FlowSys – Report - Catalog

This FlowSys reports catalog is a collection of reports made in Crystal Reports using the data of an classical FlowSys database as it exists on a FlowSys Server (Version: FlowSys2000-ND).

It can be used to show examples which reports can be made out of the data in the FlowSys database. The focus is here on "examples". They give just a brief overview which data are available today. The reports are not customized. The data shown in the examples are not from any real customer site. They are simulated, the rules of the simulation are documented below.

Grouping FlowSys reports

Perhaps it is hard to divide the reports into groups. There is too much overlapping between the fields of interest. But anyhow here we try to create certain groups of reports.

Groups:

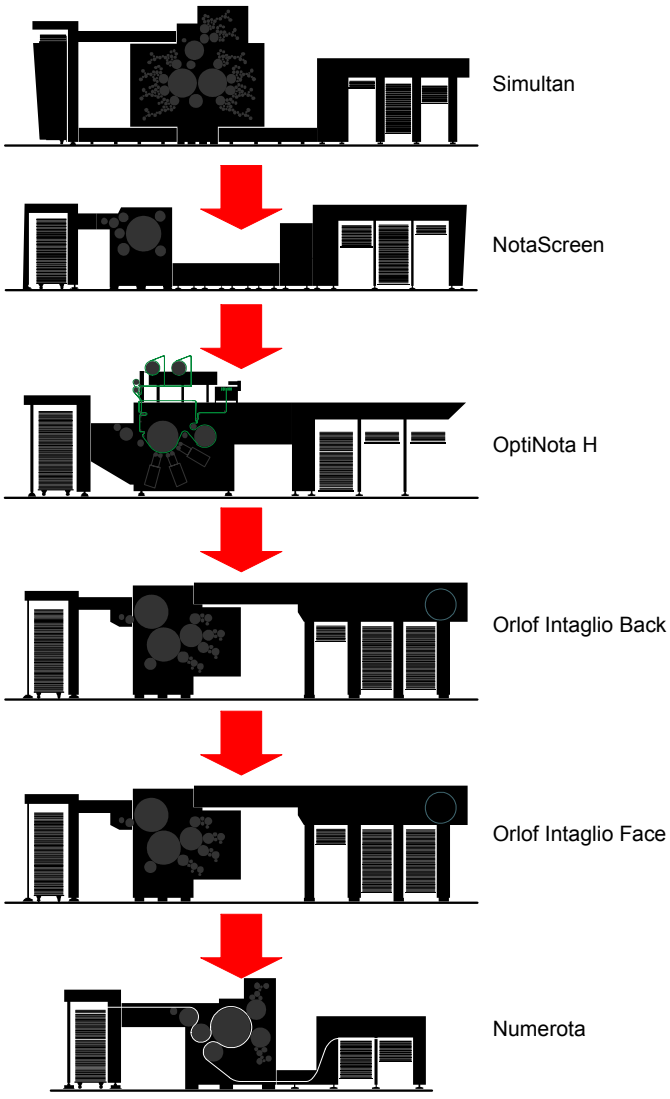
- Production (all about Quantity)
- Information and events in the production
- Planning & Costing (all about consumables and usage)
- Maintenance (when done, what comes next)
- Security (all about security interests)
- Quality (all about the quality measurements from quality devices in the production)
- Track&Trace (all about the sheet level point of view when FlowSys Track&Trace is installed)

Remarks about the data shown

The data shown are not from a real production. They are simulated with the so-called Demo database. Here a short specification of this database:

Definition
The demo database contains one production line. Every press runs Truck & Trace

Presses:
Production sequence of the denomination LEONARDO: SUSI, NOSC, OPT, SOIB, SOIF, SUNU



Load sizes:	7.500
Make ready sheets (MRE):	SOI(150), all others(15)
Load#, order#, suffix:	YYMMDD##, SS#, __
Good / Bad:	Bad random 0% - 5%
Bad – P3:	Inspection (90-95%), rest as bad, sidelay, etc.
Duration / Period:	2 weeks, Mo – Fr, ~10h / day, 9 loads / day

Contents

1 Group: Production

In this group you will find all reports, which display the all-possible quantities produced in the production.

1.1 Starting blanks by denomination (P001)

Title (Document properties)	**Group**	**Graphic**
Starting blanks by denomination	Production	No

Sub-Title (inside report)
Displays sheets versus muts by section, starting blanks and average muts by denomination

Comment (Document properties)
Displays sheets versus muts by section, starting blanks and average muts by denomination

Description
Use for measurement reasons about the production performance – related to each denomination. Calculates the muts for each production step (Simultan, Intaglio, …) and the sum of all muts by denomination. For each denomination the % muts over all (for all production steps) is calculated and an assumption how much blank sheets will be needed to produce 1.000.000 good sheets for a denomination. All calculated values are depending on the time frame specified. % muts will get closer to reality as longer the timeframe is chosen.

Rpt name	Grouping (top to botton)
P001_xx.rpt	Denomination / Production Step

Origin (db_user: 1st table or view)	Preceding tables or views used
demo_line:denom	relation, load, load_step, {load_run, loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Starting blanks by denomination

Displays sheets versus muts by section, starting blanks and average muts by denomination

DENOMINATION / PRODUCTION STEP	No. loads	Good Sheets	Muts	Muts %
LEONARDO				
1 SIMULTAN	70	514,979	10,021	1.91%
2 NOTASCREEN	63	454,707	8,800	1.90%
3 OPTINOTA	56	396,017	8,200	2.03%
4 INTAGLIO FACE	42	286,623	5,994	2.05%
5 INTAGLIO BACK	49	340,604	6,216	1.79%
6 NUMEROTA	35	257,085	5,415	2.06%
Total LEONARDO			**44,646**	

*To product **1.000.000** good sheets of Denomination **LEONARDO** you need **1,125,876** blanks sheets.*

*This is equivalent to **11.18**% average muts rate thru whole production.*

GRAND TOTAL OVER ALL **44,646**

Starting blanks by denomination — User defined range: 2003 April 14, 09:25 - 2003 April 25, 17:16

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1.2 Order status by denomination (P002)

Title (Document properties)	**Group**	**Graphic**
Order status by denomination	Production	No

Sub-Title (inside report)
Displays sheets ordered, finished and left blanks for denomination

Comment (Document properties)
Displays sheets ordered, finished and left blanks to finish the denomination

Description
Use for overview about the production status – related to each denomination. Calculates the muts for each production step (Simultan, Intaglio, …). For each denomination the sheets ordered, how much are finished as amount and as % and calculates an assumption how much blank sheets are left to be produced to fulfill the order. This assumption considers (includes) the %-muts over all. All calculated values are depending on the time frame specified. For this report the maximum time frame should be chosen to get all sheets produced for a denomination.

Rpt name	Grouping (top to bottom
P002_xx.rpt	Denomination / Production Step

Origin (db_user:1st table or view)	Preceding tables or views used
demo_line:denom	relation, load, load_step, {load_run, loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Order status by denomination

Displays sheets ordered, finished and left blanks for denomination

DENOMINATION

PRODUCTION STEP	No. loads	Good Sheets	Muts	Muts %
LEONARDO				
1 SIMULTAN	42	309,096	5,904	1.87%
2 NOTASCREEN	35	252,739	4,829	1.87%
3 OPTINOTA	28	197,777	4,362	2.16%
4 INTAGLIO BACK	21	145,865	2,403	1.62%
5 INTAGLIO FACE	14	95,365	1,741	1.79%
6 NUMEROTA	7	46,443	969	2.04%

Status of LEONARDO	ordered sheets	finished sheets	done in %	blanks left
	1,000,000	46,443	4.64 %	1,075,143

Order status by denomination — User defined range: 2003 April 14, 09:22 - 2003 April 21, 17:35

Printed: 2004/01/16 Data: 2004/01/16 — P002_02.rpt — Page 1 of 1

1.3 Press Muts per Denomination (P003)

Title (Document properties)	**Group**	**Graphic**
Press Muts per Denomination	Production	No

Sub-Title (inside report)
Displays muts for each press involved of the production of a denomination

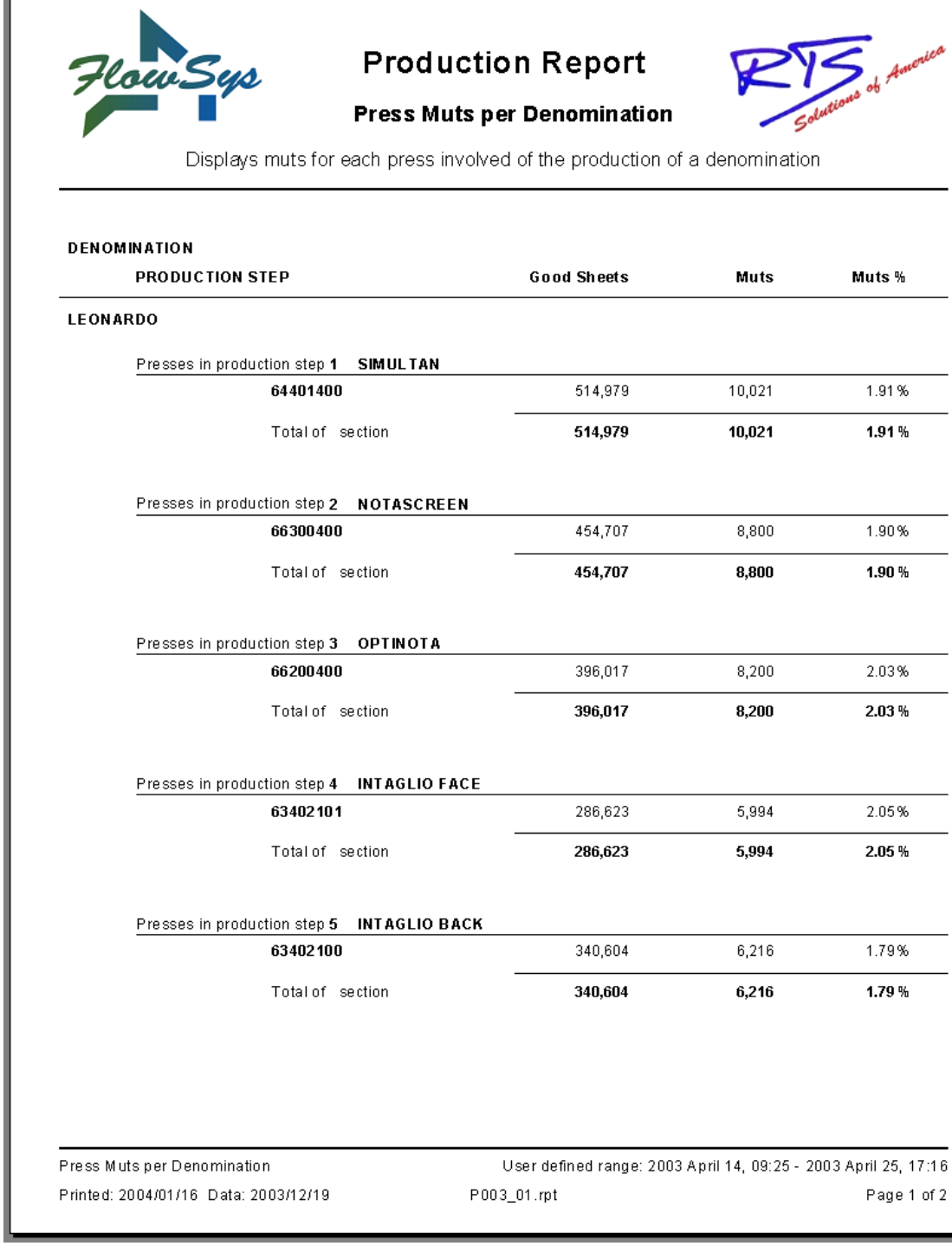
Comment (Document properties)
Displays muts for each press involved of the production of a denomination

Description
Use for measurement reasons about the production performance – related to each denomination. Calculates the muts for each press and for each production step (Simultan, Intaglio, …), which are involved in the production of a certain denomination. Best to use when you see in the overall report that a certain denomination / production step does not perform very well and produces a lot of muts. In this report here you can find out which press is the reason for doing so. All calculated values are depending on the time frame specified.

rpt name	Grouping (top to bottom
P003_xx.rpt	Denomination / Production Step / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:denom	relation, load, load_step, {load_run, loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Production Report

Press Muts per Denomination

Displays muts for each press involved of the production of a denomination

DENOMINATION

PRODUCTION STEP	Good Sheets	Muts	Muts %
LEONARDO			
Presses in production step **1** **SIMULTAN**			
64401400	514,979	10,021	1.91 %
Total of section	**514,979**	**10,021**	**1.91 %**
Presses in production step **2** **NOTASCREEN**			
66300400	454,707	8,800	1.90 %
Total of section	**454,707**	**8,800**	**1.90 %**
Presses in production step **3** **OPTINOTA**			
66200400	396,017	8,200	2.03 %
Total of section	**396,017**	**8,200**	**2.03 %**
Presses in production step **4** **INTAGLIO FACE**			
63402101	286,623	5,994	2.05 %
Total of section	**286,623**	**5,994**	**2.05 %**
Presses in production step **5** **INTAGLIO BACK**			
63402100	340,604	6,216	1.79 %
Total of section	**340,604**	**6,216**	**1.79 %**

Press Muts per Denomination — User defined range: 2003 April 14, 09:25 - 2003 April 25, 17:16

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1.4 Press Muts per Production Step (P004)

Title (Document properties)	**Group**	**Graphic**
Press Muts per Production Step	Production	No

Sub-Title (inside report)
Displays good sheets, muts and share for each press on the production step

Comment (Document properties)
Displays good sheets, muts and share for each press on the production step

Description
Use for measurement reasons about the production performance – related only to the production steps (sections). Calculates the good sheets and the muts for each press and for each production step (Simultan, Intaglio, …). It indicates also the share of good and muts for a certain press on the whole production step (section). Best to use when you see in the overall report that a certain production step does not perform very well and produces a lot of muts. In this report here you can find out which press is the reason for doing so. All calculated values are depending on the time frame specified.

rpt name	Grouping (top to bottom
P004_xx.rpt	Production Step / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:load	load, load_step, {load_run, loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Press Muts per Production Step

Displays good sheets, muts and share for each press on the production step

PRODUCTION STEP / PRESS NO.	No. loads	%	Good Sheets	%	Muts	%
INTAGLIO BACK presses						
63402100	21	100%	144,496	100%	3,314	2.24%
	21		**144,496**		**3,314**	2.24%
INTAGLIO FACE presses						
63402200	14	100%	94,655	100%	1,717	1.78%
	14		**94,655**		**1,717**	1.78%
NOTASCREEN presses						
66300400	35	100%	251,839	100%	5,201	2.02%
	35		**251,839**		**5,201**	2.02%
NUMEROTA presses						
64902900	7	100%	47,008	100%	940	1.96%
	7		**47,008**		**940**	1.96%
OPTINOTA presses						
66200400	28	100%	197,498	100%	4,126	2.05%
	28		**197,498**		**4,126**	2.05%
SIMULTAN presses						
64401400	42	100%	308,462	100%	6,538	2.08%
	42		**308,462**		**6,538**	2.08%

Press Muts per Production Step — User defined range: 2003 April 14, 09:14 - 2003 April 21, 17:34

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1.5 Muts Graphic per Production Step (P005)

Title (Document properties)	**Group**	**Graphic**
Muts Graphic per Production Step	Production	Yes

Sub-Title (inside report)

Displays graphic for good sheets, muts on the production step

Comment (Document properties)

Displays graphic for good sheets, muts on the production step

Description

Use for measurement reasons about the production performance – related only to the production steps (sections).

