



Transfer of Production Messages Finished Goods FGDATA / Work In Progress WPDATA

Field No.	Description	A/N	Length (Bytes)	Offset	Remarks
1	<i>Record Type</i>	A	1	0	0: Initial Production 1: Correction 2: Deletion 3: Shift Change 4: Start Setup 5: Start Run
2	<i>Order Number</i>	A	10	1	
3	<i>Part Number</i>	A	4	11	
4	<i>Job Number</i>	A	1	15	
5	<i>Machine Code</i>	A	6	16	
6	<i>Conversion Step No.</i>	N	1	22	
7	<i>Machine Code Next Step</i>	A	6	23	
8	<i>Program Number</i>	N	7	29	XXXX.YY
9	<i>Number of Outs (this and following)</i>	N	2	36	
10	<i>Number of Outs this Machine</i>	N	2	38	
11	<i>Starting Date (Setup)</i>	A	8	40	DDMMYYYY
12	<i>Starting Time (Setup)</i>	N	4	48	HHMM
13	<i>Starting Date (Run)</i>	A	8	52	DDMMYYYY
14	<i>Starting Time (Run)</i>	N	4	60	HHMM
15	<i>Ending Date</i>	A	8	64	DDMMYYYY
16	<i>Ending Time</i>	N	4	72	HHMM
17	<i>Quantity Scheduled</i>	N	6	76	
18	<i>Quantity Produced (Good)</i>	N	6	82	
19	<i>Waste Quantity</i>	N	6	88	
20	<i>Number of Pallets</i>	N	3	94	
21	<i>Quantity per Pallet</i>	N	5	97	
22	<i>Quantity on Last Pallet</i>	N	5	102	
23	<i>Waste Details</i>	N	20x6	107	20 fields à 6 bytes
24	<i>Pallet Type</i>	A	6	227	
25	<i>Pallet Size</i>	N	9	233	
26	<i>Has Parts to Finish</i>	B/A	1	242	Non-blank if order has non-produced parts
27	<i>Set-Up Hours (excluding breaks, including downtimes during set-up)</i>	N	4	243	HHMM
28	<i>Run Hours (excluding breaks, including downtimes during run)</i>	N	4	247	HHMM
29	<i>Quantity from Stock (before machine)</i>	N	6	251	
30	<i>Quantity to Stock (before machine)</i>	N	6	257	
31	<i>Quantity from Stock (after machine)</i>	N	6	263	
32	<i>Quantity to Stock (after machine)</i>	N	6	269	
33	<i>Good Quantity (all split parts)</i>	N	6	275	
34	<i>Waste Quantity (all split parts)</i>	N	6	281	
35	<i>Set-Up Hours (excluding breaks and downtimes during set-up)</i>	N	4	287	HHMM
36	<i>Run Hours (excluding breaks and downtimes during run)</i>	N	4	291	HHMM

Comments

Generally

- 1) The record layout FG-WP is used for both files FGDATA and WPDATA. These files are written in real time if shop floor data collection (Machine Terminal or Supervisor Terminal) is made by PC-Topp.
- 2) There are six different record types: new production messages (record type 0), modifications (record type 1), deletions of previously published data (record type 2) or partial productions when changing the shift during one run (record type 3); Start Setup (record type 4) and Start Run (record type 5)

Start Setup and Start Run only include the (setup or run) time, without quantity or other times. Shift Change (3), Initial Production (0) and Correction(1) include the quantity.

The usual production process:

- Order starts (4)
- Start Run (5)
- Shift Change (3)
- Order is finished (0)
- Correction (1)

- 3) **FGDATA – Production messages for Finished Goods:** FGDATA only contains records for produced orders that are finished products and can therefore be used as an entry in the finished good stock. PC-Topp writes this file when the last conversion step for this order has been collected. (The exact definition, *when* records are written to FGDATA, is: When the "next conversion step" takes place one of the following machine types shipping machine, palletizer (bander) or if sheets are concerned.

Example: If an order has been produced at first on the corrugator, after that on the first conversion machine and then on a second conversion machine, there will be a record in FGDATA file when the second conversion machine has been the last step and has finished this order. Also for "sheet" orders (no conversion steps) records are written in FGDATA when the corrugator has finished a run (combination). So the record contains the according program number and combination number for "sheet" orders. That's why the same "sheet" order may appear in FGDATA more often than once. The FGDATA user can "add" the sheet quantities of several records for the same order with record type 0.

- 4) **WPDATA - Production messages for Work in progress:** WPDATA only contains records for products not yet regarded as finished but produced on the corrugator or on conversion machines when other conversion steps will follow. The records of this file can be regarded as entry in the work in progress.
- 5) PC-Topp.NET allows to "switch" ON/OFF FGDATA and WPDATA separately and to filter the corrections. So, if a user prefers to get only finished good production messages without corrections or deletions this can be specified in the configuration.



Field	Remark
2,3,4	These fields represent the order number. The field 3 is called "job" number and contains "a" , "b" or a blank. (It will be filled only for "split" orders when an order is scheduled to be run in several steps (i.e. on different days)
8	Only contains program numbers when the record represents a production event that is completely or partially produced on the corrugator.
17	Only contains a quantity when there is a "previous" conversion step. For records representing a production event on the corrugator this field is empty.
23	Waste details are entered individually.