

Helm Instrument Company, Inc. 361 West Dussel Drive Maumee, Ohio 43537 USA 419/ 893-4356 Fax: 419/ 893-1371 www.helminstrument.com

## **OPERATIONS MANUAL**



Revision 1.1 © Helm Instrument Co., Inc, 2005

#### DOWNTIME

JOB N/ NOI	AME Ne		PRES	ET: 0 ES: 2		operator Unknown			
	8	3/17/2	004 7:33:27	PM DOWNTIME: 8					
	RIAL	BAD	MATERIAL	MATERIA HANDLIN	iL G	WAITING FOR FORKLIFT			
MECHANI TROUBI	CAL LE	EL T	ECTRICAL ROUBLE	TOOL TROU	JBLE	OTHER			
CHANG GRIPPE BLOCK	iE iR S	BLO	CKS LOOSE	CHANGE BLC	DCKS	N	DT USED		
CHANGE [	DIES	LO	ose head	NO AIR PRES	SURE	N	ot used		
BREAK	BREAK LUNCH			MEETING	3	N	DT USED		
EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	SAGE	SUPERVISOR		

Report a DOWNTIME event by touching the green Reason Button containing the desired reason. This opens the DOWNTIME RESET panel. Touch the red RESET ALARM button to save this downtime event. Touch the grey CANCEL button to close the panel without saving the event.



Writes to Table: DOWNTIME



306 N	AME	_	PRES	ET: 0		OPERATOR			
No	ne		CYCL	ES: 2		Unk	Unknown		
	1	8/17/2	004 7:33:27	PM DOWNT	IME: 8	}			
NO MATERIAL BAD			MATERIAL	MATERIA HANDLIN	NL IG	WAITING FOR FORKLIFT			
MECHANI TROUB	ical Le	EL 1	ectrical Trouble	TOOL TROU	JBLE	OTHER			
CHANG GRIPPE BLOCK	ie ir is	BLO	CKS LOOSE	CHANGE BLO	жкя	N	ot used		
CHANGE I	DIES	LO	ose head	NO AIR PRES	SURE	N	DT USED		
BREAK		LUNCH	MEETIN	3	N	ot used			
EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	MESSAGE SUPERVI			

#### <u>JOB</u>

JOB N	AME		PRES	ET: 0		OPERATOR			
No	ne		CYCL	ES: 2		Unknown			
			8/17/2004	7:34:18 PM					
NO MATERIAL BAI			MATERIAL	MATERIA HANDLIN	L G	W FC	AITING FOR DRKLIFT		
MECHANI TROUB	CAL LE	EL 1	ECTRICAL TROUBLE	TOOL TROUBLE OTHE			DTHER		
CHANG GRIPPE BLOCK	ie ir S	BLO	icks loose	CHANGE BLC	ocks	N	)T USED		
CHANGE I	DIES	LO	ose head	NO AIR PRES	SURE	N	ot used		
BREAK	BREAK		LUNCH	MEETING	3	N	DT USED		
EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	SAGE	SUPERVISOR		

Touch the JOB NAME button to display the JOB SELECTION panel. Use ADD to create a job. Use DELETE to remove a job. Activate a job by choosing touching the desired job name and then touching SELECT. Touch the DONE button to close the panel.



					TES	T-2 H	INGE,	750				1	JOB NAME, PARTS-I TEST-1 BRACKET 800 TEST-2 HINGE,750
		ES	с	1	2		3	4		5	BKSP		
		CL	R	6	7		8	9	(	)	-		
		Q	w	E	R	Т	Y	U	Ι	0	Р		
		Α	S	D	F	G	н	J	К	L			
		Z	X	С	V	В	N	м	,				
RDD	$\rightarrow$			<	SPAC	E>				Ľ	NTER	$\rightarrow$	

