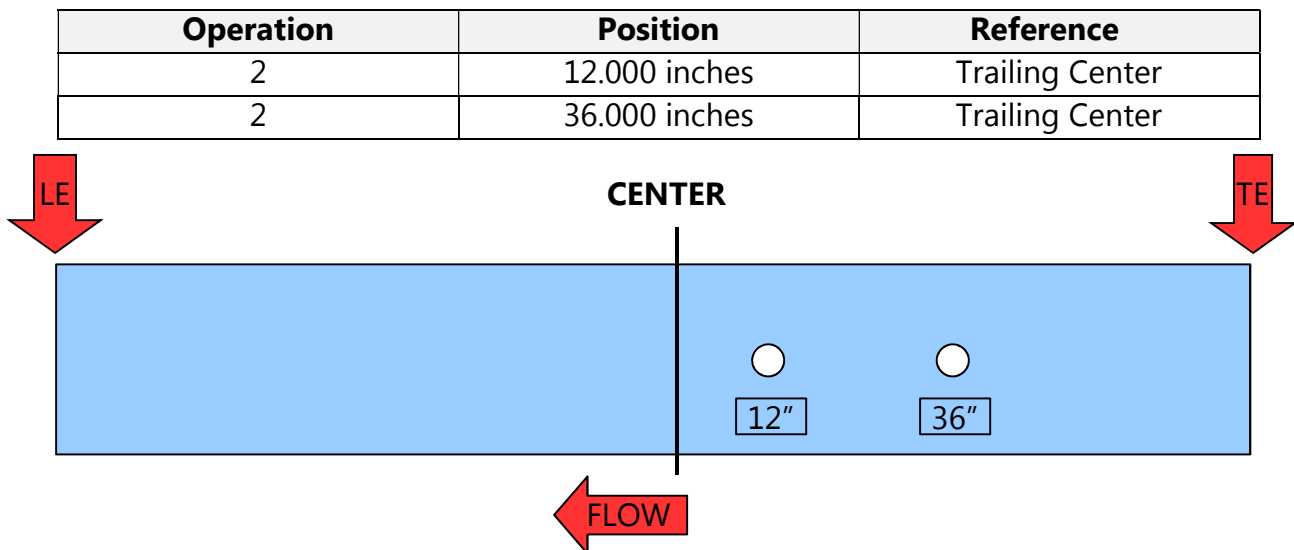
Leading Center

Measures the punch location from the center of the part towards the leading edge. Below is an example of the part programmed in Connex and where the holes will be punched on the part.



Trailing Center

Measures the punch location from the center of the part towards the trailing edge. Below is an example of the part programmed in the controller and where the holes will be punched on the part.



Even Spacing

Causes the specified tool to fire repeatedly at evenly spaced intervals defined in the "position" column. To prevent punches from occurring too close to the ends of a part, the **Spacing Start** and **Spacing End** reference may be defined before this reference is entered.

- **Spacing Start**

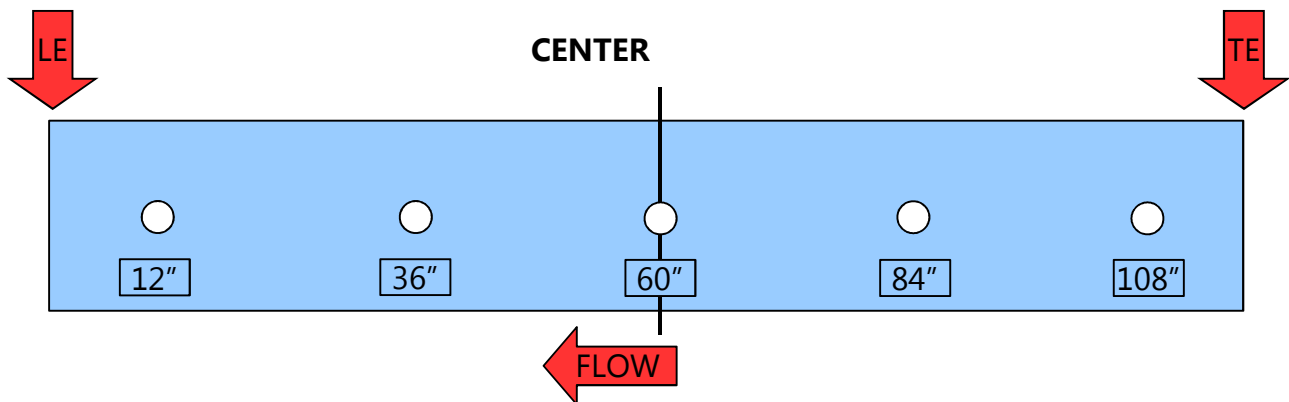
The location of the first hole for the Even Spacing punch reference. This is optional for even spaced operations. If it is used, it must be specified above the even space reference.

- **Spacing End**

The minimum distance from the trailing edge of a part that an even spaced punch can occur. This prevents an even spacing punch reference from locating a punch too close to the end of a part, and it is optional for even spaced operations. If it is used, it must be specified above the even space reference.









Below is an example of the part programmed in Connex and where the holes should be on the part.

Operation	Position	Reference
2	12.000 inches	Spacing Start
2	12.000 inches	Spacing End
2	24.000 inches	Even Spacing









Folder Parts

Define parts for folders on this screen. Access this screen by clicking on Program and selecting Folder Parts from the drop-down.

