

RotoEdge Pro

Version 1 | User Manual



RotoEdge Pro LLC



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Dashboard

Your Plant at a Glance

This display of your plant's efficiency focuses on all Conforming and Non-Conforming parts yielded over the current calendar month across each stage of production.

-  Gross Quantity of Conforming parts
-  Gross Quantity of Non-Conforming parts
-  Percentage of Non-Conforming parts yielded in each department
-  Percentage of Non-Conforming parts yielded at each production stage



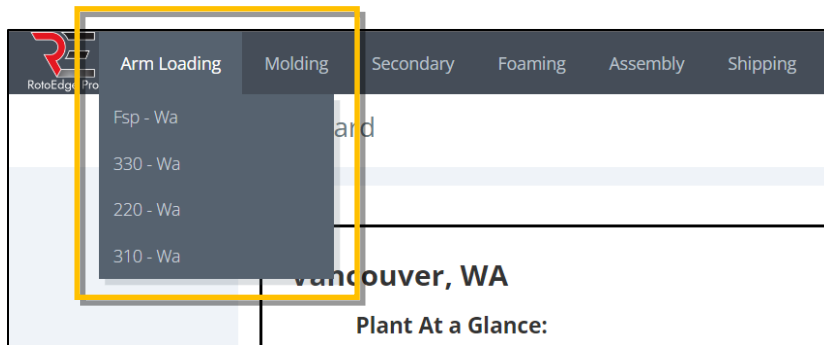
-  Indicates either a machine or secondary line is operating at an efficient rate.
-  Indicates either a machine or secondary line is operating at an inefficient rate.

Arm Loading

Allows operators to manage molds on each machine/arm.

Drop-Down Menu

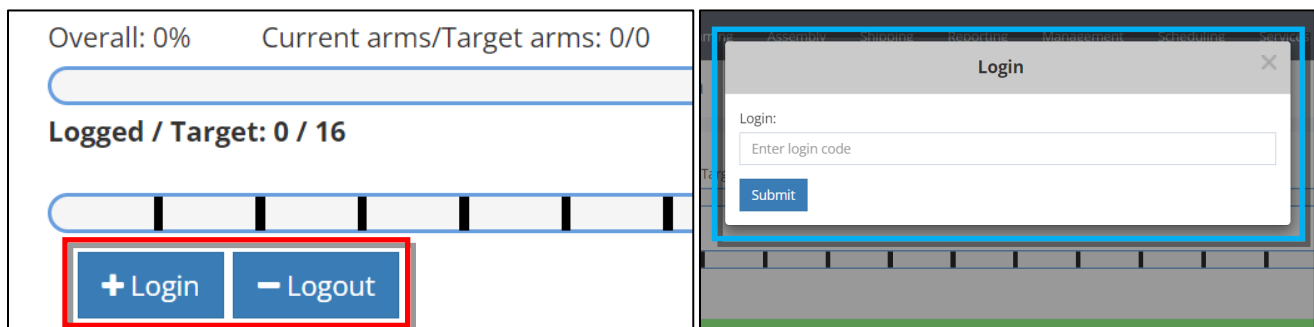
-  The Arm Loading tab lists each of your facility's active machines. Select one of these options to open the Arm Loading page specific to your chosen machine.



Logging In & Out

Enables operators and workers to enter their unique employee code. This will attach a worker's profile to all subsequent work performed on a machine or line over the course of their shift.

-  Toward the top of the page are two buttons labeled "+ Login" and "- Logout."
-  Clicking one of these options will open a window requesting a worker's 4-digit Login Code.



Machine Arms

- ➡ Listed numerically are the individual arms of your selected machine.
An arm will be colored green if it is within capacity, or red if the molds exceed an arm's capacity.
- ➡ The required temperature, cook, takt, and cooling times of your attached molds are displayed on the arm, as Cycle Info.

The screenshot displays three machine arms, each with a green header bar containing cycle information. A red arrow points to the 'Cycle Info' text in each header. A blue arrow points to the 'Actions' button in the top right of each header. Below each header is a yellow message box and a table of mold details.

Arm 1: Cycle Info: (Temp: 575, Min: 22) - Takt time: 27.0 minutes - Cooling time : 24.0 minutes. Message: We need to add on the 100 Gal Fuel Tank(10313-002) to this arm. MK 11/16/23. Open Channel | Acknowledge Message.

01-10314-002 150 Gal... 0020414	01-10677-001 Tank E1... 0020543	66 Available
QTY: 19	QTY: 50	

Arm 2: Cycle Info: (Temp: 550, 525, Min: 18, 20) - Takt time: 12.0 minutes - Cooling time : 20.0 minutes.

01-10074-001 SwingSm... 0018997	01-10483-001 2-Step ... 0019524	72 Available
QTY: 60	QTY: 50	

Arm 3: Cycle Info: (Temp: 535, Min: 23) - Takt time: 20.0 minutes - Cooling time : 25.0 minutes.

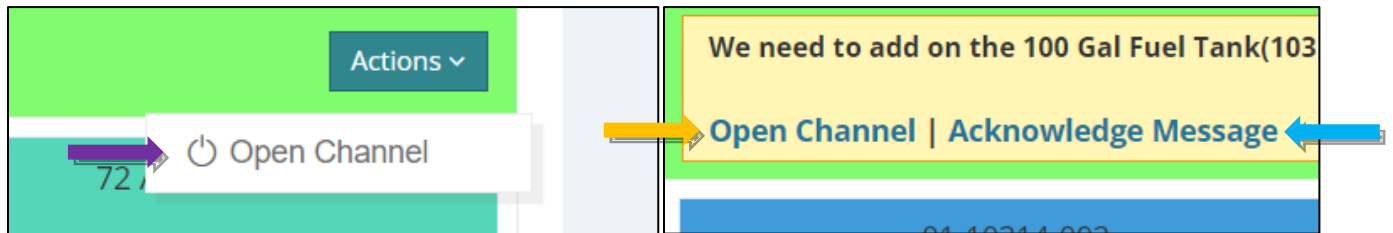
In the upper left corner of the machine is a button labeled “Actions.” Selecting this will launch a page listing your machine’s productions status is in terms of both arms logged and units molded.

The screenshot shows the 'Machine Report: 330 - WA' page. On the left, a yellow arrow points from the 'Actions' button on the machine screen to the report page. The report page has a 'Machine Shutdown' status indicator. It displays production logs for 1st, 2nd, and 3rd logged units, each with a target of 0/0. Below the logs are 'Back', 'Submit', and 'Reset' buttons. A table titled 'Molded Units' is shown with columns: Item, Mold, Arm, Order, Total Ordered, Conforming, N/C, Shift, User, Timestamp, Edited Time, Deleted Time, and Action. The table currently shows 'No Data Record'.

Open Channels

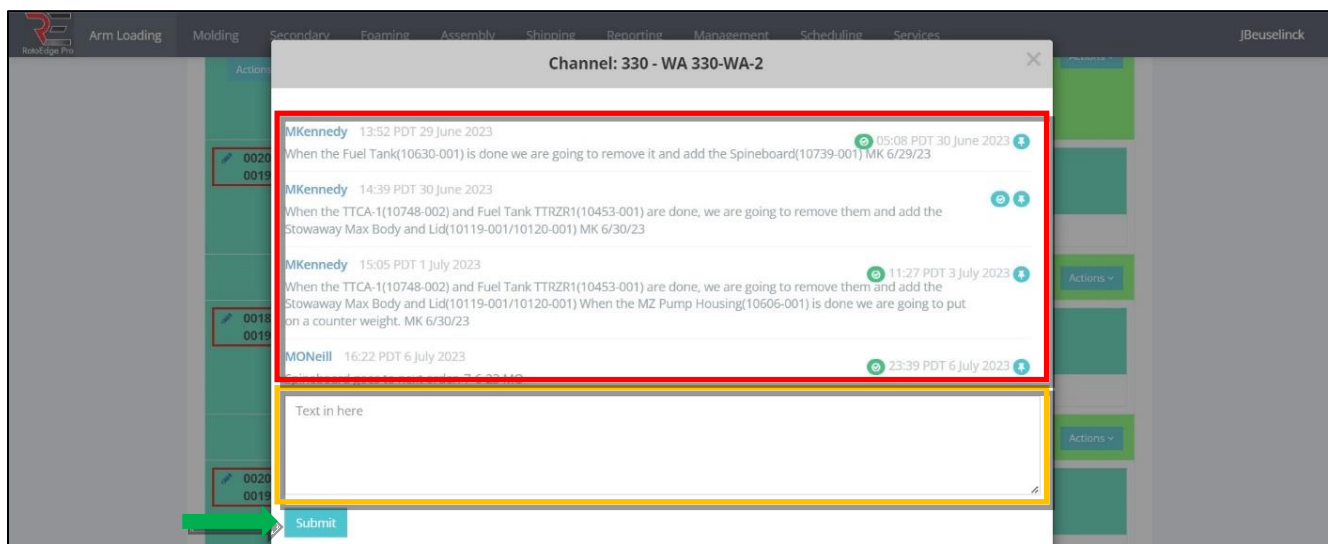
Available on each machine arm is the ability for operators and admins to communicate specific messages by using Open Channels:

- ➡ Click the “Actions” button located on the right-most section of a given arm.
- ➡ Or select “Open Channel” on a message already posted.
- ➡ Choose “Acknowledge Message” to add a message to the archive.



After selecting one of the Open Channel options, a window will launch

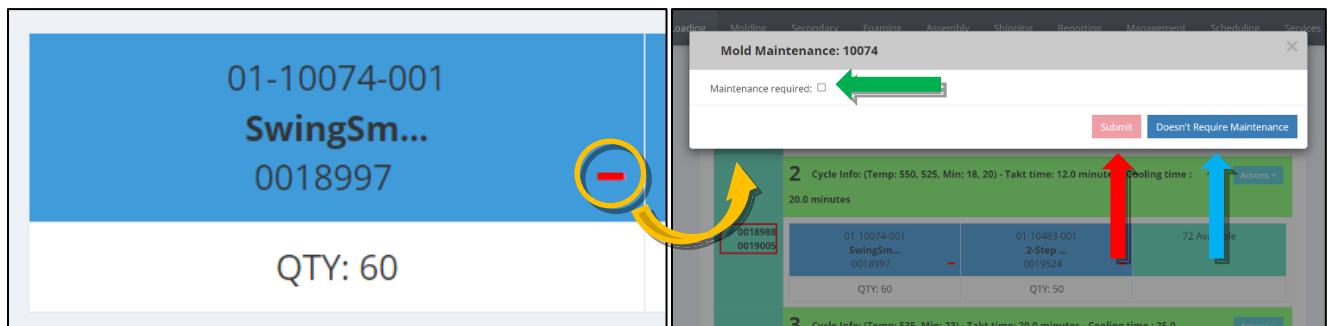
- Use the text field to compose a new message.
- ➡ To post your message, click “Submit.”
- Included is an archive list of previously posted messages.
- Ⓢ Indicates that a message has yet to be acknowledged. Click to acknowledge.
- Ⓢ Indicates that a message has been acknowledged. Click to un-acknowledge.
- 📌 Select to pin a message within the Archive.



Loaded Molds

A loaded mold will be shown below the arm to which it is currently attached, listing its description, item and order numbers.

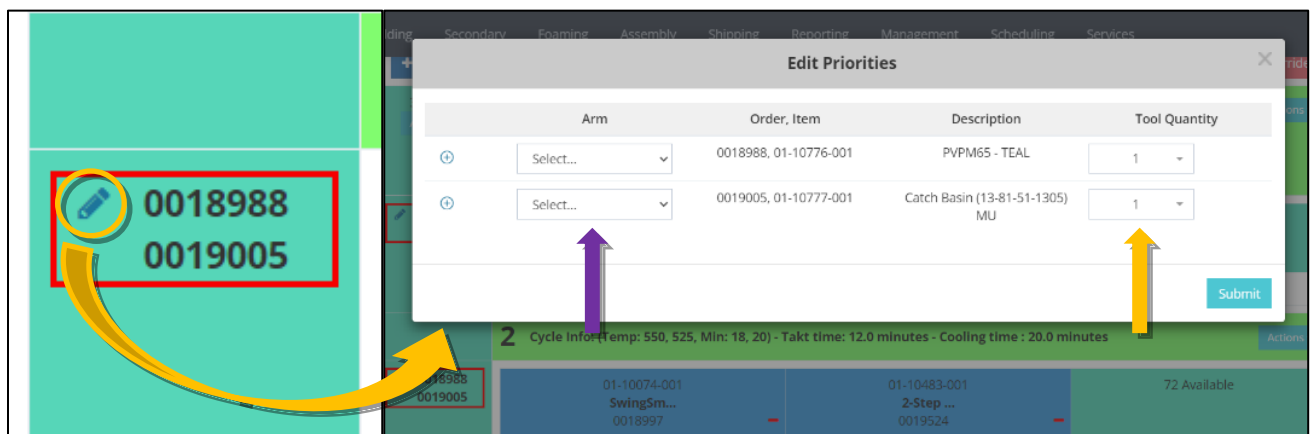
-  Select to remove a mold from an arm.
-  Assign “Maintenance Required” to the mold in question, if applicable.
-  Or choose “Doesn’t Require Maintenance”
-  Click “Submit” when done.



Priority Molds

To the left of each machine arm, listed within a red box, are priority molds staged to be loaded once the current mold cycle is complete.

-  Select to launch the Edit Priorities window.
-  Add a priority mold to an arm.
-  Change the arm to which the priority mold is currently set.
-  Adjust the tool quantity.



Active Molds List

Located at the bottom of the page is a list of Loaded Molds and Priority Molds.

- ➡ Loaded Molds are colored grey, and will have a green “Check” attached.
- ➡ Primary Molds are colored yellow, and will have a black “Pin” attached.
- Expected Ship Date of item(s).
- Remaining balance of items left to mold before the order is complete.
- Number of molds loaded / number of molds available
- A user can select a specific item number to deploy the item’s Setup Sheet.
This is a printable, comprehensive description of a specific part.
- Clicking the “Actions” button located on the right side of a listed mold, will open a drop-down menu with multiple options specific to a chosen mold.

