

# Manual Filling

## Production management for manual packaging

### PC Software

1. Product configuration with the following parameters:
  - Product code
  - Product description
  - Tolerance +
  - Tolerance –
  - Nominal weight
  - PreCorrect (below the proper weight), flashing traffic light
  - PostCorrect (over the proper weight), flashing traffic light
  - Recipient tare (for known value)
2. Start of production batch.
3. Finish of actual production batch.
4. Configuration of workers.
5. Historical records.
6. Data shown on screen:
  - General data:
    - Actual batch
    - Total hours worked in that batch
    - Supplier
    - Overall total of produced kg
    - Batch starting date
    - Mean of kg per worker
    - Batch starting time
  - For each worker:
    - Name of the worker
    - Total produced
    - Performed cycles
    - Batch total time of production
    - total production per scale, total time of production, etc.
7. Data export:

The program allows the historical record exportation to an ASCII file (possible to open with EXCEL, for instance)
8. About the operational:
  - 8.1. From standby mode.
  - 8.2. Press batch start.

Some data are requested:

    - Supplier (informative data)
    - Number of batch
    - Date / start time ((informative data)
    - Product
    - Observations ((informative data)
    - etc
  - 8.3. The equipments shift to RUN mode, workers start to work.
  - 8.4. At this time, the screen is showing the cumulative totals and, simultaneously, it is possible to check the historical records previously performed.
  - 8.5. Once finished the product/batch.
  - 8.6. Select End Batch
    - The program saves the totals
    - Stop the equipments
    - The totals of equipments will reset at the beginning of next batch.
  - 8.7. The program remains waiting for the next batch.
- Notes:
  - Program for Windows XP
  - Database engine MySQL

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## Production management for manual packaging PC Software

Monitorización de producción

Inicio Lote    Fin Lote    Operarios    Histórico

Lote: 20101220175713    Fecha Inicio: 20/12/2010    Horas Trabajadas: 1d 1:50:34  
 Proveedor:    Hora Inicio: 17:57:15    kg Totales: 0    Media: 0

Operario	Tiempo	total kg	ciclos
1	1d 1:50:34	0	0
2			
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
14			
15			
16			
17			
18			
19			
20			
21			
22			
23			
24			
25			
26			
27			
28			
29			
30			

76 Báscula de salida 1d 1:50:34 0 0

Main screen of the program

Listado de Consumos.    *Históricos.*

Fecha Inicial: 01/01/2009    Fecha Final: 21/12/2010

Sin Agrupar    por Proveedor    por Operario    por Partida

Fecha	Operario	Inicio	Fin	kg	Partida	Operario	kg	Partida	kg
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	4	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	5	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	6	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	7	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	8	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	9	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	10	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	11	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	13	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	14	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	15	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	16	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	17	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	18	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	19	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	20	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	21	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	22	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	23	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	24	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	25	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	26	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	27	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	28	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	29	20091211165318	
11/12/09	16:53:20	11/12/09	16:55:48	0	2	jhfg	30	20091211165318	
1							1	20091214165937	
1							1	20091214170136	
1							1	20091214171239	
1							1	20091214171300	
1							1	20101026113129	

Screen: detail of batches

Activación / Desactivación Básculas

Nombre Operario	Nombre Operario	Nombre Operario	Básculas Integradora
<input checked="" type="checkbox"/> Báscula 1	<input type="checkbox"/> Báscula 26	<input type="checkbox"/> Báscula 51	<input checked="" type="checkbox"/> Integrad. 1
<input type="checkbox"/> Báscula 2	<input type="checkbox"/> Báscula 27	<input type="checkbox"/> Báscula 52	<input type="checkbox"/> Integrad. 2
<input type="checkbox"/> Báscula 3	<input type="checkbox"/> Báscula 28	<input type="checkbox"/> Báscula 53	<input type="checkbox"/> Integrad. 3
<input type="checkbox"/> Báscula 4	<input type="checkbox"/> Báscula 29	<input type="checkbox"/> Báscula 54	<input type="checkbox"/> Integrad. 4
<input type="checkbox"/> Báscula 5	<input type="checkbox"/> Báscula 30	<input type="checkbox"/> Báscula 55	<input type="checkbox"/> Integrad. 5
<input type="checkbox"/> Báscula 6	<input type="checkbox"/> Báscula 31	<input type="checkbox"/> Báscula 56	
<input type="checkbox"/> Báscula 7	<input type="checkbox"/> Báscula 32	<input type="checkbox"/> Báscula 57	
<input type="checkbox"/> Báscula 8	<input type="checkbox"/> Báscula 33	<input type="checkbox"/> Báscula 58	
<input type="checkbox"/> Báscula 9	<input type="checkbox"/> Báscula 34	<input type="checkbox"/> Báscula 59	
<input type="checkbox"/> Báscula 10	<input type="checkbox"/> Báscula 35	<input type="checkbox"/> Báscula 60	
<input type="checkbox"/> Báscula 11	<input type="checkbox"/> Báscula 36	<input type="checkbox"/> Báscula 61	
<input type="checkbox"/> Báscula 12	<input type="checkbox"/> Báscula 37	<input type="checkbox"/> Báscula 62	
<input type="checkbox"/> Báscula 13	<input type="checkbox"/> Báscula 38	<input type="checkbox"/> Báscula 63	
<input type="checkbox"/> Báscula 14	<input type="checkbox"/> Báscula 39	<input type="checkbox"/> Báscula 64	
<input type="checkbox"/> Báscula 15	<input type="checkbox"/> Báscula 40	<input type="checkbox"/> Báscula 65	
<input type="checkbox"/> Báscula 16	<input type="checkbox"/> Báscula 41	<input type="checkbox"/> Báscula 66	
<input type="checkbox"/> Báscula 17	<input type="checkbox"/> Báscula 42	<input type="checkbox"/> Báscula 67	
<input type="checkbox"/> Báscula 18	<input type="checkbox"/> Báscula 43	<input type="checkbox"/> Báscula 68	
<input type="checkbox"/> Báscula 19	<input type="checkbox"/> Báscula 44	<input type="checkbox"/> Báscula 69	
<input type="checkbox"/> Báscula 20	<input type="checkbox"/> Báscula 45	<input type="checkbox"/> Báscula 70	
<input type="checkbox"/> Báscula 21	<input type="checkbox"/> Báscula 46	<input type="checkbox"/> Báscula 71	
<input type="checkbox"/> Báscula 22	<input type="checkbox"/> Báscula 47	<input type="checkbox"/> Báscula 72	
<input type="checkbox"/> Báscula 23	<input type="checkbox"/> Báscula 48	<input type="checkbox"/> Báscula 73	
<input type="checkbox"/> Báscula 24	<input type="checkbox"/> Báscula 49	<input type="checkbox"/> Báscula 74	
<input type="checkbox"/> Báscula 25	<input type="checkbox"/> Báscula 50	<input type="checkbox"/> Báscula 75	