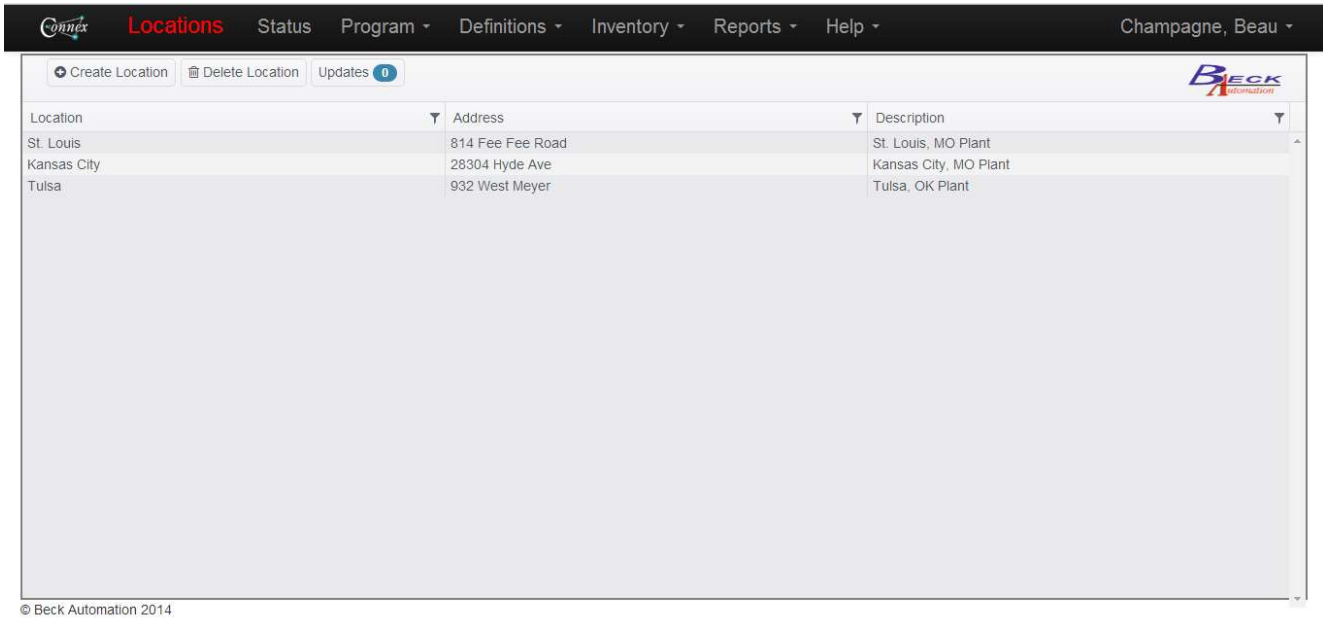
<div>  Folder Parts Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ Smith, John ▾ </div>									
<div> <div>  Create Part  Copy  Delete Part Expand Selected ▾ Collapse Selected ▸ Updates 0 </div> <div>  Create Operation  Copy Operation  Delete Operation </div> </div>									
Folder Part ▾	Folder Material ▾	Description ▾	Clamp Pressure	Over Bend ▾	Thickness	Paint Up ▾	Labor Adder ▾	Multiplier	
CANOPY-PANEL	Undefined		1500.000 psi	8	0.0400 in	1	\$0.00	0	
Step ▾	Back Gauge	Back Gauge Adjust	Back Gauge Two	Bend Angle ▾	Upper Jaw ▾	Clamp Pressure ▾	Overbend ▾	Rotary Shear	
0	19.000 in	0.000 in	19.000 in	0	0.7	0.000 psi	0	200 in	
1	18.250 in	0.000 in	18.250 in	90	0.7	0.000 psi	0	0 in	
2	17.200 in	0.000 in	17.200 in	90	0.7	0.000 psi	0	0 in	
3	14.370 in	0.000 in	14.370 in	95	0.7	0.000 psi	0	0 in	
4	1.550 in	0.000 in	1.550 in	90	0.7	0.000 psi	0	0 in	
5	0.600 in	0.000 in	0.600 in	85	2	0.000 psi	0	0 in	
6	2.820 in	0.000 in	2.820 in	90	2	0.000 psi	0	0 in	
<div> <div>  DOOR-TRIM SHOW Undefined </div> <div> 1500.000 psi 5 0.0200 in 1 \$0.00 0 </div> </div>									

Folder Parts Keys

 Create Part	Creates a new part.
 Copy	Copies selected part.
 Delete Part	Deletes selected part.
▾ Expand Selected	Expands selected part so its tools are visible.
▸ Collapse Selected	Collapses selected parts.
Updates 0	Click on this key to refresh the screen and see new data added by other users.
 Create Operation	Creates a new operation in the selected part.
 Copy Operation	Copies selected operation.
 Delete Operation	Deletes selected operation.

Locations

The locations screen allows you to create locations to manage multi-plant setups. Access this screen by clicking on Definitions and selecting Locations from the drop-down. Once locations are defined, machines and coils can then be assigned to specific locations. The Create Location button will create a new location, and the Delete Location button will delete a selected location.



The screenshot shows the Connex software interface for the 'Locations' screen. The top navigation bar includes 'Connex', 'Locations' (highlighted in red), 'Status', 'Program', 'Definitions', 'Inventory', 'Reports', and 'Help'. The user 'Champagne, Beau' is logged in. Below the navigation bar, there are buttons for 'Create Location', 'Delete Location', and 'Updates' (showing 0 updates). The main area contains a table with three columns: 'Location', 'Address', and 'Description'. The table lists three locations: St. Louis, Kansas City, and Tulsa, each with an address and a description.

Location	Address	Description
St. Louis	814 Fee Fee Road	St. Louis, MO Plant
Kansas City	28304 Hyde Ave	Kansas City, MO Plant
Tulsa	932 West Meyer	Tulsa, OK Plant

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Connexor Servers



This page displays information about the Connexor servers. Access this screen by clicking on Definitions and selecting Connexor Servers from the drop-down.




Connexor Servers							
Connexor Server	Location	Online	Has Connexor	Has Printer	Printer	Printer Driver	
Example Connexor Server	Beck Automation	false	false	false	Example Printer	Sato	
28665	Undefined	false	false	false			




Columns

Column	Description
Connexor server	Name of Connexor server
Location	Location of server, defined on locations screen (see page 21).
Online	Displays "true" if a server is communicating to Connex. Otherwise, it will display "false."
Has Connexor	Displays "true" if the USB/485 converter is plugged in and working properly. Otherwise, it will display "false."
Has Printer	Displays "true" if a printer is associating with the server and is communicating. Otherwise, it will display "false."
Printer	The name of the printer associated with the server.
Printer Driver	The printer's driver.

