

Version
2.4



RotoEdge Pro

**Official
User
Manual**



Contents

Page 1 | NavBar

Page 2 - 3 | Dashboard

Page 4 - 8 | Arm Loading

Page 9 - 10 | Molding

Page 11 | Post-Molding

Page 12 | Shipping

Page 13 - 14 | Quality

Page 15 - 18 | Reporting

Page 19 - 22 | Scheduling

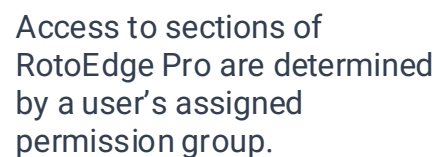
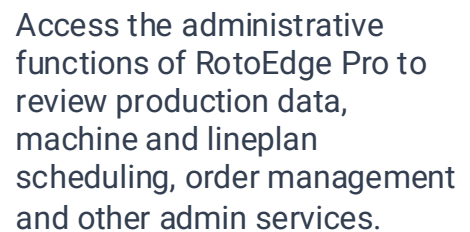
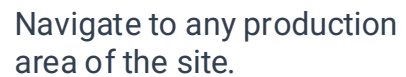
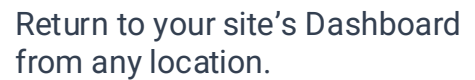
Page 23 - 26 | Services

Page 27 - 30 | Facility

1

The diagram illustrates the transition from a collapsed sidebar to an expanded sidebar. On the left, the collapsed sidebar is shown as a vertical blue bar with a white hamburger menu icon at the top. An arrow points to the right, where the expanded sidebar is shown. The expanded sidebar has a blue header with a white hamburger menu icon. Below the header, the sidebar contains a list of menu items, each with an icon and a text label. The items are: Dashboard (grid icon), Arm Loading (arrow icon), Molding (circular arrow icon), Secondary (person with gear icon), Foaming (bubbles icon), Assembly (wrench icon), Shipping (truck icon), Quality (sparkles icon), Reporting (bar chart icon), Scheduling (calendar icon), Services (shield with 'e' icon), and Facility (factory icon). Each item has a dropdown arrow on the right side of the text label.

Icon	Menu Item	Dropdown
	Dashboard	
	Arm Loading	▼
	Molding	▼
	Secondary	▼
	Foaming	▼
	Assembly	▼
	Shipping	
	Quality	▼
	Reporting	▼
	Scheduling	▼
	Services	▼
	Facility	▼



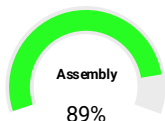
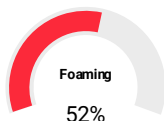
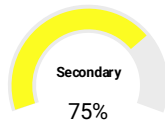
Dashboard

2

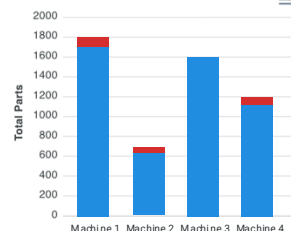
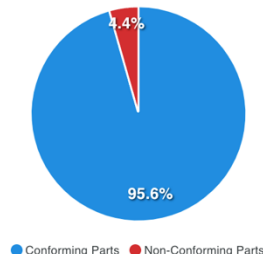
An at-a-glance layout of your facility's production status.

SHIFT MONTH TO DATE

Department Productivity



Scrap Summary



SHIFT MONTH TO DATE

View your facility's productivity for either the current shift or the current month to date.

Department Productivity

Production rate by department. Select one to view individual machines or lines.

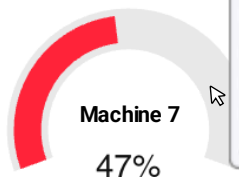
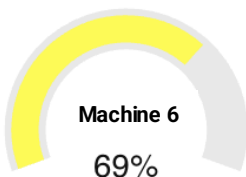
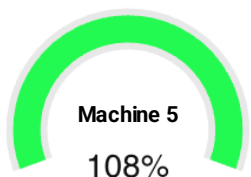
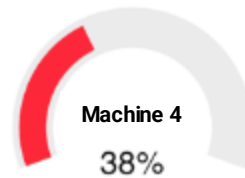
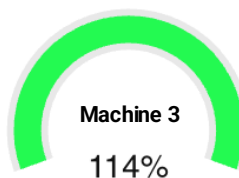
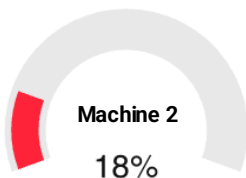
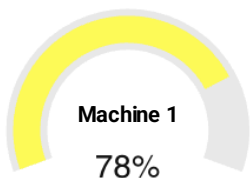


<60% = Red
60 – 79% = Yellow
>80% = Green

Machine Statistics

View a summary of a machine's performance for the current shift.

Machine Productivities



Machine Statistics

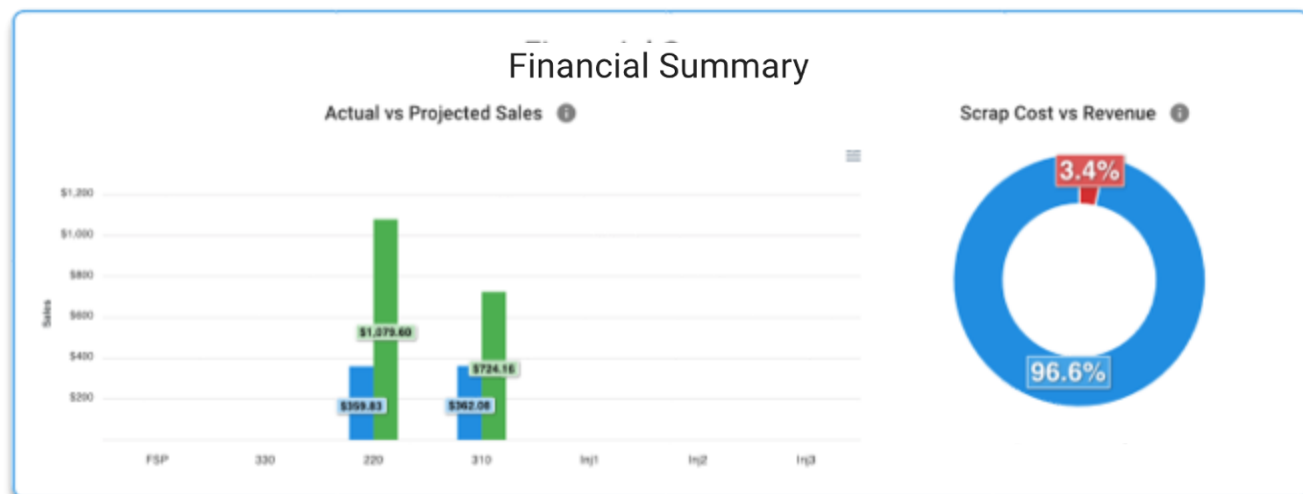
Employee Count: 1
Logged Arms: 3
Expected Arms: 8
Adjusted Target Arms: 13

CLOSE

Dashboard

3

Financial Summary: An at-a-glance view of your facility's performance based on dollars earned and lost.



