

How do I know if a corrugator program contains underruns?

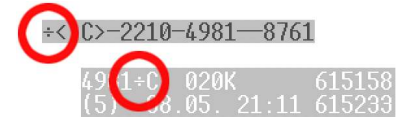
The ÷ sign lets you find the underruns.

All finished schedules in Program memory have a star to the left of the Program Number that marks them as completed.

If a program has an incomplete star (the symbol ÷) in that spot, then that program was not completed correctly: Either one or several runs are severely underrun, or were not run at all.

Of course, the currently running program (highlighted in blue) always has this mark because it is being produced right now thus is only partly finished.

So, look out for grey programs that are marked with the symbol ÷. In these programs something went wrong, and the orders have not been completed.



Why does it matter if there are underruns among the produced programs?

Obviously, if a schedule was run short or parts of a schedule were not produced at all, then there will not be the expected quantity of finished goods to deliver to the customer.

Often, you will have to re-run the order in conversion at a later time, which means that time is wasted for a second set-up on each machine.

Alternatively, you may have to wait for a re-run on the corrugator, which may mean that the order doesn't get finished on time.

Clearly, a slight underrun can be tolerated. PC-Topp flags only such underruns where more than 10% of the run were not made. (More precisely: A run is classified as underrun if it lacks more than 10% [short runs] or 500m [long runs] of its scheduled meters.)

There is an underrun but the quantity looks like before ...

As long as there is hope that the run might come back, PC-Topp keeps the quantities for conversion unchanged.

When the corrugator does not finish a run and continues with something else, PC-Topp "hopes" that the crew will come back to that run and finish it later.

With an on-line connection to the corrugator, this is correctly recognized, and the additional meters for the run are added to what was produced earlier.

On the Corrugator Terminal, too, the operator can select any of the grey runs as "current run" and enter additional meters.

Therefore, it is right that the quantity that goes into conversion is not reduced immediately. PC-Topp needs you to accept the underrun before it will adjust the quantities.

How do I accept an underrun?

Use Production Data Entry to accept each underrun!

You must confirm that the run will not come again by using **Production Data Entry** in Program Memory. This will reduce the quantity going into the first conversion machine to the quantity actually produced on the corrugator.

Action	Shortcut
1. Select VIEW, then COMBINATION	ALT + V, then C
2. Place the cursor on the run that will remain incomplete	
3. Select TRANSFER, then PRODUCTION DATA ENTRY	ALT + T, then P
4. Select CONTINUE in the alert message asking you to re-check your selection.	C

If you forget this step, then PC-Topp still adjusts the quantities at the moment when you delete the schedules that contain underruns – from that moment on there is really no hope that the operator will come back to continue the run that was run short.

What do I do if a run in a produced program has been completely left out?

Use Un-number Programs to manage omitted runs!

Determine if the run only appears to have been left out because there is a mistake in the transferred data. If the run turns out to have been produced after all, you can simply declare it produced as explained above.

If the run has actually been omitted, you have to take it out of the produced program by un-numbering it:

Action	Shortcut
1. Select VIEW, then STANDARD	ALT + V, then T
2. Place the cursor on the program containing the omitted run.	
3. Select TRANSFER, then UN-NUMBER PROGRAMS	ALT + T, then U

The left-over run is then displayed without a program number and scheduled starting time. Now you can decide whether to remove it or to reschedule it for production.