

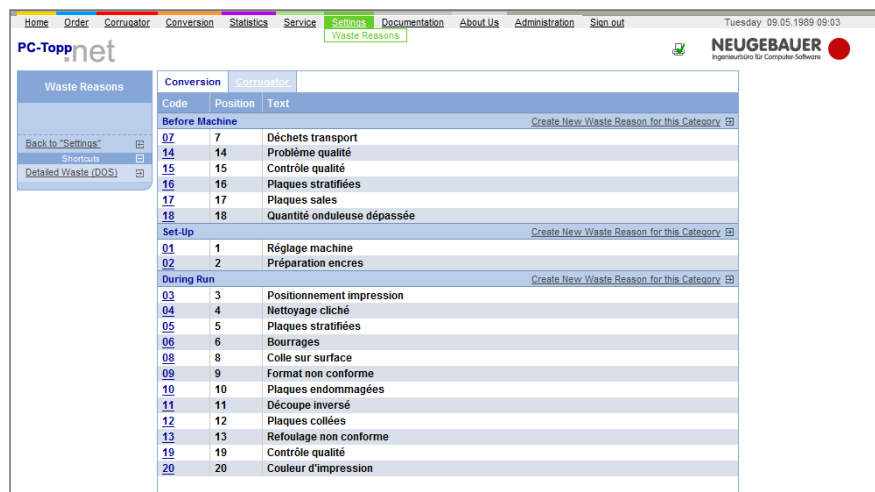
# Detailed Waste Recording

Overview .....	2
Creating Detailed Waste Reasons .....	3
Modifying Existing Detailed Waste Reasons .....	4
Deleting Detailed Waste Reasons .....	5
Entering Detailed Waste at the PC-Topp.NET Machine Terminal.....	6



## Creating Detailed Waste Reasons

To enable the detailed waste feature in PC-Topp you have to define waste reasons in the PC-Topp.NET Waste Reasons page.



Conversion		Corrugator
Code	Position	Text
<b>Before Machine</b>		
07	7	Déchets transport
14	14	Problème qualité
15	15	Contrôle qualité
16	16	Plaques stratifiées
17	17	Plaques sales
18	18	Quantité onduleuse dépassée
<b>Set-Up</b>		
01	1	Réglage machine
02	2	Préparation encres
<b>During Run</b>		
03	3	Positionnement impression
04	4	Nettoyage cliché
05	5	Plaques stratifiées
06	6	Bourrages
08	8	Colle sur surface
09	9	Format non conforme
10	10	Plaques endommagées
11	11	Découpe inversé
12	12	Plaques collées
13	13	Refoulement non conforme
19	19	Contrôle qualité
20	20	Couleur d'impression

The page offers three different categories of waste reasons describing the production steps where waste can occur:

- Before Machine
- Set-Up
- During Run

### ◆ Maximum of 20 Waste Reasons

PC-Topp.NET supports a maximum of 20 reasons for detailed waste. You can create your own waste reasons within the three categories listed above and assign them to one of the 20 available positions.

A waste reason is defined by the following characteristics.

- **Code**
  - Short label for the waste reason.
  - Enter an alphanumeric value (6 characters maximum).
- **Position**
  - Defines which position the waste reason has in the list of 20 possible waste reasons.
  - Enter a numeric value (between 1 and 20).
- **Text**
  - The text describing the waste reason (e.g. “Board delaminated”).
  - Enter a short phrase (40 characters maximum).

- **Type**

- Defines the category the waste reason belongs to (Before Machine, Set-Up, During Run).
- Is automatically assigned by clicking “Create New Waste Reason for this Category”

◆ **For Users of Personalized Machine Terminals**

If you have been using a personalized Machine Terminal please note that in the new Detailed Waste Reasons feature the fixed descriptions for the 20 available waste reasons in the personal Machine Terminal screen are replaced by the description texts you can freely enter in the “Text” field.

This means that in the statistics the new texts appear instead of the old descriptions too. So it is very important to name your waste reasons exactly as they were in the personalized screen if you want to go on using your waste reasons and your waste statistics as they were.

You can freely name your waste reasons as you like if

- you don't need your past waste statistics anymore and want to start recording detailed waste again from scratch
- you haven't done any detailed waste entry so far.