Machine Definitions

This screen allows you to view, edit, and delete machines. Access this screen by clicking on Definitions and highlighting Machines, then select "Definitions" from the menu that appears to the right. Click  to add a new machine and  to delete a machine.

Connex Machines Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ Smith, John ▾								
 		Updates 0						
Machine	Location	IP Address	Connexor Server	Network Node	Shift 1 Start	Shift 2 Start	Shift 3 Start	Hardware Version
Connexor Test	Undefined		28665	5	No Time Set	No Time Set	No Time Set	BA1200
Phoenix	Undefined	192.168.1.143	Undefined	3	7:00 AM	12:55 PM	11:55 PM	Phoenix
S2 Test	Undefined	192.168.1.129	Undefined	4	8:00 AM	2:00 PM	10:00 PM	BA1200
Rollformer	Undefined		Undefined		No Time Set	No Time Set	No Time Set	
Central States	Undefined	192.168.1.83	Undefined	2	6:00 AM	2:00 PM	10:00 PM	Phoenix
JP	Undefined	192.168.1.21	Undefined	9	No Time Set	No Time Set	No Time Set	BA1200

Connex Machines Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ Smith, John ▾								
 		Updates 0						
Software Version	Printer	Printer File	Bend Allowance	Type 1	Type 2	Type 3	Type 4	Type 5
Tue Nov 10 10:10:...		Undefined	0.000 in	None	None	None	None	None
		Undefined	0.100 in	Flip x	Shift y	None	None	None
Tue Sep 27 08:10:...		Undefined	0.100 in	Flip x	Shift y	None	None	None
		Undefined	0.000 in	None	None	None	None	None
4ee4d7751dbb		Undefined	0.000 in	Shift y	None	None	None	None
Thu Sep 22 23:42:...		Undefined	0.000 in	None	None	None	None	None

Columns

Column	Description
Machine	Name of machine.
Location	Location of machine, defined on Locations screen (see page 21).
IP Address	IP adress of machine.
Connexor server	Server associated with the machine (if using 485 communications).
Network node	Assign this machine a network node number. The same number must also be entered in the controller's "Network Unit Number" parameter. Each machine on a specific Connexor requires a unique number, but different Connexors can have machines with the same network node.
Shift # Start	Enter start times for each shift if you would like to track production by shift. Otherwise, leave at "no time set."
Software Version	Automatically populates based on the machine's current software.
Printer	Connexor servers will appear on this drop-down. Select one of these to associate the printer for that server with a machine.






Printer File	Select a bundle ticket to assign to the machine. This allows different ticket layouts to be assigned to different machines.
Bend Allowance	The bend allowance for the machine.
Type #1-5	<p>Defining a type in one of these columns will alter the punch pattern on a part depending on the type chosen here and the profile assigned to the job. These changes will be made to a part upon sending the associated job to the controller. (See profiles, page 28).</p> <ul style="list-style-type: none"> • Flip X: Changes all "leading" references to "trailing" and vice versa. • Flip Y: Changes all negative Y-offset locations to positive and vice versa. • Shift Y: Adds half the profile's web to the Y-offset locations.

The last three columns are the machine's line velocity, line acceleration, and average dwell time. These values can be defined if you want to estimate completion times for jobs.

Smith, John ▾		
		
Line Velocity ▾	Line Accelerat... ▾	Avg Dwell ▾
0 ft/minute	0.000 in/s ²	0 seconds
0 ft/minute	0.000 in/s ²	0 seconds
0 ft/minute	0.000 in/s ²	0 seconds
0 ft/minute	0.000 in/s ²	0 seconds
0 ft/minute	0.000 in/s ²	0 seconds
0 ft/minute	0.000 in/s ²	0 seconds

Machine Setups

This screen allows you to download setups from the controller. Access this screen by clicking on Definitions and highlighting Machines, then select "Setups" from the menu that appears to the right.






 Machine Setups Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾			
Machine:	Group:		
S2 Test ▾	2016-10-20 13:34:04 ▾	 Request	 Send  Delete Group  Print Group
Name	Value	Units	
MACHINE: General: Material Encoder Direction	Clockwise		
MACHINE: General: Encoder Resolution	1666.000	Cnts/In	
MACHINE: General: SmartCut Location	0.000	In	
MACHINE: General: SmartCut Stops for	Material		
MACHINE: General: Correction Factor	100.000	%	
MACHINE: General: Length +/- Correction Adjust	0.062	In	
MACHINE: General: Shear To Encoder Distance	0.000	In	
MACHINE: General: Minimum Part Length	12.000	In	
MACHINE: General: Scrap Length	24.000	In	
MACHINE: General: Slug Width	0.000	In	
MACHINE: General: Delay After Shear	0.000	Sec	
MACHINE: General: Batch Complete Dwell Time	0.000	Sec	
MACHINE: General: Prompt For New Coil?	Never		
MACHINE: General: Run Method	Sequential		
MACHINE: General: Halt Method	Never		
MACHINE: General: Prompt to Continue Punching on New:	Never		
MACHINE: General: Control Tolerance	0.020	In	
MACHINE: General: Delete Done Items After...	0.000	Days	
MACHINE: Closed Loop Control: Line Velocity	300.000	Ft/Min	
MACHINE: Closed Loop Control: Jog Velocity	20.000	Ft/Min	
MACHINE: Closed Loop Control: Use Speed Pot	No		
MACHINE: Closed Loop Control: Motor Encoder Resolution	500.000	Cnts/In	
MACHINE: Closed Loop Control: Run Feedback Encoder	Motor		

To download setups, select the machine from the drop-down menu titled "Machine," then click request. Once the setups have been downloaded, you can select the desired group of setups (titled by date and time) from the "Group" drop-down. A new group is created every time changes are made to the machine setups on the controller, and also when setups are requested.