		JOB NAM	E <mark>, PARTS</mark>	-PER-HOL	JR					
DELETE		ADD DE	LETE SEL	.ect do	NE					
	TEST-1 BRACKE	PRES	ET: 800	OPERATOR		XOR NAME TEST XOB #3		PRESET: 0		OPTRATOR JIM SHUE
		8/17/2004	7:34:18 PM	in Balande anderendin Frain Fra			8/17	/2004 7:34:18	3 PM	
	NO MATERIAL	BAD MATERIAL	MATERIAL HANDLING	WAITING FOR FORKLIFT		NO MATERIAL		TAG-1		WAITING FOR FORKLIFT
	MECHANICAL TROUBLE	ELECTRICAL TROUBLE	TOOL TROUBLE	OTHER		MECHANICAL TROUBLE		HEAT		OTHER
	CHANGE GRIPPER BLOCKS	BLOCKS LOOSE	CHANGE BLOCKS	NOT USED		CHANGE GRIPPER BLOCKS		HEAT-1		NOT USED
	CHANGE DIES	LOOSE HEAD	NO AIR PRESSURE	NOT USED		CHANGE DIES				NOT USED
SELECT	BREAK	LUNCH	MEETING	NOT USED		BREAK		SAVE RECORD		NOT USED
$\rightarrow$	EDIT COUR	NTER QUALITY	DOWNTIME MES	sage supervisor	$\rightarrow$		COUNTER	QUALITY	MESSAGE	SUPERVISOR

Writes to Table: JOBHISTORY

		JOB NAME None			PRES	ET: 0 ES: 2	OPERATOR Unknown		
					8/17/2004	7:34:18 PM			
			RIAL	BAD	AD MATERIAL MATERIA			W FC	AITING FOR DRKLIFT
		MECHANI TROUB	CAL LE	EL 1	ECTRICAL ROUBLE	TOOL TROU	JBLE	(	OTHER
		CHANG GRIPPE BLOCK	iE iR S	BLOCKS LOOSE		CHANGE BLO	ocks	N	DT USED
		CHANGE (	DIES	LO	LOOSE HEAD NO AIR P		SURE	JRE NOT USE	
		BREAK			LUNCH	MEETIN	3	N	ot used
DOINE	$\rightarrow$	EDIT COL		ITER	QUALITY	DOWNTIME ME		SSAGE SUPERVIS	

#### **OPERATOR**

JOB N/ Noi	AME Ne		PRES	ET: 0 ES: 2		operator Unknown			
			8/17/2004	7:34:18 PM					
	RIAL	BAD	MATERIAL	MATERIA HANDLIN	iL G	WAITING FOR FORKLIFT			
MECHANI TROUBI	CAL LE	EL T	ECTRICAL ROUBLE	TOOL TROU	JBLE	OTHER			
CHANG GRIPPE BLOCK	iE iR S	BLO	CKS LOOSE	CHANGE BLC	DCKS	N	)T USED		
CHANGE [	DIES	LO	ose head	NO AIR PRES	SURE	NOT USED			
BREAK	Break Lui		LUNCH	MEETING	3	N	DT USED		
EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	SAGE	SUPERVISOR		

Touch the OPERATOR button to display the OPERATOR SELECTION panel. Use ADD to enter a new operator name. Use DELETE to remove a name. Activate a new operator by choosing touching the desired name and then touching SELECT. Touch the DONE button to close the panel.







	JOB NAME None	PRES CYCL	ET: 0	OPERATOR BRAD
		8/17/2004	7:34:18 PM	
	NO MATERIAL	BAD MATERIAL	MATERIAL HANDLING	WAITING FOR FORKLIFT
	MECHANICAL TROUBLE	ELECTRICAL TROUBLE	TOOL TROUBLE	OTHER
	CHANGE GRIPPER BLOCKS	BLOCKS LOOSE	CHANGE BLOCKS	NOT USED
	CHANGE DIES	LOOSE HEAD	NO AIR PRESSURE	NOT USED
	BREAK	LUNCH	MEETING	NOT USED
$\rightarrow [$	EDIT COU	NTER QUALITY	DOWNTIME MES	SSAGE SUPERVISOR

