User Manual

EN_7122

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Concrete Plant Automation System

License Agreement

1. SUBJECT OF AGREEMENT

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

2.1. GENERAL PROVISIONS

2.1.1. Using license includes loading to computer, operating, using, monitoring, storing and backing up the software.

2.1.2. 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.

2.1.3. All copyrights and ownership rights other than this non-exclusive 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. USAGE IN ONE COMPUTER

USER (except the multi-user license packs) can't install the software simultaneously in the hard disks of two or more 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-ROM containing defective software and written document is returned within 7 days 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 authorized seller selling the software with its invoice. USER can't raise any objection for defective product after prescribed time.

4. RESTRICTIONS ON GUARANTEE AND LIABILITY

4.1. Guarantee period for software products is one year from the date of invoice. PRODUCER pays maximum attention that software products perform ideally the functions described in the documentation of software products and the one provided in printed and/or magnetic environment. PRODUCER can't claim and undertake that software is completely faultless, perfect and that it shall meet user's general and/or special needs.

4.2. PRODUCER can't be kept liable for the information and software losses arising from the failure of hardware or operating system, data base software of which copyrights don't belong to PRODUCER, network design and connection failures,

voltage fluctuation and power outage, virus shedding and similar environmental factors and user errors.

4.3. PRODUCER can't guarantee the information stored in magnetic environment. User is always responsible for backing up regularly the information obtained by the use of software.

4.4. USER accepts that it shall use the software of which using license it has acquired on hardware bearing minimum technical features stated in the documents of hardware and provide this necessary hardware to it, that PRODUCER has no material and legal liability for the conflict between hardware and software, that liability of PRODUCER is limited with the delivery of using license for the contractual software products.

4.5. PRODUCER is not liable for material, moral, legal and financial results, earnings or losses which may arise from misuse or illegal use of software products.

4.6. Parties accept that all kinds of indemnity amounts (financial liability) that they can claim in all conflicts between them which may arise directly or indirectly from this agreement are limited with the amount that USER pays as license fee.

4.7. Reserving the actions breaching law of intellectual property rights, in any case enforcing indemnity claims PRODUCER can demand an indemnity from USER until the total price of agreement. When right to return software license for any reason arises out for USER, it accepts and undertakes in advance that it shall not demand any indemnity other than license fee paid for software. Parties are restricted mutually so.

4.8. PRODUCER provides freely telephone and internet support to USER for one year following the date when USER starts to use software (receipt of password for the first time). After the expiration of this period, USER can buy service and support from PRODUCER for a certain fee if it wills.

4.9. Parties accept in advance that PRODUCER gave only "Using License" on these contractual software to USER and that PRODUCER has no liability for any loss or damage arising from productivity, loss of income and/or profit, localization of software, use of software and data etc. and is not obliged to indemnify it. Unless there is an additional agreement bearing the signatures of authorized persons, verbal or written declaration of any company member, e-mail, fax text, service form and similar communications shall not be considered a special commitment.

5. COPYRIGHTS OF SOFTWARE

5.1. Copyrights of hardware and documentation are protected by law of intellectual property rights no. 5846, Turkish Penal Code, Code of Brands, Statutory Decree on the Protection of Brands, Turkish Code of Commerce and various provisions of tax law. Copying and such kind of transactions outside of the using license right are subject to criminal sanctions in accordance with the type of action.

5.2. USER is absolutely responsible for whether the software on which application software provided by PRODUCER is operated and database and network software of which copyrights don't belong to PRODUCER are valid and have sufficient using license or not.

6. CONDITIONS ON THE DELIVERY OF SOFTWARE PRODUCTS

USER accepts that software products of which it buys using license be delivered to its address. Delivery to this address is considered valid delivery. USER accepts that it shall not raise any objection that delivery is not made to it or related member of firm in the deliveries made to this address and that it waives this right in advance.

7. CD/DVD-ROM, WRITTEN DOCUMENT (DOCUMENTATION)

Copyrights of CD/DVD-ROM containing contractual software products and accompanying documents belong to

PRODUCER. To amend, to use for other purposes, to copy and reproduce the documents constitutes the breach of copyrights.

8. VERSION CHANGE AND MAINTENANCE

PRODUCER has right to make modification in software and written documents and to release new versions of software products without giving a prior notice, USER can obtain this new version and written documents only by paying upgrade fee to be stated in price lists and getting a new license. PRODUCER can perform the upgrades periodically and freely if it wills. PRODUCER doesn't assure that information entered or obtained with previous version is processed also by new version when new version is received. PRODUCER is not liable for transferring the data processed with previous version to new version for each released version conventionally.

Current version of the software of which new version is released is supported for 1 year following the date of release of new version. But modifications occurring in legislation and corrections and innovations related to the operation of program are not applied to previous versions. At the end of one year period, production of previous version is discontinued or PRODUCER reserves its right to discontinue. Programs and disks, documentation of the versions of which production is discontinued and support service for this software can't be received from PRODUCER. Unless contrary provision is agreed by parties in written, PRODUCER is not liable for rendering support service to database and network software on which application products are operated and to resolve the troubles arising from them.

If USER requests a support service outside of the service stated in the special provisions of agreement, it may fulfill this demand for a certain fee by making an additional maintenance agreement.

9. TERMINATION OF AGREEMENT AS A RESULT OF DISSOLVING CONDITION

In following cases license agreement is terminated automatically without need to any provision, warning and notice.

9.1. In the event that USER doesn't pay license fee or doesn't pay it fully.

9.2. In the event that PRODUCER breaches any copyright of USER

In this case USER is obliged to deliver the software and documentation at its hand to PRODUCER within 7 days without need to any provision, warning and notice and to delete all copies of the software installed in its computer.

10. OTHER PROVISIONS

10.1. Upon the acceptance of this agreement, written and verbal offers made about software license, proposals and acceptances, written agreements, other commercial communications and commitments become obsolete. If there is any Special Using License supplementing this agreement, it is out of this provision.

10.2. Provisions in this agreement can be modified with additional agreements. Any declaration and letter doesn't mean the amendment of agreement.

10.3. In the conflicts arising from this agreement, enforcement offices and courts in Izmir are authorized. Turkish law is applied in conflicts.

10.4. This agreement is deemed to have been accepted by USER.

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

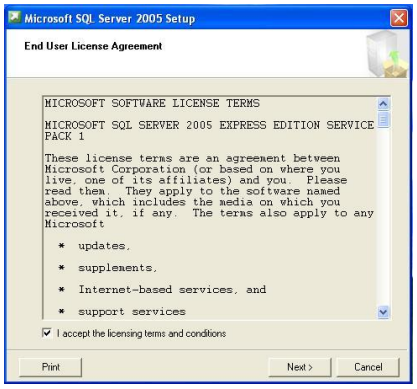
1. If SQL Server is already installed in the computer to which installation will be made, it should be backed up and removed from computer.

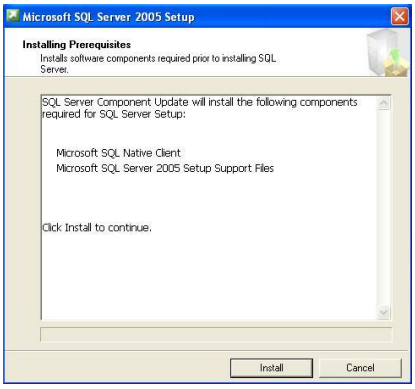
2. If Anti-Virus program is available, it should be deactivated during installation.

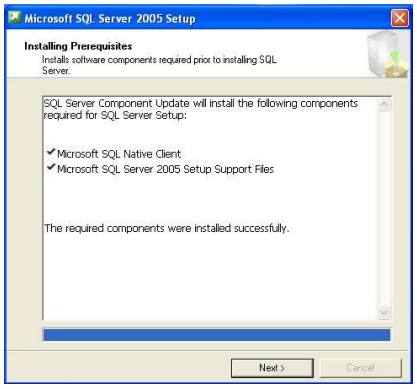
3. SQLEXPR32.EXE in the folder of Microsoft SQL Server 2005 Express Edition SP2 in CD is run.

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

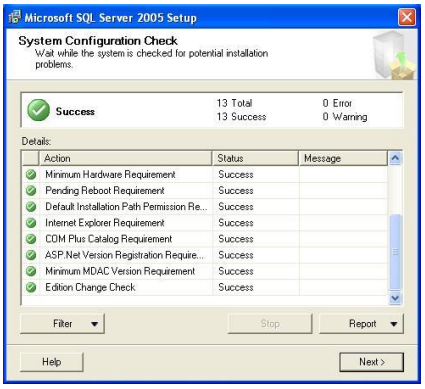
5. First of all confirmation of license agreement is required. "I accept the licensing terms and conditions" is checked on "End User License Agreement" screen and Next button is clicked on and installation is continued. In following step all necessary components will be loaded before the installation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



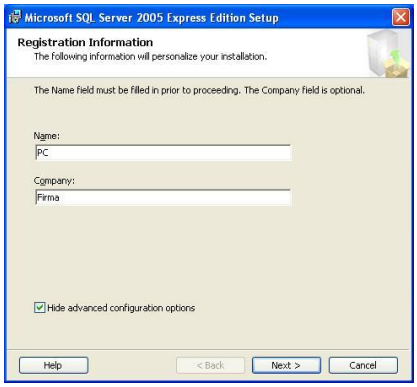




6. In following step, configuration control is made. If there is no deficiency in configuration, Next button is clicked on and next step is followed.

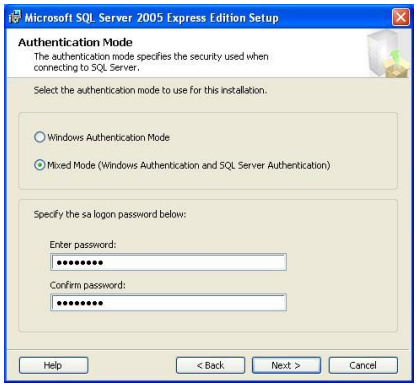


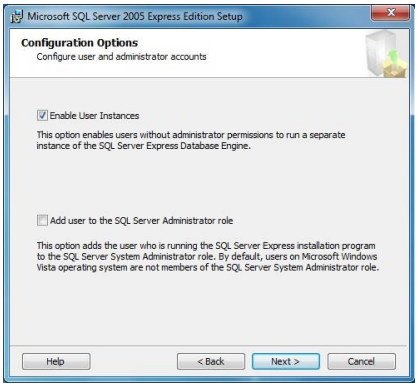
7. Name and firm information is entered on “Registration Information” and then next button is clicked on. Before making any modification on Feature Selection, Next Button is clicked on and installation is continued.

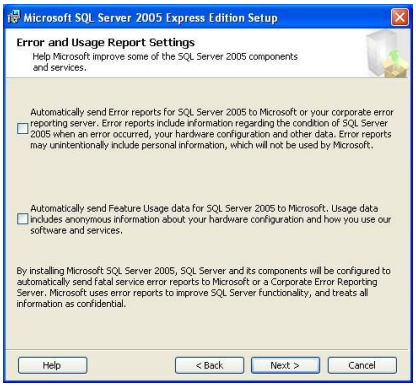


IMPORTANT!

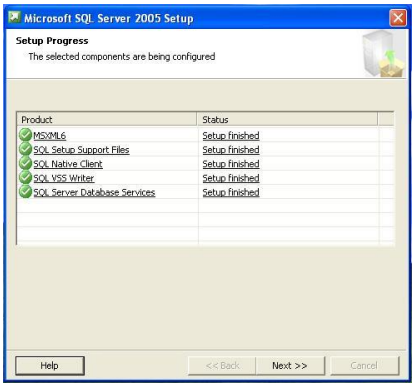
8. Mixed Mode should be selected on Authentication Mode screen, otherwise “Login Failed” error may appear when application is run. Password to be used in database connection is entered in both password areas and Next button is clicked on and installation is continued without making any change in Options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

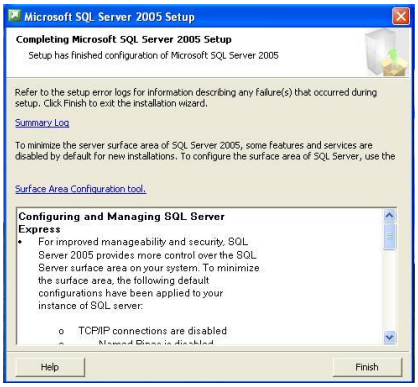






9. Install and Next buttons are clicked on respectively without making any change in Ready to Install and Setup Progress screens and installation is continued. Finish is clicked on Complete Microsoft SQL Server 2005 Setup screen and installation is completed.

