

RT50 Frame Shop ASM Line
Production instruction system
Screen Specifications

31 Aug. 2010

IC ENGINEERING CORPORATION

Approval	check	Making
		Morita

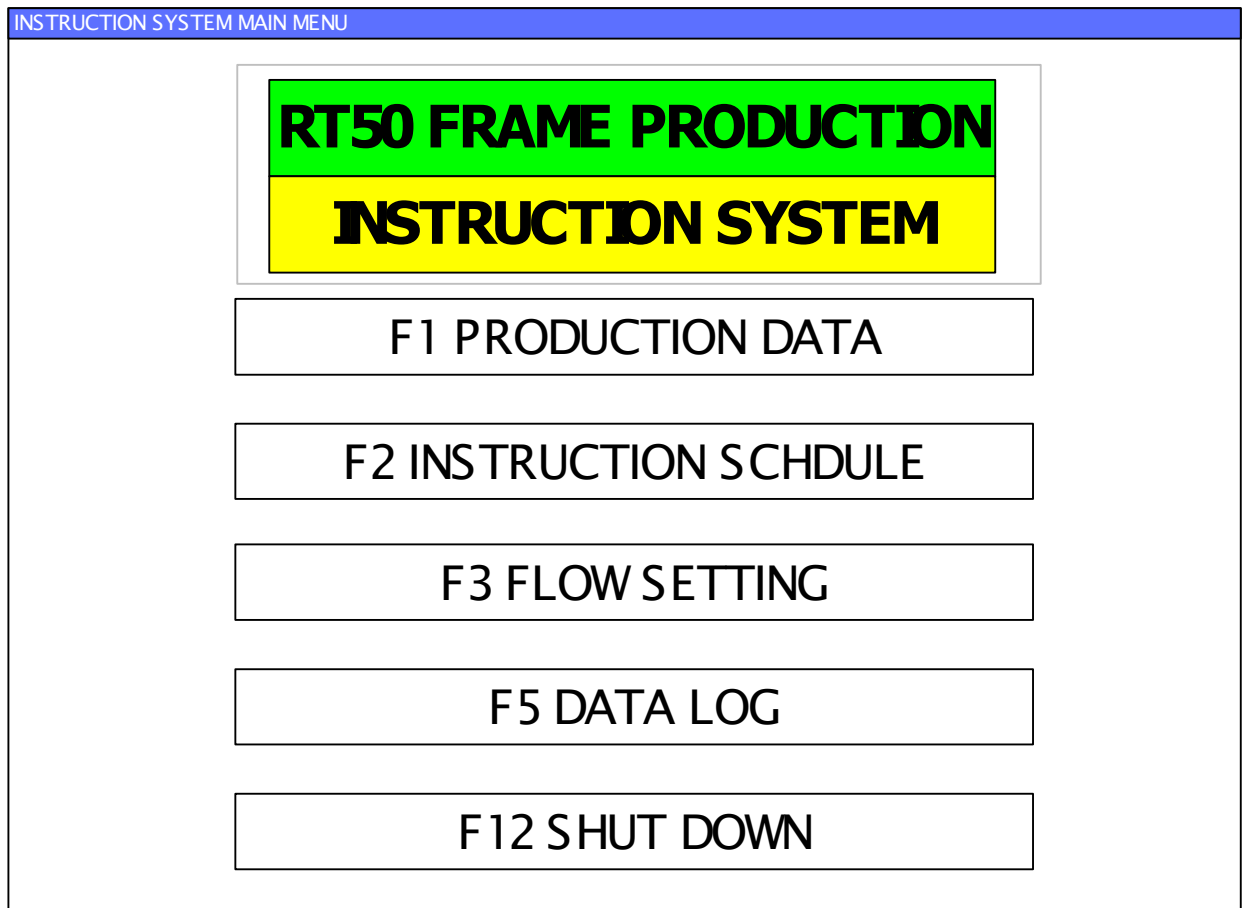
Recode of Revisions

Version	Date of Revision	Details	Administrator	Approved
1	07/Sep./2010	02/Sep./2010 Review by screen review meeting with IMCT	Morita	

The main menu

Click each of the buttons to move to individual screens.

Screen size is set to 1024 x 768.

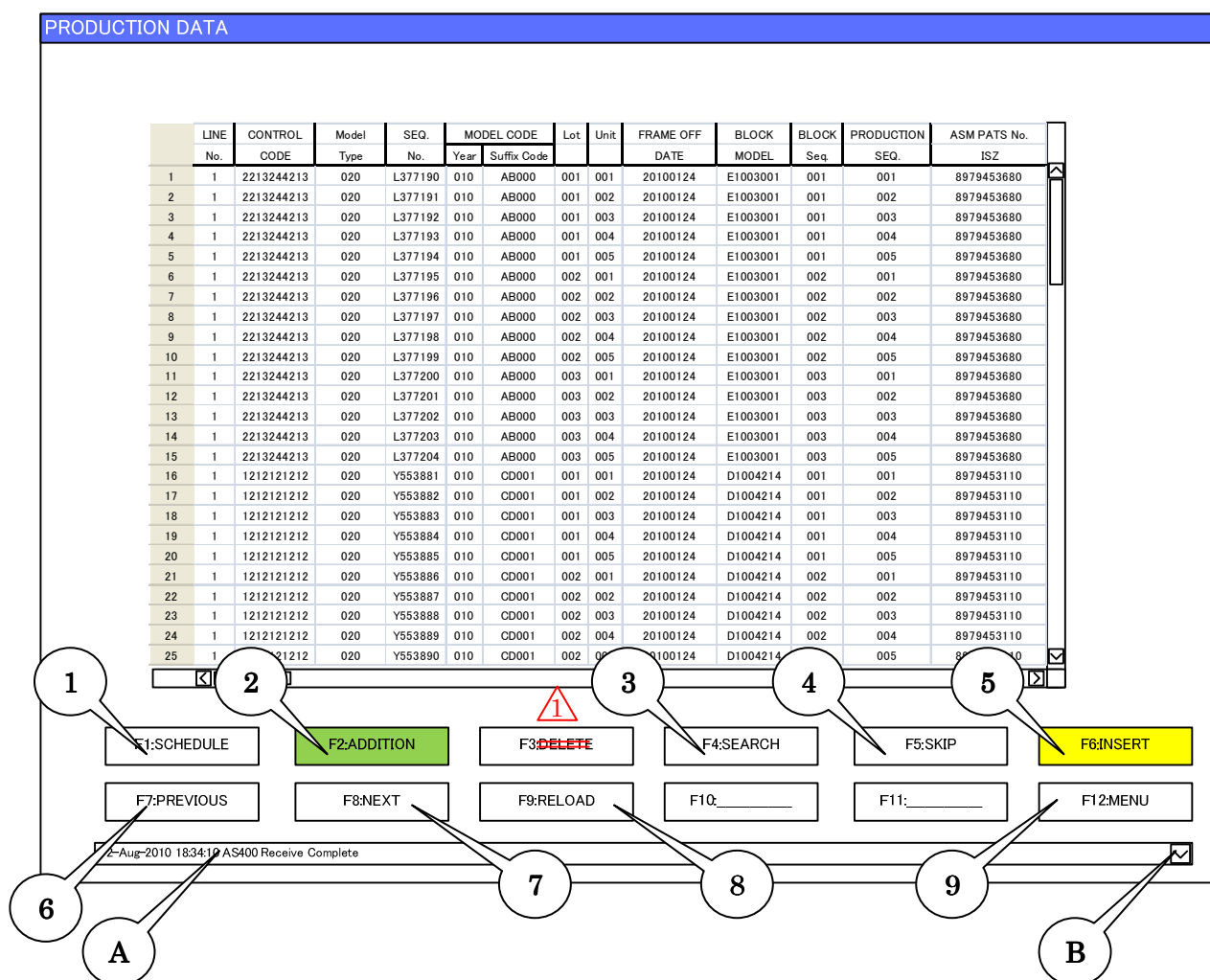


< Figure1・1・1 >

- ① F1 PRODUCTION DATA
Displays and allows editing of production data.
- ② F2 INSTRUCTION SCHDULE
Displays and allows editing of model instruction schedule.
- ③ F3 FLOW SETTING
The flow of the production order of the module line is decided.
- ④ F5 DATA LOG
Displays log data.
Allows operator to view operation log and data communication log.
- ⑤ F12 SHUT DOWN
Shuts down the program.
Can also be used to shut down power to the computer terminal.

