

PRODUCTION CONTROL

Points of interest:

- Real-Time
- Item & Lot Number Accountability
- WIP Tracking
- Supervisor Overrides
- Detailed Reports/Inquiry

Guiding the Manufacturing Process

Production Control for DC Connect is an easy to use PC based work in progress package. Production Control works in conjunction with IBM DC Connect to provide communications to a variety of data collection terminals, as well as host communications. Production Control also allows for the ability to operate in batch or discrete modes.

Production Control allows users to quickly and easily track products during the manufacturing process. Production status, location, raw materials usage and blending ingredients can easily be tracked and monitored from start to completion.

Production Control provides screens to allow the user to review the data of validity before transactions are sent to a host computer or submitted to other PC based applications on the network.

Unique Features

- * Tracking items by department or container location
- * Back tracking the genealogy of items consumed during each subassembly or batch process
- * Automatic calculating of recipe portions
- * Suspending and resuming production
- * Scrapping product
- * Manual or automated data from scales or counters
- * Recycling of container numbers
- * FIFO and expiration date validation for time sensitive items
- * Supports fixed Ethernet DCTs or mobile RF PTCs
- * Standard reports and user defined queries for real-time data access

Function Briefs

Functions are provided to prompt the operator to scan or enter data. As the operator completes each step, the next screen will be displayed until the transaction is complete. Once completed, a transaction record is created which contains user data for the operation (i.e. date/time stamp, terminal address, location, user identification number). Functions also re-



ferred to as transactions can be invoked by the operator by pressing or scanning the appropriate function key.

Production Control uses these functions to collect and guide operators actions for monitoring and processing orders.

- * PF1 Recall Transaction
- * PF2 WIP (work in process) Transaction
- * PF3 Move Transaction
- * PF5 Waste
- * PF7 New Blend
- * PF8 Continue Blend

PF1 Recall Transaction occurs before the beginning of major processes such as blending, injection, stuffing, or cooking. There are three main purposes for this function.

The first purpose is to assign a new item number and lot number to the items in this process to this point. Some processes only consume one lot number such as a tumbling process. Other processes may have multiple item numbers and lot numbers associated with it, such as blending. The attachment of previous lot and item numbers will allow the user to track back through all ingredients and processes in the final product.

The second purpose is to relieve inventory of raw material consumed by a particular process.

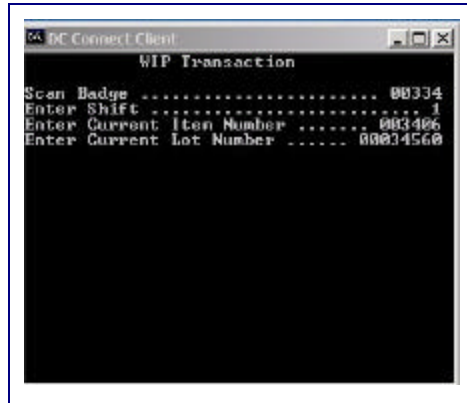
The third is to provide departmental visibility of yields by identifying weight into a department and comparing it to the weight out of the department.

PF2 WIP Transaction follows the end of a process as a new item and lot number are created. The three primary functions of the WIP

transaction are assign, update and weight tracking.

The first function is to assign a bin or rack number, weight and/or units, and a status code to a newly created item through its item number & lot number. This transaction is designed to track a WIP by bin, rack or tank.

The second purpose is to update the FIFO table in the database on the PC.



WIP Transaction

The third job of this function is to track the weight out of a particular department or process. This in conjunction with the weight provided by the recall transaction, provides departmental and/or process accountability. Lot number validation and container not in use validation is provided.

PF3 Move Transaction is used to change the status code of a particular bin or rack as it

PRODUCTION SYSTEM	
PF1	RECALL Transaction
PF2	WIP Transaction
PF3	MOVE Transaction (FIFO)
PF4	CPR (Clear Partial) Transaction
PF5	WASTE Transaction
PF6	TEMPERATURE Transaction
PF7	NEW BLEND Routine
PF8	CONTINUE BLEND Routine
PF9	NEW INJECTION Routine
PF10	CONTINUE INJECTION Routine

7527 Terminal Screen

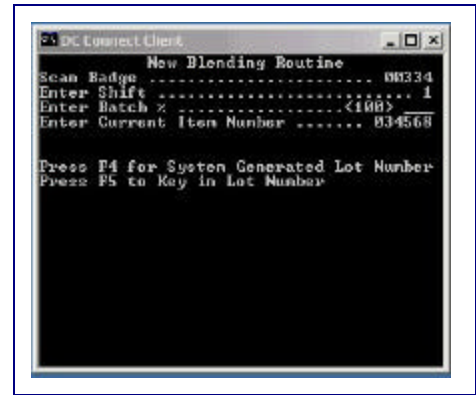
passes from in and out of storage locations such as a cooler. The move transaction can also be used to move items from one bin/rack to another. The move can be a partial or a complete transfer by weight or units.

PF5 Waste is used to measure the amount of discarded material generated from a particular process. This information serves as a check for departmental or process yields.

PF7 New Blend allows the operator to cycle

through as many recall transactions as necessary to process all the ingredients into a blend.

PF8 Continue Blend allows the operator to stop or put the blending process on hold and



New Blend

then continue it at a later time.