	JOB N	AME		PRES	ET: 0		OPE	RATOR
	Noi	ne		CYCL	ES: 2		Unk	nown
				8/17/2004	7:34:18 P <b>M</b>			
		RIAL	BAD	MATERIAL	MATERIA HANDLIN	NL IG	W FC	AITING FOR DRKLIFT
	MECHANI TROUBI	MECHANICAL ELECTRICAL TROUBLE TROUBLE				JBLE	0	OTHER
	CHANG GRIPPE BLOCK	ie ir S	BLO	CKS LOOSE	CHANGE BLC	DCKS	N	ot used
	CHANGE [	DIES	LO	ose head	NO AIR PRES	SURE	N	ot used
	BREAK	(		LUNCH	MEETING	3	N	DT USED
$\rightarrow$	EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	SAGE	SUPERVISOR

## <u>COUNTER</u>

Touch the COUNTER button to display or hide the COUNTER panel.



Use the "<" button to decrease the Cycles Counter when desired.

	23751	
<	$\rightarrow$	23750

Touching RESET zeros the Parts Counter and clears all CURRENT values.



## <u>QUALITY</u>

Touch the QUALITY button to display or hide the Quality Panel.



Touch the BOLT TYPE list to select a bolt name.

BOLT TYPE ONE	•		BOLT TYPE ONE	-
BOLT TYPE TWO			BOLT TYPE TWO	
BOLT TYPE THREE			Bolt type three	
BOLT TYPE FOUR			BOLT TYPE FOUR	
BOLT TYPE FIVE			BOLT TYPE FIVE	
BOLT TYPE SIX			BOLT TYPE SIX	
BOLT TYPE SEVEN			BOLT TYPE SEVEN	
BOLT TYPE EIGHT			BOLT TYPE EIGHT	
BOLT TYPE NINE	-	$\neg$	BOLT TYPE NINE	-

Touching a QUALITY button clears its value.



Use the KEYPAD to enter a new Quality Value.



The SAVE RECORD button will record the Quality Record if all values have been entered. You must complete all quality fields and select a Bolt Type.

	JOB NAME		PRES	T: 0		OPERATO	DR	
	None		CYCL	.ES: 2		Unknown		
		8/17/2004 7:34:18 PM						
	NO MATERIAL	BAD MATERIAL		MATERIAL HANDLING		WAIT FOR FORKL	ING ₹ .IFT	
	MECHANICAL TROUBLE	ELECTRICAL TROUBLE		TOOL TROUBLE		OTH	ER	
	CHANGE GRIPPER BLOCKS	BLOCKS LOOSE		CHANGE BLC	оскя	NOT U	ISED	
	CHANGE DIES	LOOSE HEAD		NO AIR PRESSURE		NOT U	ISED	
	BREAK		LUNCH	MEETING		NOT USED		
$\rightarrow$	EDIT COUN	ITER	QUALITY	DOWNTIME	MES	SAGE SUP	PERVISOR	

#### THREADER

JOB NAME			PR	ESET: 0	SET: 0		OPERATOR			
TEST JOB #3			CY	CLES: 2			JIM SHUE			
		8/17/	/200	4 7:34:18	3 PM					
<u>TAG</u>		BOL	т	40	0					
TAG-1		LENG	TH	40	.0		7	8	9	
HEAT		THRE GAU	AD Ge	1.2	22					
HEAT-1		THRE	AD		-	-1	4	5	0	
BOLT_TYPE		LENG	TH	12	.5		1	2	3	
BOLT TYPE ONE		TIP S	IZE	1.4	44		-			
BOLT TYPE TWO		MIDD	IE		-	0		CLR		
BOLT TYPE FOUR BOLT TYPE FIVE		SIZI	E	1.4	43					
Bolt type six Bolt type seven Bolt type eight	-	BAC SIZI	K E	1.	.5		SAV	'E REC	ORD	
	cou	NTER	Q	JALITY	MESS	SAGE		SUPE	ERVISOR	

SHEAR

# Portal Downtime System

JOB NAME		PRESET: 0		OF	ERATOR	ł
TEST JOB #3		CYCLES: 2		JIC	M SHUE	
	8/17,	/2004 7:34:1				
TAG	BOL	T 1	<b>_</b>			
TAG-1	LENG	тн 1	.5	7	8	9
HEAT						
HEAT-1				4	5	6
BOLT TYPE				1	2	3
BOLT TYPE ONE BOLT TYPE TWO BOLT TYPE THREE BOLT TYPE FOUR	<u>^</u>			0		CLR
Bolt type five Bolt type six Bolt type seven Bolt type eight	<b>▼</b>			SAV	E RECO	ORD
	COUNTER	QUALITY	MESSAGE		SUPE	RVISOR

#### MESSAGE

Touch the MESSAGE button to display or hide the Message Panel. The MESSAGE button will turn BROWN when a new message has been received. A new message is displayed at the top of the panel and recent messages are shown in on the lower display.