1.1 F1: PRODUCTION DATA

Displays and allows editing of the production data schedule.



< Figure1·2·1 >

All the scheduled auto instruction data is displayed.

Data is displayed in order of Production Date + SEQ No..

It is possible to display all data contained. Use the horizontal scroll bar to navigate around the screen.

- Line. No.
- Comntrol Code
- Model type
- Seq. No.
- Model Code : Year + Suffix Code
- Lot No.
- Unit No.

- Frame Off Date
- Block Model
- Block Seq.
- Production Seq.
- ASM Parts No. ISZ
- Spare

Note: PRODUCTION TIME data is stored in the database.

A: Message display window

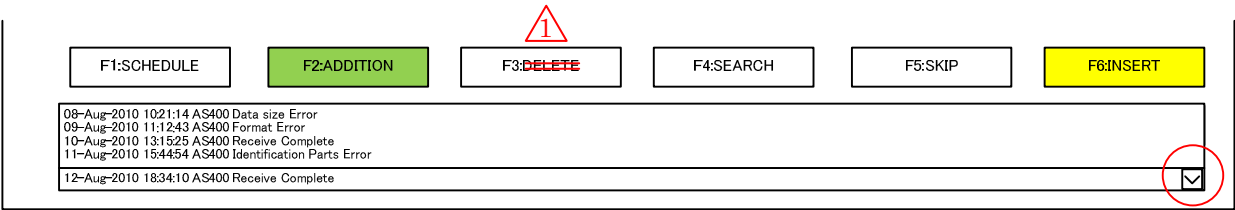
Displays latest error message.

B: Error message history display

Click the combo box to display a log of the last 30 error messages.

Contains a combination of information from the data communication log and log data from the host computer (AS400).

The message display function is the same for all screens.



< Figure1・2・2 >

□ F1 SCHEDULE

The scheduled production instruction data is displayed.

□ F2 ADDITION

Used to add schedules.

Select the appropriate line with the cursor and click the [F2: ADDITION] button.

PRODUCTION DATA

LINE No.	CONTROL CODE	Model Type	SEQ. No.	MODEL CODE			Lot	Unit	FRAME OFF DATE	BLOCK MODEL	BLOCK Seq.	PRODUCTION SEQ.	ASM PATS No. ISZ
				Year	Suffix Code								
1	1	2213244213	020	L377190	010	AB000	001	001	20100124	E1003001	001	001	8979453680
2	1	2213244213	020	L377191	010	AB000	001	002	20100124	E1003001	001	002	8979453680
3	1	2213244213	020	L377192	010	AB000	001	003	20100124	E1003001	001	003	8979453680
4	1	2213244213	020	L377193	010	AB000	001	004	20100124	E1003001	001	004	8979453680
5	1	2213244213	020	L377194	010	AB000	001	005	20100124	E1003001	001	005	8979453680
6	1	2213244213	020	L377195	010	AB000	002	001	20100124	E1003001	002	001	8979453680
7	1	2213244213	020	L377196	010	AB000	002	002	20100124	E1003001	002	002	8979453680
8	1	2213244213	020	L377197	010	AB000	002	003	20100124	E1003001	002	003	8979453680
9	1	2213244213	020	L377198	010	AB000	002	004	20100124	E1003001	002	004	8979453680
10	1	2213244213	020	L377199	010	AB000	002	005	20100124	E1003001	002	005	8979453680
11	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
12	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
13	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
14	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
15	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
16	1	1212121212	020	Y553881	010	CD001	001	001	20100124	D1004214	001	001	8979453110
17	1	1212121212	020	Y553882	010	CD001	001	002	20100124	D1004214	001	002	8979453110
18	1	1212121212	020	Y553883	010	CD001	001	003	20100124	D1004214	001	003	8979453110
19	1	1212121212	020	Y553884	010	CD001	001	004	20100124	D1004214	001	004	8979453110
20	1	1212121212	020	Y553885	010	CD001	001	005	20100124	D1004214	001	005	8979453110
21	1	1212121212	020	Y553886	010	CD001	002	001	20100124	D1004214	002	001	8979453110
22	1	1212121212	020	Y553887	010	CD001	002	002	20100124	D1004214	002	002	8979453110
23	1	1212121212	020	Y553888	010	CD001	002	003	20100124	D1004214	002	003	8979453110
24	1	1212121212	020	Y553889	010	CD001	002	004	20100124	D1004214	002	004	8979453110
25	1	1212121212	020	Y553890	010	CD001	002	005	20100124	D1004214	002	005	8979453110

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F1:SCHEDULE F2:ADDITION F3:DELETE F4:SEARCH F5:SKIP F6:INSERT

F7:PREVIOUS F8:NEXT F9:RELOAD F10: F11: F12:MENU

< Figure1・2・3 >

Clicking [F2 : ADDITION] will bring up the data editing screen shown in <Figure 1・2・4>.

MIX DATA

F1:MASS

Parts Select
☐ ALL

	LINE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
	No.	CODE	Type	No.	Year	Suffix Code			DATE	MODEL	Seq.	SEQ.	ISZ
1	1	2213244213	020	L377190	010	AB000	001	001	20100124	E1003001	001	001	8979453680
2	1	2213244213	020	L377191	010	AB000	001	002	20100124	E1003001	001	002	8979453680
3	1	2213244213	020	L377192	010	AB000	001	003	20100124	E1003001	001	003	8979453680
4	1	2213244213	020	L377193	010	AB000	001	004	20100124	E1003001	001	004	8979453680
5	1	2213244213	020	L377194	010	AB000	001	005	20100124	E1003001	001	005	8979453680
6	1	2213244213	020	L377195	010	AB000	002	001	20100124	E1003001	002	001	8979453680
7	1	2213244213	020	L377196	010	AB000	002	002	20100124	E1003001	002	002	8979453680
8	1	2213244213	020	L377197	010	AB000	002	003	20100124	E1003001	002	003	8979453680
9	1	2213244213	020	L377198	010	AB000	002	004	20100124	E1003001	002	004	8979453680
10	1	2213244213	020	L377199	010	AB000	002	005	20100124	E1003001	002	005	8979453680
11	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
12	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
13	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
14	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
15	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
16	1	2213244213	020	L377205	010	AB000	004	001	20100124	E1003001	004	001	8979453680
17	1	2213244213	020	L377206	010	AB000	004	002	20100124	E1003001	004	002	8979453680
18	1	2213244213	020	L377207	010	AB000	004	003	20100124	E1003001	004	003	8979453680

F1:MASS

F2:PILOT

F3:EMERGENCY

F4:SERVICE

F5:CSO

F6:_____

F7:_____

F8:_____

F9:_____


F10:UPDATE

F11:CANCEL

F12:MENU

< Figure1・2・4 >

One of the production instruction data that has divided into 5 pieces is selected.

- F1 : MASS
- F2 : PILOT
- F3 : EMERGENCY
- F4 : SERVICE
- F5 : CSO 

MIX DATA

F1:MASS

Parts Select
☐ ALL

	LINE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
	No.	CODE	Type	No.	Year	Suffix Code			DATE	MODEL	Seq.	SEQ.	ISZ
1	1	2213244213	020	L377190	010	AB000	001	001	20100124	E1003001	001	001	8979453680
2	1	2213244213	020	L377191	010	AB000	001	002	20100124	E1003001	001	002	8979453680
3	1	2213244213	020	L377192	010	AB000	001	003	20100124	E1003001	001	003	8979453680
4	1	2213244213	020	L377193	010	AB000	001	004	20100124	E1003001	001	004	8979453680
5	1	2213244213	020	L377194	010	AB000	001	005	20100124	E1003001	001	005	8979453680
6	1	2213244213	020	L377195	010	AB000	002	001	20100124	E1003001	002	001	8979453680
7	1	2213244213	020	L377196	010	AB000	002	002	20100124	E1003001	002	002	8979453680
8	1	2213244213	020	L377197	010	AB000	002	003	20100124	E1003001	002	003	8979453680
9	1	2213244213	020	L377198	010	AB000	002	004	20100124	E1003001	002	004	8979453680
10	1	2213244213	020	L377199	010	AB000	002	005	20100124	E1003001	002	005	8979453680
11	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
12	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
13	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
14	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
15	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
16	1	1212121212	020	Y553881	010	CD001	001	001	20100124	D1004214	001	001	8979453110
17	1	1212121212	020	Y553882	010	CD001	001	002	20100124	D1004214	001	002	8979453110
18	1	1212121212	020	Y553883	010	CD001	001	003	20100124	D1004214	001	003	8979453110

F1:MASS

F2:PILOT

F3:EMERGENCY

F4:SERVICE

F5:CSO

F6:_____

F7:_____

F8:_____

F9:_____

F10:UPDATE

F11:CANCEL

F12:MENU

< Figure1・2・5 >

Next, the data produced with the selected production instruction data is selected.

