

User Manual

EN_7122

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Concrete Plant Automation System

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PROGRAM FEATURES

- Computer supported electronic control system gives an opportunity for preparation of concrete in such a way that full automatic or manually if it is needed.
- System can be controlled in 4 different ways: Full automatic control with PC, full automatic control with operator panel, manual control from PC (using mouse), manual control from the control panel (using buttons)
- Manually weighing which is made on PC or panel, is saved with date, time and user information. When the automatically production is cancelled on any stage, so far the scaling amounts are added to the manual amounts. When the manual recipes are printed, the amounts of recipe are recorded by deducted from manual weighings.
- Computer program which can be installed with setup CD easily has multilingual support and user-friendly interface that everyone can use. Illustrated user manual and quick beginning guide makes learning process short and easy.
- Basic errors which occur probably in system can be monitored to PC instantly, they are saved by the time of occurrence and they can be deleted after the problem is resolved.
- Confirms and alerts are notified by voice, to users.
- There is a manual/automatic switch which allows activating mixer discharging door, even the plant operates in automatic mode. To prevent overflow and splash, mixer discharging door is opened step by step.
- Considering the moisture, water and aggregate ratio adjusted automatically (If there is a moisture probe). Also there is no probe; moisture can be entered to the program manually.
- Program allows for reporting produced and consumed material, listing records and getting waybills.
- There is no limit to record recipe, customer, site, truckmixer and driver.
- In case of deficient material flow, vibration performed to aggregates, air shocked performed to cements.
- In one period aggregate weighing, opening and closing time of valves are shorter. System makes these movements faster. That allows for sensitive measuring.
- Measuring, mixing and discharge parameters can be entered one by one for every recipe. That allows producing concrete which has specific parameters.
- In power failure situation, production is paused automatically. When the power is on, system gives opportunity to resume the production.
- Authorizations relating to reading, record, deletion, changing operations can be defined one by one for different users. All of these events are recorded by the program.
- After discharging, system washes the additive bunker by spraying water (optional).
- With remote support, operations like troubleshooting, installing program, including waybill-report updates, can be done with using internet.
- There are 8 aggregates, 6 cements, 3 waters and 6 additives on the system, as well as the system features multi-material support such as ash, paint and ice.
- The system uses Microsoft SQL database. Microsoft SQL, secure data storage, backup, easy access with the advantages of integration and flexible reporting, preferred by much software. More plants can use a common database server.
- The records appear to be unused and unwanted in the list can be deactivated by using archiving function. So the complex process of making lists and the user chooses the wrong registration problems are eliminated. Records required to be taken from the archive can be activated again.
- Order lists and reports can easily be transferred to hard disk, external memory or anywhere on the network in several formats, including Excel.
- After starting of production, amounts of production can be changed. It is possible to command "production end" during the active cycle.
- Before starting of production or during the production, amounts of materials on order records can be changed. These changes can be made within the limits set by the authorized person.
- When the production or return the product needs to be shipped to different places, the necessary correction on the waybill, split or merge operations can be performed.
- At the end of the production or the beginning of production, different forms of recipes can be printed by two different printers. In addition, the waybill number can be changed on the waybill confirmation screen that is displayed as an option.

- With easy waybill design feature, waybill is placed in the background of the design screen with scanner so it can be edited with the mouse according to the background. Similarly, it is possible to design the report by choosing area and removing area with mouse.
- Available as standard shipping, sales, inventory, wasted material and manual weighing as well as reports "produced / sold / damaged / repeated" sale information is created that contains the end of day summary. This summary with optional modules can be sent to authority of company as SMS and E-mail.
- Required pictures can be used as a background on the production screen. Again, company name or logo can be replaced on the production screen by the users.
- With logout feature, locking program and user switching operations can be performed without exiting program.
- The screens used often can be accessed by clicking the relevant icons in the production screen. In addition, moisture, time and weight parameters of raw materials can be easily reached with the mouse.
- If there is a defective sensor, the sensor can be disabled for not stopping production, sensor can be activated again removal of the problem.
- After the weighing, tolerance control is made for each material. The users can resume production or provide to complete missing amount automatically. Also flow control is made for all materials. If insufficient flow is detected the user is warned, that weighing can be skipped by using "weighing skip" option. These are optional features.
- Cubic meters and weighing the values of each cycle can be displayed in the table, saved and sent to the printer if desired.
- Users can message each other between programs. These messages are recorded in computer.

Note: Features may vary in accordance with versions.

MODULES

MONITORING MODULE

Reporting, authorization, parameters changes can be made from any computer which is connected to local network, without affecting the operations in production computer. Production screen can be watched online.

SMS AND E-MAIL MODULE

One of the advantages of the new version is information feature with SMS (short message). When the production is completed and truckmixer departs from the worksite, an information message is sent to worksite authority. When starting of ordering, starting of production or completed of order, this function can be used when and to whom it is desired.

The information sent via SMS, can be sent via E-mail. Important warnings and faults can be sent to the authorized personnel via SMS and E-mail too. When changes are made to recipes or production is deleted, the person concerned is informed immediately.

WEB MONITORING MODULE

When entering www.betonum.com address from PC, mobile phone, iPad or android tablets, production and orders can be displayed in report format. Vendors and customer can reach that "how much delivered, status of order" information without by phone or asking. They can learn them from internet instantly.

ACCOUNTING SOFTWARE INTEGRATION

Current, waybill, raw materials, recipe, order and current risk control information can be integrated with much ERP/ accounting software. Moreover, all these properties can be obtained must be taken not only of what is needed.

QUALITY CONTOL MODULE

Laboratory sample data for productions; concrete temperature, consistency, air temperature, the resistance value can be entered by days. The reports of these data can be taken.

VEHICLE MANAGEMENT

Truckmixers round-trip can be followed. If vehicle could not return in specified period, program gives a warning message. Arrival time to the site, starting and ending times of the delivery can be entered to the computer. If return time of vehicle is not entered, related truckmixer cannot be selected for production.

TRUCK SCALE MODULE

When produced concrete is weighed, it checks the accuracy of plant scales as well as automatic stock entry function, if there is a difference over determined tolerance, it warns. It calculates returned concrete amount on decimal basis and saves it in truck information for the use of production program.

GENERAL INFORMATION AND WARNINGS

- While program running, computer shouldn't be turned off by pressing on ON/OFF button. It is required to close program first and then to proceed to Windows environment and to turn off the computer with Turn Off feature. In power failure situation, computer system should be fed by UPS in order to prevent computer from being turned off automatically.
- In case of power failure during production, production is paused automatically. In this case, if it is necessary to wait until the removal of power failure, program should be exited and computer and UPS should be turned off. When power failure is removed, Continue button should be activated on production screen. In this case production will be resumed without any information loss.
- System has been designed to run with all kinds of mechanical infrastructures. Changing parameters and plant information in settings menu, configuration of related plant is memorized. As these values are directly related to PLC flow and control, when they are changed or entered wrongly, mistakes will occur in production start and flow.
- As waybill related to that production is printed at the end of every production, settings of printer should be controlled before starting production.
- When productions, resulted problematically are completed, waybill is printed and recorded with Manual Record Addition feature. Number of waybills which is not increased in the course of uncompleted production is increased and recorded. As a result of this, it is ensured that delivery records should be kept healthily.
- System reset means restoration of system. Resetting is performed automatically at the end of production.
- If the weighings are overloaded (overloading occurs when exceeding "Weighing Limit Value" entered on parameters screen) "fault occurred" warning is given and when production continues, weighing units related to that weighing are stopped. Units connected to other weighings complete the weighing transactions and wait the removal of failure only for that period.
- In the event that weighings are overloaded, system is set to manual mode and scale concerned is unloaded until a reasonable weight value and then system is set to automatic mode and resumed. If there is a trouble so great that it is not possible to continue production, system is reset and that production is cancelled.
- Working conditions for automation system; 0-50C ambient temperature, 5%-95% environment moisture.
- Load Cells located on scale platform and indicators to which they are connected in control cabinet are extremely sensitive to PLC and computer system leakage current. Thus whether earthling system is healthy or not should be checked often.
- If welding process is made in any part of concrete plant, powers of all devices should be cut (plug-in devices should be unplugged), connection cables coming from load cells to indicators should be removed. The securest method is to cut the electricity input of master switch and control cabin. Ground cable should be fixed to a place next to the point to be welded.
- In case of power failure UPS serves as accumulator and filters electrical fluctuations which occurs probably, feeds outputs for a
 while and regulates feeding voltages of computer group and PLC devices which are sensitive to electrical shocks (it should be
 noted that UPS to be used for these applications is Line-Interactive or Online preferably). Thus UPS' output power in circuit should
 be 1kVA in order that the devices in question work healthily.
- When system energized, before starting of production, it is necessary to wait for minimum 10 minutes in order for electronic elements in indicators to be heated and enter in regime.
- It should be noted that all devices connected to computer (printer, monitor, PLC, weighing indicators) should be on same ground line.

INSTALLATION

Recommended features for the computer to which installation is made are as follows:

Intel Core 2 processor, Intel chipset, 2 GB memory, 160 GB Hard Disk, 250 MB display card, optical driver, sound and ethernet ports, Windows XP Professional or Windows 7 Home Premium and upper versions, preferably internet connection.

Installation of Microsoft SQL Server 2005 Express Edition

1. If SQL Server is already installed in the computer to which installation will be made, it should be backed up and removed from computer.

2. If Anti-Virus program is available, it should be deactivated during installation.

3. SQLEXPR32.EXE in the folder of Microsoft SQL Server 2005 Express Edition SP2 in CD is run.

4. When any error is encountered, SQLEXPR.EXE should be run in same folder and following steps should be taken respectively:

5. First of all confirmation of license agreement is required. "I accept the licensing terms and conditions" is checked on "End User License Agreement" screen and Next button is clicked on and installation is continued. In following step all necessary components will be loaded before the installation of "SQL Server 2005 Express Edition". Install button is clicked on. And then Next button is clicked on and installation is continued.

🖾 Microsoft SQL Server 2005 Setup	Microsoft SQL Server 2005 Setup	🖾 Microsoft SQL Server 2005 Setup
End User License Agreement	Installing Prerequisites Installs software components required prior to installing SQL, Server.	Installing Prerequisites Installs software components required prior to installing SQL Server.
<pre>MICROSOFT SOFTWARE LICENSE TERMS MICROSOFT SOL SERVER 2005 EXERNESS EDITION SERVICE PACK 1 These license terms are an agreement between Microsoft Corporation (or based on where you live, one of its affiliates) and you. Please read them. They apply to the software named acceived it inclues the weils on Whichyot received it inclues the weils on Whichyot Microsoft • updates. • supplements. • Internet-based services, and • support services</pre>	SQL Server Component Update will install the following components required for SQL Server Setup: Microsoft SQL Native Clent Microsoft SQL Server 2005 Setup Support Files Click Install to continue.	SQL Server Component Update will install the following components required for SQL Server Setup:
Print Next > Cancel	Install Cancel	Next> Cancel

6. In following step, configuration control is made. If there is no deficiency in configuration, Next button is clicked on and next step is followed.

🕞 Microsoft SQL	Server 20	105 Setup 🛛 🔀	旧 Mi	crosoft SQL Server 2005 Setup		
		Welcome to the Microsoft SQL Server Installation Wizard		stem Configuration Check wait while the system is checked for poter problems.	ntial installation	
				Success	13 Total 13 Success	0 Error 0 Warning
		Setup will help you install, modify or remove Microsoft SQL Server. To continue, click Next.	Del	ails:		
		SUL Server. To continue, click Next.		Action	Status	Message 🔥
			0	Minimum Hardware Requirement	Success	
			0	Pending Reboot Requirement	Success	
			0	Default Installation Path Permission Re	Success	
			0	Internet Explorer Requirement	Success	
			0	COM Plus Catalog Requirement	Success	
			0	ASP.Net Version Registration Require	Success	
			0	Minimum MDAC Version Requirement	Success	
			0	Edition Change Check	Success	
						~
				Filter 🔻	Stop	Report 🔻
		< Back Next > Cancel		Help		Next >

7. Name and firm information is entered on "Registration Information" and then next button is clicked on. Before making any modification on Feature Selection, Next Button is clicked on and installation is continued.

Registration Information	侵 Microsoft SQL Server 2005 Express Editi Feature Selection	on Setup
The following information will personalize your installation.	Select the program features you want installed.	
The Name field must be filled in prior to proceeding. The Company field is optional.	Click an icon in the following list to change how a featu	re is installed.
Ngne: PC	Detabase Services X Cient Components X Software Development Kit	Feature description Installs the SQL Server Database Engine, tools for managing relational and XML data, and replication.
Company:		
		This feature requires 119 MB on you hard drive. It has 2 of 3 subfeatures selected. The subfeatures require 9 MB on your hard drive.
V Hide advanced configuration options	Installation path C:\Program Files\Microsoft SQL Server\	Browse Disk Cost
Help < Back Next > Cancel	Help <back< td=""><td>Next > Cancel</td></back<>	Next > Cancel

IMPORTANT!

8. Mixed Mode should be selected on Authentication Mode screen, otherwise "Login Failed" error may appear when application is run. Password to be used in database connection is entered in both password areas and Next button is clicked on and installation is continued without making any change in Options and Error and Usage Report Settings screens.

🖟 Microsoft SQL Server 2005 Express Edition Setup	j뉑 Microsoft SQL Server 2005 Express Edition Setup	i₿ Microsoft SQL Server 2005 Express Edition Setup
Authentication Mode The authentication mode specifies the security used when connecting to SQL Server.	Configuration Options Configure user and administrator accounts	Error and Usage Report Settings Help Microsoft improve some of the SQL Server 2005 components and services.
Select the authentication mode to use for this installation. O Windows Authentication Mode O Mixed Mode (Windows Authentication and SQL Server Authentication)	Enable User Instances This option enables users without administrator permissions to run a separate instance of the SQL Server Express Database Engine.	Automatically send Error reports for SQL Server 2005 to Nicrosoft or your corporate error reporting server. Error reports include information regarding the condition of SQL Server 2005 when an error occurred, your hardware configuration and other data. Error reports may unintentionally include personal information, which will not be used by Microsoft.
Specify the sa logon password below: Enter password: Confirm password: 	Add user to the SQL Server Administrator role This option adds the user who is running the SQL Server Express installation program to the SQL Server System Animistrator role. Verdenut, users on Microsoft Windows Vista operating system are not members of the SQL Server System Administrator role.	Automatically send Feature Usage data for SQL Server 2005 to Microsoft. Usage data Includes anonymous information about your hardware configuration and how you use our software and services. By installing Microsoft SQL Server 2005, SQL Server and its components will be configured to automatically send fatal service error reports to Microsoft or a Corporate Error Reporting Server. Microsoft usee error reports to improve SQL Server functionality, and treats all information as confidential.
Help < Back Next > Cancel	Help < Back Next > Cancel	Help < Back Next > Cancel

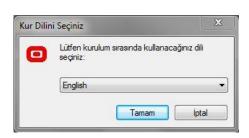
9. Install and Next buttons are clicked on respectively without making any change in Ready to Install and Setup Progress screens and installation is continued. Finish is clicked on Complete Microsoft SQL Server 2005 Setup screen and installation is completed.

@ Microsoft SQL Server 2005 Express Edition Setup	🐱 Microsoft SQL Server 2005 Se	tup 🛛 🕅	Microsoft SQL Server 2005 Setup
Ready to Install Setup is ready to begin installation.	Setup Progress The selected components are being o	onfigured	Completing Microsoft SQL Server 2005 Setup Setup has finished configuration of Microsoft SQL Server 2005
Step has enough information to start copying the program files. To proceed, dok Install. To charge any of your installation settings, dick Back. To exit setup, dok Cancel. The following components will be installed: • SQL Server Database Services (Database Services)	Product Miscelia SQL Status Support Files SQL Status Support Files SQL Solver Database Services	Status Status finished Satus finished Satus finished Satus finished Satus finished	Refer to the setup error logs for information decrebing any failure(s) that occurred during setup. Click Finish to exit the installation wizerd. Summary Log Tominimum the server surface area of SQL Server 2005, some features and services are disabled by default for new installations. To configure the surface area of SQL Server, use the Surface Area Configuration tool. Configuring and Managing SQL Server Express • For improved manageability and security. SQL Server 2005 provides more control over the SQL Server 2005 provides more contro
Help < Back Install Cancel	Help	<sback next="">> Concel</sback>	Help

Probeton SQL Setup

After the installation of Microsoft SQL Server 2005 Express Edition Bs_Setup.exe should be run and following instructions should be followed:

1. Language of installation is selected and OK is clicked on the screen appearing first. On the second screen appearing Next is clicked on.





IMPORTANT!

2. In the event that monitoring module is used, some versions of Windows operating system impose restrictions for sharing in C: folder. Thus it is recommended to install the program in the folder of **D:\"Probeton_Sql** in second disk. Next buttons are clicked on "Setup Directory" and "Start Menu Directory" selection screens respectively and installation is continued.

ielect Destination Location Where should Probeton_Sql be installed?		Select Start Menu Folder Where should Setup place the program's shore	touts?
Setup will install Probeton_Sql into the following fold To continue, click Next. If you would like to select a different		Setup will create the program's short To continue, click Next. If you would like to st	cuts in the following Start Menu folder.
D:\Probeton_Sql	Browse	Probeton_Sql	Browse

3. On the appearing screen "Create a desktop icon" is checked and Next is clicked on, on ready to install screen Install is clicked on and setup files are copied to computer. After installation is completed, "Run Probeton Program" is checked and End is clicked on and then transactions are completed and program is run. If "Run Program" is not checked, program can be run by the use of the shortcut created on desktop.

erformed?	Č.
Id like Setup to perform while i	nstalling Probeton_Sql.

Ready to Install Setup is now ready to begin installing Probeton_Sql on your computer.	P
Click Install to continue with the installation, or click Back if you want to review or change any settings.	
Destination location: D:\Probeton_Sql	*
Start Menu folder: Probeton_Sql	
Additional tasks: Additional icons: Create a desktop icon	
	Ŧ
4	
< Back Instal	Cancel

Setup - Probeton_Sql	
	Completing the Probeton_Sql Setup Nashing Probeton_Sql on your computer the sepisation may be launched by selecting the installed Long. Calk: Finish to est Setup. I Launch Probeton
	Finish

Database Definition

When program is run first, it can be associated with a newly created database.

Related flag is clicked on the first appearing screen, Turkish or English Language is selected and then "Ok" is clicked.

In second screen, "SQL Server", "User" and "Password" appear automatically if new installation is made. If existing SQL server is used, related information is typed. If Connection Successful appears when "Connection Test" is clicked on, Connect is clicked on.

⊻ Probeton [Ver No :2.3.0.0.] – □ ×	× Create a Database [Ver № :2.3.0.0] – □ ×	Database Update = 😐 🗙
C*	SQL Server JOHN-6560\SQLEXPRESS User Sa Password ********	Database Units Table Transaction Type Table Table of Materials Groups Materials Table Check Deleted Records
Dil Seçimi / Language Selection İngilizce	SQL Connection without Password (Windows Authentication Mod Connection Successful Test Connection	Oriz

After Database update, user and password definition screen appears.

Note: Password of admin is defined as "1" by technical team of program. Password can be changed on "User" screen in "System" menu of production program.

When clicking on "OK", PLC settings are displayed; transaction is cancelled with "Close".

User Login	E PLC Settings	Yrobeton [Ver № :2.3.0.0]
admin	Disable the PLC Connection PLC Settings To Advance 192.168.0.58	Upper Limits PLC Register Information
User admin V	Ip.Address 192.168.0.58 Port 592 Bolfor Size 32768	V FLC negister information
	Connection Trial Period Type 100	0%
🔯 Ok 🔯 Close	PLC Type 258 V	
	Load Default Values	

When clicking on "Load Default Values", displayed settings should be used. In special cases where many programs are operated in same computer, IP number of PLC with which every program will be in connection is entered in "IP Address" box.

In the event that communication is not established, functions like production and parameter change can't be used. In such a case "Disable the PLC communication" is checked, database transactions like recording and reporting can be performed.

Type number is used for plant configuration and adjusted by technical team of program. Settings used frequently are as follows:

101 (systems with 4 aggregates, single weighing belt) 102 (systems with 3+3 aggregates, double weighing belts), 105 (systems with 5 aggregates, single weighing belt).

PLC Type, used in PLC type is selected (340, 258, Twido)

If "Connection Successful" appears when clicked on "Connection Test", "OK" is clicked on. Transaction is cancelled by clicking on "Close".

Activation of Program

When program is run in a new computer for the first time, it should be activated within 7 days. "Institution Code" and "Machine Code" given with setup CD are entered respectively on "License" screen appeared. Machine Codes are "1" and "2" for production program and "monitoring program" respectively. If same firm has many production and monitoring programs, machine codes go on respectively.

Institution Code 1000	Send	1
Machine Code 35		1
		1

istitution Machine			— L	V Send				
			Please Cal	l Program Ve	ndor for Gett	ting Password	Î.	
1	2	3	4	5	6	7	8	
1000	000DA	7E4D6	E017A	1D93A	98307	3865E	80E5C	
			Incoming	Numbers				Save Licence
1	2	3	4	5	6	7	8	

After "Send" button is pressed, "Activate over the Internet" is clicked on. If it is not allowed to get password over internet, an alert window appears. In the event that alert window appears or there is no internet connection, it should be activated by phone. Codes received from program seller are entered in "Incoming Codes" and then "Save License" is clicked on.

Probeton	Probeton X	× ×
This program can not be found on the Customer Password can not be given	7 Days Temporary License Operation Completed	The program must be activated. Please contact the program vendor.
Tamam	Tamam	Remained Days:7

When "Activate Later" is selected, seven-day temporary license is given and every time you run the program, window showing remaining days for activation appears. Program may be run by delaying activation by clicking on "Close" button. "Activate Program" displays license screen.

When "Activate over the Internet" is selected, "Person who get the password" area is filled in, "I have read and agree to Agreement" is checked and "Activate over the Internet" is clicked on.

Institution Code	1000	License Agreement
Machine Code	351	Concrete Plant Automation System
Your ip Number	213.153.251.66	License Agreement 1. SUBJECT OF AGREEMENT
Person who get the	P user name	This agreement includes the license terms for the use of purchased software product in a computer with appropriate hardware and operating system. 2. SCOPE OF USING LICENSE
I have read and ag	ree to Agreement	 GFNERAL PROVISIONS Using license includes loading to computer, operating, using, monitoring, storing and backing up the software. L2. USER can't offer the software for the benefit of third parties and let them use it in any way like lending or leasing it whether paid or free. L3. All copyrights and ownership rights other than this non-exclusive
	activate Over the Internet	right remain on PRODUCER and lie outside the scope of this agreement. 2.1.4. Rights and obligations arising from this agreement can't be transferred to third parties. 2.2. USACE II NOIE COMPUTER USER (except the multi-user license packs) can't install the software simultaneously in the hard disks of two romer computers under any circumstances. USER can't load the software to same hard disk in many copies and use them for different transactions.
		3. DEFECTIVE PRODUCT AND USER'S RIGHTS In the event that CD/DVD-ROH containing defective software and written document is returned within 74 anys following the date of invoice at the latest, it is replaced with new one or returned against its price or price of defective material is deducted from sale price. USER uses this right by referring to choorn be used in the sale of the sale of the sale of the sale of the sale objection for defective product after prescribed time.