	Order	Item	Description	Ship Date	Balance	Loaded	Action
➡	✓ 0020414	01-10314-002	150 Gal Fuel Tank(SS)-XL NAT	12/13/2023	20	1/1	Actions ▾
➡	✓ 0020543	01-10677-001	Tank E18004-A07 - BLACK LLDPE	01/01/2024	47	1/1	Actions ▾
➡	✚ 0020206	01-10313-002	100 Gallon FuelTank(SS)-XL NAT	09/06/2023	25	0/1	Actions ▾
➡	✚ 0019884	01-10606-001	MZ Pump Housing Hopper-GRANITE	10/10/2023	50	0/1	Actions ▾

10/26/2023
60
1/2
Actions ▾

➡ Kick Back to Molding Plan
➡ Flag Tool For Maintenance
➡ Assign to Arm
➡ Print Powder Label
➡ Unload all related molds

10/10/2023
50
0/1
Actions ▾

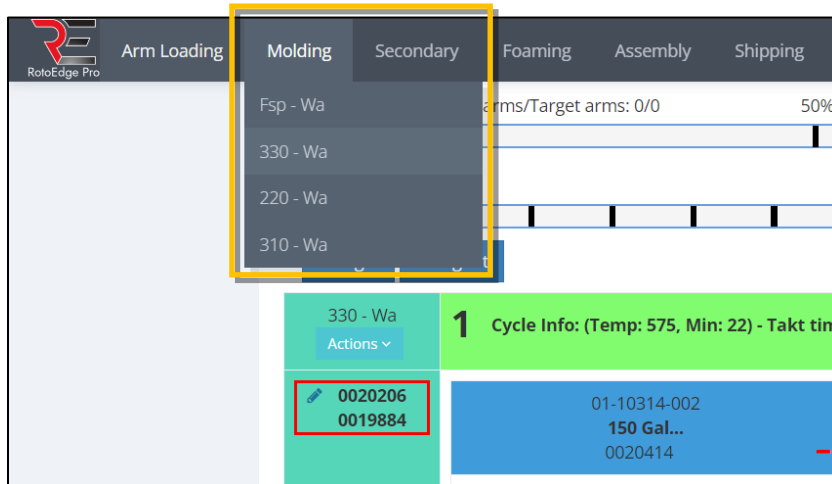
➡ Reschedule
➡ Kick Back to Molding Plan
➡ Flag Tool For Maintenance
➡ Assign to Arm
➡ Print Powder Label

- ➡ Completely removes a mold from a machine.
- ➡ Indicate which molds require attention from maintenance.
- ➡ Select to which arm you want to move a mold.
- ➡ Send Powder Labels to your DYMO printer.
- ➡ Select to choose either a new machine or new spot on the priority list.
- ➡ Unload all molds, from machines, with matching item numbers.

Molding

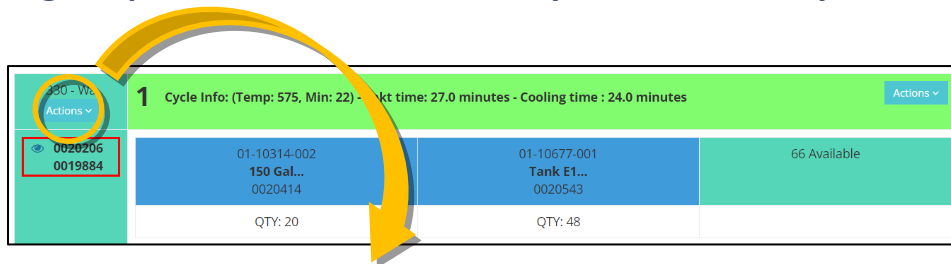
Drop-Down Menu

 The Molding tab lists each of your facility's active machines. Select one of these options to open the Mold Production Log page specific to your chosen machine.

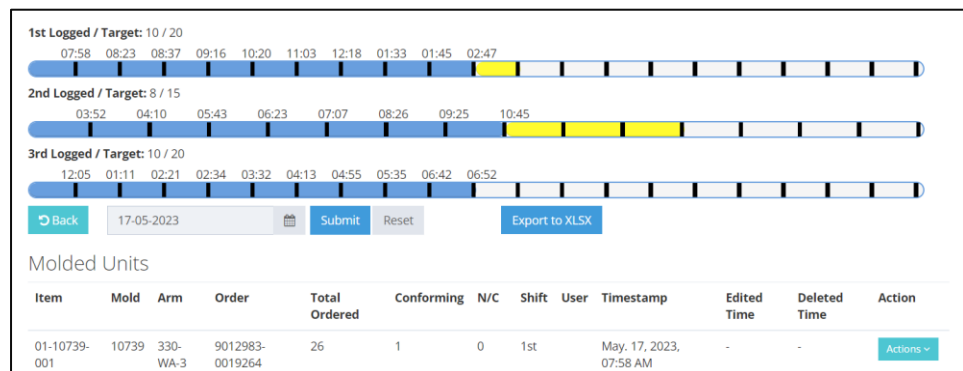


Mold Production Log

Log the production of molds already on each arm of your machine(s).

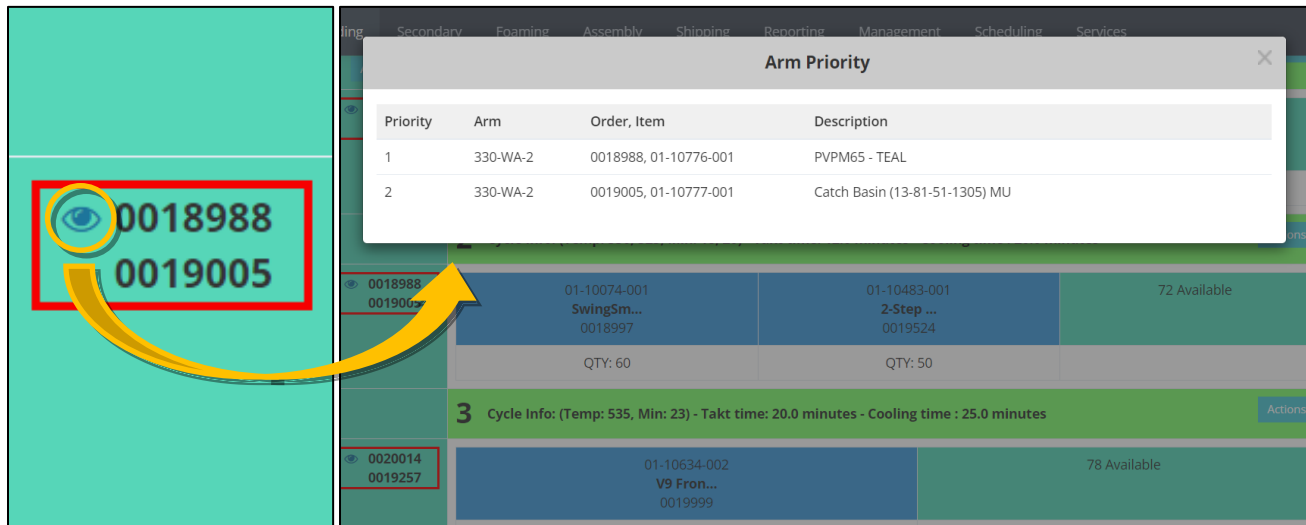


Select the “Actions” button to launch a Machine Report. This includes Logged Arms, Molded Units, and Skipped Arms.



Priority Molds

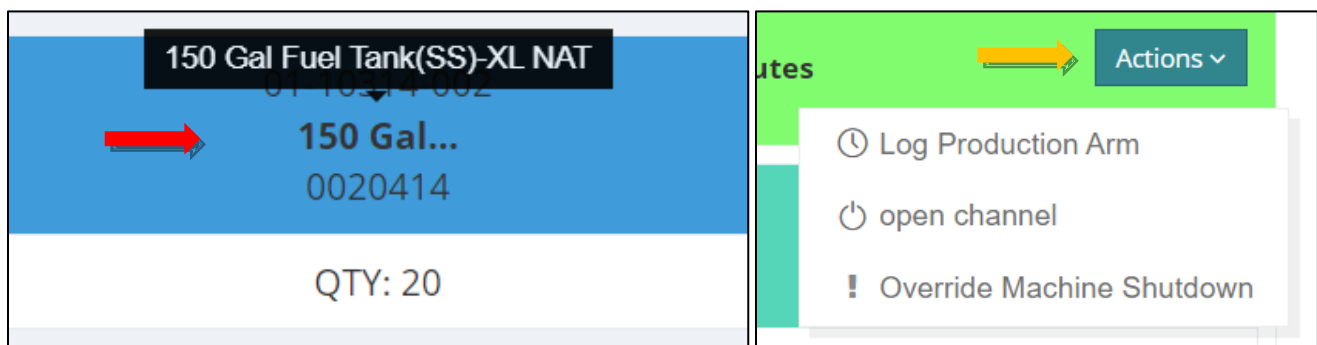
To view the details of an arm's Priority Orders, click the “eyeball” icon located within the red box on the left of a machine arm. This will launch an “Arm Priority” window listing a Priority Order and Item number, as well as a description.



Logging Production

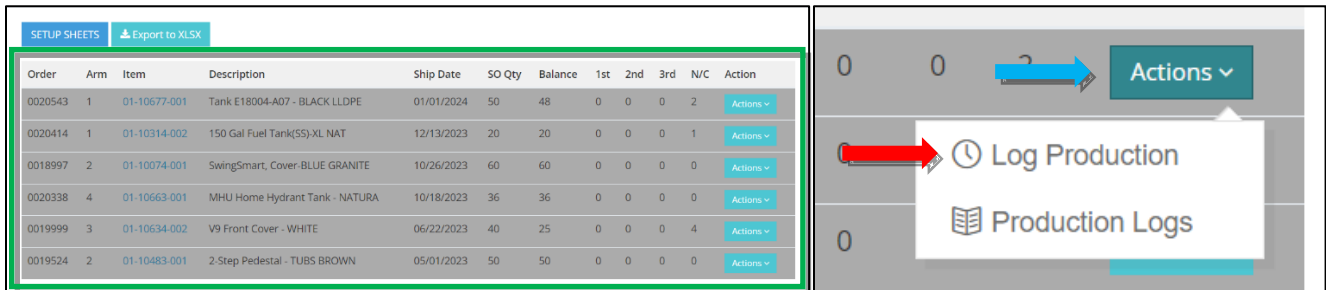
Logging production of an arm is the main function of the Molding section of RotoEdge Pro. To log the production of arm an operator can either:

- ➡ Click on a “Loaded Mold.”
- ➡ Or select “Actions” on the far-right of an arm, then Choose “Log Production Arm.”



Admin users have the ability to log individual items, when necessary, by:

-  Scroll down to the list of loaded molds located at the bottom of the page.
-  Then click the “Actions” button located to the far-right of a mold.
-  Choose “Log Production” From the drop-down menu.



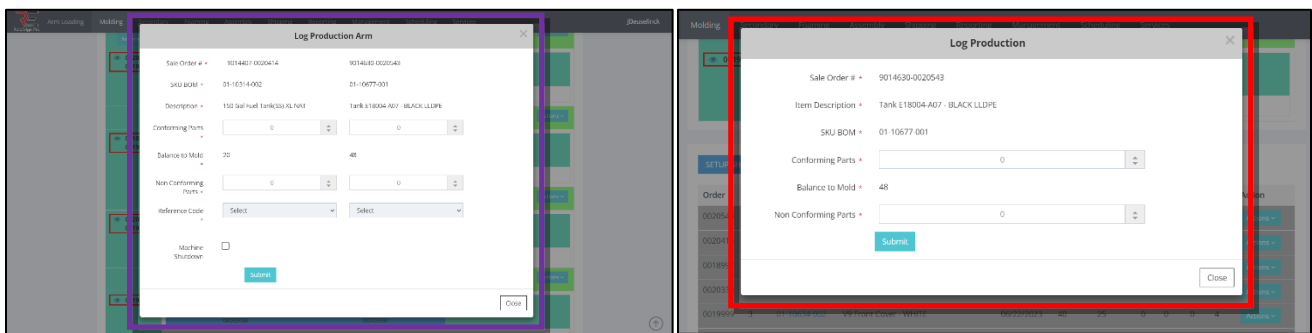
Order	Arm	Item	Description	Ship Date	SO Qty	Balance	1st	2nd	3rd	N/C	Action
0020543	1	01-10677-001	Tank E18004-A07 - BLACK LLDPE	01/01/2024	50	48	0	0	0	2	Actions
0020414	1	01-10314-002	150 Gal Fuel Tank(55) XL NAT	12/13/2023	20	20	0	0	0	1	Actions
0018997	2	01-10074-001	SwingSmart, Cover-BLUE GRANITE	10/26/2023	60	60	0	0	0	0	Actions
0020338	4	01-10663-001	MHU Home Hydrant Tank - NATURA	10/18/2023	36	36	0	0	0	0	Actions
0019999	3	01-10634-002	V9 Front Cover - WHITE	06/22/2023	40	25	0	0	0	4	Actions
0019524	2	01-10483-001	2-Step Pedestal - TUBS BROWN	05/01/2023	50	50	0	0	0	0	Actions

This function is not available to staff level permissions. Only admins.

Log Production Windows

After following one of the processes for logging production, a user will be faced with one of two windows.

-  Log Production Arm: used to log the production of an entire arm.
-  Log Production: used to log the production of an individual mold.



Available to all staff permissions.

Available only to admin users.

Both windows include details on the listed mold(s), such as Sale Order number, Item Description, Item Number and Balance to Mold (remaining amount on order).

Log Production & Log Production Arm Windows (Continued)

The Log Production windows require that a user categorizes the items yielded as either Conforming or Non-Conforming.

Conforming Parts

Logging a part as Conforming states that the part meets the necessary specifications to move into the Secondary and/or Assembly phase.