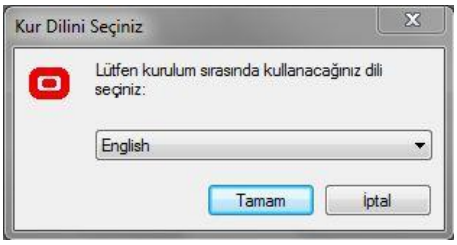




Probeton SQL Setup

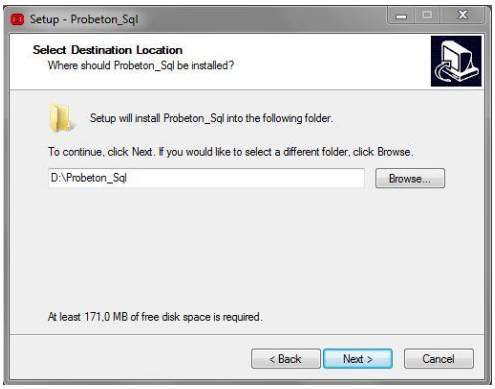
After the installation of Microsoft SQL Server 2005 Express Edition Bs_Setup.exe should be run and following instructions should be followed:

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

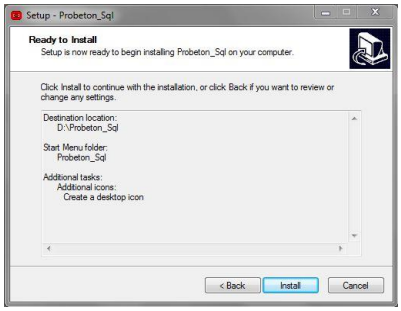


IMPORTANT!

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.



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.

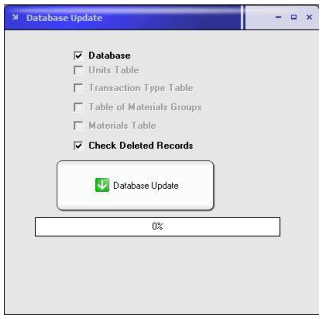


Database Definition

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.

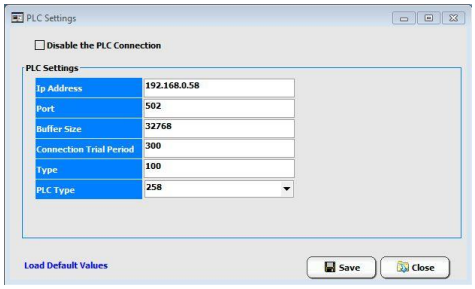
In second screen, “SQL Server”, “User” and “Password” appear automatically if new installation is made. If existing SQL server is used, related information is typed. If Connection Successful appears when “Connection Test” is clicked on, Connect is clicked on.

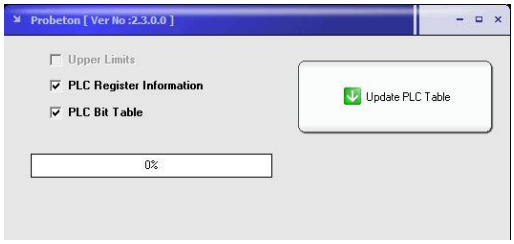


After Database update, user and password definition screen appears.

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”.





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:

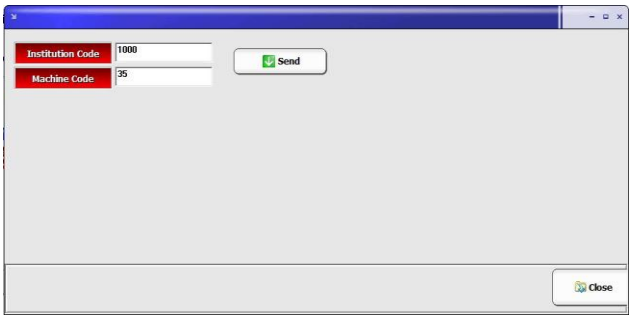
101 (systems with 4 aggregates, single weighing belt) **102** (systems with 3+3 aggregates, double weighing belts), **105** (systems with 5 aggregates, single weighing belt).

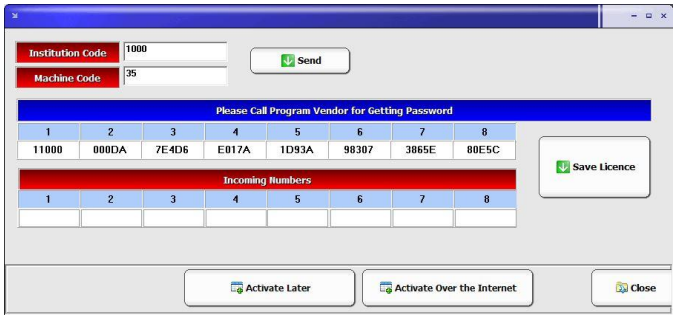
PLC Type, used in PLC type is selected (340, 258, Twido)

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

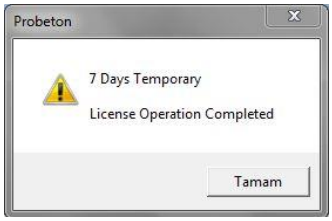
Activation of Program

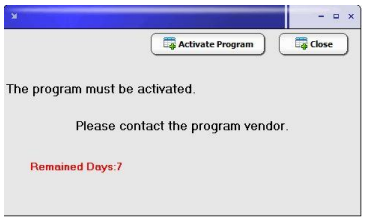
When program is run in a new computer for the first time, it should be activated within 7 days. “Institution Code” and “Machine Code” given with setup CD are entered respectively on “License” screen appeared. Machine Codes are “1” and “2” for production program and “monitoring program” respectively.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





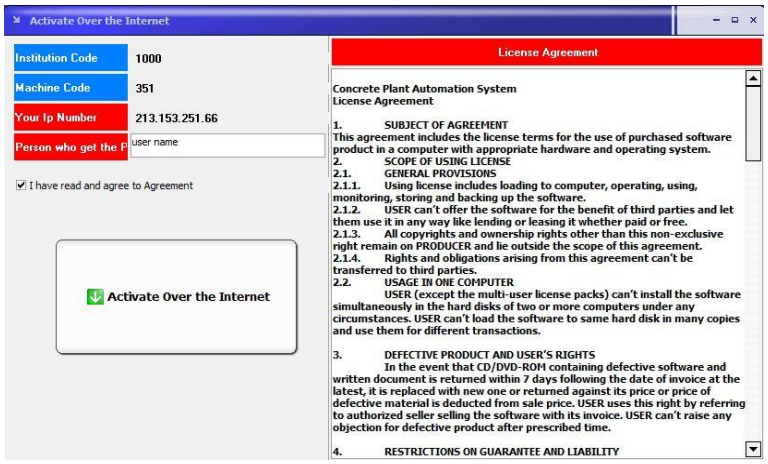
After “Send” button is pressed, “Activate over the Internet” is clicked on. If it is not allowed to get password over internet, an alert window appears. In the event that alert window appears or there is no internet connection, it should be activated by phone. Codes received from program seller are entered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





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.

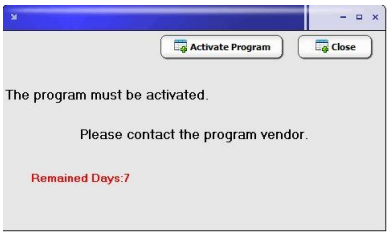
When “Activate over the Internet” is selected, “Person who get the password” area is filled in, “I have read and agree to Agreement” is checked and “Activate over the Internet” is clicked on.



Introduction to Program

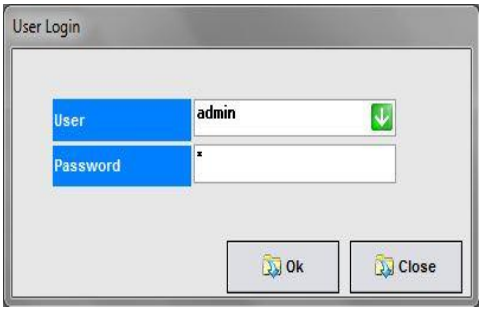
Probeton_Sql icon on Windows desktop or “Probeton.exe” in the directory where program is installed (C:\Probeton_Sql or D:\Probeton_Sql) is double clicked and program is run.

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.



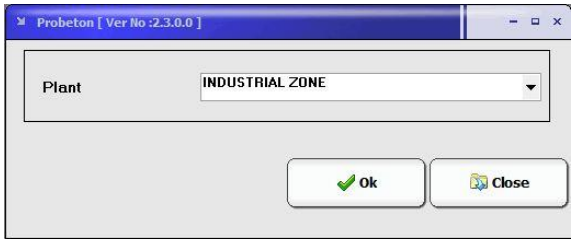
User selection is made by arrow icon in the box of “User” on Login screen and related password is entered in “Password” box, “Ok” is clicked on. In the event that wrong information is entered, warning screen appears.

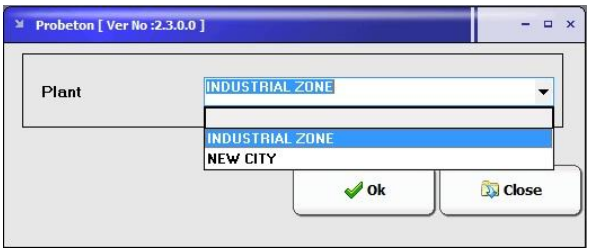
Attention! User name having all rights is “admin” and default password is “1”. As detailed in “User” and “User Rights”, password of admin should be changed.



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.





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

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

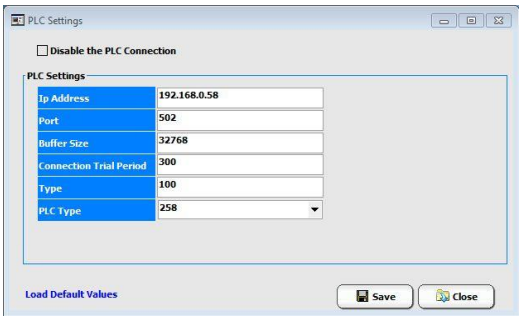
F10	Displays detailed/ technical records	**Ctrl + Alt +M**	Start / stop mixer
Ctrl + F9	Displays hidden buttons on parameter screens	**Ctrl + S**	Horn
F9	Displays production screen	**F8**	Displays coordinate settings window on production screen
		Ctrl + Alt +Shift + F10	Displays report design screen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

First Transactions

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.



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).

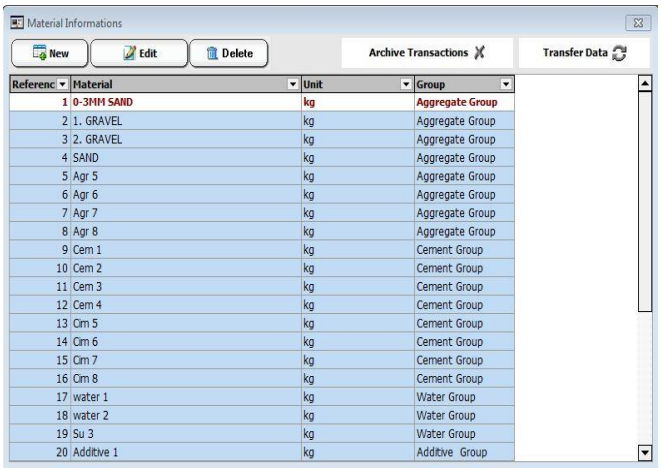
PLC Type, used in PLC type is selected (340, 258, Twido).

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

First Transactions

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

Materials



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

Archive transactions are to send the record which is not requested to be displayed in the list and used to archive and to call them back when required. When requested record is selected and “Send to the Archive” is clicked on, record is removed from the list. When “Show All” is clicked on, these records are displayed in red.

When “Current Records” is clicked on, records sent to archive are not displayed. “Show All” should be 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.

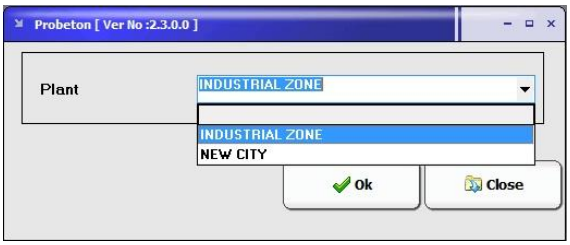
Any record list used in program may be saved in a different format. Convertible formats are Excel, Html, Xml and Txt. When any transfer is selected from “Data Transfer” menu, a window appears, in which target directory and name information may be defined.