Introduction to Program

Probeton_Sql icon on Windows desktop or "Probeton.exe" in the directory where program is installed (C:\Probeton_Sql or D:\Probeton_Sql) is double clicked and program is run.

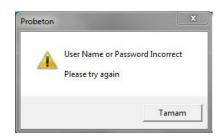
Note: If program is not activated, it appears on "activation screen". By clicking on "Close", program may be run temporarily. Activation transaction is detailed in "Installation" part. When Database and PLC table update screens appear, upon confirmation necessary updates are performed.

K	×
Activate Program	Close
The program must be activated.	
Please contact the program vend	or.
Remained Days:7	

User selection is made by arrow icon in the box of "User" on Login screen and related password is entered in "Password" box, "Ok" is clicked on. In the event that wrong information is entered, warning screen appears.

Attention! User name having all rights is "admin" and default password is "1". As detailed in "User" and "User Rights", password of admin should be changed.

	admin	
User		
Password	2	



- -

Close

It is possible to return to Windows by clicking on "Close" on Login screen.

Program has multi-plant operation feature. If user is authorized to work in many plants after user entry is made, he is asked to which plant he wants to connect.

Probeton [Ver N	lo :2.3.0.0]	×	Probeton [Ver No	:2.3.0.0]
Plant	INDUSTRIAL ZONE	•	Plant	INDUSTRIAL ZONE
L				INDUSTRIAL ZONE
				NEW CITY
	√ Ok	🔯 Close		🖌 Ok
0				

Recently used plant is displayed on screen. To select a different plant, selection button next to "Plant" box is used. "OK" is clicked on. It is possible to return to Windows by clicking on "Close".

Main Screen

Probeton [2.3. Entries Settings				ring	Repa	orts		Prok Progr	erations System All System A	:30/804 ÜRKİYE com.tr 446 51 52 446 12 46 662 77 37 elf hakları saklıdır. bir kusmını izinsiz anıması yasakıtır. Jested by copyright.	Beton Santail Opmasyon Stenni				
123	4 5	6	7	8	9	10) 1:	1 12	13 Production	14 OPERATOR	15 SUN CONCRET	16 E INDUSTRIAL ZONE	17 192.168.0.58	18 Messages	

Menu and information area are located in lower and upper parts of "Main screen" respectively. Meanings of the icons and expressions in information area are as follows.

1	Voice warning feature on / off	2	Communication with PLC yes (green) / no (red)
3	PLC processor mode: Run / Stop	4	System Ready (Smiley Face) / Not Ready (sulky face)
5	Production yes / no	6	Sequential production feature on / off
7	System in automatic mode	8	System in manual mode
9	Fault	10	Program test mode (simulation mode)
11	Electricty test mode (for electrical control)	12	Panel mode active (computer control deactivated)
13	States whether program is in production mode or monitoring mode	14	Active user name
15	Name of firm	16	Name of plant
17	PLC IP address	18	Feature of messaging between users

Required screen may be displayed by making a selection on the menu in upper part. Some shortcut keys used in program are as follows:

Alt + F4	Closes program	Ctrl + F4	Closes active screen
F1	Help	Ctrl + M	Displays manual transactions on production screen.
F5	Refresh screen information	Ctrl + O	Removes manual transactions on production screen

F10	Displays detailed/ technical records	Ctrl + Alt +M	Start / stop mixer
Ctrl + F9	Displays hidden buttons on parameter screens	Ctrl + S	Horn
F9	Displays production screen	F8	Displays coordinate settings window on production screen
		Ctrl + Alt +Shift + F10	Displays report design screen when preview page is processed by printer.

When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

PLC Settings

Here is the screen where PLC confirmation information may be defined. Under normal conditions, settings appearing when "Load Default Values" is clicked on should be used. In special cases where many programs are operated in same computer, IP number of PLC with which every program will be in connection is entered in "IP Address" box.

ffer Size 32768 nnection Trial Period 300	9 Address	192.168.0.58	1	
nnection Trial Period 300	Port	502		
nnection That Period	Suffer Size	32768		
	onnection Trial Period	300		
pe 100	Type	100		
C Type 258 👻	ч.С Туре	258	•	

In the event that communication is not established, functions like production and parameter change can't be used. In such a case "Disable the PLC communication" is checked, database transactions like recording and reporting can be performed.

Type number is used for plant configuration and adjusted by technical team of program. Settings used often are as follows:

101 (systems with 4 aggregates, single weighing belt) 102 (systems with 3+3 aggregates, double weighing belts), 105 (systems with 5 aggregates, single weighing belt).

PLC Type, used in PLC type is selected (340, 258, Twido).

Settings are saved by clicking on "Save" button and screen is exited by clicking on "Close".

When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

Materials

Material Informat	CION2				23	Material Informations	2	
Rew (🌌 Edit	Delete		Archive Transactions 💥	Transfer Data 🤪	Save 🔯 Close	J	
ferenc 🔻 Mater	rial		▼ Unit	▼ Group ▼	_	Material	1. GRAVEL	
1 0-3MM	M SAND		kg	Aggregate Group			kg _	
2 1. GRA	AVEL		kg	Aggregate Group		Unit		
3 2. GRA	AVEL		kg	Aggregate Group		Group	Aggregate Group 🚽	
4 SAND			kg	Aggregate Group		Min.Quantity		
5 Agr 5			kg	Aggregate Group		Producer		
6 Agr 6			kg	Aggregate Group				
7 Agr 7			kg	Aggregate Group		Production Site		
8 Agr 8			kg	Aggregate Group		Type of Materials	Coarse Material	O Fine Materia
9 Cem 1			kg	Cement Group			Course indentity	Onnernatena
10 Cem 2	2		kg	Cement Group		Minimum Value (Recipe)		
11 Cem 3			kg	Cement Group		Maximum Value (Recipe)		
12 Cem 4	ł		kg	Cement Group		Min.Quantity (Recipe Edit)		
13 Cim 5			kg	Cement Group				
14 Cim 6			kg	Cement Group		Max.Quantity (Recipe Edit)		
15 Cim 7			kg	Cement Group		Maximum Value (Moisture)		
16 Cim 8			kg	Cement Group				
17 water	1		kg	Water Group		Check For Stock		
18 water	2		kg	Water Group				
19 Su 3			kg	Water Group				
20 Additiv	ve 1		kg	Additive Group	•			

Raw materials used in production are defined in Material Information screen. When "New" or existing record is selected and "Edit" is clicked on, editing screen appears.

Material	Material name	Minimum Value (Recipe)	Min.value which can be defined for this material on recipe
Unit	Unit kg, lt etc.	Maximum Value (Recipe)	Max.value which can be defined for this material on recipe
Group	Aggregate, Cement, Water or Additive	Min.Value (Edit Recipe)	Min.value which user may correct without changing recipe
Min. Quantity	min. quantity for stock alert	Max.Value (Edit Recipe)	Max.value which user may correct without changing recipe
Producer	Producer Information	Maximum Value (Moisture)	Maximum moisture percentage which may be defined for aggregate group
Production Site	Production site information	Check for stock	Whether material stock is enough for related production is checked.
Type of Materials	Only for aggregate group		

Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Record used in any productions is not deleted but may be sent to archive. Screen is closed by clicking on red X in the top right-hand corner.

	Archive Transactions and Transfer Data
<u>S</u> how All S <u>e</u> nd to The Archive	Archive transactions are to send the record which is not requested to be displayed in the list and use to archive and to call them back when required. When requested record is selected and "Send to the
100	Archive" is clicked on, record is removed from the list. When "Show All" is clicked on, these records are displayed in red.
<u>C</u> urrent Records <u>R</u> estore From The Archive	When "Current Records" is clicked on, records sent to archive are not displayed. "Show All" should b activated first to restore from the archive, requested one should be selected from the displayed red
	records and "Restore from the Archive" should be clicked on.
Export to MS Excel	Any record list used in program may be saved in a different format. Convertible formats are Excel,
Export to XML Exp <u>o</u> rt to Text	Html, Xml and Txt. When any transfer is selected from "Data Transfer" menu, a window appears, in which target directory and name information may be defined.

When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

Plant Descriptions

Program has multi-plant operation feature. If user is authorized to work in many plants after user entry is made, he is asked to which plant he wants to connect.



Diant	INDUSTRI	AL ZONE		
Plant		AE 20112		
	INDUSTRIAL ZONE			
	NEW CITY			
		Ø Ok	🔯 Close	

When "New" or existing plants is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if any production is not made.

Plant Descriptions	
Save Save	
	Plant Descriptions
Plant Information	
Company SUN CONCRETE	📓 Save 🕽 🔯 Close
Plant INDUSTRIAL ZONE	Silo
200	
	Agr 1 Agr 2 Agr 3 Agr 4
Waybill No 1	Aggregate Grou Agr 6
Returned Concrete Time Limit 120 Dk	Aggregate Grou Agr 7
	Aggregate Grou Agr 8
	Aggregate Grou 0-3MM SAND
Waybill Description - 1	Aggregate Grou 1. GRAVEL Cem 1 Cem 2 Cem 3 Cim 4
Waybill Description - 2	Aggregate Grou 2. GRAVEL
Waybill Description - 3	Aggregate Grou SAND
Waybill Description - 4	Cernent Group Cem 1 Cernent Group Cem 2
	Cernent Group Cem 3 water 1 water 2
Waybill Description - 5	Center Group Cent 3
Waybill File (End of Production) Irsaliye_A4.frf	Cement Group Cm 5
Waybill File (Production Records) Irsaliye1.frf	Cement Group Om 6
Waybill File (Production Start) Irsaliye3.frf	Cernent Group Om 7
	Cement Group Om 8 Additive Additive Additive Additive
	Water Group Su 3
	Water Group water 1 Add Delete
	De De De De
	Additive Group Additive 1
	Additive Group Additive 2
	Additive Group Katha 4
	Additive Group Katks 5
	🛃 Back

Company	Company Name	Waybill Description 1-5	Constant descriptions which may be printed on waybill
Plant	Plant Name	Waybill File (End of Production)	Selection of waybill form to be printed at the end of production
Mixer Capacity	Max. concrete quantity which may be produced in one cycle	Waybill File (Production Records)	Selection of waybill to be printed from Production Records
Waybill No	Waybill number	Waybill File (Production Start)	Selection of Waybill to be printed in Production Start.
Rtrn.Concrete Time Limit	Maximum duration in which returned concrete can be used (in min)		

"Forward" is clicked on and silo definition screen is switched to. Material is selected in the list at left part and corresponding icon is right clicked and "Add" is clicked on. When error is made or related silo is requested to be deactivated, "Delete" is clicked on after right clicking on silo. Clicking on "Back", plant information screen is switched to.

Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

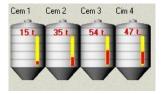
When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

Silo Capacities

Capacity values of material silos used in production can be defined in "kg".

🞺 Save	Transfer Data 😷
Material	Capacity -
0-3MM SAND	100.000,00
1. GRAVEL	100.000,00
2. GRAVEL	100.000,00
Cim 1	100.000,00
Cim 2	100.000,00
Katkı 1	10.000,00
SAND	100.000,00
Su 1	2.000,00
Su 1	2,000,00

Cement and additive stock quantities are shown as level bar on silo images on production screen.





"Transfer Data" transaction is detailed in "First Transaction-Materials".

Values are memorized by clicking on "Save" button. Screen is closed by clicking on red X in the top right-hand corner.

Stock Entry

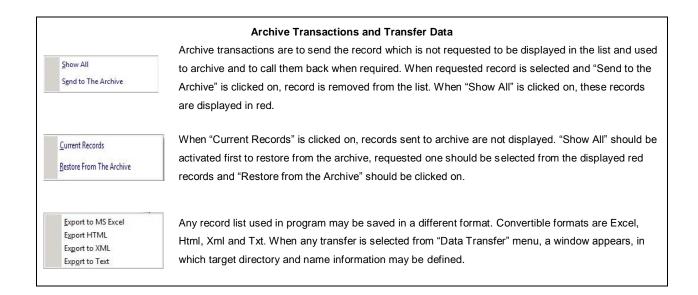
Entries for materials or correction transactions can be performed. Material list containing "material code", "material name" and "remaining" is available at the left part of screen.

Transaction details for selected material are displayed at the right part. These details include sequentially "transaction code", "transaction type" containing sale/purchase waybill, production return or record correction options, "date of transaction", "production no." if material is used in production, "production no.", "description" about stock entries/outflows, Input/output stock, "silo" numbers related to material.

Total quantities of selected material are displayed under input and output columns. Remaining amounts are displayed in "remaining" column next to material names.

	(New	🛛 🖉 Edit	💼 Dele	ete		Т	ransfer Data	ŧ
Referenc 💌 Material	▼ Remaining ▼	A Referenc -	Transaction	Transaction I -	Productic -	Descripti 💌	Input 💌	Output 💌	Silo
1 0-3MM SAND	45.120,34	247	Production	30.12.2012 19:0	0	Manuel Üret	0,00	3.043,33	
2 1. GRAVEL	63.729,57	239	Production	30.12.2012 18:1	0	Manuel Üreti	0,00	4.066,08	
3 2. GRAVEL	69.616,64	231	Production	30.12.2012 18:0	0	Manuel Üreti	0,00	3.043,33	
4 SAND	44.272,24	223	Production	30.12.2012 17:5	0	Manuel Üreti	0,00	1.022,76	
5 Agr 5		215	Production	30.12.2012 17:5	0	Manuel Üreti	0,00	4.066,08	
6 Agr 6		207	Production	30.12.2012 17:1	0	Manuel Üreti	0,00	3.043,33	
7 Agr 7		199	Production	30.12.2012 14:3	0	Manuel Üreti	0,00	4.066,08	
8 Agr 8		191	Production	30.12.2012 13:2	0	Manuel Üreti	0,00	4.066,08	
9 Cem 1	15.466,79	183	Production	30.12.2012 13:1	0	Manuel Üreti	0,00	2.020,57	
10 Cem 2	35.653,60	175	Production	30.12.2012 13:0	0	Manuel Üreti	0,00	3.068,27	
11 Cem 3		167	Production	30.12.2012 12:4	0	Manuel Üreti	0,00	3.043,33	
12 Cim 4		159	Production	30.12.2012 12:3	20	Üretim (Ürt 1	0,00	5.088,84	
13 Cim 5		151	Production	30.12.2012 12:1	0	Manuel Üreti	0,00	1.022,76	
14 Cim 6		143	Production	30.12.2012 12:0	0	Manuel Üreti	0,00	2.020,57	
15 Cim 7		135	Production	30.12.2012 12:0	0	Manuel Üreti	0,00	4.066,08	
16 Cim 8		127	Production	30.12.2012 11:1	16	Üretim (Ürt I	0,00	5.088,84	
17 water 1	9.804,33	119	Production	29.12.2012 21:2	0	Manuel Üreti	0,00	3.043,33	
18 Su 2		115	Purchase Invoice	29.12.2012		KUM	100.000,00		
19 Su 3									
20 Additive 1	9.641,01								
21 Katki 2		-					100.000,00	54.879,66	

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted. "Transfer Data" transaction is as follows:



cock Entry	🔉 Close	Stock Entry	🗊 Close
Description	Manuel Üretim	Description	Manuel Üretim
Transaction Type	rchase Invoice / Tally 👻	Transaction Type	egistration Correction 🚽
Transaction Date	30.12.2012 19:01:34 👻	Transaction Date	
5ilo	1 [0-3MM SAND] 👻	Silo	Purchase Invoice / Tally Production
nput	0 kg	Input	Return
Dutput	3.043 kg	Output	Registration Correction

Description	Description about transaction may be entered (waybill/invoice no etc.)	Silo	Silo number of the group including material is selected.
Transaction Type	Transaction type (purchase or correction) is selected.	Input	Stock Input
Transaction Date	Date of transaction is selected	Output	Stock Output

Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

Stock Correction

Remaining stock may be displayed and corrected via this screen if required. One thing to be done is to click on "Save" by setting "Stock Amount" at the rightmost part to requested value in requested material line. In this way "stock amount" located at leftmost part is set to new value.

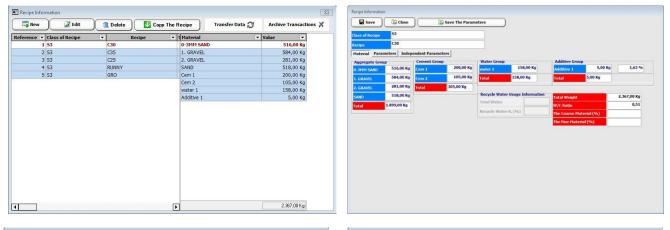
Group 🗛 🔻	Silo 🗛	Material	Stock Quantity	Stock Quantity
Aggregate Group	1	0-3MM SAND	45.120,34	45.120,34
Aggregate Group	2	1. GRAVEL	63.729,57	63.729,57
Aggregate Group	3	2. GRAVEL	69.616,64	69.616,64
Aggregate Group	4	SAND	44.272,24	44.272,24
Cement Group	1	Cem 1	15.466,79	15.466,79
Cement Group	2	Cem 2	35.653,60	35.653,60
Water Group	1	water 1	9.804,33	9.804,33
Additive Group	1	Additive 1	9.641,01	9.641,01

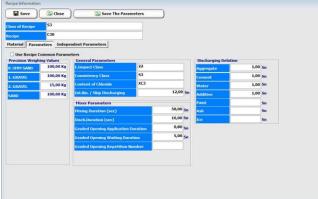
"Transfer Data" transaction is described in "Entries-Stock Entry" part. Screen is closed by clicking on red X in the top right-hand corner.

Recipe

It is the screen where concrete recipes may be entered and modified. At left part "code", "class" and "name of recipe" take place. When any recipe is selected, material quantities are displayed at the right part.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. When "Copy the Recipe" is clicked on, copy of selected recipe is created and placed under the name of "New Recipe". It is possible to select and correct it. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".





cope C30			
	Independent Parameters		
Use Recipe Common	Parameters		
Impact Class	22		
onsistency Class	53		
ontent of Chloride	XC3		

ipe Information		
Save 🔯 Close	Save The Parameters	
ss of Recipe 53		
cipe C30		
iterial Parameters Independent Par	eters	
1	6	
2	7	
3 CEM I 42.5 R	8	
4	9	
5	10	

Correction screen is made up of three parts; "Material", "Parameters" and "Independent Parameters" options are clicked on and related sections are displayed in the manner that recipe class and name information become constant in upper part.

In material part, requested values to be weighed for 1 m3 are entered on group basis. For information purpose, weight, recipe, total weight, percentage values of additives in accordance with cement amount, water/cement ratio and thick and thin material percentages in aggregates are displayed. Definitions for coarse and fine materials may be made on "First Transactions-Materials" screen.

Parameters part divides in four sub parts.

Precision Weighing Values: They are the parameters entered in order to minimize the error rate in weighing and to control material flow. When kg value to be received from bin in aggregate bins with double doors falls below the entered parameter value, one of the doors is closed and weighing is continued. Values herein should be entered for 1 m3.

"Environmental impact class", "consistency class" and "content of chloride" taking place in General Parameters are used in waybill. "Aggregate Intermediate bin / Skip Discharging Duration" corresponds to the duration where aggregate is discharged fully from intermediate bin or skip to mixer.

In the sub part of Discharging Delay, certain delay durations may be defined for each group, when it becomes necessary to discharge into mixer.

In Mixer Parameters, "mixing duration" may be defined since material is discharged to mixer and "discharging duration" where discharging door will be kept open may be defined. In order that discharging transaction be made in a controlled manner, discharging door is opened gradually. Door is opened during "Graded Opening Application Duration" and waited during "waiting duration". This operation is performed by considering "graded opening repetition number" and then door is opened fully. In the event that repetition number is entered as "0", graded opening transaction is made until door is opened fully. In order that door is opened at once, "waiting duration" should be entered as "0"

Attention! Parameters taking place in this sub part are sent to PLC together with material values when production starts and become valid during production.

When "Use Recipe Common Parameters" is selected, parameters herein become invalid and parameters entered in "Settings-Recipe Common Parameters" are used.

In Independent Parameters, fields in which special descriptions which are requested to appear on waybill and related to that recipe can be entered are available.

Information is saved with "Save", screen is exited by clicking on "Close" without saving. In order that parameter values are used in new recipes in same way, values are memorized by clicking on "Save Parameters" button. Screen is closed by clicking on red X in the top right-hand corner.

Print Recipe Detail <u>A</u>ll Prescription Detailed Information Recipe information selected by clicking on "Print Recipe Details" on the menu displayed by right clicking on any recipe record may be printed.

Reçete Adı	ŞERBET			Kıvam Sınıfı	S4	
Sınıfı	ŞERBET			Klor İçeriği	0,20	
C Etki Sınıfı	XO					
			к	ullanılan Malz	emeler	
Agrega G	irubu	Çime	ento Grubu		Grubu	Katkı Grubu
5/15		Cim 1	940	Su 1	660	Katki 1S
05		Cim 2				Katki 2H
05		Cim 3				Antifiriz
15/25						
Agr 4						
Agr 5						

Clicking on "All Recipe Details" on same menu, all recipe information may be printed.

Firma :Irmak B	eton									RE	ÇETE B	LGILER	i	
Tesis :Söke		5145	05	05	45.05	0. 1	0: 0	0: 0		16.11	14.11	A 115 1	A 115 1	T 1 4× 11
SAP 250	00	5/15	05 980	05 980	15/25	Cim 1	Cim 2 220	Cim 3	Su 1	Katkı	Katkı	Antifiriz	Antifiriz	
	S3 S3			980		A	1		190	1,54				2351,54
	S3 S3	0	940 965	940		G	300		190	2,10		4		2382,10
		050			000	0			190	1,75		0		2371,75
	S3	350	480	480	600		300		170	3,60				2383,60
	S3	350	500	500	610		270		170	3,00			_	2403,00
	S4	370	490	490	590	u .	290		155		3,62	15		2388,62
	S3	350	570	570	550	0	160		175	1,60		0	e	2376,60
	S4	360	530	530	590		225		180	2,25				2417,25
	S4	340	540	540	570	1	260		155		2,60			2407,60
	S4	810	550	550		a .	290		180	2,90				2382,90
C 20/25 BÜRÜT		740	600	600			260		180			0		2380,00
C 30/37 BÜRÜT		820	530	530			320		155		3,84			2358,84
C 16/20 BÜRÜT	S3	800	620	620	-	82 	160		190	1,60	1000 10000	8		2391,60
C 40/45	S4	370	440	440	610	(). ().	400		130		5,60			2395,60
C 45/50	S4	380	410	410	600	0	470		140		6,58	0		2416,58
C 50/60	S4	320	390	390	650		530		140		7,42			2427,42
C 35/45	S4	360	460	460	620		340		155		4,59	5.	() ()	2399,59
SERBET	SERBE						940		660					1600.00
C 35/45	S3	380	430	430	620		370		170	4.44				2404.44
C 40/50 BÜRÜT	S4	860	460	460			420		160		6.72			2366.72
C 35/45 BRÜT	S4	850	500	500		E.	380		160		5.13	8	0 e	2395.13
C 25/30	SAHA	380	500	500	570		250		180	1,50				2381.50
C 30/37	SAHA	400	455	455	620		280		170	2,20				2382.20
	Mikserli	390	560	560	550		160		170	1,60				2391.60
	Mikserli	380	500	500	610	19	210		175	2,10		2	3	2377,10
	Mikserli	380	500	500	600		250		155	-, 10	2.50		-	2387.50
	Mikserli	380	480	480	610		280		155		2,80			2387,80
5.15.5.1.5.C	Mikserli	400	450	450	620	2	320		155		4,16			2399,16
	Mikserli	810	550	550	020	2	270		180	2,60	4,10	8		2362.60
	S4	340	540	540	570		260		160	1.04	2.08	4		2413.12

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

After requested design modifications, screen is closed by clicking on red X in the top right-hand corner. On exit, confirmation screen is displayed. Modifications are saved by clicking on "Yes", screen is exited by clicking on "No" and design screen is switched back to by clicking on "Cancel".