"ALL" is clicked when producing by the order of the received production instruction data.

Parts Select
☒ ALL

Clicking the [UPDATE] button will display the data list shown in < Figure1・2・6 >.

Use the cursor to select where you want to insert the data and click the [F1: INSERT] button to insert the data in that position.

ADDITION INSERT

	LINE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
	No.	CODE	Type	No.	Year	Suffix Code			DATE	MODEL	Seq.	SEQ.	ISZ
1	1	2213211213	020	L122001	010	BD000	001	001	20100123	E1002203	001	001	8979412340
2	1	2213211213	020	L122002	010	BD000	001	002	20100123	E1002203	001	002	8979412340
3	1	2213211213	020	L122003	010	BD000	001	003	20100123	E1002203	001	003	8979412340
4	1	2213211213	020	L122004	010	BD000	001	004	20100123	E1002203	001	004	8979412340
5	1	2213211213	020	L122005	010	BD000	001	005	20100123	E1002203	001	005	8979412340
6	1	2213211213	020	L122006	010	BD000	002	001	20100123	E1002203	002	001	8979412340
7	1	2213211213	020	L122007	010	BD000	002	002	20100123	E1002203	002	002	8979412340
8	1	2213211213	020	L122008	010	BD000	002	003	20100123	E1002203	002	003	8979412340
9	1	2213211213	020	L122009	010	BD000	002	004	20100123	E1002203	002	004	8979412340
10	1	2213211213	020	L122010	010	BD000	002	005	20100123	E1002203	002	005	8979412340
11	1	2213211213	020	L122011	010	BD000	003	001	20100123	E1002203	003	001	8979412340
12	1	2213211213	020	L122012	010	BD000	003	002	20100123	E1002203	003	002	8979412340
13	1	2213211213	020	L122013	010	BD000	003	003	20100123	E1002203	003	003	8979412340
14	1	2213211213	020	L122014	010	BD000	003	004	20100123	E1002203	003	004	8979412340
15	1	2213211213	020	L122015	010	BD000	003	005	20100123	E1002203	003	005	8979412340
16	1	2213211213	020	L122016	010	BD000	004	001	20100123	E1002203	001	001	8979412340
17	1	2213211213	020	L122017	010	BD000	004	002	20100123	E1002203	001	002	8979412340
18	1	2213211213	020	L122018	010	BD000	004	003	20100123	E1002203	001	003	8979412340
19	1	2213211213	020	L122019	010	BD000	004	004	20100123	E1002203	001	004	8979412340
20	1	2213211213	020	L122020	010	BD000	004	005	20100123	E1002203	001	005	8979412340
21	1	2213211213	020	L122021	010	BD000	005	001	20100123	E1002203	002	001	8979412340
22	1	2213211213	020	L122022	010	BD000	005	002	20100123	E1002203	002	002	8979412340
23	1	2213211213	020	L122023	010	BD000	005	003	20100123	E1002203	002	003	8979412340
24	1	2213211213	020	L122024	010	BD000	005	004	20100123	E1002203	002	004	8979412340
25	1	2213211213	020	L122025	010	BD000	005	005	20100123	E1002203	002	005	8979412340

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< Figure1・2・6 >

Once you have completed the INSERT process, the screen will return to the PRODUCTION DATA screen shown in < Figure1・2・1 >.

Data added using the ADDITION feature will be displayed in the PRODUCTION DATA screen in a different color.

<Figure1・2・7>において背景色が変更になっている部分が ADDITION 操作によって追加された部分になります。

PRODUCTION DATA

LINE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.	
				No.	Year								Suffix Code
1	1	2213211213	020	L122001	010	BD000	001	001	20100123	E1002203	001	001	8979412340
2	1	2213211213	020	L122002	010	BD000	001	002	20100123	E1002203	001	002	8979412340
3	1	2213211213	020	L122003	010	BD000	001	003	20100123	E1002203	001	003	8979412340
4	1	2213211213	020	L122004	010	BD000	001	004	20100123	E1002203	001	004	8979412340
5	1	2213211213	020	L122005	010	BD000	001	005	20100123	E1002203	001	005	8979412340
6	1	2213211213	020	L122006	010	BD000	002	001	20100123	E1002203	002	001	8979412340
7	1	2213211213	020	L122007	010	BD000	002	002	20100123	E1002203	002	002	8979412340
8	1	2213211213	020	L122008	010	BD000	002	003	20100123	E1002203	002	003	8979412340
9	1	2213211213	020	L122009	010	BD000	002	004	20100123	E1002203	002	004	8979412340
10	1	2213211213	020	L122010	010	BD000	002	005	20100123	E1002203	002	005	8979412340
11	1	2213244213	020	L377190	010	AB000	001	001	20100124	E1003001	001	001	8979453680
12	1	2213244213	020	L377191	010	AB000	001	002	20100124	E1003001	001	002	8979453680
13	1	2213244213	020	L377192	010	AB000	001	003	20100124	E1003001	001	003	8979453680
14	1	2213244213	020	L377193	010	AB000	001	004	20100124	E1003001	001	004	8979453680
15	1	2213244213	020	L377194	010	AB000	001	005	20100124	E1003001	001	005	8979453680
16	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
17	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
18	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
19	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
20	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
21	1	2213211213	020	L122011	010	BD000	003	001	20100123	E1002203	003	001	8979412340
22	1	2213211213	020	L122012	010	BD000	003	002	20100123	E1002203	003	002	8979412340
23	1	2213211213	020	L122013	010	BD000	003	003	20100123	E1002203	003	003	8979412340
24	1	2213211213	020	L122014	010	BD000	003	004	20100123	E1002203	003	004	8979412340
25	1	2213211213	020	L122015	010	BD000	003	005	20100123	E1002203	003	005	8979412340

A

F1:SCHEDULE F2:ADDITION F3:DELETE F4:SEARCH F5:SKIP F6:INSERT

F7:PREVIOUS F8:NEXT F9:RELOAD F10: F11: F12:MENU

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< Figure1・2・7 >

A : The color shown will depend on whether you selected ALL, CAB or PUBX in the ADDITION screen.

- F1 : MASS
- F2 : PILOT
- F3 : EMERGENCY
- F4 : SERVICE
- F5 : CSO

Caution: You cannot use the INSERT feature to insert data into an area with existing instructions.

□ F4 SEARCH

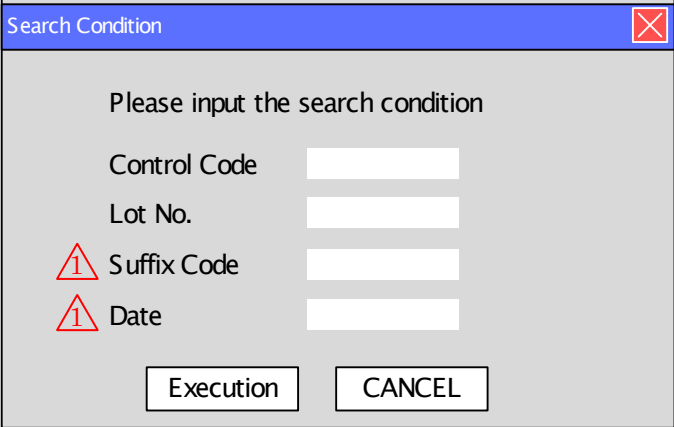
Used to search for specific data. (Enter the search conditions and click the Execution button) <Figure1·2·8>

The search key will be the MODEL CODE and the search results will be displayed in the data list shown in <Figure1·2·1>. Use the cursor to navigate around the search results.

Hold down the [EXECUTION] button to execute the search.

A warning message will be displayed if no data matches the search conditions.