First Transactions

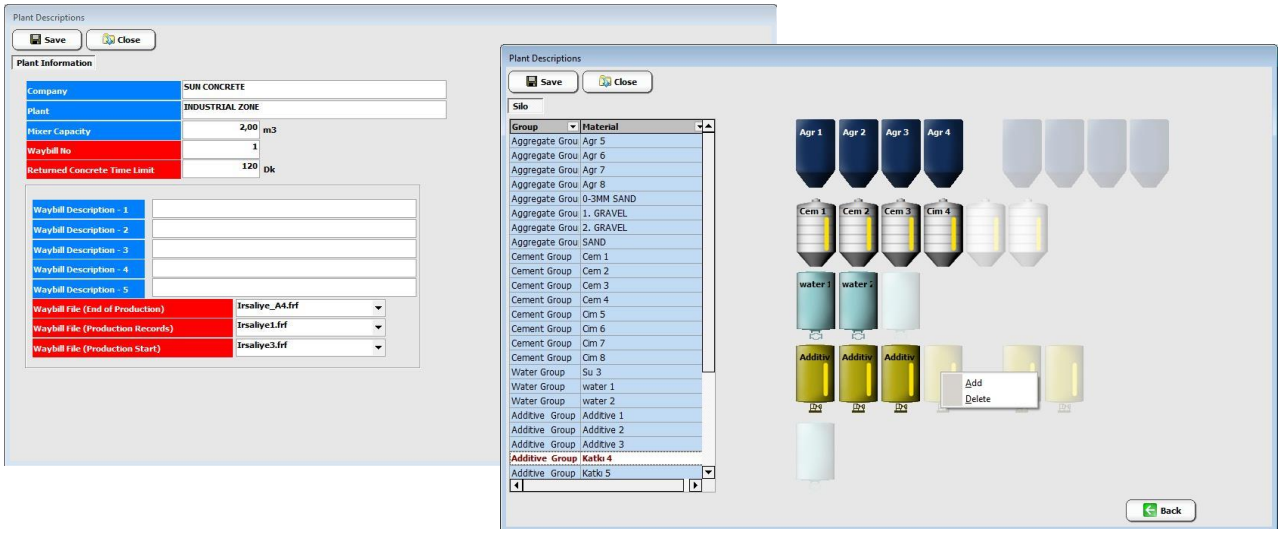
When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

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.



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.



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.

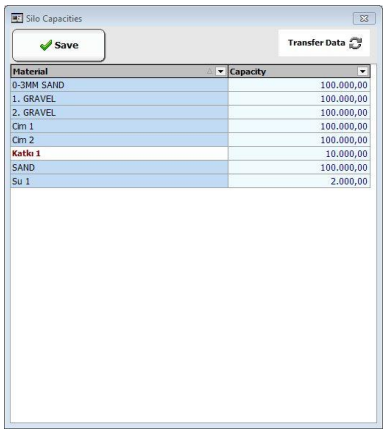
Information is saved by clicking on “Save”, screen is exited by clicking on “Close” without saving. Screen is closed by clicking on red X in the top right-hand corner.

First Transactions

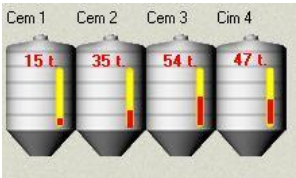
When program is run first time, a number of basic definitions should be made. This menu may be displayed only by admin.

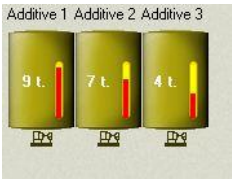
Silo Capacities

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



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.

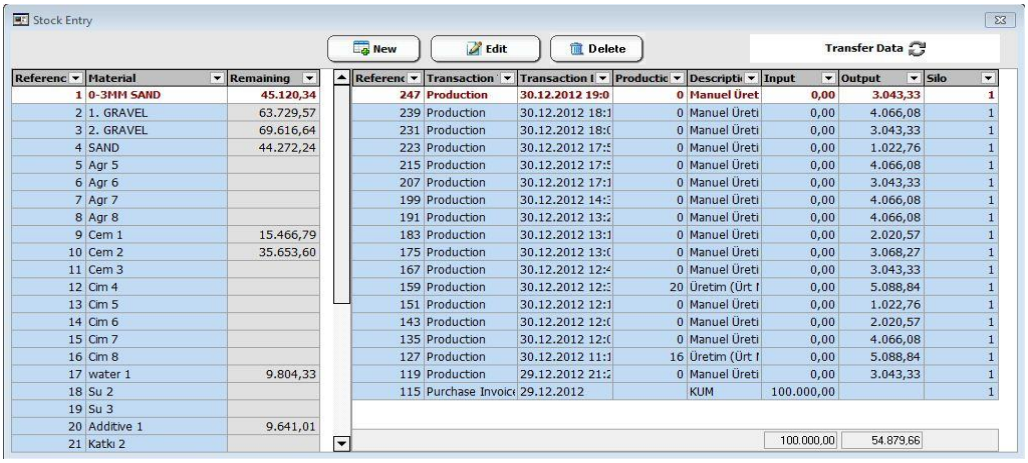
Entries

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.



Referenc	Material	Remaining
1	0-3MM SAND	45.120,34
2	1. GRAVEL	63.729,57
3	2. GRAVEL	69.616,64
4	SAND	44.272,24
5	Agr 5	
6	Agr 6	
7	Agr 7	
8	Agr 8	
9	Cem 1	15.466,79
10	Cem 2	35.653,60
11	Cem 3	
12	Cim 4	
13	Cim 5	
14	Cim 6	
15	Cim 7	
16	Cim 8	
17	water 1	9.804,33
18	Su 2	
19	Su 3	
20	Additive 1	9.641,01
21	Katkı 2	

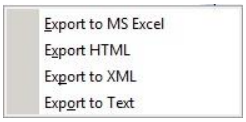
Referenc	Transaction	Transaction	Productic	Descriptic	Input	Output	Silo
247	Production	30.12.2012 19:0	0	Manuel Üret	0,00	3.043,33	1
239	Production	30.12.2012 18:1	0	Manuel Üreti	0,00	4.066,08	1
231	Production	30.12.2012 18:0	0	Manuel Üreti	0,00	3.043,33	1
223	Production	30.12.2012 17:5	0	Manuel Üreti	0,00	1.022,76	1
215	Production	30.12.2012 17:5	0	Manuel Üreti	0,00	4.066,08	1
207	Production	30.12.2012 17:1	0	Manuel Üreti	0,00	3.043,33	1
199	Production	30.12.2012 14:3	0	Manuel Üreti	0,00	4.066,08	1
191	Production	30.12.2012 13:2	0	Manuel Üreti	0,00	4.066,08	1
183	Production	30.12.2012 13:1	0	Manuel Üreti	0,00	2.020,57	1
175	Production	30.12.2012 13:0	0	Manuel Üreti	0,00	3.068,27	1
167	Production	30.12.2012 12:4	0	Manuel Üreti	0,00	3.043,33	1
159	Production	30.12.2012 12:3	20	Üretim (Ürt I	0,00	5.088,84	1
151	Production	30.12.2012 12:1	0	Manuel Üreti	0,00	1.022,76	1
143	Production	30.12.2012 12:0	0	Manuel Üreti	0,00	2.020,57	1
135	Production	30.12.2012 12:0	0	Manuel Üreti	0,00	4.066,08	1
127	Production	30.12.2012 11:1	16	Üretim (Ürt I	0,00	5.088,84	1
119	Production	29.12.2012 21:2	0	Manuel Üreti	0,00	3.043,33	1
115	Purchase Invoic	29.12.2012		KUM	100.000,00		1
					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:

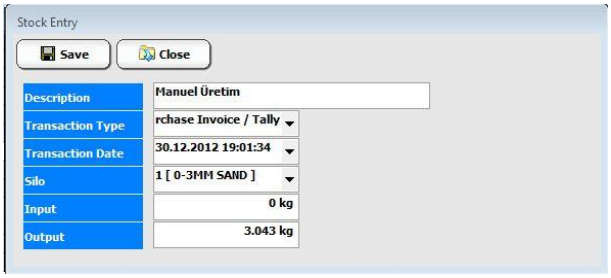
Archive Transactions and Transfer Data

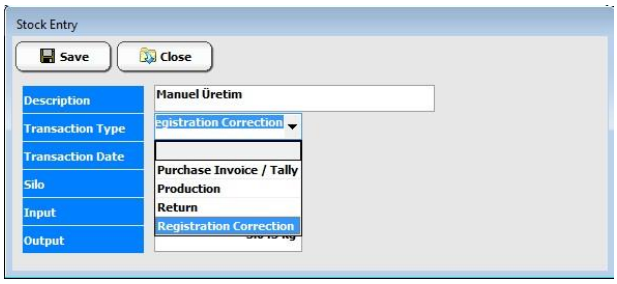
Archive transactions are to send the record which is not requested to be displayed in the list and used to archive and to call them back when required. When requested record is selected and “Send to the Archive” is clicked on, record is removed from the list. When “Show All” is clicked on, these records are displayed in red.

When “Current Records” is clicked on, records sent to archive are not displayed. “Show All” should be 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.



Any record list used in program may be saved in a different format. Convertible formats are Excel, 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.





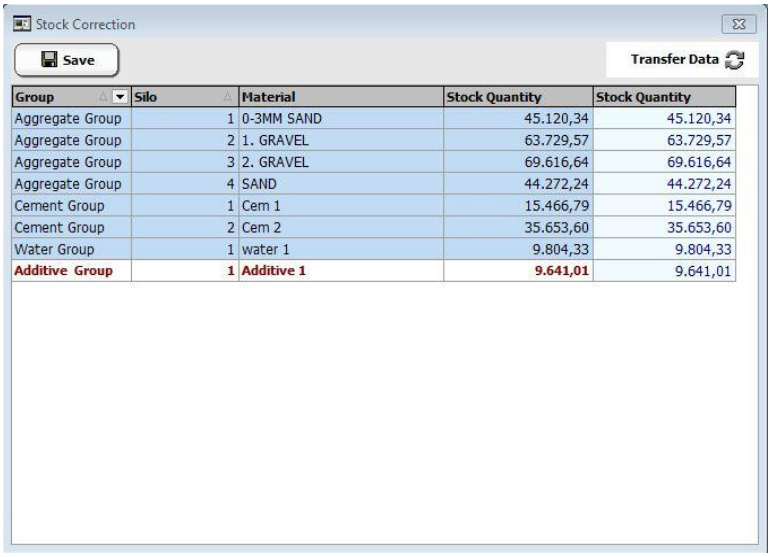
Description	Description about transaction may be entered (waybill/invoice no etc.)	**Silo**	Silo number of the group including material is selected.
Transaction Type	Transaction type (purchase or correction) is selected.	**Input**	Stock Input
Transaction Date	Date of transaction is selected	**Output**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

Entries

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

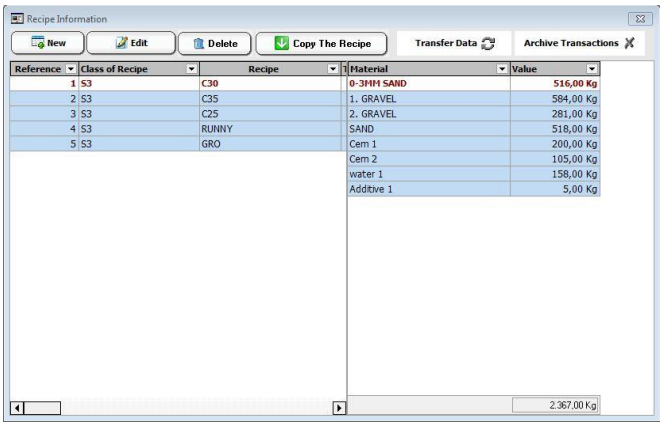
“Transfer Data” transaction is described in “Entries-Stock Entry” part. Screen is closed by clicking on red X in the top right-hand corner.

