TRICORN SYSTEMS
INTEGRATED MANUFACTURING SOFTWARE

TRICORN:SFDC-e

Shop Floor Data Capture

Tricorn Systems Shop Floor Data capture system is designed to provide vital information directly to the shop floor operatives that is accurate and current. TRICORN:SFDC is driven by TRICORN:Scheduler and provides real-time "work-to" lists to terminals so operators are informed of changes to job priorities immediately rather than being issued with paper lists that can be superseded withing minutes in a dynamic working environment.

TRICORN:SFDC allows the operator to view all jobs/operations for a specific work centre (or group of work centres) within a selected period and by selecting a job the operator can see information on preceding and succeeding operations.

The job can then be logged onto and vital information recorded which automatically populates the relevant areas in TRICORN:Production.

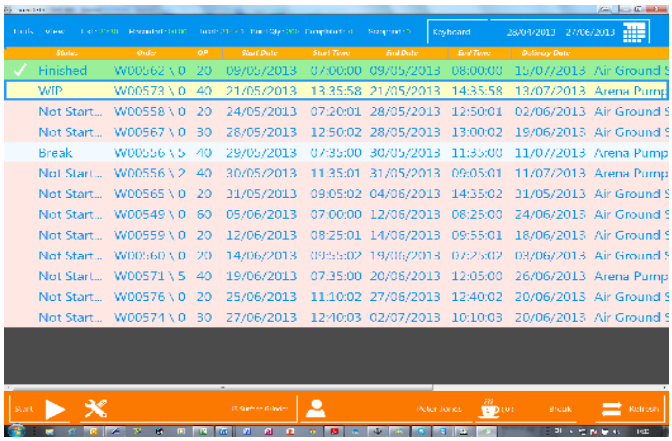
Key Features

- ✓ Touch-screen or Keyboard/Mouse
- ✓ Real-Time Machine Loading
- ✓ Group similar resources (work centres)
- ✓ Record Setting & Run Times
- ✓ Pause jobs for breaks
- ✓ Record notes against operations
- ✓ Record scrapped parts
- ✓ Up to 10 work centres per terminal
- ✓ Optionally amend times
- ✓ Optionally view times estimates
- ✓ View drawings, instructions etc online
- ✓ View status of preceding operations
- ✓ Multi-worker operations
- ✓ "Paperless Manufacturing"

WORK QUEUES

The Work Queues (Machine Loading lists) are built by the TRICORN:Scheduler and communicated to the shop floor terminals. Any change to job priority is instantly updated on the terminal so there is no need to regularly run to the work shop to amend "work-to" lists.

Each terminal can control up to ten work centres (resources), although in many cases a single terminal per resource is recommended. Similar resources (lathes, mills, turns,

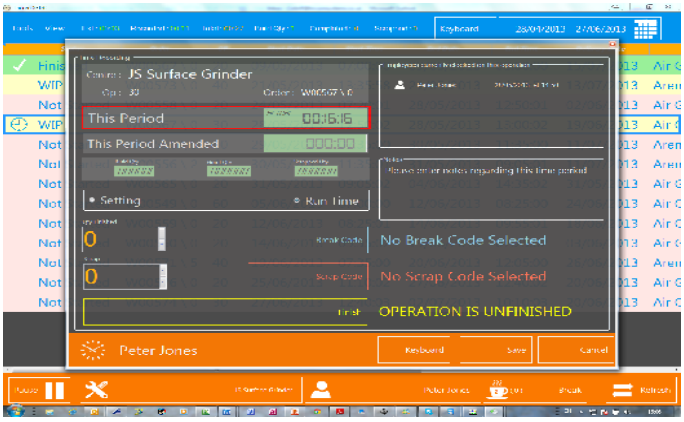


welding bays etc) can be grouped onto a single terminal. The operator can click on the operations in the work queue to see the status of preceding operations and assess how long it will be before the operation designated for their machine is ready to execute.

All information relevant to the job is shown on the terminal – Works Order No., Scheduled Start Date, Delivery (completion) Date, Customer Name, Part Description, Part No. & issue.

TIME RECORDING

Once an operation is ready to execute the operator can indicate to the system whether they're "setting" or "running" thereby enabling times to be recorded for both – which can then be compared to the setting and run-time estimates. If



the part is a regularly manufactured production part these actual times can be used to update the parts master template time estimates to better reflect reality.

Breaks/pauses can be recorded either manually or set by default. If an operator is working multiple machines they can pause all of them by a single click and then restart them all via another single click.

Estimated setting and run times can optionally be shown on the screen against each operation.

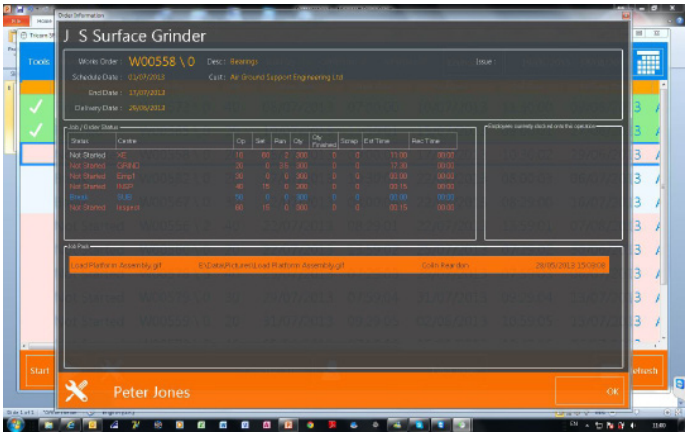
Multiple operators can be logged onto a job/operation

concurrently and all the times are recorded within the TRICORN:Production system.

Actual times can optionally be amended by operators on the shop floor (e.g. if they forgot to clock off a job) although this can be hidden so that any changes are effected by the production manager or admin staff.

JOB PACKS

Any file can be linked to a job or operation and the file can



then be viewed on the terminal (as long as the application relevant to the file also resides on the terminal). The files can be attached to works orders in TRICORN:Production and they are then available to the operator at execution time.

Drawings, tooling instructions, setting instructions, video clips and NC programs can all be linked to a works order or operation – the first step towards paperless manufacturing!

NOTES/FINISHED/SCRAPPED

The operator can record notes against each time period (a touch-screen keyboard can be launched) so that any vital information about the operation can be recorded for later review and possibly adding to the manufacturing notes and job instructions on the Job Card.

For long running jobs the operator can enter the number of parts completed which can then inform the TRICORN:Scheduler of an estimate of how much time is left to complete the operation.

Scrapped parts can be recorded with user-defined reason codes for later review by Quality Control and management.

ADMINISTRATION

The Production Manager can control which machines/resources are assigned to each terminal and can also assign specific operators to a terminal.

The administrator can also decide if time estimates are shown on the terminal and if operators can adjust their own times if they've made a mistake.

LICENSING

The SFDC-e system is licensed on a per-resource (work centre) basis (in blocks of five) and pricing is also based on the number of terminals (touch-screens) that the system is installed on.

The system can be licensed for just work queues, work queues plus time recording and work queues, time recording and job packs.

ABOUT TRICORN SYSTEMS

Tricorn Systems Ltd. is based in Farnham, Surrey. It has extensive experience in dealing with UK-based manufacturing companies and there are hundreds of customers operating Tricorn Job Processing Software - TRICORN:Production on a daily basis.

In addition to the Job Processing system, Tricorn provides an integrated Quality Management System - TRICORN:QMS (suitable for ISO9001 and AS9100), a workshop scheduling (planning board) system - TRICORN:Scheduler.

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