Customer

It is the screen where customer information may be entered or modifications may be made.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

🔯 Close

15TANBUL (216) 000 00

KARTAL

CARTAL MUNICIPALITY IOHN SMITH

	🖉 Edit	Delete	Archive Transaction	15 X	Transfer Data 🖓	
				PERSON]
	tomer Cod 🔻 Cus		•	City	-	
2 1		RTAL MUNICIPALITY		İSTANBUL		
3		ER MÜHENDİSLİK		İSTANBUL		
4		I İNŞAAT		İSTANBUL		
5		MAZ İNŞAAT İNSAAT		İSTANBUL İSTANBUL		
6	AT	INŞAAT		15 TANBUL		

Address and communication information takes places in correction screen. In the event that SMS and E-mail modules are used, "Mobile Phone", "E-mail" and "Authorized" information should be entered and "Send SMS" and "send E-mail" options should be checked. If "Lock" option is checked, production is not made for this customer.

Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

Worksite

It is the screen on which worksite information may be entered or changed.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

		(🔽 New	🖉 Edit 🕅 🛍 Dele	ete Archive Transactions 🕽	Transfer Data 🖓	Save	Close	
erenc 🔻	Customer	▼ City	E 🔁				Worksite	SCHOOL CONST	RUCTION
	KARTAL MUNICIPALITY	İSTANBUL		Worksite		District / Co	Address 1		
	AKER MÜHENDİSLİK	İSTANBUL		2 THE COASTAL PATH	İSTANBUL	KARTAL	Autress 1		
	INCI İNŞAAT	İSTANBUL		3 SCHOOL CONSTRUCTION	İSTANBUL	KARTAL			
	YILMAZ İNŞAAT	İSTANBUL		Contraction of the second second second second second second second second second second second second second s	and the second s		Address 2		
6	AY İNŞAAT	İSTANBUL							
							District		
							County		
							City		
							Phone	()	
							Fax	()	
							Mobile Phone	()	Send SMS
							E-mail		Send E-m
							Authorized		
							Distance		Km

Address and communication information take places in correction screen. In the event that SMS and E-mail modules are used, "Mobile Phone", "E-mail" and "Authorized" information should be entered and "Send SMS" and "send E-mail" options should be checked. If "Vehicle Management" module is used, "distance" information should be entered in order to calculate the distance made by trucks.

Information is saved by clicking on "Save", screen is exited by clicking on "Close". Screen is closed by clicking on red X in the top righthand corner.

Service

It is the screen on which additional services given in the stage of the delivery of concrete are entered or modified. To display them on waybill and production records, "concrete pump" information, "delivery by truckmixer" or "under plant" options may be defined.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

📮 New		📝 Edit 🗍 💼 Delete	Transfer Data 🐔
eference	-	Service	•
	1	TRANSMIXER	
	2	CONCRETE PUMP	
	3	CONCRETE PUMP 2	
	4	PLANT UNDER	
Servia		Close Concrete PUMP	

Information is saved by clicking on "Save", screen is exited by clicking on "Close". Screen is closed by clicking on red X in the top righthand corner.

Order

It is the screen on which order information may be entered or modified. Order list is displayed at the left part and information related to selected order is displayed at right part. Information at right part includes automatic and manual production amounts and number of truck trips as well as produced amount of concrete.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

Corder Information		X	Order Information		
Tag New Z Edit 💼 Delete	Archive Transactions 💥	Transfer Data 📿	Save	🔯 Close	
Referenc V Date V Customer V Worksite V				17.10.2012	
1 17.10.2012 KARTAL MUNICIPALITY SCHOOL CONSTRUCTION	Recipe C35	•	Date		
2 07.02.2013 AKER MÜHENDİSLİK FABRİKALAR YOLU	Desired 100,0	0 m3	Customer	KARTAL MUNICIPALITY	
	Given		Worksite	SCHOOL CONSTRUCTION	W
	Service 1 CONCRETE PL	JMP 2 👻	Recipe	C35	V
	Service 2 CONCRETE PL	JMP 👻	Production Amount	100,00 m3	
	Description		Service 1	CONCRETE PUMP 2	V
			Service 2	CONCRETE PUMP	
			Delivery Type		
			Delivery Time	:	
	Production Site INDUSTRIAL 2	ZONE	Description		
	Automatic Productio				
	Manual Production				
	The number of Trip				
	Service 2 Description Production Site Automatic Productio Manual Production	JMP	Production Amount Service 1 Service 2 Delivery Type Delivery Time	100,00 m3 CONCRETE PUMP 2 CONCRETE PUMP	

On correction screen, service, casting type, hour and descriptions may be entered as well as screen, date, client, worksite, recipe of order. Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving.

When any order record is right clicked on, a menu is displayed.

List of the productions, number of productions and total production amount from that order to the present are displayed with the option of "orders". Screen is exited by clicking on "Exit".

	Orders								Recipe corre	ctions						
	<u>R</u> ecipe c	orrection							Aggregate Gro		Close		Cement Grou			
			nedule by Serv						Aggregate on	Rcp.	Rev.	Tot.	Cement droup	Rcp.	Rev.	Tot.
	Archive	the old o	rder informati	ion					0-3MM SAND	520	0		CEM 1	135	0	135
									1. GRAVEL	580	0	580	CEM 2	120	0	120
Crders								00	2. GRAVEL	270	0	270	CEM 3	90	0	90
Close									SAND	530	0	530	CEM 4	110	0	110
<u></u>	_	• User •	Worksite	▼ Truck	▼ Driver	• Quantity •	- Comico 1	Service 2								
INDUSTRIAL ZONE	4 04.02.2013	admin !	SCHOOL CONSTRUCTION	34 SUN 1259	GEORGE CARTE	R 10,0	IO CONCRETE PUP	IP	Water Group				Additive Grou	p		
INDUSTRIAL ZONE	3 04.02.2013	admin !	SCHOOL CONSTRUCTION	34 SUN 1259	GEORGE CARTE	ER 5,0	0 CONCRETE PU	MP		Rcp.	Rev.	Tot.		Rcp.	Rev.	Tot.
									Water 1	120			Additive 1	1,50	0,00	1,50
									Water 2	80	0	80	Additive 2	1,80	0,00	1,80
													Additive 3	2,00	0,00	2,00
					2	15,0	0		Report Dat	.e [17.	10.2012		•			

Temporary correction can be made on the recipe used in order without changing the recorded values with the option of "Recipe Corrections". "Increase and decrease values" which may be entered on correction screen may be in the range of "Maximum and Minimum Recipe Correction Values". Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving.

"Daily Concrete Delivery Schedule by Service" option enables to print delivery schedule grouped by, concrete pumps, truckmixer or under plant deliveries. Date of report is selected on the appearing screen and list is printed by clicking on "Print" button or screen is closed by clicking on "Screen" button without making any transaction.

				PO	MPA 1(38	LİK)					
Görev No	Müşteri	Şantiye	Vergi Dairesi	Vergi No	Beton Cinsi	Tahmini Miktar	Döküm Sekli	Slump Döküm Saati	Açıklama	Şanti <mark>y</mark> e Adresi	Müşteri Telefon N
1	ÇENGEL TİCARET	MEHMET EDİZ/DAVUTLAR	KUŞADASI	24200178 51	C 25/30 BÜRÜT	7 m³		S4 Saat:		DAVUTLAR GIRIŞI YAGHANE KARŞISI	(MEHMET Ç
2	ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMIRCAN/DAVUTLAR	SELÇUK	90004100 5	C 30/37 BÜRÜT	20 m³		S4		DAVUTLAR ÇIKIŞI AYTEMIZ PETROL KARŞISI	(ASLANHA
3	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTLAR	KUŞADASI	24200178 51	C 20/25	16 m³		S4		DAVUTLAR ÇAVUŞ MOBİLYA YANI DAVUTLAR	(MEHMET Ç
					oplam : DMPA 2(43	43 m³ lük)					
	Müsteri	Santive	Vergi	PC Vergi	OMPA 2(43 Beton	lük) Tahmini	Döküm	Slump Döküm	Acıklama	Santive Adresi	Müşteri
No	Müşteri	Şantiye	Vergi Dairesi	PC	DMPA 2(43 Beton Cinsi	lük) Tahmini Miktar	Döküm Sekli	Slump Döküm Saati	Açıklama	Şantiye Adresi KUŞADASI YAT LIMANI	Telefon N
No	Müşteri BORE İNŞ.TAAH.SAN.TİÇ.AŞ	Şantiye BORE İNŞAAT/KUŞADASI(2)		PC Vergi	OMPA 2(43 Beton	lük) Tahmini		<u>Šaati</u> S4 Saat:	Açıklama	KUŞADASI YAT LİMANI KARŞISI	Telefon N (549) 736 9
12 2012 3		BORE		PC Vergi	DMPA 2(43 Beton Cinsi C 35/45	lük) Tahmini Miktar		Saati S4	Açıklama	KUSADASI YAT LIMANI	Müşteri Telefon N (549) 736 9 (Süleyman 1 (MEHMET Ç
No 1	BORE İNŞ.TAAH.SAN.TİÇ.AŞ	BORE İNŞAAT/KUŞADASI(2) KAĞAN İNŞ/FAHRİ	Dairesi	PC Vergi No 24200178 51	DMPA 2(43 Beton Cinsi C 35/45 C 35/45	lük) Tahmini Miktar 120 m³		<u>Šaati</u> S4 Saat:	Açıklama	KUŞADASI YAT LİMANI KARŞISI SÖKE DEVLET HASTANESI	Telefon N (549) 736 9 (Süleyman
No 1	BORE İNŞ.TAAH.SAN.TİÇ.AŞ	BORE İNŞAAT/KUŞADASI(2) KAĞAN İNŞ/FAHRİ	Dairesi	PC Vergi No 24200178 51	DMPA 2(43 Beton Cinsi C 35/45 BRÜT	lük) Tahmini Miktar 120 m ³ 30 m ³ 150 m ³		<u>Šaati</u> S4 Saat:	Açıklama	KUŞADASI YAT LİMANI KARŞISI SÖKE DEVLET HASTANESI	Telefon N (549) 736 9 (Süleyman
No 1	BORE İNŞ.TAAH.SAN.TİÇ.AŞ	BORE İNŞAAT/KUŞADASI(2) KAĞAN İNŞ/FAHRİ	Dairesi	PC Vergi No 24200178 51	DMPA 2(43 Beton Cinsi C 35/45 C 35/45 BRÙT Oplam :	lük) Tahmini Miktar 120 m ³ 30 m ³ 150 m ³		<u>Šaati</u> S4 Saat:	Açıklama	KUŞADASI YAT LİMANI KARŞISI SÖKE DEVLET HASTANESI	Telefon N (549) 736 9 (Süleyman

Report Design

When "Ctrl + Alt + Shift + F10" keys are pressed on printer preview page, report design screen appears.

After requested design modifications, screen is closed by clicking on red X in the top right-hand corner. On exit, confirmation screen is displayed. Modifications made are saved by clicking on "Yes", screen is exited by clicking on "No" and design screen is switched back to by clicking on "Cancel".

Previous information may be sent to archive by clicking on "Archive Previous Order Information", when required, these records may be displayed by the use of "Archive Transactions".

Screen is closed by clicking on red X in the top right-hand corner.

Driver

It is the screen where driver information may be entered or modified.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

Driver Informati	on		83
New (📝 Edit 🗎 🗎 🕅 Delete	Archive Transactions 💥	Transfer Data 🤪
	Name and Surname	▼ Phone	
ADAM RICE		(212) 534 14 12	
ADEM AKKAYA		(544) 111 11 11	
EROL GÜNAYDIN		(544) 333 33 33	
GEORGE CARTER JACK WARNER		(212) 346 11 61 (212) 518 88 07	
JACK WARNER		(212) 518 88 07	

Phone, registration and address information of driver take place on correction screen.

Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

Truck

It is the screen where truck information (truckmixer) may be entered or modified.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Archive Transactions and Transfer Data" are detailed in "Entries-Stock Entry".

E	ſ	Truck Information
Archive Transactions 🗶 🛛 Transfer Data 😅		
Type Driver		Save
110 ADAM RICE		
110 JACK WARNER		in the second second second second second second second second second second second second second second second
110 GEORGE CARTER MAN ERQL GÜNAYDIN		Plate
MAN EROL GÜNAYDIN MERCEDES ADEM AKKAYA		
PIENCEDED PIDEPPINIOTTY		Туре
		Register
		Capacity
		Driver

On correction screen, license plate, type, registration, capacity and driver information are available. If driver definition is made, when truck is selected for production, related driver may be selected automatically.

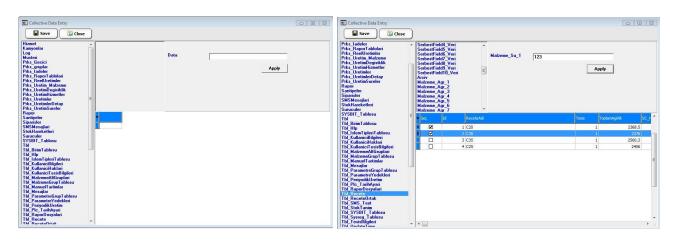
Information is saved by clicking on "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

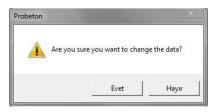
Entries

Collective Data Entry

Collective Data Entry ensures that modifications to be made on many records are performed quickly and easily.

For example to change the quantity of water of many recipes quickly "Tbl_Recete" should be selected on the list at the left part of screen. At the right part, modifiable fields taking place in recipe are displayed. When "Malzeme_Su_1" is selected on the list, list of recipes is displayed at the bottom of screen. Recipes requested to be changed are selected by checking in the boxes in "Select "section."





After the confirmation screen appeared, changes are saved by clicking on "Save". Screen is exited by clicking on "Exit".

Production Parameters

All durations and weight parameters, used in production process and control of production may be changed and monitored via this screen.

Attention! Parameters take place on recipe screen are sent to PLC together with material values when production starts and those parameters become valid during that production. Even though these values are changed on production parameters, parameters of the recipe to be used in following production are entered on these values. If "Use Recipe Common Parameters" option is selected for related recipe, values in "Settings- Recipe Common Parameters" become valid.

Note: In the event that "F10" is pressed, "technical parameters" are viewed. These parameters are the parameters which are not recommended to be changed by user and used in installation and service transactions.

Parameters which are displayed on screen by clicking on "save to disk" button and take place in PLC memory are saved to disk in accordance with current date and hour.

Production Parameters	
Save to Disk	

Note: When "Ctrl + F9" keys are pressed, "Send Defaults" and "Send to PLC" buttons appear. These buttons are hidden to reduce the probability of misuse.

Production Parameters			۲
Save to Disk	Send Defaults	Send to PLC	

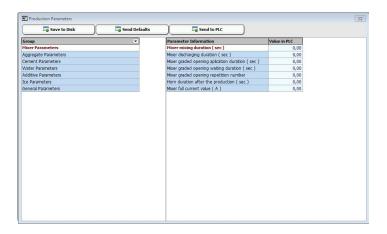
In the event that parameters in PLC are deleted or changed or changed accidentally, parameters saved already to disk may be sent to PLC. When "Send to PLC" button is clicked on, records saved previously appear at the left part. Requested record is selected and "Send" button is clicked on. Transaction may be cancelled by clicking on "Close".

Date	▼ Referent △	Nick Name	Parameter Information	Value in PLC
30.12.2012 13:18:36	1004	BUZOLCSR	Buz Ölçüm Alma Süresi (sn)	0,00
29.12.2012 19:04:58	1005	BUZGECSR	Buz Boşaltım Gecikme Süresi (sn)	1,00
	1006	BUZBS_SR	Buz Boşaltım Sonrası Bekleme Süresi (sn)	0,00
	1007	BUZVKNAG	Buz Kantarı Vibrasyon Kontrol Ağırlığı (kg)	0,00
	1008	BUZVONSR	Buz Kantarı Vibrasyon Kontrol Süresi (sn)	0,00
	1009	BUZVOFFSR	Buz Kantarı Vibrasyon Uygulama Süresi (sn)	0,00
	1010	BUZAKAG	Buz Akış Kontrol Ağırlığı (kg)	0,00
	1011	BUZAKSR	Buz Akış Kontrol Süresi (sn)	0,00
	1012	BUZINCSN	Buz Hata Düzeltme Sınır Değeri (%)	0,00
	1013	BUZHTCRP	Buz Hata Çarpım Değeri	0,00
	1014	BUZHTBOL	Buz Hata Bölüm Değeri	0,00
	1015	BUZ1INC	Buz Hata Düzeltme Değeri (kg)	0,00
	1016	BUZ1PERTOL	Buz Çevrimsel Hata Toleransı (kg)	0,00
	1017	BUZ1HAS	Buz Hassas Tartım Değeri (kg)	0,00
	1018	BUZKISSR	Buz Kısmi Boşaltım Ara Bekleme Süresi (sn)	0,00
	1019	BUZKISYZ	Buz Kısmi Boşaltım Miktarı (%)	0,00
	1020	BUZPKAG	Buz Hizli Aç-Kapa Kontrol Ağırlığı (kg)	0,00
	1021	BUZPONSR	Buz Hızlı Aç-Kapa Uygulama Süresi (sn)	0,00
	1022	BUZPOFSR	Buz Hızlı Aç-Kapa Bekleme Süresi (sn)	0,00
	1023	BUZFSAY	Buz klepe Aç Kapa Tekrar Sayısı	0,00
	1051	MX1KRSR	Mikser Karışım Süresi (sn)	10
	1052	MX1BOSR	Mikser Bosaltim Süresi (sn)	10.00

Default values saved to another part of disk are sent to PLC by clicking on "Send Defaults" button.

Screen is closed by clicking on red X in the top right-hand corner.

Mixer Parameters



Mixer Mixing Duration (*)	It is the duration where materials are mixed in mixer since they are discharged to mixer. Unless all of the materials discharging doors are closed, discharge doesn't start.
Mixer Discharging Duration (*)	It is the duration where mixer discharging door will be kept open. Durations starts when "discharging door is open" signal is perceived.
Mixer graded opening application duration (*)	Discharging door is opened gradually in order to perform discharging transaction in a controlled manner and it is waited in waiting duration.
Mixer graded opening waiting duration (*)	Discharging door is opened gradually in order to perform discharging transaction in a controlled manner, door is opened in application and it is waited in waiting duration.
Mixer graded opening repetition number (*)	Door is opened fully at once after a certain number of repetitions of gradual opening transaction. When "0" is entered, transaction is repeated until door is opened fully.
Horn duration after the production	When last cycle mixer discharging door is closed, Horn is activated for a while to state that production is over.
Mixer full current value	Full account value is used in order that any additional material is not included in mixer when there is a mixture inside. A little higher amount of empty current may be entered.

 $(\ensuremath{^*})$ These parameters vary up to the recipe to be used in production.

Aggregate Parameters

	Gover to Disk				
fer 🛆	Group	• Referent	Nick Name	Parameter Information	Value in PLC
	1 Mixer Parameters	6	AGBASAG	Aggregate tare control weight (kg)	0,00
	2 Aggregate Parameters	6	2 AGSONAG	Aggregate discharging control weight (kg)	0,00
	3 Moisture Parameters	61	3 AGDRSR	Aggregate tare duration (sec)	0,00
	4 Cement Parameters	61	4 AGOLCSR	Aggregate measuring duration (sec)	0,00
	5 Water Parameters	61	5 AGGECSR	Aggregate delay duration before discharging (sec	0,00
	6 Additive Parameters	61	6 AGBS_SR	Aggregate waiting duration after discharging (sec	0,00
	7 Ice Parameters	61	7 AGVKNAG	Aggregate vibration control weight (kg)	0,00
	8 General Parameters	6	8 AGVKNSR	Aggregate vibration control duration (kg)	0,00
		61	9 AGVONSR	Aggregate vibration application duration (sec)	0,00
		6:	0 AGAKAG	Aggregate flow control weight (kg)	0,00
		6	1 AGAKSR	Aggregate flow control duration (sec)	0,00
		6:	2 AG1HAS	Aggregate 1 precision weighing value (kg)	0,00
		6	3 AG2HAS	Aggregate 2 precision weighing value (kg)	0,00
		6	4 AG3HAS	Aggregate 3 precision weighing value (kg)	0,00
		6	5 AG4HAS	Aggregate 4 precision weighing value (kg)	0,00
		6	6 AG5HAS	Aggregate 5 precision weighing value (kg)	0,00
		6	7 AG6HAS	Aggregate 6 precision weighing value (kg)	0,00
		6	8 AG7HAS	Aggregate 7 precision weighing value (kg)	0,00
		6	9 AG8HAS	Aggregate 8 precision weighing value (kg)	0,00
		67	0 AG1PKAG	Aggregate 1 fast blinking control weight (kg)	0,00
		63	POIONSR	Aggregate 1 fast blinking application duration (s	0,00
		63	2 PO1OFSR	Aggregate 1 fast blinking waiting duration (sec)	0,00
		63	3 AG2PKAG	Aggregate 2 fast blinking control weight (kg)	0,00
		63	4 PO2ONSR	Aggregate 2 fast blinking application duration (s	0,00
		63	5 PO2OFSR	Aggregate 2 fast blinking waiting duration (sec)	0,00
		6.	6 AG3PKAG	Aggregate 3 fast blinking control weight (kg)	0.00

In first cycle tare control is made in scales and if weight is high "tare error" occurs. Scale should be discharged for solution, this value should be increased or indicator should be zeroed.
Scale discharging process is completed not by durations but when weight falls below a certain value. If discharging delays, this value should be increased or indicator should be zeroed.
It should be waited for a while that scale becomes stable in order that scale vibrations don't affect tare value before weighing.
It should be waited for a while that scales become stable in order that bin vibrations don't affect measurement value after weighing.
A certain delay duration may be defined for each material before discharged to mixer.
In spite of falling below "discharging control weight" scale may be waited in discharge position for a while and discharged fully.
In the event that there is not any flow as much as "Control Weight" in "Control Duration", vibration is applied in "Application Duration".
When kg value falls below the parameter value to be entered in the aggregate bins with double doors, one of the doors is closed and weighing is continued.
Weighing errors are extracted from the value to be weighed in following cycle (or added if negative) error is corrected on total production basis.
When weighing belt weight falls below "Control Weight" during discharge, vibration is applied in "Application duration", it is waited in "waiting duration".
It is the duration from the completion of discharging process of weighing belt to opening of the door of intermediate bin.