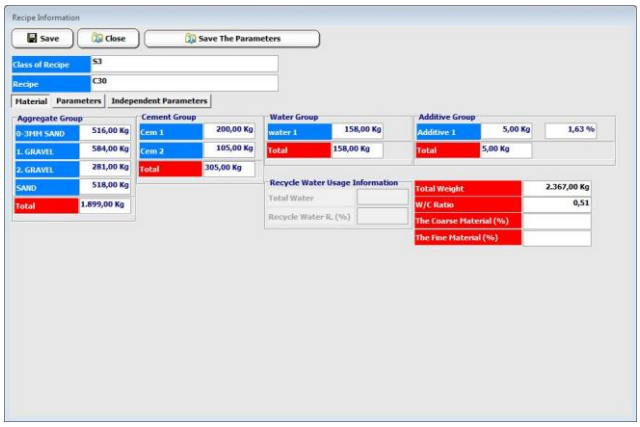
Entries

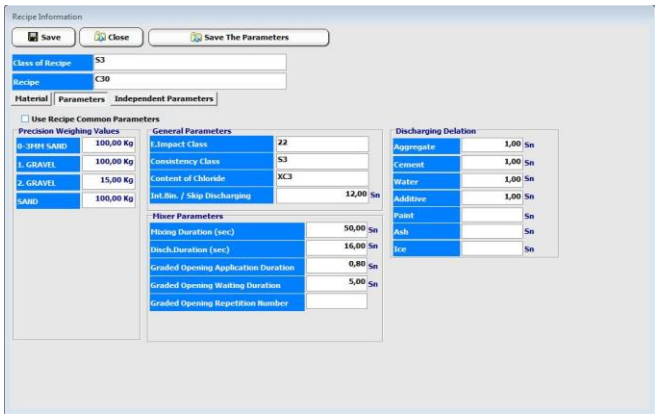
Recipe

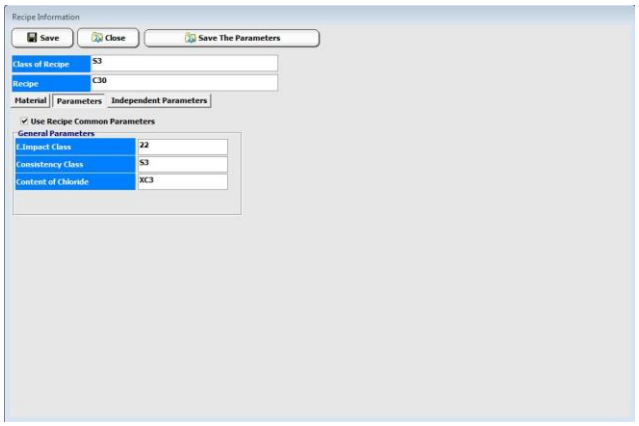
It is the screen where concrete recipes may be entered and modified. At left part “code”, “class” and “name of recipe” take place. When any recipe is selected, material quantities are displayed at the right part.

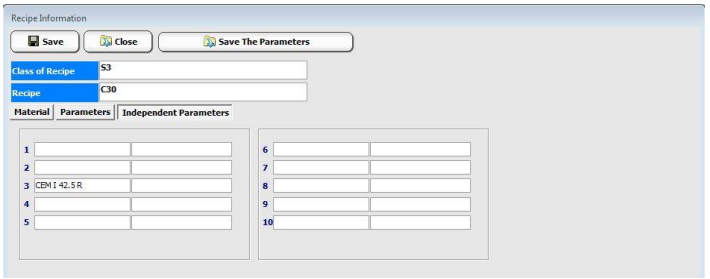
When “New” or existing record is selected and “Edit” is clicked on, editing screen appears. Clicking on “Delete”, selected record may be deleted if not used in any production. Otherwise it may be only sent to archive. When “Copy the Recipe” is clicked on, copy of selected recipe is created and placed 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”.











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.

Recipe information selected by clicking on “Print Recipe Details” on the menu displayed by right clicking on any recipe record may be printed.

Irmak Beton
Söke

Reçete Adı	ŞERBET	**Kıvam Sınıfı**	S4
Sınıfı	ŞERBET	**Klor İçeriği**	0,20
C Etki Sınıfı	X0		

Kullanılan Malzemeler

Agrega Grubu	Çimento Grubu		Su Grubu		Katkı Grubu
5/15	Cim 1	940	Su 1	660	Katkı 1S
05	Cim 2				Katkı 2H
05	Cim 3				Antifiriz
15/25					
Agr 4					
Agr 5					

Toplam Ağırlık 1600

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

Firma :Irmak Beton
Tesis :Söke

REÇETE BİLGİLERİ

		5/15	05	05	15/25	Cim 1	Cim 2	Cim 3		Su 1		Katkı	Katkı	Antifiriz	Antifiriz	Toplam Ağırlık
ŞAP 250	S3		980	980			220			190		1,54				2351,54
ŞAP 350	S3		940	940			300			190		2,10				2382,10
ŞAP 300	S3		965	965			250			190		1,75				2371,75
C 30/37	S3	350	480	480	600		300			170		3,60				2383,60
C 25/30	S3	350	500	500	610		270			170		3,00				2403,00
C 30/37	S4	370	490	490	590		290			155			3,62			2388,62
C 16/20	S3	350	570	570	550		160			175		1,60				2376,60
C 20/25	S4	360	530	530	590		225			180		2,25				2417,25
C 25/30	S4	340	540	540	570		260			155			2,60			2407,60
C 25/30 BÜRÜT	S4	810	550	550			290			180		2,90				2382,90
C 20/25 BÜRÜT	S4	740	600	600			260			180						2380,00
C 30/37 BÜRÜT	S4	820	530	530			320			155			3,84			2358,84
C 16/20 BÜRÜT	S3	800	620	620			160			190		1,60				2391,60
C 40/45	S4	370	440	440	610		400			130			5,60			2395,60
C 45/50	S4	380	410	410	600		470			140			6,58			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			2399,59
ŞERBET	ŞERBE						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			380			160			5,13			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
C 16/20	Mikserli	390	560	560	550		160			170		1,60				2391,60
C 20/25	Mikserli	380	500	500	610		210			175		2,10				2377,10
C 25/30	Mikserli	380	500	500	600		250			155			2,50			2387,50
C 30/37	Mikserli	380	480	480	610		280			155			2,80			2387,80
C 35/45	Mikserli	400	450	450	620		320			155			4,16			2399,16
C 25/30 BRÜT	Mikserli	810	550	550			270			180		2,60				2362,60
C 25/30(MLZ)	S4	340	540	540	570		260			160		1,04	2,08			2413,12

Report Design

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

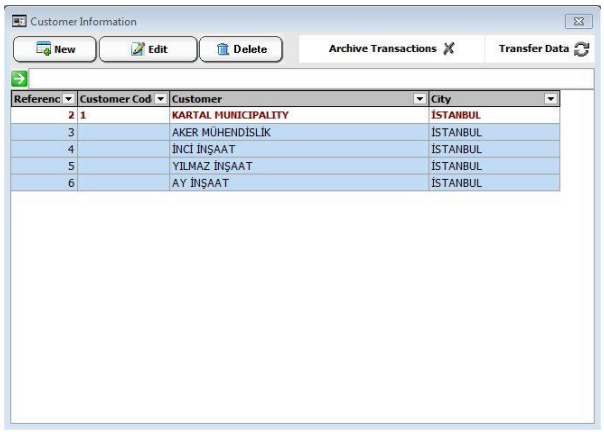
After requested design modifications, screen is closed by clicking on red X in the top right-hand corner. On exit, confirmation screen is displayed. Modifications are saved by clicking on “Yes”, screen is exited by clicking on “No” and design screen is switched back to by clicking on “Cancel”.

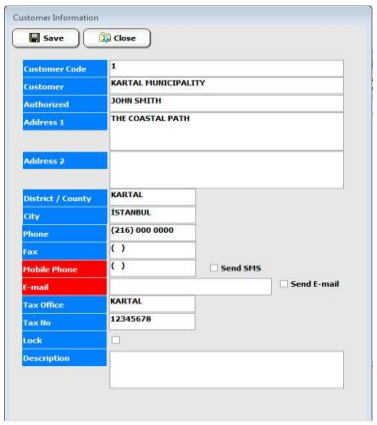
Entries

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”.





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.

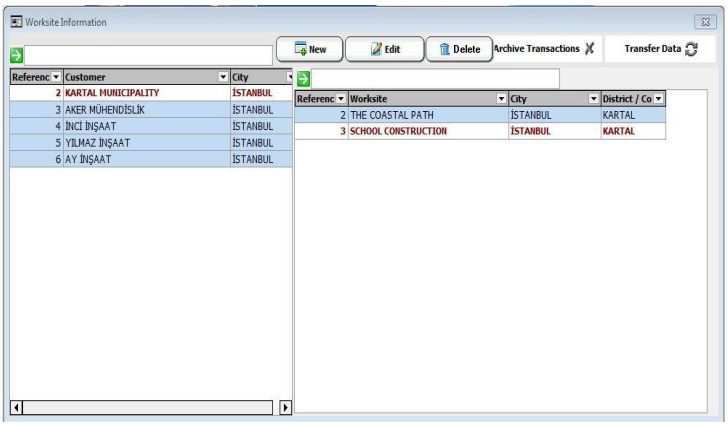
Information is saved by clicking on “Save”, screen is exited by clicking on “Close” without saving. Screen is closed by clicking on red X in the top right-hand corner.

Entries

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”.



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.

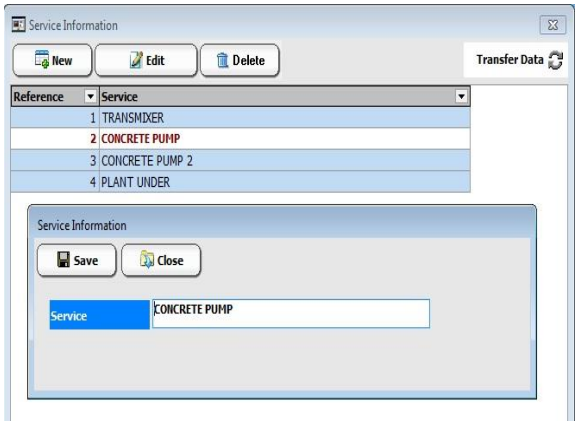
Information is saved by clicking on “Save”, screen is exited by clicking on “Close”. Screen is closed by clicking on red X in the top right-hand corner.

Entries

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”.



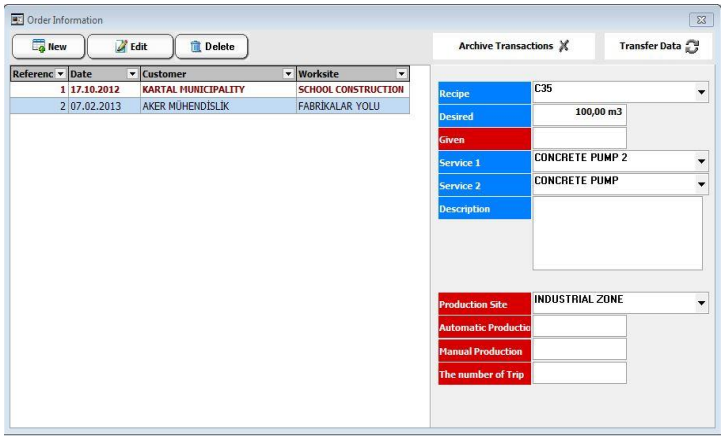
Information is saved by clicking on “Save”, screen is exited by clicking on “Close”. Screen is closed by clicking on red X in the top right-hand corner.

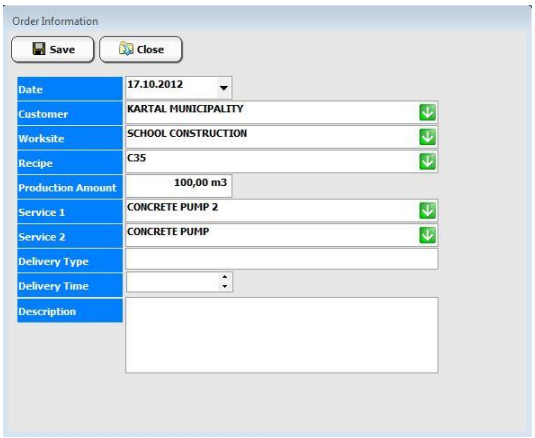
Entries

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”.

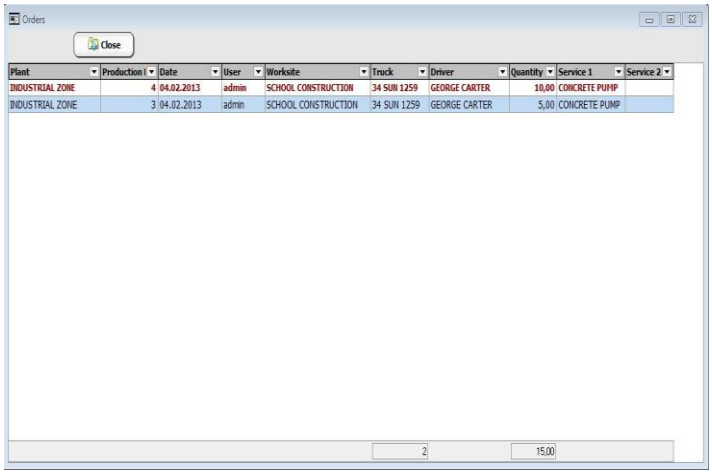


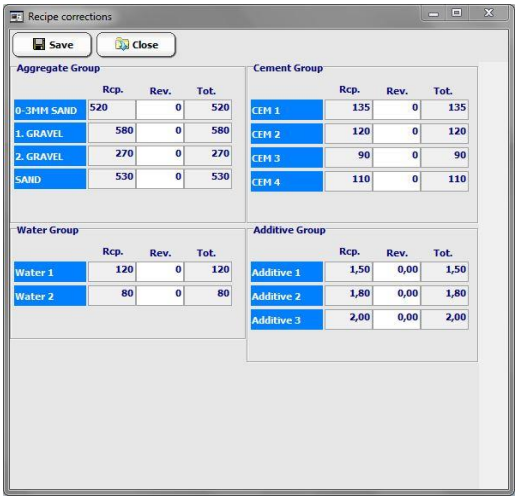


On correction screen, service, casting type, hour and descriptions may be entered as well as screen, date, client, worksite, recipe of order. Information is saved by clicking on “Save”, screen is exited by clicking on “Close” without saving.