#### Touch the NEW MESSAGE to acknowledge it and move it to the list box.



### EDIT DOWNTIME REASONS

	JOB N/ NOI	AME Ne		PRESI	ET: 0 ES: 2			RATOR NOWN
				8/17/2004	7:34:33 PM			
		RIAL	BAD MATERIAL		MATERIAL HANDLING		W FC	AITING FOR DRKLIFT
	MECHANI TROUB	CAL LE	EL 1	ECTRICAL TROUBLE	TOOL TROL	JBLE	C	OTHER
	CHANG GRIPPE BLOCK	iE iR S	BLO	CKS LOOSE	CHANGE BLC	DCKS	NC	DT USED
	CHANGE [	DIES	LOOSE HEAD		NO AIR PRESSURE		NOT USED	
	BREAK	BREAK		LUNCH	MEETING	3	NC	DT USED
$\vdash^{\text{EDIT}} \rightarrow$	EDIT			QUALITY	DOWNTIME	MES	SAGE	SUPERVISOR

Touching the EDIT button, when visible, locks all other buttons, turns the DOWNTIME REASON blue and allows you to edit the reasons.



Touch a blue downtime button to open the keyboard and enter the new reason.

## SUPERVISOR KEYPAD

JOB N/	<b>ME</b>		PRES	ET: 0		OPERATOR				
Nor	ne		CYCL	ES: 0	RAD					
			8/17/2004	7:47:50 PM						
	RIAL	BAD	MATERIAL	MATERIA HANDLIN	IG	7	8	9		
MECHANI TROUBI	CAL _E	EL	ECTRICAL ROUBLE	TOOL TROU	JBLE	4	5	6		
CHANG GRIPPE BLOCK	E R S	BLO	CKS LOOSE	CHANGE BLC	оск:	1	2	3		
CHANGE [	DIES	LO	ose head	NO AIR PRES	SUR	0		CLR		
BREAK			LUNCH	MEETING	G		ESC			
EDIT	COUN	ITER	QUALITY	DOWNTIME	MES	SAGE	SUPE	RVISOR		

#### **CLEAN SCREEN**

					CLEAN SCREEN FOR 27 SECONDS
0	0	0	0	$\rightarrow$	

Touch four zeros on the SUPERVISOR KEYPAD to open the CLEAN SCREEN panel. This disables the Touch Screen and allows you to wipe off the screen without pressing any buttons.

### **SUPERVISOR**







This is the number of cycles to break on for a quality

check.

## **Portal Downtime System**



## PORTPal: MAIN SCREEN

PortPAL Portal	Monitor				
		PRESS01	UNIT: P(	DRTAL	SHEAR
			OB / BADGE:	LDTEST	JIM SHUE
			DATE:	72000 7:32:49 PM TED: 1/1/2000 6:26:00	PPH: 50 P 1/1/2000 6:26:00 P
		FIFTEEN	AVAILABLE HO	URS: 44585.07	44585.07
			ACTUAL CYC	LES:7	7
			CYCLES / H	OUR: 0.00	0.00
	- TWENTY- TWEN		X EFFICIE	NCY: 0.00 %	0.00 %
			DOWN	TME: <u>37</u>	37
Badge Heat JIM SHUE HEAT-1	Job RecordDate T OLDTEST 1/1/2000 7:29 T.	ag Unit AG-1 PORTAL	UnitType Weight SHEAR 2000		
	_	_	_		
SETUP	JOB	MESSAGE	QUALITY	DOWNTIME	END
PORTAL					
				<u>^</u>	
	Juit is AC	IIVE and	RUININ	J.	
PORTAL					
	Jnit is AC⁻	<b>FIVE</b> and	DOWN.		
PORTAL					
· On · · ·					
	Jnit is beir	ng POLLE	D for stat	tus.	
PORTAL					
	Init is OFF			=	
				-	
DODTE					
PURTAL					
(	Communic	ation has	encounte	ered an E	RROR.

