

1. Method of operating Production Instruction Sysyem

	AS400(P&P)	Frame Server	Production instruction PC	Remarks
Day time	Production schedule data is made.			
23:00		Daily batch (Auto) Data is received.		
8:00			The communication are checked the server Is it a reception and is not Error generated? Error none Check The Q'ty of receive data It is confirmed the Q'ty written on paper. Not same Q'ty FRD Contact P&P	Q'ty of received data =MASS+PILOT+EMERGENCY+SERVICE +CSO+CLAIM
	P&P ← Contact (from FRD to P&P) Check Production schedule data.			
		Manual reception Data is received.	Error ①Control code none "000000..." or "space" FEG unsetting.? or FRD uninput? Confirmation FEG setting / FRD input	
	P&P ← Contact (from FRD to P&P) Production schedule data is made.			
		Manual reception Data is received.	②Data errors other than control code "Hedder", "ISUZU ASM Parts No.",erc. Data NG	
	P&P ← Contact (from FRD to P&P) Check Production schedule data			
		Manual reception Data is received.	Receive data is OK. Making of production plan	

2. Function of client

FPS-PM-PE-001 Rev.0

F1: Production Data

Production data screen

F2: Addition Data

F1: MASS
F2: PILOT
F3: EMERGENCY
F4: SERVICE
F5: CSO
F6: CLAIM
F8: Delete

User & Password is necessary.

F9: Add To Last
F10: UPDATE
F11: CANCEL
F12: MANU

Data is added at the end of the production instruction data.
Data is inserted in the position of Production data screen cursor.
Return to Production data screen
Return to Main menu screen

F4: Search

F1: Execution
F12: CANCEL

"Control Code", "Lot No.", "Suffix Code", "Date"

F5: Skip

F1: Execution
F12: CANCEL

F6: Insert

F1: MASS
F2: PILOT
F3: EMERGENCY
F4: SERVICE
F5: CSO
F6: CLAIM
F9: Delete
F10: Insert
F10: UPDATE
F11: CANCEL
F12: MANU

F7: Previous

F8: Next

F9: Reload

F11: Make Data

F2: Addition
F3 :Delete
F11: Update
F12: MANU

Return to Main menu screen

F12: MANU

Return to Main menu screen

F2: Production Schedule

F1: Change

The position of the pointer (orange) is changed.

F7: Previous

Previous data is displayed.

F8: Next

Next data is displayed.

F9: Reload

F10: Search

F1: Execution
F12: CANCEL

"Control Code", "Lot No.", "Suffix Code", "Date"

F12: MANU

Return to Main menu screen

F3: Flow Setting

F5: Data Log

Save

LOG is saved by the CSV file format.
"AS400 Log", "PLC Log", "Option"

Reload

Manu

Return to Main menu screen

F12: Shut Down

3. Switch condition of "USE", "NO USE" of PIS

	USE→NO USE	NO USE→USE																								
1)	S/M A, B, C ①MANUAL Mode ②-1: Parts set on JIG ②-2: HOME Position	①MANUAL Mode ②-1: Parts set on JIG ②-2: HOME Position ③"NO DATA" in touch screen																								
2)	MA, MC ①MANUAL Mode : O/H & #1sta ②-1: Parts set on JIG ②-2: HOME Position	①MANUAL Mode : O/H & #1sta ②-1: Parts set on JIG ②-2: HOME Position ③"NO DATA" in touch screen																								
3)	CPT ①MANUAL Mode : O/H & #2sta ②-1: Parts set on JIG <table border="1"> <thead> <tr> <th></th><th>Pattern 1</th><th>Pattern 2</th></tr> </thead> <tbody> <tr> <td>MA ASM</td><td>○</td><td>x</td></tr> <tr> <td>MC ASM</td><td>○</td><td>x</td></tr> <tr> <td>S/M B</td><td>x</td><td>x</td></tr> </tbody> </table> ②-2: HOME Position		Pattern 1	Pattern 2	MA ASM	○	x	MC ASM	○	x	S/M B	x	x	①MANUAL Mode : O/H & #2sta ②-1: Parts set on JIG <table border="1"> <thead> <tr> <th></th><th>Pattern 1</th><th>Pattern 2</th></tr> </thead> <tbody> <tr> <td>MA ASM</td><td>○</td><td>x</td></tr> <tr> <td>MC ASM</td><td>○</td><td>x</td></tr> <tr> <td>S/M B</td><td>x</td><td>x</td></tr> </tbody> </table> ②-2: HOME Position ③"NO DATA" in touch screen		Pattern 1	Pattern 2	MA ASM	○	x	MC ASM	○	x	S/M B	x	x
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PIS:Production Instruction System