Actual sales produced by one of your facility's machines.



Potential sales if a machine is operating at 100% Productivity.

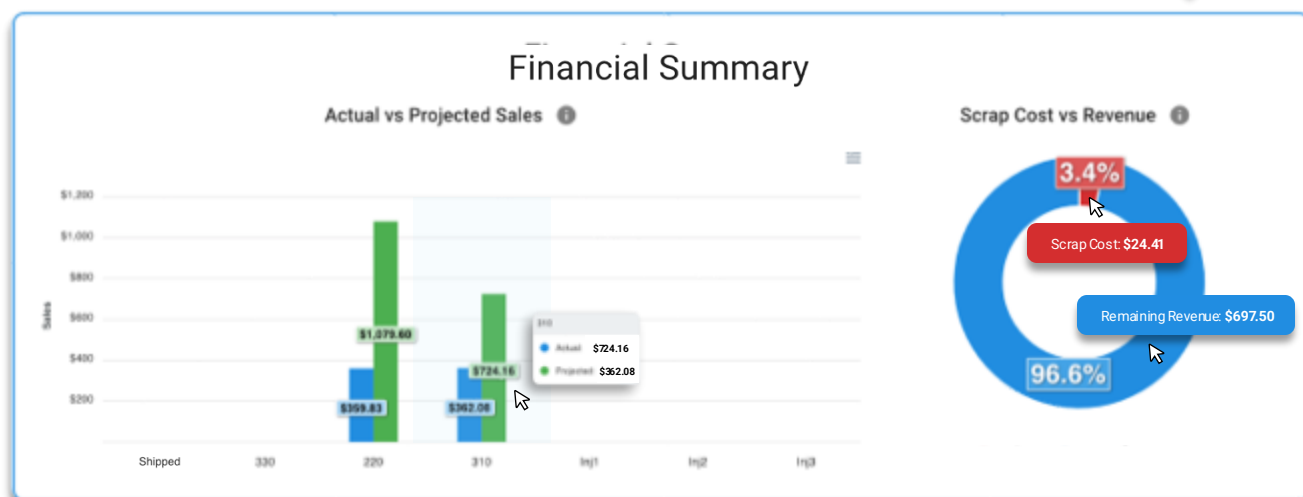


The Scrap cost percentage as a function of sales dollars.



Sales revenue percentage for the current shift.

Hover your mouse over either chart to view further details.





Arm Loading

4

Manage the production of molded items by adding and removing molds from each arm of a specific machine.

Section 1 | Personnel and User Activity

Arm Loading / Machine 1

Productivity: 50% | Logged arms / Current target arms: 2 / 4



Logged arms / Shift target arms: 2 / 16



Currently logged in: Sanchez, Rick | Smith, Morty

Logged Arms / Current Target Arms

Predicting the number of arms that will be logged given the present rate of production.

Logged Arms / Shift Target Arms

The number of arms logged vs the predicted number of arms to be logged by the end of a shift.

Logged arms / Shift target arms: 2 / 16



Currently logged in: Sanchez, Rick | Smith, Morty

LOGIN

LOGOUT

OVERRIDE

LOGIN

LOGOUT

OVERRIDE

Selecting these options will launch a Login window, prompting operators to enter their unique four-digit personnel code.

Circumvent arm loading restrictions by entering a unique code. (Generally, for supervisors or facility admins.)



Login

×

Personnel Code

Enter your personnel code then submit to login.

SUBMIT

Override Permissions

×

Override code

User code to temporarily set override permissions to.

SUBMIT



Arm Loading

5

Section 2 | Machine Arms

● In Cycle ● Overloaded/Done ● Shutdown/Idle ● Almost Done

Machine 1-2

Cycle Info: (Temp(s): 550, Time(s): 19, 21) | Takt time: 28 minutes | Cooling time: 20 minutes

ACTIONS ▾

Machine 1-2

Machine arms are listed in numerical order alongside your machine name.

Cycle Info

Based on the molds loaded to your machine arm, temperature, cook/cooling times, and takt.

- Refresh
- Production
- Remove All Molds
- Skip Production

Refresh

Display any new changes made to your machine arm.

Production

Launch a "Production Logs" window.

Remove All Molds

Removes all molds from an arm that have the same mold ID.

Skip Production

Allows operator to skip production on the arm, recording no molded parts.

Production Logs

● Archived ● Molded ● Secondary ● Foamed ● Assembly ● Kit ● Shipping

Search...

REFRESH EXPORT

Item	Description	Location	Factory	Order	Total	Conforming	Non Conforming	Shift	User	Created	Updated	Archived
01-10404-001	Exhaust Stack Extension (HILL)	Machine 2	Vancouver, WA	0021204	36	1	-	1st	mold-operator	10:21 AM, Mar 19, 24	-	-
01-10671-001	3500 Cover MX4774 - DK BLUE	Machine 2	Vancouver, WA	0021099	70	1	-	1st	mold-operator	10:21 AM, Mar 19, 24	-	-

Reprint Log

Print another log sticker in the event the original copy is either lost or illegible.

Archive Log

This effectively deletes the log activity, but it is kept as archived so it can be reactivated if a mistake is made.

Edit Log

Alter the number of Conforming or Non-Conforming parts yielded, change Scrap Code, or change the shift in which the log occurred.

- Edit Log
- Archive Log
- Reprint Log



Arm Loading

6

Section 3 | Open Channels





Arm Loading

7

Section 4 | Loaded Molds

01-10787-001
Flood Extractor Back - BLACK
0022422
Balance: 25

01-10695-002
Cobra 10.0 Rec Tank - FILTR
0021941
Balance: 5

01-10804-001
Blower Housing (50983) - BLACK
9015366-0021816
Balance: 16

01-10791-001
Flood Extractor Vac Box - BLAC
0022426
Balance: 26

35.56% Available

Each mold loaded to your machine arm appears in the form of a block. Which includes the Order Number, Mold ID, and description.

—

Select to remove mold from the arm. This action will launch a pop-up window.

Balance: 26

Balance remaining on an order.

XX.XX' Available
A percentage of arm space remaining.

Unload **Order No. & Mold ID** 0347-001 from 330-WA-1?

☐

 Needs Maintenance?

☐

 Remove all molds?

CANCEL

CONFIRM

☐ Needs Maintenance?

Alert all users that a mold requires maintenance.

☐ Remove all molds?

This function removes all molds loaded to this arm, using the same mold ID.