Calculates the good sheets and the muts for each press and for each production step (Simultan, Intaglio, …).

It shows also a graphic indicating good sheets versus muts for the whole production step (section).

Best to use when you want to have a quick graphical overview about the performance of production steps (sections).

All calculated values are depending on the time frame specified.

rpt name	Grouping (top to bottom)
P005_xx.rpt	Production Step / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:load	load_step, {load_run, loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Muts Graphic per Production Step

Displays graphic for good sheets, muts on the production step

PRODUCTION STEP	PRESS NO.	No. loads	Good Sheets	Muts	Muts %
INTAGLIO BACK presses					
	63402100	49	340,604	6,216	1.79%
		49	**340,604**	**6,216**	1.79%
INTAGLIO FACE presses					
	63402101	42	286,623	5,994	2.05%
		42	**286,623**	**5,994**	2.05%
NOTASCREEN presses					
	66300400	63	454,707	8,800	1.90%
		63	**454,707**	**8,800**	1.90%
NUMEROTA presses					
	64902900	35	257,085	5,415	2.06%
		35	**257,085**	**5,415**	2.06%

Muts Graphic per Production Step — User defined range: 2003 April 14, 09:25 - 2003 April 25, 17:16

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1.6 Analyzing Muts per Production Step (P006)

Title (Document properties)	**Group**	**Graphic**
Analyzing Muts per Production Step	Production	No

Sub-Title (inside report)
Displays the reason sheets are becoming muts

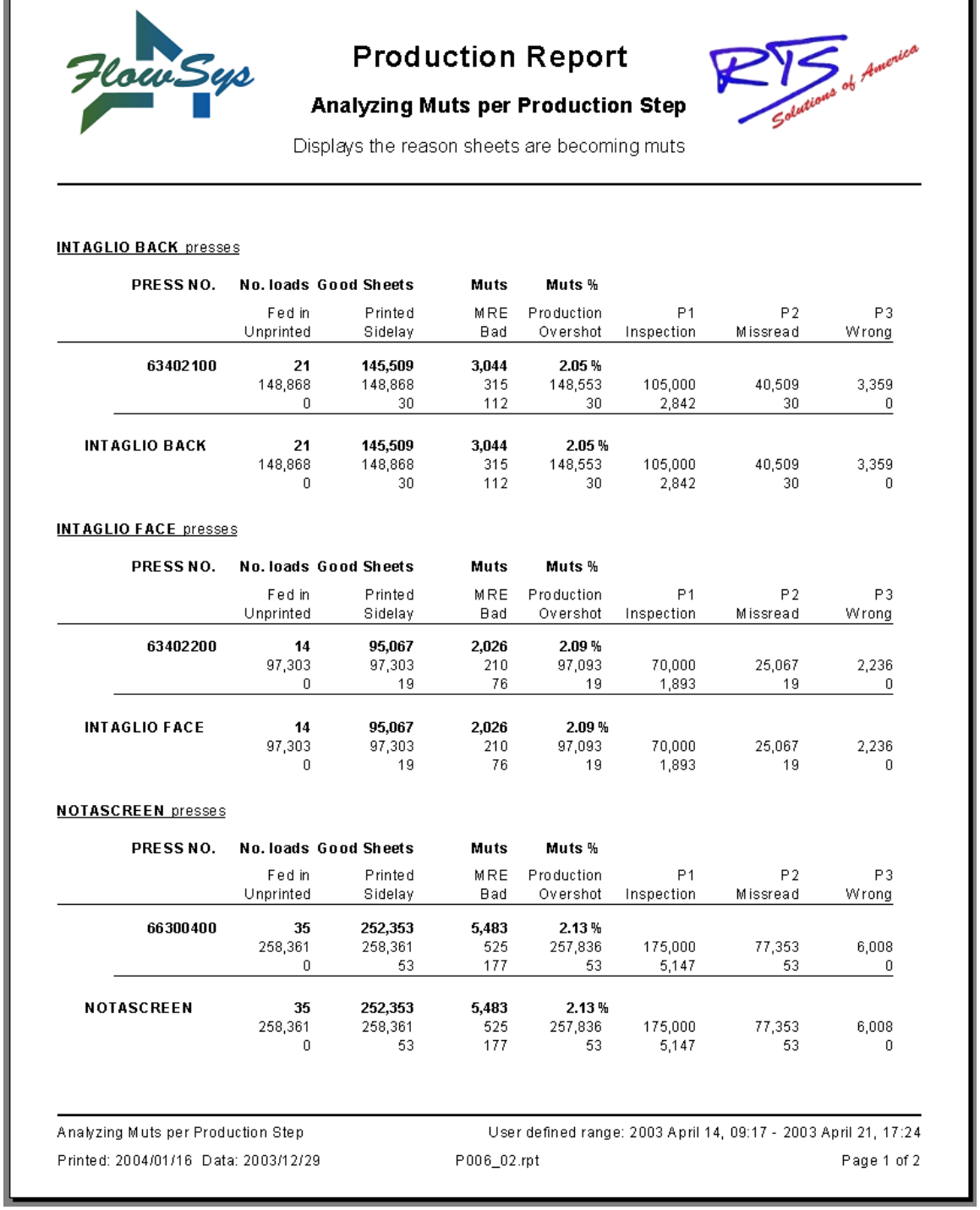
Comment (Document properties)
Displays the reason sheets are becoming muts

Description
Use for measurement reasons about the production performance – related only to the production steps (sections). Calculates the good sheets and the muts for each press and for each production step (Simultan, Intaglio, …). It shows a detailed reason / description why sheets are becoming muts and went to pile 3. All reasons are calculated per press and as sum of all presses in the same production step (section). Best to use when you want to go into detail to find out the reasons. All calculated values are depending on the time frame specified.

rpt name	Grouping (top to bottom)
P006_xx.rpt	Production Step / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:load	load_step, load_run {loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Production Report

Analyzing Muts per Production Step

Displays the reason sheets are becoming muts

INTAGLIO BACK presses

PRESS NO.	No. loads	Good Sheets	Muts	Muts %			
	Fed in Unprinted	Printed Sidelay	MRE Bad	Production Overshot	P1 Inspection	P2 Missread	P3 Wrong
63402100	**21**	**145,509**	**3,044**	**2.05 %**			
	148,868	148,868	315	148,553	105,000	40,509	3,359
	0	30	112	30	2,842	30	0
INTAGLIO BACK	**21**	**145,509**	**3,044**	**2.05 %**			
	148,868	148,868	315	148,553	105,000	40,509	3,359
	0	30	112	30	2,842	30	0

INTAGLIO FACE presses

PRESS NO.	No. loads	Good Sheets	Muts	Muts %			
	Fed in Unprinted	Printed Sidelay	MRE Bad	Production Overshot	P1 Inspection	P2 Missread	P3 Wrong
63402200	**14**	**95,067**	**2,026**	**2.09 %**			
	97,303	97,303	210	97,093	70,000	25,067	2,236
	0	19	76	19	1,893	19	0
INTAGLIO FACE	**14**	**95,067**	**2,026**	**2.09 %**			
	97,303	97,303	210	97,093	70,000	25,067	2,236
	0	19	76	19	1,893	19	0

NOTASCREEN presses

PRESS NO.	No. loads	Good Sheets	Muts	Muts %			
	Fed in Unprinted	Printed Sidelay	MRE Bad	Production Overshot	P1 Inspection	P2 Missread	P3 Wrong
66300400	**35**	**252,353**	**5,483**	**2.13 %**			
	258,361	258,361	525	257,836	175,000	77,353	6,008
	0	53	177	53	5,147	53	0
NOTASCREEN	**35**	**252,353**	**5,483**	**2.13 %**			
	258,361	258,361	525	257,836	175,000	77,353	6,008
	0	53	177	53	5,147	53	0

Analyzing Muts per Production Step — User defined range: 2003 April 14, 09:17 - 2003 April 21, 17:24

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1.7 Analyzing muts graphic per production step (P007)

Title (Document properties)	**Group**	**Graphic**
Analyzing muts graphic per production step	Production	Yes

Sub-Title (inside report)
Displays the reason sheets are becoming muts as graphic

Comment (Document properties)
Displays the reason sheets are becoming muts as graphic

Description
Use for measurement reasons about the production performance – related to the production steps (sections). Calculates the good sheets and the muts for each press and for each production step (Simultan, Intaglio, …). It shows a detailed reason / description why sheets are becoming muts and went to pile 3. All reasons are calculated per press and as sum of all presses in the same production step (section). Graphic is displayed for each production step. Best to use when you want to go into detail to find out the reasons. All calculated values are depending on the time frame specified.

rpt name	Grouping (top to bottom)
P007_xx.rpt	Production Step / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:load	load_step, load_run {loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

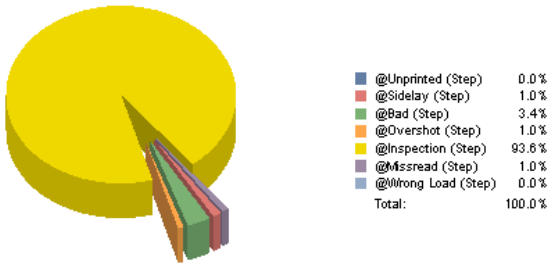
Production Report

Analyzing muts graphic per production step

Displays the reason sheets are becoming muts as graphic

INTAGLIO BACK presses

PRESS NO.	No. loads	Good Sheets	Muts	Muts %			
	Fed in Unprinted	Printed Sidelay	MRE Bad	Production Overshot	P1 Inspection	P2 Missread	P3 Wrong
66300400	**84**	**577,472**	**12,447**	**2.11 %**			
	591,179	591,179	1,260	589,919	420,000	157,472	13,707
	0	125	422	125	11,650	125	0
66300401	**84**	**581,142**	**11,850**	**2.00 %**			
	594,252	594,252	1,260	592,992	420,000	161,142	13,110
	0	118	403	118	11,093	118	0
INTAGLIO BACK	**168**	**1,158,614**	**24,297**	**2.05 %**			
	1,185,431	1,185,431	2,520	1,182,911	840,000	318,614	26,817
	0	243	825	243	22,743	243	0



Analyzing muts graphic per production step — User defined range: 2003 April 14, 09:16 - 2003 May 02, 17:27

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1.8 Shift report by press (P008)

Title (Document properties)	**Group**	**Graphic**
Shift report by press	Production	No

Sub-Title (inside report)
Displays sheets versus muts by shift and press

Comment (Document properties)
Displays sheets versus muts by shift and press

Description
Use for measurement reasons about the production performance – related to the production of every press per shift. The report is done out of the logbooks of all presses.

rpt name	Grouping (top to bottom
P008_xx.rpt	Denomination / Production Step

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	load_step
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Shift report by press

Displays sheets versus muts by shift and press

Press: **64401400**

2003/04/14 Shift: **Day** starts at 08:01:55

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts
1	SIMULTAN	03041401	SS0	L2	LEONARDO	09:22:38	7,450	50
2	SIMULTAN	03041402	SS0	L2	LEONARDO	10:32:30	7,475	25
3	SIMULTAN	03041403	SS0	L2	LEONARDO	11:48:57	7,496	4
4	SIMULTAN	03041404	SS0	L2	LEONARDO	12:59:42	7,300	200
5	SIMULTAN	03041405	SS0	L2	LEONARDO	14:08:07	7,283	217
6	SIMULTAN	03041406	SS0	L2	LEONARDO	15:26:02	7,329	171
7	SIMULTAN	03041407	SS0	L2	LEONARDO	16:46:51	7,236	264
							51,569	931

2003/04/14 Shift: **None** starts at 16:55:19

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts
							0	0

2003/04/15 Shift: **Day** starts at 08:05:03

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts
1	SIMULTAN	03041501	SS0	L2	LEONARDO	09:15:42	7,277	223
2	SIMULTAN	03041502	SS0	L2	LEONARDO	10:31:26	7,436	64
3	SIMULTAN	03041503	SS0	L2	LEONARDO	11:51:29	7,451	49
4	SIMULTAN	03041504	SS0	L2	LEONARDO	13:05:54	7,315	185
5	SIMULTAN	03041505	SS0	L2	LEONARDO	14:24:29	7,394	106
6	SIMULTAN	03041506	SS0	L2	LEONARDO	15:46:35	7,240	260
7	SIMULTAN	03041507	SS0	L2	LEONARDO	17:07:53	7,261	239
							51,374	1,126

2003/04/15 Shift: **None** starts at 17:16:21

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts
							0	0

2003/04/16 Shift: **Day** starts at 08:02:20

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts
1	SIMULTAN	03041601	SS0	L2	LEONARDO	09:16:59	7,297	203
2	SIMULTAN	03041602	SS0	L2	LEONARDO	10:40:51	7,336	164
3	SIMULTAN	03041603	SS0	L2	LEONARDO	12:07:07	7,365	135
4	SIMULTAN	03041604	SS0	L2	LEONARDO	13:31:51	7,384	116
5	SIMULTAN	03041605	SS0	L2	LEONARDO	14:48:57	7,479	21
6	SIMULTAN	03041606	SS0	L2	LEONARDO	16:06:28	7,448	52
7	SIMULTAN	03041607	SS0	L2	LEONARDO	17:18:36	7,271	229
							51,580	920

2003/04/16 Shift: **None** starts at 17:27:04

	Production step	Load #	Order #	Suff	Denomination	Finished	Good	Muts

Shift report by press — User defined range: 2003 April 14, 08:01 - 2003 April 21, 17:44

Printed: 2004/01/16 Data: 2004/01/16 — P008_01.rpt — Page 1 of 6

1.9 Produced loads by denomination (P009)

Title (Document properties)	**Group**	**Graphic**
Produced loads by denomination	Production	No

Sub-Title (inside report)
Displays loads produced for this denomination

Comment (Document properties)
Displays loads produced for this denomination

Description
Use for getting all loads for a denomination, which are produced in a certain time frame. It shows: • the normal load information like load number, order number and suffix • as well as the time this load got finished on this production step • which press it was running at • and the good sheets as well as the muts

rpt name	Grouping (top to bottom
P009_xx.rpt	Denomination / Production Step

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:denom	relation, load, load_step, load_run {loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Production Report