Hold down the [CANCEL] button to return to the screen shown in <Figure1·2·1>.





Search Condition

Please input the search condition

Control Code

Lot No.

 Suffix Code

 Date

Execution CANCEL

< Figure1·2·8 >

If there is more than one, place your cursor on the first one.

□ F5 SKIP

Used to skip the production schedule.

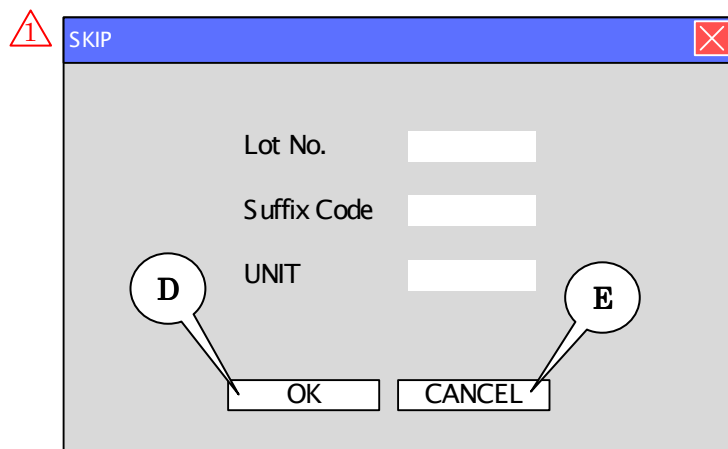
It is used to suspend production and extract items from the schedule.

Select items from the PRODUCTION DATA screen using the cursor and click the [F5: SKIP] button.

You can choose to skip items by lot or select a specific line from the list.

When choosing items by lot, the block you have selected will be displayed.

△ It is possible to skip by the lot unit, the unit of Suffix Code, and the unit of UNIT.



< Figure1・2・9 >

△ When D is pushed, the confirmation screen < Figure 1・2・11> of data is displayed.

Once this process is complete, the data you have selected to be skipped will be moved to the holding area and will be deleted from the PRODUCTION DATA list.

Only data for which work has not yet begun can be extracted.

It is necessary to check all lines, and if instructions have been issued to even one line it will not be possible to execute a SKIP.

All changes will be immediately reflected in the production schedule.

△ It returns to < Figure 1・2・1> when E is pushed.

CONFIRMATION OF SKIP DATA

LINE No.	CONTROL CODE	Model Type	SEQ. No.	MODEL CODE		Lot	Unit	FRAME OFF DATE	BLOCK MODEL	BLOCK Seq.	PRODUCTION SEQ.	ASM PATS No. EZ	
				Year	Suffix Code								
1	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
2	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
3	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
4	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
5	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													
16													
17													
18													
19													
20													
21													
22													
23													
24													
25													

OK

CANCEL

< Figure1・2・11 >

□ F6 INSERT

Used to insert a schedule from currently suspended list of schedules into the Production Data list.

As in the SKIP process, operators must check all lines to confirm that no work is in progress before inserting a schedule into the list.

SKIP DATA

F1:MASS

	LNE	CONTROL	Model	SEQ.	MODEL CODE	Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.	
	No.	CODE	Type	No.	Year	Suffix Code		DATE	MODEL	Seq.	SEQ.	ISZ	
1	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
2	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
3	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
4	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
5	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
6	1	2213211213	020	L122011	010	BD000	003	001	20100123	E1002203	003	001	8979412340
7	1	2213211213	020	L122012	010	BD000	003	002	20100123	E1002203	003	002	8979412340
8	1	2213211213	020	L122013	010	BD000	003	003	20100123	E1002203	003	003	8979412340
9	1	2213211213	020	L122014	010	BD000	003	004	20100123	E1002203	003	004	8979412340
10	1	2213211213	020	L122015	010	BD000	003	005	20100123	E1002203	003	005	8979412340
11													
12													
13													
14													
15													
16													
17													
18													

F1:MASS

F2:PILOT

F3:EMERGENCY

F4:SERVICE

F5:CSO

F6:_____

F7:_____

F8:_____

F9:DETELE

F10: OK

F11: CANCEL

F12:MENU

< Figure1・2・12>

F : DELETE

Used to delete a schedule from the SKIP holding area.

If a Lot No. /Part has been selected, the entire Lot will be deleted.

⚠ When “F:DELETE” is pushed, the confirmation screen < Figure 1・2・12> is displayed.

After "User Name" and "Password" are input and OK is pushed, data is deleted.

CONFIRMATION OF DELETE DATA

Do you delete data?

User Name

Password

OK

CANCEL

< 1・2・12>

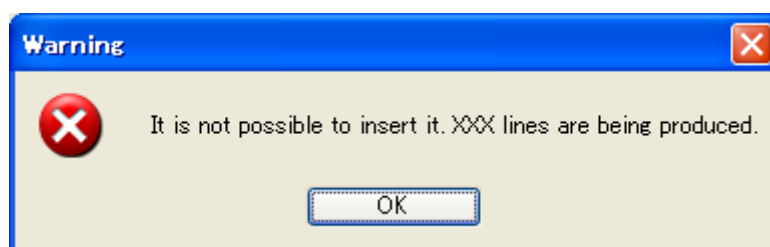
G : OK

Used to return data from the SKIP holding area back to the PRODUCTION DATA LIST shown in <Figure 1·2·1>. All data selected using the cursor will be returned to the list. If a Lot No. has been selected, the entire Lot will be returned to the list.

H : CANCEL

Used to cancel the request and return to the PRODUCTION DATA list shown in <Figure 1·2·1>.

As in the SKIP process, data may be inserted by selecting Lot No. Part or Selected Parts. Once this process is complete, the data you have selected will be deleted from the holding area. A warning message will be displayed when work is in progress. Changes will be immediately reflected on the shared SKIP/INSERT screen.



<Figure 1·2·13>

PRODUCTION DATA													
LINE	CONTROL	Model	SEQ.	MODEL CODE			Lot	Unit	FRAME OFF	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
No.	CODE	Type	No.	Year	Suffix Code			DATE	MODEL	Seq.	SEQ.	SEQ.	EZ
1	1	2213211213	020	L122001	010	BD000	001	001	20100123	E1002203	001	001	8979412340
2	1	2213211213	020	L122002	010	BD000	001	002	20100123	E1002203	001	002	8979412340
3	1	2213211213	020	L122003	010	BD000	001	003	20100123	E1002203	001	003	8979412340
4	1	2213211213	020	L122004	010	BD000	001	004	20100123	E1002203	001	004	8979412340
5	1	2213211213	020	L122005	010	BD000	001	005	20100123	E1002203	001	005	8979412340
6	1	2213211213	020	L122006	010	BD000	002	001	20100123	E1002203	002	001	8979412340
7	1	2213211213	020	L122007	010	BD000	002	002	20100123	E1002203	002	002	8979412340
8	1	2213211213	020	L122008	010	BD000	002	003	20100123	E1002203	002	003	8979412340
9	1	2213211213	020	L122009	010	BD000	002	004	20100123	E1002203	002	004	8979412340
10	1	2213211213	020	L122010	010	BD000	002	005	20100123	E1002203	002	005	8979412340
11	1	2213244213	020	L377190	010	AB000	001	001	20100124	E1003001	001	001	8979453680
12	1	2213244213	020	L377191	010	AB000	001	002	20100124	E1003001	001	002	8979453680
13	1	2213244213	020	L377192	010	AB000	001	003	20100124	E1003001	001	003	8979453680
14	1	2213244213	020	L377193	010	AB000	001	004	20100124	E1003001	001	004	8979453680
15	1	2213244213	020	L377194	010	AB000	001	005	20100124	E1003001	001	005	8979453680
16	1	2213244213	020	L377200	010	AB000	003	001	20100124	E1003001	003	001	8979453680
17	1	2213244213	020	L377201	010	AB000	003	002	20100124	E1003001	003	002	8979453680
18	1	2213244213	020	L377202	010	AB000	003	003	20100124	E1003001	003	003	8979453680
19	1	2213244213	020	L377203	010	AB000	003	004	20100124	E1003001	003	004	8979453680
20	1	2213244213	020	L377204	010	AB000	003	005	20100124	E1003001	003	005	8979453680
21	1	2213211213	020	L122011	010	BD000	003	001	20100123	E1002203	003	001	8979412340
22	1	2213211213	020	L122012	010	BD000	003	002	20100123	E1002203	003	002	8979412340
23	1	2213211213	020	L122013	010	BD000	003	003	20100123	E1002203	003	003	8979412340
24	1	2213211213	020	L122014	010	BD000	003	004	20100123	E1002203	003	004	8979412340
25	1	2213211213	020	L122015	010	BD000	003	005	20100123	E1002203	003	005	8979412340

F1:SCHEDULE

F7:PREVIOUS

F2:ADDITION

F8:NEXT

F3:DELETE

F9:RELOAD

F4:SEARCH

F10:_____

F5:SKIP

F11:_____

F6:INSERT

F12:MENU

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<Figure 1·2·15>

I: Schedules inserted from the holding area using the INSERT feature will be displayed in yellow.