PORTAL

Unit's CYCLE COUNT >= to 95% of BATCH PRESET. PORTPal: JOB HISTORY

		PortPAL Po	rtal Monit	tor					
				REE		PRESS01			SHEAR JIM SHUE
		SIX SE	EVEN EIG	iht N		TEN polling	DATE: 1	/1/2000 7:32:49 PM	PPH: 60
				IRTEE FI		FIFTEEN	AVAILABLE F ACTUAL C	OURS: 44585.07 ACLES: 7	44585.07
							CYCLES /	HOUR: 0.00	0.00
						TWENTY- FIVE	× EFFIC DOW	IENCY: 0.00 %	0.00 %
		Badge Heat JIM SHUE HEAT-	Job 1 OLDTEST	Record Da 1/1/2000 7	ite Tag :29 TAG-1	Unit	UnitType Weight SHEAR 2000		
JOB	$\rightarrow$	SETUP		JOB	r	MESSAGE	QUALITY	DOWNTIME	END

PORTPal: QUALITY

		PortPAL	PortPAL Portal Monitor							
		ONE		THREE	FOUR	PRESSO1		OLDTEST	SHEAR JIM SHU	
		SIX	SEVEN	EIGHT		TEN	DATE:	1/1/2000 7:33:49 PM ARTED: 1/1/2000 6:265	PPF	4: 60 6:26:00 P
		ELEVEN			FOURTEE N	FIFTEEN pollin	AVAILABLE ACTUAL (	HOURS: 44585.08 YCLES: 7	445	85.08
		SIXTEEN	SEVENTE EN	EIGHTEE N	NINE TEE N		CYCLES	HOUR: 0,00		584.46
		TWENTY- ONE	TWENTY-		TWENTY-	TWENTY- FIVE	¥ EFFI DOY	OLENCY: 0.00 %		37
		Badge	BoltType Hea	t Job	QC1	QC2	QC3 QC4	QC5 QC6	RecordDa 7 S	hift Tag
		JIM SHUE	BOLT TYPE R2	OLDT	EST 123.4	0	0 0	0 0	1/1/2000 6:50 2	R1
	_	•								Þ
QUALITY	$\rightarrow$	SETU	P	JOB		MESSAGE	QUALITY	DOWNTIME	6	IND

PORTPal: DOWNTIME

		PortPAL I	Portal Me	onitor							
			PORTALpolling	THREE	FOUR	PRESSO1	UNIT:			SHEAR JIM SHUE	
		six	SEVEN	EIGHT	NINE	TEN	DATE:	1/1/2000 7:34:1 TARTED: 1/1/20	0 PM 00 6:26:00 P	РРН: 1/1/2000	60 6:26:00 P
		ELEVEN	TWELVE	THIRTEE N	FOURTEE N	FIFTEEN	AVAILABLE	HOURS: 4	4585.08 7	4458	5.08
		SIXTEEN	SEVENTE EN	EIGHTEE N	NINE TEE N		CYCLE	: 7 HOUR:4	0.00	0.0 44,58	34.46
			TWENTY- TWO		TWENTY-	TWENTY-	X EFF DO		0.00 % 37	0.00	) % <b>* * *</b>
		Badge	Description	Downtime	Heat	Job	Notes	RecordDate 🖓	Shift	Tag	Unit
		JIM SHUE	CHANGE MAT	TER 37	R2	OLDTE	ST	1/1/2000 7:28:56	2	R1	PORTA
		JIM SHUE	QA HOLD: CO	SM 0	R2	OLDTE	ST	1/1/2000 6:51:16	2	R1	PORTA
DOLUSITISAE		1									Þ
DOMME	$\rightarrow$	SETUP		JOB		MESSAGE	QUALITY	DOWNI	IME	EM	ND