Produced loads by denomination

Displays loads produced for this denomination

DENOMINATION **LEONARDO**

Load	Order	S	Load finished at	Press #	Good	Muts
Production step **1** for denomination **LEONARDO** is **SIMULTAN**						
03041402	SS0	L2	2003/04/14 10:32:30	64401400	7,475	25
03041403	SS0	L2	2003/04/14 11:48:57	64401400	7,496	4
03041404	SS0	L2	2003/04/14 12:59:42	64401400	7,300	200
03041405	SS0	L2	2003/04/14 14:08:07	64401400	7,283	217
03041502	SS0	L2	2003/04/15 10:31:26	64401400	7,436	64
03041504	SS0	L2	2003/04/15 13:05:54	64401400	7,315	185
03042106	SS0	L2	2003/04/21 15:37:14	64401400	7,391	109
03042104	SS0	L2	2003/04/21 12:58:40	64401400	7,441	59
03042102	SS0	L2	2003/04/21 10:30:36	64401400	7,358	142
03041601	SS0	L2	2003/04/16 09:16:59	64401400	7,297	203
03041507	SS0	L2	2003/04/15 17:07:53	64401400	7,261	239
03041506	SS0	L2	2003/04/15 15:46:35	64401400	7,240	260
03042107	SS0	L2	2003/04/21 17:00:36	64401400	7,297	203
03041804	SS0	L2	2003/04/18 13:37:12	64401400	7,453	47
03041805	SS0	L2	2003/04/18 14:56:21	64401400	7,294	206
03041806	SS0	L2	2003/04/18 16:10:52	64401400	7,402	98
03041807	SS0	L2	2003/04/18 17:25:03	64401400	7,352	148
03042101	SS0	L2	2003/04/21 09:18:17	64401400	7,434	66
03041803	SS0	L2	2003/04/18 12:11:28	64401400	7,284	216
03041802	SS0	L2	2003/04/18 10:49:08	64401400	7,452	48
03041801	SS0	L2	2003/04/18 09:24:13	64401400	7,334	166
03041707	SS0	L2	2003/04/17 16:41:39	64401400	7,407	93
03041401	SS0	L2	2003/04/14 09:22:38	64401400	7,450	50
03041706	SS0	L2	2003/04/17 15:32:11	64401400	7,411	89
03041705	SS0	L2	2003/04/17 14:14:06	64401400	7,265	235
03041704	SS0	L2	2003/04/17 13:03:09	64401400	7,205	295
03041703	SS0	L2	2003/04/17 11:40:27	64401400	7,254	246
03041702	SS0	L2	2003/04/17 10:30:06	64401400	7,488	12
03041701	SS0	L2	2003/04/17 09:17:34	64401400	7,445	55
03041607	SS0	L2	2003/04/16 17:18:36	64401400	7,271	229
03041606	SS0	L2	2003/04/16 16:06:28	64401400	7,448	52
03041605	SS0	L2	2003/04/16 14:48:57	64401400	7,479	21
03041604	SS0	L2	2003/04/16 13:31:51	64401400	7,384	116
03041603	SS0	L2	2003/04/16 12:07:07	64401400	7,365	135
03041602	SS0	L2	2003/04/16 10:40:51	64401400	7,336	164
03042103	SS0	L2	2003/04/21 11:41:53	64401400	7,294	206
03042105	SS0	L2	2003/04/21 14:18:55	64401400	7,312	188
03041505	SS0	L2	2003/04/15 14:24:29	64401400	7,394	106
03041503	SS0	L2	2003/04/15 11:51:29	64401400	7,451	49
03041501	SS0	L2	2003/04/15 09:15:42	64401400	7,277	223
03041407	SS0	L2	2003/04/14 16:46:51	64401400	7,236	264
03041406	SS0	L2	2003/04/14 15:26:02	64401400	7,329	171

Produced loads by denomination — User defined range: 2003 April 14, 09:22 - 2003 April 21, 17:00

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1.10 Load History (P010)

Title (Document properties)	**Group**	**Graphic**
Load History	Production	No

Sub-Title (inside report)
Displays the production history of load(s)

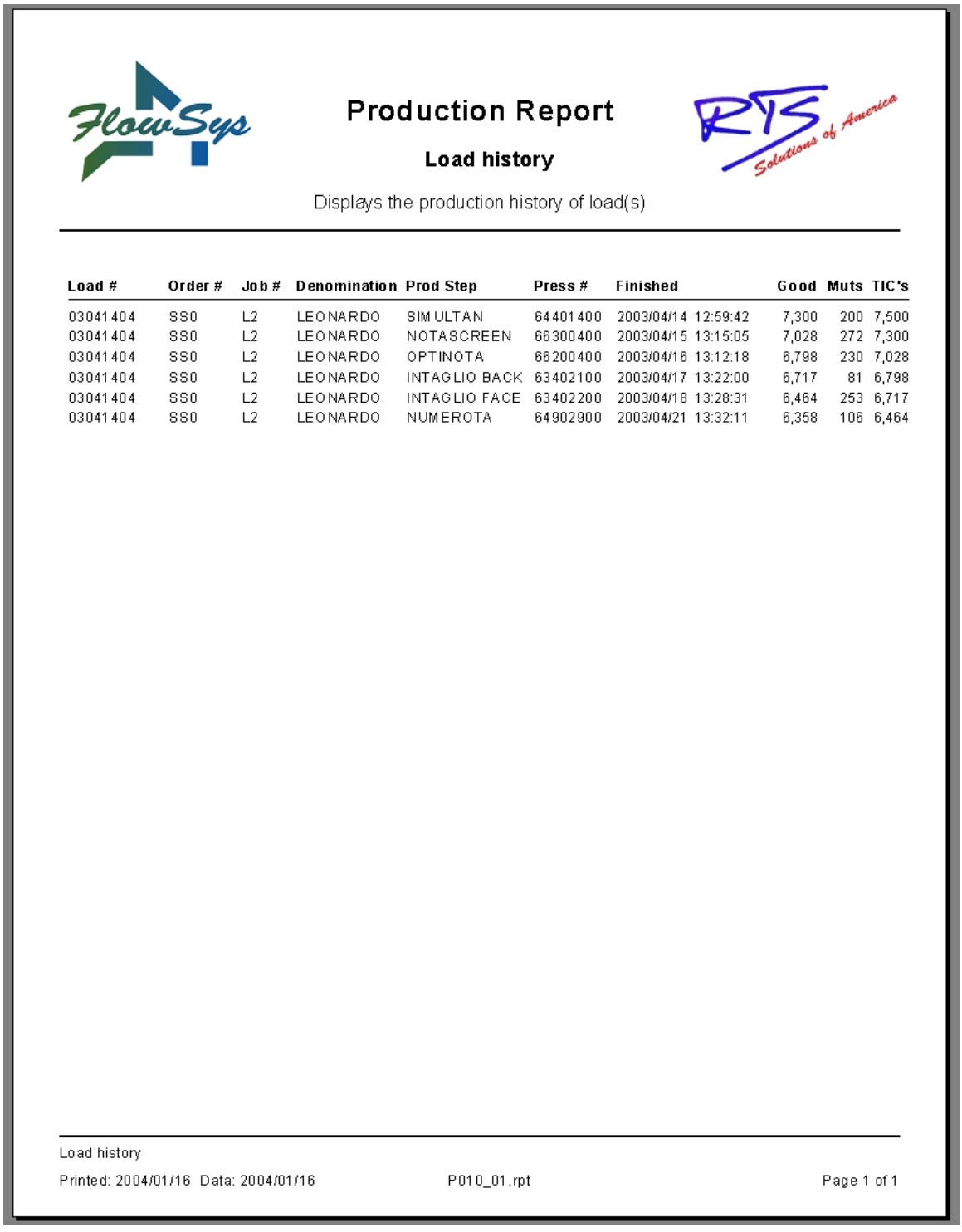
Comment (Document properties)
Displays the production history of load(s)

Description
Use this for getting information about. It shows: • the normal load information like load number, order number and suffix • as well as the time this load got finished on this production step • which press it was running at • and the good sheets as well as the muts • the used TIC's (Total Impact counts) on this run just for checking You can select the load were you want to see the load history from. It is possible to work with wildcards. Use "*" for multiple characters and "?" for single characters.

rpt name	Grouping (top to bottom
P010_xx.rpt	Denomination / Production Step

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:denom	relation, load, load_step, load_run
Time limitation field	Parameter field
	dwh_load.ld_id_load (wildcards: *,?)

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Production Report

Load history

Displays the production history of load(s)

Load #	Order #	Job #	Denomination	Prod Step	Press #	Finished	Good	Muts	TIC's
03041404	SS0	L2	LEONARDO	SIMULTAN	64401400	2003/04/14 12:59:42	7,300	200	7,500
03041404	SS0	L2	LEONARDO	NOTASCREEN	66300400	2003/04/15 13:15:05	7,028	272	7,300
03041404	SS0	L2	LEONARDO	OPTINOTA	66200400	2003/04/16 13:12:18	6,798	230	7,028
03041404	SS0	L2	LEONARDO	INTAGLIO BACK	63402100	2003/04/17 13:22:00	6,717	81	6,798
03041404	SS0	L2	LEONARDO	INTAGLIO FACE	63402200	2003/04/18 13:28:31	6,464	253	6,717
03041404	SS0	L2	LEONARDO	NUMEROTA	64902900	2003/04/21 13:32:11	6,358	106	6,464

Load history

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2 Group: Information and events

In this group you will find all reports, which display data about events and certain information about the production.

2.1 Press stop reason and downtime statistic (I001)

Title (Document properties)	**Group**	**Graphic**
Press stop reason and downtime statistic	Information	No

Sub-Title (inside report)
Displays the stop reasons and downtime by press

Comment (Document properties)
Displays the stop reasons and downtime by press

Description
The stop reason is supposed to be the main error occurring whenever a press stops (first error transmitted to FlowSys). All following errors occurring while the stop reason is ON (active) are defined to be subsequent errors and are not ascertainable by this statistic. Display for each stop reason by press: • how often it occurred • sum of downtimes of this certain stop reason • average of all downtimes of this certain reason • maximum of all downtimes of this certain reason • standard deviation of all downtimes of this certain reason Drill down (available for each stop reason) gives the possibility to see exactly when these stop reasons occurred and how much downtime they caused.

rpt name	Grouping (top to bottom)
I001_xx.rpt	Press / Stop reason

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	

Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Information Report

Press stop reason and downtime statistic

Displays the stop reasons and downtime by press

Press: **64401400**

Press stop reason	Count	Sum in sec	Avg in sec	Max in sec	StdDev in sec
KBA-ERR 0102 emergency stop DT12	42	2,814	67	67	0
KBA-ERR 0131 interrupt production	42	630	15	15	0
KBA-ERR 0610 sheetfollowing system	84	3,822	46	68	23

Press: **64902900**

Press stop reason	Count	Sum in sec	Avg in sec	Max in sec	StdDev in sec
KBA-ERR 0103 Overshoot monitoring at frontlay left	14	609	44	44	1
KBA-ERR 0104 Overshoot monitoring at frontlay right	7	2,422	346	346	0
Manual	7	0	0	0	0

Press: **66200400**

Press stop reason	Count	Sum in sec	Avg in sec	Max in sec	StdDev in sec
KBA-ERR 1220 feeder error	28	0	0	0	0
KBA-ERR 1644 Complete sheet monitoring delivery	28	2,828	101	101	0
KBA-ERR 1930 monitoring Indramat drives	28	280	10	10	0
KBA-ERR 1968 Paper reached photocell	28	9,520	340	340	0
Manual	56	0	0	0	0

Press: **66300400**

Press stop reason	Count	Sum in sec	Avg in sec	Max in sec	StdDev in sec
KBA-ERR 0243 Interrupt of production	35	15,050	430	430	0

Press: **64401400** Reason: **KBA-ERR 0610 sheetfollowing system**

Timestamp	downtime	Stop reason
2003/04/14 08:42:04	68	KBA-ERR 0610 sheetfollowing system
2003/04/21 16:07:25	23	KBA-ERR 0610 sheetfollowing system
2003/04/21 16:06:04	68	KBA-ERR 0610 sheetfollowing system

Press stop reason and downtime statistic — User defined range: 2003 April 14, 08:24 - 2003 April 21, 16:43

Printed: 2004/01/16 Data: 2004/01/06 — I001_01.rpt — Page 1 of 1

2.2 Press error statistic (I002)

Title (Document properties)	**Group**	**Graphic**
Press error statistic	Information	Yes

Sub-Title (inside report)
Displays statistic of all press errors by press

Comment (Document properties)
Displays statistic of all press errors by press

Description
This statistic is related to all errors occurring on a press. In contrast to the stop reason, which consider only the main errors. The statistic shows the top 10 of all errors and summarizes the rest of all others to make you get to the most important first. Display for each occurring error by press how often it occurred and a pie graphic for each press to give a quick overview where to focus. Drill down (available for each error) gives the possibility to see exactly when these errors occurred.

rpt name	Grouping (top to bottom)
I002_xx.rpt	Press / Error

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	

Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Information Report

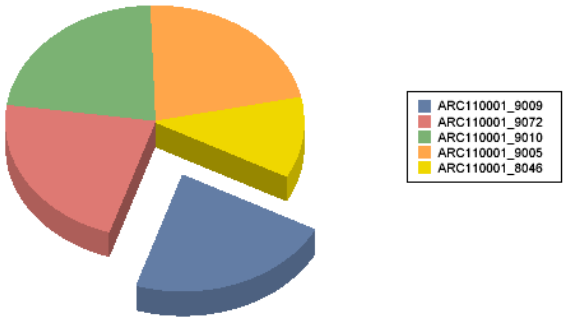
Press error statistic

Displays statistic of all press errors by press (Top 10)

Press: **63402100**

Error key		Occurences	in %
ARC110001_9009	KBA-CON 0010 sheet control left	42	22.2%
ARC110001_9072	KBA-CON 0073 value range positioningmodule SI	42	22.2%
ARC110001_9010	KBA-CON 0011 sheet control right	42	22.2%
ARC110001_9005	KBA-CON 0006 sidelay control	42	22.2%
ARC110001_8046	KBA-ERR 0215 cover stop drum	21	11.1%
Sum of all errors occured on this press		189	

Error count (Top 10)



Press error statistic — User defined range: 2003 April 17, 08:36 - 2003 April 21, 17:27

Printed: 2004/01/16 Data: 2004/01/16 — I002_02.rpt — Page 1 of 1

2.3 Press error trend (I003)

Title (Document properties)	**Group**	**Graphic**
Press error trend	Information	Yes

Sub-Title (inside report)
Press top 5 error trend

Comment (Document properties)
Press top 5 error trend

Description
This statistic is related to all errors occurring on a press. In contrast to the stop reason, which consider only the main errors. The statistic shows the top 5 of all errors and summarizes the rest of all others to make you get to the most important first. Display for each occurring error by press how often it occurred and a trend 3D bar graphic for occurring errors day / day. Drill down (available for each error) gives the possibility to see exactly when these errors occurred.