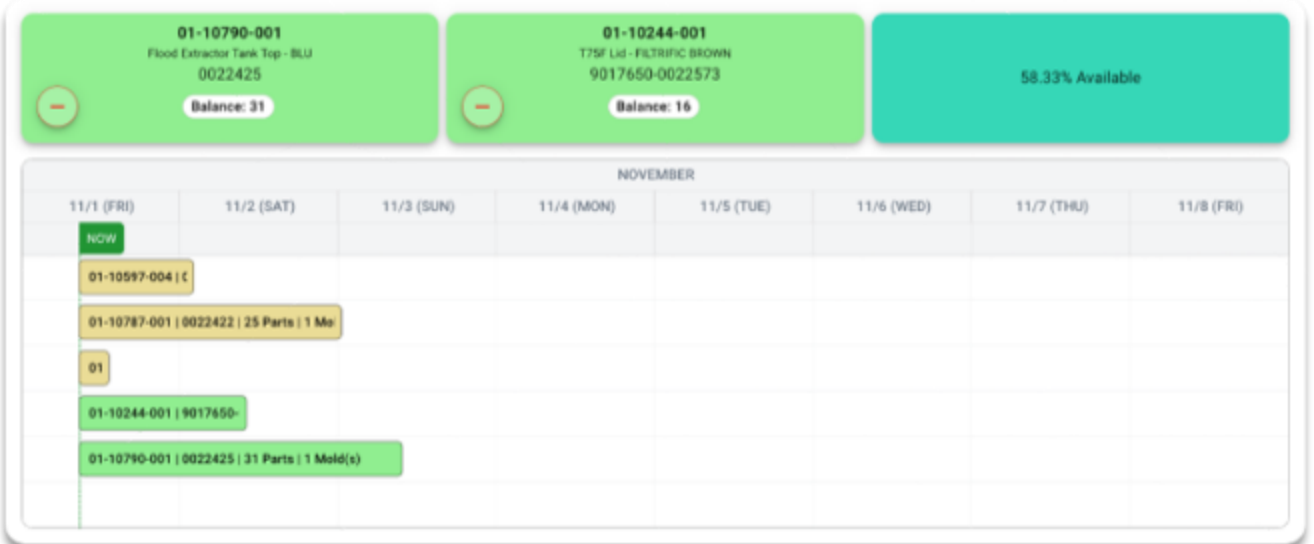


Arm Loading

8

Section 5 | Available Molds

Arm Schedule: timeline of scheduled orders.



01-10293-001 | 0022252-0022253 | 63 Parts | 1 Mold(s)

Orders currently loaded to a machine arm.

01-10598-001 | 0021939 | 43 Parts | 1 Mold(s)

Order scheduled to an arm, but not yet loaded.



See page 19-22 for further scheduling details.

Order	Item	Description	Arm	Ship Date	Balance	Loaded
9017650-0022573	01-10244-001	T7SF Lid - FILTRIFIC BROWN	220-WA-1	Nov 06, 24	14	1/1
0022603	01-10597-004	NEPTUNE SOLUTION TANK -	220-WA-1	Oct 25, 24	11	1/1
0022425	01-10790-001	Flood Extractor Tank Top - BLU	220-WA-1	Oct 15, 24	30	0/1
0021880	01-10790-001	Flood Extractor Tank Top - BLU	220-WA-1	Jul 05, 24	13	0/1

0022603

Actively loaded to a machine arm.

⬇️ Unload all molds

Remove all molds on this arm using the same mold number.

ACTIONS ▾

⬇️ Unload all molds
🖨️ Print Powder Label

0022425

Queued to be loaded to an arm.

⬆️ Load to Arm

Load a mold to this machine arm.

⬆️ Load to Arm

Molding

9

Enables operators to log the production of molded items and classify them as either Conforming or Non-Conforming.

Section 1 | Logging Mold Production

Machine 1-2
Cycle Info: (Temp(s): 600, Time(s): 27) | Takt time: 45 minutes | Cooling time: 25 minutes ACTIONS ▾

Remove 1x 350 Home Hydrant (10521)"BROKEN BUSHING" - and add the Home Hydrant 450(10654-001) JSmailey • 5:33 PM, Oct 31, 24

Open Channel Acknowledge Message Hide Message

01-10654-001
Home Hydrant 450 G Tank - NAT
9017259-0022647
Balance: 6

01-10521-001
Home Hydrant 350 Gallon Tank -
0022626
Balance: 27

31.94% Available



Select to view the Arm Schedule for the machine arm.

Select a mold to Log Production.



NOVEMBER				
11/26 (TUE)	11/27 (WED)	11/28 (THU)	11/29 (FRI)	12/2
NOW				
01-10292-001 9017517-0022503 23 Parts 1 M		01-1063		

0023334

01-10753-001

PVU57 Poly 13-81-51-1120 - TEA

Available	Balance
-	48

Conforming Parts

-	0	+
---	---	---

Non-Conforming Parts

-	0	+
---	---	---

Scrap Code

Select non-conforming code ▾



Select to show or hide weekends on your Arm Schedule.

-	0	+
---	---	---

Log the quantity of Conforming and/or Non-Conforming parts yielded by a mold.

Scrap Code:

Scrap Code ▾

When logging a Non-Conforming part, you must select a scrap code.

Section 2 | Active Molds

● Currently Running
 ● Almost Done
 ● Done

Order	Arm	Item	Description	Ship Date	Quantity	Balance	1st	2nd	3rd	N/C
0022566	310-WA-1	01-10753-001	PVU57 Poly 13-81-51-1120 - TEA	Oct 17, 24	144	6	0	0	3	7
0022610	310-WA-1	01-10761-001	PVU-68 (13-81-51-1121) - TEAL	Oct 22, 24	54	16	0	0	3	2
0022399-0022400	310-WA-2	01-10187-001	Slidesmart Cover Set - BLUE GR	Oct 25, 24	180	102	0	0	6	2
0022093-0022095	310-WA-3	01-10129-001	Stowaway Max Lid - BLACK	Aug 27, 24	42	12	0	0	3	2
0022583	310-WA-4	01-10595-004	NEPTUNE RECOVERY TANK HD	Oct 23, 24	25	2	1	0	2	0
0022531	310-WA-1	01-10770-001	PVU-68 (NB) - TEAL	Oct 17, 24	54	42	0	0	2	1
0022093-0022094	310-WA-3	01-10119-001	Stowaway Max Body - BLACK	Aug 27, 24	42	30	0	0	3	0
9017684-0022604	310-WA-1	01-10763-001	PVU48 - TEAL	Oct 25, 24	54	44	0	0	3	0
9017582-0022534	310-WA-4	01-10606-001	MZ Pump Housing Hopper-GRANITE	Nov 06, 24	25	0	1	0	1	4

Quantity

Total order quantity.

01-10770-001

Select the Item Number to launch the item's Setup Sheet (See page 23).

Balance

Shows the number of parts still to be molded.

1st 2nd 3rd

Conforming parts during each shift over the past 24 hours.

N/C

Non-Conforming parts yielded over the course of the entire order.