Intermediate Bin Discharging Duration (*)	Information about duration in which door of intermediate bin is open. It starts upon the perception of "Door Opened" signal. It is used as "Skip Discharging Duration" in the system with bin.
Intermediate Bin Vibration Parameters	After "Control Duration" following intermediate bin discharging start, Vibration is applied in "Application Duration", it is waited in "waiting duration".

(*) These parameters vary up to the recipe to be used in production.

Cement Parameters

ave to Disk					
Group	▼ Refer	en 🍐	Nick Name	Parameter Information	Value in PLC
1 Mixer Parameters		751	CMBASAG	Cement tare control weight (kg)	0,00
2 Aggregate Parameters		752	CMSONAG	Cement discharging control weight (kg)	0,00
3 Moisture Parameters		753	CMDRSR	Cement tare duration (sec)	0,00
4 Cement Parameters		754	CMOLCSR	Cement measuring duration (sec)	0,00
5 Water Parameters		755	CMGECSR	Cement delay duration before discharging (sec)	0,00
6 Additive Parameters		756	CMBS_SR	Cement waiting duration after discharging (sec)	0,00
7 Ice Parameters		757	CMVKNAG	Cement bin vibration control weight (kg)	0,00
8 General Parameters		758	CMVONSR	Cement bin vibration application duration (sec)	0,00
		759	CMVOFSR	Cement bin vibration waiting duration (sec)	0,00
		760	CKAYONSR	Cement air shock application duration (sec)	0,00
		761	CKAYOFSR	Cement air shock waiting duration (sec)	0,00
		762	CMAKAG	Cement flow control weight (sec)	0,00
		763	CMAKSR	Cement flow control duration (sec)	0,00
		764	CMINCSN	Cement error correction limit value ??(%)	0,00
		765	CMHTCRP	Cement error multiplication value	0,00
		766	CMHTBOL	Cement error division value	0,00
		767	CM1INC	Cement 1 error correction value (kg)	0,00
		768	CM2INC	Cement 2 error correction value (kg)	0,00
		769	CM3INC	Cement 3 error correction value (kg)	0,00
		770	CM4INC	Cement 4 error correction value (kg)	0,00
		771	CM5INC	Cement 5 error correction value (kg)	0,00
	1	772	CM6INC	Cement 6 error correction value (kg)	0,00
			CM1PERTOL	Cement 1 cyclic fault tolerance (kg)	0,00
		774	CM2PERTOL	Cement 2 cyclic fault tolerance (kg)	0,00
		775	CM3PERTOL	Cement 3 cyclic fault tolerance (kg)	0,00
		776	CM4PERTOL	Cement 4 cyclic fault tolerance (kg)	0.00

Cement Tare Control Weight	In first cycle tare control is made in scales and if weight is high, "tare error" occurs. Scale should be discharged for solution, this value should be increased or indicator should be zeroed.
Cement Discharging Control Weight	Scale discharging process is completed not by durations but when weight falls below a certain value. If discharging delays, this value should be increased or indicator should be zeroed.
Cement Tare Duration	It should be waited for a while that scale becomes stable in order that bin vibrations don't affect tare value before weighing.
Cement Measuring Duration	It should be waited for a while that scales become stable in order that bin vibrations don't affect measurement value after weighing.
Cement Delay Duration Before Discharging	A certain delay duration may be defined for each material before discharged to mixer.
Cement Waiting Duration After Discharging	In spite of falling below "discharging control weight" scale may be waited in discharge position for a while and discharged fully.
Cement Vibration Parameters	In the event that there is not any flow as much as "Control Weight" in "Control Duration", vibration is applied in "Application Duration".
Cement Air Shock Parameters	Air shock is applied in Application Duration" in order to increase the flow during cement weighing, it is waited in "Waiting Duration".
Cement Error Correction Value	Weighing errors are extracted from the value to be weighed in following cycle (or added if negative) error is corrected on total production basis.

Water Parameters

🐻 Save to Disk					
er 👻 Group		Referenc	Nick Name	Parameter Information	Value in PLC
1 Mixer Parameter	3	801	SUBASAG	Water tare control weight (kg)	0,00
2 Aggregate Para	neters	802	SUSONAG	Water discharging control weight (kg)	0,00
3 Moisture Parame	ters	803	SUDRSR	Water tare duration (sec)	0,00
4 Cement Parame	ers	804	SUOLCSR	Water measuring duration (sec)	0,00
5 Water Paramet	275	805	SUGECSR	Water delay duration before discharging (sec)	0,00
6 Additive Parame	ters	806	SUBS_SR	Water waiting duration after discharging (sec)	0,00
7 Ice Parameters		807	SUAKAG	Water flow control weight (kg)	0,00
8 General Paramet	ers	808	SUAKSR	Water flow control time(kg)	0,00
		809	SUINCSN	Water error correction limit value ??(%)	0,00
		810	SUHTCRP	Water error multiplication value	0,00
		811	SUHTBOL	Water error division value	0,00
		812	SU1INC	Water 1 error correction value (kg)	0,00
		813	SUZINC	Water 2 error correction value (kg)	0,00
		814	SU3INC	Water 3 error correction value (kg)	0,00
		815	SU1PERTOL	Water 1 cyclic fault tolerance (kg)	0,00
		816	SU2PERTOL	Water 2 cyclic fault tolerance (kg)	0,0
		817	SU3PERTOL	Water 3 cyclic fault tolerance (kg)	0,00
		818	SU1HAS	Water 1 precision weighing value (kg)	0,00
		819	SU2HAS	Water 2 precision weighing value (kg)	0,00
		820	SU3HAS	Water 3 precision weighing value (kg)	0,00
		821	SUKISSR	Water partial discharging waiting duration (sec)	0,00
		822	SUKISYZ	Water partial discharging value (%)	0,00
		823	SUPKAG	Water fast blinking control weight (kg)	0,00
		824	SUPONSR	Water fast blinking application duration (sec)	0,00
		825	SUPOFSR	Water fast blinking waiting duration (sec)	0,00
		826	ILAVESU	Additional water (kg/m3)	0,00

Water Tare Control Weight	In first cycle tare control is made in scales and if weight is high, "tare error" occurs. Scale should be discharged for solution, this value should be increased or indicator should be zeroed.
Water Discharging Control Weight	Scale discharging process is completed not by durations but when weight falls below a certain value. If discharging delays, this value should be increased or indicator should be zeroed.
Water Tare Duration	It should be waited for a while that scale becomes stable in order that bin vibrations don't affect tare value before weighing.
Water Measuring Duration	It should be waited for a while that scales become stable in order that bin vibrations don't affect measurement value after weighing.
Water Delay Duration Before Discharging	A certain delay duration may be defined for each material before discharged to mixer.
Water Waiting Duration After Discharging	In spite of falling below "discharging control weight" scale may be waited in discharge position for a while and discharged fully.
Water Error Correction Values	Weighing errors are extracted from the value to be weighed in following cycle (or added if negative) error is corrected on total production basis.
Water Partial Discharging Parameters	Water discharging may be performed in two stages. Amount of percentage entered in "Water Partial Discharging Value" is discharged and it is waited in, "Discharging Waiting Duration".

Additive Parameters

Group	▼ Referent △	Nick Name	Parameter Information	Value in PLC
1 Mixer Parameters	851	KTBASAG	Additive tare control weight (kg)	0,00
2 Aggregate Parameters	852	KTSONAG	Additive discharging control weight (kg)	0,0
3 Moisture Parameters	853	KTDRSR	Additive tare duration (sec)	0,0
4 Cement Parameters	854	KTOLCSR	Additive measuring duration (sec)	0,0
5 Water Parameters	855	KTGECSR	Additive delay duration before discharging (sec)	0,0
6 Additive Parameters	856	KTBS_SR	Additive waiting duration after discharging (sec	0,0
7 Ice Parameters	857	KATYIKSR	Additive washing duration (sec)	0,0
8 General Parameters	858	KTAKAG	Additive flow control weight (kg)	0,0
	859	KTAKSR	Additive flow control duration (kg)	0,0
	860	KTINCSN	Additive error correction limit value (%)	0,0
	861	KTHTCRP	Additive error multiplication value	0,0
	862	KTHTBOL	Additive error division value	0,0
	863	KT1INC	Additive 1 error correction value (kg)	0,0
	864	KT2INC	Additive 2 error correction value (kg)	0,0
	865	KT3INC	Additive 3 error correction value (kg)	0,0
	866	KT4INC	Additive 4 error correction value (kg)	0,0
	867	KT5INC	Additive 5 error correction value (kg)	0,0
	868	KT6INC	Additive 6 error correction value (kg)	0,0
	869	KT1PERTOL	Additive 1 cyclic fault tolerance (kg)	0,0
	870	KT2PERTOL	Additive 2 cyclic fault tolerance (kg)	0,0
	871	KT3PERTOL	Additive 3 cyclic fault tolerance (kg)	0,0
	872	KT4PERTOL	Additive 4 cyclic fault tolerance (kg)	0,0
	873	KT5PERTOL	Additive 5 cyclic fault tolerance (kg)	0,0
	874	KT6PERTOL	Additive 6 cyclic fault tolerance (kg)	0,0
	875	KT1HAS	Additive 1 precision weighing value (kg)	0,0
	876	KT2HAS	Additive 2 precision weighing value (kg)	0,0

Additive Tare Control Weight	In first cycle tare control is made in scales and if weight is high, "tare error" occurs. Scale should be discharged for solution, this value should be increased or indicator should be zeroed.	
Additive Discharging Control Weight	Scale discharging process is completed not by durations but when weight falls below a certain value. If discharging delays, this value should be increased or indicator should be zeroed.	
Additive Tare Duration	It should be waited for a while that scale becomes stable in order that bin vibrations don't affect tare value before weighing.	
Additive Measuring Duration	It should be waited for a while that scales become stable in order that bin vibrations don't affect measurement value after weighing.	
Additive Delay Duration Before Discharging	A certain delay duration may be defined for each material before discharged to mixer.	
Additive Waiting Duration After Discharging	In spite of falling below "discharging control weight" scale may be waited in discharge position for a while and discharged fully.	
Additive Error Correction Values	Weighing errors are extracted from the value to be weighed in following cycle (or added if negative) error is corrected on total production basis.	

General Parameters

	Save to Disk						
efer	Group	-	Referenc	Nick Name	Parameter Information	Value in PLC	Ŀ
	1 Mixer Parameters		1101	AGR1MAX	Aggregate group 1 weighing limit value (kg)	0,00	Г
	2 Aggregate Parameters		1102	AGR2MAX	Aggregate group 2 weighing limit value (kg)	0,00	
	3 Moisture Parameters		1103	CIM1MAX	Cement group 1 weighing limit value (kg)	0,00	L
	4 Cement Parameters		1104	SU1MAX	Water group 1 weighing limit value (kg)	0,00	
	S Water Parameters		1105	KAT1MAX	Additive group 1 weighing limit value (kg)	0,00	l
	6 Additive Parameters		1106	BOYA1MAX	Paint group 1 weighing limit value (kg)	0,00	l
	7 Ice Parameters		1107	KUL1MAX	Ash group 1 weighing limit value (kg)	0,00	
	8 General Parameters		1108	BUZ1MAX	Ice group 1 weighing limit value (kg)	0,00	1
			1109	CIM2MAX	Cement group 2 weighing limit value (kg)	0,00	l
			1110	SU2MAX	Water group 2 weighing limit value (kg)	0,00	1
			1111	KAT2MAX	Additive group 2 weighing limit value (kg)	0,00	ł
			1112	BOYA2MAX	Paint group 2 weighing limit value (kg)	0,00	
			1113	KUL2MAX	Ash group 2 weighing limit value (kg)	0,00	l
		1	1114	BUZ2MAX	Ice group 2 weighing limit value (kg)	0,00	ł
			1115	TAGR+	Simulation mode to increase aggregate value (kg)	0,00	l
			1116	TAGR-	Simulation mode to decrease aggregate value (kg)	0,00	ł
			1117	TCIM+	Simulation mode to increase cement value (kg)	0,00	l
			1118	TCIM-	Simulation mode to decrease cement value (kg)	0,00	
			1119	TSU+	Simulation mode to increase water value (kg)	0,00	I
			1120	TSU-	Simulation mode to decrease water value (kg)	0,00	
			1121	TKAT+	Simulation mode to increase additive value (kg)	0,00	I
			1122	TKAT-	Simulation mode to decrease additive value (kg)	0,00	I
			1123	TBOY+	Simulation mode to increase paint value (kg)	0,00	l
			1124	TBOY-	Simulation mode to decrease paint value (kg)	0,00	ľ
			1125	TKUL+	Simulation mode to increase ash value (kg)	0,00	
			1126	TKUL-	Simulation mode to decrease ash value (kg)	0,00	F

Weighing Limit Value	"Limit Value" may be entered for each weighing. In the event that these values are
	exceeded, weighing is stopped and user is warned.

Upper Limits

It is the screen on which upper limits of bin may be entered and modified. These values should be as same as the capacity of weighing indicators.

When "New" or existing record is selected and "Edit" is clicked on, editing screen appears. Clicking on "Delete", selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. "Transfer Data" transaction is detailed in "Entries-Stock Entry".

Upper Limits		23
🖉 Edit		Transfer Data 🕃
teference 💌 Name	▼ Value Valu	ue 💌
1 AGR 1	7000	32000
3 CIM 1	1500	32000
5 SU 1	1000	32000
7 KATKI 1	50	32000
9 BOYA 1	50	32000
11 KUL 1	50	32000
13 BUZ 1	1000	32000
15 NEM	20	32000
17 NORMAL	32000	32000
36 SURE	3200	32000

Second "value" expression appearing on screen is a technical parameter adjusted during installation and may vary with the feature of PLC used.

Information is saved with "Save", screen is exited by clicking on "Close" without saving. Screen is closed by clicking on red X in the top right-hand corner.

Recipe Common Parameters

When "Use Recipe Common Parameters" option is selected and related recipe is used in production, parameters on this screen become valid during that production.

Precision Weigh	ning Values	1				
0-3MM SAND	200,00 Kg	Int.Bin. / Skip Dis	chargin 10		Sn	
	200,00 Kg	Mixer Parameter	s			
1. GRAVEL		Mixing Duration (sec)		15,00	Sn
2. GRAVEL	200,00 Kg	Disch.Duration (se	ec)		10,00	Sn
SAND 200,00	200,00 Kg	Graded Opening Application Duration			0,50	Sn
		Graded Opening Waiting Duration			4,00	Sn
		Graded Opening F	Repetition No	umber	3	
		Discharging Dela	tion			
		Aggregate	0,00	Sn		
		Cement	4,00	Sn		
		Water	2,00	Sn		
		Additive	1,00	Sn		

Precision Weighing Values: They are the parameters entered in order to minimize the error rate in weighing and to control material flow. When kg value to be received from bin in aggregate bins with double doors falls below the entered parameter value, one of the doors is closed and weighing is continued. Values herein should be entered for 1 m3.

"Environmental impact class", "consistency class" and "content of chloride" taking place in General Parameters are used in waybill. "Aggregate Intermediate bin / Skip Discharging Duration" corresponds to the duration where aggregate is discharged fully from intermediate bin or skip to mixer.

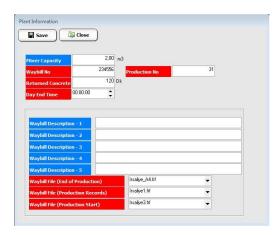
In the sub part of discharging delay, certain delay durations are defined for each group, when it becomes necessary to discharge into mixer.

In Mixer Parameters, "mixing duration" may be defined since material is discharged to mixer and "discharging duration" where discharging door will be kept open may be defined. In order that discharging transaction be made in a controlled manner, discharging door is opened gradually. Door is opened in "Graded Opening Application Duration" and it is waited in "waiting duration". This operation is performed by considering "graded opening repetition number" and then door is opened fully. In the event that repetition number is entered as "0", graded opening transaction is made until door is opened fully. In order that door is opened at once, "waiting duration" should be entered as "0".

Information is saved by clicking on "Save" and Screen is closed without saving by clicking on red "X" in the top right-hand corner.

Plant Information

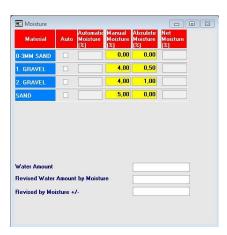
It is the screen on which some features of plant may be entered or modified.



Mixer Capacity	Maximum concrete amount which may be produced in one cycle.
Waybill and Production No	Waybill number and production number are increased automatically at the end of each production. By the use of this screen waybill and production number may be changed.
Returned Concrete Duration	Maximum duration in which returned concrete can be used (in min). If this duration is exceeded, concrete transaction can't be made.
Day End Time	It is the time when day is closed for production records. Start time for production reports is determined in accordance with this time.
Waybill Descriptions	Descriptions requested to be printed on waybill may be entered in these boxes.
Waybill File (Production End, Production Records, Production Start)	Selection of waybill from production records or waybill to be printed at the beginning or end of production.

Moisture

It is the screen where aggregate moisture percentages may be displayed and modified.



Moisture Information may be processed manually or automatically. In the event that moisture sensor is used, "auto" option next to related aggregate should be checked. In this case, moisture information read on sensor shall be displayed in "Automatic Moisture" box. If "auto option" is not selected, moisture value may be entered in "Manual Moisture" box. "Absolute Moisture" is deducted from automatic or manual moisture and result is displayed in "Net Moisture" boxes

Important! After each value entry, enter should be clicked on. Box color becomes yellow for a while. It means that value is sent to PLC. If enter is not clicked on, value remains on screen but not sent to PLC.

In the calculation, moisture amount in aggregate (kg) is deducted from water amount on recipe and added into related aggregate. At the bottom of screen "water amount" will be deducted from water amount on recipe after moisture calculation (if absolute moisture is higher), "Moisture Revision" and "Moisture Revised Water Amount" to be used in production will be displayed in kg/cycle.

Screen is closed by clicking on red "X" in the top right-hand corner.

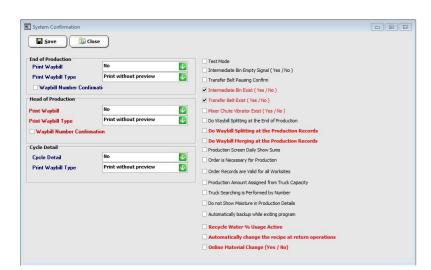
Confirmations

Production Confirms



Production Background Image	An image may be placed on background of production screen. Most appropriate resolution is 1280 * 653 pixels.	
Customer Logo	Customer Logo may be used on production screen. Most appropriate width is 160 pixels.	
Truck (Truckmixer)	Truckmixer image displayed on production screen may be changed. Most appropriate is 238 * 100 pixels.	
Get Permission Before Discharging	If option is active, permission is taken from user before discharging mixer at first cycle. In the event that truckmixer is not ready, discharging process may be waited.	
Description Entry After the Production	If option is active, description screen is displayed at the end of production. These entered descriptions are displayed as "production and description" in production records.	
Use Voice Feature	If option is active, warning messages displayed in program are voiced.	
Use Periodic Casting Feature	If option is active, "requested-measured-difference-total material" details for each cycle are saved and printed.	

System Confirms



Waybill may be printed at the end of, at the beginning of production or about cyclic material details.

In the event that "No" is selected for print waybill, waybill is not printed. If "Confirmation" is selected, confirmation of user is taken before printing, if "Without Confirmation" is selected, it is sent to printer without taking confirmation.



Print type may be selected as "Quick Print" or "With Design View". If "design view" is selected, waybill is previewed. When "quick print" is selected, it is sent to printer without being previewed.

Print without preview
Print without preview
Print with preview

If "Waybill Number Confirmation" is checked, user is authorized to change waybill number before printing waybill.

Test Mode	It ensures all functions of system are operated even though there is no material in silos. It is used by technical team during installation.	
Intermediate Bin Empty Signal (Yes / No)	If option is active and intermediate bin empty sensor is available, discharge control made in accordance with "intermediate bin empty" signal.	
Transfer Belt Pausing Confirm	If option is active, when production is waited or taken to manual control, transfer belt is stopped; otherwise, it is not stopped.	
Intermediate Bin Exist (Yes / No)	This option should be activated in the constant plants with intermediate bin.	
Transfer Belt Exist (Yes / No)	This option is not activated in mobile plants where weighing and transfer transaction are made on one belt.	
Chute Vibrator Exist (Yes / No)	This option is activated when mixer is discharged and vibrator is available.	

Do Waybill Splitting at the End of Production	If option is active, waybill is split at the end of production.
Do Waybill Splitting at the Production Records	If option is active, waybill is split for the productions made previously.
Do Waybill Merging at the Production Records	If option is active, waybill is merged for the productions made previously.
Order is Necessary for Production	If option is active, unless order is entered, production is not made.
Order Records are Valid for all Worksites	Production can be made by using many common plant databases. If option is active order entered in one plant can be used in other plants also.
Production Amount Assigned from Truck Capacity	If option is active, when truck is selected, its capacity is appointed to the amount to be produced.
Truck Searching is Performed by Number	Truck searching is made in accordance with license plate in records and production start. If option is active, truck searching is performed by number.
Do not Show Moisture in Production Details	Whether moisture information will be displayed or not may be determined in "Production records-production details".
Recycle Water % Usage Active	If option is active, recycle water is entered as % of total water
Automatically change the recipe at return operations	In the event that returned concrete is completed with a different recipe, material values are adjusted automatically.
Online Material Change (Yes / No)	If option is active, material modification can be made during production.

Vibrator Confirms

Vibrator Confirmation	
✓ Aggregate 1 Vibrator Exist (Yes / No) Aggregate 2 Vibrator Exist (Yes / No)	 Weighing Belt 1 Vibrator Exist (Yes / No) Weighing Belt 2 Vibrator Exist (Yes / No)
✓ Aggregate 3 Vibrator Exist (Yes / No)	 Intermediate Bin Vibrator Exist (Yes / No)
 Aggregate 4 Vibrator Exist (Yes / No) Aggregate 5 Vibrator Exist (Yes / No) 	 Cement Bin Vibrator Exist (Yes / No) Mixer Chute 1 Vibrator Exist (Yes / No)
Aggregate 6 Vibrator Exist (Yes / No)	Mixer Chute 1 Vibrator Exist (Yes / No)
🗌 Aggregate 7 Vibrator Exist (Yes / No)	
Aggregate 8 Vibrator Exist (Yes / No)	

Vibrators used in system may be defined on this screen.

Information is saved by clicking on "Save" and screen is exited by clicking on "Close".

Indicator Confirms



In the event that indicator is used in the type with serial communication, definition can be made on this screen.

Periodic Error Control Confirms

Cycle Error Control Confirmation	
Save Control Active	Addive 1 Periodic Einer Control Active Addive 2 Periodic Einer Control Active Addive 3 Periodic Einer Control Active Addive 3 Periodic Einer Control Active Addive 5 Periodic Einer Control Active Addive 5 Periodic Einer Control Active Ofference Completion Active Cement Difference Completion Active Addive Difference Completion Active Addive Difference Completion Active Addive Difference Completion Active Addive Difference Completion Active Addive Difference Completion Active Addive Difference Completion Active
Cement 4 Pesiodic Error Control Active Cement 5 Pesiodic Error Control Active Cement 6 Pesiodic Error Control Active Water 1 Periodic Error Control Active Water 3 Periodic Error Control Active	

Periodic error control is made for selected material. If negative or positive error is available except "cyclic error tolerance" entered in "production parameters", a message appears on screen. User may continue production, if incomplete material is received, "difference completion" can be made or production may be cancelled fully.