rpt name	Grouping (top to bottom)
I003_xx.rpt	Press / Day / Error

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	

Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

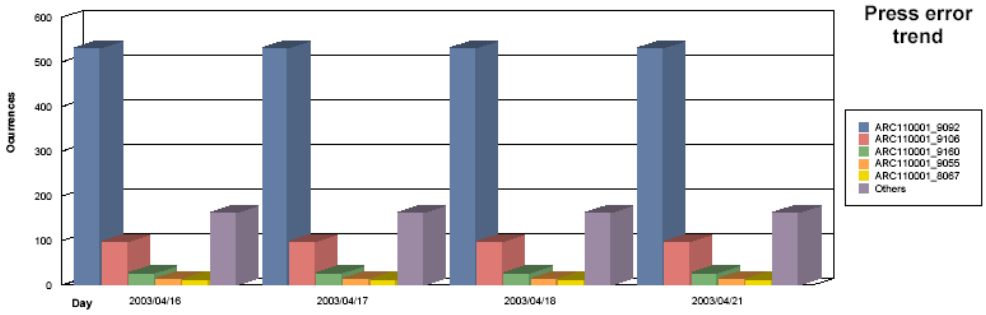
Information Report

Press error trend

Press top 5 error trend

Press: **66200400**

Error key		Occurance
2003/04/16		
ARC110001_9092	KBA-CON 0392 heating at stamp cylinder	532
ARC110001_9106	KBA-CON 0430 monitoring register controller	98
ARC110001_9160	KBA-CON 0930 start of production	28
ARC110001_9055	KBA-CON 0307 error power-factor compensation	15
ARC110001_8067	KBA-ERR 1220 feeder error	14
Others	Others	163
2003/04/17		
ARC110001_9092	KBA-CON 0392 heating at stamp cylinder	532
ARC110001_9106	KBA-CON 0430 monitoring register controller	98
ARC110001_9160	KBA-CON 0930 start of production	28
ARC110001_9055	KBA-CON 0307 error power-factor compensation	15
ARC110001_8067	KBA-ERR 1220 feeder error	14
Others	Others	163
2003/04/18		
ARC110001_9092	KBA-CON 0392 heating at stamp cylinder	532
ARC110001_9106	KBA-CON 0430 monitoring register controller	98
ARC110001_9160	KBA-CON 0930 start of production	28
ARC110001_9055	KBA-CON 0307 error power-factor compensation	15
ARC110001_8067	KBA-ERR 1220 feeder error	14
Others	Others	163
2003/04/21		
ARC110001_9092	KBA-CON 0392 heating at stamp cylinder	532
ARC110001_9106	KBA-CON 0430 monitoring register controller	98
ARC110001_9160	KBA-CON 0930 start of production	28
ARC110001_9055	KBA-CON 0307 error power-factor compensation	15
ARC110001_8067	KBA-ERR 1220 feeder error	14
Others	Others	163
Sum of all errors occured on this press		**3,400**



Press error trend — User defined range: 2003 April 16, 08:09 - 2003 April 21, 16:59

Printed: 2004/01/16 Data: 2004/01/16 — I003_01.rpt — Page 1 of 1

2.4 Equipment Exchanges (I004)

Title (Document properties)	**Group**	**Graphic**
Equipment exchanges	Information	No

Sub-Title (inside report)
Displays when consumables / equipments have changed

Comment (Document properties)
Displays when consumables / equipments have changed

Description

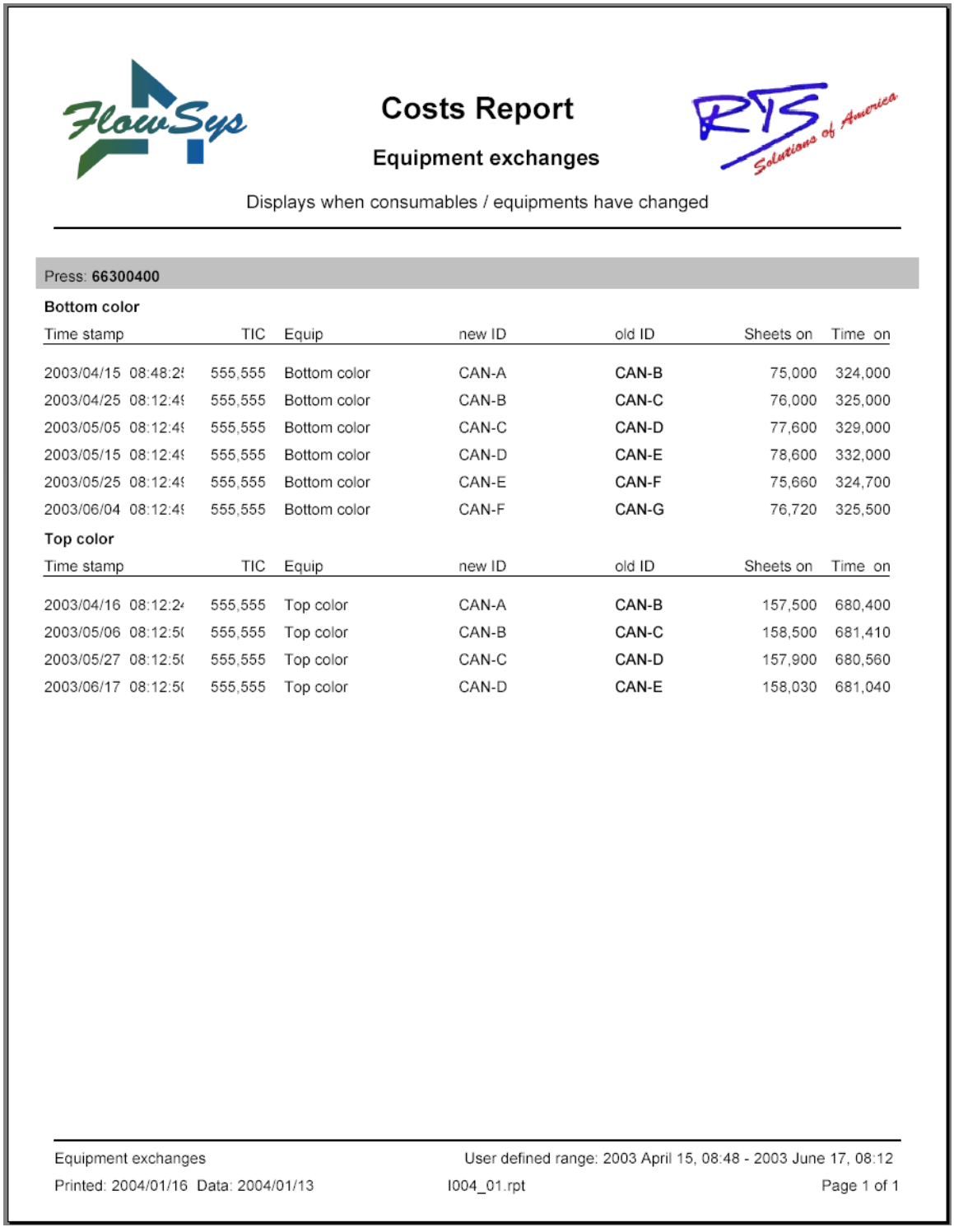
Displays every change of a consumables or used materials like **ink, plates, blankets, impression cylinders, blades, ball bearings, patches** or whatever you specify as so called equipments at the presses FlowSys console (actually it's up to your administrator to use up to 50 different one) :

- Time
- TIC
- Name of the material / equipment
- New and old ID number
- How much sheets the "old" material got on before it was exchanged
- How much time (in seconds) the "old" material got on before it was exchanged

rpt name	Grouping (top to bottom)
I004_xx.rpt	Press / equipment

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Costs Report

Equipment exchanges

Displays when consumables / equipments have changed

Press: **66300400**

Bottom color

Time stamp	TIC	Equip	new ID	old ID	Sheets on	Time on
2003/04/15 08:48:2	555,555	Bottom color	CAN-A	CAN-B	75,000	324,000
2003/04/25 08:12:4	555,555	Bottom color	CAN-B	CAN-C	76,000	325,000
2003/05/05 08:12:4	555,555	Bottom color	CAN-C	CAN-D	77,600	329,000
2003/05/15 08:12:4	555,555	Bottom color	CAN-D	CAN-E	78,600	332,000
2003/05/25 08:12:4	555,555	Bottom color	CAN-E	CAN-F	75,660	324,700
2003/06/04 08:12:4	555,555	Bottom color	CAN-F	CAN-G	76,720	325,500

Top color

Time stamp	TIC	Equip	new ID	old ID	Sheets on	Time on
2003/04/16 08:12:2	555,555	Top color	CAN-A	CAN-B	157,500	680,400
2003/05/06 08:12:5	555,555	Top color	CAN-B	CAN-C	158,500	681,410
2003/05/27 08:12:5	555,555	Top color	CAN-C	CAN-D	157,900	680,560
2003/06/17 08:12:5	555,555	Top color	CAN-D	CAN-E	158,030	681,040

Equipment exchanges — User defined range: 2003 April 15, 08:48 - 2003 June 17, 08:12

Printed: 2004/01/16 Data: 2004/01/13 — I004_01.rpt — Page 1 of 1

2.5 Load throughput (I005)

Title (Document properties)	**Group**	**Graphic**
Load throughput	Information	No

Sub-Title (inside report)
Displays load throughput on presses

Comment (Document properties)
Displays load throughput on presses

Description
Shows every load related event on the press: • Load create • Load received from database • Load run start • Load run stop • Load removed from load list (delete a new one, or sent back to database received loads) • Load changed inside load queue (changeable are "running sheets" and load text only)

rpt name	Grouping (top to bottom)
I005_xx.rpt	Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Information Report

Load throughput

Displays load throughput on presses

64401400

Time	TIC	Action related to a load
2003/04/14 08:21:30	16,344,512	LOAD NEW: name: 03041401 size: 7500 running: 7500
2003/04/14 08:27:10	16,344,512	LOAD START: name: 03041401 Running: 7500
2003/04/14 08:51:40	16,352,012	LOAD STOP: name: 03041401 Running: 7500 to 7500
2003/04/14 09:36:25	16,352,012	LOAD NEW: name: 03041402 size: 7500 running: 7500
2003/04/14 09:42:05	16,352,012	LOAD START: name: 03041402 Running: 7500
2003/04/14 10:06:35	16,359,512	LOAD STOP: name: 03041402 Running: 7500 to 7500
2003/04/14 11:00:44	16,359,512	LOAD NEW: name: 03041403 size: 7500 running: 7500
2003/04/14 11:06:24	16,359,512	LOAD START: name: 03041403 Running: 7500
2003/04/14 11:30:54	16,367,012	LOAD STOP: name: 03041403 Running: 7500 to 7500
2003/04/14 12:11:52	16,367,012	LOAD NEW: name: 03041404 size: 7500 running: 7500
2003/04/14 12:17:32	16,367,012	LOAD START: name: 03041404 Running: 7500
2003/04/14 12:42:02	16,374,512	LOAD STOP: name: 03041404 Running: 7500 to 7500
2003/04/14 13:28:45	16,374,512	LOAD NEW: name: 03041405 size: 7500 running: 7500
2003/04/14 13:34:25	16,374,512	LOAD START: name: 03041405 Running: 7500
2003/04/14 13:58:55	16,382,012	LOAD STOP: name: 03041405 Running: 7500 to 7500
2003/04/14 14:36:30	16,382,012	LOAD NEW: name: 03041406 size: 7500 running: 7500
2003/04/14 14:42:10	16,382,012	LOAD START: name: 03041406 Running: 7500
2003/04/14 15:06:40	16,389,512	LOAD STOP: name: 03041406 Running: 7500 to 7500
2003/04/14 15:53:53	16,389,512	LOAD NEW: name: 03041407 size: 7500 running: 7500
2003/04/14 15:59:33	16,389,512	LOAD START: name: 03041407 Running: 7500
2003/04/14 16:24:03	16,397,012	LOAD STOP: name: 03041407 Running: 7500 to 7500
2003/04/15 08:25:32	16,397,012	LOAD NEW: name: 03041501 size: 7500 running: 7500
2003/04/15 08:31:12	16,397,012	LOAD START: name: 03041501 Running: 7500
2003/04/15 08:55:42	16,404,512	LOAD STOP: name: 03041501 Running: 7500 to 7500
2003/04/15 09:37:51	16,404,512	LOAD NEW: name: 03041502 size: 7500 running: 7500
2003/04/15 09:43:31	16,404,512	LOAD START: name: 03041502 Running: 7500
2003/04/15 10:08:01	16,412,012	LOAD STOP: name: 03041502 Running: 7500 to 7500
2003/04/15 10:50:57	16,412,012	LOAD NEW: name: 03041503 size: 7500 running: 7500
2003/04/15 10:56:37	16,412,012	LOAD START: name: 03041503 Running: 7500
2003/04/15 11:21:07	16,419,512	LOAD STOP: name: 03041503 Running: 7500 to 7500
2003/04/15 12:13:18	16,419,512	LOAD NEW: name: 03041504 size: 7500 running: 7500
2003/04/15 12:18:58	16,419,512	LOAD START: name: 03041504 Running: 7500
2003/04/15 12:43:28	16,427,012	LOAD STOP: name: 03041504 Running: 7500 to 7500
2003/04/15 13:32:25	16,427,012	LOAD NEW: name: 03041505 size: 7500 running: 7500
2003/04/15 13:38:05	16,427,012	LOAD START: name: 03041505 Running: 7500
2003/04/15 14:02:35	16,434,512	LOAD STOP: name: 03041505 Running: 7500 to 7500
2003/04/15 14:57:27	16,434,512	LOAD NEW: name: 03041506 size: 7500 running: 7500
2003/04/15 15:03:07	16,434,512	LOAD START: name: 03041506 Running: 7500
2003/04/15 15:27:37	16,442,012	LOAD STOP: name: 03041506 Running: 7500 to 7500
2003/04/15 16:19:07	16,442,012	LOAD NEW: name: 03041507 size: 7500 running: 7500
2003/04/15 16:24:47	16,442,012	LOAD START: name: 03041507 Running: 7500
2003/04/15 16:49:17	16,449,512	LOAD STOP: name: 03041507 Running: 7500 to 7500
2003/04/16 08:21:29	16,449,512	LOAD NEW: name: 03041601 size: 7500 running: 7500
2003/04/16 08:27:09	16,449,512	LOAD START: name: 03041601 Running: 7500
2003/04/16 08:51:39	16,457,012	LOAD STOP: name: 03041601 Running: 7500 to 7500
2003/04/16 09:28:30	16,457,012	LOAD NEW: name: 03041602 size: 7500 running: 7500
2003/04/16 09:34:10	16,457,012	LOAD START: name: 03041602 Running: 7500