### Modifying Existing Detailed Waste Reasons

Much in the same way as creating your waste reasons you can edit (and delete) existing waste reasons in the Waste Reasons page by clicking the code of any waste reason. (For details on deleting waste reasons see next chapter.)

◆ **Be Careful When Modifying Existing Waste Reasons.**

Please note that modifications of existing waste reasons affect the waste statistics of the complete past. E.g. if you decide that the waste reason “Wet board” isn't needed any more and rename it to “Warped board” then all

figures for “Wet board” in the waste statistics before the change will show as “Warped board” which is of course misleading.

Therefore you shouldn’t replace an existing waste reason with a new one if you want to keep your statistics consistent.

(On the other hand, it is o.k. to change the text of a waste reason if you have a better description for it.)

### Deleting Detailed Waste Reasons

#### ◆ Deleted Waste Reasons Are Only Deactivated.

If you delete an existing waste reason it is not irreversibly removed from the list of waste reasons. As a precaution it is only deactivated.

This means it isn’t available at the Machine Terminal any more (to prevent further waste entry) but stays visible in the waste statistics along with its waste figures.

#### ◆ How to Reactivate Deleted Waste Reasons

Deleted waste reasons can be reactivated. To do so click the Toolbox link “Show Deleted Causes”. If you have administrator rights you can display all deleted waste reasons. In this mode you have two options:

- “**Undelete**” reactivates deleted waste reasons.
- “**Kill**” removes deleted waste reasons for good.

#### ◆ Be Careful When Using “Kill”.

Before permanently deleting a waste reason with “Kill” you should consider the following:

- **Really deleting a waste reason** with “Kill” means that in the waste statistics the quantity for the deleted waste reason is still available but permanently loses its description, i.e. you can’t see why it occurred anymore.
- **Deactivating a waste reason** with “Delete” means that in the waste statistics the quantity for the deleted waste reason is still available along with its description.

◆ Deleted Waste Reasons Keep Their Position.

You should also keep in mind that a deleted waste reason still occupies its position so you can't assign the position to a different waste reason.

(Already assigned positions can only be cleared by using "Kill". Please be aware that this will delete the description of the removed waste reason in your statistics data, as mentioned above. When you reassign this cleared position the description of this new reason will be applied to the statistics data for the deleted waste reason.)

### Entering Detailed Waste at the PC-Topp.NET Machine Terminal

In the Machine Terminal General view there are three buttons for detailed waste entry which correspond to the three categories of waste "Before Machine", "Set-Up", and "During Run".

The screenshot shows the PC-Topp.NET Machine Terminal interface. The top left displays the shift information: Morning Shift 08:24. The machine is currently Running. Performance metrics show a Target Speed of 2300 and a Current Speed of 3000. The Shift Produced is 1662. The current order is 615180 from UNIVERSAL PLANT, with 4797 sheets scheduled, 327 produced, and 1 sheet out. The interface also shows production data: 4797 Scheduled, 4797 Available, 327 x 1 = 327 Currently Produced, 0 / 35 Pallets, and 4797 Total Expected. Three buttons are circled in red: 'Waste Before', 'Set-Up Waste', and 'Prod. Waste'. The interface also shows order details for 'UNIVERSAL PLANT' and various technical specifications.

- Button "Waste Before" = category "Before Machine"
- Button "Set-Up Waste" = category "Set-Up"
- Button "Prod. Waste" = category "During Run"

When you click one of the buttons only waste reasons of the corresponding category are available for entry.

The quantity of waste entered for the corresponding waste reason is immediately taken into account for

- calculating the correct number of sheets (or products) into resp. out of the machine
- showing the waste quantity for this waste reason in sheets (or products) and m<sup>2</sup> in the Detailed Waste report.

SH' RH	Passes m <sup>2</sup>	Av. Out	Waste <sup>2</sup>		Régla ge machi	Prépa ration encre	Positi onne ment	Nettoy age cliché	Plaqu es stratifi	Bourr ages	Déche ts trans	Colle sur surfac
			Before Qty/m <sup>2</sup>	Prod. Qty/m <sup>2</sup>								
5'46	6,001	1.00	67	104							67	
2'00	11,180		147	170							147	