MACHINE

330 - WA

ITEM

01-10770-001

MOLD

10770

MOLD LOCATION

A-16 / A-20

CUSTOMER NAME

ITEM DESCRIPTION
PVU-68 (NB) - TEAL

COOLING FIXTURE

No

BILL OF MATERIALS

Name	Description	Quantity
20-00088	PP Teal	30

MACHINE CYCLE INFORMATION

OVEN TEMPERATURE
550

OVEN TIME
22

VENT MATERIAL
-

ARM/PLATE SPEED
5.5/1.3

OVEN REVERSE TIME
-

OVEN AIR TIME
-

PSI
-

WALL THICKNESS
0.188

1ST COOLING DELAY
-

1ST COOLING STATION TIME
15

2ND COOLING DELAY
-

2ND COOLING STATION TIME
15



Post-Molding

11

Log the production of items as they pass through the post-molding checkpoints of your facility's production process.

Section 1 | Logging Post-Molding Production

● Completed ● In Progress ○ Unaddressed

Priority	Order	Item	Description	Balance	Available	Quantity	Completed	Takt Time	Per Group
1	0021187	01-10656-001	Container 10G 14-0510 - XL GRE	6	1	10	9	6	60
2	0021101	01-10074-001	SwingSmart, Cover-BLUE GRANITE	65	36	12	0	14	168
3	0021184	01-10795-001	Halibut Tub - BLACK	69	2	10	8	5	50
4	0021197	01-10783-001	Waste Bottle - NATURAL	41	2	8	9	5	40
5	0021185	01-10392-002	Float Ball (A23460) - FDA ORAN	1	1	1	0	1.1	1.1

Priority

In Assembly, select these numbers to launch a Pull BOM.

0021101

Select the Order Number of available items to launch a Log Production window.

Available

Reflects the number of units in WIP.

Takt Time

A preset time of how long a post-molding process should take for one unit.

Per Group

A calculation of total takt elapsed after how many units have been marked completed.

Section 2 | Available Products

A complete list of items available in post-molding.

Order	Item	Description	Balance	Available	1st	2nd	3rd	N/C
0018806	01-10765-001	Pegasus Rec Tank - FILTRIFI	20	12	98	0	0	8
0018987	01-10776-001	PVPM65 - TEAL	32	7	76	0	0	0

ACTIONS ▾

🔍 Re-Schedule to Lineplan



Schedule to Lineplan 0018806 01-10765-001

ⓘ Lineplans this order is already scheduled to will be automatically selected. Items will remain scheduled if they are left selected.

Secondary - 1st Shift

Stage to these Lineplans
Secondary 1st Line - 1

RESET

SUBMIT



Shipping

12

Finalize orders by logging completed units.

Section 1 | Logging Shipping & Staging

STAGE

Log completed units that will remain at your facility to be shipped later.

SHIP

Log completed units when they have left your facility.

STAGING LOGS

SHIPPING LOGS

Order	Item	Description	Available to Stage ↑	Available to Ship ↑
9018564-0023303	01-10709-002	DLX37 Lid - RED	0	20
0023091	01-10753-001	PVU57 Poly 13-81-51-1120 - TEA	0	90
9018564-0023302	01-10708-002	DLX37 Base - RED	0	19
0021777	02-10021	Fish Box -165 - LT BLUE/WHITE	0	38
0023306	01-10521-001	Home Hydrant 350 Gallon Tank -	0	26
9017797-0023113	01-10804-001	Blower Housing (50983) - BLACK	0	133

0021032

Select order number to log production.



9018564-0023303

01-10709-002

DLX37 Lid - RED

Available: 20 Balance: 21

Conforming Parts

-

8

+

SUBMIT



ACTIONS ▾

- Stage
- Ship



Sort table by Available to Ship or Stage.

STAGING LOGS

View Production Logs of units that have been staged.

SHIPPING LOGS

View Production Logs of units that have been shipped.

View parts, molds and machines that require quality review and/or maintenance and repairs.

Section 1 | Quality Assurance

● Molded
 ● Secondary
 ● Foamed
 ● Assembled

Order	Item	Description	Location	Order Quantity	Non-Conforming (Total NC / Part)	Shift	User	Confirmed	Not Found	Created	Edited
0021328	01-10566-001	SPOTTER SOLUTION TANK - BLACK	220 - WA	30	10 / 1 - BH	1st	mold-operator			7:10 AM, Apr 12, 24	-
0021328	01-10566-001	SPOTTER SOLUTION TANK - BLACK	220 - WA	30	10 / 1 - BH	3rd	mold-operator			5:10 AM, Apr 12, 24	-
0021328	01-10566-001	SPOTTER SOLUTION TANK - BLACK	220 - WA	30	10 / 1 - DM	3rd	mold-operator			2:42 AM, Apr 12, 24	-
0021218	01-10058-001	Cyclone Exit - BLUE	330 - WA	4	3 / 1 - C0	3rd	mold-operator			2:32 AM, Apr 12, 24	6:50 AM, Apr 12, 24 - zstuder
0021218	01-10058-001	Cyclone Exit - BLUE	330 - WA	4	3 / 1 - DM	3rd	mold-operator			12:40 AM, Apr 12, 24	-

Order → Edited

View details of a logged part, such as Location, Scrap Code, Shift, Date/Time, etc.

✓ Edit

Confirm the quality of a Non-Conforming part and make any changes to the details by launching a log window.

✗ Not Found

Indicate when a Non-Conforming unit cannot be located.

ACTIONS ▾

✓ Edit

✗ Not Found

Confirm Non-Conforming Log



Order
0021798-0021800 01-10120-001

Location
330 - WA

Shift
1st

Non-Conforming Code
MI - Missing inserts, lose core... ▾

Apply To Machine
330 - WA ▾

Apply To Shift
1st ▾

Non Conforming
1

Conforming

RESET

SUBMIT

Section 2 | Maintenance

MOLDS

MACHINES

Needs Maintenance

Search...

Mold Name	Description	Last Maintenance	Maintenance Type	Parts Logged	Performed By	Actions
10701	Sharp Shooter 16 - BLACK	N/A		1,531	N/A	 
10760	Barricade - ORANGE	N/A		2,965	N/A	 
05004	PE1200 SWITCH PLATE	N/A		125	N/A	 



MOLDS

MACHINES

Switch between molds and machines needing maintenance.

Last Maintenance

Most recent maintenance performed on a mold or machine.

Maintenance Type

Select the code for the type of maintenance performed last.

Parts Logged

Total number of parts yielded by a mold since last performed maintenance.



10635 Maintenance History

Date	Maintenance Type	Description	Performed By	Archive
11-12-2024 10:14:17 AM	Clamps Cleaning	They lost a core. We had to torch the whole mold and we went over all the clamps and adjusted as needed.	SKunz	

CLOSE

Atlas-Plate Maintenance Form

Type

Description

CANCEL

SUBMIT

Description

Detail the maintenance performed on a mold or machine.

Type

Select maintenance type

Brushing

Clamps

Cleaning

Coating

Component Replacement

Select from a preset list of maintenance types.



Reporting

15

Your facility's productivity, by station, over the last completed 24-hour period.