Non-Conforming Parts

Logging a part as Non-Conforming is to express a defect or imperfection with the part(s) yielded, thus adding it to the Scrap Log to await further attention.

State the quantity of Conforming and/or Non-Conforming parts yielded, either by:

➔ Using the toggles on the right side of either text field.

➔ By typing the quantity of parts directly into the text field.

☐ If one or more parts are classified as Non-Conforming, the Log Production window will extend an option to add a Reference Code. This asks users to designate why the part was classified this way.

The screenshot shows the 'Log Production' window. It contains the following fields and elements:

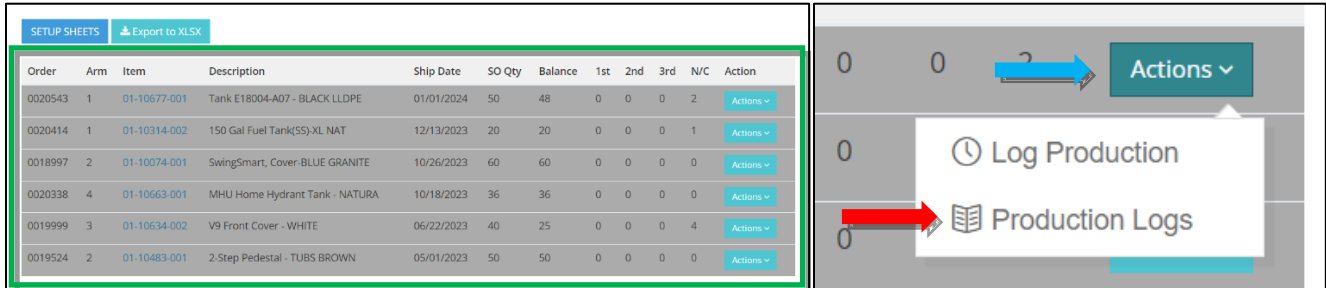
- Sale Order #**: 9014630-0020543
- Item Description**: Tank E18004-A07 - BLACK LLDPE
- SKU BOM**: 01-10677-001
- Conforming Parts**: A text field with '0' and a red arrow pointing to the up/down toggles on the right.
- Balance to Mold**: 48
- Non Conforming Parts**: A text field with '0' and a yellow arrow pointing to it. A blue box highlights this field, and a blue arrow points from it to a dropdown menu.
- Submit**: A green button with a green arrow pointing to it.
- Close**: A button at the bottom right.
- Reference Code Dropdown**: A list of codes including BH, CO, CS, FA, GR, MI, PI, SS, EM, AD, CU, DM, and FIA.

➔ Click "Submit" when the total quantity of parts is tallied. All parts will then be added to the Production Log with corresponding stickers printed as well. Non-Conforming parts will be added to the Scrap Log.

Production Logs

To access Productions Logs a user will:

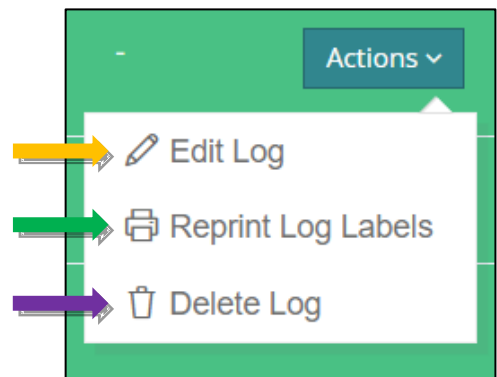
-  Scroll down to the list of loaded molds located at the bottom of the page.
-  Then click the “Actions” button located to the far-right of a mold.
-  Choose “Production Logs” From the drop-down menu.



A complete list of logged items, Conforming and Non-Conforming, will be launched for the specified order.

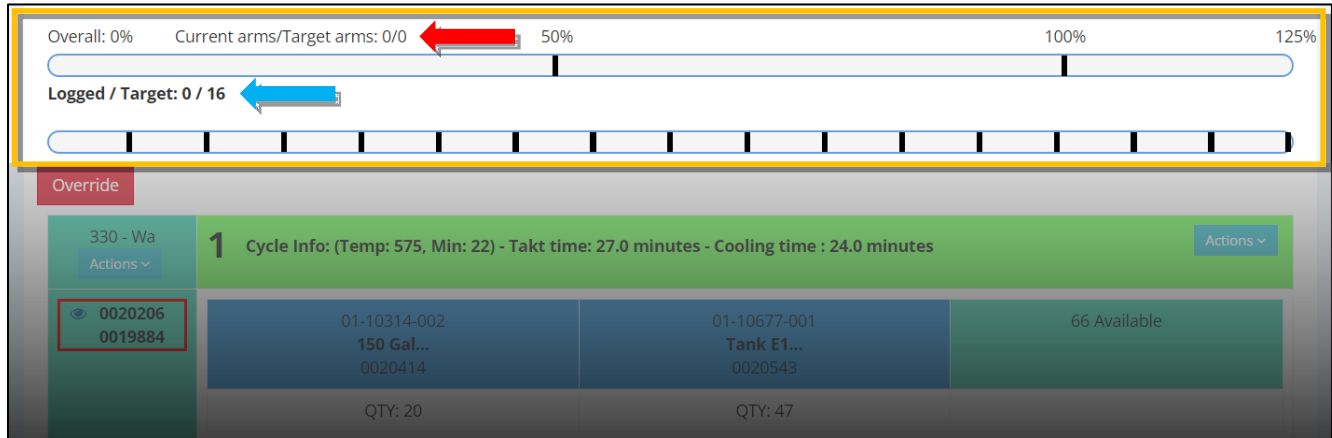
Item	Machine	Factory	Order	Total Ordered	Conforming	N/C	Shift	User	Timestamp	Edited Time	Deleted Time	Action
01-10677-001	330 - WA	Vancouver, WA	9014630-0020543	50	1	0	2nd	Joe Beuselinck	Nov. 27, 2023, 03:41 PM	-	-	Actions ▾
01-10677-001	330 - WA	Vancouver, WA	9014630-0020543	50	0	1 - BH	1st	Joe Beuselinck	Nov. 27, 2023, 01:25 PM	-	-	Actions ▾
01-10677-001	330 - WA	Vancouver, WA	9014630-0020543	50	0	1 - BH	1st		Nov. 22, 2023, 10:39 AM	-	-	Actions ▾
01-10677-001	330 - WA	Vancouver, WA	9014630-0020543	50	1	0	1st		Nov. 22, 2023, 10:33 AM	-	-	Actions ▾

-  Click “Actions” to open item options.
-  Launch Production Logs - Edit page (full screen version of Production Log windows - see Pages 11-12) to change any details of a logged item.
-  Reprint Log Labels
-  Delete Log



Progress Bars

 Located at the top of both the Arm Loading and Molding pages are two progress bars that track logged arms during a given shift.



cvb

After all parts loaded to an arm have completed a cycle and been logged, either as Conforming or Non-Conforming, the results will be posted as follows:

 Gross number of arms logged over the course of a shift. This progress bar is visible to both operator and admin users.

 Logged arms against time lapsed over the course of a shift, presented as a completion percentage. This progress bar is only visible to admin users.

 Example:

If the goal for an 8-hour shift is to log 10 arms

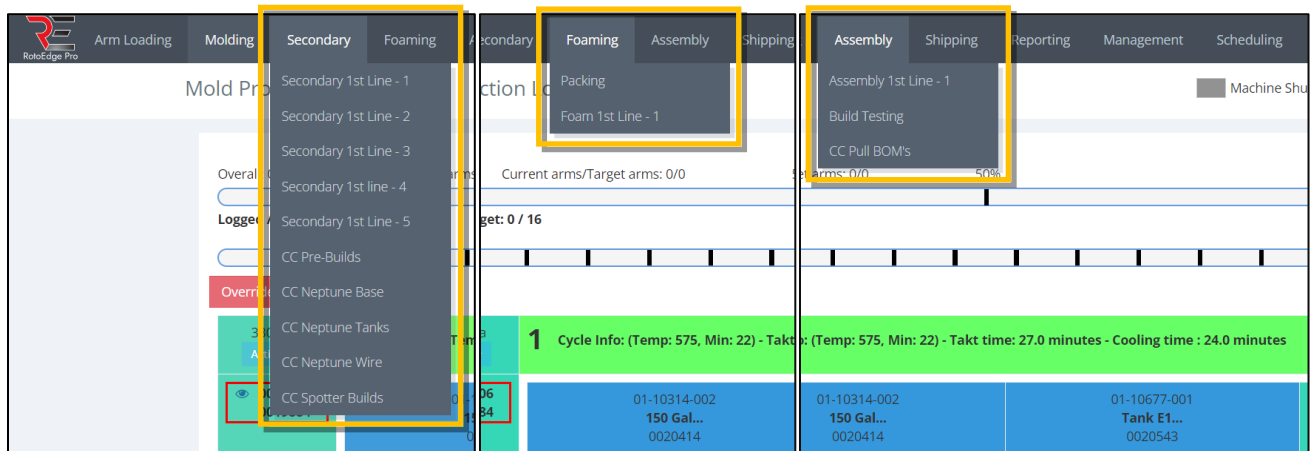
- 3 arms logged after 2 hours = 120%
- 3 arms logged after 4 hours = 60%
- 3 arms logged after 8 hours = 30%

 This is a tool for admins to track the level of efficiency of a worker, machine or a mold process.

Secondary, Assembly & Advanced Operations

Drop-Down Menu

 The tabs are organized by your facility's individual secondary, foaming and assembly lines.



Line Plan

When workers begin their shift, they'll address list items from top to bottom.

 Green items show the total quantity of planned parts is completed and logged.

 Yellow line items indicate the partial completion of an item quantity.

 White line items have had no secondary action taken.

Priority	Order	Item	Description	Balance	Available	Quantity	Completed	Tak time	Per Group
1	M92779	68- Cobra1-T1	Cobra 10.0 Solution Tank	0	0	10	10	10	100.0
2	0018806	01-10765-001	Pegasus Rec Tank - FILTRIFI	39	14	5	5	12	60.0
3	M92753	68-30004-B	PE220 Base	0	0	5	5	25	125.0
4	M92775	68-10009-T2	Cobra 10.0 Recovery Tank Mate	10	10	10	0	10	0.0
5	0020414	01-10314-002	150 Gal Fuel Tank(SS)-XL NAT	20	0	10	0	18	0.0
6	M92780	42B-00031	Heater Assembly 1750W 120V	10	10	10	0	10	0.0
7	M92752	68-30004-T	PE220 Mate	3	3	3	0	25	0.0
8	M92755	42B-00034	PE220 SWITCH PLATE	5	5	5	0	10	0.0
9	M92756	42B-00031	Heater Assembly 1750W 120V	2	2	2	1	10	10.0

Logging Secondary, Foaming & Assembly Items

To log an item, a user has two options:

- If an item is listed on the Line Plan, click on the Order Number located on the left side of the part listed. A Log Production window will launch.
- Using the search bar in the upper right-hand corner of the page, enter either the Order or Item Number of the part you're looking for.
- In Assembly, these numbers are actionable and will launch a BOM window when clicked.

Order Number	Item Number	Description
6	M92780	42B-00031
7	M92752	68-30004-T
8	M92755	42B-00034
9	M92756	42B-00031

Search Order/SKUBOM Q

Override

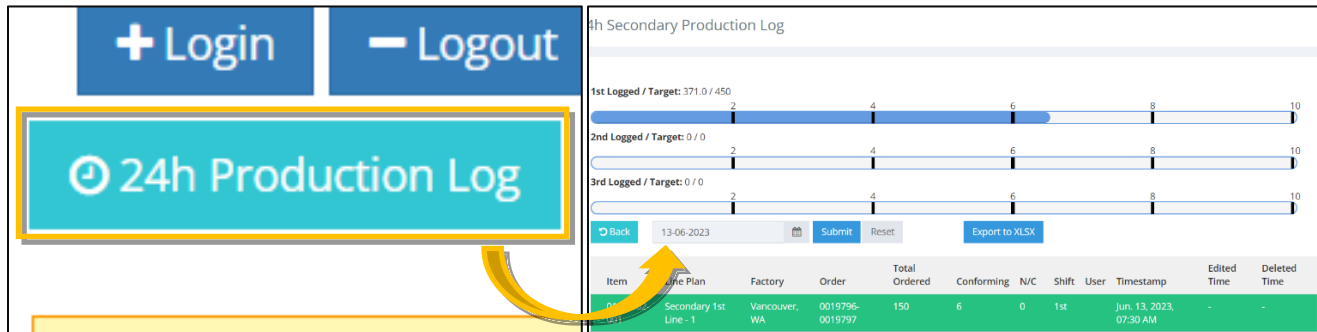
- The results from the search bar will appear at the bottom of the page in the Secondary Log. To log the item(s) either:
- ➡ Click on the Order Number located on the left side of the part listed.
- ➡ Select “Actions” on the right side of a listed part and choose “Log Production.”

Secondary Log

Order	Item	Description	Balance	Available	1st	2nd	3rd	N/C	Action
0019761		PVU-55 (13-81-51-1123) - TEAL	81	7	0	0	0	0	Actions ▾ +
0019754	01-10630-001	Fuel Tank - XL Natural	6	1					⌚ Log Production ⌚ Assign Planning Line
0018987	01-10776-001	PVPM65 - TEAL	88	26	0	0			Actions ▾ +
0018599	01-10770-001	PVU-68 (NB) - TEAL	80	5	0	0	0	0	Actions ▾ +
0018520	01-10672-001	PVU60, 13-81-51-1105 - TEAL	57	2	0	0	0	0	Actions ▾ +
0018282	01-10749-001	ATK Turbo Inlet Pipe - XL BLAC	40	9	0	0	0	8	Actions ▾
0017962	01-10757-001	RT-PVU Vault - TEAL	79	3	0	0	0	0	Actions ▾
M92780	42B-00031	Heater Assembly 1750W 120V	10	10	0	0	0	0	Actions ▾ +
M92778	68- Cobra1-T2	Cobra 10.0 Recovery Tank	10	10	0	0	0	0	Actions ▾
M92777	68-10009-B	Cobra 10.0 Base	10	10	0	0	0	0	Actions ▾
M92776	68-10009-T1	Cobra 10.0 Solution Tank Mate	10	10	0	0	0	0	Actions ▾

24-hour Production Log

 Located above the Line Plan is a button marked “24h Production Log.” Select this button to launch a comprehensive list of logged items.