Caution: When executing SKIP after ADDITION etc, it will be color coded in accordance with the last executed process.

□ F7 PREVIOUS

Used to display previous production data. (will scroll one page back to display the previous page)

□ F8 NEXT

Used to display the next page of production data. (will scroll one page forward to display the next page)

□ F9 RELOAD

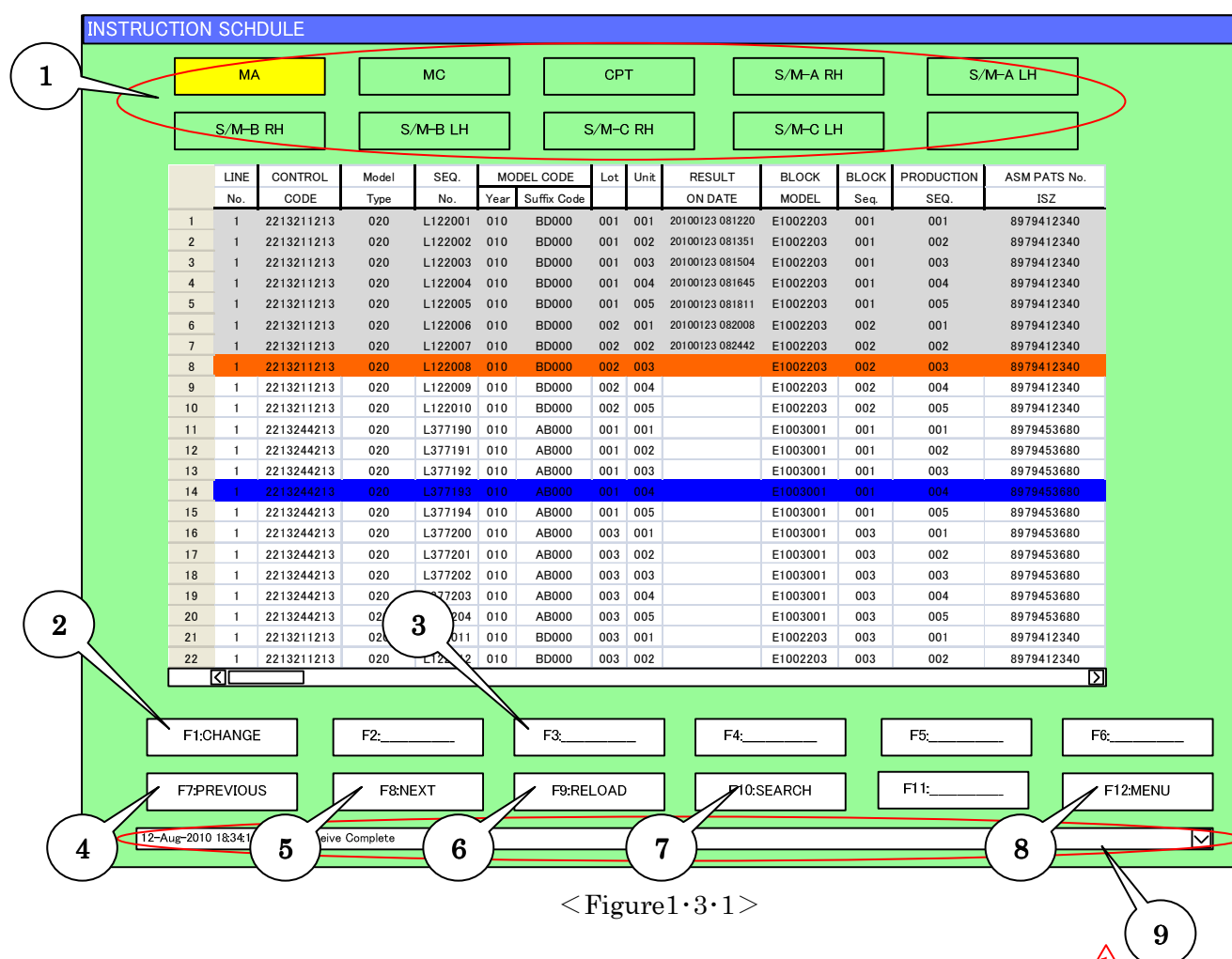
Used to rewrite data. (update to the latest data)

□ F12 MENU

It returns to the main menu screen.

1.2 F2: INSTRUCTION SCHEDULE

The schedule of the production instruction is displayed, and edited by the unit of the module line.



< Figure1·3·1 >

Result data (format: YYYY/MM/DD HH:mm:ss) displays the Weld ON / Line OFF time (registration).

Display directed data + ON / OFF Time.

Data is color coded as follows

Data (line) next in the schedule for production is colored in orange

The current position of the cursor is colored in blue

Data for which instructions have already been issued in colored in grey

The cursor can be moved by using the arrow keys.

The screen will display all the data in the database. The initial display will present data next in the schedule for production towards the center of the screen.

□ Module line selection

Used to select individual lines. The selected line will be displayed in yellow.

□ F1 CHANGE

Select a row and click the F1 button to move the pointer to that position.

(The current position of the cursor will be displayed in orange.)

When the pointer is moved down, rows between its initial and final position will be displayed in grey.

□ F3 EDIT

"EDIT" makes data to transmit results data to AS400 forcibly when the production results that production instructions system is "NO USE" are not recorded.

FLLOW SETTING

MA
MC
CPT
S/M-A RH
S/M-A LH

S/M-B RH
S/M-B LH
S/M-C RH
S/M-C LH

LINE No.	CONTROL CODE	Model Type	SEQ. No.	MODEL CODE			Lot	Unit	RESULT ON DATE	BLOCK MODEL	BLOCK Seq.	PRODUCTN SEQ.	ASM PATS No. SZ
				Year	Suffix Code								
1	2213211213	020	L122001	010	BD000	001	001	20100123 081220	E1002203	001	001	8979412340	
2	2213211213	020	L122002	010	BD000	001	002	20100123 081351	E1002203	001	002	8979412340	
3	2213211213	020	L122003	010	BD000	001	003		E1002203	001	003	8979412340	
4	2213211213	020	L122004	010	BD000	001	004		E1002203	001	004	8979412340	
5	2213211213	020	L122005	010	BD000	001	005		E1002203	001	005	8979412340	
6	2213211213	020	L122006	010	BD000	002	001		E1002203	002	001	8979412340	
7	2213211213	020	L122007	010	BD000	002	002	20100123 082442	E1002203	002	002	8979412340	
8	2213211213	020	L122008	010	BD000	002	003		E1002203	002	003	8979412340	
9	2213211213	020	L122009	010	BD000	002	004		E1002203	002	004	8979412340	
10	2213211213	020	L122010	010	BD000	002	005		E1002203	002	005	8979412340	
11	2213244213	020	L377190	010	AB000	001	001		E1003001	001	001	8979453680	
12	2213244213	020	L377191	010	AB000	001	002		E1003001	001	002	8979453680	
13	2213244213	020	L377192	010	AB000	001	003		E1003001	001	003	8979453680	
14	2213244213	020	L377193	010	AB000	001	004		E1003001	001	004	8979453680	
15	2213244213	020	L377194	010	AB000	001	005		E1003001	001	005	8979453680	
16	2213244213	020	L377200	010	AB000	003	001		E1003001	003	001	8979453680	
17	2213244213	020	L377201	010	AB000	003	002		E1003001	003	002	8979453680	
18	2213244213	020	L377202	010	AB000	003	003		E1003001	003	003	8979453680	
19	2213244213	020	L377203	010	AB000	003	004		E1003001	003	004	8979453680	
20	2213244213	020	L377204	010	AB000	003	005		E1003001	003	005	8979453680	
21	2213211213	020	L122011	010	BD000	003	001		E1002203	003	001	8979412340	
22	2213211213	020	L122012	010	BD000	003	002		E1002203	003	002	8979412340	

<
>

F1:CHANGE
F2:_____
F3:EDIT
F4:_____
F5:_____
F6:_____

F7:PREVIOUS
F8:NEXT
F9:RELOAD
F10:SEARCH
F11:_____
F12:MENU

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< Figure1・3・2 >

1)The range to put the turning on results data is selected.