Once setups have been retrieved, you can choose "Delete Group" to delete the currently displayed group, or "Print Group" to print out the currently displayed group's setups.

Machine Tools

This screen allows you to download tools from the controller. Access this screen by clicking on Definitions and highlighting machines, then select Tools from the menu that appears to the right.

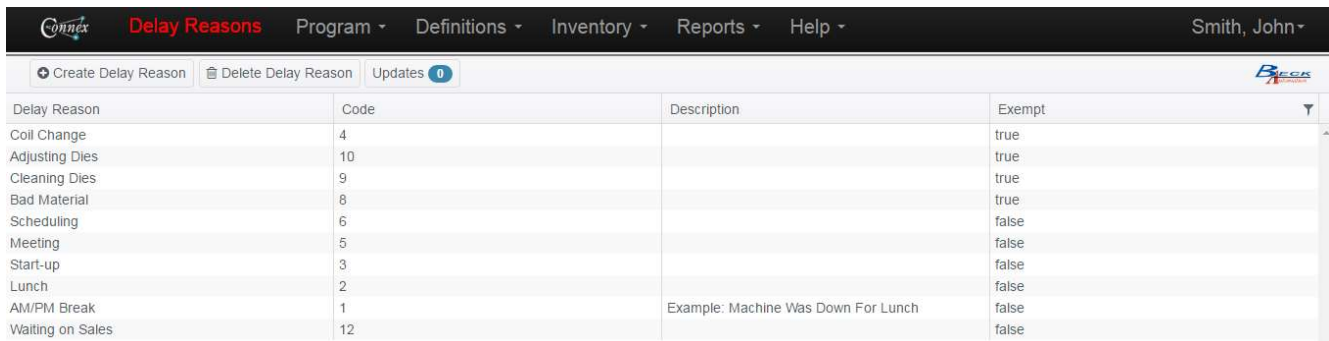
<div>  Machine Tools Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ </div>									
Machine: S2 Test ▾		Group: Thu Oct 20 13:46:28 2016 ▾		<div>  Request  Send  Delete Group  Print Group </div>					
Name ▾	Press ▾	Gag(s) ▾	Offset ▾	Down Time ▾	Up Time ▾	Reaction Time ▾	Boost Time ▾		
1	1		0.000	0.100	0.100	0.000	0.000		
11	1	127	0.000	0.100	0.100	0.000	0.000		
12	1	128	0.000	0.100	0.100	0.000	0.000		
A.0	2	1 65	21.000	0.100	0.100	0.000	0.000		
B.0	2	1 66	24.000	0.100	0.100	0.000	0.000		
A.1	2	2 67	33.000	0.100	0.100	0.000	0.000		
C.1	2	2 68	36.000	0.100	0.100	0.000	0.000		
A.2	2	3 69	45.000	0.100	0.100	0.000	0.000		
C.2	2	3 70	48.000	0.100	0.100	0.000	0.000		
A.3	2	4 71	57.000	0.100	0.100	0.000	0.000		
G.3	2	4 72	60.000	0.100	0.100	0.000	0.000		
D.4	2	5 73	69.000	0.100	0.100	0.000	0.000		
F.4	2	5 74	72.000	0.100	0.100	0.000	0.000		
A.5	3	6 75	21.000	0.100	0.100	0.000	0.000		
B.5	3	6 76	24.000	0.100	0.100	0.000	0.000		
A.6	3	7 77	33.000	0.100	0.100	0.000	0.000		
C.6	3	7 78	36.000	0.100	0.100	0.000	0.000		
A.7	3	8 79	45.000	0.100	0.100	0.000	0.000		
C.7	3	8 80	48.000	0.100	0.100	0.000	0.000		
A.8	3	9 81	57.000	0.100	0.100	0.000	0.000		
G.8	3	9 82	60.000	0.100	0.100	0.000	0.000		
D.9	3	10 83	69.000	0.100	0.100	0.000	0.000		

To download tools, select the machine from the drop-down menu titled "Machine," then press request. Once the tools have been downloaded, you can select the desired group from the Group drop-down. A new group is created every time changes are made to the machine tools, and also when tools are requested.


Use "Delete Group" to delete the currently displayed group, or "Print Group" to print out the currently displayed group's tools.

Delay Reasons

This screen allows you to define delay reasons in order to track downtime. Access the Delay Reasons screen by clicking on the Definitions drop down and selecting Delay Reasons. If the controller has the “Maximum Delay without Reason” parameter set, the operator will be prompted to input a delay reason prior to being able to run the machine if it has been halted for longer than this parameter is set for. Downtime reports can then be ran to track downtime by reason (see Page 36).



Delay Reason	Code	Description	Exempt
Coil Change	4		true
Adjusting Dies	10		true
Cleaning Dies	9		true
Bad Material	8		true
Scheduling	6		false
Meeting	5		false
Start-up	3		false
Lunch	2		false
AM/PM Break	1	Example: Machine Was Down For Lunch	false
Waiting on Sales	12		false


To add a delay reason, click on the  button at the top of the page. A code number will automatically be generated, but it can be manually changed to any number. The description column is optional; it provides a more in-depth description for each delay reason.

The Exempt column is used to track downtime. On downtime reports, exempt and non-exempt downtime are tracked in separate columns. If “true” is selected, the downtime will be considered exempt for that reason, and this downtime will not be counted in the total downtime. If “false” is selected, the downtime will be counted as non-exempt.

To delete a delay reason, click on the  button at the top of the page.

Profiles

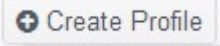


This screen allows you to add, edit, and delete profiles. You can access the Profiles screen by clicking on the Definitions drop down and selecting Profiles. Connex uses profiles to determine which machines can run each job. A job with a profile assigned to it may only be downloaded to a line capable of running that profile. This prevents a job from being downloaded to a line that is not capable of running the job.

