

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operators are informed of changes to job priorities immediately rather than being issued with paper lists that can be superseded within minutes in a dynamic working environment.

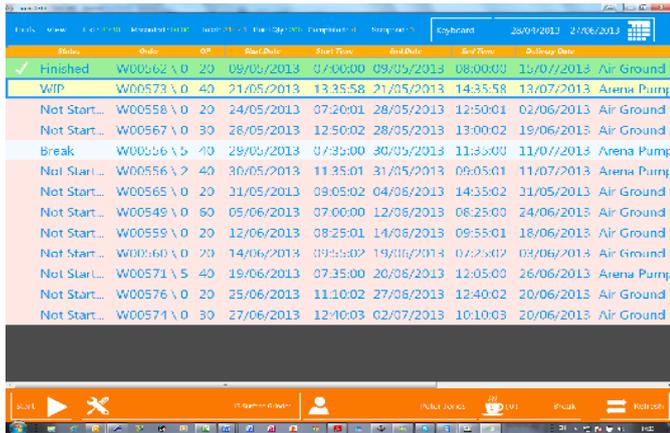
TRICORN:SFDC allows the operator to view all jobs/operations for a specific work centre (or group of work centres) within a selected period and by selecting a job the operator can see information on preceding and succeeding operations.

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

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,



Status	Order	OP	Start Date	Start Time	End Date	End Time	Delivery Date	Work Centre
Finished	W00562 \ 0	20	09/05/2013	07:00:00	09/05/2013	08:00:00	15/07/2013	Air Ground S
WIP	W00573 \ 0	40	21/05/2013	13:35:58	21/05/2013	14:35:58	13/07/2013	Arena Pump
Not Start...	W00558 \ 0	20	24/05/2013	07:20:01	28/05/2013	12:50:01	02/06/2013	Air Ground S
Not Start...	W00567 \ 0	30	28/05/2013	12:50:02	28/05/2013	13:00:02	19/06/2013	Air Ground S
Break	W00556 \ 5	40	28/05/2013	07:35:00	30/05/2013	11:35:00	11/07/2013	Arena Pump
Not Start...	W00556 \ 2	40	30/05/2013	11:35:01	31/05/2013	09:55:01	11/07/2013	Arena Pump
Not Start...	W00565 \ 0	20	31/05/2013	09:05:02	04/06/2013	14:35:02	31/05/2013	Air Ground S
Not Start...	W00549 \ 0	80	05/06/2013	07:00:00	12/06/2013	08:25:00	24/06/2013	Air Ground S
Not Start...	W00559 \ 0	20	12/06/2013	08:25:01	14/06/2013	09:55:01	18/06/2013	Air Ground S
Not Start...	W00560 \ 0	20	14/06/2013	09:55:02	19/06/2013	07:25:02	03/06/2013	Arena Pump
Not Start...	W00571 \ 5	40	19/06/2013	07:35:00	20/06/2013	12:05:00	26/06/2013	Arena Pump
Not Start...	W00576 \ 0	20	25/06/2013	11:10:02	27/06/2013	12:40:02	20/06/2013	Air Ground S
Not Start...	W00571 \ 0	30	27/06/2013	12:40:03	02/07/2013	10:10:03	20/06/2013	Air Ground S

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.

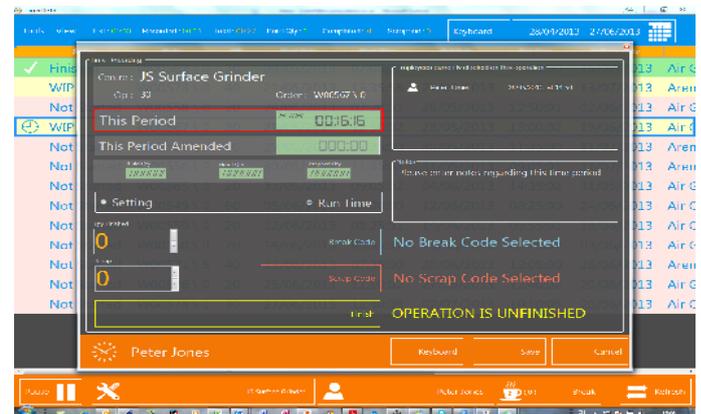
Key Features

- ✓ 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”

& 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