Difference Completion Confirmation

If incomplete material is taken after "periodic error control" while selected group is weighed, it is tried to be completed automatically with "fast blinking" method.

Information is saved by clicking on "Save" and screen is exited by clicking on "Close".

Sensor Fault



If "intermediate bin door is closed" and signal is not perceived, weighing belt is not operated. If "intermediate bin door is open" signal is not perceived, discharging duration doesn't start. If "door is closed" signals of cement, water and additive bins are not perceived, weighing units are not operated. If any one of these sensors is fault, production is interrupted at that stage.

Until sensor is replaced, related sensor is deactivated in order to continue production.

Production

Production Screen

Production Screen is the screen on which production transactions may be controlled and watched. It may be displayed by pressing F9 shortcut key and may be closed by pressing Ctrl + F4 shortcut keys or by clicking on red "X" in the top right-hand corner. If required, information on screen may be refreshed by pressing F5 shortcut key.



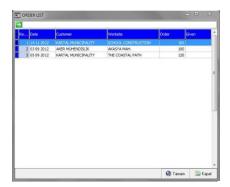
Information at upper left part:

Production No	It is increased automatically in each production. It may be modified in "Plant Information".	Production Duration	Duration Information of active production.
Total Cycle	Number of cycles of active production.	Cycle Production Amount	Concrete amount (m3) to be produced in every cycle.
Total Production	Concrete amount (m3) of active production.	Working Duration	Mixer working duration of that day.

Production Start

Making a selection from the previously defined orders or entering "Customer", "Worksite" and "Recipe" information, production may be started.

Using selection button next to "Order No.", "list of orders" is displayed. Requested order record is selected and "Ok" is clicked on. To cancel, screen is closed by clicking on "Close". "Total" and Remaining" amounts of selected amount are displayed on table.



When cancel button next to "Order No." is used and "Order is Necessary for Production" is not selected in "Settings-Confirmations-System Confirmations", "Customer", "Worksite" and "Recipe" options become active.

After selecting customer, worksite selection screen appears automatically. Using worksite selection button, different worksite may be selected.

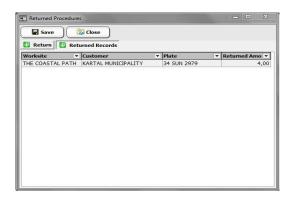
Truck information selection is made in accordance with license plate or vehicle number. This option is available in "Settings-Confirmations-System Confirmations". Driver defined to related truck is displayed automatically. A different driver may be selected by using driver selection button.

Service options like pump and truckmixer are defined by using Service 1 and 2.

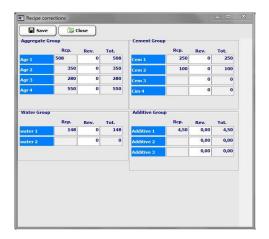
Increasing and decreasing transactions per m3 without changing water amount in recipe may be made by using "additional water" box.

After entering amount, selection should be sent to PLC by using arrow icon.

If returned concrete transaction is not performed, "Ready Amount" may be defined. Real production amount is calculated by extracting ready amount from "Production Amount", waybill is printed in accordance with "Production Amount".



Production amount can't be entered more than selected truck capacity. If "Production Amount Assigned from Truck Capacity" is selected in "Settings-Confirmations-System Confirmations", "Production Amount" becomes defined. If required, it is possible to make modification on it. Using "Recipe Correction" button, it is possible to make modification in the quantity of material to be valid in that production without making any modification in original recipe information.





Amounts to be increased or decreased amounts per m3 for related material are entered in middle "Correction" box on the appearing window. Original recipe amounts and amounts calculated are displayed in left and right columns respectively. Correction amounts are limited with "minimum and maximum recipe correction values" defined in "First transactions-Material". When incorrect amount is entered, user is warned.

When clicking on "Save" button, confirmation screen is displayed. Corrections are applied and screen is exited by clicking on "Yes". Clicking on "No" screen is exited without making any modification.

Production is started by clicking on "Start" and confirming. Program makes a number of controls in this stage; user is warned about the situations preventing production start and production doesn't start. Only warning is given to user about the issues which won't prevent production start and user may correct during production but production is not stopped. "Production Information" window is switched to from production start screen.

Production Information

	Вср.	Rev.	Des.	Mea.	Tot.)ifferen
0-3MM SAND	520	0	1.034	1.022	5.188	-12
1. GRAVEL	560	0	1.134	1.147	5.612	13
2. GRAVEL	290	0	580	573	2.893	-7
SAND	510	0	1.033	1.047	5.113	14
Skip	120	0	240	129	959	-111
CEM Z	110	0	220	U	880	-220
СЕМ З	70	0	139	0	560	-139
CEM 4	80	0	160	0	640	-160
Water 1	100	0	200	200	799	0
Water 2	10	0	20	0	79	-20
Additive 1	2,00	0,00	4,01	4,02	20,00	0,01
Additive 2	3,00	0,00	6,07	6,03	29,95	-0,04
Additive 3	1,00	0,00	2,00	0,46	7,99	-1,54

Columns in Production Information are as follows:

Recipe	Amounts of selected recipe	Correction	Correction amounts entered on "Recipe Correction" screen
Requested	Amounts to be weighed for each cycle	Measured	Amounts calculated by extracting tare value from scale value.
Total	Total amount weighed until the cycle at that time.	Difference	Difference between "measured" and "requested" amount.

Total amount for each column is displayed at the sub part.

"Measured" box for unit being weighed becomes yellow. While moving mouse on the name of any material, "Skip" indication appears. When clicked on "Skip" for the material of which weighing transaction is requested to be terminated for any reason, weighing is stopped and following material is handled.

Wait Reset KARTAL MUNICIPALITY	THE COASTAL PATH	C35	Daily Production :4 m ³	CONCRETE PUMP	34 SUN 2979 (Sef: 1)
--------------------------------	------------------	-----	------------------------------------	---------------	----------------------

At the bottom of production screen "Customer", "Worksite", "Recipe", "Daily Production Quantity", "Service", "Plate of Truck and Trip no." information are displayed respectively.

When production started, "Start" button turns to "Wait" and when clicked on it, production is suspended. Button turns to "Continue", when clicked on it, production is continued.

If "reset" button is clicked on when there is no production, confirmation screen is displayed. When confirmed, production values are zeroed on production screen and PLC. When "Reset" is clicked on during production, production is suspended and options to continue or reset are offered. When reset, production made until that time is saved.



Clicking on "Correction" column during production, it is possible to increase or decrease the amounts therein without changing recipe values.

Order No	0		💵 🗤	0,00 m ³
Customer	KARTAL M	UNICIPALITY	N 🚺	4,00 m ³
₩orksite	THE COAS	TAL PATH	N 🚺	4,00 m ³
Recipe	C35 (S3)		10	4,00 m ³
Total Order				
Remaining Order				
Truck	34 SUN 29	79	V 60	4,00 m ³
Driver	ADEM AKK	AYA	N 🚺	4,00 m
Service 1	CONCRETE	PUMP	N 🔽	4,00 m
Additional Water	0,00 kg/m³	>		
Ready Amount	0 m ³		10	
Production Amour	8,00	nish Producti	Chan	ae

It is possible to make modification in amount and information in "Production Start". When "Change Production Information" is clicked on, information change window appears. After necessary modifications, changes are confirmed by clicking on "Save" and transaction is cancelled by clicking on "Close".

Order No	0 (🔜 🥎	0,00 m ³
Customer	KARTAL MUNICIPALITY	4,00 m ³
Worksite	THE COASTAL PATH	4,00 m ³
Recipe	C35 (S3)	4,00 m ³
Total Order		
Remaining Order		
Truck	34 SUN 1445 🛛 🚺 🗠	0,00 m ³
Driver	GEORGE CARTER	0,00 m ³
Service 1	CONCRETE PUMP 🛛 👽 🗠	4,00 m ³
Additional Water	0,00 kg/m³ 💽	
Ready Amount	0 m ³	
Production Amour	8,00 nish Productic Cha	nge

Clicking on "Finish Production" button, production is finished at the end of the current cycle. Clicking on "Change" button it is possible to make modification in cubic meter for once only. Requested amount is entered in the red box and "Confirm" button is clicked on. Clicking on Close, transaction is cancelled. Decrease of amount is confirmed by program if production is in appropriate cycle.

Desired Amount (m3)	10,00 m3		
Ready Amount (m3)	0,00 m3		
Produced Amount (m3)	2,00 m3		
lew Desired Amount (m3)	5		
lew Desired Amount (m3)	5]	
lew Desired Amount (m3)	5]	

A	Amount changing process is done one time during the production
<u> </u>	Are you sure you want to continue?

Production Plan

Plan is created for following production and sequential production can be made by the use of this window.

Graphical Screen

Aggregate



At the upper part of aggregate bins there are material names and moisture percentages take place on them.

When any bunker picture is right clicked on, "easy access menu" appears.

<u>M</u>oisture <u>P</u>arameters M<u>o</u>isture Parameters <u>S</u>tock S<u>t</u>art Vibrator Stop <u>V</u>ibrator

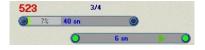
"St No

Through easy access menu, it is possible to switch to "Moisture", "Parameter", Moisture Parameters" and "Stock" screens and vibrator of related bunker may be start.

Note : Clicking on F10, detailed parameters may be displayed.

"Open door" command. One or two doors are opened in accordance with precision weighing feature.

Vibration.



At the upper part of weighing belt, aggregate bin value, current cycle/ total cycle information is available. On picture there is percentage bar showing weight increase and discharging control duration are available. At the end of "Discharging Control Duration" which may be defined as

parameter, if it doesn't fall below "discharging control weight", user is warned.

"Transport Duration" is displayed on Transfer Belt. When this duration is completed, discharging door of intermediate bin is opened.

When any belt picture is right clicked on, "easy access menu" appears. It is possible to access to parameters of aggregate group on menu.

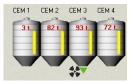
O	"Start Belt" command (green color).	"Belt is running" signal.
≷	Vibration.	



On intermediate bunker current cycle/total cycle and "discharging duration" information are viewed. At the end of this parametric duration discharging door of intermediate bin is closed. After "vibration control duration" vibrator is start in a time-controlled manner in the course of discharging process with "apply-wait" property. It is possible to access to aggregate group parameters through easy access menu.

-	"Discharging door is closed" signal.	8	"Discharging door is open" signal.
➡	"Open discharging door" command.	>>	Vibration.

Cement



Over cement silos there are material names, stock quantities and stock level bar are located on them. When right clicked on any silo image, "easy access menu" appears. Level display is made in accordance with the values entered on the screen of "first transactions-silo capacities".

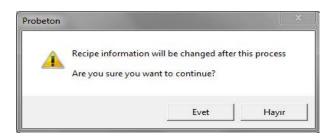
<u>P</u> arameters	
Stock	
<u>A</u> ctive Silo	
<u>C</u> ancel Active Silo	
<u>F</u> orwarding	,
Grouping	

Through easy-access menu it is possible to switch to "Parameters" and "Stock" screens easily and "Active Silo", "Forwarding" and "Grouping" transactions may be performed.

Note : Clicking on F10, detailed parameters may be displayed.

•	"Start screw" command.	*	Air shock.
	"Silo full" and "silo empty" signals.		

Active silo feature: When one cement amount is entered on recipe, this amount is received from the silo which is defined as "active". In the event that cement is empty, active silo is changed on easy access menu. In this case, warning window will appear and cement amount in recipes are transferred to active silo line. Silo defined as active becomes green. In the productions where different types of cements are used, active silo feature should be cancelled on easy access menu.



Forwarding and Grouping feature:

Cancel Forwarding	
Forward Silo 1	
Forward Silo 2	
Forward Silo 4	
For <u>w</u> ard Silo 5	
Forward Silo 6	

When it is perceived that flow is not enough or cement is empty, another silo may be forwarded to through easy access menu. Previous screw is stopped and forwarded silo screw is start. It is stated on forwarded silo to which direction it is forwarded with arrow icon. Forwarding may be cancelled through easy access menu.

Silos containing same type of cement may be grouped and weighing may be accelerated in this way. On

the screen appearing through easy access menu, related grouping is made and "Apply" button is clicked on. Stocks of the silos running in a group are shared and deducted. For cancelation "No grouping" should be selected and "Apply" should be clicked on.

arouping	Silo 2-4	-
	Silo 1-2 Silo 1-3 Silo 1-4 Silo 2-3 Silo 2-4	<u> </u>
	Silo 1-2 Silo 3-4 Silo 1-3 Silo 2-4 Silo 1-4 Silo 2-3	



At the upper part of cement bin there is bin weight value and current cycle/total cycle information is located on it. Bin fullness rate is shown by percentage and level bar.

-	"Discharging door is closed" signal.	"Open discharging door" command.
8	Vibration.	

Water

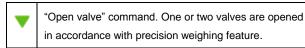


Material names are located on water tanks. When right clicked on tank image, "easy access menu" appears.

It is possible to switch to "Parameter" and "Stock" Screens easily through easy access menu.



Note: When F10 is clicked on parameter screens, detailed parameters may be displayed.





Tare weight information is available over water bin; current cycle/total cycle information takes place on it. Bin fullness rate is shown by percentage and level bar.

"Discharging door is closed" signal.	-	"Open discharging door" command.
--------------------------------------	---	----------------------------------

Additive



Over additive tank there are material names, stock quantities and stock level bar are located on them. When right clicked on any tank image, "easy access menu" appears. Level display is made in accordance with the values entered on the screen of "first transactions-silo capacities".

It is possible to switch to "Parameter" and "Stock" Screens easily through easy access menu.



Note: When F10 is clicked on parameter screens, detailed parameters may be displayed.



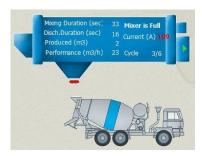
"Start pump" command.

7,52

At the upper part of additive bin there is bin weight value and current cycle/total cycle information is located on it. Bin fullness rate is shown by percentage and level bar.

-	"Discharging door is closed" signal.	➡	"Open discharging door" command.
---	--------------------------------------	---	----------------------------------

Mixer



On mixer image there are mixing and discharging durations, amount produced for active production (discharged to truckmixer), performance (hourly production capacity), mixer full/empty information, current motor current and cycle information.

It is possible to switch to "Parameter" and "Stock" Screens easily through easy access menu.

Note : Clicking on F10, detailed parameters may be viewed on parameter screens.

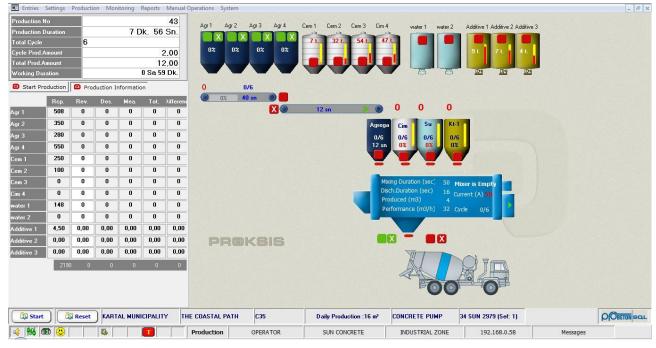
Mixer full/empty information may be shown in accordance with digital or analog information received from mixer ammeter. In the event that analog information is received, instant current value is compared with" mixer full current value". If current at that time is higher than this value, "full" information is displayed, otherwise "empty" information is displayed. In "full" situation, material is not discharged, unless "empty" signal is perceived, discharging doors are not closed. "Mixer full current value" is recommended to be entered a few ampere more. In the event that digital information is received, similar settings should be made on ammeter.

- "	"Discharging door is closed" signal.		"Discharging door is open" signal.
-----	--------------------------------------	--	------------------------------------

-	"Open discharging door" command.		"Close discharging door" command.
♦	Chute Vibrator	(()	"Production is over" horn

Manual Operation

When "Manual" (Ctrl +M) is selected on "Manual Operation" menu, manual operations buttons are displayed on screen. Requested unit may be operated by mouse. Double buttons are used for aggregate doors requiring quick start-stop and mixer discharging doors requiring bidirectional command. Other units are controlled by single button. Buttons may be removed from screen by pressing Ctrl + O shortcut keys and selecting "automatic" on "manual operation" menu. "Mixer start-stop" (Ctrl + Alt + M) and "Horn" (Ctrl + S) functions are accessible also on same menu.



Coordinate setting

Clicking on F8, coordinates settings window may be displayed and closed on production screen. After changing figures, "Apply" button should be clicked on. Figures are pixel numbers.

]
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-

laterial Height	239	
Form Width	1300	
Form Height	650	
Form Margin from Top	0	
Logo 1 Margin from Top	477	
Logo 1 Margin from Left	426	
Logo 2 Margin from Top		
Logo 2 Margin from Left		
		Apply

Material Height: When the number of used raw materials is increased, height of "Production Information" table may be increased. Entered figures determine the height of table.

Form Width, Height, and Margin from Top: Dimensions of production screen and how much lower it will be placed from top right part of screen may be determined.

Logo 1 and 2 Margin from top and left: Locations of logo of producing firm (Logo 1) and customer logo (Logo2) may be determined in coordinates from right and top.

Production

Returned Concrete Transactions

Returned concrete may be transferred to a different customer as is or after additional production.

Co New				Pi	repare Waybill For Other	Customer	Transfer Data
Referenc 🔻	Order No	•	Recipe	-	Customer -	Returned Amc -	Production An -
38		0	C35		KARTAL MUNICIPALITY	4,00	4,00
38		0	C35		KARTAL MUNICIPALITY	0,00	4,00
38		0	C35		KARTAL MUNICIPALITY	4,00	4,00
38		0	C35		KARTAL MUNICIPALITY	4,00	4,00

Clicking on "New" button, a new record is created. At the right part of the screen displayed, productions made in "returned concrete duration" defined in "Settings-Plant Information" are listed. Production in which returning transaction will be made is selected and "return" button is clicked on.

ransactions of Returne	🕅 Close					Retur	'n
Order No	0	Referenc 💌	Production •	Customer 💌	Worksite	▼ Truck	▼ Reci
Customer	KARTAL MUNICIPALITY 🚽	1	8,00	KARTAL MUNICI	THE COASTAI	P. 34 SUN 1445	C35
Vorksite	THE COASTAL PATH 👻						
Recipe	C35 👻						
roduction Amount	8,00 m3						
Invoice the Return	ed Amount to Previous Customer 4,00 m3						
etumied Amount							
		•				(•

Customer, worksite and recipe information if required may be changed at the left part. If related waybill is fully accepted and signed by previous customer, "Invoice the Returned Amount to Previous Customer" is selected. In this way an overproduction is generated as much as returned concrete amount. "Returned Amount" is entered and information is saved by clicking on "Save", screen is exited by clicking on "Close".

Note : New production amount is calculated by deducting "Returned amount" displayed on this screen from "Production amount". If recipe information is changed, program sets total amounts by increasing or decreasing materials for the future production in accordance with requested recipe.

📰 Transactio	ons of Returne	d Conc	rete				Σ
Rew			(🗾 Pr	epare Waybill For Othe	r Customer	Transfer Data 🖓
Referenc 🔻	Order No	•	Recipe	•	Customer	Returned Amc -	Production Arr -
38		0	C35		KARTAL MUNICIPALIT	Y 4,00	4,00

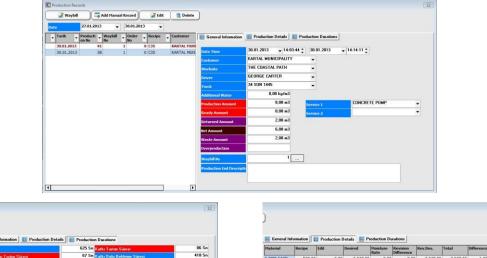
If required, the entire production defined as returned may be transferred to a different customer without making a new production. Thus clicking on "Prepare Waybill for Other Customer", "manual production screen" appears, information is arranged and recording and waybill transactions are carried out.

"Transfer Data" transaction is detailed in "Entries-Stock Entry". Screen is closed by clicking on red "X" in the top right-hand corner.

Production Records

Production Records

It is possible to display the information like "General Information", Production Details" and "Production Duration" and to make a modification in records and to correct and print waybill. Screen is closed by clicking on red "X" in the top right-hand corner.



Toplam Süre	625 Sn	Katkı Tartım Sürəsi	86 Sn
Agrega 1. Grup Tartim Süresi	67 Sn	Katkı Doly Bekleme Süresi	418 Sn
Agrega 1. Grup Boşaltını Süresi	0 Sn	Katkı Boşaltım Süresi	73 Sn
Agr 1. Grup Tartı Bandı Dolu Bek. Süresi	406 Sn	Boya Tartım Süresi	0 Sn
Agrega 2. Grup Tartım Süresi	0 Sn	Boya Dolu Bekleme Süreti	0 Sn
Agrega 2. Grup Bosaltes Süresi	0 Sn	Boya Boşaltını Süresi	0 Sn
Agrega 2. Grup Tarti Bandi Dolu Bek, Süresi	406 Sn	Kul Tartımı Süresi	0 Sn
Yükleme Bandı Boşta Calışma Süreşi	496 Sn	Kül Dolu Bekleme Süresi	0 Sn
Yükleme Bandı Agrega Taşıma Süresi	129 Sn	Kül Boşaltın Süresi	0 Sn
Biriktirme Bunk. Boşta Bek. Süresi	68 Sn	Buz Tartım Süresi	0 Sn
Biriktirme Bunk, Dolum Konum, Süresi	371 Sn	Buz Dolu Bekleme Süresi	0 Sn
Bisiktisme Bunk. Boşaltım Süresi	57 Sn	Buz Boşaltın Süresi	0 Sn
Cimento Tartun Sürezi	217 Sn		
Cimento Dolu Bekleme Süresi	197 Sn		
Çimento Boşaltını Süresi	172 Sn		
Su Tartım Sürezi	207 Sn		
Su Dolu Bekleme Süresi	254 Sn		
Su Boşaltın Süresi	137 Sn		

1,00 -4,00 3,00 11,00
3,00
11,00
0,00
0,00
0,00
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0,00

Buttons taking place at upper part;

Waybill of the production selected with "waybill" may be printed again.

Necessary information is entered on the screen opened by clicking on "Add Manual Record" and a new production record may be created. Information is saved by clicking on "Save" or screen is exited by clicking on "Close" without saving.

Save (Close	A CONTRACTOR OF
der	3	v2 🗤
istomer	KARTAL MUNICIPALITY	en 🛃
orksite	SCHOOL CONSTRUCTION	n 🛃
ecipe	C35 (S3)	ra 🚺
uck	34 SUN 1260	V 1
iver	THOMAS MORGAN	n 🛃
ervice 1	CONCRETE PUMP	V 1
ervice 2	CONCRETE PUMP	👽 🗤
ady Amount	0 m3	ra 🚺
x	12,00	
aybill No		
oduction End Descri	ption	

When "correct" button is clicked on, "Save" button is displayed. Requested information modification is made and saved by clicking on "Save".