Section 1 | Production Statistics

MOLDING

POST MOLDING

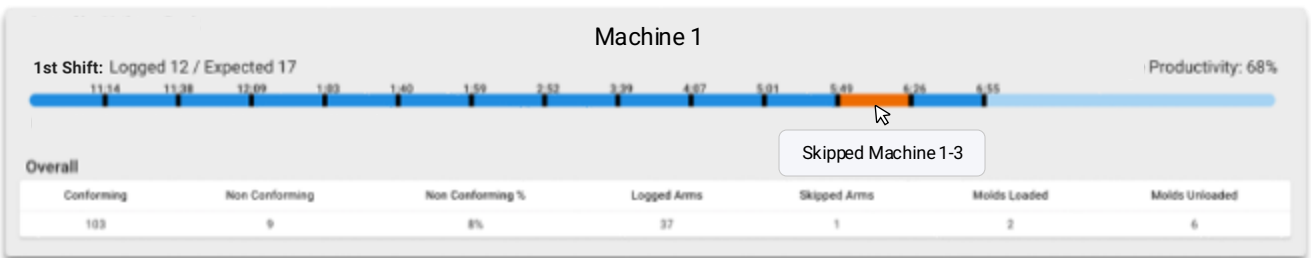
ASSEMBLY

Select between production departments to view their individual statistics.

Machine 1

Machine 2

Machine 3



Processed Orders

Order	Item	Ship Date	Balance	Conforming Parts	Non Conforming Parts	Skipped Count
0021657-0021658	01-10119-002	2024-06-04	38	4	4	0
0021657-0021659	01-10120-002	2024-06-04	37	4	4	0
0021958-0021959	01-10760-001	2024-07-08	0	4	0	0
9016773-0022012	01-10714-003	2024-07-25	19	1	1	3
9016773-0022013	01-10715-003	2024-07-25	18	2	0	3
0022027	01-10521-001	2024-07-26	3	1	0	4
9016614-0021928	01-10654-001	2024-07-30	14	1	0	4

Logged / Expected

Arms logged for a shift against the number of arms predicted to be logged. This is also shown as a completion percentage: Avg. Productivity.



Blue bars show an arm logged. Orange bars show skipped arms. Hover your mouse over the log to see which arm this occurred on.

Overall

Obtain general information for the previous 24-hour period. Such as Total Parts, Arms, Mold Changes, etc.

Processed Orders

See details on all orders processed on a machine for the last full 24-hour period.



Reporting

16

Section 2 | Accounting

Financial data for your facility's performance over a custom date range.

IMPORT FINANCIAL DATA		Shift All	Period Month to Date	Start 07/01/2024	End 07/25/2024
Parts Produced		MACHINES >	LINEPLANS >	Admin Molding	Total Molding
Conforming	3,246	4,283	349	3,595	
Non Conforming	149	41	0	149	
Non Conforming %	4.4%	0%	0%	4.0%	
Production Cost		MACHINES >	LINEPLANS >	Admin Molding	Total Molding
Conforming	\$210,626.16	\$316,139.04	\$7,616.5	\$218,242.66	
Non Conforming	\$15,136.71	\$2,139.59	\$0	\$15,136.71	
Non Conforming %	6.7%	0.7%	0%	6.5%	
Sales Value		MACHINES >	LINEPLANS >	Admin Molding	Total Molding
Conforming	\$377,772.8	\$555,586.89	\$11,366.97	\$389,139.77	
Non Conforming	\$27,064.01	\$4,101.01	\$0	\$27,064.01	
Non Conforming %	6.7%	0.7%	0%	6.5%	

[IMPORT FINANCIAL DATA](#)

Select to update to the Cost and Sales Price of items via Excel.

Shift
All

Select one of your facility's production shifts.

[MACHINES >](#) [LINEPLANS >](#)

Select either header to expand the table. This will show data from your facility's individual machines or post-molding lines.

Admin Molding

Logs performed by an admin account.



Parts Produced	MACHINES >	LINEPLANS <	C1	C2	C3	C4	C5	L1	L2	L3	L4	L5	F1	A1	A2	A3	Admin Molding	Total Molding
Conforming	3,246	4,283	40	8	16	11	0	936	559	274	1,497	0	59	797	0	31	349	3,595
Non Conforming	149	41	0	0	0	0	0	18	0	0	20	0	0	0	0	0	0	149
Non Conforming %	4.4%	0%	0%	0%	0%	0%	0%	1.9%	0%	0%	1.3%	0%	0%	0%	0%	0%	0%	4.0%



Reporting

17

Section 2 | Accounting (Continued)

Use the search fields to find accounting data for specific items and orders.

Shift
All

Machine
All

Item Type
Moldable

Start
07/01/2024

End
07/25/2024

Personnel

Item

Order

SUBMIT



Item	Associated Orders	Conforming Parts	Non Conforming Parts	Scrap Rate	Production Cost	Scrapped Production Cost	Sales Price	Scrapped Sales Price	Personnel
01-10037-003	0022001	3	2	40.0%	\$398.04	\$265.36	\$630.00	\$420.00	
01-10038-001	0022000	2	3	60.0%	\$243.30	\$364.95	\$420.00	\$630.00	
01-10044-001	9016416-0021681	10	1	9.0%	\$1,079.10	\$107.91	\$1,820.00	\$182.00	
01-10079-003	9016539-0021874	5	2	29.0%	\$940.65	\$376.26	\$1,810.00	\$724.00	
01-10119-002	0021657-0021658	0	3	100.0%	\$0.00	\$239.58	\$0.00	\$124.00	
01-10120-002	0021657-0021659	1	2	67.0%	\$62.79	\$125.58	\$64.25	\$128.50	
01-10187-001	0021752-0021753 0021749-0021750	42	0	0.0%	\$1,997.94	\$0.00	\$3,775.80	\$0.00	
01-10253-001	9016473-0021960	12	0	0.0%	\$360.00	\$0.00	\$1,198.80	\$0.00	
01-10270-001	Flex60240	1	0	0.0%	\$476.36	\$0.00	\$1,166.00	\$0.00	
01-10280-001	0021855-0021856 0021625-0021626 0021541-0021542 0021685-0021686 0021980-0021981 +9	90	0	0.0%	\$2,518.20	\$0.00	\$3,470.40	\$0.00	

EXPORT

Conforming Parts →
Scrapped Sales Price

View production and financial data related to your listed items.

Personnel

View personnel involved with the items and orders listed. "Personnel" must be included in the search query.

Highlight columns by selecting the header. These highlighted columns will appear in your Excel export.

EXPORT

Select this button to export the highlighted columns of your table to an Excel file.



Reporting

Section 3 | Personnel Statistics

Start
Jul 22nd, 24

-

End
Jul 26th, 24

SUBMIT

RESET

Line Plan

Machine

Start
Jul 22nd, 24

-

End
Jul 26th, 24

Select a date range to filter personnel stats.

Line Plan | Machine
Choose between Line Plan and Machine operators.