2.6 Press errors (I006)

Title (Document properties)	**Group**	**Graphic**
Press errors	Information	No

Sub-Title (inside report)
Displays all errors occurred on presses

Comment (Document properties)
Displays all errors occurred on presses

Description

Shows every KBA error occurred on the press:

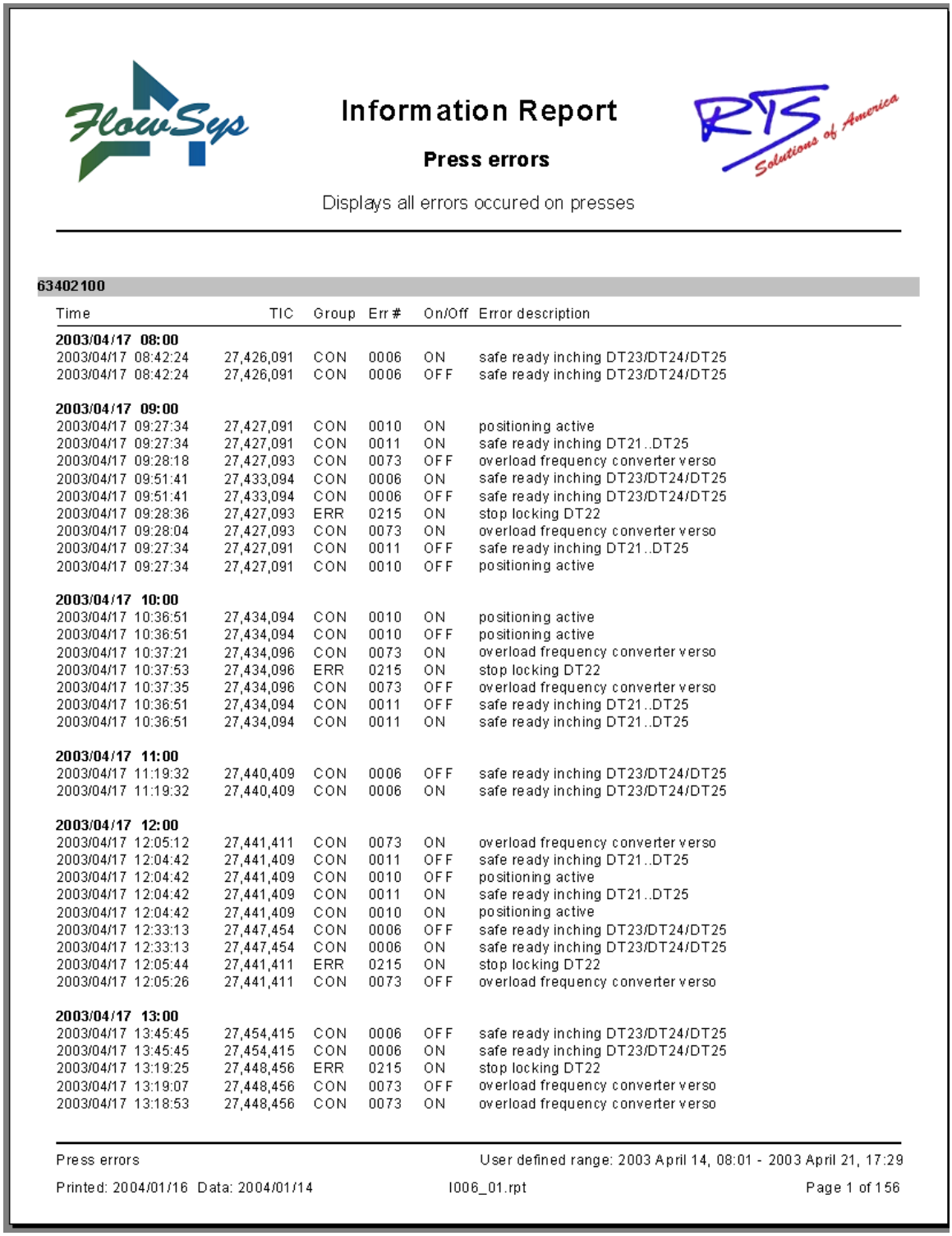
- Time stamp
- TIC Total Impact Counter
- Error group
  - ERR … KBA press error
  - CON … KBA press condition message
  - RED … KBA press redundant message
- Error number & description
- Error On/Off

rpt name	Grouping (top to bottom)
I006_xx.rpt	Press / Hourly

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	

Limitation field(s)	Parameter field
dm_arc_v:arc_time dm_arc_v:arc_station	KBA error number (dm_evtxt_v:part of ev_decription) (Wildcards ?,*)

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Information Report

Press errors

Displays all errors occured on presses

63402100

Time	TIC	Group	Err #	On/Off	Error description
2003/04/17 08:00					
2003/04/17 08:42:24	27,426,091	CON	0006	ON	safe ready inching DT23/DT24/DT25
2003/04/17 08:42:24	27,426,091	CON	0006	OFF	safe ready inching DT23/DT24/DT25
2003/04/17 09:00					
2003/04/17 09:27:34	27,427,091	CON	0010	ON	positioning active
2003/04/17 09:27:34	27,427,091	CON	0011	ON	safe ready inching DT21..DT25
2003/04/17 09:28:18	27,427,093	CON	0073	OFF	overload frequency converter verso
2003/04/17 09:51:41	27,433,094	CON	0006	ON	safe ready inching DT23/DT24/DT25
2003/04/17 09:51:41	27,433,094	CON	0006	OFF	safe ready inching DT23/DT24/DT25
2003/04/17 09:28:36	27,427,093	ERR	0215	ON	stop locking DT22
2003/04/17 09:28:04	27,427,093	CON	0073	ON	overload frequency converter verso
2003/04/17 09:27:34	27,427,091	CON	0011	OFF	safe ready inching DT21..DT25
2003/04/17 09:27:34	27,427,091	CON	0010	OFF	positioning active
2003/04/17 10:00					
2003/04/17 10:36:51	27,434,094	CON	0010	ON	positioning active
2003/04/17 10:36:51	27,434,094	CON	0010	OFF	positioning active
2003/04/17 10:37:21	27,434,096	CON	0073	ON	overload frequency converter verso
2003/04/17 10:37:53	27,434,096	ERR	0215	ON	stop locking DT22
2003/04/17 10:37:35	27,434,096	CON	0073	OFF	overload frequency converter verso
2003/04/17 10:36:51	27,434,094	CON	0011	OFF	safe ready inching DT21..DT25
2003/04/17 10:36:51	27,434,094	CON	0011	ON	safe ready inching DT21..DT25
2003/04/17 11:00					
2003/04/17 11:19:32	27,440,409	CON	0006	OFF	safe ready inching DT23/DT24/DT25
2003/04/17 11:19:32	27,440,409	CON	0006	ON	safe ready inching DT23/DT24/DT25
2003/04/17 12:00					
2003/04/17 12:05:12	27,441,411	CON	0073	ON	overload frequency converter verso
2003/04/17 12:04:42	27,441,409	CON	0011	OFF	safe ready inching DT21..DT25
2003/04/17 12:04:42	27,441,409	CON	0010	OFF	positioning active
2003/04/17 12:04:42	27,441,409	CON	0011	ON	safe ready inching DT21..DT25
2003/04/17 12:04:42	27,441,409	CON	0010	ON	positioning active
2003/04/17 12:33:13	27,447,454	CON	0006	OFF	safe ready inching DT23/DT24/DT25
2003/04/17 12:33:13	27,447,454	CON	0006	ON	safe ready inching DT23/DT24/DT25
2003/04/17 12:05:44	27,441,411	ERR	0215	ON	stop locking DT22
2003/04/17 12:05:26	27,441,411	CON	0073	OFF	overload frequency converter verso
2003/04/17 13:00					
2003/04/17 13:45:45	27,454,415	CON	0006	OFF	safe ready inching DT23/DT24/DT25
2003/04/17 13:45:45	27,454,415	CON	0006	ON	safe ready inching DT23/DT24/DT25
2003/04/17 13:19:25	27,448,456	ERR	0215	ON	stop locking DT22
2003/04/17 13:19:07	27,448,456	CON	0073	OFF	overload frequency converter verso
2003/04/17 13:18:53	27,448,456	CON	0073	ON	overload frequency converter verso

Press errors — User defined range: 2003 April 14, 08:01 - 2003 April 21, 17:29

Printed: 2004/01/16 Data: 2004/01/14 — I006_01.rpt — Page 1 of 156

2.7 All Press events (I007)

Title (Document properties)	**Group**	**Graphic**
All press events	Information	No

Sub-Title (inside report)
Displays all events occurred on presses

Comment (Document properties)
Displays all events occurred on presses

Description

Shows every event occurred on the press. That means: Every KBA press error messages, mixed with all FlowSys events are displayed.

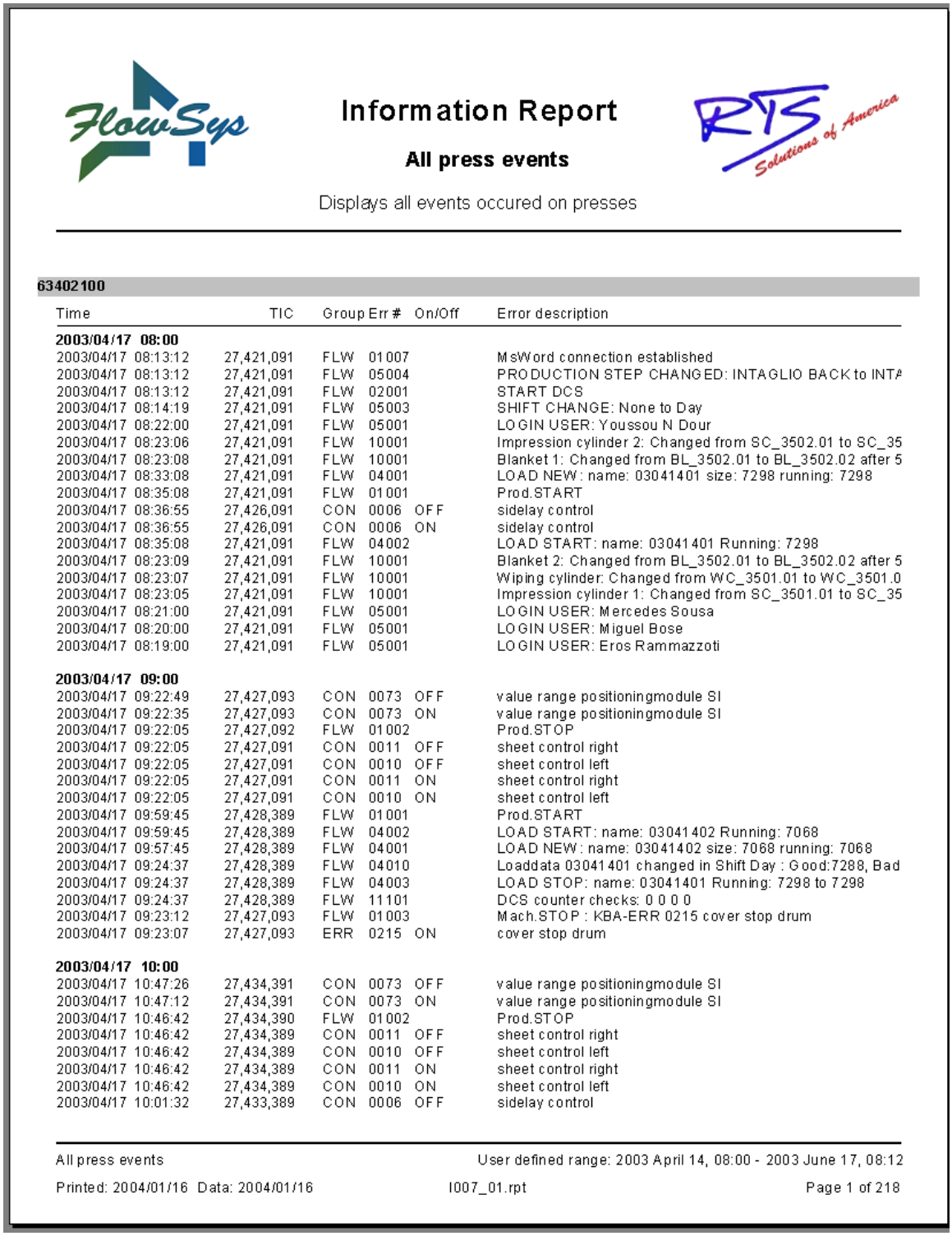
- Time stamp
- TIC Total Impact Counter
- Error group
  - ERR … KBA press error
  - CON … KBA press condition message
  - RED … KBA press redundant message
  - FLW … FlowSys event
- KBA-Error number / FlowSys-Event number & description
- Error On/Off

rpt name	Grouping (top to bottom)
I007_xx.rpt	Press / per hour

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	

Limitation field(s)	Parameter field
dm_arc_v:arc_time dm_arc_v:arc_station	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Information Report