### PORTPal: MESSAGE DISPLAY

		POPTPAL I	Portal Mi	onitor					
				THREE	FOUR	PRESS01		ORTAL	SHEAR
							JOB / BADGE:	OLDTEST	JIM SHUE
		six	SEVEN	EIGHT		TEN		/1/2000 7:33:32 PM	PPH: <u>60</u>
			TWEINE	TUIDICC			DATE SIA	ALED: 1/1/2000 6:26:00	P 1/1/2000 6:26:00 P
		ELEVEN		N E	N		AVAILABLE H	OURS: 44585.07	44585.07
							ACTUAL CI	CLES: 7	7
		SIXTEEN	SEVENTE EN			TWENTY	CYCLES /	HOUR: 0.00	0.00
							ACTUAL H	OURS: 44,584.45	44,584.45
					TWENTY-		X EFFIC	IENCY: 0,00 %	0.00 %
					polling		DOW	ITTIME: <u>37</u>	37
		ENTER NEW	V MESSAGE						
									SEND
		RECENT ME	SSAGES						SEND MESSAGE
		RECENT ME	SSAGES						SEND MESSAGE
		RECENT ME Message TEST MESSAG	E						SEND MESSAGE
		RECENT ME Message TEST MESSAG 2/1/2005 10:29: 2/1/2005 10:46:	E E 42 AM SWAGEF	R-1: test					SEND MESSAGE
		RECENT ME Message TEST MESSAG 2/1/2005 10:29: 2/1/2005 10:46:	E E A2 AM SWAGEF 33 AM PORTAL:	R-1: test : TEST					SEND MESSAGE
		RECENT ME Message TEST MESSAG 2/1/2005 10:29: 2/1/2005 10:46:	E E AM SWAGEF 33 AM PORTAL	R-1: test : TEST					SEND MESSAGE
		RECENT ME Message TEST MESSAG 2/1/2005 10:49: 2/1/2005 10:46:	E E 22 AM SWAGEF 33 AM PORTAL:	3-1: test TEST					MESSAGE
		RECENT ME Message TEST MESSAG 2/1/2005 10:29: 2/1/2005 10:46:	E E 42 AM SWAGEF 33 AM PORTAL	R-1: test : TEST					SEND MESSAGE
MESSAGE		RECENT ME Message TEST MESSAg 2/1/2005 10:29: 2/1/2005 10:46:	E E 42 AM SWAQEF 33 AM PORTAL:	R-1: test : TEST					SEND MESSAGE
MESSAGE	$\rightarrow$	RECENT ME Message TEST MESSAG 2//2005 10:29: 2//2005 10:46:	E E 42 AM SWAGER 33 AM PORTAL	R-1: test : TEST JOB		MESSAGE	QUALITY	DOWNTIME	SEND MESSAGE

## Click on the Unit to send a message to.

Click on the Message Panel and type in the desired message.



	P	PortPAL Po	rtal Moni	tor							
		UNIT ID -		SHIF	r ———		JOB				
		1 1	ACTIVE	1 5:0	00:00 AM	1:00:00 PM	Job				Par 🔺
		<u>⊥</u> -		2 1:0	00:00 PM	9:00:00PM	TEST 10	)-1			10
		NETW	ORK NAME	3 9:0	00:00 PM 🗧	4:00:00 AM	TEST 1-	1			10
		KYCE5W01		4 4:0	00:00 AM	5:00:00 AM	TEST 1-	2			10
		UN	IT NAME	5 5:0	00:00 AM	5:00:00 AM	TEST2-	1			20
		PORTAL		6 5:	JU:UU AM	5:00:00 AM	TEST2-	2			20
		DOWNTIME	REASONS			_	TEST3-	1			10
		DIE SETUP				SAVE	TEST3-	2			20
				1			TEST4-	1			10
		DIE SETUP	DIE RESET	AL QC AT	NO PACKER	OPERATO	TESTA.	2			20-
	Ī			LAB	AVAILABLE	AVAILABL					
	1	NO	RAW - COIL	RAW -	RAW -	SCRAP	BADGE	OPERA	TOR		
	1	AVAILABLE	CHANGE	DEREELER	FLATNESS)	DUMP	Badge				Descrip
			OBTAIN	i	TR:	TR: SENSC					OPER
		PACKAGING RESTOCK	ORDER,	MEETING	DIMENSION	IN-PRESS	JOHN J	OHNSON	1		MAIN
			LADELD, GL		AL IN-PRES	AUJUST	KEVIN	<ramer< th=""><th></th><th></th><th>OPER</th></ramer<>			OPER
		TR: BURR IN-PRESS	TR: TOOL MAKER	QA: DIMENSION	QA: COSMETIC	OA: OTHER					_
		ADJUST	PRESS CALL	AL ISSUE	OR VISUAL	Ľ	1				Þ
		MAINT:	MAINT:	ENGINEERI	PRESS	SUPERVIS	2				
		PRESS	FEEDER	NG HOLD	DOWN - SAFETY	R HOLD	UPC	ATE	CANCEL	D	ONE
CETUD						_					
SETUP	$\rightarrow$	SETUP		JOB	MESSA	GE	QUALITY	D	DWNTIME		END