	ID	Name	Total Login Time	Total Billed Time	Total Takt Time	Total Conforming Parts	Total N/C Parts	N/C %	Avg Personnel Productivity	Avg Line Productivity	Avg Billed Productivity
▼	306		7:49:50	0:00:00	137	17.5	0	0%	10%	26%	0%
▼	550		0:34:07	0:00:00	192	22	0	0%	10%	20%	0%
▼	552		4:50:57	0:00:00	0	0	0	0%	0%	0%	0%
▼	DT001		0:22:02	0:00:00	12	4	0	0%	0%	0%	0%
▼	268		1 day, 1:20:42	0:00:00	350	32	0	0%	8%	9%	0%
▼	EHC0121		12:12:41	0:00:00	1195	164.5	0	0%	40%	46%	0%
▼	DT002		0:21:08	0:00:00	36	9	0	0%	0%	0%	0%
▼	417		1 day, 19:02:53	0:00:00	3969	441	5	0%	59%	77%	0%

▼
Expand a line to view a user's daily statistics.

ID → Avg Billed Prod.
View productivity statistics for each employee over your date range.

Shows a user is currently logged in to their station.

ACTIONS ▼
Logout



Location	Login	Logout	Billed Time	Takt Time	Conforming Parts	N/C Parts	N/C %	Personnel Productivity	Line Productivity	Billed Productivity
Foam 1st Line - 1	3:28 PM, Jul 22, 24	3:29 PM, Jul 22, 24	0.00	5.00	1.00	0.00	-	1.11	18.40	0.00
Secondary 1st Line - 4	3:10 PM, Jul 26, 24	3:11 PM, Jul 26, 24	0.00	0.00	0.00	0.00	-	0.00	0.00	0.00
Secondary 1st Line - 2	3:11 PM, Jul 26, 24	11:00 PM, Jul 26, 24	0.00	132.00	16.50	0.00	-	29.33	58.70	0.00

Scheduling

19

Section 1 | Order Management

+ NEW ORDER

AUTO SCHEDULE

ORDER SYNC

EXPORT ORDERS

Open ▾

Loaded (0)

Machine (0)

Lineplan (0)

Number	Item	Description	Type	Ship Date	Quantity	Molded	Secondary	Foamed	Assembly	Shipped	Scheduled To	Actions
9017762-9022662	01-10314-002	150 Gal Fuel Tank(SS...	Moldable	11-21-2024	20	19/4	11/7	-	-	11	330-WA-2 Secondary 1st Line - 6	
9022661	01-10595-004	NEPTUNE RECOVERY TAN...	Moldable	11-06-2024	50	46/1	16	-	-	16	220 - WA 310-WA-3 Secondary 1st Line - 5	

Order is loaded to a machine arm.

Order is scheduled to a machine.

Order is scheduled to a lineplan.

Order is queued to a machine arm.

Order Management can be sorted by any of these categories. Select one or more of the filters at the top of the page.

+ NEW ORDER

Create a new order within RotoEdge.

ORDER SYNC

Reflect orders in your Accounting software.

- Mark as Stock Order
- Schedule
- Log Production
- Auto-Scheduling Defaults

Mark an order as stock.

View Order Production Logs.

Manually schedule an order.

Log units in Molding / Secondary.

Schedule unprocessed orders to their primary Machines / Lines.

Auto-Scheduling Defaults

Manually set the primary Machine and Lineplan of your orders.

New Order

Order Number

Parent Order ▾

Item ▾

Quantity 1

Due Date

Ship Date

No child orders available

CANCEL

CREATE

Auto Scheduling Defaults

01-10803-001 • Hydraulic Tank (40389) - XL BL : Moldable

Primary Machine
220 - WA ▾

Primary Lineplan
Secondary 1st Line - 1

CANCEL

SAVE



Scheduling

20

Section 2 | Machine Scheduling

<

220 - WA 3

330 - WA 2

310 - WA 2

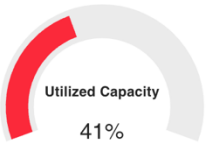
FSP - WA

Injection Molding - 1

Injection Molding - 3

Injection >

Orders Near Completion				
Arm	Number	Item	Quantity	Balance
220-WA-2	0022247	01-10575-001	75	3
220-WA-2	0022572	01-10547-002	25	0
220-WA-4	0022453	01-10504-003	25	10



220 - WA
Select a Rotomolding machine.

3 ↔ Orders Near Completion
Default threshold is set at 10 remaining units.
To edit, follow these steps starting from the NavBar:
Facility → Machines → Select Machine → Actions → Edit

Utilized Capacity
Percentage of total arm space being used on your machine.

Arm Schedule: Select machine arm to begin scheduling.



< Zoom One Week >

COUNTER WEIGHT

ADD HARD BREAK

01-10266-008 | 0022612-0022613 | 27 Parts | 1 Mold(x)
Orders currently loaded.

01-10204-002 | 9017037-0022175 | 19 Parts | Counter Weight
Orders not currently loaded.

COUNTER WEIGHT
Drag and drop onto the scheduling chart to add a visual of a counter weight.

ADD HARD BREAK
04/24/2024 1:47 PM
ADD
Notify operators to a major machine change.

Length of orders on the schedule predicts the time of completion.



Scheduling

21

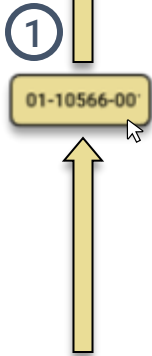
Section 2 | Machine Scheduling (Continued)

Reference the following instructions on how to load orders onto the Arm Schedule from the list of orders below.

NOVEMBER				DECEMBER	
11/26 (TUE)	11/27 (WED)	11/28 (THU)	11/29 (FRI)	12/2 (MON)	12/3 (TUE)
NOW					
01-10504-001	01-10566-001				
01-10628-001 0022529-0022530					
01-10392-002 9015138-0022287 47 Parts 1 Mold(s)			01-10566-001		

SAVE CHANGES

DISCARD CHANGES



①

Grab an order from the list and drag it onto the Arm Schedule.

②

Place the order on its own row, or behind another order.

SAVE CHANGES

DISCARD CHANGES

Select to post your schedule to your operating pages.

Reset your schedule to your most recent save point.

Order	Item	Description	Arm	Ship Date	Balance	Loaded	Mold Count	Mold Volume	Oven Temperature	Oven Time	Takt Time
0021218	01-10058-001	Cyclone Exit - BLUE	330-WA-3	Mar 14, 24	0	0/1	1	32.46'	600	26	7

0021218

Orders queued to a machine arm, but not yet added to the Arm Schedule.

Move to different Arm

Assign an order to a separate arm on the machine you're working with.

Unschedule from Arm

Remove an order from a specific arm, and back into the general pool of orders for your machine.

ACTIONS

Move to different Arm

Unschedule from Arm



Scheduling

22

Section 3 | Lineplan Scheduling

Live Line: The orders visible to your post-molding workers.

Priority	Order	Item	Description	Balance	Available	Quantity	Completed	Takt Time	Per Group
1	9017486-0022560	01-10397-02-005	SP300 Tote w/ Lid (Stan) - BLA	3	4	3	0	20	60
2	0022626	01-10521-001	Home Hydrant 350 Gallon Tank -	18	10	12	0	7	84
3	0022612-0022613	01-10266-008	200 Gal (NI) ECO Tank -NATURAL	34	6	20	0	5	100

Line Schedule: Orders assigned to a post-molding line.