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”.





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.

GÜNLÜK BETON SEVKİYAT ÇİZELGESİ

Tarih : 14.02.2012

POMPA 1(38 LİK)

Görev No	Müşteri	Şantiye	Vergi Dairesi	Vergi No	Beton Cinsi	Tahmini Miktar	Döküm Sekli	Slump Döküm Saati	Açıklama	Şantiye Adresi	Müşteri Telefon No
1	ÇENGEL TİCARET	MEHMET EDİZ/DAVUTLAR	KUŞADASI	2420017851	C 25/30 BÜRÜT	7 m³		S4 Saat :		DAVUTLAR GİRİŞİ YAGHANE KARŞİSI	(MEHMET ÇE
2	ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMİRCAN/DAVUTLAR	SELÇUK	900041005	C 30/37 BÜRÜT	20 m³		S4		DAVUTLAR ÇIKIŞI AYTEMİZ PETRÖL KARŞISI	(ASLANHAN
3	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTLAR	KUŞADASI	2420017851	C 20/25	16 m³		S4		DAVUTLAR ÇAVUŞ MOBİLYA YANI DAVUTLAR	(MEHMET ÇE

Toplam : 43 m³

POMPA 2(43 lük)

Görev No	Müşteri	Şantiye	Vergi Dairesi	Vergi No	Beton Cinsi	Tahmini Miktar	Döküm Sekli	Slump Döküm Saati	Açıklama	Şantiye Adresi	Müşteri Telefon No
1	BORE İNŞ.TAAH.SAN.TİÇ.AŞ	BORE İNŞAAT/KUŞADASI(2)			C 35/45	120 m³		S4 Saat :		KUŞADASI YAT LİMANI KARŞISI	(549) 736 91 (Süleyman Be
2	ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ KAVALCI/SÖKE	KUŞADASI	2420017851	C 35/45 BRÜT	30 m³		S4		SÖKE DEVLET HASTANESİ YANI	(MEHMET ÇE

Toplam : 150 m³

SANTRAL ALTI

Görev No	Müşteri	Şantiye	Vergi Dairesi	Vergi No	Beton Cinsi	Tahmini Miktar	Döküm Sekli	Slump Döküm Saati	Açıklama	Şantiye Adresi	Müşteri Telefon No
1	AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR BETON/ORTAKLAR	BUCAK	0080092134	C 25/30	50 m³		S3 Saat :		ORTAKLAR	(AS ADO HA

Toplam : 50 m³

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”.

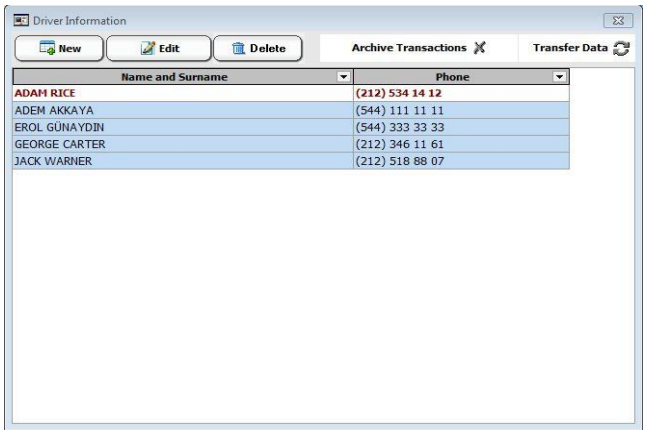
Screen is closed by clicking on red X in the top right-hand corner.

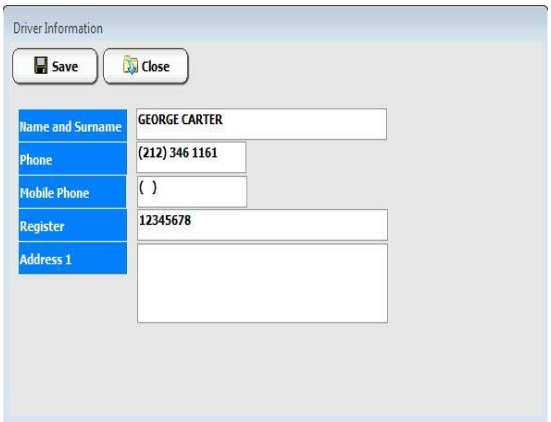
Entries

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”.





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

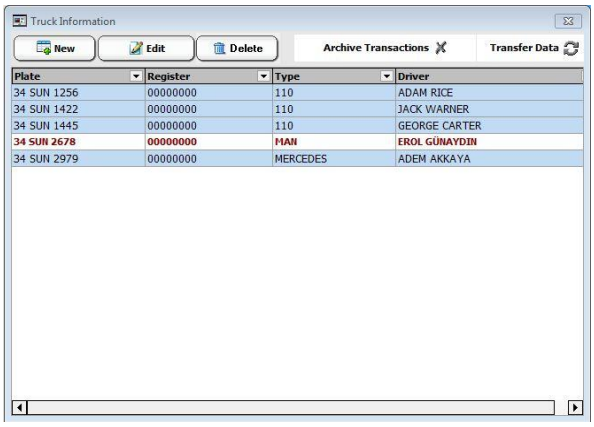
Information is saved by clicking on “Save”, screen is exited by clicking on “Close” without saving. Screen is closed by clicking on red X in the top right-hand corner.

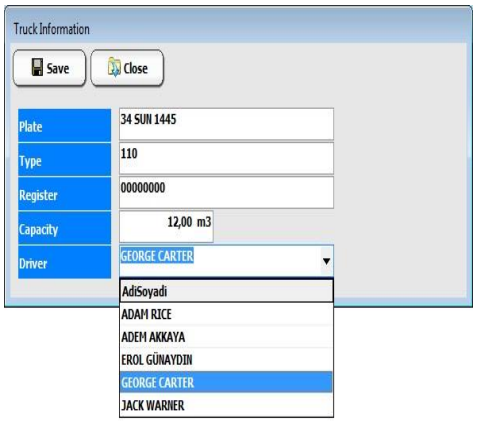
Entries

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”.





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.

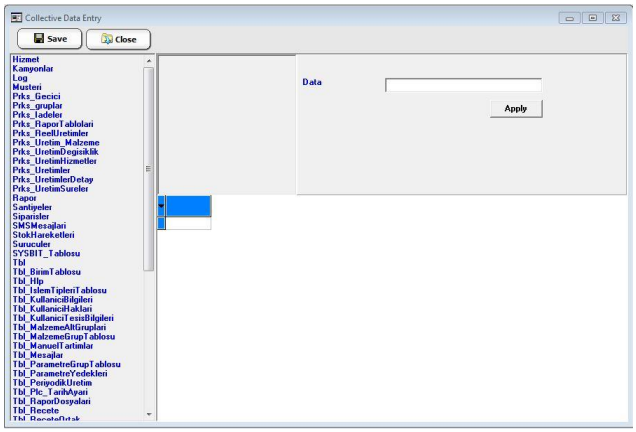
Information is saved by clicking on “Save”, screen is exited by clicking on “Close” without saving. Screen is closed by clicking on red X in the top right-hand corner.

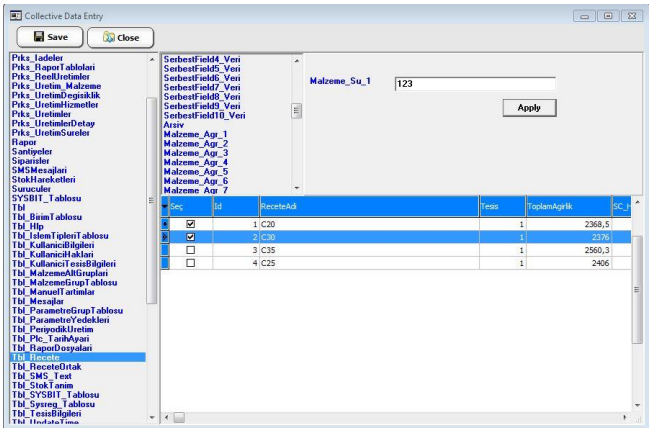
Entries

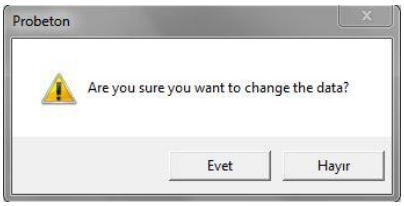
Collective Data Entry

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”.

Settings

Production Parameters

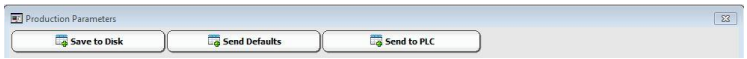
All durations and weight parameters, used in production process and control of production may be changed and monitored via this screen.

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.

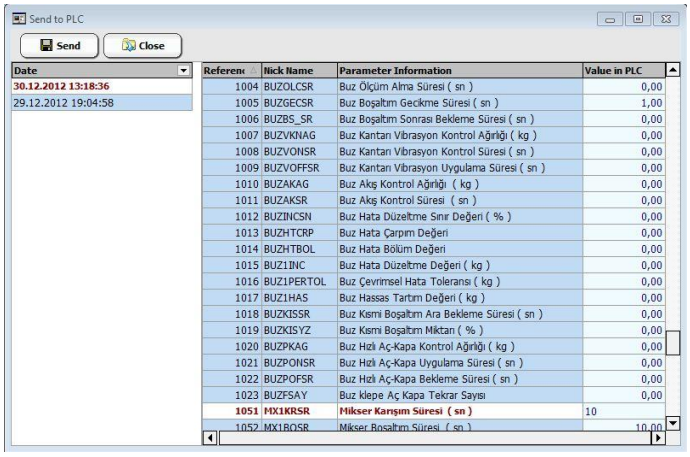
Note: In the event that “F10” is pressed, “technical parameters” are viewed. These parameters are the parameters which are not recommended to be changed by user and used in installation and service transactions.

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.

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.



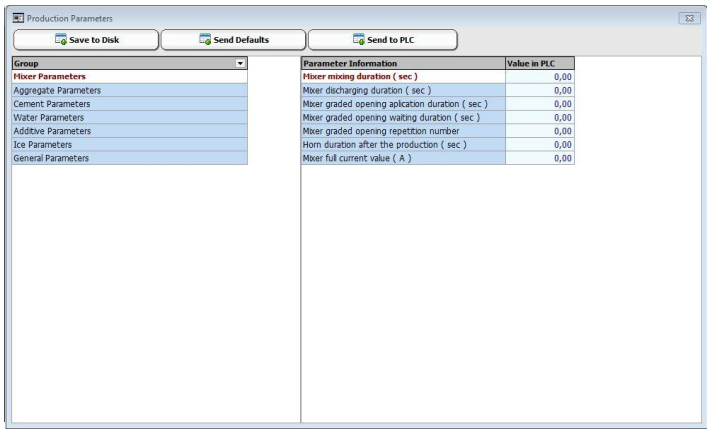
In the event that parameters in PLC are deleted or changed or changed accidentally, parameters saved already to disk may be sent to PLC. When “Send to PLC” button is clicked on, records saved previously appear at the left part. Requested record is selected and “Send” button is clicked on. Transaction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



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.

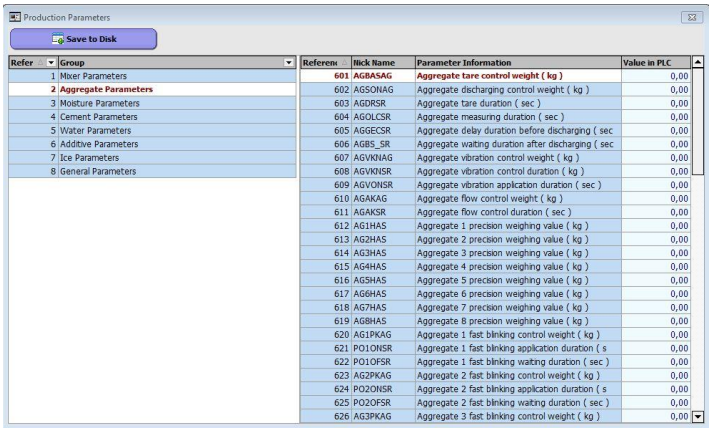
Mixer Parameters



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.