Select the unit by number. Name it or provide an IP

address. Toggle polling.



Edit shift times.

-DOWNTIME REASONS										
DIE SETUP				SAVE						
DIE SETUP	DIE RESET	DIMENSION AL QC AT LAB	NO PACKER AVAILABLE	NO OPERATOR AVAILABLE						
NO MATERIAL AVAILABLE	RAW - COIL CHANGE	RAW - LOAD DEREELER	RAW - DEBUG (I.E. FLATNESS)	SCRAP SWAP OR DUMP						
PACKAGING RESTOCK	OBTAIN ORDER, LABELS, GL	MEETING	TR: DIMENSION AL IN-PRES	TR: SENSOR IN-PRESS ADJUST						
TR: BURR IN-PRESS ADJUST	TR: TOOL MAKER PRESS CALL	QA: DIMENSION AL ISSUE	QA: COSMETIC OR VISUAL	QA: OTHER						
MAINT: PRESS	MAINT: FEEDER	ENGINEERI NG HOLD	PRESS DOWN - SAFETY	SUPERVISO R HOLD						

JOB	
Job	Par 🔺
TEST 10-1	10
TEST 1-1	10
TEST 1-2	10
TEST2-1	20
TEST2-2	20
TEST3-1	10
TEST3-2	20
TEST4-1	10
TEST4-0	20-
<	•

Set up Jobs for download to each units.

BADGE / OPERATOR	1	
Badge		Descrip
JIM SHUE		OPER
JOHN JOHNSON		MAIN
KEVIN KRAMER		OPER
•		Þ

List operators for each unit.

UPDATE

Commit pending changes.

Edit downtime reasons.

## **Portal Downtime System**



## PORTAL DOWNTIME CONNECTIONS



#### PORTAL DATABASE STRUCTURE

#### Table: BADGE - Operator's Name by Unit

Name	Туре	Size
Badge	Text	<u>50</u>
<u>UnitName</u>	Text	<u>50</u>
Description	Text	<u>255</u>

#### Table: DOWNTIME – Events recorded by Date & Time

Name	Туре	Size
RecordDate	Text	25
Downtime	Long Integer	4
Description	Text	255
Job	Text	<u>50</u>
<u>Unit</u>	Text	<u>35</u>
<u>UnitType</u>	Text	<u>50</u>
<u>Badge</u>	Text	<u>35</u>
Notes	Text	<u>255</u>
<u>Shift</u>	Integer	<u>2</u>
<u>Tag</u>	Text	<u>50</u>
Heat	Text	50

#### Table: DOWNTIMEREASONS - Maintenance table or uploading event reasons to a Unit

Name	Туре	Size
Reason	Integer	2
Description	Text	255

#### Table: JOB - Tabled by Unit Name, this data is uploaded to each unit.

Name	Туре	Size
Job	Text	<u>50</u>
<u>UnitName</u>	Text	<u>50</u>
<u>PPH</u>	Long Integer	<u>4</u>
<u>PartsToRun</u>	Long Integer	<u>4</u>

#### <u>**Table: JOBHISTORY**</u> – <u>Recorded by date & time, contains records of each job change or</u> material change.