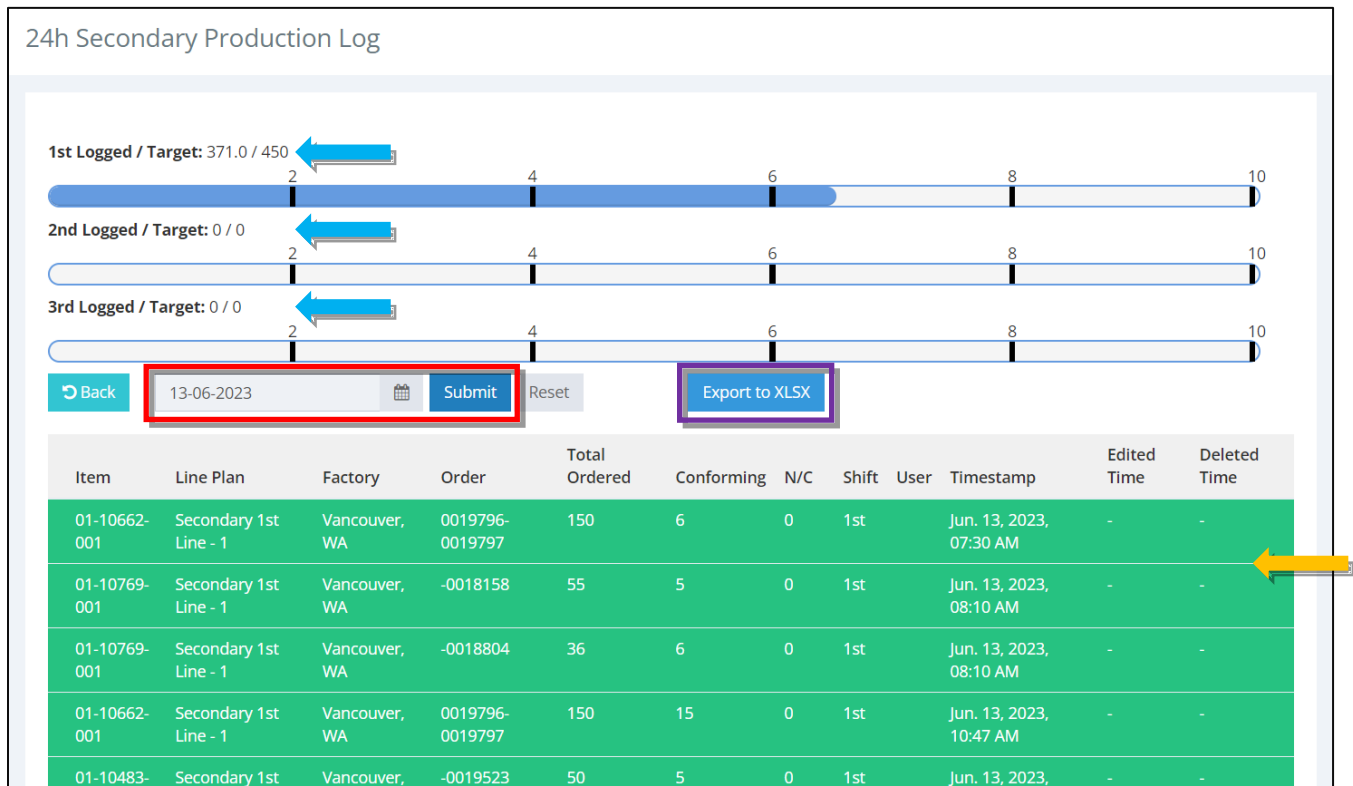


 Track the quantity of parts logged against the goal of a shift.

 Select date you wish to view.

 See logged parts in list format.

 Export list to a Microsoft Excel sheet.



Shipping

Shipping Production Log

Upon selecting the Shipping tab, a user will be presented with the Shipping Production Log, showing a list of parts logged by Secondary, ready to be shipped.

To log an item, either:

-  Click the item's Order Number
-  Select the "Actions" button
-  Choose "Log Production" which will launch a Log Production window

Users have other options on this page, which include:

-  Access a 24-hour Production Log of shipping items (see Page 17).
-  Export Shipping Production Log to a Microsoft Excel Sheet.
-  Open a channel by selecting "Add Message" (see Pages 5 - 6).
-  Locate specific parts in the Shipping Production Log by using the search bar.



The screenshot shows the Shipping Production Log interface. At the top, there are two buttons: "24h Production Log" (highlighted with a green box) and "Export to XLSX" (highlighted with a purple box). To the right is a search bar labeled "Search Order/SKUBOM" with a magnifying glass icon. Below these is a yellow bar with the "Add Message" button (highlighted with a blue arrow). The main part of the interface is a table with the following columns: Order, Item, Description, Available, and Action. The table contains several rows of data. The "Order" column is highlighted with a red box. The "Actions" button in the third row is highlighted with a purple arrow, and a dropdown menu is shown with the "Log Production" option (highlighted with a yellow arrow). The table data is as follows:

Order	Item	Description	Available	Action
wa	01-10003-002	Fuel Tank - TTYN, XL BLACK	1	Actions ▾
0019730	06-10140	(EM15.1) 15G Eco Tank - NATURA	13	Actions ▾
0019439	02-10021	Fish Box -165 - LT BLUE/WHITE		Log Production
0016737	02-10021	Fish Box -165 - LT BLUE/WHITE	1	Actions ▾
wa	01-10003-002	Fuel Tank - TTYN, XL BLACK	1	Actions ▾
0019730	06-10140	(EM15.1) 15G Eco Tank - NATURA	13	Actions ▾
0019439	02-10021	Fish Box -165 - LT BLUE/WHITE	5	Actions ▾
0016737	02-10021	Fish Box -165 - LT BLUE/WHITE	1	Actions ▾

Reporting

MRP / Inventory Management

Here, an MRP Report (list of needed materials, stock and location of a mold) can be created and exported to a Microsoft Excel sheet; allowing cage workers to determine a machine’s needs for a given shift.

Machine

- ➡ Click “Populate” beside a machine to show items loaded to each arm.
- Blue items are currently loaded to a machine arm.
- Red items are priority molds staged for loading.
- Priority molds are also listed on the left of each arm.

FSP - WA

Populate

FSP-WA-1	01-10437-001 New Dexter Lid - NATURAL M91223, QTY: 10	1	Unchanged	Unchanged
M91223 0020604	01-10709-002 DLX37 Lid - RED 0020604, QTY: 30	1	Unchanged	Unchanged
FSP-WA-2	01-10713-003 DLX75 Lid - BLACK 0020632, QTY: 16	Count 1	Shift On Unchanged	Shift Off Unchanged
wa	01-10003-002 Fuel Tank - TTYN, XL BLACK wa, QTY: 9	1	Unchanged	Unchanged
FSP-WA-3	01-10663-001 MHU Home Hydrant Tank - NATURA 0020336, QTY: 36	Count 1	Shift On Unchanged	Shift Off Unchanged
0020336				

Submit

To stage priority molds to a machine, use the Molding Machines section of the Scheduling tab (see Pages 42-44).

Machine (Continued)

- ➡ To set the removal of a loaded mold, click the drop-down menu located in the “Shift Off” column and select which shift you plan to have the mold removed.

FSP-WA-2 wa	01-10713-003 DLX75 Lid - BLACK 0020632, QTY : 16	Count 1	Shift On Unchanged	Shift Off Unchanged
	01-10003-002 Fuel Tank - TTYN, XL BLACK wa, QTY : 9	1	Unchanged	2nd

- ➡ To set a priority mold for addition to an arm, click the drop-down menu located in the “Shift On” column and select to have the mold added.

	01-10003-002 Fuel Tank - TTYN, XL BLACK wa, QTY : 9	1	Unchanged	Unchanged
FSP-WA-3 0020336	01-10663-001 MHU Home Hydrant Tank - NATURA 0020336, QTY : 36	Count 1	2nd	Shift Off Unchanged

- ➡ Then select the new mold’s “Shift Off” time based on your estimation of the mold’s takt, cook, and cooling times.
- ➡ Select “Submit” to launch the MRP report for the machine(s) you’ve engaged with.

	01-10003-002 Fuel Tank - TTYN, XL BLACK wa, QTY : 9	1	Unchanged	Unchanged
FSP-WA-3 0020336	01-10663-001 MHU Home Hydrant Tank - NATURA 0020336, QTY : 36	Count 1	Shift On Unchanged	1st

Submit

Statistics

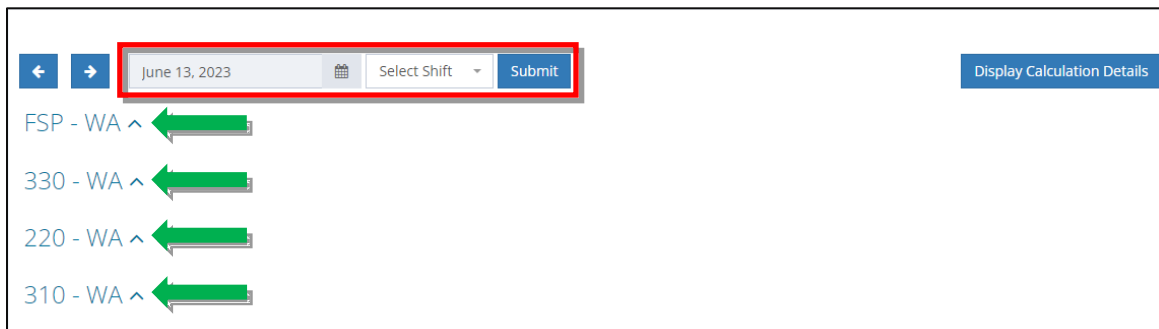
This presents a snap-shot of your facility's molding and post-molding productivity on a given date, shift and time.

Machine

Opening the Machine Statistics page will launch a list of your facility's active machines.

 To set your facility's data tracking to a specific date or shift, use these toggles to select a period of review. System will default to present day.

 Click machine drop-down menus to open their statistical breakdown.

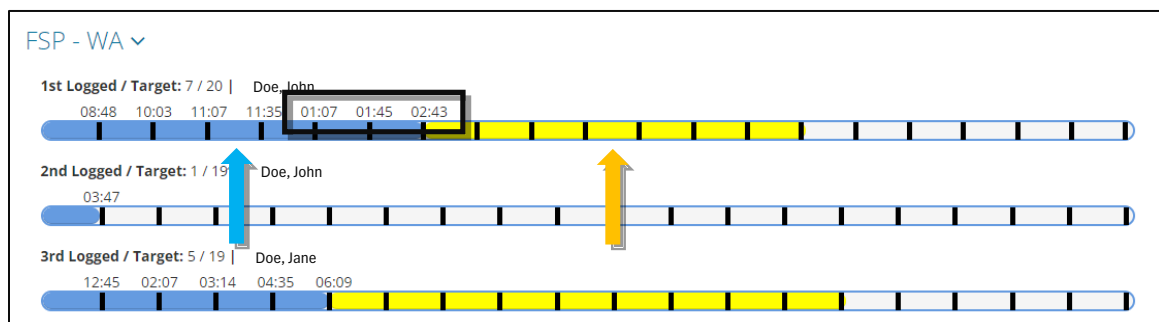


Upon opening a machine's drop-down menu, a user will be presented with progress bars tracking the arm activity of each shift.

 Blue indicates logged arms.

 Yellow indicates skipped arms. These will show at the end of the graph without a timecode attached.

 The time codes above each increment mark when an arm was logged.

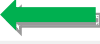


Machine (Continued)

Below your machine's progress bars are two more drop-down menus containing further machine information:

-  **Molded Units** displays the quantity of parts yielded from a machine.
-  Also included is the time elapsed at each stage of the molding process.
-  **Statistics** gives a breakdown of Conforming and Non-Conforming parts logged. As well as Logged and Skipped arms, all for each machine.

Molded Units 											
Item	Description	Ship Date	SO Quantity	Oven Time	1st Cooling	2nd Cooling	Takt Time	1st	2nd	3rd	N/C
01-10412-005	Exit - Sectional Slide (1650-P	June 26, 2023	15	26	10	0	10	3	0	0	0
01-10413-001	Straight - Sectional Slide (16	June 19, 2023	80	22	5	0	10	4	1	5	0
01-10765-001	Pegasus Rec Tank - FILTRIFI	January 02, 2023	110	26	10	20	12	3	0	0	0

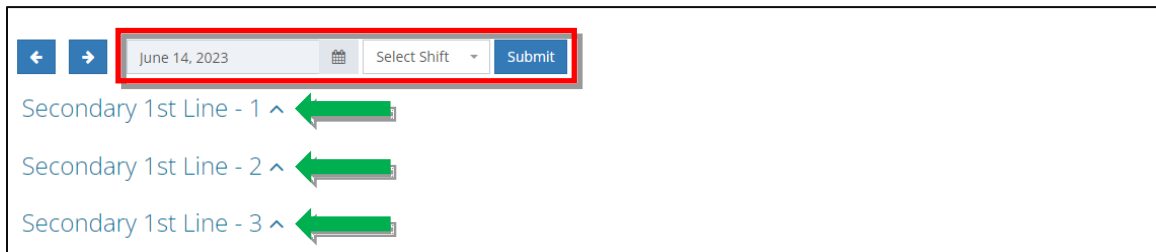
Statistics 				
	FSP - WA	330 - WA	220 - WA	310 - WA
Conforming:	16	105	105	0
Non Conforming:	0	4	13	0
Non Conforming %:	0	3.67%	11.02%	0
Logged Arms:	13	45	36	0
Skipped Arms:	16	1	8	0

Line Plan

Opening the Line Plan portion of the Statistics page will show your facility's post-molding productivity; including Secondary, Foaming and Assembly.