Abrir-Cerrar Descargas    Aceptar    Cancelar

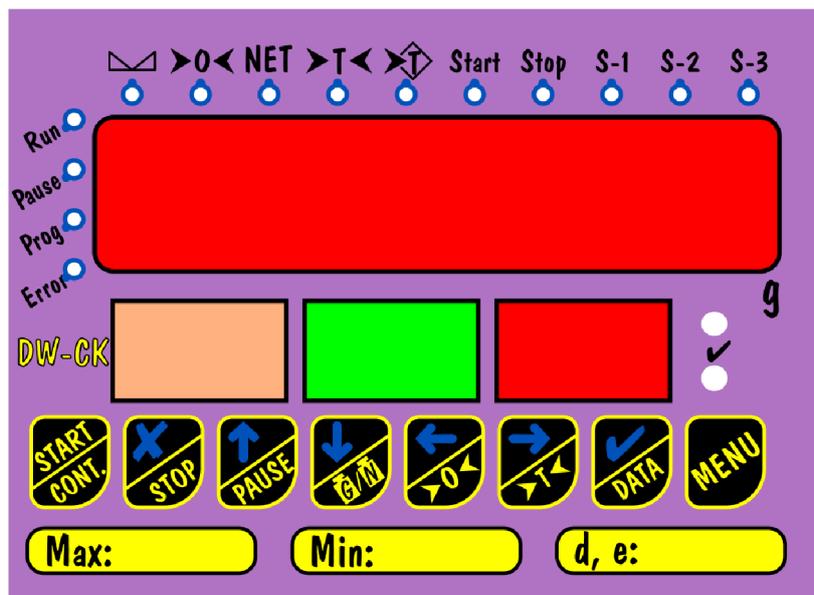
Screen of worker assignment to each scale

# Manual Filling

## Production management for manual packaging Weight controller | operating mode

1. Configure working values (locally or from PC).
  2. Change mode equipment to RUN (locally or from PC).
  3. Place a box on the scale.
  4. Predetermined tare or pulse TARE or work with gross weight.
  5. Indication of weight state.
  6. Once the weight is correct and a button to validate the weight has been pressed, there is an indication to remove the box (1).
  7. At the moment of weight validation, it is registered to be sent to the PC.
  8. Go to step 3.
- Main functions of the indicator:
    - Manual / Automatic operating mode.
    - Weight validation by contactless button (it allows an unlimited life for the key).

(1) At point 6, it is possible to validate the weight by detecting stable weight instead of pressing a button or a pedal.



# Manual Filling

## Production management for manual packaging Platforms

### Option 1:

1. 300x300mm platform (other dimensions available on request).
2. Carbon steel structure, galvanised.
3. Plate of stainless steel AISI 304.
4. Aluminium load cell Ip65.
5. Display of weight and traffic light fixed to the platform.
6. Main supply: 220Vac.
7. RS232 and RS485 communication ports.
8. Possibility of connection to a printer.
9. Non-verifiable.

### Option 2:

1. 300x300mm platform (other dimensions available on request).
2. Structure of stainless steel AISI304.
3. Plate of stainless steel AISI 304.
4. Aluminium load cell Ip67.
5. Display of weight and traffic light fixed to the platform.
6. Main supply: 220Vac.
7. RS232 and Rs485 communication ports.
8. Possibility of connection to a printer.
9. Verifiable.