Name	Туре	Size
RecordDate	Text	<u>50</u>
<u>Job</u>	Text	<u>50</u>
<u>Badge</u>	Text	<u>35</u>
<u>Unit</u>	Text	<u>50</u>
<u>UnitType</u>	Text	<u>50</u>
Tag	Text	<u>50</u>
Heat	Text	<u>50</u>
<u>Weight</u>	<u>Single</u>	<u>4</u>
Table: MESSAGE - Logs message	es sent to the Units	
Name	Туре	Size
Message	Text	<u>255</u>

<u>Table: QUALITY</u> – Logs quality information. When a unit reaches a preset cycle count, the unit stops and requires a quality record entry. Operators may also enter a quality record at any time. The QC values are defined by unit type.

Name	Туре	Size
RecordDate	<u>Text</u>	<u>25</u>
<u>Unit</u>	<u>Text</u>	<u>35</u>
<u>UnitType</u>	Text	<u>50</u>
Job	Text	<u>50</u>
Badge	<u>Text</u>	<u>50</u>
Shift	<u>Integer</u>	<u>2</u>
Tag	<u>Text</u>	<u>50</u>
Heat	<u>Text</u>	<u>50</u>
BoltType	<u>Text</u>	<u>50</u>
<u>QC1</u>	<u>Single</u>	<u>4</u>
QC2	<u>Single</u>	<u>4</u>
QC3	<u>Single</u>	<u>4</u>
<u>QC4</u>	<u>Single</u>	<u>4</u>
<u>QC5</u>	<u>Single</u>	<u>4</u>
<u>QC6</u>	<u>Single</u>	<u>4</u>

#### <u>SHEAR</u>

<u>QC1 – SHEAR LENGTH</u>

QC2 - BACKCUT

#### SWAGER

QC1 - SWEDGE LENGTH QC2 - TIP QC3 - MIDDLE QC4 - BACK QC5 - BOLT LENGTH

#### **THREADER**

<u>QC1 - BOLT LENGTH</u>
QC2 - THREAD GAUGE
QC3 - THREAD LENGTH
<u>QC4 - TIP SIZE</u>
<u>QC5 - MIDDLE SIZE</u>
QC6 - BACK SIZE

Name	Туре	Size
<u>Prime</u>	Byte	<u>1</u>
Start1	Text	<u>11</u>
Stop1	Text	<u>11</u>
Start2	<u>Text</u>	<u>11</u>
Stop2	Text	<u>11</u>
Start3	Text	<u>11</u>
Stop3	Text	<u>11</u>
Start4	Text	<u>11</u>
Stop4	Text	<u>11</u>
<u>Start5</u>	Text	<u>11</u>
Stop5	Text	<u>11</u>
<u>Start6</u>	Text	<u>11</u>
Stop6	Text	<u>11</u>

Table: SHIFT – Maintenance table of shift times.

<u>**Table:**</u> <u>**UNIT**</u> – <u>This table contains current status information and is updated each time the unit is polled.</u>

Name	Туре	Size
Index	<u>Byte</u>	<u>1</u>
<u>Computer</u>	Text	<u>50</u>
Unit	Text	<u>50</u>
<u>UnitType</u>	Text	<u>50</u>
Active	<u>Byte</u>	<u>1</u>
JobStarted	Text	<u>25</u>
<u>TotalAvailable</u>	<u>Single</u>	<u>4</u>
<u>TotalDowntime</u>	<u>Single</u>	<u>4</u>
<u>TotalCycles</u>	<u>Single</u>	<u>4</u>
CurrentStarted	Text	<u>25</u>
<u>CurrentAvailable</u>	<u>Single</u>	<u>4</u>
<u>CurrentDowntime</u>	<u>Single</u>	<u>4</u>
<u>CurrentCycles</u>	<u>Single</u>	<u>4</u>
<u>PPH</u>	<u>Single</u>	<u>4</u>
Batch	<u>Single</u>	<u>4</u>
RecordDate	Text	<u>25</u>
Job	Text	<u>50</u>
Badge	Text	<u>35</u>