 To set your facility's data tracking to a specific date or shift, use these toggles to select a period of review.

 Click any of the secondary line drop-down menus to open their statistical breakdown.



← → June 14, 2023  Select Shift 

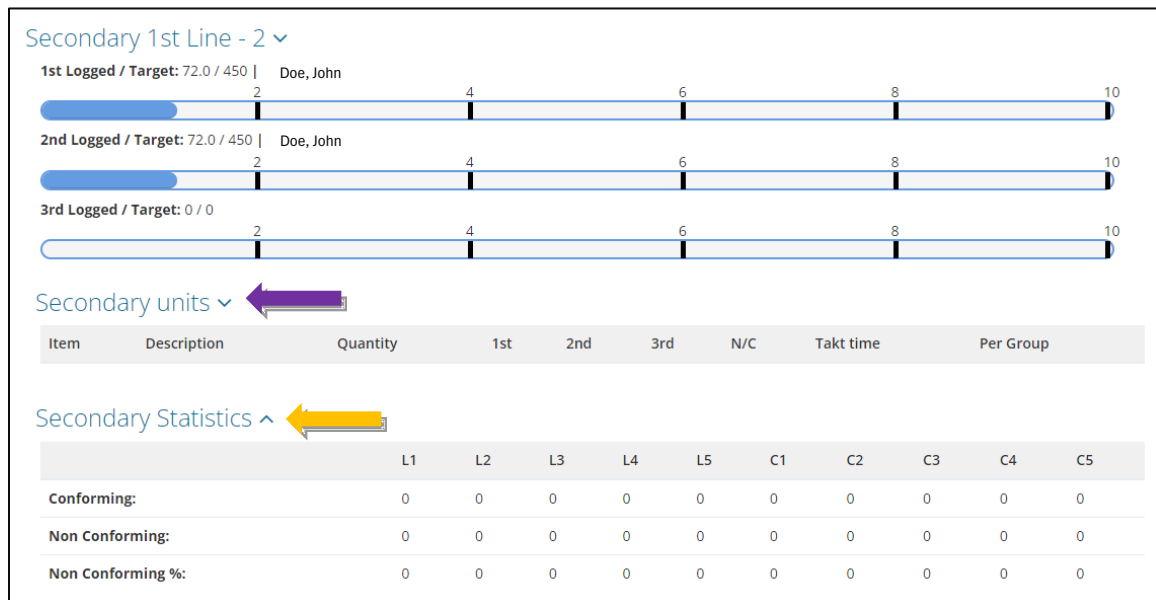
Secondary 1st Line - 1 

Secondary 1st Line - 2 

Secondary 1st Line - 3 

 Secondary Units provides the number of items completed on a particular line against the quantity of an active order.

 Secondary Statistics shows the amount of Conforming and Non-Conforming items yielded on all secondary lines, in both gross quantity and percentage.



Productivity

This section of the Reporting tab measures the efficiency of your facility in terms of product yielded against projections, expressed in gross figures and/or dollars.

At a Glance

When Productivity is launched, this tab will open automatically, and display your plant's efficiency for the current calendar month.

-  Use these toggles to display data for a specific shift or date range.
-  Represents the gross dollar amount yielded by each of your machines.
-  Shows all Conforming and Non-Conforming parts yielded by each of your plant's lines and machines.
-  Lists total production costs of each line and machine at your facility.

At a Glance ^

Select ShiftJun, 12 2023Jun, 16 2023

Search Order/SkuBomSubmitReset

Cost Summary

	FSP - WA	330 - WA	220 - WA	310 - WA	Total
Conforming	\$2,979	\$57,633	\$15,332	\$0	\$75,944
0% Non Conforming	\$3,239	\$59,051	\$16,549	\$0	\$78,839
100% Plant Efficiency	\$6,364	\$69,597	\$24,958	\$0	\$116,604
100% Capacity Projected	\$17,332	\$142,008	\$43,277	\$0	\$202,617
100% Capability	\$20,457	\$152,554	\$51,686	\$0	\$224,697

Parts Produced

Total conforming/non conforming parts produced on lines and machines

	Line Plans																Machines						Total
	L1	L2	L3	L4	L5	C1	C2	C3	C4	C5	No Line	PA	F1	A1	A3	A2	FSP - WA	330 - WA	220 - WA	310 - WA	Admin Molding		
Conforming	166	109	330	381	86	52	26	23	12	0	0	0	0	0	0	0	40	429	477	0	67	1013	
Non Conforming	14	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	4	15	34	0	0	68	
Non Conforming Dept	0%										0%	0%	0%	0%	5.53%								
Non Conforming %	7.78%	0%	0%	0.26%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	9.09%	3.38%	6.65%	0%	0.0%	6.71%	

Production Cost

Total product costs (not sales) on lines and machines

	Line Plans																Machines						Total
	L1	L2	L3	L4	L5	C1	C2	C3	C4	C5	No Line	PA	F1	A1	A3	A2	FSP - WA	330 - WA	220 - WA	310 - WA	Admin Molding		
Conforming	\$4,270	\$7,582	\$12,593	\$47,612	\$2,330	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$2,979	\$57,633	\$15,332	\$0	\$2,357	\$78,301	
Non Conforming	\$405	\$0	\$0	\$74	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$260	\$1,418	\$1,217	\$0	\$0	\$3,374	
Non Conforming Dept	0%										0%	0%	0%	0%	3.7%								
Non Conforming %	8.66%	0%	0%	0.16%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	0%	8.03%	2.4%	7.35%	0%	0.0%	4.31%	

At a Glance (Continued)

- ➡ Plant Efficiency measures target takt times against actual takt time elapsed at each of your facility's lines. As well as target arms to run on a machine against actual arms ran.
- ➡ Machine Capacity Efficiency tracks how full your machines were during the date range selected.
- ☐ Select "Show Capacity Rows" to reveal the total cubic footage capacity available and used for an arm of a machine.

Plant Efficiency

For lines: target takt and actual takt times
For machines: target arms to run and actual arms ran

	Line Plans																	Machines				
	L1	L2	L3	L4	L5	C1	C2	C3	C4	C5	No Line	PA	F1	A1	A3	A2	Total	FSP - WA	330 - WA	220 - WA	310 - WA	Total
Projected Takt/Arms	2250	2250	4500	5400	900	450	450	450	450	0	-	0	1350	2250	2700	900	24300	188	256	289	0	733
Actual Takt/Arms	969	614	1798	3696.5	663	430	528	585	240	0	-	0	120	1269	4590	162	15664.5	88	212	180	0	480
Efficiency %	43.07%	27.29%	39.96%	68.45%	73.67%	95.56%	117.33%	130.0%	53.33%	0%	0%	0%	8.89%	56.4%	170.0%	18.0%	64.46%	46.81%	82.81%	62.28%	0%	65.48%
Projected \$ 100%	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	-	\$6,364	\$69,597	\$24,618	\$0	\$115,980
Conforming \$	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	\$0	-	\$2,979	\$57,633	\$15,332	\$0	\$75,944

Machine Capacity Efficiency

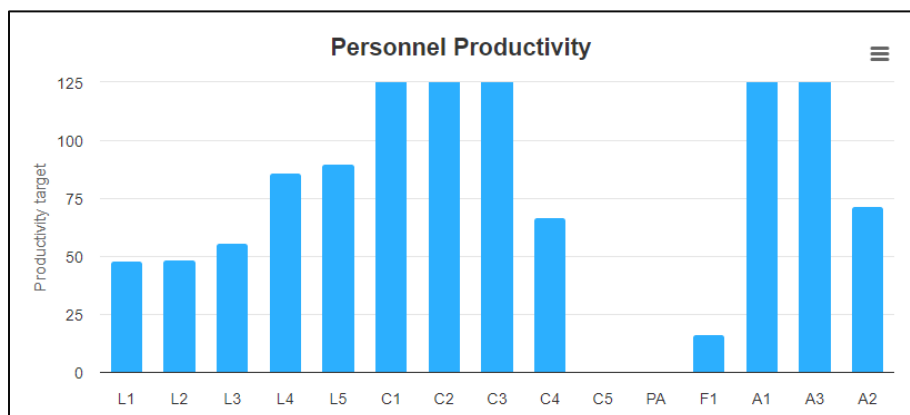
Machine potential load opportunity

Show Capacity Rows

	FSP - WA	330 - WA	220 - WA	310 - WA	Total
Projected Molds To Pull	85	517	752	0	1,354
Actual Molds Pulled	40	429	466	0	935
Capacity Efficiency	17.19%	40.58%	35.43%	0%	37%
Projected \$ 100%	\$17,332	\$142,008	\$43,277	\$0	\$202,617
Conforming \$	\$2,979	\$57,633	\$15,332	\$0	\$75,944

Post Molding & Molding

These sections present the same productivity information as the At a Glance section, separated between Machine and Lines, with the institution of graphs.



Scrap Log

This section shows a list of Non-Conforming parts. Quality employees will determine if these parts are either salvageable or beyond repair.

-  Blue items have yet to be addressed by a Quality employee. This will be the default listing of items in the Scrap Log.
-  Green items have been located and confirmed as either Non-Conforming or changed to Conforming upon review.
-  Red items indicate that Quality cannot locate the part in question.
-  Both Green and Red items will not be immediately visible after the Scrap Log page is refreshed, and will need to be searched by date.
-  This list can also be exported to a Microsoft Excel sheet.

Scrap log search date

Submit

Reset

Export start date

Export end date

Export to XLSX

Item	Description	Location	Factory	Order	Total Ordered	N/C (Total/Part)	Shift	User	Timestamp	Edited Time	Deleted Time	
01-10506-005	Single PC Hopper-COMPOUND BLUE	330 - WA	Vancouver, WA	0020063	10	6 / 1 - DM	3rd		Jun. 30, 2023, 01:34 AM	-	-	→ ✕ ✓
01-10713-005	DLX75 Lid - YELLOW	Secondary 1st Line - 2	Vancouver, WA	0019995	20	8 / 4 - DM	1st		Jun. 30, 2023, 07:13 AM	-	-	→ ✕ ✓
01-10712-005	DLX75 Base - YELLOW	Secondary 1st Line - 2	Vancouver, WA	0019994	20	2 / 1 - AD	1st		Jun. 30, 2023, 07:49 AM	-	-	→ ✕ ✓
01-10748-002	TTCA-1 Fuel Tank - XL BLACK	Secondary 1st Line - 1	Vancouver, WA	0019908	51	13 / 1 - DM	1st		Jun. 30, 2023, 10:49 AM	-	-	→ ✕ ✓
01-10654-001	Home Hydrant 450 G Tank - NAT	330 - WA	Vancouver, WA	0020065	25	1 / 1 - EM	2nd		Jun. 30, 2023, 05:26 PM	-	-	→ ✕ ✓
01-10521-001	Home Hydrant 350 Gallon Tank -	330 - WA	Vancouver, WA	0020066	30	3 / 1 - EM	2nd		Jun. 30, 2023, 05:26 PM	-	-	→ ✕ ✓
01-10712-001	DLX75 Base - EARTH	330 - WA	Vancouver, WA	0020067	30	4 / 1 - BH	2nd		Jun. 30, 2023, 07:40 PM	-	-	→ ✕ ✓
01-10712-001	DLX75 Base - EARTH	330 - WA	Vancouver, WA	0020067	30	4 / 1 - EM	2nd		Jul. 02, 2023, 05:16 PM	-	-	→ ✕ ✓
01-10713-001	DLX75 Lid - EARTH	330 - WA	Vancouver, WA	0020068	30	1 / 1 - EM	2nd		Jul. 02, 2023, 05:16 PM	-	-	→ ✕ ✓

Scrap Log (Continued)

-  The “Check” button of a listed item will launch the Edit Scrap Log window. Following a review, a Quality employee can change an item to Conforming, alter the reference code, or edit which shift or machine the item came from.
-  Once “Confirm” is selected, the item will change to green on the Scrap Log.
-  A Quality employee will click the “X” button when they cannot locate an item, changing it from Blue to Red on the Scrap Log.
-  The “Arrow” button will reset an item from located and reviewed, or lost, back to unaddressed; changing the item from green or red back to blue.

Non-Conforming Productivity Review & Scrap Codes

-  Non-Conforming Productivity Review filters parts for secondary review based on a particular Scrap Code.
-  Scrap Codes are able to be added, removed or edited by admin users. Allowing for specific designations of Non-Conforming parts relevant to your facility.

Non Conforming Productivity Review ^ 						
Scrap Codes v 		14 / 15 Codes  				
Name	Description	Molding	Secondary	Foaming	Assembly	Counted
BH	blowholes/incomplete fills	✓	✓	✓	✓	✓  
CO	contamination, parting line and foreign materials (like vent material)	✓	✓	✓	✓	✓  
CS	Cosmetic issues marbling, pockmarks	✓	✓	✓	✓	✓  

Validate Line Plans

These are items that have not been assigned to a Line, or have been removed by mistake following completion at the previous production stage.

➡ Click “Load [Line] Items” button to populate your list.

➡ Select the “Actions” button, then “Assign to Line Plan.”

Secondary

Loaded Unloaded/Priority Unloaded/No Priority Unloaded/No Priority/Avail=0

Items appear here that are not on the secondary line plan, but have available count > 0, or is prioritized, or is loaded to a machine.

Order #	Item	Description	Balance	Available	Actions
0001420-M91577	01-10125-001	25 Gallon Tank/Lid-GRY GRANITE	2		Actions

Reload Secondary Items

An Add To window will launch, allowing a user to assign an item to a production line.

Additional Secondary Lines:

Select...

Select...

- Secondary 1st Line - 1
- Secondary 1st Line - 3
- Secondary 1st Line - 2
- Secondary 1st Line - 5
- CC Neptune Tanks
- Secondary 1st line - 4
- CC Neptune Base
- CC Neptune Wire
- CC Pre-Builds
- CC Spotter Builds

Submit

Following the selection of a production line, lick “Submit” and a notification will launch in the upper right-hand corner of the screen confirming your action.