Selected production record may be deleted by clicking on "Delete" button.

Any record is right clicked on, transaction menu is displayed.

<u>S</u> plit Waybill
Merge Waybill
Cancel the Waybill Merging
Print Production Detail
Private Transactions

Waybill Splitting

"Split Waybill" is selected on transaction menu and requested production record may be turned to many waybills.

	lew	🌽 Edit	📜 Delete				
Producti on No	Waybill No	Order	Customer	Worksite	Production Amount		
45	21		KARTAL MUNICIPALI	THE COASTAL PATH	12,00		
3					12,00		
Product	tion Amount	12,	00	😈 Database Update	•	🔯 Close	

In the opening window, "New" is clicked on. At the right part new waybill information to be created is displayed. After amount entry and modification of other information, they are saved by clicking on "Save" and right section is closed by clicking on "Cancel".

C 11								x
	lew (🔏 Edit	Delete					
Producti on No	Waybill No	Order	Customer	Worksite	Production Amount	Production No	46	
46	22		KARTAL MUNICIPALT	THE COASTAL PATH		₩aybill No	22	
45	21		KARTAL MUNICIPALI	THE COASTAL PATH	12,00	Order No		•
						Customer	KARTAL MUNICIPALITY	•
						Worksite	THE COASTAL PATH	•
						Truck	34 SUN 1445	•
						Driver	GEORGE CARTER	•
						Production Amount	5	
					12,00	Save	Cancel	
Product	ion Amount	12,0	0	🚺 Database Update		🔯 Close		

Clicking "Correct" and "Delete" buttons, it is possible to make modification on the records created. Information is saved by clicking on "Ok". Screen is "Closed" by clicking on "Close" without saving.

Merge Waybill/ Cancel

Clicking on "Merge Waybill" on transaction menu, selected production record is merged with another record. On the opening list other record to be merged is selected. Information is saved by clicking on "Ok", screen is exited by clicking on "Close" without saving.

Date 0	_	Producti	_	🔯 Close Waybill	Customer		Worksite	_	Recipe	_	Net
Date		on No		No -	Customer	•		•	Recipe	-	Amou
04.02.2013			4	1101	KARTAL MUNICIPALITY		SCHOOL CONSTRUC	TI	C35		10,0
4.02.2013			3	1101	KARTAL MUNICIPALITY		SCHOOL CONSTRUC	ст	C35		5,0

At the left part of the production record, "*" icon is displayed and "Combined Waybill Number" is displayed at the right part of screen.

P P	roduction Reci	ords											23
	🌌 Waybill		Add Manu	ual Record) 🖉 Edit	💼 🚺 Delete)						
Dat	e	27.01.201	3 -	30.01.	2013 👻								
-	Tarih 🗸	Producti .	- Waybill	- Order	Recipe	• Customer	🔲 General Information	E Production Details	📕 Prod	luction Durations]		
*	30.01.2013		15	21	0 C35	KARTAL MUN		00.01.0010	10.00 1	30.01.2013	45.00.00		
	30.01.2013		1	1	0 C35	KARTAL MUN	Date Time		19:22 🛟	30.01.2013	▼ 15:30:32 ⁺		
	30.01.2013	3	38	1	0 C35	KARTAL MUN	Customer	KARTAL MUNICIPALI	Y	-		25	
							Worksite	THE COASTAL PATH		Combin	ed Waybill Number	2.5	
							Driver	GEORGE CARTER		•			
							Truck	34 SUN 1445		-			
							Additional Water	0,00 kg/m3	8				
							Production Amount	19,00 m3		Service 1	CONCRETE PUMP		•
							Ready Amount	7,00 m3		Service 2			•
							Returned Amount	0,00 m3	•				
							Net Amount	12,00 m	1				
							Waste Amount	0,00 m3	8				
							Overproduction	0,00 m3	8				
							Waybill No	21					
							Production End Description						
							-						
1						Þ							

If required, selecting "Cancel the Waybill Merging" option, transaction may be cancelled.

<u>S</u> plit Waybill
Merge Waybill
Cancel the Waybill Merging
Print Production Detail
Private Transactions

Print Production Details

Selecting "Print Production Details" on transaction menu, detailed information may be sent to printer differently from waybill.

Detailed information includes "material name", corrections made on "recipe value", "moisture", "requested to be measured", "Requested as moisture revised", "total", "difference" columns and "Grand Totals" under columns.

			PROD	UCTION DET.	AIL			
Production No	3				Production Amount	5 m²		
Waybill No	1101				Oprerator	admin		
Date	04.02.2013				Truok	34 SUN 1259		
Time	14:07:41				Driver	GEORGE CA	RTER	
Customer	KARTAL MUNICI	PALITY			Reolpe	C35		
	THE COASTAL	PATH			Effect Class	22		
					Chlorine Content	XC3		
Worksite	SCHOOL CONS	TRUCTION			Consistency	53		
					W/C Volume	0,43		
	TUZLA	ISTAN	BUL		Service	CONCRETE	PUMP	
Material	Reolpe	Recipe	Moisture Rate	Desired	N Desired	Total	Differen	Fark (%
Agr 1	520 Kg	Kg	-0,03	2500 Kg	-	2594 Kg	-5 Kg	96 -0,19
Agr 2	580 Kg	Ka	-0,03	2900 Kg	2899 Kg	2894 Kg	-5 Kg	96-0,17
Agr 3	270 Kg	Ka		1350 Kg	1350 Kg	1347 Kg	-3 Kg	% -0,22
Agr 4	530 Kg	Kg	-0,03	2650 Kg	2649 Kg	2644 Kg	-5 Kg	96 -0,19
	Ka	Kg		Kg	Kg	Kg	Kg	95
	Ka	Kg		Kg	Kg	Ka	Kg	95
	Ka	Kg		Ka	Kg	Kg	Kg	96
	Ka	Ka		Ka	Ka	Kg	Ka	96
Clm 1	135 Kg	Ka		675 Kg	675 Kg	675 Kg	Kg	96
Clim 2	120 Kg	Kg		600 Kg	600 Kg	600 Kg	Kg	95
Clim 3	90 Kg	Ка		450 Kg	450 Kg	450 Kg	Ka	95
Clim 4	110 Kg	Ka		550 Kg	550 Kg	551 Kg	1 Kg	95 0,18
Su 1	120 Kg	Kg		600 Kg	600 Kg	600 Kg	Ka	95
Su 2	SO Kg	Ka		400 Kg	400 Kg	399 Kg	-1 Kg	95
Katki 1	1,5 Kg	Kg		7,5 Kg	7 Kg	S Kg	1 Kg	96 14,29
Katki 2	1,8 Kg	Ka		9 Kg	9 Kg	9 Kg	Ka	96
Katki 3	2 Kg	Kg		10 Kg	10 Kg	10 Kg	Ka	95 14,29
	Ка	Kg		Ka	Ka	Kg	Kg	96
Toplam	2560,3 Kg	0 Kg		12801,5 Kg	12798 Kg	12781 Kg	-17 Kg	

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

After requested design modifications, screen is closed by clicking on red "X" in the top right-hand corner. On exit, confirmation screen is displayed. Modifications are saved by clicking on "Yes", screen is exited by clicking on "No", design screen is switched back to by clicking on "Cancel"

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Page1					
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	L	URETI	A DETAYI		
Object inspector			-		
Page1: TfrPage 💌	Üretim No	j_UretimNo"]		[Rapor."Uretim_NetMiktar"] m ^e	
BottomMargin 0	İrsaliye No	IrsaliyeNo"]	Opreratör Kamvon	[Rapor."Uretim_Kullanici"] [Rapor."Kamyon Plaka"]	
ColumnGap 0 Columns 0	Tarih	"[Rapor."Uretim_Tarih"]] "Rapor."Uretim_BitisTarihi"]	Sürücü	[Rapor."Surucu AdiSoyadi"]	
Height 1069	Saat Müsteri	[Rapor. "Musteri Adi"]	Recete	[Rapor."ReceteAdi"]	
LeftMargin 0 ≡ OnBeforePrint (OnBef	hindgteri	[Rapor."Musteri Adr1"]	Eki Sınıfı	JRapor."Recete CEtki Sinifi"1	
Orientation poPortr		/usteri_VergiD"], /usteri_VergiN"]	Klor İçeriği	[Rapor."Recete Klor Icerioi"]	
PrintToPrevPa False RightMargin 0	Şantiye	[Rapor."Santiye Adi"]		[Rapor."Recete Kivam Sinifi"].	
Size A4	Junayo	[Rapor."Santiye Adr1"]	S/C Hacmi	JRapor."Recete SC Hacmi"1	
StretchToPrint False +		[Rapor."Santiye_Ilce"] [Rapor."Santiye_Se	hir"]	JRapor."Hizmet1"1	=
🛅 DataModule1.Ado_Kullanic 🔺	"Malzeme Adi2"	ecete Aar2"1Ka Duz Aar2"1Ka Nem Aar2"1;ener	Aar2"1 Ka [°] enen Aar2"1 K	o plam Agr2" Kg "Fark Agr2" Kg	
DataModule1 Ado, StobD. DataModule1 Ado, TesisBi DataModule1 Ado, UretimC Form_Ana.Ado, Degisilk Form_Ana.Ado, Degisilk Form_Ana.Ado, Sibahi Form_Ana.Ado, Sibahi Form_Ana.Ado, Sibahi Form_Ana.Ado, Toplan Form_Ana.Ado, Toplan Form_Ana.Ado, Toplan	Malzeme_Adi3" Malzeme_Adi4" Malzeme_Adi10" Malzeme_Adi10" Malzeme_Adi11" Malzeme_Adi15" Malzeme_Adi16"	ete_Cim21Kg_uz_Cim21Kgnen, sete_Cim31Kg_uz_Cim31Kgnen, scete_Su11Kg_Uz_Su11Kgtener ete_Katki11Kg_uz_Katki11Kgnen	_Agr37 Kg enen_Agr37 K _Agr47 Kg enen_Agr47 K _Cim17 Kg nen_Cim17 K _Cim27 Kg nen_Cim27 K _Cim37 Kg nen_Cim37 K _Su17 Kg en_Cim37 K LSu17 Kg en_Katki17 K	gʻplam_Agr31Kg gʻplam_Agr41Kg gʻlam_Cim11Kg gʻlam_Cim11Kg gʻlam_Cim21Kg gʻlam_Cim21Kg gʻlam_Cim21Kg gʻplam_Su11Kg gʻplam_Su11Kg gʻam_Katkr11Kg ark_Katkr11Kg	
DataModule1 Ado_StokDu DataModule1 Ado_TexisBi DataModule1 Ado_UretimC Form_AnaAdo_Degisilk Form_AnaAdo_Ilade Form_AnaAdo_Mesaj Form_AnaAdo_Mesaj Form_AnaAdo_Siparis Form_AnaAdo_Toplam	Malzeme_Adi3 Malzeme_Adi4 Malzeme_Adi47 Malzeme_Adi107 Malzeme_Adi107 Malzeme_Adi117 Malzeme_Adi119 Malzeme_Adi197	cete_Agr31 Kg Duz_Agr31 Kg Nem_Agr31 ener cete_Agr41 Kg Duz_Agr41 Kg Nem_Agr31 ener sete_Cim11 Kg Duz_Cim11 Kg sete_Cim21 Kg Duz_Cim31 Kg sete_Cim31 Kg Duz_Cim31 Kg ecete_Su11 Kg Duz_Su11 Kg ecete_Katkl11 Kg uz_Katkl11 Kg ete_Katkl21 Kg uz_Katkl21 Kg ete_Katkl21 Kg uz_Katkl21 Kg ete_Katkl21 Kg uz_Katkl21 Kg ete_Katkl21 Kg uz_Katkl21 Kg ete_Katkl21 Kg uz_Katkl21 Kg	_Agr31 Kg enen_Agr31 K _Agr41 Kg enen_Agr41 K Cim11 Kg nen_Cim11 K Cim21 Kg nen_Cim21 K Cim31 Kg nen_Cim31 K _Su11 Kg tenen_Su11 K Katk111 Kg en_Katk11 K Katk111 Kg en_Katk11 K	gʻplam_Agr31KgʻFark_Agr31Kg gʻplam_Agr41KgʻFark_Agr41Kg gʻlam_Cim11Kgʻark_Cim11Kgʻ gʻlam_Cim21Kgʻark_Cim21Kgʻ gʻlam_Cim21Kgʻark_Cim21Kgʻ gʻlam_Cim31Kgʻark_Cim31Kgʻ	

Faults

It is the screen on which faults in system may be monitored and solved. Screen is made up of two parts.

Permanent Faults

Nonpermanent Faults

Faults		<u></u>
Permanent Faults	Nonpermanent Faults	•

Permanent Faults

Faults in this part are the faults which should be solved by user by removing reason of fault after occurring in production. To solve any fault in the part of Permanent Faults it should be selected by clicking with mouse and then "Solve the Fault" button should be clicked on.

Nonpermanent Faults

In the part of nonpermanent faults, the faults solved automatically without need to user intervention after removing the reason of fault are listed.

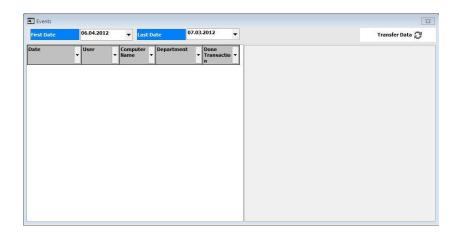
Monitoring

Events

Events realized in system, faults may be displayed on date and user basis.

Changing "First Date" and "Last Date" at the upper part it is possible to list certain date range.

List may be saved with "Transfer Data" feature. "Transfer Data" transaction is detailed in "Entries-Stock Entry" part.



Monitoring

PLC Inputs/Outputs

At the left part of screen there are input signals and at right part of screen output signals are available. Active signals are shown in red italic font.

Reg Name	 Input 	-	Reg Name	Output	
18820F	Intermediate bin 2 discharging door closed		QKT2KLAC	Open Additive bin discharging valve	
ICM2OK	Cement screw conveyor 2 is running		QKVUPST	Start Skip up	2
ICM4OK	Cement screw conveyor 4 is running		QKVDNST	Start Skp bottom	
ICMIMAX	Cement silo 1 full		QMX1VST	Start Moxer chute vibrator	
ICM2NIN	Cement silo 2 empty		QKT6ST	Start Additive 6 pump	
ICM4MIN	Cement silo 4 empty		QAG11AC	Open Aggregate 1 door 1	
ICM4MAX	Cement silo 4 full		QAG12AC	Open Aggregate 1 door 2	
ICM5MIN	Cement silo 5 empty		QAG21AC	Open Aggregate 2 door 1	3
IMX1UCGN	Mixer delta		QAG22AC	Open Aggregate 2 door 2	
IMX12OF	Mixer discharging door 2 closed		QAG31AC	Open Aggregate 3 door 1	
IKVARA	Skip wait position		QAG32AC	Open Aggregate 3 door 2	
ITEST	Test mode active		QAG41AC	Open Aggregate 4 door 1	
STEST	Simulation mode active		QAG42AC	Open Aggregate 4 door 2	
ISYS2SEC	System 2 selection		QAG51AC	Open Aggregate 5 door 1	
IMX220F	Mixer 2 discharging door 2 closed		QAG52AC	Open Aggregate 5 door 2	
IWB10K	Weighing belt is running		QAG61AC	Open Aggregate 6 door 1	
ISYSOK	System ready		QAG62AC	Open Aggregate 6 door 2	
IOTOMOD	System in automatic mode		QAG71AC	Open Aggregate 7 door 1	
IMANMOD	System in manual mode		QAG72AC	Open Aggregate 7 door 2	
IWB2OK	Weighing belt 2 is running		QAG81AC	Open Aggregate 8 door 1	
IBESLOK	Transfer belt is running		QAG82AC	Open Aggregate 8 door 2	
IBBON	Intermediate bin discharging door opened		QAG1VST	Start Aggregate 1 vibrator	
IBBOF	Intermediate bin discharging door closed		QAG2VST	Start Aggregate 2 vibrator	
ICM1 OK	Cement screw conveyor 1 is running		QAG3VST	Start Aggregate 3 vibrator	
ICM3OK	Cement screw conveyor 3 is running		QAG4VST	Start Aggregate 4 vibrator	
ICM50K	Cement screw conveyor 5 is running		QAG5VST	Start Aggregate 5 vbrator	
ICM6OK	Cement screw conveyor 6 is running		QAG6VST	Start Aggregate 6 vibrator	
ICM1MIN	Cement slo 1 empty		QAG7VST	Start Aggregate 7 vibrator	3
ICM2MAX	Cement slo 2 full		QAG8VST	Start Aggregate 8 vibrator	
ICM3MIN	Cement slo 3 empty		QWB1ST	Start Weighing belt	

Delivery Report

Changing "First Date" and "Last Date" at the upper part, productions made may be listed between two dates and sent to Printer by clicking on "Print".

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

						\sim		Print			Transfer D	^{ata} 📿		
roduction Time	e		Date 🗸	Order No 🚽 Ty	p - Waybill No		+ Worksite	+ Plate +	Driver 🚽	Production	Ready	- Returned	+ Ne	et mount
irst Date	12.09.2012	-	30.12.2012	0 0		1 KARTAL HI C35	THE COASTAL PA	TH 34 SUN 2		10,0		0,00		10,0
rst bate	- And Base and a		30.12.2012	0 0		1 AKER MÜHI C25	AKASYA MAH.	34 SUN	EROL GÜN	10,0	0 0	,00		10,0
	00:00:00	¢	29.12.2012	0 0		1 AKER MÜHI C25	AKASYA MAH.	34 SUN	ADEM AKK	2,0	0 3	,00		5,0
ast Date	01.01.2013	-	29.12.2012	0 0		1 AKER MÜHI C25	AKASYA MAH.	34 SUN	ADEM AKK	5,0	0 0	,00	3,00	2,0
ist Date			29.12.2012			1 KARTAL MI C35	THE COASTAL P	AT 34 SUN	EROL GÜN	8,0		,00		8,0
	23:59:59	‡	29.12.2012			1 KARTAL MI C35	THE COASTAL P			8,0		,00		8,0
			28.12.2012	0 0		1 KARTAL MI C30	THE COASTAL P	AT 34 SUN	ADEM AKK	12,0	0 0	,00		12,0
✓ All Plants														
										55.0	3	.00	3.00	55,1

(All) (Custom...) AKER MÜHENDİSLİK KARTAL MINICIPALIYA

KARTAL MUNICIPALITY Using filtering feature in column heads, it is possible to display one record or all records.

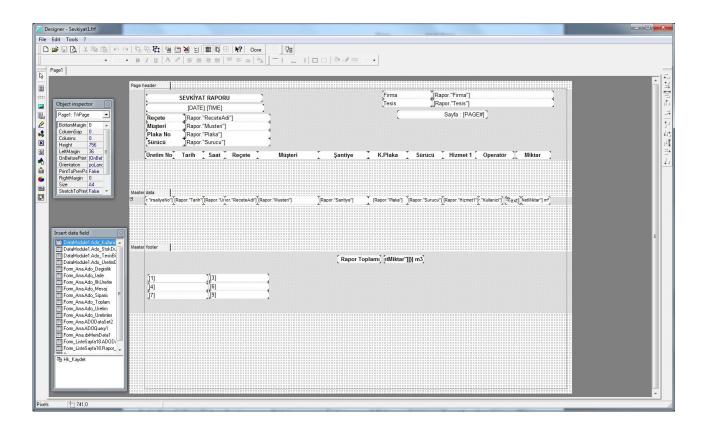
												Print			mansi	er Data 🛔	
roduction Time			Date 🚽	Order No	Typ -	Waybill No	- Cust	itom 🚽	Recipe	•	Worksite	▼ PI	ate 🗸	Driver	+ Prod	uction	•
rst Date	09.02.2012	-	30.12.2012		0 0			ER MÜHI			AKASYA MAH.			EROL G			0,00
	00:00:00		29.12.2012		0 0			R MÜHI			AKASYA MAH.			ADEM A			2,00
		÷	29.12.2012		0 0	10	1 AKE	er mühi	C25	-	AKASYA MAH.	34	SUN :	ADEM A	KK		5,00
st Date	30.01.2013	-															
	23:59:59	÷															
pe of Plant																	
All Plants																	

Totals are available on screen and at the bottom of printer form.

	SEVKIY/	T RAPO	RU			Firma		ak Beton			
	17.04.20	12 16:41:	32			Tesis	Söl	(e			
								Sayfa :	1		
Üretim No	Tarih	Saat	Reçete	Müşteri	Şantiye	K.Plaka	Sürücü	Hizmet 1	Operatör		Miktar
295543	02.14.2012	12:33:35	C 25/30	AS ADO HAZIR BETON SAN.	and an an an an an an an an an an an an an	09 EL 835	ADEM MERT	SANTRAL ALTI	Proksis	М	14,50 m ³
295542	02.14.2012	12:33:12	C 20/25	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTI	09 EL 912	AZİZ ÇETİN	POMPA 1(38 LİK;	Proksis	М	8,00 m ³
295540	02.14.2012	12:30:42	C 20/25	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTI	09 EL 627	HAKİM GÜNEY	POMPA 1(38 LIK	Proksis	М	8,00 m ³
295539	02.14.2012	11:07:14	C 25/30	AS ADO HAZIR BETON SAN.	AS ADO HAZIR BETON/	09 EL 816	SAİT YUNUSOĞL	TRANSMIXER	Santral		12,00 m ³
295538	02.14.2012	10:47:06	C 25/30	AS ADO HAZIR BETON SAN.	AS ADO HAZIR BETON/	09 EP 712	GÜRSEL ÇELİK	TRANSMIXER	Santral		12,00 m ³
295537	02.14.2012	10: <mark>35:0</mark> 2	C 20/25	SÜZGEÇ YAPI İNŞ.LTD.ŞTİ		09 EL 874	ZAFER DAĞCI	TRANSMIXER	Santral		2,00 m ³
295536	02.14.2012	10:26:15	C 25/30	AS ADO HAZIR BETON SAN.		09 EL 873	BAYRAM ALI YE		Santral		10,00 m ³
295535	02.14.2012			ASLANHAN YAPI MAL.LTD.Ş		09 EL 586		Pompa 1(38 Lik;	Santral		6,00 m ³
295534	02.14.2012	10:03:21	C 25/30	AS ADO HAZIR BETON SAN.I		09 EL 835	ADEM MERT	TRANSMIXER	Santral		11,00 m ³
295533	02.14.2012	09:33:17		ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ KAV	09 EL 926		POMPA 2(43 lūk)	Santral		12,00 m ³
295532	02.14.2012	09:20:36	C 25/30	MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	09 EL 627	HAKİM GÜNEY	TRANSMIXER	Santral		9,00 m ³
295531	02.14.2012	09:06:22	C 25/30	AS ADO HAZIR BETON SAN.I		09 EL 816	SAİT YUNUSOĞL		Santral		11,00 m ³
295530	02.14.2012			ASLANHAN YAPI MAL.LTD.Ş		09 EL 874		POMPA 1(38 LIK)	Santral		10,00 m ³
295529	02.14.2012	08:43:18	C 25/30	AS ADO HAZIR BETON SAN.I		09 EP 712	GÜRSEL ÇELİK	TRANSMIXER	Santral		11,00 m ³
295528	02.14.2012	08:26:01	C 25/30	MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ KAĞAN İNS/FAHRİ KAV	09 EL 846 09 EL 586	MEHMET AKTAŞ		Santral		11,00 m ³
295527 295526	02.14.2012	08:08:36 07:52:25	C 35/45 BRUT C 25/30	ÇENGEL TİCARET MUZAFFER SARIBAS	MUZAFFER SARIBAS	09 EL 586 09 EL 926	M.EMÍN AYTEKÍN	POMPA 2(43 lük)	Santral Santral		12,00 m ³ 11,00 m ³
295526	02.14.2012			CENGEL TICARET	MEHMET EDIZ/DAVUTLA	09 EL 926		POMPA 1(38 LIK)			7,00 m ³
293323	02.14.2012	07.55.40	C 23/30 DOR01	GENGLE HCARET	Rapor Topla			POMPA I(30 EIK,	Januar		7,00 11
POMPA		39									
POMPA 2		24									
SANTRAL	ALTI	24,5									

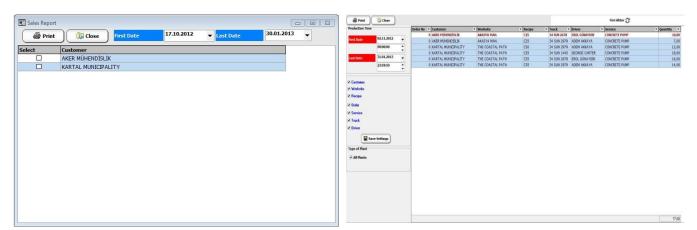
Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.