2)F3:EDIT is pushed. < Figure1・3・3 > is displayed.

FLOW SETTING

A Module/Sub Line Name: MC



B Set Weld ON Date: ☒ 2010/1/23 08:15:00 Takt time: 00:01:34

Set LINE OFF Date: ☐ 2010/1/23 08:45:00 Takt time: 00:01:34

LINE No.	CONTROL CODE	Model Type	SEQ. No.	MODEL CODE Year	Suffix Code	Lot	Unit	RESULT ON DATE	BLOCK MODEL	BLOCK Seq.	PRODUCTION SEQ.	ASM PATS No. ISZ
1	1	2213211213	020	L122003	010	BD000	001	003	E1002203	001	003	8979412340
2	1	2213211213	020	L122004	010	BD000	001	004	E1002203	001	004	8979412340
3	1	2213211213	020	L122005	010	BD000	001	005	E1002203	001	005	8979412340
4	1	2213211213	020	L122006	010	BD000	002	001	E1002203	002	001	8979412340
5												
6												
7												
8												
9												
10												
11												
12												
13												
14												
15												
16												
17												
18												
19												
20												
21												
22												

C CONFIRMATION **D** OK **E** CANCEL

< Figure1・3・3 >

- A** Set Weld ON Date
Set the start time of Weld ON.
- B** Set **LINE** OFF Date (Only CPT Line) 
Set the start time of **LINE** OFF. 
- C** CONFIRMATION
Confirm RESULT ON / OFF DATE.
- D** OK
RESULT ON/ OFF DATE is decided.

	LINE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	RESULT	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
	No.	CODE	Type	No.	Year	Suffix Code			ON DATE	MODEL	Seq	SEQ.	ISZ
1	1	2213211213	020	L122003	010	BD000	001	003	20100123 081500	E1002203	001	003	8979412340
2	1	2213211213	020	L122004	010	BD000	001	004	20100123 081634	E1002203	001	004	8979412340
3	1	2213211213	020	L122005	010	BD000	001	005	20100123 081808	E1002203	001	005	8979412340
4	1	2213211213	020	L122006	010	BD000	002	001	20100123 081942	E1002203	002	001	8979412340

< Figure1・3・4 >

- E** CANCEL
Use the CANCEL button to return to the INSTRUCTION SCHEDULE.

- ☐ **F7 PREVIOUS**
Used to display previous production data. (will scroll one page back to display the previous page)
- ☐ **F8 NEXT**
Used to display the next page of production data. (will scroll one page forward to display the next page)
- ☐ **F9 RELOAD**
Used to rewrite data. (update to the latest data)
- ☐ **F10 SEARCH**
Used to search for specific data. (Enter the search conditions and click the Execution button)
A search dialogue box identical to that shown in <Figure 1·3·9> will open.
- ☐ **F12 MENU**
Used to return to the main menu.
- ☐ **Error message display window:**
Displays a log of the last 30 error messages.
- ☐ **Previous screen button**
Used to move to the previous screen. (moves to the screen displaying the remaining line data)
Displays line data from the top left.
- ☐ **Next screen button**
Used to move to the next screen. (moves to the screen displaying the remaining line data)
Displays line data from the top left.

Color Coding

Color coding on the PRODUCTION DATA screen

- ADDITION
- INSERT

Data that has been through the above processes will be appear color coded on the PRODUCTION DATA screen.

INSTRUCTION SCHEDULE

MA

MC

CPT

S/M-A RH

S/M-A LH

S/M-B RH

S/M-B LH

S/M-C RH

S/M-C LH

	LNE	CONTROL	Model	SEQ.	MODEL CODE		Lot	Unit	RESULT	BLOCK	BLOCK	PRODUCTION	ASM PATS No.
	No.	CODE	Type	No.	Year	Suffix Code			ON DATE	MODEL	Seq.	SEQ.	SZ
8	1	2213211213	020	L122007	010	BD000	002	002	20100123 082442	E1002203	002	002	8979412340
9	1	2213211213	020	L122008	010	BD000	002	003		E1002203	002	003	8979412340
10	1	2213211213	020	L122009	010	BD000	002	004		E1002203	002	004	8979412340
11	1	2213211213	020	L122010	010	BD000	002	005		E1002203	002	005	8979412340
12	1	2213244213	020	L377190	010	AB000	001	001		E1003001	001	001	8979453680
13	1	2213244213	020	L377191	010	AB000	001	002		E1003001	001	002	8979453680
14	1	2213244213	020	L377192	010	AB000	001	003		E1003001	001	003	8979453680
15	1	2213244213	020	L377193	010	AB000	001	004		E1003001	001	004	8979453680
16	1	2213244213	020	L377194	010	AB000	001	005		E1003001	001	005	8979453680
17	1	2213244213	020	L377190	010	AB000	001	001		E1003001	001	001	8979453680
18	1	2213244213	020	L377191	010	AB000	001	002		E1003001	001	002	8979453680
19	1	2213244213	020	L377192	010	AB000	001	003		E1003001	001	003	8979453680
20	1	2213244213	020	L377193	010	AB000	001	004		E1003001	001	004	8979453680
21	1	2213244213	020	L377194	010	AB000	001	005		E1003001	001	005	8979453680
22	1	2213211213	020	L122011	010	BD000	003	001		E1002203	003	001	8979412340
23	1	2213211213	020	L122012	010	BD000	003	002		E1002203	003	002	8979412340
24	1	2213211213	020	L122013	010	BD000	003	003		E1002203	003	003	8979412340
25	1	2213211213	020	L122014	010	BD000	003	004		E1002203	003	004	8979412340
26	1	2213211213	020	L122015	010	BD000	003	005		E1002203	003	005	8979412340
27	1	2213244213	020	L377200	010	AB000	003	001		E1003001	003	001	8979453680
28	1	2213244213	020	L377201	010	AB000	003	002		E1003001	003	002	8979453680
29	1	2213244213	020	L377202	010	AB000	003	003		E1003001	003	003	8979453680

F1:CHANGE

F2:_____

F3:EDIT

F4:_____

F5:_____

F6:_____

F7:PREVIOUS

F8:NEXT

F9:RELOAD

F10:SEARCH

F11:_____

F12:MENU

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< Figure1・3・5 >

1.3 F3:FLOW SETTING

The flow of the production order of each module line is decided.

PRDUCTION FLOW SETTING					
	Advance	Reverse	UNIT	BLOCK	
CPT	<input type="radio"/>	<input checked="" type="radio"/>	5	1	
M/A	<input checked="" type="radio"/>	<input type="radio"/>	5	1	
M/C	<input checked="" type="radio"/>	<input type="radio"/>	5	1	
S/M SUB A&C	<input type="radio"/>	<input checked="" type="radio"/>	5	1	
S/M SUB B	<input type="radio"/>	<input checked="" type="radio"/>	5	3	

Example

← Parts Flow

Advance	001	002	003	004	005	006	007	008	009	010	011	012	013	014	015
Reverse	005	004	003	002	001	010	009	008	007	006	015	014	013	012	011

1

2

3

< Figure1・4・1 >

A Selection

select "Advance" or "Reverse"



B UNIT

It produces by "How many quantity" and quantity is input.

C BLOCK

It produces by "How many Unit" and quantity of Unit is input.

☐ OK

Used to OK button to fixe.

☐ CANCEL

Used to CANCEL button to interrupt processing.

☐ MENU

Use the MENU button to return to the main menu.