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

Aggregate Parameters



Refer	Group
1	Mixer Parameters
2	Aggregate Parameters
3	Moisture Parameters
4	Cement Parameters
5	Water Parameters
6	Additive Parameters
7	Ice Parameters
8	General Parameters

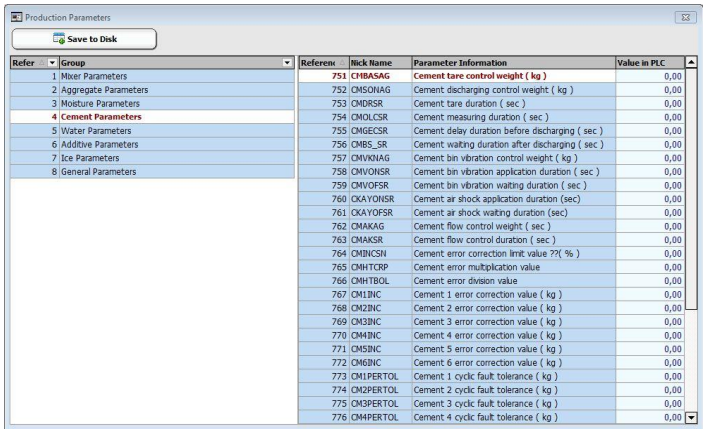
Referenc	Nick Name	Parameter Information	Value in PLC
601	AGBASAG	Aggregate tare control weight (kg)	0,00
602	AGSONAG	Aggregate discharging control weight (kg)	0,00
603	AGDRSR	Aggregate tare duration (sec)	0,00
604	AGOLCSR	Aggregate measuring duration (sec)	0,00
605	AGGECSR	Aggregate delay duration before discharging (sec	0,00
606	AGBS_SR	Aggregate waiting duration after discharging (sec	0,00
607	AGVKNAG	Aggregate vibration control weight (kg)	0,00
608	AGVKNSR	Aggregate vibration control duration (kg)	0,00
609	AGVONSR	Aggregate vibration application duration (sec)	0,00
610	AGAKAG	Aggregate flow control weight (kg)	0,00
611	AGAKSR	Aggregate flow control duration (sec)	0,00
612	AG1HAS	Aggregate 1 precision weighing value (kg)	0,00
613	AG2HAS	Aggregate 2 precision weighing value (kg)	0,00
614	AG3HAS	Aggregate 3 precision weighing value (kg)	0,00
615	AG4HAS	Aggregate 4 precision weighing value (kg)	0,00
616	AG5HAS	Aggregate 5 precision weighing value (kg)	0,00
617	AG6HAS	Aggregate 6 precision weighing value (kg)	0,00
618	AG7HAS	Aggregate 7 precision weighing value (kg)	0,00
619	AG8HAS	Aggregate 8 precision weighing value (kg)	0,00
620	AG1PKAG	Aggregate 1 fast blinking control weight (kg)	0,00
621	PO1ONSR	Aggregate 1 fast blinking application duration (s	0,00
622	PO1OFSR	Aggregate 1 fast blinking waiting duration (sec)	0,00
623	AG2PKAG	Aggregate 2 fast blinking control weight (kg)	0,00
624	PO2ONSR	Aggregate 2 fast blinking application duration (s	0,00
625	PO2OFSR	Aggregate 2 fast blinking waiting duration (sec)	0,00
626	AG3PKAG	Aggregate 3 fast blinking control weight (kg)	0,00

Aggregate 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.
Aggregate 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.
Aggregate tare duration	It should be waited for a while that scale becomes stable in order that scale vibrations don’t affect tare value before weighing.
Aggregate 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.
Aggregate delay duration before discharging (*)	A certain delay duration may be defined for each material before discharged to mixer.
Aggregate 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.
Aggregate 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”.
Aggregate Precision Weighing Values (*)	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.
Aggregate 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.
Weighing Belt Vibration Parameters	When weighing belt weight falls below “Control Weight” during discharge, vibration is applied in “Application duration”, it is waited in “waiting duration”.
Transfer Belt Transport 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



Refer	Group
1	Mixer Parameters
2	Aggregate Parameters
3	Moisture Parameters
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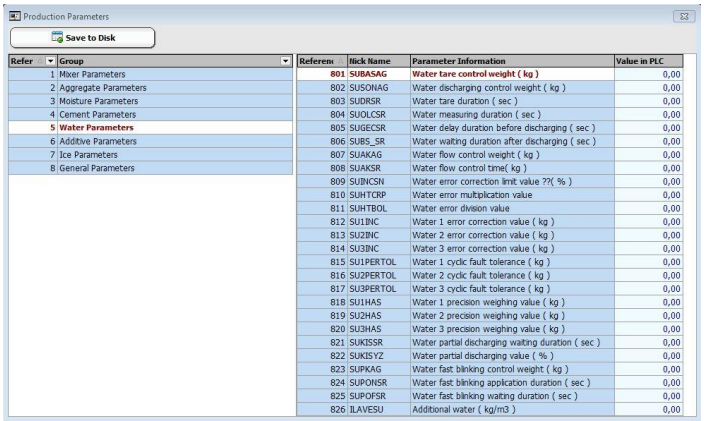
6	Additive Parameters
7	Ice Parameters
8	General Parameters

Referenc	Nick Name	Parameter Information	Value in PLC
751	CMBASAG	Cement tare control weight (kg)	0,00
752	CMSONAG	Cement discharging control weight (kg)	0,00
753	CMDRSR	Cement tare duration (sec)	0,00
754	CMOLCSR	Cement measuring duration (sec)	0,00
755	CMGECSR	Cement delay duration before discharging (sec)	0,00
756	CMBS_SR	Cement waiting duration after discharging (sec)	0,00
757	CMVKNAG	Cement bin vibration control weight (kg)	0,00
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
772	CM6INC	Cement 6 error correction value (kg)	0,00
773	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

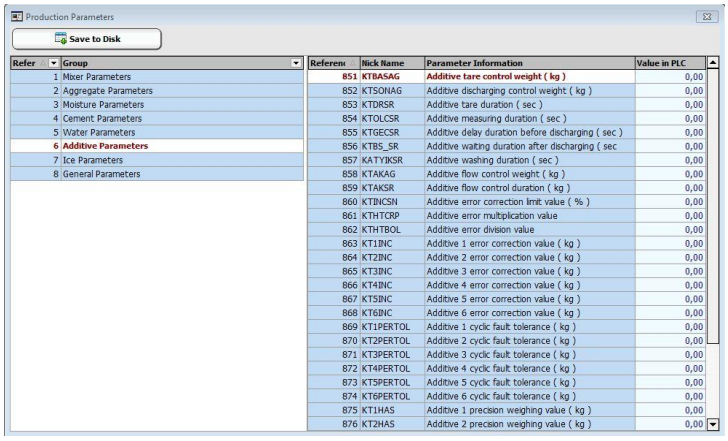


Refer	Group
1	Mixer Parameters
2	Aggregate Parameters
3	Moisture Parameters
4	Cement Parameters
5	Water Parameters
6	Additive Parameters
7	Ice Parameters
8	General Parameters

Referen	Nick Name	Parameter Information	Value in PLC
801	SUBASAG	Water tare control weight (kg)	0,00
802	SUSONAG	Water discharging control weight (kg)	0,00
803	SUDRSR	Water tare duration (sec)	0,00
804	SUOLCSR	Water measuring duration (sec)	0,00
805	SUGECSR	Water delay duration before discharging (sec)	0,00
806	SUBS_SR	Water waiting duration after discharging (sec)	0,00
807	SUAKAG	Water flow control weight (kg)	0,00
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	SU2INC	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)	0,00
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

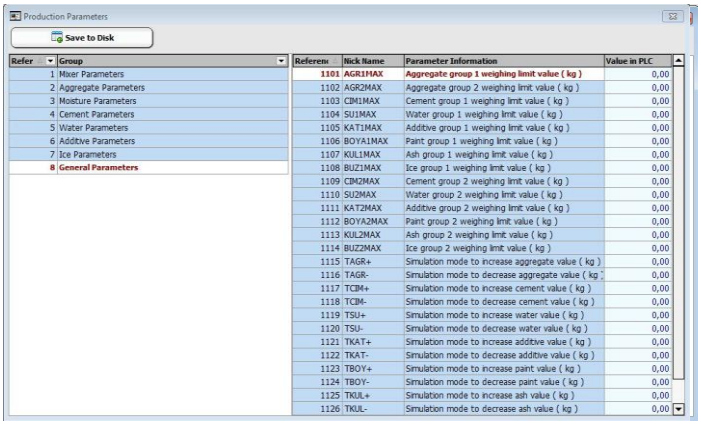
Water Tare Control Weight	In first cycle tare control is made in scales and if weight is high, “tare error” occurs. Scale should be discharged for solution, this value should be increased or indicator should be zeroed.
Water Discharging Control Weight	Scale discharging process is completed not by durations 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



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



Refer	Group
1	Mixer Parameters
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3	Moisture Parameters
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5	Water Parameters
6	Additive Parameters
7	Ice Parameters
8	General Parameters

Referen	Nick Name	Parameter Information	Value in PLC
1101	AGR1MAX	Aggregate group 1 weighing limit value (kg)	0,00
1102	AGR2MAX	Aggregate group 2 weighing limit value (kg)	0,00
1103	CIM1MAX	Cement group 1 weighing limit value (kg)	0,00
1104	SU1MAX	Water group 1 weighing limit value (kg)	0,00
1105	KATiMAX	Additive group 1 weighing limit value (kg)	0,00
1106	BOYA1MAX	Paint group 1 weighing limit value (kg)	0,00
1107	KUL1MAX	Ash group 1 weighing limit value (kg)	0,00
1108	BUZ1MAX	Ice group 1 weighing limit value (kg)	0,00
1109	CIM2MAX	Cement group 2 weighing limit value (kg)	0,00
1110	SU2MAX	Water group 2 weighing limit value (kg)	0,00
1111	KAT2MAX	Additive group 2 weighing limit value (kg)	0,00
1112	BOYA2MAX	Paint group 2 weighing limit value (kg)	0,00
1113	KUL2MAX	Ash group 2 weighing limit value (kg)	0,00
1114	BUZ2MAX	Ice group 2 weighing limit value (kg)	0,00
1115	TAGR+	Simulation mode to increase aggregate value (kg)	0,00
1116	TAGR-	Simulation mode to decrease aggregate value (kg)	0,00
1117	TCIM+	Simulation mode to increase cement value (kg)	0,00
1118	TCIM-	Simulation mode to decrease cement value (kg)	0,00
1119	TSU+	Simulation mode to increase water value (kg)	0,00
1120	TSU-	Simulation mode to decrease water value (kg)	0,00
1121	TKAT+	Simulation mode to increase additive value (kg)	0,00
1122	TKAT-	Simulation mode to decrease additive value (kg)	0,00
1123	TBOY+	Simulation mode to increase paint value (kg)	0,00
1124	TBOY-	Simulation mode to decrease paint value (kg)	0,00
1125	TKUL+	Simulation mode to increase ash value (kg)	0,00
1126	TKUL-	Simulation mode to decrease ash value (kg)	0,00

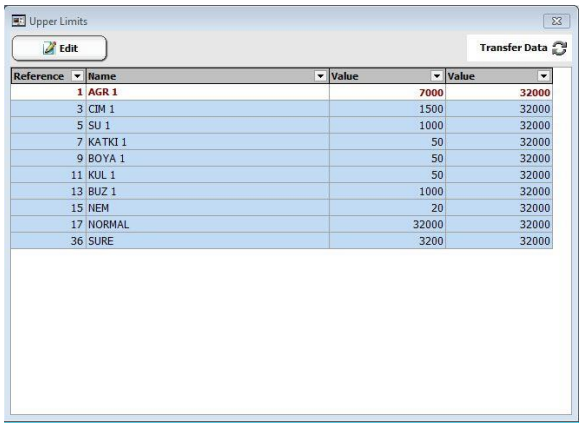
Weighing Limit Value	“Limit Value” may be entered for each weighing. In the event that these values are exceeded, weighing is stopped and user is warned.

Settings

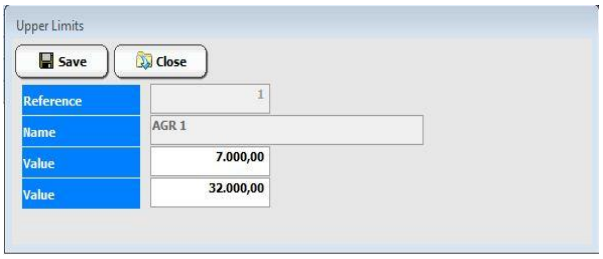
Upper Limits

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”.