A Reports and Inquiry function is also available in Production Control. Users may print out reports or display information on the screen. The menu could provide the following available reports:

- * WIP Items
- * New Blend Items
- * Production Item Status
- * Items by Department
- * Waste
- * Current Lot Numbers
- * Quality Inspection Part Produced & Scrapped
- * Container Assignment
- * Actual Raw Data
- * Audit Trail Item Blend
- * Status by Employee
- * Items on Hold

Standard Features

- * WIP raw product items into production
- * New Blend
- * Recall
- * Move
- * Quantity Scrapped
- * Supervisor Adjustments

Advanced Features

- * Automated Scale data
- * Lot Identification Tracking
- * Quality Inspection
- * Real-time Employee Job Status
- * User defined query manager interface

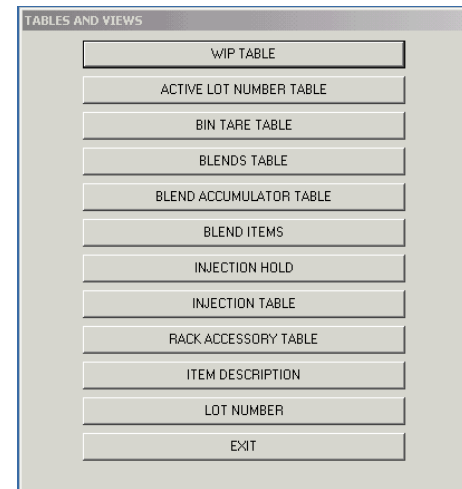
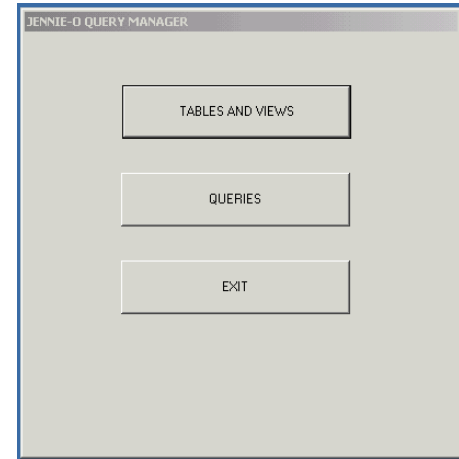
“Production... directly linked to a companies well being”

Using the tables and views in the Production Manager software allows a supervisor to make changes to the raw data. Data can be viewed or modified in any table by the supervisor. An audit trail is created to track changes by the supervisor.

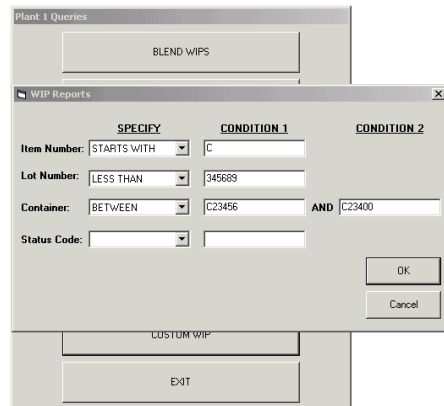
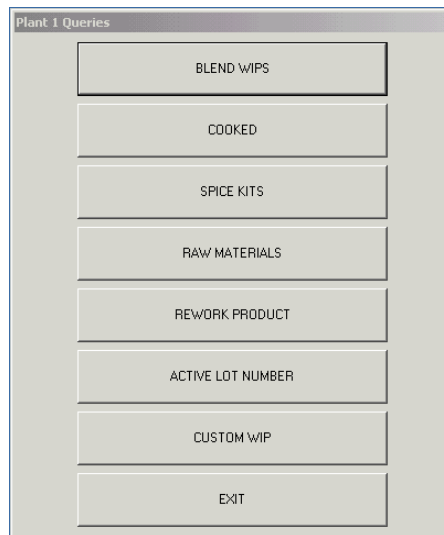
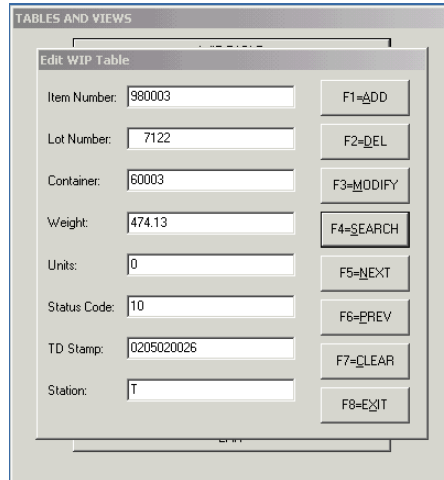
Custom reports can easily be generated by using query manager to add specific criteria to narrow data lookup.

Software Requirements

Open job orders, validation and receipts data must be available in a fixed format downloadable text file or can be extracted from existing AS-400 screens using IBM Transaction Connection. The order information must contain production quantity and product item code. A recipe must also be included. The recipe must con-



tain a list of item ingredients and amounts including process requirements for each department or operational step. An order ticket may accompany the order that contains the printed barcodes for the work order and routings.



“Linking... the production process, knowledge and people.”

System Requirements

Pentium 4 processor
512MB RAM
20 GB hard drive

Windows 2000/NT (5 users)
IBM DC Connect
IBM Transaction Connection & Client Access for host connectivity

or
Windows 2000 Server & MS SQL Server 2000 for enterprise networked environment

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