1.4 F5: DATA LOG

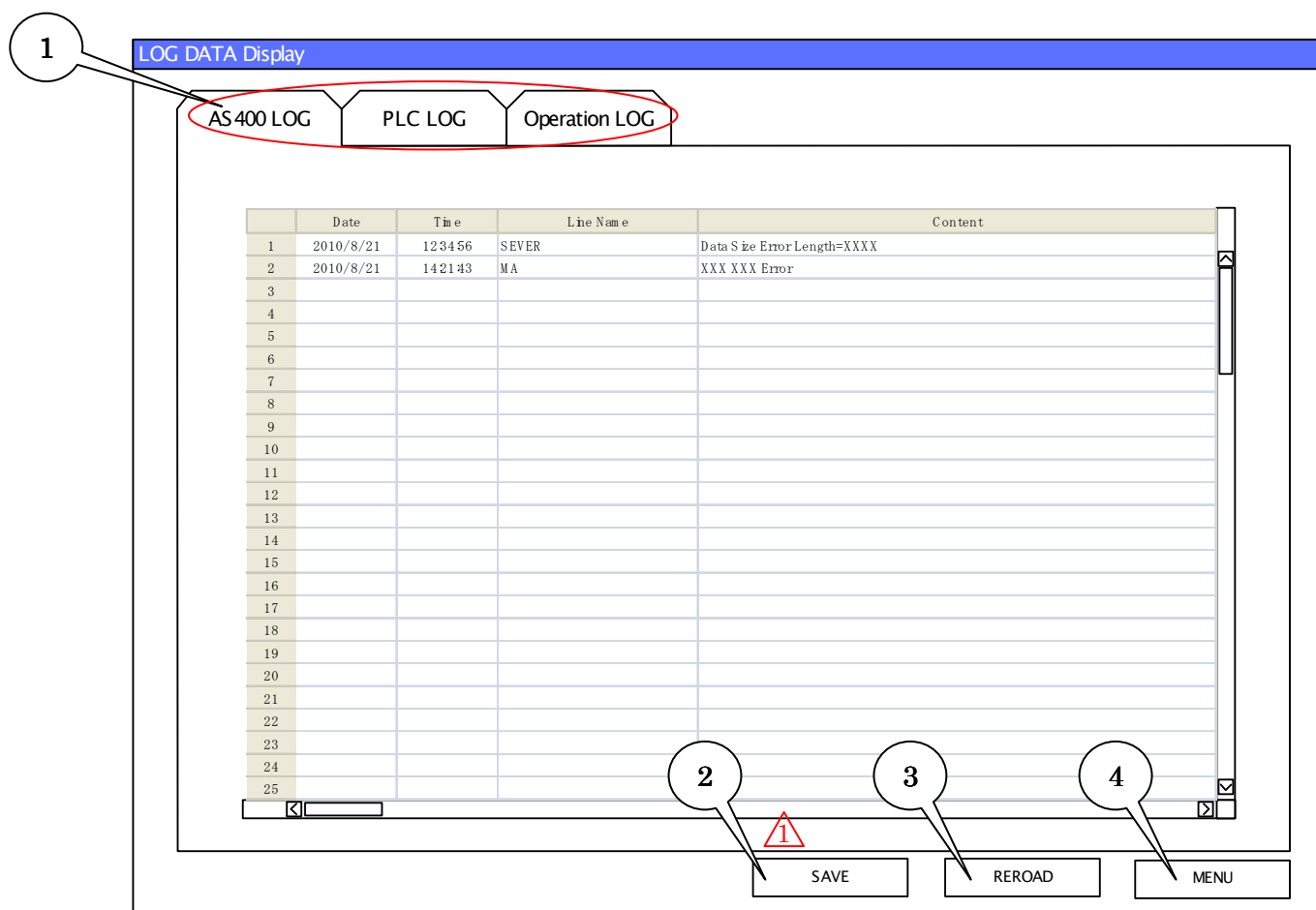
Used to display log data.

It is possible to display the following logs.

- AS400 LOG
- PLC LOG
- Operation LOG

Log data is stored in the database for 30 days. (can be changed using INI files)

The first log to be displayed is the AS400 LOG.



< Figure1・5・1 >

- Switching between log displays

Use the tabs to switch between the log displays.



- **SAVE**

Use the **SAVE** button to save log data.

- **RELOAD** (update)

Use the **RELOAD** button to obtain and display the latest log data.

- **CANCEL**

Use the **CANCEL** button to return to the main menu.

The data communication log allows you to view data sent from the host computer (AS400) and data sent to the PLC.

Data will be stored for a period of two weeks (default).

These settings can be changed using the INI files.

The AS400 data log will contain

- Date/time data was sent
- Name of the sent file
- Path (name of the path to the original data)
- OK/NG information
- Number of files sent

When you delete data from the log, the original data will also be deleted.

Caution: The AS400 data communication log will also record normally received data.

Figure 7.6.2 shows the PLC data communication LOG screen

Figure 7.6.3 shows the operation LOG screen

	Date	Time	LINE Name	Content
1	2010/06/01	12:34:56	SERVER	Net:XX Node:XX Unit:ΔΔ Time Out
2	2010/05/31	19:51:14	B/SIDE RH	Net:XX Node:XX Unit:ΔΔ Time Out
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				
22				
23				
24				
25				
26				

< Figure1・5・2 >

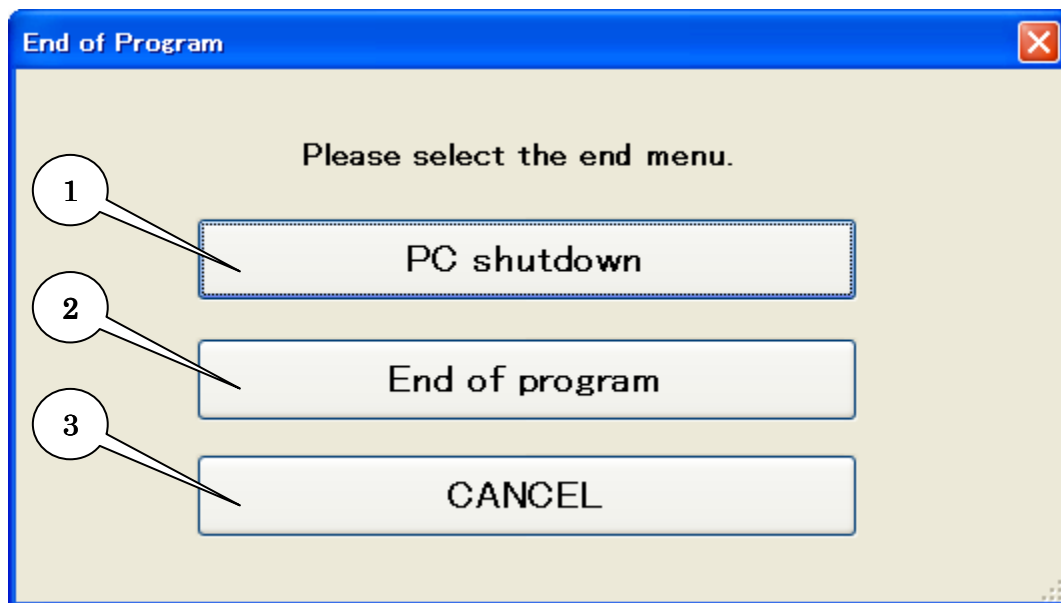
	Date	Time	PC No.	LINE Name	Content
1	2010/06/01	12:34:56	SERVER		F1 PRODUCTION DATA Screen
2	2010/05/31	19:51:14	Eng. ROOM		POINTER Changed
3	2010/05/31	19:51:00	Eng. ROOM		Value Changed OLD: 10→New: 12
4	2010/05/24	10:00:00	FLOOR		F3 DELETE Execution
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					
25					
26					

< Figure1・5・3 >

F12: SHUT DOWN

Used to shut down the program.

It is also possible to select to shut down the OS.



< Figure1・6・1 >

☐ PC shutdown

Used to shut down the program and turn off power to the computer terminal.

☐ End of program

Used to shut down the program.