<div>  Profiles Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ </div> <div>Smith, John ▾</div>						
<div> <div> Create Profile Copy Delete Profile ▾ Expand Selected ▸ Collapse Selected Updates 0 </div> <div> Create Profile Machine Delete Profile Machine </div> </div>						
Profile	Description	Coverage	Package Capacity	Type	Web	
10X3.5 DE 5-15 14GA				2	6.000 in	
Machine						
Central States						
Phoenix						
4x2.5 C 16GA				1	4.000 in	
Machine						
S2 Test						
Phoenix						
6X2.5 DE 2-12 14GA				2	6.000 in	
4X2.5 C 14GA				2	6.000 in	
4X3 OC 14GA				3	12.000 in	
4X2.5 Z 16GA				2	8.000 in	
6X2.5 DE 3-12 16GA				4	8.000 in	
4X2.5 Z 14GA				1	6.000 in	
6X2.5 C 16GA				1	5.000 in	
6X2.5 C 14GA				5	6.000 in	
10X3.5 DE 3-12 14GA				4	6.000 in	
6X3 OC 14GA				4	4.000 in	
6X2.5 Z 16GA				1	8.000 in	

Profile Keys





	Creates a new profile.
	Copies selected profile(s).
	Deletes selected profile(s).
	Expands selected profile(s).
	Collapses selected profile(s).
	If the Show Edit Lock feature is turned on, this key will unlock the screen for editing.
	If the Show Edit Lock feature is turn on, this key will lock the screen so the information cannot be edited.
Updates 0	Click on this key to refresh the screen and see new data added by other users.
	Creates a new machine for the selected profile.
	Deletes selected profile machine(s).

Entering New Profiles

1. Click on the  button at the top of the page.
2. Enter the name of the profile.
3. Coverage, package capacity and description are optional fields that may be useful for record keeping or printing on a part or bundle ticket. You can enter any appropriate data or leave them blank.
4. The number selected in the type column determines which type will be used for jobs this profile is applied to. There are 5 different options for type, or you can choose 0 if no alterations will be made to the punch pattern. These types are defined on the Machine Definitions screen, see page 23.
5. If you enter the web length in this field, punches that are programmed for greater than $\frac{1}{2}$ of this value on the Y-axis will be brought to the center of the part by the bend allowance amount defined on the Machine Definitions screen.
6. From the drop-down list, pick the first machine that can run this profile.
7. If additional machines can run this profile, click  at the top of the page and select another machine. Repeat this step until all machines capable of running this profile are listed.
8. Repeat the above steps for each profile. The  button will make entering similar profiles much faster.



Materials

This screen allows you to add, edit, and delete materials. You can access the Materials screen by clicking on Definitions and selecting Materials from the drop-down. Connex uses materials to inform the operator which material or coil to use for a job. If you choose not to use materials, the job's material may be set to "undefined."

<div>  Materials Status Program - Definitions - Inventory - Reports - Help - </div> <div>Champagne, Beau -</div>							
<div>  Create Material  Delete Material Updates 0 <div></div> </div>							
Material	Color	Gauge	Width	Thickness	Density	Description	
16GA 12IN GALV	GALV	16	11.968 in	0.0540 in	2.358 lbs/ft		
16GA 16IN RED	RED	16	15.968 in	0.0540 in	3.336 lbs/ft		
16GA 16IN GALV	GALV	16	15.968 in	0.0540 in	3.336 lbs/ft		
14GA 12IN GALV	GALV	14	11.968 in	0.0690 in	2.890 lbs/ft		
16GA 14IN GALV	GALV	16	13.968 in	0.0540 in	2.838 lbs/ft		
14GA 16IN GALV	GALV	14	15.968 in	0.0690 in	4.100 lbs/ft		
12GA 16IN GALV	GALV	12	15.968 in	0.0950 in	5.366 lbs/ft		
14GA 14IN GALV	GALV	14	13.968 in	0.0690 in	3.483 lbs/ft		
12GA 14IN GALV	GALV	12	13.968 in	0.0950 in	4.710 lbs/ft		
14GA 18IN GALV	GALV	14	17.968 in	0.0690 in	4.820 lbs/ft		
12GA 18IN RED	RED	12	17.968 in	0.0950 in	6.090 lbs/ft		
12GA 18IN GALV	GALV	12	17.968 in	0.0950 in	6.090 lbs/ft		
16GA 10IN RED	RED	16	9.968 in	0.0540 in	1.882 lbs/ft		
16GA 10IN GALV	GALV	16	9.968 in	0.0540 in	1.882 lbs/ft		
14GA 10IN GALV	GALV	14	9.968 in	0.0690 in	2.224 lbs/ft		
16GA 12IN RED	RED	16	11.968 in	0.0540 in	2.358 lbs/ft		
14GA 12IN RED	RED	14	11.968 in	0.0690 in	2.890 lbs/ft		
14GA 16IN RED	RED	14	15.968 in	0.0690 in	4.100 lbs/ft		
16GA 14IN RED	RED	16	13.968 in	0.0540 in	2.838 lbs/ft		
14GA 14 IN RED	RED	14	13.968 in	0.0690 in	3.483 lbs/ft		
12GA 16IN RED	RED	12	15.968 in	0.0950 in	5.366 lbs/ft		
14GA 18IN RED	RED	14	17.968 in	0.0690 in	4.820 lbs/ft		

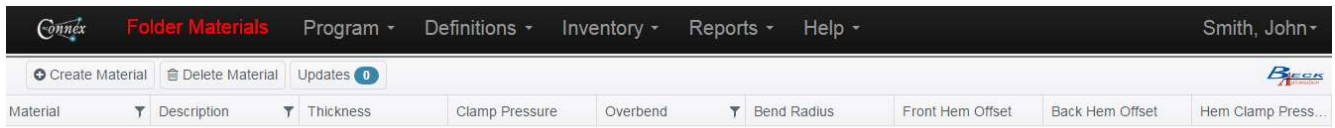
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Entering New Materials




1. Click on  Create Material at the top of the page.
2. Enter the name of the material.
3. Gauge, Thickness, Width, Color, Density and Description are optional fields that may be useful for record keeping or printing on the material or on bundle tickets. You can enter any appropriate data or leave them blank.
4. To delete a material, click on the  Delete Material icon at the top of the page. You cannot delete a material if it is currently being used in a job. You must either delete the job or select a different material for the job prior to deleting.