All press events

Displays all events occured on presses

63402100

Time	TIC	Group	Err #	On/Off	Error description
2003/04/17 08:00					
2003/04/17 08:13:12	27,421,091	FLW	01007		MsWord connection established
2003/04/17 08:13:12	27,421,091	FLW	05004		PRODUCTION STEP CHANGED: INTAGLIO BACK to INTA
2003/04/17 08:13:12	27,421,091	FLW	02001		START DCS
2003/04/17 08:14:19	27,421,091	FLW	05003		SHIFT CHANGE: None to Day
2003/04/17 08:22:00	27,421,091	FLW	05001		LOGIN USER: Youssou N Dour
2003/04/17 08:23:06	27,421,091	FLW	10001		Impression cylinder 2: Changed from SC_3502.01 to SC_35
2003/04/17 08:23:08	27,421,091	FLW	10001		Blanket 1: Changed from BL_3502.01 to BL_3502.02 after 5
2003/04/17 08:33:08	27,421,091	FLW	04001		LOAD NEW: name: 03041401 size: 7298 running: 7298
2003/04/17 08:35:08	27,421,091	FLW	01001		Prod.START
2003/04/17 08:36:55	27,426,091	CON	0006	OFF	sidelay control
2003/04/17 08:36:55	27,426,091	CON	0006	ON	sidelay control
2003/04/17 08:35:08	27,421,091	FLW	04002		LOAD START: name: 03041401 Running: 7298
2003/04/17 08:23:09	27,421,091	FLW	10001		Blanket 2: Changed from BL_3502.01 to BL_3502.02 after 5
2003/04/17 08:23:07	27,421,091	FLW	10001		Wiping cylinder: Changed from WC_3501.01 to WC_3501.0
2003/04/17 08:23:05	27,421,091	FLW	10001		Impression cylinder 1: Changed from SC_3501.01 to SC_35
2003/04/17 08:21:00	27,421,091	FLW	05001		LOGIN USER: Mercedes Sousa
2003/04/17 08:20:00	27,421,091	FLW	05001		LOGIN USER: Miguel Bose
2003/04/17 08:19:00	27,421,091	FLW	05001		LOGIN USER: Eros Rammazzoti
2003/04/17 09:00					
2003/04/17 09:22:49	27,427,093	CON	0073	OFF	value range positioningmodule SI
2003/04/17 09:22:35	27,427,093	CON	0073	ON	value range positioningmodule SI
2003/04/17 09:22:05	27,427,092	FLW	01002		Prod.STOP
2003/04/17 09:22:05	27,427,091	CON	0011	OFF	sheet control right
2003/04/17 09:22:05	27,427,091	CON	0010	OFF	sheet control left
2003/04/17 09:22:05	27,427,091	CON	0011	ON	sheet control right
2003/04/17 09:22:05	27,427,091	CON	0010	ON	sheet control left
2003/04/17 09:59:45	27,428,389	FLW	01001		Prod.START
2003/04/17 09:59:45	27,428,389	FLW	04002		LOAD START: name: 03041402 Running: 7068
2003/04/17 09:57:45	27,428,389	FLW	04001		LOAD NEW: name: 03041402 size: 7068 running: 7068
2003/04/17 09:24:37	27,428,389	FLW	04010		Loaddata 03041401 changed in Shift Day : Good:7288, Bad
2003/04/17 09:24:37	27,428,389	FLW	04003		LOAD STOP: name: 03041401 Running: 7298 to 7298
2003/04/17 09:24:37	27,428,389	FLW	11101		DCS counter checks: 0 0 0 0
2003/04/17 09:23:12	27,427,093	FLW	01003		Mach.STOP : KBA-ERR 0215 cover stop drum
2003/04/17 09:23:07	27,427,093	ERR	0215	ON	cover stop drum
2003/04/17 10:00					
2003/04/17 10:47:26	27,434,391	CON	0073	OFF	value range positioningmodule SI
2003/04/17 10:47:12	27,434,391	CON	0073	ON	value range positioningmodule SI
2003/04/17 10:46:42	27,434,390	FLW	01002		Prod.STOP
2003/04/17 10:46:42	27,434,389	CON	0011	OFF	sheet control right
2003/04/17 10:46:42	27,434,389	CON	0010	OFF	sheet control left
2003/04/17 10:46:42	27,434,389	CON	0011	ON	sheet control right
2003/04/17 10:46:42	27,434,389	CON	0010	ON	sheet control left
2003/04/17 10:01:32	27,433,389	CON	0006	OFF	sidelay control

All press events — User defined range: 2003 April 14, 08:00 - 2003 June 17, 08:12

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2.8 All FlowSys events (I008)

Title (Document properties)	**Group**	**Graphic**
All FlowSys events	Information	No

Sub-Title (inside report)

Displays all FlowSys events occurred on presses

Comment (Document properties)

Displays all FlowSys events occurred on presses

Description

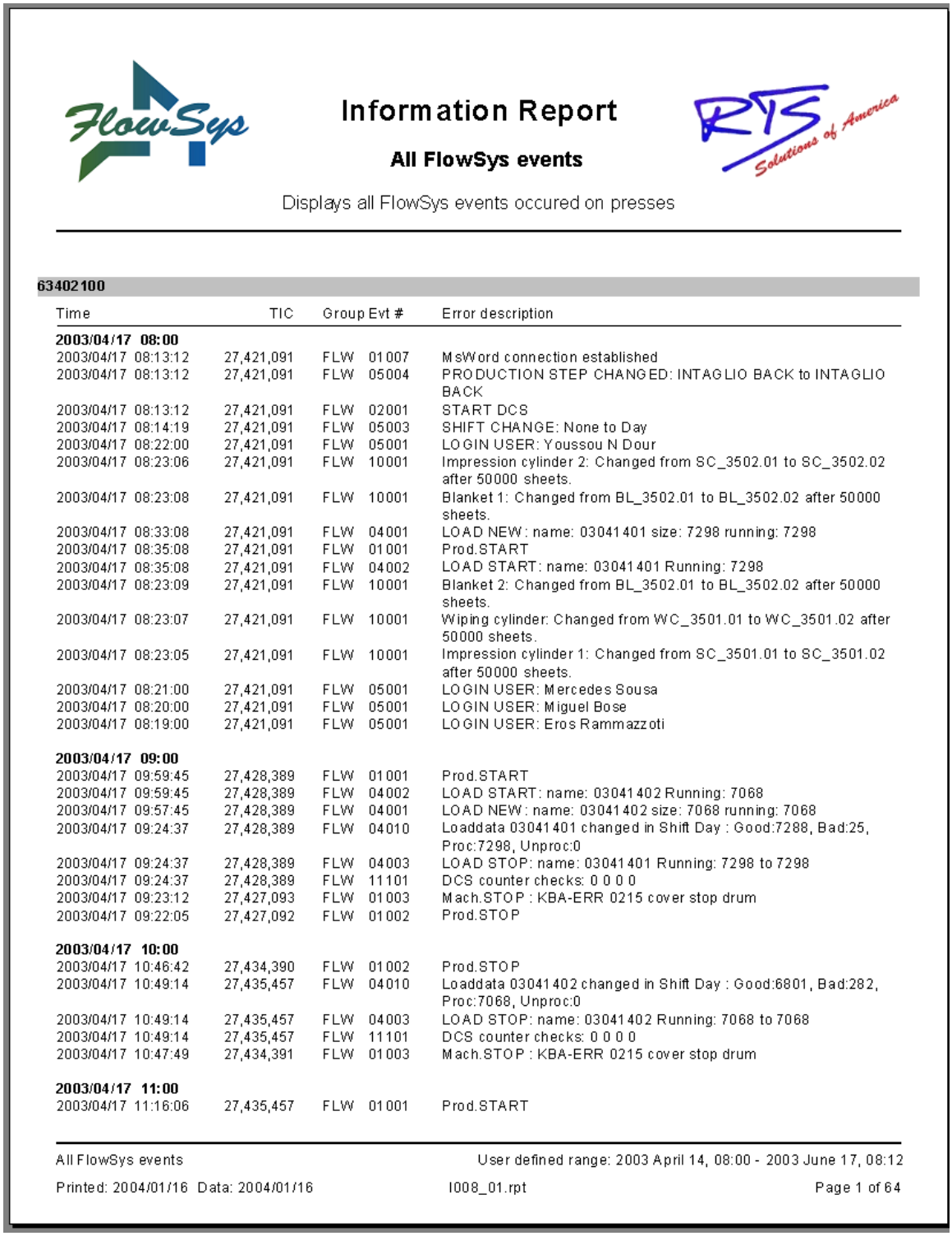
Shows every event occurred on the press. That means: Every KBA press error messages, mixed with all FlowSys events are displayed.

- Time stamp
- TIC Total Impact Counter
- Error group
  - ERR … KBA press error
  - CON … KBA press condition message
  - RED … KBA press redundant message
  - FLW … FlowSys event
- KBA-Error number / FlowSys-Event number & description
- Error On/Off

rpt name	Grouping (top to bottom)
I008_xx.rpt	Press / per hour

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Limitation field(s)	**Parameter field**
dm_arc_v:arc_time dm_arc_v:arc_station	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Information Report

All FlowSys events

Displays all FlowSys events occured on presses

63402100

Time	TIC	Group	Evt #	Error description
2003/04/17 08:00				
2003/04/17 08:13:12	27,421,091	FLW	01007	MsWord connection established
2003/04/17 08:13:12	27,421,091	FLW	05004	PRODUCTION STEP CHANGED: INTAGLIO BACK to INTAGLIO BACK
2003/04/17 08:13:12	27,421,091	FLW	02001	START DCS
2003/04/17 08:14:19	27,421,091	FLW	05003	SHIFT CHANGE: None to Day
2003/04/17 08:22:00	27,421,091	FLW	05001	LOGIN USER: Youssou N Dour
2003/04/17 08:23:06	27,421,091	FLW	10001	Impression cylinder 2: Changed from SC_3502.01 to SC_3502.02 after 50000 sheets.
2003/04/17 08:23:08	27,421,091	FLW	10001	Blanket 1: Changed from BL_3502.01 to BL_3502.02 after 50000 sheets.
2003/04/17 08:33:08	27,421,091	FLW	04001	LOAD NEW: name: 03041401 size: 7298 running: 7298
2003/04/17 08:35:08	27,421,091	FLW	01001	Prod.START
2003/04/17 08:35:08	27,421,091	FLW	04002	LOAD START: name: 03041401 Running: 7298
2003/04/17 08:23:09	27,421,091	FLW	10001	Blanket 2: Changed from BL_3502.01 to BL_3502.02 after 50000 sheets.
2003/04/17 08:23:07	27,421,091	FLW	10001	Wiping cylinder: Changed from WC_3501.01 to WC_3501.02 after 50000 sheets.
2003/04/17 08:23:05	27,421,091	FLW	10001	Impression cylinder 1: Changed from SC_3501.01 to SC_3501.02 after 50000 sheets.
2003/04/17 08:21:00	27,421,091	FLW	05001	LOGIN USER: Mercedes Sousa
2003/04/17 08:20:00	27,421,091	FLW	05001	LOGIN USER: Miguel Bose
2003/04/17 08:19:00	27,421,091	FLW	05001	LOGIN USER: Eros Rammazzoti
2003/04/17 09:00				
2003/04/17 09:59:45	27,428,389	FLW	01001	Prod.START
2003/04/17 09:59:45	27,428,389	FLW	04002	LOAD START: name: 03041402 Running: 7068
2003/04/17 09:57:45	27,428,389	FLW	04001	LOAD NEW: name: 03041402 size: 7068 running: 7068
2003/04/17 09:24:37	27,428,389	FLW	04010	Loaddata 03041401 changed in Shift Day : Good:7288, Bad:25, Proc:7298, Unproc:0
2003/04/17 09:24:37	27,428,389	FLW	04003	LOAD STOP: name: 03041401 Running: 7298 to 7298
2003/04/17 09:24:37	27,428,389	FLW	11101	DCS counter checks: 0 0 0 0
2003/04/17 09:23:12	27,427,093	FLW	01003	Mach.STOP : KBA-ERR 0215 cover stop drum
2003/04/17 09:22:05	27,427,092	FLW	01002	Prod.STOP
2003/04/17 10:00				
2003/04/17 10:46:42	27,434,390	FLW	01002	Prod.STOP
2003/04/17 10:49:14	27,435,457	FLW	04010	Loaddata 03041402 changed in Shift Day : Good:6801, Bad:282, Proc:7068, Unproc:0
2003/04/17 10:49:14	27,435,457	FLW	04003	LOAD STOP: name: 03041402 Running: 7068 to 7068
2003/04/17 10:49:14	27,435,457	FLW	11101	DCS counter checks: 0 0 0 0
2003/04/17 10:47:49	27,434,391	FLW	01003	Mach.STOP : KBA-ERR 0215 cover stop drum
2003/04/17 11:00				
2003/04/17 11:16:06	27,435,457	FLW	01001	Prod.START

All FlowSys events — User defined range: 2003 April 14, 08:00 - 2003 June 17, 08:12

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3 Group: Costs

In this group you will find all reports, which display data relating to a cost overview over the production.

3.1 Crew work time per week (C001)

Title (Document properties)	**Group**	**Graphic**
Crew work time per week	Costs	No

Sub-Title (inside report)
Displays the crew work time per week for each press

Comment (Document properties)
Displays the crew work time per week for each press

Description
Use for work time calculations by the crew of the presses.

rpt name	Grouping (top to bottom)
C001_xx.rpt	Week of Year / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Cost Report

Crew worktime per week

Displays the crew worktime per week for each press

Year 2003 / Week 16 (starting 2003/04/13)

Press #	Hours
63402100	70.47
63402200	35.42
64401400	170.57
66200400	106.98
66300400	138.07

Year 2003 / Week 17 (starting 2003/04/20)

Press #	Hours
63402100	33.93
63402200	33.37
64401400	34.63
64902900	35.30
66200400	34.83
66300400	33.43

Press #	Daily hours	Date	Crew member
63402100	9.05	2003/04/17	Eros Rammazzoti
63402100	9.07	2003/04/17	Miguel Bose
63402100	9.07	2003/04/17	Mercedes Sousa
63402100	9.08	2003/04/17	Youssou N Dour
63402100	8.53	2003/04/18	Eros Rammazzoti
63402100	8.55	2003/04/18	Miguel Bose
63402100	8.55	2003/04/18	Mercedes Sousa
63402100	8.57	2003/04/18	Youssou N Dour
63402100	**70.47**		

Crew worktime per week — User defined range: 2003 April 14, 08:31 - 2003 April 21, 17:54

Printed: 2004/01/16 Data: 2003/12/28 — C001.rpt — Page 1 of 1

3.2 Crew work time per month (C002)

Title (Document properties)	**Group**	**Graphic**
Crew work time per month	Costs	No

Sub-Title (inside report)
Displays the crew work time per month for each press

Comment (Document properties)
Displays the crew work time per month for each press

Description
Use for work time calculations by the crew of the presses.

rpt name	Grouping (top to bottom)
C002_xx.rpt	Month of Year / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Cost Report

Crew worktime per month

Displays the crew worktime per month for each press

Year 2003 / Month April

Press #	Hours
63402100	104.40
63402200	68.78
64401400	205.20
64902900	35.30
66200400	141.82
66300400	171.50

Press #	Daily hours	Date	Crew member
63402100	9.05	2003/04/17	Eros Rammazzoti
63402100	9.07	2003/04/17	Miguel Bose
63402100	9.07	2003/04/17	Mercedes Sousa
63402100	9.08	2003/04/17	Youssou N Dour
63402100	8.53	2003/04/18	Eros Rammazzoti
63402100	8.55	2003/04/18	Miguel Bose
63402100	8.55	2003/04/18	Mercedes Sousa
63402100	8.57	2003/04/18	Youssou N Dour
63402100	8.47	2003/04/21	Eros Rammazzoti
63402100	8.48	2003/04/21	Miguel Bose
63402100	8.48	2003/04/21	Mercedes Sousa
63402100	8.50	2003/04/21	Youssou N Dour
63402100	**104.40**		

Crew worktime per month — User defined range: 2003 April 14, 08:31 - 2003 April 21, 17:54

Printed: 2004/01/16 Data: 2003/12/28 — C002.rpt — Page 1 of 1

3.3 Equipment mileage (C003)

Title (Document properties)	**Group**	**Graphic**
Equipment mileage	Costs	No

Sub-Title (inside report)

Displays the mileage of equipment

Comment (Document properties)

Displays the mileage of equipment

Description

Displays for every change of consumables or used materials like **ink, plates, blankets, impression cylinders, blades, ball bearings, patches** or whatever you specify as so called equipments at the presses (actually it's up to your administrator to use up to 50 different one) a statistic which shows the following figures for a defined time frame:

- how often this equipment type was changed
- how long did one last in sheets and time (sheet mileage, time mileage)
  - as minimum,
  - average and
  - maximum
- how much of this units you will need to produce one million of sheets
  - in minimum,
  - average and
  - maximum

This post estimation shows you exactly how many of this "equipments" you used in the given time frame (the mileage) and calculates a base for pre estimation on future productions.