☐ CANCEL

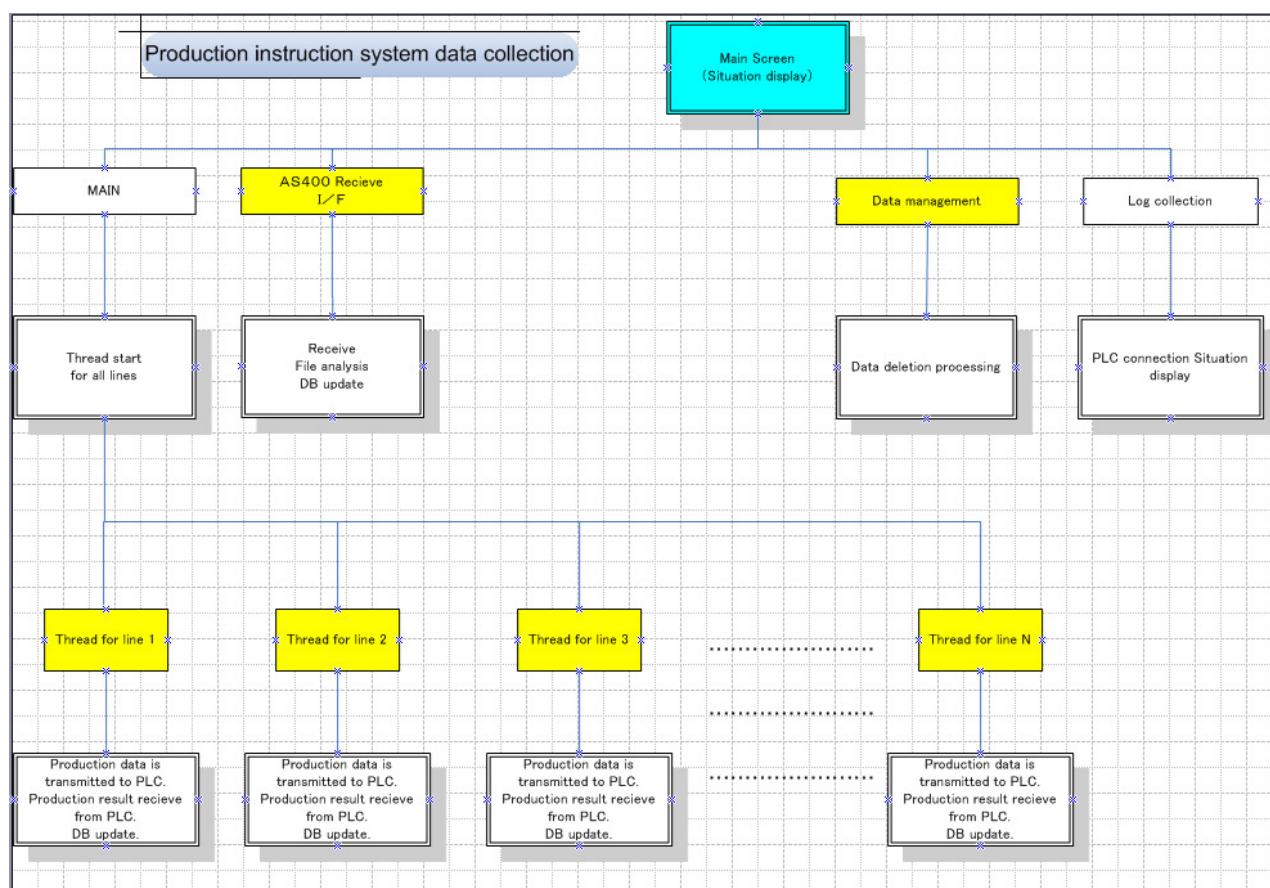
Used to return to the main menu.

2. Data Collection

The data collection program configuration is shown below.

2.1 Configuration

Divided primarily into the display screen and the data collection process.



< Figure2.1.1 >

Blue: Screen

Yellow: Thread

2.2 PLC Data Communication Area Map

Please refer to separate material.

2.3 Database Configuration

Data sent from the host computer (AS400) will be stored in the database.

Please refer to separate material for detailed information on the database.

2.4 Error Processing

A designated number of retries will be established for data delivery/receipt errors.

The number of retries can be changed using the INI files.

2.5 AS400 Data Receipt

Data will be stored in the database following receipt using HULFT software.

Received files will not be deleted and will be stored for a designated period.

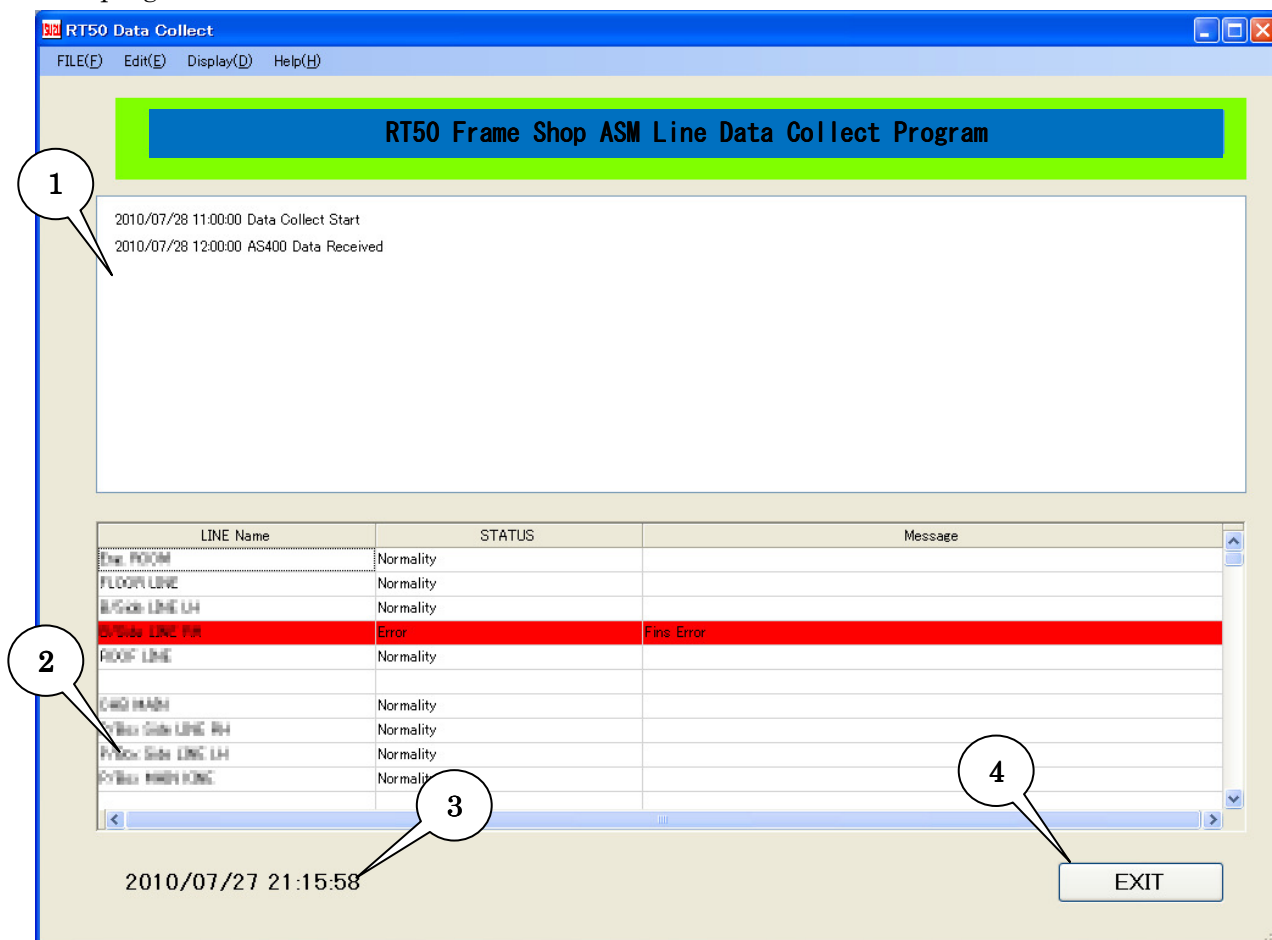
If the Lot No. + Unit + MODEL CODE are the same overwrite the data and rearrange the order of the data by Production Day + SEQ. No.

(Data will be displayed as Order by)

2.6 Data Collection Main Screen

The data collection screen is shown below.

This program is run on the server.



< Figure2.6.1 >

☐ Display Area

This area enables operators to check data that has been received from AS400 in real time. The maximum number of data that can be displayed in this area can be set in the INI files. (Default 200 lines of data)

☐ ASM LINE Connection Status

Enables operators to check the connection status of each line.

☐ Date/Time Display

Shows the current date and time.

☐ EXIT Button

Used to shut down the data collection program.