

PC-Topp.NET Corrugator Control Page

Short Reference

◆ Function

The Corrugator Control Page has been designed to administrate the development of production on the corrugator: It allows to view and modify the production status on the corrugator and to print corrugator schedules as well as lists of material requirements. This way, program changes are transferred to the corrugator.

Using the Corrugator Control Page also shifts can be entered.

Data displayed on the Corrugator Control Page is a combination of the content of the program memory and of programs on the dry end controller scheduled on the corrugator.

Due to the Corrugator Control Page the program memory is automatically adapted to any new sequence on the dry end controller. The display will be up-to-date at any moment.

Morning Shift 09:48		Queue	Papers	Shift Report	Personnel	Corrugator Link ONLINE	Transfer MANUAL	
Corrugator Terminal		Prg. Run	Flute / Width Order	Grade Customer	Combination	C	Meters	
OND Onduleuse		4997	10:20 B 2210	B 010			11,395	
PC-Topp.net Action		1	10:20 618055 VICAT VIZILLE	2 790 x 1488	H	471	632	
Running			09:05 628867 PROVENCE REGI	1 547 x 1121	B	(471)	420	
Current Production		2	10:24 618055 VICAT VIZILLE	2 790 x 1488	H	5,388	7,240	
Shift M			621026 TRAMIER	2 299 x 1007	B		10,700	
m / min 65		3	11:05 616073 SPMP	1 1374 x 3149	H	1,363	432	
Run Time 5'22			621001 JAFFEUX	1 802 x 990	B		1,376	
Downtime 0'09		4	11:15 628600 ANTARTIC II	4 393 x 1125	H	3,612	12,840	
Next Change			621027 TRAMIER	2 299 x 1007	B		7,172	
Grade 9971		5	11:43 628824 PRODUITS NYON	5 357 x 1019	H	561	2,750	
Roll Size 9971			628823 PROD NYONSAIS	1 357 x 733	B		765	
Flute 34525		4998	11:50 B 2110	B 010		1,884	0'14	
Current Roll		4999	12:05 B 2110	B 020B		7,603	0'58	
4997.2		5000	13:05 B 2010	B 010		2,465	0'19	
Target Speed								
Current Speed								
130								
134								
Scheduled Meters								
5387								
Current Meters								
953								
Board Grade								
B 010								
Roll Size								
2210								
Meters								
5387								
618055 VICAT VIZILLE 2								
790x1488								
621026 TRAMIER 2								
299x1007								
Performance								
Run								
Shift								
Ø Speed (m / min)								
135								
65								
Produced m								
953								
21785								
Produced m²								
2106								
48150								
Efficiency								
Current								
103								
Run								
Shift								
51								
Actions								
Exit								
Configuration								
MailProg								
Other Pages								

Fig. 1

The Corrugator Control Page is structured as follows: With a mouse click the different tabs lead to sub programs. These tabs are: QUEUE, PAPERS, SHIFT REPORT and PERSONNEL.

1. Queue

Queue		Papers		Shift Report		Personnel		Corrugator Link ONLINE		Transfer MANUAL	
Prg. Run	Start	Flute / Width Order	Grade Customer	Combination	C	Meters	Duration Sheets	Ordered	Trim	Next	
4997	10:20	B 2210	B 010			11,395	1'27				
1	10:20	618055 VICAT VIZILLE	B 010	2 790 x 1488	H	471	632	16000 : 2	83	51	↑
		09.05. 628867 PROVENCE REGI		1 547 x 1121	B	(471)	420	4000 : 2	32	32	
2	10:24	618055 VICAT VIZILLE	B 010	2 790 x 1488	H	5,388	7,240	16000 : 2	32	51	↑
		621026 TRAMIER		2 299 x 1007	B		10,700	10000 : 1	30	30	
3	11:05	615073 SPMP	B 010	1 1374 x 3149	H	1,363	432	1000 : 1	34	31	↑
		621001 JAFFEUX		1 802 x 990	B		1,376	5000 : 4	51	51	
4	11:15	628600 ANTARTIC II	B 010	4 393 x 1125	H	3,612	12,840	12000 : 1	40	30	↑
		621027 TRAMIER		2 299 x 1007	B		7,172	20000 : 1	30	30	
5	11:43	628824 PRODUITS NYON	B 010	5 357 x 1019	H	561	2,750	2500 : 1	68	20	↑
		628823 PROD NYONSAIS		1 357 x 733	B		765	3000 : 1	20	20	
4998	11:50	B 2110	B 010			1,884	0'14				
4999	12:05	B 2110	B 020B			7,603	0'58				
5000	13:05	B 2010	B 010			2,465	0'19				

Fig. 2

Here, the runs on the corrugator are sorted by start time. Clicking on the vertical blue bar to the right allows scrolling.