Folder Materials

Define materials used for folder parts on this screen. Access this screen by clicking on Definitions and selecting Folder Materials from the drop-down.











Folder Materials Keys

	Creates a new material.
	Deletes highlighted material(s).
	Click on this key to refresh the screen and see new data added by other users.

Coils

The screen allows you to keep track of coil data. Access the coils screen by clicking on the Inventory drop down and selecting Coils. If your coil inventory already exists in electronic format, you can speak to Beck Automation about the possibility of importing from that system. Tracking coils is completely optional.

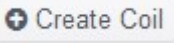

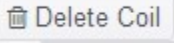

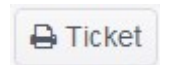

<div>  Coils Status Program Definitions Inventory Reports Help </div> <div>Champagne, Beau</div>										
<div> <div>  Create Coil  Copy Coil  Delete Coil  Print Coils  Ticket </div> <div>  Filter  Updates </div> </div> <div> Page Number: 1 Page Size: 25 </div>										
Coil	Location	Material	Good	Scrap	Total	Received	First Used	Last Used	Status	
F021110	St. Louis	16GA 16IN RED	0.000 ft	0.000 ft	0.000 ft	2/17/2014 16:13	No Date Set	No Date Set	Available	
752416	St. Louis	14GA 10IN GALV	0.000 ft	0.000 ft	0.000 ft	4/23/2014 11:37	No Date Set	No Date Set	Available	
F022425	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	2/14/2014 08:07	No Date Set	No Date Set	Available	
F022658	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	2/14/2014 08:04	No Date Set	No Date Set	Available	
F022664	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	2/14/2014 08:05	No Date Set	No Date Set	Available	
F023612	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	3/10/2014 08:10	No Date Set	No Date Set	Available	
F023613	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	3/10/2014 08:09	No Date Set	No Date Set	Available	
F023616	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	3/10/2014 08:08	No Date Set	No Date Set	Available	
F022665	St. Louis	14GA 14 IN RED	627.000 ft	191.336 ft	818.336 ft	2/14/2014 08:03	4/23/2014 15:02	4/23/2014 16:08	Available	
F023617	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	3/10/2014 08:09	No Date Set	No Date Set	Available	
754394	St. Louis	14GA 14IN GALV	1275.667 ft	8.820 ft	1284.486 ft	3/25/2014 06:41	4/22/2014 06:34	4/24/2014 06:23	Available	
F021108	St. Louis	16GA 16IN RED	2200.909 ft	44.371 ft	2245.280 ft	2/17/2014 16:13	4/11/2014 11:25	4/24/2014 15:08	Available	
755098	St. Louis	16GA 14IN GALV	0.000 ft	0.000 ft	0.000 ft	4/23/2014 11:39	No Date Set	No Date Set	Available	
F021979	St. Louis	12GA 14IN RED	0.000 ft	0.000 ft	0.000 ft	2/12/2014 13:09	No Date Set	No Date Set	Available	
755335	St. Louis	16GA 14IN GALV	0.000 ft	0.000 ft	0.000 ft	4/23/2014 11:40	No Date Set	No Date Set	Available	
F023614	St. Louis	14GA 14 IN RED	0.000 ft	0.000 ft	0.000 ft	3/10/2014 08:10	No Date Set	No Date Set	Available	
F021980	St. Louis	12GA 14IN RED	0.000 ft	0.000 ft	0.000 ft	2/12/2014 13:09	No Date Set	No Date Set	Available	
754536	St. Louis	16GA 12IN GALV	472.500 ft	0.000 ft	472.500 ft	3/31/2014 09:26	4/21/2014 10:05	4/21/2014 10:46	Available	
F021261	St. Louis	14GA 16IN RED	0.000 ft	0.000 ft	0.000 ft	1/31/2014 06:43	No Date Set	No Date Set	Available	
F024796	St. Louis	16GA 14IN RED	0.000 ft	0.000 ft	0.000 ft	4/11/2014 09:05	No Date Set	No Date Set	Available	



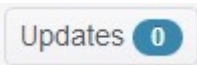
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When a coil is loaded at the line, the operator will be prompted for a coil number. The production and scrap that is created is reported back to Connex and totaled for that coil.



Connex can also verify the correct coil is loaded. Our coil feature will look up the newly loaded coil's material and compare it to the current job's material. If the materials do not match, the line operator will be sent a warning message.

Coil Keys

	Creates a new coil.
	Copies selected coil.
	Deletes selected coil(s).
	Prints a list of the selected coils to a local printer.
	Prints coil tags for selected coil(s). A bundle ticket printer must be connected to the Connex PC, and a Coil Tag must be designed and installed by Beck for this feature to work.
	Turns the database filter view on or off.

	If the Show Edit Lock feature is turned on, this key will unlock the screen for editing.
	If the Show Edit Lock feature is turn on, this key will lock the screen so the information cannot be edited.
	Click on this key to refresh the screen and see new data added by other users.

Entering New Coils

1. Click on  at the top of the page.
2. Enter the name of the coil.
3. Select the coil's material from the dropdown list. The material must first be defined on the Materials Definitions page (see page 23).
4. Select the material's status:
 - Available: Coil is stocked and ready to use.
 - Depleted: Coil has been depleted. The administrator can set depleted materials to automatically delete themselves from this screen after a set amount of time on the Server Preferences option screen (see page 6).
 - Hold: Coil is on hold and will not be used.
5. The remaining fields are optional fields that may be useful for record keeping. If the length field is entered, current length will be used when coils are scanned or requested at the controller to show how many feet are available on the selected coil. You can enter any appropriate data or leave these fields blank.
6. Repeat the above steps for each additional coil you wish to add. The  button will make entering similar coils much faster.

