

Shop Floor Work Center Reporting

ABSTRACT

Shop Floor Work Center Reporting (WCR) brings real time transaction entry to both Progression and Macola ES Manufacturing. The Shop Floor WCR is composed of a transaction entry screen designed to accept bar coded entry of SF and Labor transactions at the work center as work is being started and completed. A setup screen provides options as to how the data is to be reported and how manufacturing employees record SF transactions. For example, a setup option to allow manual labor Entry would control whether the employee could over ride the calculated time on the operation.

Real time Data Collection provides:

1. Up to Date Job and Labor information
2. Reliable Job Status
3. Accurate Job Cost Information for improved standard costs

ARCHITECTURE

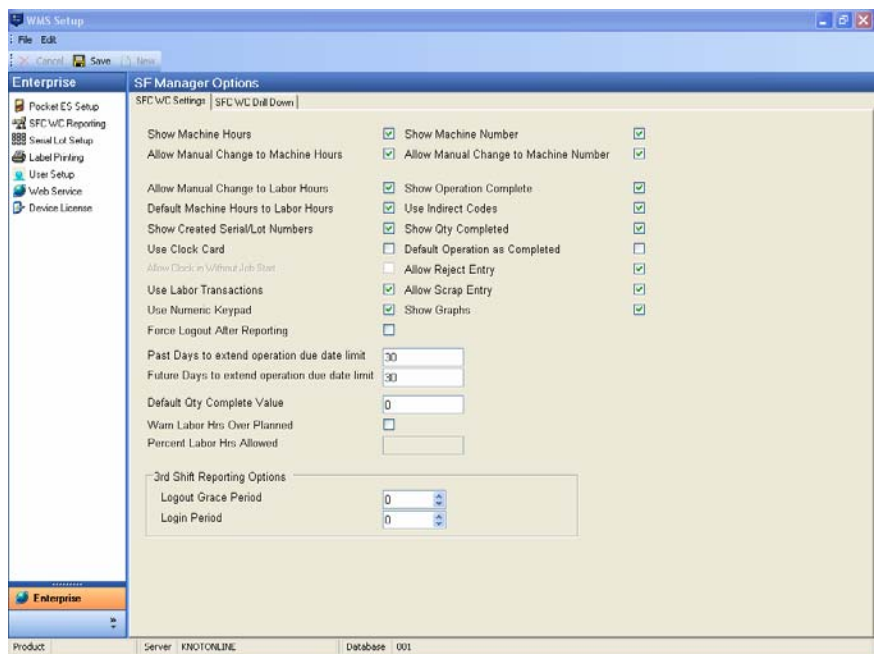
Shop Floor Manager leverages the power of your Macola ES or Macola Progression ERP system, Microsoft SQL Server, and a solid, stable architecture based on Microsoft's .Net platform.

Data capture and entry is done through the WCR which is a PC based entry screen that is located to be accessible from one or several work centers. The PC platform was chosen for the lowest cost data entry option. Bar coded Employee badges and Bar Coded Shop Packets are used to streamline data capture.

Employee Reporting— The Reporting process for each operation starts with the employee scanning their badge.

FEATURES

- Touch Screen or Bar Code Entry for Real Time Labor Reporting
- Report Production and Finished Goods on line
- Material back flushed on completion of attaching operation
- Supports S/L, & Multi-Bin for finished goods
- Barcode Printing/Item Labels on-the-floor for finished goods
- Calculates Labor on clock in and clock out of job and operation



Shop Floor Setup — The WMS setup has a section for options that control the WCR. For example this is where the integrated Clock Card system is turned on.



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▶ Shop Floor Manager

Start Operation—After the employee logs in in a shop order number and operation no is bar coded into the WCR. If the operation has not been started, transaction start is noted and materials needed are displayed. This begins a labor transaction if LP is in use and starts the clock for this operation.

Report Operation —When the employee logs in again, if an operation is open they are prompted to complete the open operation. It can also be reported as completed. Bar Charts show how much time and material has already been logged to this operation. Scrap may also be reported. Any material either attached to the operation or part of an M count point is back-flushed. If the final Finished Good operation includes a Serial or Lot Item then S/L numbers are built based on the WMS setup and labels can be printed.

Bar Coded Shop Packet—While any of the WCR fields can be manually entered. Data is usually bar coded from the employee id badge and the bar coded shop packet.