Reference	Name	Value	Value
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



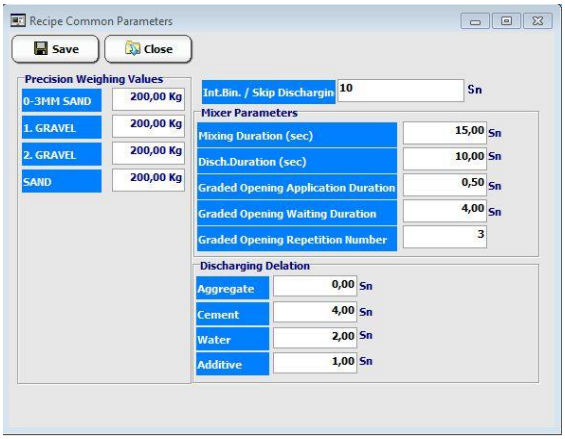
Second “value” expression appearing on screen is a technical parameter adjusted during installation and may vary with the feature of PLC used.

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.

Settings

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 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.

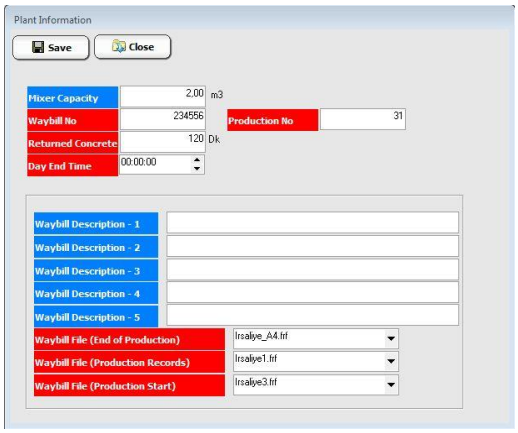
In Mixer Parameters, “mixing duration” may be defined since material is discharged to mixer and “discharging duration” where discharging door will be kept open may be defined. In order that discharging transaction be made in a controlled manner, discharging door is opened gradually. Door is opened in “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.

Settings

Plant Information

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



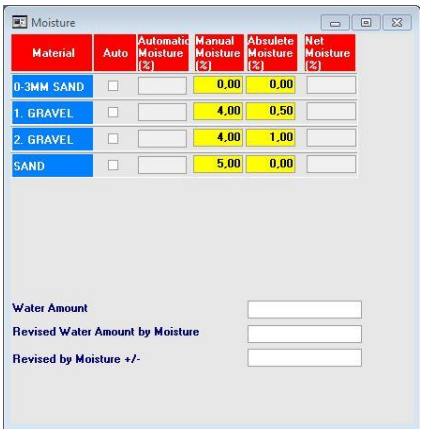
Mixer Capacity	Maximum concrete amount which may be produced in one cycle.
Waybill and Production No	Waybill number and production number are increased automatically at the end of each production. By the use of this screen waybill and production number may be changed.
Returned Concrete Duration	Maximum 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.

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

Settings

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.

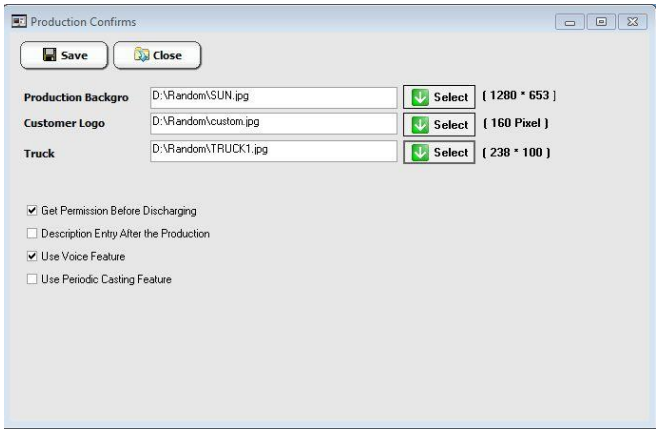
In the calculation, moisture amount in aggregate (kg) is deducted from water amount on recipe and added into related aggregate. At the bottom of screen “water amount” will be deducted from water amount on recipe after moisture calculation (if absolute moisture is higher), “Moisture Revision” and “Moisture 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.

Settings

Confirmations

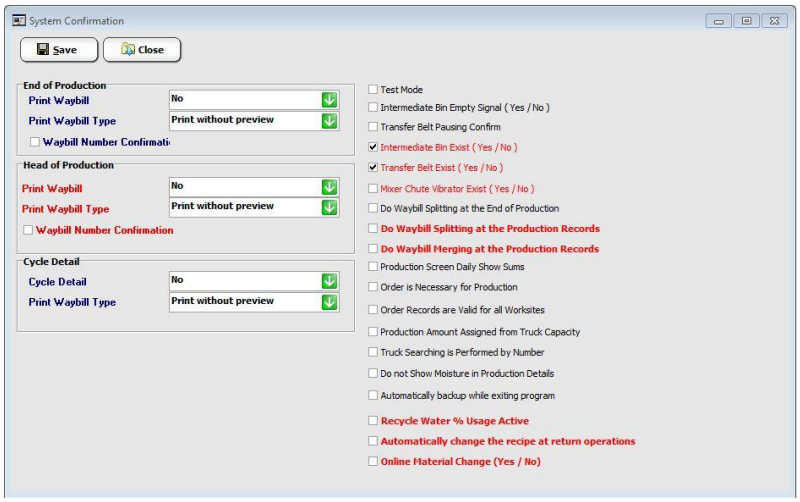
Production Confirms



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.

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

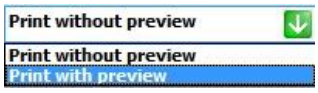
System Confirms



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.



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 is 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 transactions 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.

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

Vibrator Confirms

Vibrators used in system may be defined on this screen.

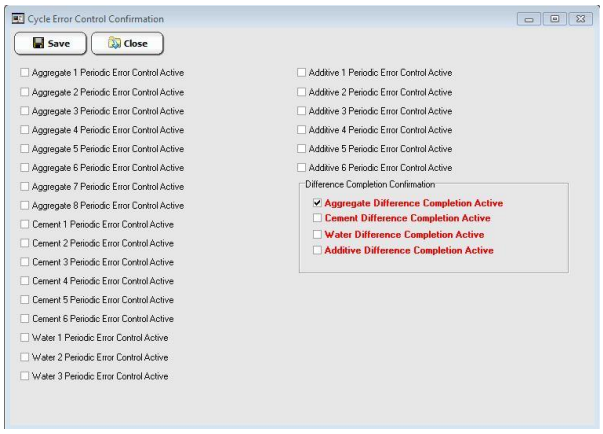
Information is saved by clicking on “Save” and screen is exited by clicking on “Close”.

Indicator Confirms

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

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

Periodic Error Control Confirms



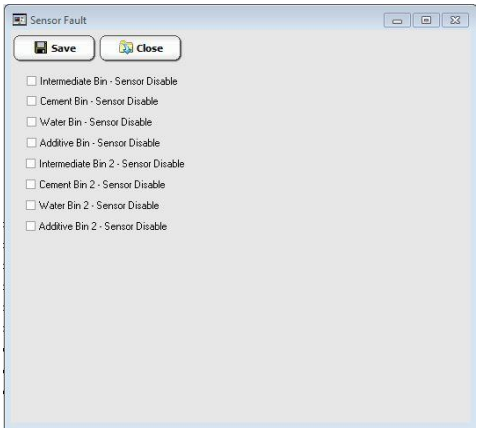
Periodic error control is made for selected material. If negative or positive error is available except “cyclic error tolerance” entered in “production parameters”, a message appears on screen. User may continue production, if incomplete material is received, “difference completion” can be made or production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

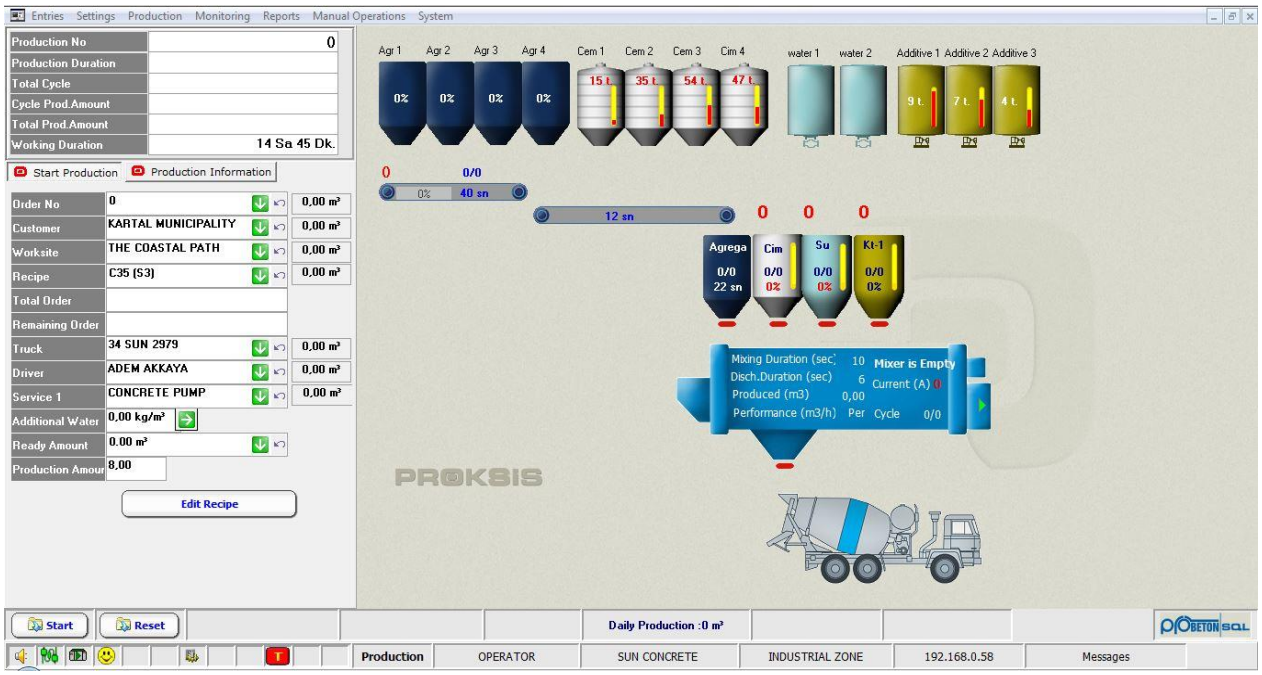
Until sensor is replaced, related sensor is deactivated in order to continue production.

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

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.



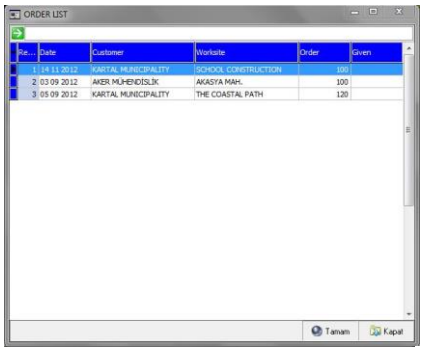
Information at upper left part:

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.

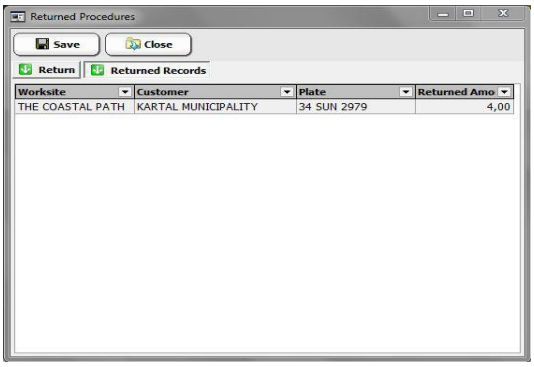
Truck information selection is made in accordance with license plate or vehicle number. This option is available in “Settings-Confirmations-System Confirmations”. Driver defined to related truck is displayed automatically. A different driver may be selected by using driver selection button.

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.

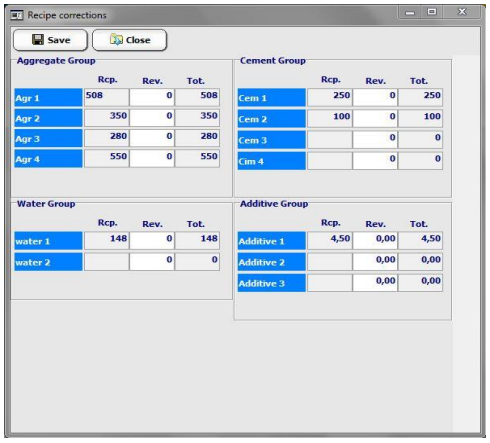
After entering amount, selection should be sent to PLC by using arrow icon.

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.