USE: The production instruction system is used.

NO USE: The production instruction system is not used.

4. Condition of Model Data Change

1) USE :

All sta cannot change data.

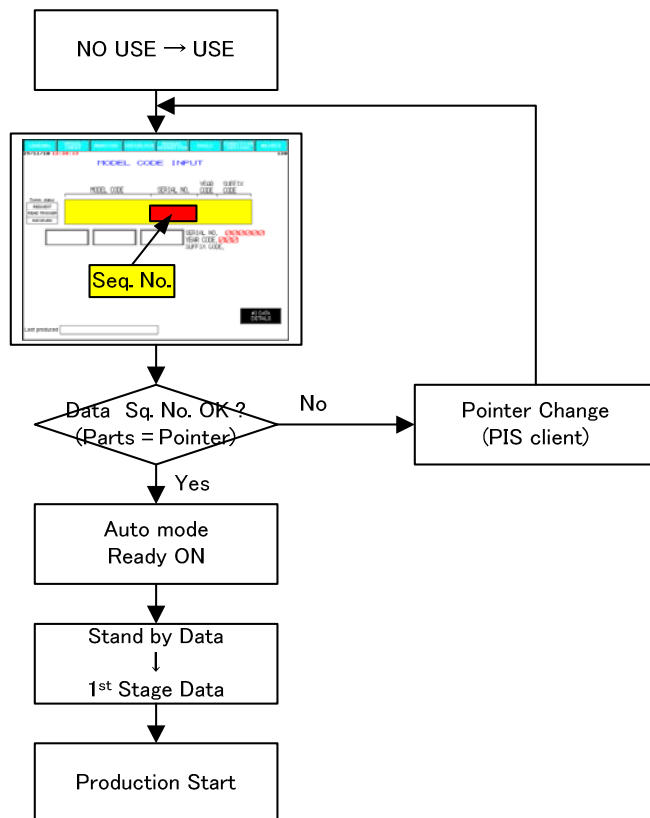
2) NO Use :

a) You cannot change data by the sta where the bar code is used.

b) Another sta can change data.

5. Importance

- ① Confirm the position of the pointer of the client when you change production from "NO USE" to "USE."



- ② The model cannot change at PIS USE.

GENERAL	MODEL	MONITOR	INTERLOCK	MANUAL	FAULT	CONDITION	MAINTENANCE		
29/11/19 10:03:12									
MODEL DATA MODIFY									
DATA				PREVIOUS					
0000000000000000				0000000000000000					
ST	DRIVE	MULTI	CAB	ENGINE	MISSION	HEIGHT	MODEL		
MODEL	DRIVE	DRIVE	DRIVE	DRIVE	DRIVE	DRIVE	DRIVE		
RHD	4-4	LWD	RED	WITH	REC	AT JATECO	TIS	STD	180
LHD	4-2	EXT LWB	EXT	WITHOUT	4J	AT JATECO	Q-EXP	WSP	RT50
4C	W-RIDE	SHORT	CREW		VS	MT MUA	C-150		07MY
			WAGON		HU	MT MONGMA	ECGAUS		08MY
					HIVS	MT MUA	T150		09MY
					4J	W-PONER	ALL		10MY
					MT MUX				11MY
DATA is non-editable in red and green colors. (Occupied by the PIS client)									
SERIAL: 00000000	YEAR: 0000	SUFFIX: 0000							
CHANGE: 00000000	CHANGE: 0000	CHANGE: 0000							