Success

01-10125-001 added to Secondary
1st Line - 2 - Planning

Management

Order Management

 Select blue text to sort orders by Ship Date, Order or Item Numbers.

 Moldable orders are assigned to a machine.

 Assembly orders are assigned to a line (Secondary, Assembly etc.).

 Parent work order.

 Child work order.

Add New Order +		Hide scheduled orders ✕									
Live WO		Closed WO		Export to XLSX		Created past date		Search Order/SKUBOM			
Order	Item	Description	Ship Date	SO Qty	Molded	Secondary	Foamed	Assembled	Shipped	Type	Action
Sale Order #0016737 -Vancouver, WA											
	02-10021	Fish Box -165 - LT B...	04/29/2022	20	-	-	-	12		Assembly	Actions v
Sale Order #0016737-0016739 -Vancouver, WA											
	01-10616-002	FishBox - 165 Lid-PT...	04/28/2022	20	28/6	28	28	-		Moldable	Actions v

 Imported orders are colored Orange. Also, when completed and not closed.

 Once an order is assigned to a machine or a priority, it will turn Yellow.

 Grey marks an item that is currently loaded on an arm currently being molded.

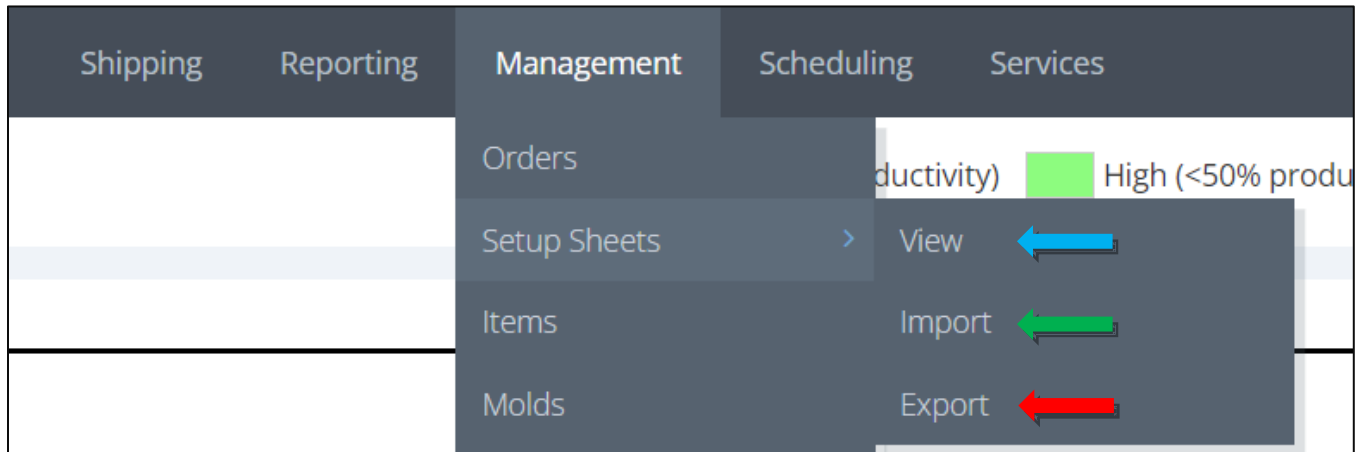
 Indicates a parent item, or a partially molded child removed from a machine.

 Red means WIP exists, but order has been removed from a post-molding line.

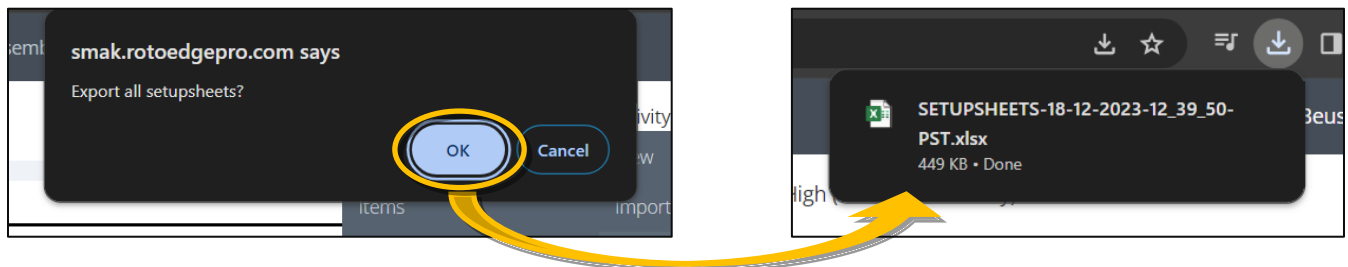
Sale Order #0019683-0019685 -Vancouver, WA											
	01-10583-001	PF-300 Base (WIDE) M...	04/26/2023	54	0	0	-	-	0	Moldable	Actions v
Sale Order #0019683-0019684 -Vancouver, WA											
	01-10280-001	PF301 Lid(188 Wall)-...	04/26/2023	54	5/1	0	-	-	0	Moldable	Actions v
Sale Order #9013348-0019687 -Vancouver, WA											
	04-50129	Barricade - ORANGE ...	08/11/2023	140	-	-	-	0	0	Assembly	Actions v
Sale Order #0019687-0019690 -Vancouver, WA											
	01-10760-001	Barricade - ORANGE ...	07/24/2023	140	0	0	-	-	0	Moldable	Actions v

Setup Sheets

Obtain molding process instructions and other details relevant to your facility's molds. Use drop-down menu to display Setup Sheet options.



→ “Export” will launch a browser window. Select “OK” to download your exported setup sheets to your browser.



→ “Import” will direct you to a page detailing the order of the columns required on your Excel file. Read them carefully before importing your sheets.

Columns: Item, Mold, Customer, Description, Cooling Fixture, Mold Location, Machine Name, Cycle Number, Vent Material, Wall Thickness, Oven Temp, Oven Time, Oven Time<78, Arm/Plate Speed, Oven reverse time, Oven air time, Vortex PSI, 1st cooling delay, 1st cooling station time, 2nd cooling station time, 2nd cooling water time, Additional molding instructions, More instructions, Cooling instructions, Last update time, Last update date

Or, just run a setup sheet export and use that as a template for this import.

File No file chosen

Setup Sheets (Continued)

Select “View” on the drop-down menu to launch a new browser window showing each part and their setup sheet(s) specific to one or more of your facility’s machines.

 Search list by item number.

 Add a setup sheet for an item to specific machine.

 Delete setup sheet for a specific machine.

Item Name	FSP - WA	330 - WA	220 - WA	310 - WA
01-10353-002	  	  	  	  
01-10353-001	  	+	  	  
01-10396-001	  	+	+	  
01-10551-001	  	  	  	  
01-10517-001	+	+	  	+
01-10439-001	  	+	  	  

 Select to view the item’s setup sheet.

Print Setupsheet

01-10353-002 FSP - WA SETUP SHEET
Last Update: 1:48:55 PM 10/25/2023

PART NUMBER
01-10353-002

MOLD NUMBER
10353

MOLD LOCATION
C-69

CUSTOMER NAME
Karcher North America

PART DESCRIPTION
8 Gallon Fuel Tank-BLANK (8.70

COOLING FIXTURE
No

BILL OF MATERIALS

Material Part Number	Description	Quantity
20-01012	PE HDX 7204 BK XLINK	5.0
33-00000	1/4-20 x 3/4, Triple Hex, Blin	4.0

MACHINE CYCLE INFORMATION

OVEN TEMPERATURE
610

OVEN TIME
22

23

VENT MATERIAL
CLEAR TAPE

ARM/PLATE SPEED
5.5/1.3

Setup Sheets (Continued)



Select to launch a new browser window. From there, a user can alter the details of an item such as names, specifications, cook/cooling/takt times, etc.



Temp and oven times are preloaded if cycle numbers are in use. Otherwise, these fields are actionable.

Customer Name Karcher North America		Mold Location C-69		☐ Cooling Fixture
Cycle Number 7	Vent Material CLEAR TAPE			
Temperature 610	Oven Time Plant > 78°F 22	Oven Time Plant < 78°F 23	Arm/Plate Speed 5.5/1.3	
Reverse Time 0	Air Time 0	PSI 0	Wall Thickness 0.188	
1st Cooling Delay 0	1st Cooling Time 5	2nd Cooling Delay 0	2nd Cooling Time 17	



Add additional instructions regarding molding, post-molding, trimming, etc.

Part Number 01-10353-002	Mold Number 10353	Machine name FSP - WA
Additional Instructions Cooling Instructions		



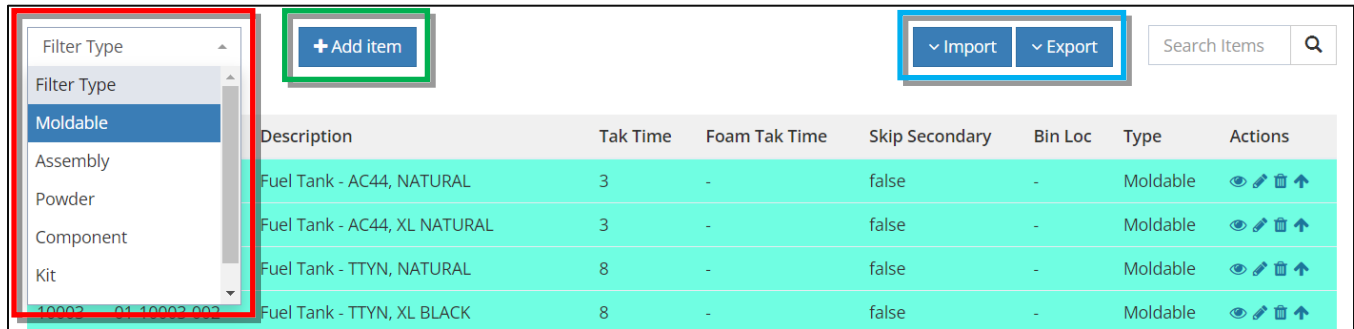
Attach PDF, PNG or JPG files to reference when interacting with a part.

Part Number 01-10353-002	Mold Number 10353	Machine name FSP - WA
• 01-10353-002_Hotsy_8_Gal_Tank_page_2_setup_sheet_pdf.pdf delete • 100_1989.JPG delete Drag & drop in the box above or Choose Files browse to upload. Supports PDF, PNG and JPG files.		

Items

Define, set and edit part numbers and descriptions.

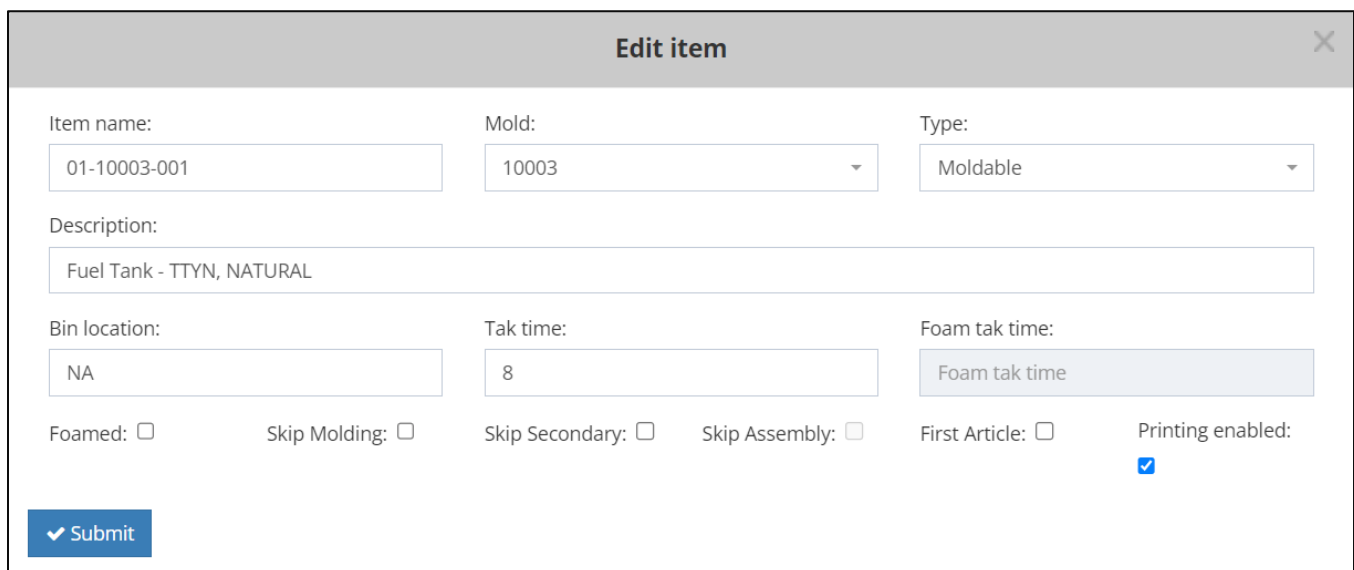
-  Use drop-down to filter items by type.
-  Add individual parts.
-  Import and Export multiple parts via Excel form.



The screenshot shows the 'Items' management interface. A red box highlights the 'Filter Type' dropdown menu, which is open and shows options: Filter Type, Moldable, Assembly, Powder, Component, and Kit. A green box highlights the '+ Add item' button. A blue box highlights the 'Import' and 'Export' buttons. The table below lists items with columns: Description, Tak Time, Foam Tak Time, Skip Secondary, Bin Loc, Type, and Actions.

Description	Tak Time	Foam Tak Time	Skip Secondary	Bin Loc	Type	Actions
Fuel Tank - AC44, NATURAL	3	-	false	-	Moldable	   
Fuel Tank - AC44, XL NATURAL	3	-	false	-	Moldable	   
Fuel Tank - TTYN, NATURAL	8	-	false	-	Moldable	   
Fuel Tank - TTYN, XL BLACK	8	-	false	-	Moldable	   

-  View item details.
-  Delete an individual item.
-  Click to launch a new browser window with a BOM for your item.
-  Select to launch an edit window.