The colors of the corrugator schedules correspond to typical PC-Topp colors:

- Grey = produced
- Yellow = scheduled
- Blue = current / running program

The queue tab also shows comments entered for programs in Program Memory.

2. Papers

Queue		Papers	Shift Report	Personnel	Corrugator Link ONLINE	Transfer MANUAL	
Runs	Grade	Width	Start	Outside	Flute	Liner	Flute
4996 4	B 010B	2210	06:45 6,966 m 6,974 kg	WT 150 6,966 2,309	FL 112 6,966 2,310	TL 140 6,966 2,155	
4997 5	B 010		10:20 11,395 m 11,660 kg	TW 160 7,476 2,644	FL 112 11,190 2,770	TL 140 7,476 2,313	
4998 1	B 010	2110	11:50 1,884 m 1,840 kg	TW 160 1,884 636	FL 112 12,713 3,004	TL 140 1,884 557	
4999 2	B 020B		12:05 7,603 m 8,230 kg	WT 150 7,603 2,406	...	TL 200 7,603 3,208	
5000 2	B 010	2010	13:05 2,465 m 2,294 kg	TW 160 2,465 793	FL 112 3,303 744	TL 140 2,465 694	

Fig. 3

This tab shows the scheduled quantities (in m and kg) for the combinations, i.e. until the next change (paper change, roll change etc.).

- Green figures are in ml
- Blue figures are in kg

The display is important for the personal at the wet end controller because it allows to calculate how long a certain roll size will be in use.

3. Shift Report

1. Performance

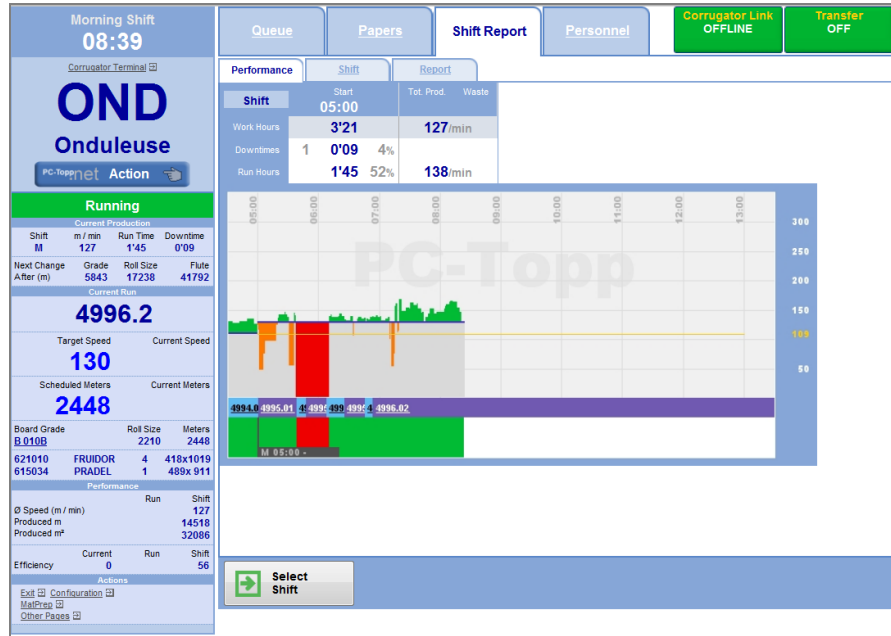


Fig. 4

The figures on top to the left represent the number of downtimes and their percentage of total run time (in %) as well as the percentage of run hours.