Staged Coils

The staged coils screen allows you to stage coils for upcoming jobs that have been programmed on the Jobs screen. Access this screen by clicking on the Inventory drop down and selecting Staged Coils. The screen will then display each machine entered in Connex, the current coil for each machine, and the material requirements for programmed Jobs.

The screenshot shows the 'Staged Coils' screen. At the top, there is a 'Current Coil' section with the following information: 'Current Coil: COIL1236', 'Material: S9008 Lipped Cee', and 'Remaining: -1621.778 ft'. Below this is the 'Staged Coils' section, which contains a 'Submit New' button and a list of staged coils. The list shows two items: 'Staged Coil COIL1234' with 'Material S7006 Lipped Cee' and 'Remaining -305.252 ft', and 'Staged Coil COIL1235' with 'Material S7008 Lipped Cee' and 'Remaining -1898.453 ft'. Each item has an 'x' button in the top right corner for removal. At the bottom, there are navigation buttons (back, previous, 1, next, forward) and a status bar indicating '1 - 2 of 2 items'.

Current Coil	
Current Coil:	COIL1236
Material:	S9008 Lipped Cee
Remaining:	-1621.778 ft

Staged Coils	
<input type="text"/> <button>Submit New</button>	
Staged Coil COIL1234	Staged Coil COIL1235
Material S7006 Lipped Cee	Material S7008 Lipped Cee
Remaining -305.252 ft	Remaining -1898.453 ft

1 - 2 of 2 items

To stage a coil for a machine, enter the coil's name and click "Select New." The selected coil, the coil's material, and the remaining amount of the coil will then display on the screen. You can stage as many coils as you would like for each machine. Remove a staged coil by pressing the "x" at the corner of a coil.

Coil Forecast

Access the Coil Forecast screen by clicking on the Inventory drop down and selecting Coil Forecast. This screen displays a list of the materials entered in Connex, the amount in stock of each material, and how much of each material is required based on currently scheduled jobs. It also displays the footage that will remain once all jobs are completed along with a current monetary value. These values depend on the information entered on the Coils screen (see page 32).

Connex Coil Forecast Status Program - Definitions - Inventory - Reports - Help - Champagne, Beau -					
Name	Required	In Stock *	Remaining	Current Value	
12GA 18IN RED	0 ft / 0 lbs	0 ft / 0 lbs	0 ft / 0 lbs	\$0.00	
14GA 18IN GALV	290 ft / 1397 lbs	0 ft / 0 lbs	-290 ft / -1397 lbs	\$0.00	
14GA 18IN RED	0 ft / 0 lbs	0 ft / 0 lbs	0 ft / 0 lbs	\$0.00	
12GA 18IN GALV	0 ft / 0 lbs	1280 ft / 7795 lbs	1280 ft / 7795 lbs	\$0.00	
14GA 16IN GALV	2151 ft / 8819 lbs	1916 ft / 7854 lbs	-235 ft / -965 lbs	\$0.00	
12GA 16IN GALV	0 ft / 0 lbs	2091 ft / 11223 lbs	2091 ft / 11223 lbs	\$0.00	
12GA 16IN RED	194 ft / 1043 lbs	2748 ft / 14746 lbs	2554 ft / 13702 lbs	\$0.00	
12GA 14IN GALV	72 ft / 339 lbs	3150 ft / 14837 lbs	3078 ft / 14498 lbs	\$0.00	
12GA 14IN RED	274 ft / 1292 lbs	3176 ft / 14957 lbs	2901 ft / 13665 lbs	\$0.00	
14GA 12IN RED	0 ft / 0 lbs	3480 ft / 10057 lbs	3480 ft / 10057 lbs	\$0.00	
16GA 12IN GALV	617 ft / 1455 lbs	3613 ft / 8518 lbs	2996 ft / 7063 lbs	\$0.00	
16GA 12IN RED	60 ft / 141 lbs	4157 ft / 9802 lbs	4097 ft / 9661 lbs	\$0.00	
14GA 10IN GALV	974 ft / 2167 lbs	4254 ft / 9460 lbs	3279 ft / 7293 lbs	\$0.00	
16GA 10IN GALV	880 ft / 1657 lbs	4594 ft / 8646 lbs	3714 ft / 6989 lbs	\$0.00	
14GA 12IN GALV	219 ft / 634 lbs	4828 ft / 13952 lbs	4608 ft / 13318 lbs	\$0.00	
16GA 16IN RED	2611 ft / 8710 lbs	6335 ft / 21133 lbs	3724 ft / 12422 lbs	\$0.00	
16GA 16IN GALV	428 ft / 1429 lbs	6835 ft / 22800 lbs	6406 ft / 21371 lbs	\$0.00	
14GA 16IN RED	634 ft / 2600 lbs	8135 ft / 33352 lbs	7500 ft / 30752 lbs	\$0.00	
14GA 10IN RED	101 ft / 224 lbs	8247 ft / 18341 lbs	8146 ft / 18117 lbs	\$0.00	
16GA 10IN RED	144 ft / 271 lbs	8335 ft / 15686 lbs	8191 ft / 15415 lbs	\$0.00	
14GA 14 IN RED	1093 ft / 3808 lbs	15888 ft / 55338 lbs	14795 ft / 51530 lbs	\$0.00	
14GA 14IN GALV	2296 ft / 7997 lbs	17730 ft / 61752 lbs	15433 ft / 53754 lbs	\$0.00	
16GA 14IN GALV	3931 ft / 11155 lbs	24586 ft / 69774 lbs	20655 ft / 58619 lbs	\$0.00	
16GA 14IN RED	3948 ft / 11205 lbs	30864 ft / 87592 lbs	26916 ft / 76388 lbs	\$0.00	

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Clicking on the arrow next to a material will display a list of the coils containing the material, jobs requiring the material, and a pie chart displaying the proportion of each material that will be used for each job.

