



## Epicor CMS PlantTalk:Build

*Delivered by Datanational Corporation*

### Shop Floor Automation for Epicor CMS

PlantTalk:Build software controls the build process on manufacturing lines where you require dynamic, part-specific operator instructions or fixture interfaces from the beginning of assembly to the end of the line, where the finished part is ready to be racked in your Finished Goods warehouse or packed for shipping.



#### Step-by-Step Instructions

The software displays user-defined assembly instructions and it interfaces with line-side scanners, PLC's and IP-based tools or line testers. These interfaces define the requirements to be performed to complete the instructions, and all operator instructions are defined by part, by workstation.

#### Solution Scalability

PlantTalk:Build is configurable to build in sequence or in batch, for simple and complex implementations alike (from quarter panels, door panels and center consoles to instrument panels and other modular assemblies). The software has the ability to collect traceability data and build metrics, such as actual torque values and pass/fail statistics.



#### CMS Integration

Our software interfaces with CMS to upload production data, which can then be used within CMS to trigger back-flushing of components against finished goods. We also provide inbound interfaces from CMS/EDI for sequencing or bulk production requirements, as well as outbound shipment data upload into CMS.

### Software Built Around You

PlantTalk MES is supported by Datanational's support and development team around the clock. As your one-stop shop for innovative business solutions, this system is field tested, customer endorsed and positioned to help you meet today's growing business demands as well as those of the future.



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# Epicor CMS System Recovery Overview

## Sample of Production Flow

First, the operator places the part in the assembly machine and scans its substrate (WIP) label. After the part is assembled in the machine (for example, clips are added, etc.), the machine will cycle. This process repeats at every applicable work cell until the final station is reached. At that point in time, the EOL tester or final poka-yoke interface is performed. The finished part will then be placed in the shipping rack and be ready for scanning for verification.



## Production Schedule

In a non-sequenced (batch) program, the application has a production schedule entry, which determines the sequence of different variations of parts to be built, as well as their associated quantities (for example, 100 of part X, the 200 of part Y, etc.).

The production quantity is validated against a multiple of the standard pack, and if a part is scrapped in the build process and the production run is not complete, the quantity will automatically increment to ensure that the run is completed for the final desired quantity. In the event that the production run has completed, the production scheduler can create a new production run that will be started before the next one on the schedule to take care of scrap or defect issues.

## Build Process Traceability

As the parts are built, the components used to create the parts are validated at the appropriate stations for replenishment. The license plate label is scanned when a new container of components is started. From this label, the starting quantity of the components will be known and as a part is processed at the station that uses the tracked component, the available parts remaining will be shown on the screen. When the quantity available reaches negative, an alert is shown on the screen with a red background and an audible alarm.

## Handling of Repair and Reporting of Scrap

Typically, there is a dedicated PC station (kiosk) on the floor running a scrap reporting application. A damaged part will be brought to the repair area and a line of supervisors will make the determination whether it can be repaired or not.

**Repair process:** If a part of off-lined, it will be taken to the repair area. The sequential part number will be entered/scanned and all of the components presently used for that part will be displayed on the monitor. They will all have check marks next to each component, indicating everything to be scrapped. If any components are salvageable, the operator will un-check those components (they won't be scrapped) and proceed to enter the reason code for the scrapped part.

**Rework Process:** If the part can be re-introduced to the build process, the operator will report any components to be scrapped along with the appropriate reason codes, and then the part will be re-introduced to the build process at the station where it was pulled off. There is a re-entry program at each application station for repaired parts.



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