2. Shift Report

Performance							
Shift							
Report							
Shift 09.05. M (05:00): Michael Schwarz							
Combination	Board Grade	Width	Meters	Trim	Time		
4995 01	B 020B	2210	4874	32	05:00	0'38	
4995 02			1050	36	05:38	0'09	
4995 03			2600	50	05:47	0'20	
4995 04			2300	50	06:07	0'18	
4995 05			2571	103	06:25	0'20	
4996 01	B 010B		1123	32	06:45	0'09	

Fig. 5

Below on the screen you can see the following 4 options:

- Select Shift
- Display / Hide Downtimes
- Display / Hide Breaks
- Add Comment



Fig. 6

Select Shift:

1. Login with password (according to the personnel's privileges)
2. Selection of the crew leader

Select Shift
✕

07.05.	A Jürgen Müller	14:00 - 22:00	⬆
	N Rainer Neugebauer	22:00 - 06:00	⬆
08.05.	M Michael Schwarz	06:00 - 13:30	⬇
	N Jürgen Müller	20:30 - 05:00	⬇
▶09.05.	M Michael Schwarz	05:00 -	⬇

✔ Select

✕ Close

Fig. 7

Hide / Show Downtimes

Downtimes can be displayed or hidden:

Performance	Shift	Report					
Shift 09.05. M (05:00): Michael Schwarz							
Combination	Board Grade	Width	Meters	Trim	Time		
4995 01	B 020B	2210	4874	32	05:00	0'38	
	Bourrage coupeuse auxiliaire				05:29	0'09	
4995 02			1050	36	05:38	0'09	
4995 03			2600	50	05:47	0'20	
4995 04			2300	50	06:07	0'18	
4995 05			2571	103	06:25	0'20	
4996 01	B 010B		1123	32	06:45	0'09	

Fig. 8

◆ **Entry of
downtime reasons**

There are several possible scenarios:

1. The corrugator can send downtimes to PC-Topp. In this case, downtime entry is not possible via this page.
2. The corrugator can't send downtimes this to PC-Topp. In this case, downtime entry is possible.

3. Shift Report

Detailed Shift Report															PC-Topp.net												
OND Onduleuse															09.05.1989												
Fig. No.	Start Time	Prod. Hours	Flute	Board Grade	g / m ²	Width	Act. m	Good Production (kg)	Waste	Good Production (m ²)	Waste	Downtime Summary	Order	Combination	Trin	Good Prod. Sheets	Waste Sheets	Rest									
09.05. Morning Shift															05:00 - 00:01												
4905.01	05:00	0:38	B	B 0208	813	2210	4.874	5.448	80	10,816	136	06:28 Storage outage auxiliaire	0208	CAMP ROMAI	2 x 803 x 1177	32	8,202	3,018	31								
							4,874										10,781	2,448	30								
4905.02	05:38	0:38	B	B 0208	813	2210	1,092	1,172	18	2,263	38		014950 02	PRADEL	3 x 802 x 1147	36	2,745	811	31								
							1,092										1,182	383	31								
4905.03	05:47	0:20	B	B 0208	813	2210	2,800	2,881	67	5,616	130		010207	S E S V	3 x 540 x 1269	80	5,144	2,198	32								
							2,800										2,881	708	30								
4905.04	06:07	0:18	B	B 0208	813	2210	2,300	2,549	59	4,958	118		010207	S E S V	2 x 540 x 1269	80	3,624	1,299	32								
							2,300										2,882	1,251	30								
4905.05	06:25	0:20	B	B 0208	813	2210	2,871	2,779	136	5,417	268		020805	CAMP ROMAI	2 x 803 x 1177	103	4,288	1,563	31								
							2,871										2,890	1,188	30								
4905.01	06:45	0:38	B	B 0108	483	2210	1,123	1,182	17	2,445	35		010208	PRADEL	4 x 442 x 811	32	5,536	954	30								
							1,123										1,182	227	32								
B - Flute															0 811	0 2210	14,818	16,027	378	31,348	748			2,31 %	62,096	18,027	

09.05. Morning Shift - Summary															Trin		Crew		Crew Leader	
05:00 - 00:01															2,31 %		Michael Schwab		Michael Schwab	
Hours	Width	g/m ²	g/m ²	Flute	Average	Waste	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	g/m ²	
Open	4301	8	748	381																
Break	4301	8	748	381	14,818	2210	910	32,088	16,387	3,822	1,361	748	378							
Work	4301	8	748	381																
Downtime	1	0208																		
UnderProd	4107																			
Production	8	1145	138	18,338	0,364															
Good Production															31,348	16,090				

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Fig. 9

Here is the detailed shift report. It contains a flute type summary per shift as well as an overview of performance, production summary, downtimes and personnel.