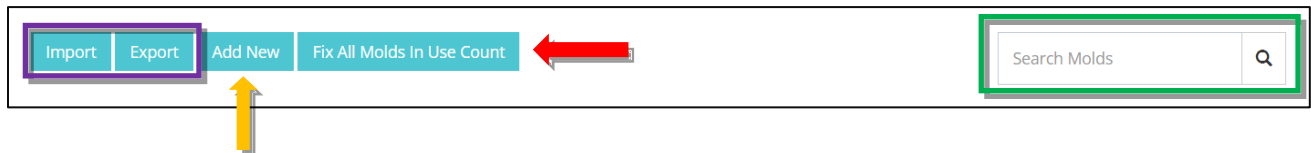
The 'Edit item' form contains the following fields and controls:

- Item name:
- Mold:
- Type:
- Description:
- Bin location:
- Tak time:
- Foam tak time:
- Foamed: ☐
- Skip Molding: ☐
- Skip Secondary: ☐
- Skip Assembly: ☐
- First Article: ☐
- Printing enabled: ☒
-

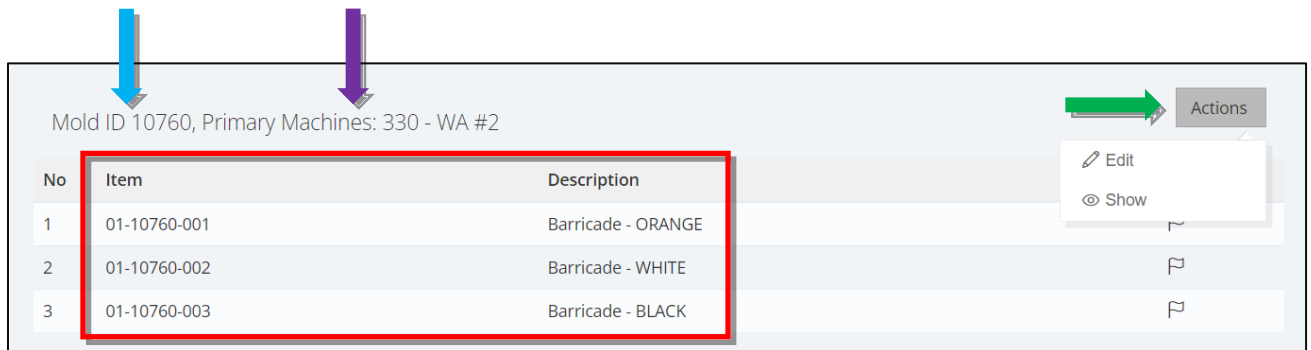
Mold Management

Define mold details.

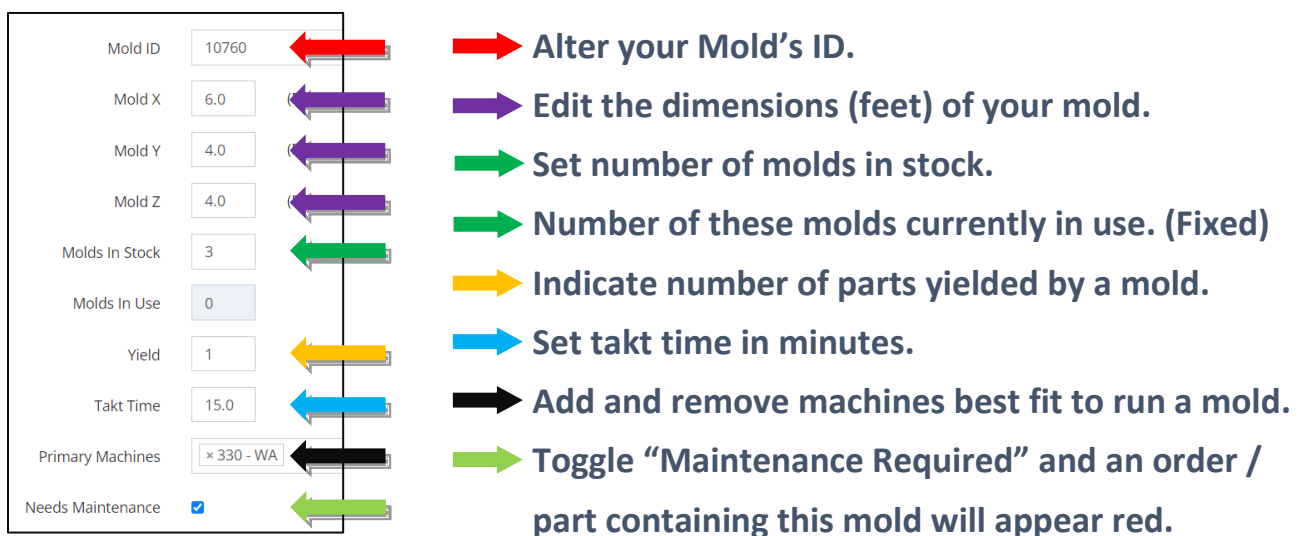
-  Import and Export mold lists via Microsoft Excel.
-  Add an individual Mold.
-  Select if an order closed includes a mold that is currently loaded to a machine.
-  Search list by Mold ID.



-  Moldables are divided into cards separated by Mold ID.
-  Also included is the Primary Machine used to produce a mold.
-  All moldable items are listed by item number and description.
-  Select the “Actions” button to launch a drop-down menu.



No	Item	Description
1	01-10760-001	Barricade - ORANGE
2	01-10760-002	Barricade - WHITE
3	01-10760-003	Barricade - BLACK



Mold ID: 10760

Mold X: 6.0

Mold Y: 4.0

Mold Z: 4.0

Molds In Stock: 3

Molds In Use: 0

Yield: 1

Takt Time: 15.0

Primary Machines: x 330 - WA

Needs Maintenance: ☒

-  Alter your Mold's ID.
-  Edit the dimensions (feet) of your mold.
-  Set number of molds in stock.
-  Number of these molds currently in use. (Fixed)
-  Indicate number of parts yielded by a mold.
-  Set takt time in minutes.
-  Add and remove machines best fit to run a mold.
-  Toggle “Maintenance Required” and an order / part containing this mold will appear red.

Bill of Materials (BOM) Management

View all BOMs for all of your facility's parent items.

-  Display children for all listed parts.
-  Import and/or Export itemized list from or to Microsoft Excel sheet.
-  Filter by part type (Moldable, Assembly and Kits)
-  Open list of children for a single part.
-  Launch drop-down menu (add a child item, print item details, view, etc.)
-  Edit child quantity or Delete child item.
-  Add new child item.

 Display children		▼ Import ▼ Export		Search Item Name Q										
Filter Type ▼		Search Child Item Name Q												
Item	Description	BOM count	Type	Actions										
▼ 01-10002-001	Fuel Tank - AC44, NATURAL	1	Moldable	Actions ▼										
<table> <tr> <th>Name</th><th>Description</th><th>Quantity</th><th>Type</th><th>Actions</th></tr> <tr> <td>20-90000</td><td>Natural Resin LLDPE</td><td>8.5 Lbs</td><td>Powder</td><td> Actions ▼ + </td></tr> </table>					Name	Description	Quantity	Type	Actions	20-90000	Natural Resin LLDPE	8.5 Lbs	Powder	Actions ▼ +
Name	Description	Quantity	Type	Actions										
20-90000	Natural Resin LLDPE	8.5 Lbs	Powder	Actions ▼ +										
Item	Description	BOM count	Type	Actions										
↑ 01-10002-002	Fuel Tank - AC44, XL NATURAL	1	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10003-001	Fuel Tank - TTYN, NATURAL	3	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10003-002	Fuel Tank - TTYN, XL BLACK	3	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10003-003	Fuel Tank - TTYN, XL NATURAL	3	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10004-001		2	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10005-001	Seat Base, BROWN GRANITE SPECK	1	Moldable	Actions ▼										
Item	Description	BOM count	Type	Actions										
↑ 01-10005-002	Seat Base - LIGHT GRAY SPECKLE	1	Moldable	Actions ▼										

Line Plans

Create, modify or delete your facility's Secondary, Assemble and/or Foaming lines.

➡ Select which set of lines to engage with.

🔴 Reorder how lines will appear in their respective drop-down menus.

🔵 These actions are customizable in the Line Scheduling section.

🗑 Delete a line from your facility.

✎ Select to launch Edit Line Plan window.

Secondary ^ 

Assembly v 

	Name	Code	Workers	Live	Planned	Post To Live	Auto Clear Plan Line	Auto Post	Shift	
	Assembly 1st Line - 1	A1	10	6302	420	12:00 AM			1st	 
	CC Pull BOM's	A2	25	5695	170	12:00 AM			1st	 
	Build Testing	A3	100	4642	193	12:00 AM			1st	 

Edit Line Plan

Line Plan editing is normally addressed during the implementation process. Any questions regarding this section of the app, contact your RotoEdge Pro technician.

Name:	Code:	Ticks per shift:	
Assembly 1st Line - 1	A1	4	
Ticks per shift displayed on productivity progress bars			
Type:	Factory:	Shift:	Expected tak per shift:
Assembly	Vancouver, WA	1st	450
Worker count:	Post to live:	Auto clear plan line:	Auto Post To Live: ☐
10	12:00 AM	--:--	
Assembly update quantity:			
--:--			

Machine Management

Edit the details and variables of your facility's machines.

➡ Select one of your facility's machines to engage with.

➡ Add a machine to your facility.

FSP - WA ^

330 - WA ^

220 - WA ^

310 - WA ^

+ Add Machine

Opening a machine drop-down will present current Machine and individual Arm data.

MRP rounds account for a complete cycle of all machine arms.

Cycle length is the time available to a user between their ability to log an arm.

Show cycles allows arm to display cycle info.

  Users can edit or delete machines, specific arms or cycle data.

Machine Data, Primary #1

Arms/Shift	MRP rounds/Shift	Cycle length	Show Cycles	Target Percent	
18	5	1 mins	False	100%	 

Arm Data

Number	Arm	Current Cycle	Loaded Items	Remaining / Capacity	Travel Time	
1	FSP-WA-1	Cycle Info: (Temp: 610, Min: 22)	0	12.25 / 38	5	 
2	FSP-WA-2	Cycle Info: (Temp: , Min:)	1	21 / 38	5	 
3	FSP-WA-3	Cycle Info: (Temp: , Min:)	0	0 / 38	5	 

+ Add Arm

Cycle Data

Number	Minutes (Factory >= 78°F)	Minutes (Factory < 78°F)	Temperature	
1	22	23	530	 
2	22	23	550	 
3	22	23	0	 

Personnel Management

Organizes a facility's workers and operators alphabetically by last name.

 Create new Profile for an employee.

 4-digit login code.

 Adjustment weighs a worker's production expectations on a scale of 1-100%.

 Alter a user's details by launching an Edit Existing Personnel window.

 Delete a profile.

Personnel 

These employees are not to be confused with the user profiles which are saved separately.

 [New Personnel](#) [Disable shift auto logout](#)

ID	Name	Location	Shift	Code	Adjustment	Actions
123	adam	-	-	3263	100	 
345	Adams, Tom	Vancouver, WA	-	1032	0	 
334	Adams, Trace	Vancouver, WA	-	8292	0	 
443	Allee, Mackenzy	Vancouver, WA	1st	7421	0	 

Personnel Stats (Machine & Line Plan)

Productivity statistics for Machine and Line employees.

 Expand profile to show production stats for days within selected time frame.

 Add billed hours for individual employees.

 Print productivity report.

 All times are expressed in minutes.

ID	Name	Location	Login Time	Billed Time	Takt time	Conforming	N/C	Productivity	Scrap	Line Productivity	Billed Productivity	
 504	Edwards, Michael	Secondary	1422	 0	798.28	219.5	5	3598.16%	2.23%	296.39%	0%	
 443	Allee, Mackenzy	Secondary	2685	 0	1393.35	281	5	77.01%	1.75%	67.96%	0%	
 166	Santy, Derrik	Secondary	2261	 0	2158.76	191.5	4	101.58%	2.05%	94.78%	0%	
 EHC0121	Chavez Velazquez, Erick	Assembly	451	 0	595	131	0	140.64%	0	140.64%	0%	
 426	Olson, Dean	Secondary	2261	 0	961.5	155	4	1158.01%	2.52%	1156.88%	0%	
 348	Wiseman, Nick	Secondary	430	 0	40	2	0	9.91%	0	9.91%	0%	
 306	Morrow, Joel	Foaming	826	 0	50	6	0	50.27%	0	12.09%	0%	

Scheduling

Users will utilize this area of RotoEdge Pro to layout the optimal timeline of which items are to be staged, attached, and removed from their facility’s machines.

Machine Scheduling

Upon opening the machine section of the scheduling tab, a user will launch an actionable list of their facility’s machine.

 Select to display your machine’s details.

330 - WA 

Machine Display 

Planning 



Load 

Machine Display

This page lists a machine’s arms and the molds currently attached.

 Your machine’s logged arms, by shift. As well as a list of molded units.

 Refresh machine details after changes by other users occur.

 Expand Arm Priorities (see next page).

Machine Production 



Refresh 

1 Cycle Info: (Temp: 575, Min: 22) - Takt time: 27.0 minutes - Cooling time : 24.0 minutes

Actions 

01-10677-001 Tank E1... 9014630-0020543	01-10313-002 100 Gal... 9014107-0020206	66 Available
QTY: 46	QTY: 24	
Not queued	Not queued	

None - This week - Monday 	None None None - This week - Tuesday 	None None MKennedy - This week - Wednesday 	None None None - This week - Thursday 	None None MKennedy - This week - Friday 	Arm Priorities 
MKennedy - Next week - Monday 	MKennedy - Next week - Tuesday 	None - Next week - Wednesday 	None - Next week - Thursday 	MKennedy - Next week - Friday 	

Machine Production

➡ Edit or Delete logs of molded units currently loaded to a machine.