Worker Count: 1 | Staged items: 111 | Live items: 3 | Scheduled to Post to Live:

This table is sortable, drag and drop rows to re-order the data.

Loaded Scheduled Available Not Loaded & Not Scheduled & Not Available

Order	Item	Description	Balance	Available	Quantity	Takt Time	Per Group	Overall	
9017486-0022560	01-10397-02-005	SP300 Tote w/ Lid (Stan) - BLA	3	4	3	20	60	60	
0022626	01-10521-001	Home Hydrant 350 Gallon Tank -	18	10	12	7	84	144	
0022612-0022613	01-10266-008	200 Gal (NI) ECO Tank -NATURAL	34	6	20	5	100	244	
MANUAL BREAKPOINT									
0022090-0022091	01-10119-001	Stowaway Max Body - BLACK	7	7	7	6	42	286	
0022093-0022094	01-10119-001	Stowaway Max Body - BLACK	42	21	11	6	66	352	
9015811-0021534	01-10634-002	V9 Front Cover - WHITE	3	2	6	5	30	382	
9016208-0021724	01-10739-001	CJR6 Spineboard - Orange	9	9	18	8	144	526	
AUTO BREAKPOINT									

0022027

Drag orders up and down the Line Schedule to organize them in priority order.

MANUAL BREAKPOINT

Drag up and down the Line Schedule, allowing you to post the exact orders you want to the Live Line.

AUTO BREAKPOINT

Shows how much takt can be done in a shift, based on Worker Count, Quantity, and total takt.

Quantity

Edit the number of units you expect your workers to complete during their shift.



Orders above highest breakpoint will be posted to the Live Line.

Set Worker Count

Indicate how many workers are assigned to your post-molding lines.

Update To Live

Add orders to your Live Line without altering the status of other orders.

Post To Live

Post all items above the highest breakpoint to the live line, and reset their units completed to 0.

ACTIONS

Set Worker Count

Update To Live

Post To Live

Section 1 | Setup Sheets

View the manufacturing procedures for your moldable items.

VENT MATERIALS

Select to create or edit vent materials.

→

Name

CLEAR TAPE

No Vent Material

RED SCOTCH-BRITE

ACTIONS

Edit

Delete

Item	Lineplan PDF	Default PDF	Injection Molding - 3	Injection Molding - 2	Injection Molding - 1	310 - WA	220 - WA	330 - WA	FSP - WA
01-10008-001			+	+	+	+		+	
01-10008-002			+	+	+	+		+	

Add a PDF to a Setup Sheet.

Add a Setup Sheet to an item.

Edit an existing Setup Sheet.

View an item's Setup Sheet.

Delete an item's setup sheet.

↓

MACHINE

FSP - WA

ITEM

01-10002-001

MOLD

10002

MOLD LOCATION

CUSTOMER NAME

CREATION COMPOSITES

ITEM DESCRIPTION

Fuel Tank - AC44, NATURAL

COOLING FIXTURE

No

BILL OF MATERIALS

Name	Description	Quantity
20-90000	Natural Resin LLDPE	0

MACHINE CYCLE INFORMATION

CYCLE

5

OVEN TEMPERATURE	OVEN TIME	VENT MATERIAL	ARM/PLATE SPEED
570	23	RED SCOTCH-BRITE	5.5/1.3
OVEN REVERSE TIME	OVEN AIR TIME	PSI	WALL THICKNESS
0	0	0	0.188
1ST COOLING DELAY	1ST COOLING STATION TIME	2ND COOLING DELAY	2ND COOLING STATION TIME
0.0	0	16.0	0

Section 2 | Molds

View the molds in stock at your facility, and their details.

+ NEW MOLD

● Needs Maintenance

Mold #	Description	Stock	In Use	Mold Yield	Takt Time	X	Y	Z	Location	Primary Machines
10049	Spiral Rail XTender - BEIGE	1	0	1	3	3.5	3.5	2.65	-	-
10272	CF-601 MG - Lid - MUNSEL GREEN	1	0	1	6	3.5	3.5	2.65	-	-
10392	Float Ball (A23460) - BLACK	1	0	1	4	1	1	1	-	-
10461	12' Hopper Adapter (w/ Mountin	1	0	1	4	3.5	3.5	2.65	-	-
10476	500 Gallon Compost Basket - BL	1	0	1	7	2	2	2	-	-

+ NEW MOLD

Mold # → Pr. Machines

Needs Maintenance

ACTIONS ▾

Creating a new mold or editing an existing one will launch a Mold Form.

View details of your molds. Stock, parts yielded, dimensions, etc.

Select when a mold needs maintenance. (See Page 15)

●

 Needs Maintenance

●

 View Items

Mold Form

✕

Primary Machines ▾

In Stock

In Use

Yield

Takt time

X dimension

Y dimension

Z dimension

Mold Number
10272

Location

Items assigned to this Mold

Name	Description
01-10272-001	CF-601 MG - Lid - MUNSEL GREEN

RESET

↑

UPLOAD PDF INSTRUCTIONS

SUBMIT

Section 3 | Items

ALL ▾

REFRESH IMPORT EXPORT

Item	Description	Mold	Type ▾	Bin Location	Foam Takt Time	Is Foam	Line Plan Takt Time	Skip Molding	Skip Secondary	Skip Assembly	Printing Enabled	First Article	
01-10485-004	Full Track Barrier - FILTRIFIC	10485	Moldable	-	-	⊕	8.00	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
20-00010	Filtrific Blue	-	Powder	-	-	⊕	-	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
01-10485-010	Full Track Barrier - YELLOW	10485	Moldable	-	-	⊕	8.00	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
20-00016	Filtrific Yellow	-	Powder	-	-	⊕	-	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
01-10763-001	PVU48 - TEAL	10763	Moldable	-	-	⊕	8.00	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
20-00088	PP Teal	-	Powder	-	-	⊕	1.00	⊕	⊕	⊕	✓	⊕	ACTIONS ▾
01-10701-002	FEW Sharp Shooter 16 - BLACK	10701	Moldable	-	-	⊕	5.00	⊕	⊕	⊕	✓	⊕	ACTIONS ▾

+ NEW ITEM

ACTIONS ▾

Item Form

Item Name

Type

Moldable

Mold

Description

Line Plan sTakt Time

First Article

Foamed

Item Cost

Item Sale Price

RESET

SUBMIT

Edit

Delete

View Item's BOM

View Process Instructions

ALL ▾

Item → First Article

View Item's BOM

View Process Instructions

Select which type of item you want displayed on your list. This option will also determine which items are included in your Excel export.

View details on your items. Such as associated mold, Bin Location, takt, etc.

Open the Bill of Materials for your item. (See Page 27)

Open your item's Setup Sheet. (See Page 24)

Section 4 | BOM Items

View the Bills of Material for your facility's items.