Modifying the Program Sequence

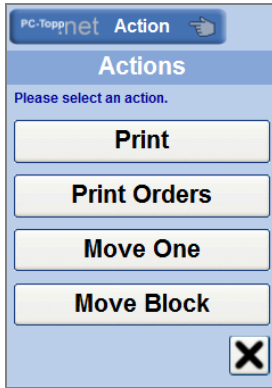
The Corrugator Control Page allows to modify the sequence of the displayed programs: Programs can be shifted forwards and backwards (see the options at "Actions" in the following section).

◆ **Please note:**

The sequence in program memory won't be affected by such modification

The "Action" Key

Clicking on this key in the toolbox 3 options are at your disposal:



Close "Actions" menu

1. Print
2. Print Orders
3. Move One
4. Move Block

1. **Print:** Access to the Print Option (DOS): Select a print range by clicking on the first and then on the last program to print.
2. **Print Orders:** Prints JobCards (PDF format) for all orders in the selected range.
3. **Move One:** Program sequence can be modified manually. At first, you have to click on the desired program and then on the program, in front of
4. **Move Block:** Click on the 1st program you want to move, then on the last one. Then click on the program in front of which you want to insert the selected section.









 4996	06:45
1	06:45 09.05.
2 	06:54
3 	05:13 15.05.
4 	05:31
 4997	05:40
 4998	07:10
 4999	07:25
 5000	08:25

Fig. 10

In the column to the left you can see little icons in shape of padlocks. The colors of these padlocks show if the sequence of the Corrugator Control Page is the same as in program memory or if it is still possible to make modifications.

For the meaning of the colors see the next paragraph:

Padlock Colors

**Orange**

Runs will be marked with an orange padlock if they are located on the corrugator (dry end controller) in another position as in program memory.

These programs can always be modified: You only have to open thy padlock by clicking on it.

**Dark Green**

The run has always been transferred to the corrugator, it is no longer possible to change it.

**Light Green**

Open padlock: The run is located only in program memory, it has not been transferred to the corrugator yet. Modifications of the sequence are always possible.

**Red**

The Red represents the current run or the run that will be started very soon. It can't be modified any more.

The queue of the programs always starts with 1 or more red padlocks. Then there will be closed padlocks (Green is ideal, but in case of modifications on dry end controller eventually in Orange).

The last run with closed padlock shows the end of the program that has already been transferred to the dry end controller.

After that, there will be no more open padlocks.

Values in the toolbox

Morning Shift
08:50

[Corrugator Terminal](#)

OND

Onduleuse

PC-Topp.net Action

Running

Current Production

Shift	m / min	Run Time	Downtime
M	127	1'45	0'09

Next Change After (m)	Grade	Roll Size	Flute
	5843	17238	41792

Current Run

4996.2

Target Speed	Current Speed
130	

Scheduled Meters	Current Meters
2448	

Board Grade	Roll Size	Meters
B 010B	2210	2448
621010	FRUIDOR	4 418x1019
615034	PRADEL	1 489x 911

Performance

	Run	Shift
Ø Speed (m / min)		127
Produced m		14518
Produced m ²		32086

	Current	Run	Shift
Efficiency	0		56

Actions

[Exit](#) [Configuration](#)

[MatPrep](#)

[Other Pages](#)

Fig. 11

The toolbox contains the most important production and planning data concerning the corrugator status:

- Run time, downtimes etc.
- Current run: Current and target speed, current lineal meters and target lineal meters
- Performance: Average speed, m produced etc.
- Efficiency

The Expected Speed is used as calculation basis for the expected duration of programs in Program Memory. It should be a realistic value.

The Target Speed is displayed as default value at the corrugator and will usually be higher. If there is no Target Speed specified, the Expected Speed will be used instead.

Options

Transfer to the Dry End Controller



The transfer to the dry end controller can be manual or automatic.

With mouse click you can switch between these two options.

"Automatic" means the programs will be automatically transferred to the corrugator, according to the parameters specified at "Settings for the Transfer to the Corrugator".

Corrugator Control online?



Communication between corrugator and PC-Topp is functioning correctly.



Automatic transfer is has stopped.

For more information on corrugator scheduling see the PC-Topp.NET Corrugator Terminal (link in the tool box).

Morning Shift
08:50
Corrugator Terminal 