Sales Report-1

Sales may be printed in accordance with the criteria like "customer", "worksite", "recipe" and "service". Changing "First Date" and "Last Date" at the upper part, listing is made between two dates and sent to printer by clicking on "Print".



Screen is closed by clicking on red "X" in the top right-hand

corner.

Many customers may be selected by checking "Select" boxes. When right clicked on column head, "Select All" and "Remove All" options are displayed.

Şirket	Irmak Beton	MÜŞTERİ SATI	·····		
Tesis	Söke				
Rapor Başlangıç Tarihi	14.02.2012				
Rapor Bitiş Tarihi	14.02.2012				
Müşteri	ASLANHAN Y	YAPI MAL.LTD.Ş	Tİ		
Şantiye	SADIK DEMİR	CAN/DAVUTLAR	2		
-0000-03000	DAVUTLAR ÇI	IKIŞI AYTEMİZ F	PETROL KARŞ	ISI	
Teslim Şekli	POMPA 1(38	LİK)			
Üretim Tarihi	Îrsaliye No	Ürün	Miktar (m3)		
14.02.2012 08:55:42	295530	C 30/37 BÜRÜ	Г	10	
14.02.2012 10:14:33	295535	C 30/37 BÜRÜ	т	6	
Toplam :16 m3					

Report Design

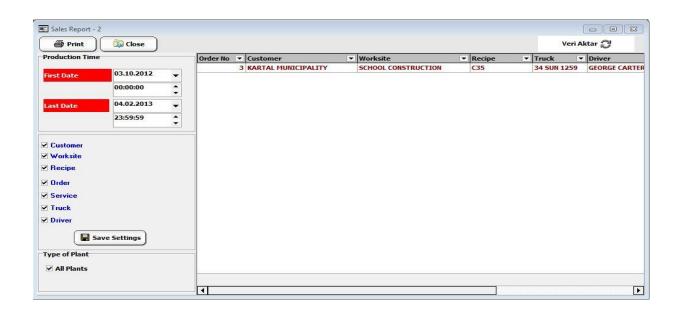
When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Sales Report-2

Sales may be printed in accordance with the criteria like "customer", "worksite", "recipe", "order", "service", "truck" and "driver". Changing "First Date" and "Last Date" at the upper part, listing is made between two dates and sent to printer by clicking on "Print".

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.



(All) [Custom...] AS ADD HAZIR BETON SAN.NAK.TİÇ.AŞ ASLANHAN YAPI MALLTD.ŞTİ MUZAFFER SARIBAŞ SÜZBEÇ YAPI İNŞ.LTD.ŞTİ ÇENGEL TİCARET

Using filtering feature in column heads, it is possible to display one record or all records

With the options at the left part, listing criteria is determined. Frequently used options may be saved by clicking on "Save Settings".

Söke			
	Satış Raporu		
Baş. Tarih : 14.02.2012			
Son Tarih : 14.02.2012			
Müşteri	Şantiye	Reçete	Miktar
CENGEL TICARET	KAĞAN İNŞ/FAHRİ	C 35/45 BRÜT	12 m ^s
CENGEL TICARET	KAĞAN İNŞ/FAHRİ	C 35/45 BRÜT	12 m³
ÇENGEL TİCARET	MEHMET EDÍZ/DAVUTLAR	C 25/30	7 m ^s
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	9 m ^s
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	11 m ^s
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	11 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	23 m ^s
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	23 m ^s
ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMIRCAN/DAVUTLAR	C 30/37	6 m ^s
ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMİRCAN/DAVUTLAR	C 30/37	10 m ^s
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	14,5 m ^s
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	10 m ^s
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	11 m ^s
SÜZGEÇ YAPI İNŞ LTD.ŞTİ	SÜZGEÇ YAPI İNŞ/KUŞADASI	C 20/25	2 m ^s
ÇENGEL TİCARET	MURAT YÖNEL/DAVUTLAR	C 20/25	8 m ^s
CENGEL TICARET	MURAT YÖNEL/DAVUTLAR	C 20/25	8 m ^s

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Stock Report

Instantaneous stock status, detailed stock entries and stock entries on daily basis may be displayed and printed.

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

Material	-	Remaining 🔹	Unit		
0-3MM SAND		10.870,45	kg		
1. GRAVEL		40.056,50	kg		
2. GRAVEL		50.733,04	kg		
SAND		7.078,79	kg		
Cem 1		1.487,04	kg		
Cem 2		30.261,90	kg		
Cem 3		54.000,00	kg		
Cem 4		47.000,00	kg		
water 1		1.529,56	kg		
water 2		8.500,00	kg		L
Additive 1		9.371,28	kg		
Additive 2		7.600,00	kg		
First Date 01.01.2013 👻	(🖨 Detailed Stock E	intries)	
Last Date 31.01.2013 -	ſ	🖨 Daily Stock En	tries	ĥ	

Clicking on "Stock Status" button, instantaneous stock status may be sent to printer.

	NCRETE	01.02.201
Tesis INDUST	RIAL ZONE	15:07:0
	STOK DURUMU	
Malzeme	Miktar (Kg)	
0-3MM SAND	10.870,45	
1. GRAVEL	40.056,50	
2. GRAVEL	50.733,04	
SAND	7.078,79	
Cem 1	1.487,04	
Cem 2	30.261,90	
Cem 3	54.000,00	
Cem 4	47.000,00	
water 1	1.529,56	
water 2	8.500,00	
Additive 1	9.371,28	
Additive 2	7.600,00	
Additive 3	4.800,00	

Setting date range at the subpart and clicking on "Detailed Stock Entries" button, detailed stock movement may be monitored and printed for each material.

İşlem Tarihi	Açıklama	Giren Mik.	Çıkan Mik.
13.02.2012 07:23:30	Üretim	0,00	3.244,00
13.02.2012 07:39:02	Üretim	0,00	3.238,00
13.02.2012 07:59:29	Üretim	0,00	3.240,00
13.02.2012 08:11:58	Üretim	0,00	3.240,00
13.02.2012 08:21:15	Üretim	0,00	2.705,00
13.02.2012 08:32:23	Üretim	0,00	3.238,00
13.02.2012 08:40:44	Üretim	0,00	2.692,00
13.02.2012 08:55:03	Üretim	0,00	3.241,00
13.02.2012 09:09:30	Üretim	0,00	2.708,00
13.02.2012 09:18:03	Üretim	0,00	3.242,00
13.02.2012 09:26:57	Üretim	0,00	3.236,00
13.02.2012 09:38:14	Üretim	0,00	3.240,00
		0,00	37.264,00
	Rapor Sonu	1	8.685,00 Kg

Setting date range at the

L

subpart and clicking on

"Stock Entries on Daily Basis" button, detailed stock movement may be monitored and printed for each material.

Firma	Irmak E	Beton	Başlangıç Tarihi : 14.02.2012	17.04.20
Tesis	Söke		Bitiş Tarihi : 14.02.2012	16:59:
		İKİ TARİH	ARASI STOK RAPORU	
Malzeme	5/15			
		Önceden Devir	-825.591,00	
İşlem Taril	hi	Açıklama	Giren Mik. Çıkan Mik.	
14.02.2012		Çıkış	0,00 82.957,00	
		22	0,00 82.957,00	
		Rapor Sonu	-908.548,00 Kg	
Malzeme	05			
		Önceden Devir	-2.297.156,00	
İşlem Taril		Açıklama	Giren Mik. Çıkan Mik.	
14.02.2012	1	Çıkış	0,00 168.762,00	
			0,00 168.762,00	
		Rapor Sonu	-2.465.918,00 Kg	
Malzeme	15/25			
		Önceden Devir	-1.235.423,00	
İşlem Taril	hi	Açıklama	Giren Mik. Çıkan Mik.	
14.02.2012		Çıkış	0,00 70.426,00	
		0000 0.0	0,00 70.426,00	
		Rapor Sonu	-1.305.849,00 Kg	
Malzeme	Cim 1			
		Önceden Devir	45.248,00	
İşlem Taril	hi	Açıklama	Giren Mik. Çıkan Mik.	
14.02.2012		Çıkış	0,00 48.115,00	
			0,00 48.115,00	
		Rapor Sonu	-2.867,00 Kg	

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Consumed Material Report (On Silo Basis)

Changing "First Date" and "Last Date" at the upper part, consumed materials for productions made may be listed by clicking on "Prepare Report" and sent to Printer in two different reports; "Report1" and "Report2".

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

roduction Tim												Trans	fer Data 🤁		
	e			▼ Waybill N ▼				▼ Registe				0-3MM SANE			SAND
			04.02.2013	110		53	C35		34 SUN 125		CONCRETE P		5.812	-	
rst Date	04.02.2013	-	04.02.2013	110	1 3	S3	C35		34 SUN 125	9 5,00	CONCRETE	2.594	2.894	1.347	2.644
	00:00:00	÷													
st Date	04.02.2013	•													
	23:59:59	•													
		•													

With "Report1", consumed material report is displayed and printed in accordance with silo sequence including materials.

Even though there is same material in different silos, consumed amounts are shown in different columns.

HARCANAN	MALZEME RAP	ORU			Firma Tesis	Irmak E Söke	Beton								
Başlama Tar	ihi : 14.02.2012														
Bitiş Tarihi	: 14.02.2012														
Üretim No	Írsaliye No	Reçete	Hizmet	Agr1	Agr2	Agr3	Agr4	Cim1	Cim2	Cim3	Su1	Katki1	Katkı 2	Katkı 3	Mik (m ^s
5036	295543	C 25/30	SANTRAL ALTI	6825	7250	7250	6710	4300			2430	33,00	17,95		14,50 r
5035	295542	C 20/25	POMPA 1(38	2880	4240	4240	4720	1800			1440	18,00			8,00 r
5033	295540	C 20/25	POMPA 1(38	2880	4240	4240	4720	1800			1440	18,00			6,00 1
5032	295539	C 25/30	TRANSMIXER	4211	5888	5989	7346	3239			2101	36,00			12,00
5031	295538	C 25/30	TRANSMIXER	4205	6015	6000	7325	3242			2100	36,00			12,00
5030	295537	C 20/25	TRANSMIXER	736	1071	1072	1167	446			370	5,00			2,00
5029	295536	C 25/30	SANTRAL ALTI	3507	4983	4987	6126	2701			1780	30,00			10,00
5028	295535	C 30/37 BÜRÜT	POMPA 1(38	4916	3179	3198		1921			959		23,00		6,00
5027	295534	C 25/30	TRANSMIXER	3858	5473	5514	6692	2968			1915	33,00			11,00
5026	295533	C 35/45 BRÜT	POMPA 2(43 lük)	10209	6003	5988		4559	j j		1933		62,00		12,00
5025	295532	C 25/30	TRANSMIXER	2560	3671	3703	4510	1988			1179	22,09			9,00
5024	295531	C 25/30	TRANSMIXER	3850	5508	5481	6700	2980			1819	33,00			11,00
5023	295530	C 30/37 BÜRÜT	POMPA 1(38	8177	5309	5220		3196			1573		38,00		10,00
5022	295529	C 25/30	TRANSMIXER	3853	5491	5446	6685	2966			1764	33,00			11,00
5021	295528	C 25/30	TRANSMIXER	3855	5498	5426	6712	2991			1803	33,00			11,00
5020	295527	C 35/45 BRÜT	POMPA 2(43 lük)	10193	6004	5983		4560			1884	-	62,00		12,00
5019	295526	C 25/30	TRANSMIXER	3865	5489	5347	6710	2967			1870	33,00			11,00
5018	295525	C 25/30 BÜRÜT	POMPA 1(38	5657	3914	3802		2029			1237	20,00			7,00
			Toplamlar	86.237	89.226	88.886	76.123	50.653	0	0	29.597	383	203	0	175,50
			Kg / m3	491	508	506	434	289			169	2,18	1,16	0,00	
			Su / Çim Oranı				L	0,58			·				

With "Report2", consumed material report is displayed and sent to printer in accordance with silo sequence including materials. Furthermore "Stock Status Report" is displayed on last page.

HARCA	NAN MAL	ZEME RAPOR	U			Firma Fesis	Irmak B Söke	eton									Firma Tesis	Irmak Beton Söke		17.04.20
Başlam	a Tarihi : 14	4.02.2012																	STOK DURUMU	
Bitiş Ta Üretim		1.02.2012 Tarih Saat	Recete	Hizmet	Agr1	Aar2	Agr3	Agr4	Cim1	Cim2	Cim3	Su1	Katki1	Katki 2	Katio 3	Mik (m ^a)	Malzeme 05 15/25	Miktar (Kg) -2.486.107,00 -1.318.749,00		
5035	295542	14.02.2012 12:33:12	C 20/25	POMPA 1(38 LIK)	2880	4240		4720	1800			1440				8,00 mª	5/15	-915.998,00 Kg		
5033	295540		C 20/25	POMPA 1(38 LIK)	2880	4240	4240	4720	1800			1440	18,00			6,00 mª	Cim 1 Cim 2	-9.247,00 Kg 55.949,00 Kg		
5028	295535	14.02.2012	C 30/37 BÜRÜT		4916	3179	3198		1921			959		23,00		6,00 m*	Cim 3	60.941,00 Kg		
5023	295530	14.02.2012 08:55:42	C 30/37 BÚRÚT	POMPA 1(38 LIK)	8177	5309	5220		3196			1573		38,00		10,00 m ^s	Su 1 Antifiriz	-396.887,00 Kg 0.00 Kg		
5018	295525		C 25/30 BÚRÚT	POMPA 1(38 LIK)	5657	3914	3802		2029			1237	20,00			7,00 m²	Katki 1S	6.611,47 Kg		
				Toplamlar	24.510	20.882	20.700	9.440	10.746	0	0	6.649	56	61	0	37,00 m*	Katki 2H	6.661,96 Kg		
			1	Kg / m3	628	535	531	242	276			170	1,51	1,65	0.00					
			F	Su / Çim Oranı					0,62											

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Consumed Material Report (On Material Basis)

Changing "First Date" and "Last Date" at the upper part, consumed materials for productions made may be listed by clicking on "Prepare Report" and sent to Printer by clicking on "Print" button.

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

Report is displayed and sent to printer in accordance with material types. If different silos include same material, consumed materials are shown in a common column.

duction Time st Date 16.1					Waybill No 🔻	Recipe	Service	▼ Produce ▼	Ouant -	0-3MM 5/ -	1. GRAVEL -	2. GRAVEL -	SAND -	Cem 1 🔻	Cem 3 🔻	-
st Date 16.1			28.12.2012	2		C30	CONCRETE PUMP	12	12,00	6.186,00	7.010,00	3.368,00	6.211,00	2.400,00		-
	10.2012	-	29.12.2012	6	1	C35	CONCRETE PUMP	8	8,00	4.066,00	2.794,00	2.245,00	4.390,00	2.000,00		
00:0	00:00	•	29.12.2012	11	1	C35	CONCRETE PUMP	8	8,00	4.041,00	2.794,00	2.220,00	4.390,00	1.999,00		
		•	29.12.2012	12	1	C25	CONCRETE PUMP	5	2,00	2.519,00	1.696,00	2.021,00	2.544,00	999,00		
st Date 30.0	01.2013	-	29.12.2012	13	1	C25	CONCRETE PUMP	2	5,00	2.509,00	1.691,00	2.035,00	2.549,00	998,00		
73.4	59:59		30.12.2012	16	1	C25	CONCRETE PUMP	10	10,00	5.089,00	3.393,00	4.091,00	5.089,00	2.000,00		
2.01		•	30.12.2012	20	1	C35	CONCRETE PUMP	10	10,00	5.089,00	3.517,00	2.794,00	5.513,00	2.500,00		
			30.01.2013	38	1	C35	CONCRETE PUMP	8	4,00	4.066,00	2.794,00	2.245,00	4.415,00	2.000,00	0,00	0
			30.01.2013	41	1	C35	CONCRETE PUMP	8	6,00	4.066,00	2.794,00	2.245,00	4.415,00	2.000,00	0,00	0
			30.01.2013	45	21	C35	CONCRETE PUMP	19	12,00							
			01.02.2013	51	25	C35	CONCRETE PUMP	4	8,00	4.054,00	2.794,00	2.245,00	4.402,00	1.999,00	0,00	0

HARCANAN MALZEME RAPORU

Başlama Tarihi : 03 10 2012 Bitiş Tarihi : 01 02 2013 Firma SUN CONCRETE Tesis INDUSTRIAL ZONE

Üretim No	Irsaliye No	Reçete	Hizmet	Miktar (m ^s)	0-3MM	1.	2.	SAND	Cem 1	Cem 2	Cem 3	Cem 4
2	1	C30	CONCRETE	12	6186	7010	3368	6211	2400	1259		0
6	1	C35	CONCRETE	8	4066	2794	2245	4390	2000	800		
11	1	C35	CONCRETE	8	4041	2794	2220	4390	1999	800		10 10
12	1	C25	CONCRETE	5	2519	1696	2021	2544	999	599		
13	1	C25	CONCRETE	2	2509	1691	2035	2549	998	599		90 90
16	1	C25	CONCRETE	10	5089	3393	4091	5089	2000	1199		
20	1	C35	CONCRETE	10	5089	3517	2794	5513	2500	999		10 10
38	1	C35	CONCRETE	8	4066	2794	2245	4415	2000	800		
41	1	C35	CONCRETE	8	4066	2794	2245	4415	2000	800		90 90
45	21	C35	CONCRETE	19	12							
51	25	C35	CONCRETE	4	4054	2794	2245	4402	1999	799		10 10
		4		Toplamlar	41.685	31.277	25.509	43.918	18.895	8.654	0,00	(
				Kg / m3	490	490	300	517	222	102	0,00	(

ARCANAN M	ALZEME RAPO	RU			Firma Irma	ik Beton						
aşlama Tarihi	: 17.04.2012				Tesis Sök	e						
litiş Tarihi	: 17.04.2012											
Üretim No	Írsaliye No	Reçete	Hizmet	Miktar	(m²) 5/15	05	15/25	Cim 1	Cim 2	Cim 3	Su 1	Katkı 1S
		Reçete C 35/45	Hizmet POMPA 2(43			05 9200	15/25 6200	Cim 1 3400	Cim 2	Cim 3	Su 1 1550,00	
Üretim No 5037					3600				Cim 2	Cim 3		

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Consumed Material Report (Real)

Changing "First Date" and "Last Date" at the upper part, consumed materials for productions made may be listed by clicking on "Prepare Report" and sent to Printer by clicking on "Print".

Note: Differently from other material reports, manual quantity changes are not taken into consideration in production records, reel consumed materials are reported.

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

Report is displayed and sent to printer in accordance with material types. If different silos include same material, consumed materials are shown in a common column.

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Consumed Material Amount

Consumed Material Amount may be listed and printed in accordance with the criteria like "customer", "worksite", "recipe", "service", "truck" and "driver". Changing "First Date" and "Last Date" at the upper part, listing is made between two dates and sent to printer by clicking on "Print".

With the "Data Transfer" feature, list may be saved in a different way. "Data Transfer" transaction is detailed in "Entries- Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

Print	Close										Transfer Data 💭	£	
Production Time			Order No			Recipe			Quantity -		Agr 2		Agr 4
and the second se	03.09.2012	-		0 AKER MÜHENDİSLİK		C25	CONCRETE PUMP		10,00 m ²	5.089 Kg			
First Date				0 AKER MÜHENDISLİK		C25	CONCRETE PUMP			3.516 Kg			
	00:00:00	\$		0 KARTAL MUNICIPALI			CONCRETE PUMP			6.186 Kg			
	30.01.2013	-		0 KARTAL MUNICIPALI			CONCRETE PUMP			12.179 Kg			
ast Date		12.00		0 KARTAL MUNICIPALI			CONCRETE PUMP			8.107 Kg			
	23:59:59	\$		0 KARTAL MUNICIPALI	THE COASTAL F	P/ C35	CONCRETE PUMP	34 SUN 2979	14,00 m 3	5.089 Kg	3.517 Kg	2.794 Kg	5.513 K
Customer Worksite Recipe Order													
Worksite Recipe Order Service Truck Driver	ive Settings												

(All) (Custom...) AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ ASLANHAN YAPI MALLITD.ŞTİ MUZAFFER SARIBAŞ SÜZBEÇ YAPI INŞ.LTD.ŞTİ ÇENGEL TİCARET

Using filtering feature in column heads, it is possible to display one record or all records.

With the options at the left part, listing criteria is determined. Frequently used options may be saved by clicking on "Save Settings".

	NCRETE RIAL ZONE							Baş. Bit. T		:03 07 2 :30 01 2			
Müşteri	Şantiye	Reçete	Üretim Mik.	Agr 1	Agr 2	Agr 3	Agr 4	Cem 1	Cem 2	Cem 3	water 1	Additive	Additive 2
AKER MÜHENDİSLİK	AKASYA MAH.	C25	10,00	5.089	3.393	4.091	5.089	2.000	1.199	0	1.430	35,00	0,00
AKER MÜHENDİSLİK	AKASYA MAH.	C25	7,00	3.516	2.369	2.843	3.566	1.397	838	0	999	24,00	0,00
KARTAL MUNICIPALITY	THE COASTAL PATH	C30	12,00	6.186	7.010	3.368	6.211	2.400	1.259	0	1.896	60,00	0,00
KARTAL MUNICIPALITY	THE COASTAL PATH	C35	18,00	12.179	8.419	6.735	13.227	6.000	2.401	0	3.552	108,00	0,00
KARTAL MUNICIPALITY	THE COASTAL PATH	C35	16,00	8.107	5.588	4.465	8.780	3.999	1.600	0	2.358	72,00	0,00
KARTAL MUNICIPALITY	THE COASTAL PATH	C35	14,00	5.089	3.517	2.794	5.513	2.500	999	0	1.480	45,00	0,00
			77,00 m³	40.166	30.296	24.296	42.386	18.296	8.296	0	11.715	344,00	0,00
			Kg / m3	522	393	<mark>31</mark> 6	550	345		-	152	4,47	0,00
				1.1	ļ	Su / Çi	m Oranı	0,44					

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Vehicle and Service Amount

Within the requested date range, truckmixer (by vehicle) and trip number of pumps (by service) and cubic meter information may be listed and "Transfer Data" feature may be saved in a different way. "Transfer Data" transaction is detailed in "Entries-Stock Entry" part.