Search Parent Items...

Search Child Items...

IMPORT

EXPORT

Name	Description	Type	Takt time	Material Count
01-10002-001	Fuel Tank - AC44, NATURAL	Moldable	3.00	0
01-10002-002	Fuel Tank - AC44, XL NATURAL	Moldable	3.00	1
01-10003-001	Fuel Tank - TTYN, NATURAL	Moldable	8.00	3

▼

Select to expand an item and view it's Bill of Materials.

Material Count

The number of Child Items that make up your Parent Item.

Search Parent Items...

Search "Parent Items" to find their Bill of Materials.

Search Child Items...

Search "Child Items" to find all BOMs the item is included in.

ACTIONS

+ New BOM Item

 Print BOM

 View Item



Child Item	Child Description	Type	Quantity	Bin Location	Include in MRP
20-90000	Natural Resin LLDPE	Powder	180	-	
33-00002	1/4-20 x .72 OAL, Dbl Hex, Bli	Component	6	R3A4	
33-00053	1/2" FNPT Brass Insert	Component	1	R3B4	
33-00054	3/4" FNPT Brass Insert	Component	1	R3B5	
33-00060	1" NPT Brass Insert	Component	1	R3B5	
33-00061	1-1/2" NPT Brass Insert	Component	1	R3B5	

Quantity

The units of a Child item required to properly build a Parent item.

 View Item

View an item within Item Management. (See Page 26)

ACTIONS

 Edit

 Delete

 View Item

Section 1 | Factories

View the details of your factory.

Factory Information

Name:

Vancouver, WA

Code:

VAN

Address:

9116 NE 130th Ave STE 106, Vancouver, WA 98682

City:

Vancouver

State:

WA

Zip:

98682

Phone:

(360) 882-0410

Timezone:

US/Pacific

EDIT

EDIT

Select to edit your Factory Information.



Edit Factory

Factory Name

Vancouver, WA

Factory Code

VAN

Maximum 4 characters

Address

9116 NE 130th Ave STE 106, Vancouver, WA 98682

City

Vancouver

State

Washington

Zip Code

98682

Phone

(360) 882-0410

Shift Count

3

Temperature Threshold (°F)

78

CANCEL

SAVE

SAVE

Select to lock in your changes to your Factory Information.

Section 1 | Factories (Continued)

Shift Management

Ordinal	Display Name	Start Time	End Time	Duration	Status	Molding	Post-Molding	Active Days	Actions
1st	Day	07:00 AM	03:00 PM	8 hours	Active	Yes	Yes	Monday, Tuesday, Wednesday, Thursday, Friday	
2nd	Night	03:00 PM	11:00 PM	8 hours	Active	Yes	No	Monday, Tuesday, Wednesday, Thursday, Friday	
3rd	Graveyard	11:00 PM	07:00 AM	8 hours	Active	Yes	No	Monday, Tuesday, Wednesday, Thursday, Sunday	

Ordinal → Duration

View the order and span of time that your shifts run.

Status → Post-Molding

See which of your shifts are actively running and the types of operations they're conducting.

Active Days

View which days of the week your shifts normally operate.



Shift — End Time

Edit details of shift, such as name, shift number, start and end time.

Use the switches and checkboxes to indicate which operations and days of the week your shift runs.

Scroll through your facility's active personnel and use the checkboxes to assign them to a specific shift.

Edit 1st (Day) Shift

Shift

1

Display Name

Day

Start Time

07:00 AM

End Time

03:00 PM

Active

☒

Molding Operations

☒

Post-Molding Operations

☒

Active Days

☒ Monday
 ☒ Tuesday
 ☒ Wednesday
 ☒ Thursday
 ☒ Friday
 ☐ Saturday
 ☐ Sunday

Assigned Personnel

Search personnel...

Name	ID
☐ Beaudoin, Ethan	211
☒ Boothe, Stephanie	487
☐ Borton, Seth	598
☒ Bristow, Aaron	636
☐ Carlsen, Dusty	433
☒ Chavez, John	542
☐ Chavez Velazquez, Erick	EHC0121
☒ Conner, Michael	637

CANCEL

SAVE

Section 2 | Line Plans

Line Plan Management

Secondary

Foaming

Assembly



Name	Code	Workers	Post To Live	Auto Post	Shift
Secondary 1st Line - 1	L1	10	11:59 PM	☒	Day
Secondary 1st Line - 2	L2	10	11:59 PM	☒	Day
Secondary 1st Line - 3	L3	10	11:59 PM	☒	Day
Secondary 1st Line - 4	L4	6	11:59 PM	☒	Day
Secondary 1st Line - 5	L5	6	11:59 PM	☒	Day

Workers

View the number of workers on a line.

Post To Live

The time when "Post to Live Later" would occur.

Auto Post

Indicate if your line is Auto Post by using the toggle.

ACTIONS

Edit

Delete



Line Plan Form

Name

Secondary 1st Line - 1

Code

L1

Factory

Vancouver, WA

Type

Secondary

Shift

Day

Post To Live

11:59 PM

Expected Takt per Shift

450

Worker Count

10

Tiks Per Shift

4

☒

Auto Post to Live

RESET

SUBMIT

Utilize the Line Plan Form to edit the details of a line. Click "Submit" when done.

Section 3 | Machines

Machine Management

330 - WA 330

Arms Count
4

Capacity Utilized
40%

Arms per Shift
16

Logging Interval
15 min

Active Shifts

Day Night Graveyard

Active Days

Monday Tuesday Wednesday Thursday Friday Sunday

ARMS (4)

CYCLES (0)

EDIT

Click to Disable or Enable your machine.

View arm, capacity and interval details for each of your machines.

See which shifts and days of the week your machines are active.

330 - WA Arms

330-WA-1
#1 | Capacity: 90 | Travel Time: 5 min

330-WA-2
#2 | Capacity: 90 | Travel Time: 5 min

330-WA-3
#3 | Capacity: 90 | Travel Time: 5 min

330-WA-4
#4 | Capacity: 90 | Travel Time: 5 min

Add a new arm to your machine.

Edit details of an existing arm.

CYCLES

Create custom machine cycles.

Edit Machine: 330 - WA

Machine Name
330 - WA

Machine Code
330

Short identifier (optional)

Logging Interval (min)
15

Arms per Shift
16

Rounds per Shift
4

Target Percentage
100

Idle Time (hrs)
4

Order Balance Threshold
10

☐ Hide Available Space

☒ Dual Oven Times

☒ Enforce Arm Order

Machine Schedule

Active Shifts

☒ Day ☒ Night ☒ Graveyard

Active Days

☒ Monday ☒ Tuesday ☒ Wednesday ☒ Thursday ☒ Friday ☐ Saturday ☒ Sunday

CANCEL

SAVE CHANGES

Machine Name — Machine Code

Edit machine name details.

Arms per Shift — Order Balance

Edit production target details of your machine arm.

Customize your machine preferences and schedule by using the available toggles and switches.

"Save Changes" when done.