Connex Coil Forecast Status Program - Definitions - Inventory - Reports - Help - Champagne, Beau -					
Name	Required	In Stock *	Remaining	Current Value	
14GA 10IN GALV	974 ft / 2167 lbs	4254 ft / 9460 lbs	3279 ft / 7293 lbs	\$0.00	
Jobs Pie Chart					
Job Name	Required	Stock	Remaining		
67725		206 ft	4254 ft	4047 ft	
67680		10 ft	4254 ft	4244 ft	
67676		18 ft	4254 ft	4236 ft	
67666		41 ft	4254 ft	4213 ft	
67688		10 ft	4254 ft	4244 ft	
67693		146 ft	4254 ft	4108 ft	
67682		66 ft	4254 ft	4188 ft	
67654		24 ft	4254 ft	4230 ft	
67726		30 ft	4254 ft	4224 ft	
67725		120 ft	4254 ft	4134 ft	
67725		179 ft	4254 ft	4075 ft	
67726		29 ft	4254 ft	4225 ft	
67726		60 ft	4254 ft	4194 ft	
67676		36 ft	4254 ft	4218 ft	
total		974 ft	4254 ft	3279 ft	
16GA 10IN GALV	880 ft / 1657 lbs	4594 ft / 8646 lbs	3714 ft / 6989 lbs	\$0.00	
14GA 12IN GALV	219 ft / 634 lbs	4828 ft / 13952 lbs	4608 ft / 13318 lbs	\$0.00	

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Report Builder

The Report Builder screen allows you to create customized reports based on your desired parameters. Access this screen by clicking on the Reports drop-down and selecting Report Builder.

Connex ReportBuilder Program ▾ Definitions ▾ Inventory ▾ Reports ▾ Help ▾ Smith, John ▾

Template: ▾ Save Delete Type: Production Machine: Undefined Start: 10/25/2016 End: 10/25/2016 Get Report Print

Grid

Drag a column header and drop it here to group by that column

Job ▾	Material ▾	Profile ▾	Machine ▾	Produ... ▾	Length ▾	Weight ▾	Gauge ▾	Weight ▾	Job U... ▾	Job U... ▾	Job U... ▾	Job U... ▾
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Creating New Report

1. Select the type of report you would like to create. There are six types of reports:
 - Production: Displays information about each job that has been run and the length of material produced.
 - Coil: Displays information for each coil that has been used, and what jobs that coil has been used for.
 - Downtime: Displays downtime and uptime for each machine.
 - Scrap: Displays information for scrap produced.
 - Machine History: Displays a detailed description of all actions taken at the machine, including coil changes, delay reasons, enter run, exit run, item data, manual shears, messages, quantity adjustments, scrap reasons, shift end, and shift start.
 - Summary: Summarizes information for each shift.
2. Select the machine that you'd like to see the data for from the drop down. Choose undefined to see data from all machines.
3. Select the start and end dates for the time frame you'd like to see the data for.
4. If there is a certain template that you'd like to use to organize the data, select it from the template drop down menu on left corner.
5. Click "get report" to display the data.
6. Click "print" to print displayed data to printer or export it to Excel.

Customizing a Report

The report display can be customized and then saved to a template that can be used for future reports.

- Rearrange columns: Click and drag a column to its desired location.
- Group data by column type: Click and drag the column header to the space right above the columns.
- Adjust column width: Click on the border of the column and drag it to the desired width.
- Add or remove columns: Click on the arrow next to any column name and highlight the columns option on the drop-down. Uncheck any boxes you would not like to be displayed.
- Sort the results by values in a certain column: Click on the arrow next to that column and highlight the Sort Ascending or Sort Descending option.
- Filter by certain results in a column (i.e. only display jobs with a certain type of profile): Click on the arrow next to the column you'd like to filter by and highlight the filter option on the drop-down menu.

Troubleshooting

Connex Log-in Screen Does Not Appear	Are you typing in the correct IP Address?	Verify Connex IP address has not changed.
	Is Connex PC Turned On?	Press the power button on front of PC and ensure that it is plugged in.
	Is Connex PC plugged into the Ethernet?	Verify the Ethernet port has a green light. Verify the router/switch Ethernet port has a green light.
Unable to Log In	Is your username and password correct?	Contact Connex Admin to reset username and/or password.
Unable to get Backups or Updates	Is Connex PC plugged into the Ethernet?	Verify Ethernet cable is plugged in PC.
	Can you get to Google.com from web browser on Connex PC?	Connect a keyboard, monitor and mouse, and enter google.com into a web browser.
	Is your system administrator blocking any websites through network?	Contact your system administrator for the answers to these questions.
	Are ports 22 or 80 being blocked by your system administrator?	
All Machines show Offline in the Status Screen	Is the Connexor box turned on?	Check power and press power on box.
	Is the USB/485 converter plugged into the correct USB port on Connexor?	Unplug and plug converter back into USB port labeled "Controller." You can also verify the "Has Connexor" displays "true" on the Connexor Servers screen.
	Is the Ethernet cable plugged into Connexor box?	Verify the lights are flashing green at both the Connexor and the router.
	Is the 485 cable (2-wire cable) damaged or is there an issue with controller communications?	Check the connections at each controller and at the USB/485 converter. You can also disconnect each controller and try connecting one at a time.
Some, not all, Machines showing offline	Are the network unit/node numbers in Connex the same as the ones on the controller?	Check machine definitions and the controller machine setups page to verify each is correct. Check to make sure these numbers are not duplicated on two different machines.

Unable to View any Data	Are your user roles setup correctly? (Users must have permission to view all information)	Ask your system administrator to verify roles/permissions are set correctly.
	Do you have a location entered in user options?	Go to user options, select locations to view, and press save.