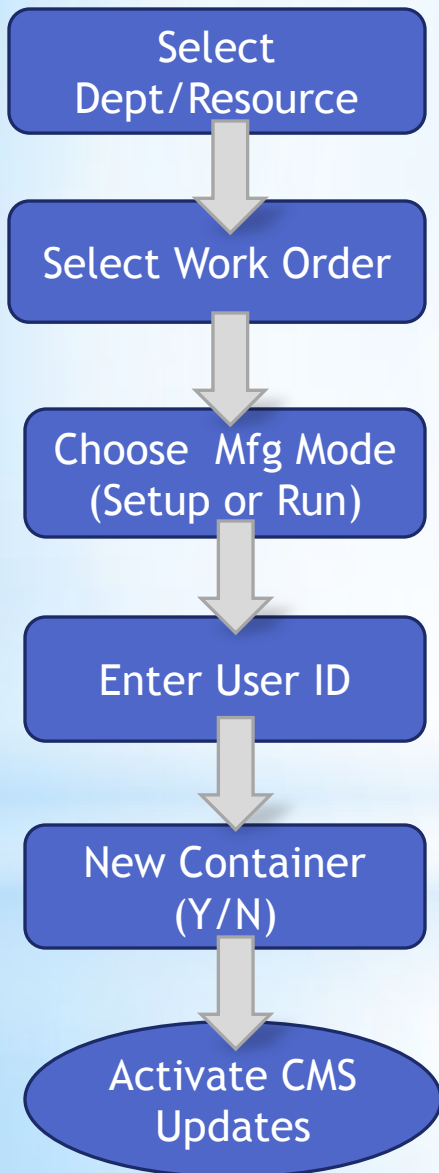




PLC Production & Labor Reporting Automation with CMS

Process and System Integration Overview

PlantTalk:Pack - Application Flow



- Scan a barcode from template or machine
- Select from pull down list (PlantTalk data table)
- Manual entry

- Scan a barcode from shop packet
- Manual entry

- On-screen selection
- Determines the Event Code for CMS

- Scan a barcode from badge
- Manual entry
- Ability to enter multiple ID's (team login)



- On-screen selection
- Determines the Event Code for CMS



Activate PLC
Connection

PlantTalk:Pack - Sample Main Application Screen

PlantTalk:Packing

Packing Application

Resource ID

Work Order [Part1234](#)

Machine Mode Run Mode Setup Mode

User ID

Show all users logged into the work order at the selected resource in this box

Required Qty 4000 Prod Qty 450 UnReported Qty 20



Mode Start Time - 08:43 Last Production Reported - 08:30

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PlantTalk:Pack - Sample Dashboard Screens

Resource Detail View



Resource ID: M01 WO: 12345 Part: Part1234 **-25 Running**

WO Qty: 4000 Total Prod: 200 Projected Rate: 70

Hour	00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24
Prod.	0	0	0	0	0	0	66	74	72	70	27	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Last Update 2014/09/27 09:45:15 Next Update in 00:45

V 2.20140936

Press #	Part Number	Production Needed	Produced Quantity	Produced In Curr Hour	Projected Hourly Rate	Difference	Status
1	Part1234	4000	200	45	70	-25	Running
2	Part1 ABC	5500	2000	120	100	20	Running
3	2345Part	3000	0	0	90	0	Setup
4	Part1234	4000	600	85	90	-5	Running
5	Part1 XYZ	2000	0	0	200	0	Setup
6	Part 987	10000	6000	200	200	0	Running
7							Idle
8							Idle
9							Idle

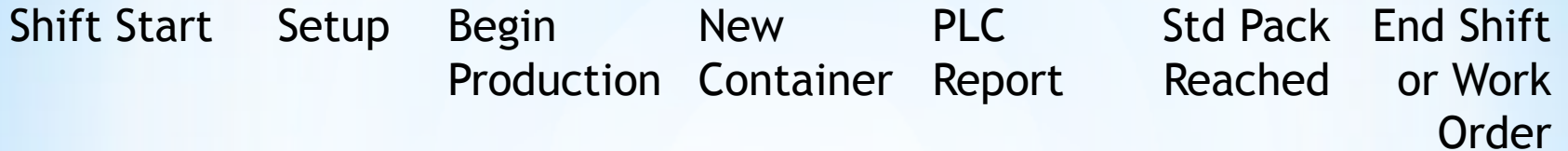
Last Update 2014/09/27 09:45:15 Next Update in 00:45

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Setup & Run Modes

CMS Production and Labor Reporting



- Identify Resource
- 10000 - Set Shift
- 10051 - Set to Setup (W/O)
- 20000 - Employee Log In

- 20009 - Log Out

- 10151 - Set to Run (W/O)
- 20000 - Log in and attach

- 51005 PLC - Create Label

At time of new container, create label to report against (Qty = 0)

Serial # created saved by PlantTalk

Label written to NOPRINT output queue

- 40002 PLC- Partial Pack

Partial Reporting at each PLC threshold interval

Report Total Qty in container via count returned from PLC.

Serial # created with 51005 will be used

Reprint Label = 'N'

- 40002 - Partial Pack

Upon PLC count reaching STD Pack, report total qty from PLC or scale

Serial # created with 51005 will be used

Reprint Label = Y

Label written to PRINT output queue

- 20009 - Log Out
- 10002 - Shift Out