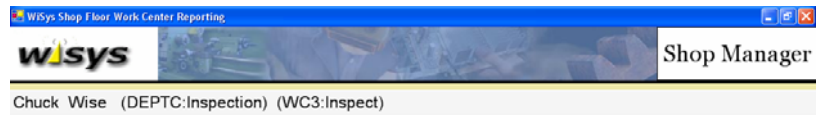


Enter Order No. and Operation

Shop Order No.

Operation No.

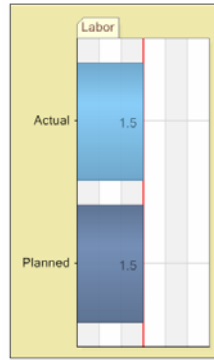
Indirect Codes



Inspection

Shop Order : 75 / 80

Abort This Job

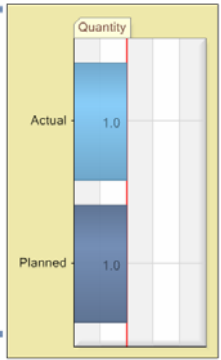


Labor Hrs

Machine Hrs

Machine No

Qty Completed



Shop Packet															
Company										User		Shop Order			
001 Pocket ES Test Company										User		Shop Order		Start Date	All
Item No										All		Path No		All	All
Shop Order No										51		Path No		All	All
30	5	HASASSY	MA	EA	1.000000	1/1/2001	10.00	Y	Y						
Handbar Assembly										A		N		10.00	10257
Full POP															
Oper	Path	Dept	Oper Description 1	Oper Description 2	Op Type	Sts	Op ID	UOM	No Wkrs	Pin Lbr Hrs	Pin Lbr Hrs	Pin Mch Hrs	Pin Mch Hrs	Pin Mch Hrs	
ES	CP	ES	Mch No	Qty Batch	Lbr Grd	Qty Plan	Queue Days	Process Time	No Mch	Move Days	User Cd				
40	0	DEPTA	Thread		P	P	EA	0.00	1	27.500000					
WC1										S		0.00		10.00	0.00
5												0.00	0.00	0.00	
Oper	Seq	Comp Item No	Loc	UOM	Qty Per	Parent	Need Date	Qty Needed	Ctl	Stk					
Description 1 <td colspan="2">Str Area <td colspan="2">Qty Planned <td colspan="2">Byr Plnr </td></td></td>										Str Area <td colspan="2">Qty Planned <td colspan="2">Byr Plnr </td></td>		Qty Planned <td colspan="2">Byr Plnr </td>		Byr Plnr	
40	5	SCASASSY	MA	EA	1.000000	1/1/2001	10.00	Y	Y						
Brake and Cable Assembly										A		N		10.00	10257
Oper	Path	Dept	Oper Description 1	Oper Description 2	Op Type	Sts	Op ID	UOM	No Wkrs	Pin Lbr Hrs	Pin Lbr Hrs	Pin Mch Hrs	Pin Mch Hrs	Pin Mch Hrs	
ES	CP	ES	Mch No	Qty Batch	Lbr Grd	Qty Plan	Queue Days	Process Time	No Mch	Move Days	User Cd				
40	0	DEPTA	Prime		P	P	EA	1.00	1	30.000000					
WC1.A										S		n nn		10.00	0.00
5												n nn	n nn	n nn	
AUTO PRIME															
30	0	DEPTA	Paint		P	P	EA	0.00	1	40.000000					
WC1.B										S		0.00		10.00	0.00
5												0.00	0.00	0.00	
Oper	Seq	Comp Item No	Loc	UOM	Qty Per	Parent	Need Date	Qty Needed	Ctl	Stk					
Description 1 <td colspan="2">Str Area <td colspan="2">Qty Planned <td colspan="2">Byr Plnr </td></td></td>										Str Area <td colspan="2">Qty Planned <td colspan="2">Byr Plnr </td></td>		Qty Planned <td colspan="2">Byr Plnr </td>		Byr Plnr	
50	5	POBCK	MA	EA	1.000000	1/1/2001	10.00	Y	Y						
Pork, Elk, Titanium Mesh										A		N		10.00	10257
1" Carbon Stecor. 43MM Rake															
Oper	Path	Dept	Oper Description 1	Oper Description 2	Op Type	Sts	Op ID	UOM	No Wkrs	Pin Lbr Hrs	Pin Lbr Hrs	Pin Mch Hrs	Pin Mch Hrs	Pin Mch Hrs	
ES	CP	ES	Mch No	Qty Batch	Lbr Grd	Qty Plan	Queue Days	Process Time	No Mch	Move Days	User Cd				