It even warns you, if there were too less (less then 5) changes in the specified time period to get a statistical significance.

rpt name	Grouping (top to bottom)
C003_xx.rpt	Press / equipment

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Costs Report

Equipment milage

Displays the milage of equipment

Press: **66300400**

Bottom color (Purple #33121) was changed **6** times.

50.00 kg of Purple #33121 lasted for	in sheets	in seconds prod. time	
Average milage:	**76,597**	**326,700.00** or	**3 days and 18:45:00**
Median milage:	**76,360**	**325,250.00** or	**3 days and 18:20:50**
Maximum milage:	**78,600**	**332,000.00** or	**3 days and 20:13:20**
Minimum milage:	**75,000**	**324,000.00** or	**3 days and 18:00:00**

For one million sheets to print you will need

min	avg	max	
12.7	**13.1**	**13.3**	50.00 kg of Purple #33121

Top color (OVI-Green #4566) was changed **4** times. *4 changes are probably to less for significance.*

15.00 kg of OVI-Green #4566 lasted for	in sheets	in seconds prod. time	
Average milage:	**157,983**	**680,852.50** or	**7 days and 21:07:33**
Median milage:	**157,965**	**680,800.00** or	**7 days and 21:06:40**
Maximum milage:	**158,500**	**681,410.00** or	**7 days and 21:16:50**
Minimum milage:	**157,500**	**680,400.00** or	**7 days and 21:00:00**

For one million sheets to print you will need

min	avg	max	
6.3	**6.3**	**6.3**	15.00 kg of OVI-Green #4566

Equipment milage — User defined range: 2003 April 15, 08:48 - 2003 June 17, 08:12

Printed: 2004/01/16 Data: 2004/01/16 — C003_01.rpt — Page 1 of 1

4 Group: Maintenance

In this group you will find all reports which data relating to all kinds of press maintenance and consumptions.

4.1 Equipment forecasting (M001)

Title (Document properties)	**Group**	**Graphic**
Equipment forecasting	Maintenance	No

Sub-Title (inside report)
Displays the a forecast when consumables have to be changed

Comment (Document properties)
Displays the a forecast when consumables have to be changed

Description

Displays for every change of consumables or used materials like **ink, plates, blankets, impression cylinders, blades, ball bearings, patches** or whatever you specify as so called equipments at the presses FlowSys console (actually it's up to your administrator to use up to 50 different one) a statistic which shows the following figures for a defined time frame:

- how often this equipment type was changed
- how long did one last in sheets and time
  - as minimum,
  - average and
  - maximum
- when to expect the next change
  - in minimum,
  - average and
  - maximum

It even warns you, if there were too less (less then 5) changes in the specified time period to get a statistical significance.

rpt name	Grouping (top to bottom)
M001_xx.rpt	Press / equipment

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.

*	*	*	*	*	*	*	*	*	*

Maintenance Report

Equipment forcasting

Displays a forcast when equipment has to be changed

Press: **66300400**

Bottom color (Purple #33121) was changed **6** times.

50.00 kg of Purple #33121 lasted	in sheets	in seconds prod. time	
Average milage:	**76,597**	**326,700** or	**3 days and 18:45:00**
Median milage:	**76,360**	**325,250** or	**3 days and 18:20:50**
Maximum milage:	**78,600**	**332,000** or	**3 days and 20:13:20**
Minimum milage:	**75,000**	**324,000** or	**3 days and 18:00:00**

	Total Impact Counter	Date / time
last exchange was at:	**555,555**	**2003/06/04 08:12:49**
Expact the next exchange to be -		
earliest at:	**630,555**	**2003/06/08 02:12:49**
most expected at (avg):	**632,152**	**2003/06/08 02:57:49**
latest at:	**634,155**	**2003/06/08 04:26:09**

Top color (OVI-Green #4566) was changed **4** times. *4 changes are probably to less for significance.*

15.00 kg of OVI-Green #4566 lasted	in sheets	in seconds prod. time	
Average milage:	**157,983**	**680,853** or	**7 days and 21:07:33**
Median milage:	**157,965**	**680,800** or	**7 days and 21:06:40**
Maximum milage:	**158,500**	**681,410** or	**7 days and 21:16:50**
Minimum milage:	**157,500**	**680,400** or	**7 days and 21:00:00**

	Total Impact Counter	Date / time
last exchange was at:	**555,555**	**2003/06/17 08:12:50**
Expact the next exchange to be -		
earliest at:	**713,055**	**2003/06/25 05:12:50**
most expected at (avg):	**713,538**	**2003/06/25 05:20:22**
latest at:	**714,055**	**2003/06/25 05:29:40**

Equipment forcasting — User defined range: 2003 April 15, 08:48 - 2003 June 17, 08:12

Printed: 2004/01/16 Data: 2004/01/16 — M001_01.rpt — Page 1 of 1

5 Group: Security

In this group you will find all reports, which display data relating to security aspects in the production.

5.1 Crew changes at presses (S001)

Title (Document properties)	**Group**	**Graphic**
Crew changes at presses	Security	No

Sub-Title (inside report)
Displays the crew changes at the presses

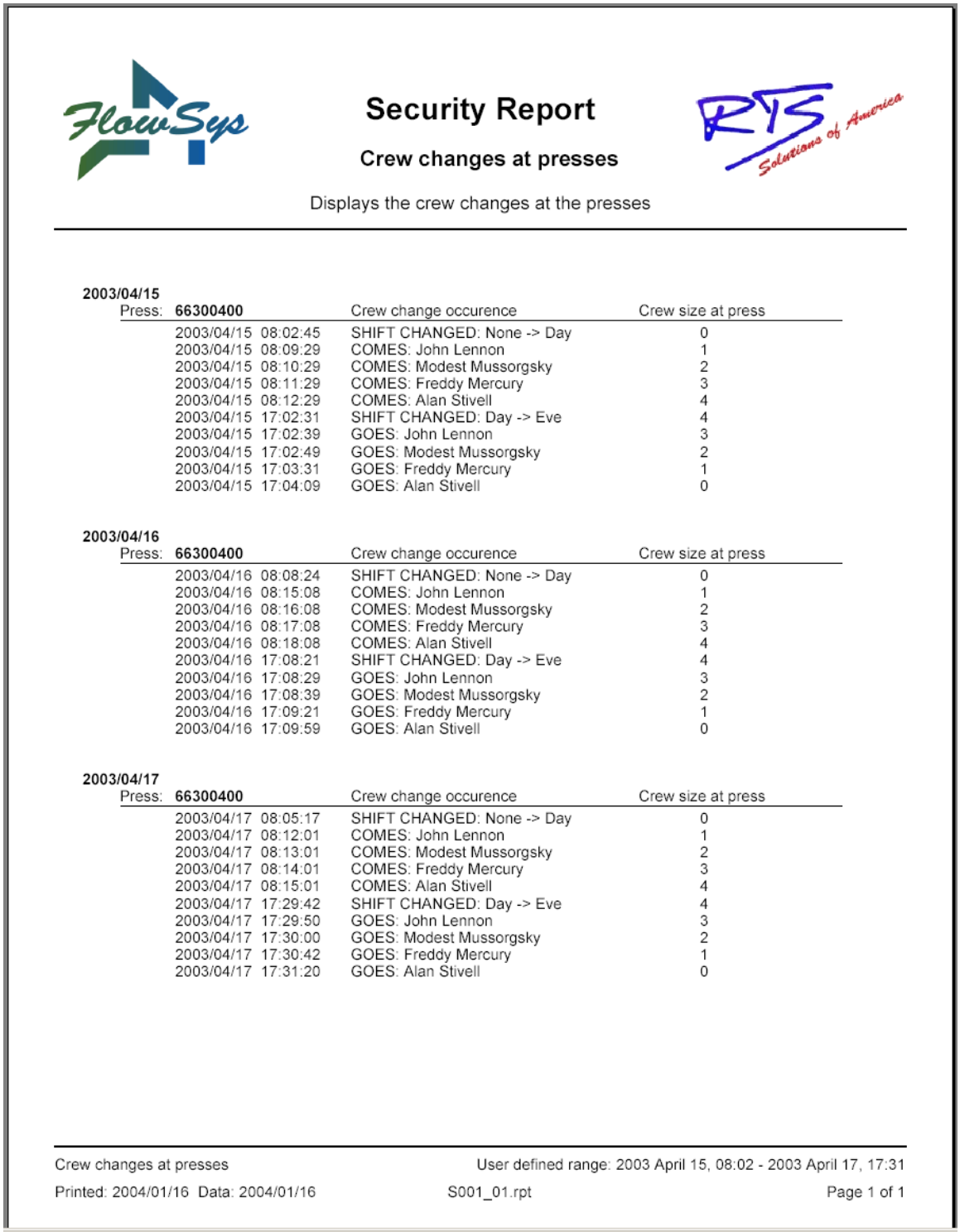
Comment (Document properties)
Displays the crew changes at the presses

Description
Shows all changes in the crew (login / logout) for any press. Displays also an indicator of the crew size on the press. Shows the shift change events too to give you a better overview.

rpt name	Grouping (top to bottom)
S001_xx.rpt	Date / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Security Report

Crew changes at presses

Displays the crew changes at the presses

2003/04/15

Press:	66300400	Crew change occurence	Crew size at press
	2003/04/15 08:02:45	SHIFT CHANGED: None -> Day	0
	2003/04/15 08:09:29	COMES: John Lennon	1
	2003/04/15 08:10:29	COMES: Modest Mussorgsky	2
	2003/04/15 08:11:29	COMES: Freddy Mercury	3
	2003/04/15 08:12:29	COMES: Alan Stivell	4
	2003/04/15 17:02:31	SHIFT CHANGED: Day -> Eve	4
	2003/04/15 17:02:39	GOES: John Lennon	3
	2003/04/15 17:02:49	GOES: Modest Mussorgsky	2
	2003/04/15 17:03:31	GOES: Freddy Mercury	1
	2003/04/15 17:04:09	GOES: Alan Stivell	0

2003/04/16

Press:	66300400	Crew change occurence	Crew size at press
	2003/04/16 08:08:24	SHIFT CHANGED: None -> Day	0
	2003/04/16 08:15:08	COMES: John Lennon	1
	2003/04/16 08:16:08	COMES: Modest Mussorgsky	2
	2003/04/16 08:17:08	COMES: Freddy Mercury	3
	2003/04/16 08:18:08	COMES: Alan Stivell	4
	2003/04/16 17:08:21	SHIFT CHANGED: Day -> Eve	4
	2003/04/16 17:08:29	GOES: John Lennon	3
	2003/04/16 17:08:39	GOES: Modest Mussorgsky	2
	2003/04/16 17:09:21	GOES: Freddy Mercury	1
	2003/04/16 17:09:59	GOES: Alan Stivell	0

2003/04/17

Press:	66300400	Crew change occurence	Crew size at press
	2003/04/17 08:05:17	SHIFT CHANGED: None -> Day	0
	2003/04/17 08:12:01	COMES: John Lennon	1
	2003/04/17 08:13:01	COMES: Modest Mussorgsky	2
	2003/04/17 08:14:01	COMES: Freddy Mercury	3
	2003/04/17 08:15:01	COMES: Alan Stivell	4
	2003/04/17 17:29:42	SHIFT CHANGED: Day -> Eve	4
	2003/04/17 17:29:50	GOES: John Lennon	3
	2003/04/17 17:30:00	GOES: Modest Mussorgsky	2
	2003/04/17 17:30:42	GOES: Freddy Mercury	1
	2003/04/17 17:31:20	GOES: Alan Stivell	0

Crew changes at presses — User defined range: 2003 April 15, 08:02 - 2003 April 17, 17:31

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5.2 Counter changes at presses (S002)

Title (Document properties)	**Group**	**Graphic**
Counter changes at presses	Security	No

Sub-Title (inside report)
Displays the counter changes at the presses

Comment (Document properties)
Displays the counter changes at the presses

Description
Shows all counter changes for any press. Every counter change (on the KBA console OR in FlowSys) is logged by FlowSys. In this report you see every counterchange, the time stamp when it happened, the load, which counter, the new as well as the old value of the counter and the reason entered by the user.

rpt name	Grouping (top to bottom)
S002_xx.rpt	Day / Press

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*

Security Report

Counter changes at presses

Displays the counter changes at the presses

2003/04/15

Press: **66300400** as production step: **NOTASCREEN**

Changed counters on KBA console

Date / Time	Load #	Counter	old	new	Reason for changing the counter
2003/04/15 08:48:25	03041401	Sidelay	12	13	Bad sheet by press
2003/04/15 08:48:26	03041401	Overshot	8	7	Bad sheet by press
2003/04/15 08:48:27	03041401	Missread	4	5	Overshot by press
2003/04/15 08:48:28	03041401	Wrong load	1	0	Overshot by press

Changed counters in FlowSys

Date / Time	Load #	Counter	old	new	Reason for changing the counter
2003/04/15 09:20:33	03041401	Bad	25	24	Overshot becomes a bad sheet
2003/04/15 09:20:34	03041401	Overshot	4	5	Overshot becomes a bad sheet
2003/04/15 09:20:35	03041401	P2	2,499	2,500	One P2 was bad
2003/04/15 09:20:36	03041401	P3	434	433	One P2 was bad
2003/04/15 09:20:37	03041401	Bad	21	20	One P2 was bad
2003/04/15 09:20:38	03041401	P1	4,999	5,000	Top sheet defined as unprinted
2003/04/15 09:20:39	03041401	P3	434	433	Top sheet defined as unprinted
2003/04/15 09:20:40	03041401	Unprinted	21	20	Top sheet defined as unprinted

2003/04/18

Press: **63402200** as production step: **INTAGLIO FACE**

Changed counters on KBA console

Date / Time	Load #	Counter	old	new	Reason for changing the counter
2003/04/18 08:59:31	03041401	Sidelay	12	13	Bad sheet by press
2003/04/18 08:59:32	03041401	Overshot	8	7	Bad sheet by press
2003/04/18 08:59:33	03041401	Missread	4	5	Overshot by press
2003/04/18 08:59:34	03041401	Wrong load	1	0	Overshot by press

Changed counters in FlowSys

Date / Time	Load #	Counter	old	new	Reason for changing the counter
2003/04/18 09:45:24	03041401	Bad	25	24	Overshot becomes a bad sheet
2003/04/18 09:45:25	03041401	Overshot	4	5	Overshot becomes a bad sheet
2003/04/18 09:45:26	03041401	P2	2,499	2,500	One P2 was bad
2003/04/18 09:45:27	03041401	P3	434	433	One P2 was bad
2003/04/18 09:45:28	03041401	Bad	21	20	One P2 was bad
2003/04/18 09:45:29	03041401	P1	4,999	5,000	Top sheet defined as unprinted
2003/04/18 09:45:30	03041401	P3	434	433	Top sheet defined as unprinted
2003/04/18 09:45:31	03041401	Unprinted	21	20	Top sheet defined as unprinted

