CSIFlex Syncing Service

List of files in ENET:

1. Mon Setup file: _SETUP\MonSetup.sys
2. Shift Setup file: _SETUP\ShiftSetup2.sys
3. Ehub Setup file: _SETUP\eHUBConf.sys
4. Monitoring list files: C:_eNETDNC_TMP\MonitorData05.SYS_

Mon Setup file: _SETUP\MonSetup.sys

- ON: represent machine observation status
  - 1 => Under observation and show it in front end
  - 0 => Disable and not show in front end
- NM: Reset counter on every shift change
  - 1 => Then reset part counter on shift change.
  - 2 => N/A?
  - 3 => Don't reset part counter
- IC: Cycle identifier to identify if its Min/Max or ideal
  - 0 => Min/Max (It means it have minimum value in CI & Max value in CA and the counter will be update when current cycle value is greater than Min value(CI)). What Max is doing?
  - 1 => Means it's ideal
    - Calculate percentage = (CI*CA)/100
    - Minimum = CI – percentage
    - Maximum = CI + percentage
    - If Minimum < 0 then set Minimum value = 0
    - CI => This is used to identify minimum or constant value depending upon IC
    - CA => This is used to identify maximum or + and - percentage depending upon IC
  - If On-> Off :
    - If Current Cycle is less than minimum then no change in Cycle count and Last Cycle Time
    - Else if Current Cycle is greater than or equal to minimum then update the Cycle count and Last Cycle Time.
  - Else
    - No change in Cycle count and Current Cycle Time

- DA: Department name
- MU: It's a multiplier (MU:A,B)
  - A => Multiplier like new part count = old part count + A
  - B => N/A

- MI: It is used to identify either Minutes (1) or Seconds (0) will use later.

Ehub Setup file: _SETUP\eHUBConf.sys

- First line is to identify machine number (1,1) => MonitorData00.SYS_ or (1,2) => MonitorData01.SYS_
- NM: Identify name of the machine (When name change NM field will change as well)

Shift Setup file: _SETUP\ShiftSetup2.sys

- Skip first line
- First is department name
- (a1, a2, a3,a4,a5,a6, a7, a8…….) {where a1,a2 is the numbers}
    - a1 -> a2 (one shift) { Sunday }
    - a3 -> a4 (2nd shift) { Sunday }
    - a5 -> a6 (3rd shift) {Sunday}
    - a7 -> a8 (1st shift) {Monday}
    - We have 3 shifts per day and It will keep going on

If shift change:

- Elapsed time will reset for all machines
- Cycle Count will be reset to zero if NM is 1 for that machine else if NM is 3 no change in Cycle Count for that machine.

Monitoring list files: C:_eNETDNC_TMP\MonitorData05.SYS_

Part number, status, elapsed time, current cycle, last cycle.

Part number:

1. If part number not exist: _PARTNO field is not there in the file.
2. If part number exist: _PARTNO field is there in the file.
    a. If _OPERATOR is not exist so we will take only _PARTNO and show it in front end.
    b. If _OPERATOR exist then we will show part number with operator id in the following format:
        i. PRT-001
            - 123

Status:

1. _CON, _COFF, _SETUP, MAINTENANCE, PROGRAM ERROR, TOOL BREAKAGE, OTHER FAILURE, NO SHIFT, NO MATERIAL, TOOL MISSING, NO PROGRAM
2. If status will go to _CON to _COFF then we need to update Cycle Count according to above logic like depend upon MU, CI & CA etc.

3. Ignore _DPrint_
4. We need save last status and semi last status to identify if part count needs to update. (I think we don't need it)

Elapsed time:

Elapsed time will only update if last date of the file will be change means it is only dependent upon the file (It will always change whenever there is new update in machine).

Elapsed time = Current date – Last updated date in the file.

Current Cycle:

- If status is changing from any status to _CON then (It will continuously run according to elapsed time)
    - Current cycle = Elapsed time
- Else
    - Current cycle = 0:0

Last Cycle:

- If status is changing from _CON to _COFF
    - Last Cycle = Elapsed time {Only if elapsed time is greater than Minimum(CI parameter)
- Else
    - Last Cycle will remain same.