Screen is closed by clicking on red "X" in the top right-hand corner.

duction Time		2	By Vehicle By S	ervice					
			Plate	•	Driver	v	The number of '	Total 💌	
st Date	06.03.2012	-	34 SUN 1445		GEORGE CARTER		2	18,00 m ³	
	00:00:00	÷	34 SUN 2678		EROL GÜNAYDIN		3	26,00 m ³	
st Date	30.01.2013	-	34 SUN 2979		ADEM AKKAYA		5	33,00 m³	
	23:59:59	•							



Using filtering feature in column heads, it is possible to display one record or all records.

🛒 Vehicle and Ser	vice Amount					
🔯 Close					Print	Transfer Data 📿
Production Time	e		By Vehicle By Service			
			Service	▼ Total	•	
First Date	13.08.2012	•	CONCRETE PUMP		85,00 m ³	
	00:00:00	+	CONCRETE PUMP 2		8,00 m²	
Last Date	01.02.2013	•				
	23:59:59	÷				
					93,00 m³	

Manual Weighings

Manual weighing saved by PLC may be displayed on date, hour, user and material type basis via this screen.

Requested records may be sent to archive. "Archive Transactions" are detailed in "Entries-Stock Entry.

											Transf	er Data 🤔		
roduction Time	-		Date	User	Agr 1				Cem 1	Cem 2				water 2
			01.02.2013 15:54:01		2.021 Kg		1.123 Kg	2.195 Kg	0 Kg	0 Kg		-	296 Kg	0 Kg
irst Date	03.09.2012 -	1	30.01.2013 14:52:53		4.066 Kg		2.245 Kg	4.415 Kg	1.001 Kg	399 Kg			592 Kg	0 Kg
	00:00:00		30.01.2013 14:27:16		4.066 Kg		2.245 Kg	4.415 Kg	1.501 Kg	600 Kg			888 Kg	0 Kg
	•		30.01.2013 14:03:18		1.023 Kg		549 Kg	1.098 Kg	500 Kg	0 Kg			296 Kg	0 Kg
st Date	01.02.2013 🗸		30.01.2013 14:02:06		4.066 Kg		2.245 Kg	4.415 Kg	999 Kg	401 Kg	-		592 Kg	0 Kg
	23:59:59		30.01.2013 13:41:40		3.043 Kg		1.671 Kg	3.268 Kg	998 Kg	399 Kg			590 Kg	0 Kg
	•		30.01.2013 13:20:38		873 Kg		474 Kg	973 Kg	490 Kg	196 Kg			291 Kg	0 Kg
pe of Plant			29.01.2013 15:22:10		873 Kg	-	474 Kg	973 Kg	490 Kg	196 Kg			291 Kg	0 Kg
pe of Plaint			30.12.2012 19:01:34		3.043 Kg	2.095 Kg	1.671 Kg	3.318 Kg	1.001 Kg	401 Kg			582 Kg	0 Kg
All Plants			30.12.2012 18:13:09		4.066 Kg		2.245 Kg	4.390 Kg	1.499 Kg	600 Kg	-		888 Kg	0 Kg
			30.12.2012 18:00:32		3.043 Kg		1.671 Kg	3.293 Kg	999 Kg	401 Kg	0 Kg	-	592 Kg	0 Kg
		20	30.12.2012 17:52:49	OPERATOR	1.023 Kg		549 Kg	1.098 Kg	0 Kg	0 Kg			0 Kg	0 Kg
		19	30.12.2012 17:51:16	OPERATOR	4.066 Kg	2.794 Kg	2.245 Kg	4.415 Kg	1.501 Kg	600 Kg	0 Kg	0 Kg	888 Kg	0 Kg
		18	30.12.2012 17:12:07	OPERATOR	3.043 Kg	2.095 Kg	1.671 Kg	3.318 Kg	999 Kg	401 Kg	0 Kg	0 Kg	592 Kg	0 Kg
		17	30.12.2012 14:35:00	OPERATOR	4.066 Kg	2.794 Kg	2.245 Kg	4.390 Kg	1.501 Kg	600 Kg	0 Kg	0 Kg	908 Kg	0 Kg
		16	30.12.2012 13:24:49	OPERATOR	4.066 Kg	2.794 Kg	2.245 Kg	3.318 Kg	1.129 Kg	399 Kg	0 Kg	0 Kg	700 Kg	0 Kg
		15	30.12.2012 13:16:45	OPERATOR	2.021 Kg	698 Kg	574 Kg	1.098 Kg	500 Kg	0 Kg	0 Kg	0 Kg	296 Kg	0 Kg
		14	30.12.2012 13:03:18	OPERATOR	3.068 Kg	2.095 Kg	1.671 Kg	3.293 Kg	999 Kg	399 Kg	0 Kg	0 Kg	592 Kg	0 Kg
		13	30.12.2012 12:43:17	OPERATOR	3.043 Kg	2.095 Kg	1.671 Kg	3.268 Kg	998 Kg	399 Kg	0 Kg	0 Kg	590 Kg	0 Kg
		12	30.12.2012 12:11:21	OPERATOR	1.023 Kg	698 Kg	574 Kg	1.098 Kg	500 Kg	0 Kg	0 Kg	0 Kg	0 Kg	0 Kg
		11	30.12.2012 12:06:52	OPERATOR	2.021 Kg	698 Kg	549 Kg	1.098 Kg	500 Kg	200 Kg	0 Kg	0 Kg	306 Kg	0 Kg
		10	30.12.2012 12:03:54	OPERATOR	4.066 Kg	2.819 Kg	2.245 Kg	4.415 Kg	1.499 Kg	600 Kg	0 Kg	0 Kg	888 Kg	0 Kg
		g	29.12.2012 21:25:30	OPERATOR	3.043 Kg	2.095 Kg	1.671 Kg	3.318 Kg	1.001 Kg	401 Kg	0 Kg	0 Kg	602 Kg	0 Kg
		8	29.12.2012 19:38:10	OPERATOR	3.043 Kg	2.095 Kg	1.696 Kg	3.293 Kg	999 Kg	401 Kg	0 Kg	0 Kg	592 Kg	0 Kg
		7	29.12.2012 18:05:55	admin	3.043 Kg	2.095 Kg	1.671 Kg	3.268 Kg	998 Kg	196 Kg	0 Kg	0 Kg	291 Kg	0 Kg
		e	29.12.2012 18:01:17	admin	1.023 Kg	698 Kg	0 Kg	0 Kg	212 Kg	0 Kg	0 Kg	0 Kg	94 Kg	0 Kg
		31	1		88.155 Kg	62.608 Kg	46.821 Kg	90.603 Kg	28.213 Kg	10.641 Kg	0 Kg	0 Kg	16.870 Kg	0 Kg

Cycle Details

When "Periodic Casting Feature" is activated in "Plant Information-Production Confirms", all cycle details about production are saved, if required they may be printed.

uction Time	-		Productio n No	- (Customer	•	Date .	Productio
Date	04.02.2013	-		7 1	KARTAL MUNICIPALITY		04.02.2013	10,00
	00:00:00	\$			KARTAL MUNICIPALITY		04.02.2013	10,00
		-		3 1	KARTAL MUNICIPALITY		04.02.2013	5,00
Date	04.02.2013	-						
	23:59:59	\$						
of Plant	23:59:59	\$						
	23:59:59	\$						
	23:59:59	:						
	23:59:59	\$						
	23:59:59	\$						
	23:59:59	•						
	23:59:59	:						
	23:59:59	:						
of Plant	23:59:59	•						
	23:59:59	•						
	23:59:59							
	23:59:59							

Requested production is selected on the list and "Print" button is clicked on. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

Firma :	KAD	TAL		PALIT	v		12	No		58			
Santive :			BTAL P					ktar		56 4 m	a		S/C:
10000	53 (A COLL	and				ansMile	CAT.		P BUN 14	15	0,42
Recete :			3 16 55	-55				t.Bit.Ta				+5 17:00:0	16
Ort.Bas.Tar :		and the	19.35				-						
Maizeme	Reg Deg		Nutite	é	latenen	Sinim lat	enen	Topiam		Toplan		F	urix
lar 1	9	505			2022		508		2032		2021	394	11,00
var 2		250		a	1400		250		1402		1297	-	2.00
lar 3		250			1122		250		1120		1123		2,00
var 4		550	1	a	2200		350		2200		2195		-8,00
em 1		250			1000		250		1000		335		-1,00
em 2		100			400		100		402		421		1.00
Xem 3		٩			a		٥		۵		۵		0,00
vater 1		145			592		145		592		592		d, 00
viditive 1 viditive 2		4,50			18,00		4,50		0.00		8,00 0.00		0.00
Toplam		219	0,5		5762	2	190,50		5762		5145		6.0°
					CI	EVRİM D	DETAYL	ARI					
Tarih	Ort.No	Per.	Agr 1	Agr 2	Agr 3	Agr 4	Cem 1	Cem 2	Cem 3		water 1	Addit live 1	Addit Ne 2
01.02.2013 16.57.02	55	\mathbb{R}	1025	695	549	1095	500	200	0		295	9,02	0,00
Olpuk	n.:		1016	700	560	1100	500	200	0		295	9,00	0.00
Fark 01.02.2013			7	-2	-11	-2			0				0,00
10.50.51	55	2	995	695	2.25	1095	500	201	٥	٥	296		0,00
Clouk			1018	100	560	1100	500	200	C	0	220	9,00	0,00
Fark			-18	-2	54	-2	0	1	0	0	0	-0,03	0,00
Tolat.		1	2021	1297	1123 212	5 999	401	٥		522	18	0	0

Report Design

When "Ctrl + Alt + Shift + F10" is pressed on printer preview page, report design screen appears.

Customizable Data Transfer

Special Reports are prepared and saved in a different form.

Selecting a record on the list of "New" or "Report Name" and clicking on "Correct" button, report preparation screen may be displayed.

Modifications requested to take place in report may be selected on the list. All variables may be selected or removed by clicking on "All Selected" or "All Unselected"

Giving "Report Name" information is saved by clicking on "Save". Screen is exited without saving by clicking on "Close".

Bapor Adi	Close					
	Acıklama	- Duru	n	v	Sira	Ŧ
Uretim Tarih	Uretim Tarih					
Uretim BasTarih	Uretim BasTarih					
Uretim_BitTarih	Uretim_BitTarih					
Uretim_Kullanici	Uretim_Kullanici					
Uretim_HazirMiktar	Uretim_HazirMiktar					
Uretim_UretilenMiktar	Uretim_UretilenMiktar					
Uretim_ladeMiktar	Uretim_ladeMiktar					
Uretim_NetMiktar	Uretim_NetMiktar					
Uretim_FreeMiktari	Uretim_FreeMiktari					
Uretim_UretimFazlasi	Uretim_UretimFazlasi					
Uretim_IlaveSu	Uretim_IlaveSu					
Uretim_Aciklama	Uretim_Aciklama					
Uretim_Tip	Uretim_Tip					
Uretim_UretimNo	Uretim_UretimNo					
Uretim_IrsaliyeNo	Uretim_IrsaliyeNo					
Siparis_Istenen	Siparis_Istenen					
Siparis_Verilen	Siparis_Verilen					
Siparis_Tarih	Siparis_Tarih					
Musteri_Adi	Musteri_Adi					
Musteri_Sehir	Musteri_Sehir					
Musteri_Yetkili	Musteri_Yetkili					
Musteri_Adr	Musteri_Adr					
Musteri IIce	Musteri IIce					

Save	🔉 Close				
Rapor Adı spe	ecial production report				
Veri 💌	Açıklama	• Durum	v	Sıra 💌	
Uretim_Tarih	Uretim_Tarih			1	
Uretim_BasTarih	Uretim_BasTarih			5	
Uretim_BitTarih	Uretim_BitTarih			7	
Uretim_Kullanici	Uretim_Kullanici	2		6	
Uretim_HazirMiktar	Uretim_HazirMiktar			2	
Uretim_UretilenMiktar	Uretim_UretilenMiktar			3	
Uretim_IadeMiktar	Uretim_IadeMiktar			8	
Uretim_NetMiktar	Uretim_NetMiktar			0	
Uretim_FreeMiktari	Uretim_FreeMiktari			0	
Uretim_UretimFazlasi	Uretim_UretimFazlasi			0	
Uretim_IlaveSu	Uretim_IlaveSu	2		0	
Uretim_Aciklama	Uretim_Aciklama			0	
Uretim_Tip	Uretim_Tip			4	
Uretim_UretimNo	Uretim_UretimNo			0	
Uretim_IrsaliyeNo	Uretim_IrsaliyeNo			0	
Siparis_Istenen	Siparis_Istenen			0	
Siparis_Verilen	Siparis_Verilen			0	
Sinaris Tarih	Sinaris Tarih			0	

Selecting "Report Name" and date range on main screen, requested report may be displayed.

Report Name	special product	tion report	-	First I	Date	28.12.2012	-	Last Date	01.02.2013	-		
Uretim_Tarih 💂	Uretim_Hazir 🗸	Uretim_Uretil 🖕	Uretim_Tip	- Uai	retim_BasT	Musteri_Adi		Uretim_Kulla 🖕	Uretim_BitTa 🗸	Uretim_Iade Miktar	-	
28.12.2012	0,00	12,00		1 2	8.12.2012 16:1	8 KARTAL MUNIC	TP	admin	28.12.2012 16:30			
29.12.2012	0,00	8,00		1 2	9.12.2012 17:4	KARTAL MUNI	CIP	admin	29.12.2012 17:4			
29.12.2012	0,00	8,00		1 2	9.12.2012 18:0	KARTAL MUNI	CIP	admin	29.12.2012 18:5			
29.12.2012	0,00	5,00		1 2	9.12.2012 19:0	AKER MÜHEND	İSI	admin	29.12.2012 19:0:	1	3,00	
29.12.2012	3,00	2,00		1 2	9.12.2012 19:0	AKER MÜHEND	İSI	admin	29.12.2012 19:1			
30.12.2012	0,00	10,00		1 3	0.12.2012 11:0	AKER MÜHEND	İSI	OPERATOR	30.12.2012 11:1:			
30.12.2012	0,00	10,00		1 3	0.12.2012 12:1	KARTAL MUNI	CIP	OPERATOR	30.12.2012 12:3			
30.01.2013	0,00	8,00		1 3	0.01.2013 13:4	KARTAL MUNI	CIP	OPERATOR	30.01.2013 13:5	4	4,00	
30.01.2013	0,00	8,00		1 3	0.01.2013 14:0	KARTAL MUNI	CIP	OPERATOR	30.01.2013 14:14		0,00	
30.01.2013	0,00	12,00		1 3	0.01.2013 15:1	I KARTAL MUNI	CIP	OPERATOR	30.01.2013 15:30			
30.01.2013	0,00	6,00		1 3	0.01.2013 15:1	I KARTAL MUNI	CIP	OPERATOR	30.01.2013 15:30		0,00	
30.01.2013	7,00	13,00		1 3	0.01.2013 15:1	II KARTAL MUNI	CIP	OPERATOR	30.01.2013 15:30	1 1	0,00	
30.01.2013	7,00	19,00		1 3	0.01.2013 15:1	I KARTAL MUNI	CIP	OPERATOR	30.01.2013 15:30		0,00	
01.02.2013	4,00	4,00		1 0	1.02.2013 14:5	5: KARTAL MUNI	CIP	OPERATOR	01.02.2013 14:5!		0,00	
01.02.2013	0,00	4,00		1 0	1.02.2013 15:5	5: KARTAL MUNI	CIP	OPERATOR	01.02.2013 16:0			
01.02.2013	0,00	4,00		1 0	1.02.2013 16:0	KARTAL MUNI	CIP	OPERATOR	01.02.2013 16:0			
01.02.2013	0,00	4,00				KARTAL MUNI			01.02.2013 16:4:			
01.02.2013	0,00					AKER MÜHEND			01.02.2013 16:4:			
01.02.2013	0,00					H AKER MÜHEND			01.02.2013 16:5:		0,00	
01.02.2013	0,00	4,00		1 0	1.02.2013 16:5	5: KARTAL MUNI	CIP	OPERATOR	01.02.2013 17:0			

With the "Transfer Data" feature, list may be saved in a different way. "Transfer Data" transaction is detailed in "Entries- Stock Entry" part.

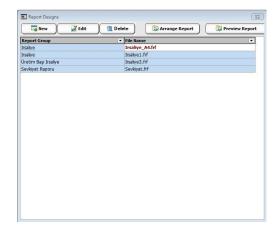
Report Design

Modifications may be made in waybill forms and new forms may be created.

Clicking on "New" or selecting a record and clicking on "Correct" button, "Report Group" and "File Name" definition/ selection screen is switched to. Selected record may be deleted by clicking on "Delete" button.

Report group is made up of two categories; "Waybill" and "Waybill (Production Start)". "Waybill" is a form printed at the end of production and from production records and other one is form printed at the beginning of production.

Clicking on the arrow next to "File Name", a new form may be created or an existing form may be selected by the use of navigation panel.



	🖉 Edit 🔰 💼 Delet	e 🚺 🦾 Arrange Report	🔯 Preview Rep
Rapor Grubu	Irsaliye		
Dosya Adı	SUN_A4.frf		
		Save	Cancel

Clicking on "Arrange Report", design part is switched to. On this screen waybill form to be designed is scanned and may be placed on background and a quick design may be made by placing fields to requested places on picture.

	Edit Tools ?		1	▫▫◬◢▰▯੶	17.
	Pagal	Totals feitm@aslangic_l Auto du	Isbe ectimetel isber Isbe ectimetel isber TESUM ALAN Kiş Adı ve Soyael İmcasi Mect Yukança minis	ININ ve ona beimlen brons akside belm adm.	
Pixels	128:8 1 932.602	% 67.78 [Picture]			

To place the scanned picture, "Insert Picture" is selected at the left part is selected. On the appearing screen, picture is selected by clicking on "Load" and the "Ok" is clicked on.

	OK Cancel
[None]	

Picture placed may appear in the forefront. To send it to background, "Send to Back" button is used at the upper part.

To set the page size, "Page Options" is selected on "File" menu.

aper Source Margins Opti	ions
Size	Orientation
A5	C Portrait
Width, mm	
Height, mm	Unlimited height

On exit confirmation screen is displayed. Modifications made are saved by clicking on "Yes" or screen is exited without saving by clicking on "No", clicking on "Cancel" design screen is switched back to.

Clicking on "See Report" design view may be checked.

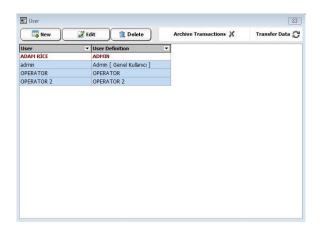
Information is saved by clicking on "Save" and clicking on "Cancel" screen is exited without saving.

System

User

Adding user and arrangement may be performed with the authority of "admin".

Attention! Name of the user having all rights is "admin" and default password is "1". It is recommended to change the password.



Clicking on "New" or "Edit" button, user information screen is opened. After defining personal information and password if many plants will be checked, plants to be controlled by user are selected at the right part. Clicking on "Delete", requested user name may be deleted.

Requested ones from the rights at the sub part are selected and information is saved by clicking on "Save", screen is exited by clicking on "Close".

er			
Jser	Select	Plant	
		INDUSTRIAL ZONE	
Jser Definition		NEW CITY	
User can determine the moisture value			Ē
 User can change the recipe parameters User can arrange the production records 			

"Archive and Transfer Data Transactions" are detailed in "Entries-Stock Entry".

System

User Rights

User rights arrangement transactions may be made with the authority of "admin".

Save	Close		U Delete Al	ll Rights 🛛 🔛 Give All Rights	phts		
Kullanici 👻	KullaniciTanim	Ana Grup	Kodu	Program	Izle	Kaydet	Ī
ADAM RÍCE	ADMIN	P&roduction	39	Returned Concrete Operations	V	V	
OPERATOR	OPERATOR	P&roduction	65	Production			
OPERATOR 2	OPERATOR 2	M&onitoring	56	PLC Inputs/Outputs			
		M&onitoring	46	Events			
		M&onitoring	32	Faults	V		
		R&eports	60	Report Design			
		R&eports	42	Customizable Data Transfer		2	
		R&eports	53	Cycle Details		2	
		R&eports	59	Manual Weighing			
		R&eports	89	Vehicles and Services Totals][
		R&eports	87	Consumed Materials Amount		×	
		R&eports	124	Consumed Material Report (Real)		2	
		R&eports	123	Consumed Material Report (by material)		2	
		R&eports	52	Consumed Report (by silo)			
		R&eports	41	Stock Status Reports		2	
		R&eports	85	Sales Report - 2		2	
		R&eports	58	Sales Report - 1			
		R&eports	38	Delivery Report		2	
		&Manual Operation	105	Automatic		2	
•	l.	&Manual Opera	104	Manual		•	ł

Rights of selected user at the left part may be displayed at the right part. In the list, screens taking place in program are displayed in accordance with menu sequence. "Save" and "Monitor" rights are available for every screen. Right to modify on screen is given with Save, but with Monitor only right to monitor is given.

"Give All Rights" and "Delete All Rights" buttons at the upper part may be used in order to remove "collective selection" and "all selections".

Information is saved by clicking on "Save" or screen is exited without saving by clicking on "Close".

<u>System</u>

Backup and Restore

It is recommended to backup information regularly. First "Backup Way" is selected. Backup folder may be determined in hard disk or by clicking on "Select" button and "Backup" button is clicked on at the sub part.

After clicked on "Ok" on the appearing confirmation screen, a screen showing the completion of transactions is displayed. When clicked on "Ok" again, a backup record bearing current date is created.

Backup and Restore	Backup and Restore
D:\Probeton_Sql I	Probeton Probeton
Backup Backup and Restore	Backup And Restore
D-(Probeton_Sql) Select	D:\Probeton_Sql D:\Probeton_Sql Phts_010220131804.Bak
Backup Restore	🕅 Backup

Note: In some versions, "Restore" feature is prepared as a different program in order to prevent usage error.

To restore the information backed up, back up folder is determined in hard disk or a portable disk and requested record is selected in the list and "Restore" button is clicked on.

After "Ok" is clicked on the appearing confirmation screen, a window showing the completion of transaction is displayed. When "Ok" is clicked on again, program is closed automatically in order that changes are valid.

	D:\Probeton_Sql	🔯 Select
	Piks_010220131804.Bak	
	Probeton	×
	Are you sure you want to do the restore process?	
	Evet Hayır	

	D:\Probeton_Sql	🗔 Select
	Prks_010220131804.Bak	
19483801091 88946-TN-9 2976789858	Probeton	×
1 4096 9 44	Restore process is finished s	successfully.
		Tamam
Backu		Restore