Counter changes at presses — User defined range: 2003 April 15, 08:48 - 2003 April 18, 09:45

Printed: 2004/01/16 Data: 2004/01/06 — S002_01.rpt — Page 1 of 1

5.3 FlowSys start / stop / reset (S003)

Title (Document properties)	**Group**	**Graphic**
FlowSys start / stop / reset	Information	No

Sub-Title (inside report)
Displays FlowSys starts / stops / resets

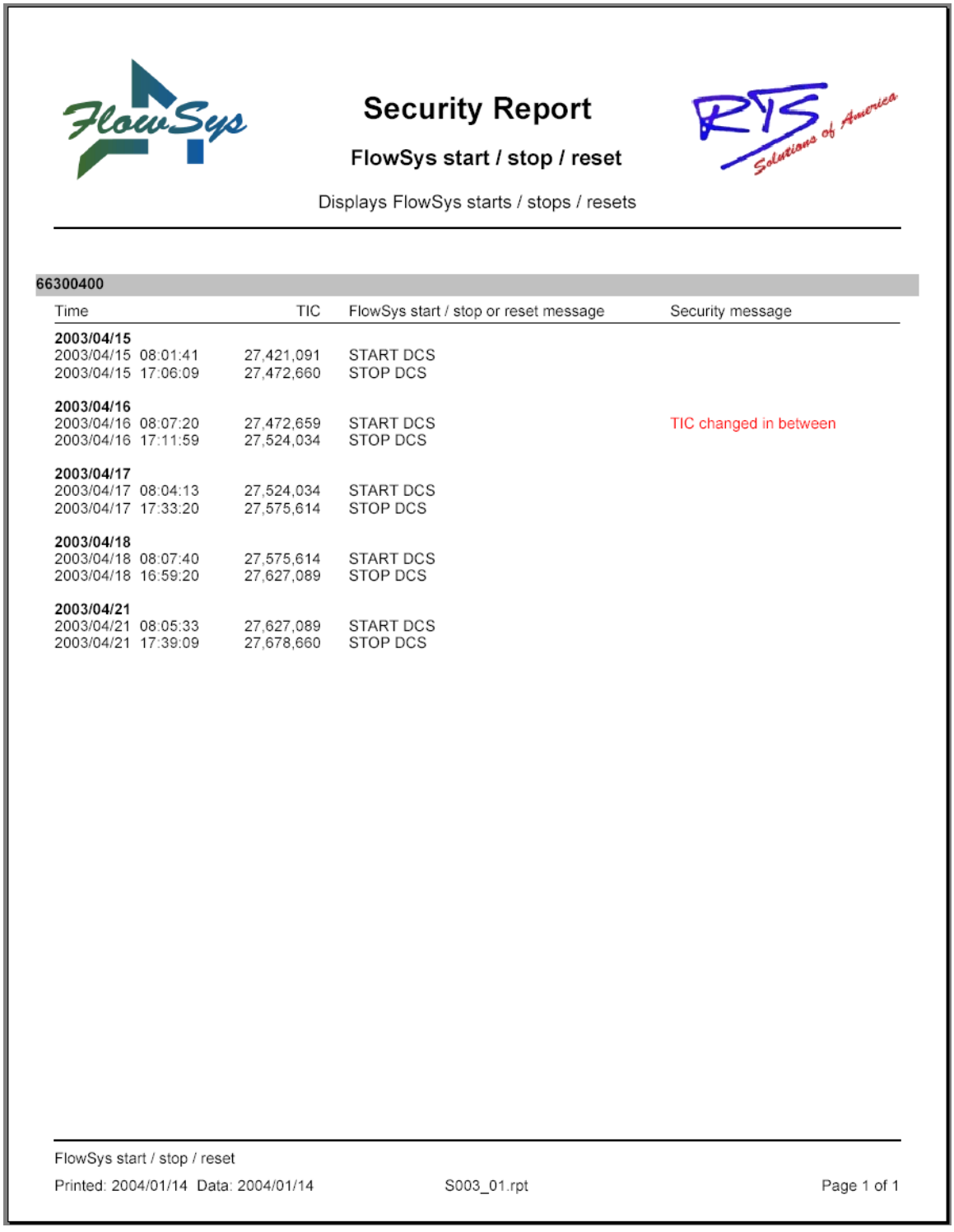
Comment (Document properties)
Displays FlowSys starts / stops / resets

Description
Displays every start, stop or reset of FlowSys. Checks the TIC (total impact counter) between FlowSys was turned off (FlowSys stop) and FlowSys turned on. A warning will be given if a manipulation is recognized.

rpt name	Grouping (top to bottom)
S003_xx.rpt	Press / Day

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:dm_arc_v	
Time limitation field	
dm_arc_v:arc_time	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Security Report

FlowSys start / stop / reset

Displays FlowSys starts / stops / resets

66300400

Time	TIC	FlowSys start / stop or reset message	Security message
2003/04/15			
2003/04/15 08:01:41	27,421,091	START DCS	
2003/04/15 17:06:09	27,472,660	STOP DCS	
2003/04/16			
2003/04/16 08:07:20	27,472,659	START DCS	TIC changed in between
2003/04/16 17:11:59	27,524,034	STOP DCS	
2003/04/17			
2003/04/17 08:04:13	27,524,034	START DCS	
2003/04/17 17:33:20	27,575,614	STOP DCS	
2003/04/18			
2003/04/18 08:07:40	27,575,614	START DCS	
2003/04/18 16:59:20	27,627,089	STOP DCS	
2003/04/21			
2003/04/21 08:05:33	27,627,089	START DCS	
2003/04/21 17:39:09	27,678,660	STOP DCS	

FlowSys start / stop / reset

Printed: 2004/01/14 Data: 2004/01/14 S003_01.rpt Page 1 of 1

5.4 Sheet accounting verification (S004)

Title (Document properties)	**Group**	**Graphic**
Sheet accounting verification	Security	No

Sub-Title (inside report)
Comparison of different sheet accounting systems

Comment (Document properties)
Comparison of different sheet accounting systems

Description

Shows you all loads produced on a press and compares different "sheet accounting systems" to verify all counters are right.

The following systems are compared:

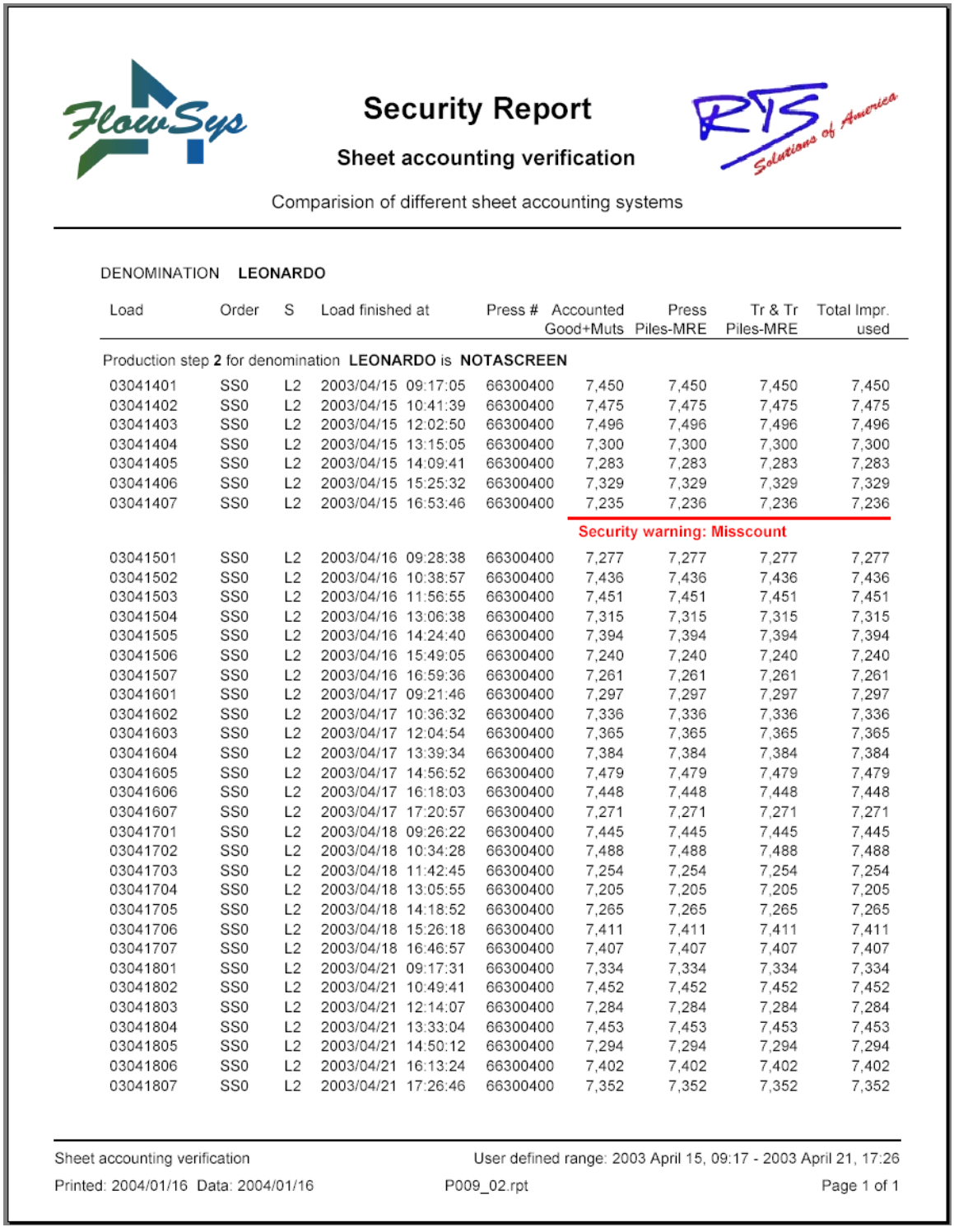
a) Defined good sheets + muts in the load report
b) Counters from press for all piles – MRE (Make Ready Sheets)
c) Counters from FlowSys Truck & Trace system for all piles - MRE
d) Total Impact counts (TIC) at load end – Total impact count at load end = Used TICs

If the comparison goes wrong a security warning will be printed.

rpt name	Grouping (top to bottom
S004_xx.rpt	Denomination / Production Step

Origin (db_user:1st table or view)	preceding tables or views used
demo_line:denom	relation, load, load_step, load_run {loadreport}
Time limitation field	
dwh_load_step.ls_stop	

shift	today	yester	week	lweek	month	lmonth	yearTD	lyear	f.e.
*	*	*	*	*	*	*	*	*	*



Security Report

Sheet accounting verification

Comparision of different sheet accounting systems

DENOMINATION **LEONARDO**

Load	Order	S	Load finished at	Press #	Accounted Good+Muts	Press Piles-MRE	Tr & Tr Piles-MRE	Total Impr. used
Production step **2** for denomination **LEONARDO** is **NOTASCREEN**								
03041401	SS0	L2	2003/04/15 09:17:05	66300400	7,450	7,450	7,450	7,450
03041402	SS0	L2	2003/04/15 10:41:39	66300400	7,475	7,475	7,475	7,475
03041403	SS0	L2	2003/04/15 12:02:50	66300400	7,496	7,496	7,496	7,496
03041404	SS0	L2	2003/04/15 13:15:05	66300400	7,300	7,300	7,300	7,300
03041405	SS0	L2	2003/04/15 14:09:41	66300400	7,283	7,283	7,283	7,283
03041406	SS0	L2	2003/04/15 15:25:32	66300400	7,329	7,329	7,329	7,329
03041407	SS0	L2	2003/04/15 16:53:46	66300400	7,235	7,236	7,236	7,236
					Security warning: Misscount			
03041501	SS0	L2	2003/04/16 09:28:38	66300400	7,277	7,277	7,277	7,277
03041502	SS0	L2	2003/04/16 10:38:57	66300400	7,436	7,436	7,436	7,436
03041503	SS0	L2	2003/04/16 11:56:55	66300400	7,451	7,451	7,451	7,451
03041504	SS0	L2	2003/04/16 13:06:38	66300400	7,315	7,315	7,315	7,315
03041505	SS0	L2	2003/04/16 14:24:40	66300400	7,394	7,394	7,394	7,394
03041506	SS0	L2	2003/04/16 15:49:05	66300400	7,240	7,240	7,240	7,240
03041507	SS0	L2	2003/04/16 16:59:36	66300400	7,261	7,261	7,261	7,261
03041601	SS0	L2	2003/04/17 09:21:46	66300400	7,297	7,297	7,297	7,297
03041602	SS0	L2	2003/04/17 10:36:32	66300400	7,336	7,336	7,336	7,336
03041603	SS0	L2	2003/04/17 12:04:54	66300400	7,365	7,365	7,365	7,365
03041604	SS0	L2	2003/04/17 13:39:34	66300400	7,384	7,384	7,384	7,384
03041605	SS0	L2	2003/04/17 14:56:52	66300400	7,479	7,479	7,479	7,479
03041606	SS0	L2	2003/04/17 16:18:03	66300400	7,448	7,448	7,448	7,448
03041607	SS0	L2	2003/04/17 17:20:57	66300400	7,271	7,271	7,271	7,271
03041701	SS0	L2	2003/04/18 09:26:22	66300400	7,445	7,445	7,445	7,445
03041702	SS0	L2	2003/04/18 10:34:28	66300400	7,488	7,488	7,488	7,488
03041703	SS0	L2	2003/04/18 11:42:45	66300400	7,254	7,254	7,254	7,254
03041704	SS0	L2	2003/04/18 13:05:55	66300400	7,205	7,205	7,205	7,205
03041705	SS0	L2	2003/04/18 14:18:52	66300400	7,265	7,265	7,265	7,265
03041706	SS0	L2	2003/04/18 15:26:18	66300400	7,411	7,411	7,411	7,411
03041707	SS0	L2	2003/04/18 16:46:57	66300400	7,407	7,407	7,407	7,407
03041801	SS0	L2	2003/04/21 09:17:31	66300400	7,334	7,334	7,334	7,334
03041802	SS0	L2	2003/04/21 10:49:41	66300400	7,452	7,452	7,452	7,452
03041803	SS0	L2	2003/04/21 12:14:07	66300400	7,284	7,284	7,284	7,284
03041804	SS0	L2	2003/04/21 13:33:04	66300400	7,453	7,453	7,453	7,453
03041805	SS0	L2	2003/04/21 14:50:12	66300400	7,294	7,294	7,294	7,294
03041806	SS0	L2	2003/04/21 16:13:24	66300400	7,402	7,402	7,402	7,402
03041807	SS0	L2	2003/04/21 17:26:46	66300400	7,352	7,352	7,352	7,352

Sheet accounting verification — User defined range: 2003 April 15, 09:17 - 2003 April 21, 17:26

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