1st Logged / Target: 11 / 19

07:53 08:30 09:04 10:23 10:37 11:09 12:03 12:44 01:01 02:01 02:46

2nd Logged / Target: 12 / 20

03:41 04:04 04:39 06:00 06:17 06:49 07:27 08:08 08:54 09:34 10:08 10:56

3rd Logged / Target: 10 / 20

12:07 12:33 01:12 02:24 02:45 03:31 04:20 05:22 05:34 06:41

Back 16-05-2023 Submit Reset Export to XLSX

Molded Units

Item	Mold	Arm	Order	Total Ordered	Conforming	N/C	Shift	User	Timestamp	Edited Time	Deleted Time	Action
01-10760-001	10760	330-WA-4	0019667-0019668	140	2	0	1st		May. 16, 2023, 07:53 AM	-		Actions
01-10345-001	10345	330-WA-1	-0019572	20	1	0	1st		May. 16, 2023, 08:30 AM	-		Edit Log Delete Log

Arm Priorities



Add to arm.



Delete an item.



Reschedule an item.



Queue an order behind another loaded to an arm or in your priority list.



Load order to arm without being queued. "Remove" will undo this action.



Determines how many tools a user wants to load.



Press and hold the arrows to drag and reorder items in your priorities list.

	Order Queue	Order, Item	Arm	Description	Balance	Ship Date	Tool Time	Tool Volume	Tool Quantity
+	Select...	-0020066, 01-10521-001	Add	Home Hydrant 350 Gallon Tank -	2	2023-06-29	20	180	2
+	Select...	9013650-0019884, 01-10606-001	Add	MZ Pump Housing Hopper-GRANITE	50	2023-10-10	6	32.46	1
+	Loaded	9014630-0020543, 01-10677-001							
+		9014107-0020206, 01-10313-002							
+	Arm Priorities	9014407-0020414, 01-10314-002	Add	150 Gal Fuel Tank(SS)-XL NAT	20	2023-12-13	12	32.46	1

Machine Planning

Once a user has selected Schedule Build in the Order Management section, items are then listed with the machine selected.

- Priority items assigned to an arm, waiting to be loaded.
- Items currently loaded to a machine.
- Assigned to a machine, but not an arm.
- Missing a setup sheet or requires maintenance.

Actions Menu

- Select desired arm to which an item will be loaded.
- Switch the machine and assembly line of an order.
- Switch only the machine of an order.
- If an order needs to be delayed, it is sent back to order management.
- Finds already scheduled orders with similar cycle info, within tolerance, to run them on the same arm.
- View your Production logs.

Planning ▾

Overall: 0% Logged arms: 0 Target arms: 16 Logged in personnel: 0 Additional personnel needed: 1.5 Additional personnel target: 20

Q
Refresh

Order	Item	Arm	Description	Ship Date	Balance	Loaded	Volume	Temp	Time	Takt	Action
9014630-0020543	01-10677-001	330-WA-1	Tank E18004-A07 - BLACK LLDPE	01/01/2024	44	1/1	32.5'	575.0	22.0	15.0	Actions ▾
9014107-0020206	01-10313-002	330-WA-1	100 Gallon FuelTank(SS)-XL NAT	09/06/2023	22	1/1	32.5'	575.0	22.0	15.0	Actions ▾
9013650-0019884	01-10606-001	330-WA-1	MZ Pump Housing Hopper-GRANITE	10/10/2023	50	0/1	32.5'	575.0	22.0	15.0	Actions ▾
9014407-0020414	01-10314-002	330-WA-1	150 Gal Fuel Tank(SS)-XL NAT	12/13/2023	20	0/1	32.5'	575.0	22.0	15.0	Actions ▾
0018994-0018997	01-10074-001	330-WA-2	SwingSmart, Cover-BLUE GRANITE	10/26/2023	60	1/2	15.9'	575.0	22.0	15.0	Actions ▾
-0019524	01-10483-001	330-WA-2	2-Step Pedestal - TUBS BROWN	05/01/2023	50	1/1	32.5'	575.0	22.0	15.0	Actions ▾
9012731-0018988	01-10776-001	330-WA-2	PVPM65 - TEAL	02/14/2023	108	0/1	20.0'	550.0	19.0	10.0	Actions ▾
9012544-0019005	01-10777-001	330-WA-2	Catch Basin (13-81-51-1305) MU	04/04/2023	111	0/1	16.0'	525.0	19.0	6.0	Actions ▾
-0019999	01-10634-002	330-WA-3	V9 Front Cover - WHITE	06/22/2023	25	1/1	32.5'	535.0	23.0	20.0	Actions ▾
0020012-0020014	01-10583-001	330-WA-3	PF-300 Base (WIDE) MUNSEL GRN	06/16/2023	8	1/8	9.0'	525.0	21.0	4.0	Actions ▾
0019256-0019257	01-10266-001	330-WA-3	200 Gallon Dexter Tank-NATURAL	03/02/2023	-1 (Over-run)	0/1	32.5'	525.0	21.0	10.0	Actions ▾
0020337-0020338	01-10663-001	330-WA-4	MHU Home Hydrant Tank - NATURA	10/18/2023	36	2/2	180.0'	600.0	23.0	20.0	Actions ▾
0019439-0019440	01-10615-001	330-WA-4	Fish Box -165 Body-LT BLUE	03/27/2023	1	0/1	32.5'	600.0	19.0	15.0	Actions ▾
0016737-0016738	01-10615-001	-	Fish Box -165 Body-LT BLUE	04/28/2022	-8 (Over-run)	0/1	32.5'	600.0	19.0	15.0	Actions ▾
9012299-0018520	01-10672-001	-	PVU60, 13-81-51-1105 - TEAL	02/09/2023	55	0/2	32.5'	-	-	8.0	Actions ▾

Line Plan Scheduling

-  In the event of a minor order change (quantity, priority level, etc.), this will update the line, but currently completed quantities will stay visible.
-  Refresh a user's screen with the new balance required of an order, and reset the colors of an order on the line from either green or yellow, back to white.
-  Upon completing scheduling for the next work day, click this to have your line updated automatically at a preset time.
-  Set worker count to gain an accurate total takt time for this line.
-  Items above the breakpoint are able to be completed with your line's current number of workers. To reorder, simply drag and drop items on the list.
-  Delete an item from the line.
-  Switch an item to a different line.

Set Worker Count - 2

Update to live now

! Post to live now

⌚ Post to live later

— Disable Breakpoint

🖨️

Search Order/SkuBom 🔍

📄 Show live table

←

Click on a quantity entry to edit the items quantity value. (Press enter to submit and save the quantity when entry is open)

	Order	Item	Description	Balance	Available	Quantity	Takt Time	Per Group	Overall
🕒 🗑️ L1	0020475-M93356	68-30061-W	PE5003 Unit Wiring	30	30	30	20	600	600
🕒 🗑️ L1	0020476-M93364	68-30006-T	PE500 Mate	30	30	30	30	900	1500

➡️ Live Table

-  Items that have been completed in the secondary stage.
-  Partially completed items.
-  Items not yet engaged with.

2	-0018806	01-10765-001	Pegasus Rec Tank - FILTRIFI	34	10	5	10	12	60
3	0020220-M92753	68-30004-B	PE220 Base	0	0	5	5	25	125
4	0020277-M92775	68-10009-T2	Cobra 10.0 Recovery Tank Mate	0	0	10	10	10	100
5	9014407-0020414	01-10314-002	150 Gal Fuel Tank(SS)-XL NAT	20	0	10	0	18	180
6	0020277-M92780	42B-00031	Heater Assembly 1750W 120V	0	0	10	10	10	100
7	0020220-M92752	68-30004-T	PE220 Mate	1	1	3	2	25	75

Services

User Profiles

Opening this page of the services section will launch a complete list of RotoEdge users.

-  Click to add a new user profile.
-  Edit a user profile details and permissions.
-  Change a user's password.
-  Delete a user profile.

Operator-WA	-	Vancouver, WA	-	×	×	  
Roto-Master	r@g.com	Vancouver, WA	-	✓	✓	  

[+ Add User Profile](#)

User

First name:

Last name:

Username:

Email:

Password:

Confirm password:

Staff: ☐ Ignore in Productivity: ☐

Profile

Shift: Override Code:

Dashboard:

Loading:

Molding:

Secondary:

Assembly:

Lineplan:

Shipping:

MRP:

Assembly MRP:

Accounting:

Services:

Setupsheet:

Scrap Log:

Machine Schedule:

Lineplan Schedule:

Productivity:

Open Sales Orders:

Machine Planning:

Machine/Lineplan Stats:

Item Management:

Mold Management:

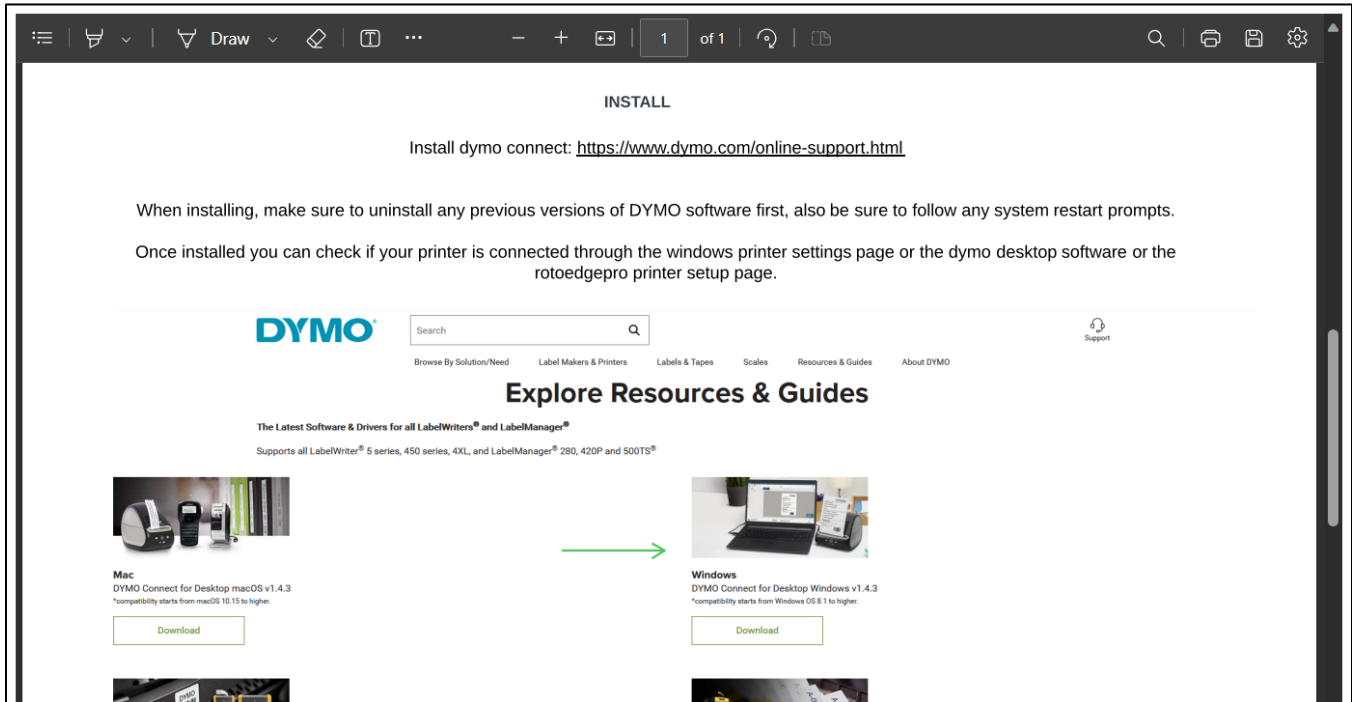
BOM Management:

Factory Locations:

-  Input users' general info.
-  Select for admin status.
-  Choose to stop tracking non-production workers.
-  Select the permissions a user will have in each section of RotoEdge Pro.
 - "None" locks a user out of given section.
 - "Viewer" can see, but take no action in a section.
 - "Logger" allows a user to log production.
 - "Editor" can alter items and data.
 - "Staff" has full permissions throughout the app.

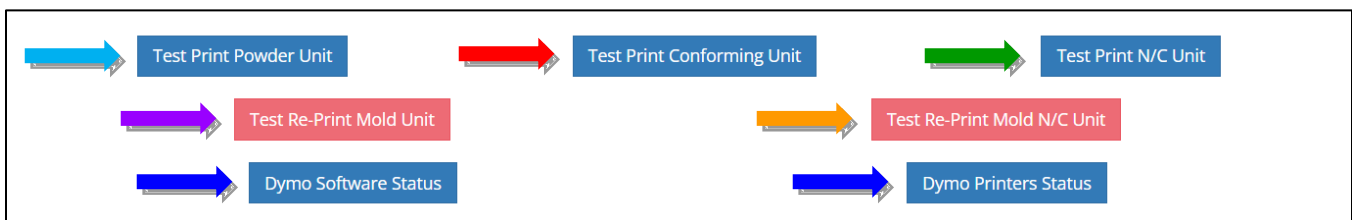
Printer Setup

Upon launching this section of the Services tab, a user will find a step-by-step guide to installing a DYMO printer and the accompanying software to your local workstation.



When complete select each of the following buttons to confirm your printer's full capabilities within RotoEdge Pro.

-  **Print Powder Label**
-  **Print Conforming Part Label**
-  **Print Non-Conforming Part Label**
-  **Re-Print Conforming Unit**
-  **Re-Print Non-Conforming Unit**
-  **Test DYMO software and hardware status**



Shifts and Factories

The Factories portion of this page will be configured by your RotoEdge Pro Implementation technician.

2/3 Factories

Name	Code	Phone	Address	Filter Manual Orders	
Hayden, ID	000	-	-	✖	
Vancouver, WA	VAN	(360) 882-0410	9116 NE 130th Ave STE 106, Vancouver, WA 98682	✔	

+ Add Factory

Also in this section is an area to establish your facility’s production shifts.

 Use the edit button to set the name, order, and time range of your shifts.

Name	Number	Start	End	
1st	1	07:00 AM	02:59 PM	
2nd	2	03:00 PM	10:59 PM	
3rd	3	11:00 PM	06:59 AM	