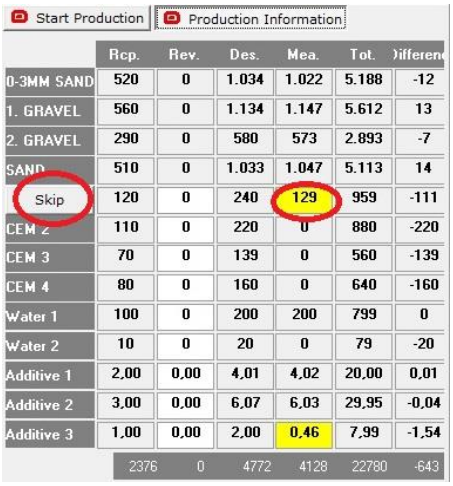


Amounts to be increased or decreased amounts per m3 for related material are entered in middle “Correction” box on the appearing window. Original recipe amounts and amounts calculated are displayed in left and right columns respectively. Correction amounts are limited with “minimum and maximum recipe 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



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.

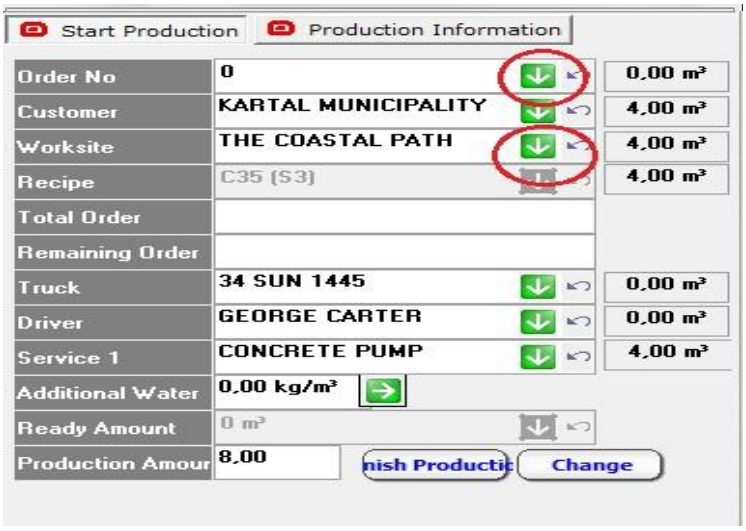
At the bottom of production screen “Customer”, “Worksite”, “ Recipe”, “Daily Production Quantity”, “Service”, “Plate of Truck and Trip no.” information are displayed respectively.

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.

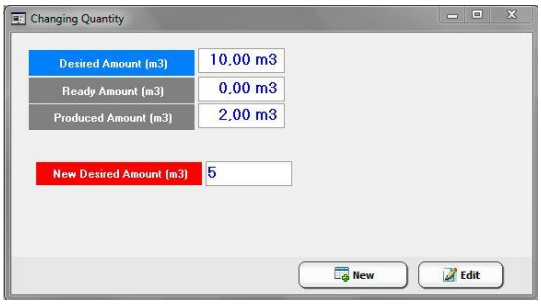
If “reset” button is clicked on when there is no production, confirmation screen is displayed. When confirmed, production values are zeroed on production screen and PLC. When “Reset” is clicked on during production, production is suspended and options to continue or reset are offered. When reset, production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

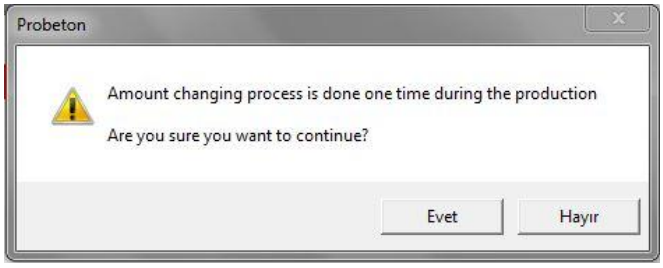
Clicking on “Correction” column during production, it is possible to increase or decrease the amounts therein without changing recipe values.

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”.



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.



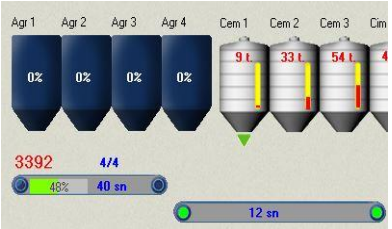


Production Plan

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

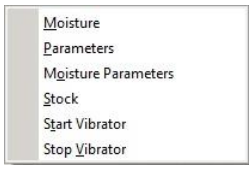
Graphical Screen

Aggregate



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

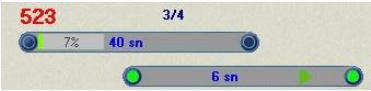
When any bunker picture is right clicked on, “easy access menu” appears.



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.

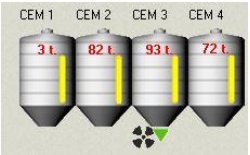
When any belt picture is right clicked on, “easy access menu” appears. It is possible to access to parameters of aggregate group on menu.

	“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.		“Discharging door is open” signal.
	“Open discharging door” command.		Vibration.

Cement



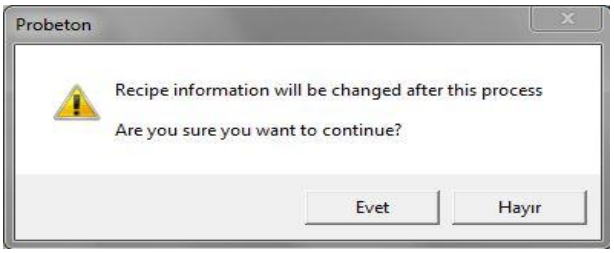
Over cement silos there are material names, stock quantities and stock level bar are located on them. When right clicked on any silo image, “easy access menu” appears. Level display is made in accordance with the values entered on the screen of “first transactions-silo capacities”.

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.

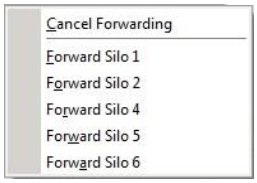
Note **:** Clicking on F10, detailed parameters may be displayed.

▼	“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.

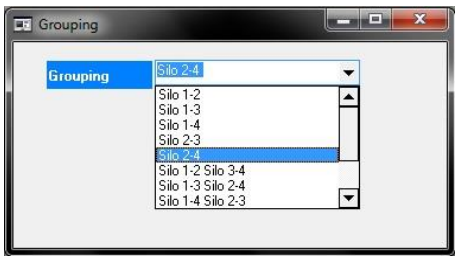


Forwarding and Grouping feature:



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.



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.
	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.

.

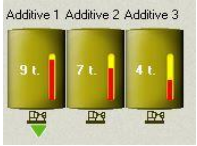
Note: When F10 is clicked on parameter screens, detailed parameters may be displayed.

	“Open valve” command. One or two valves are opened in accordance with precision weighing feature.

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.

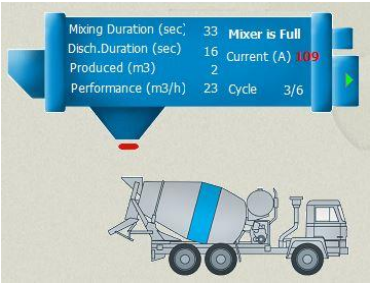
Note: When F10 is clicked on parameter screens, detailed parameters may be displayed.

	“Start pump” command.

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.

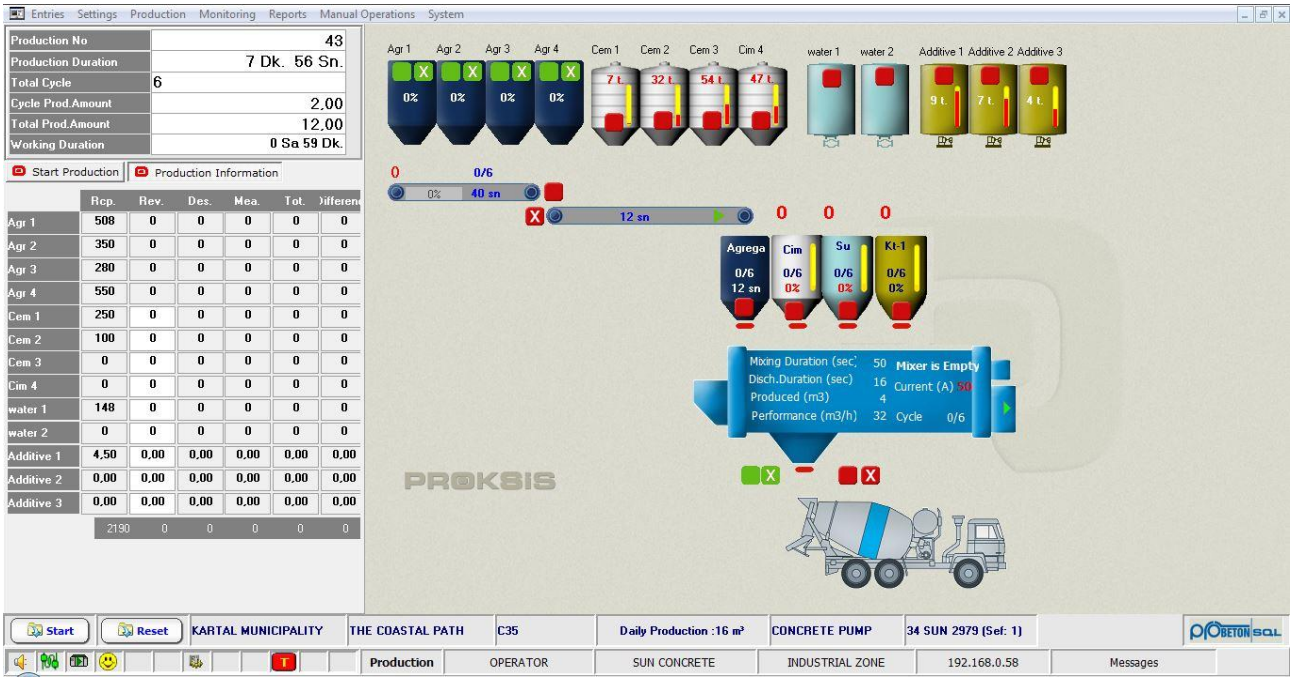
Mixer full/empty information may be shown in accordance with digital or analog information received from mixer ammeter. In the event that analog information is received, instant current value is compared with” mixer full current value”. If current at that time is higher than this value, “full” information 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.

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.

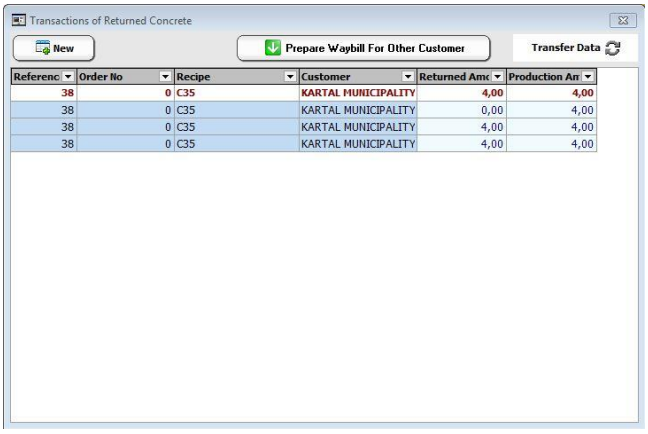
Form Width, Height, and Margin from Top: Dimensions of production screen and how much lower it will be placed from top right part of screen may be determined.

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.

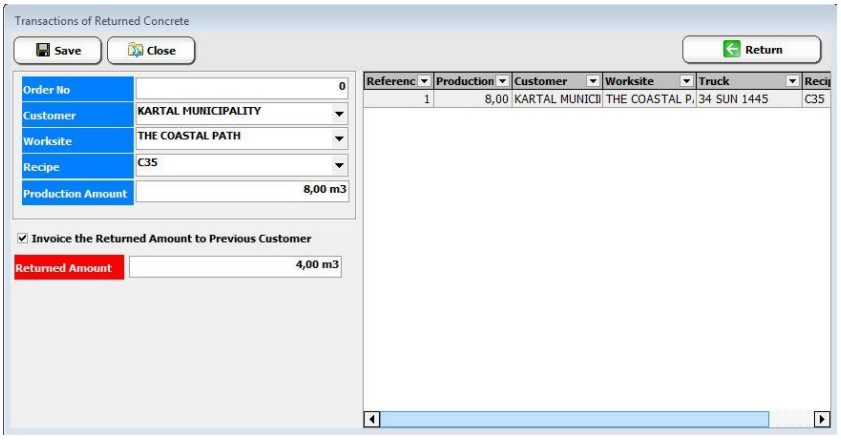
Production

Returned Concrete Transactions

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



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.



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.

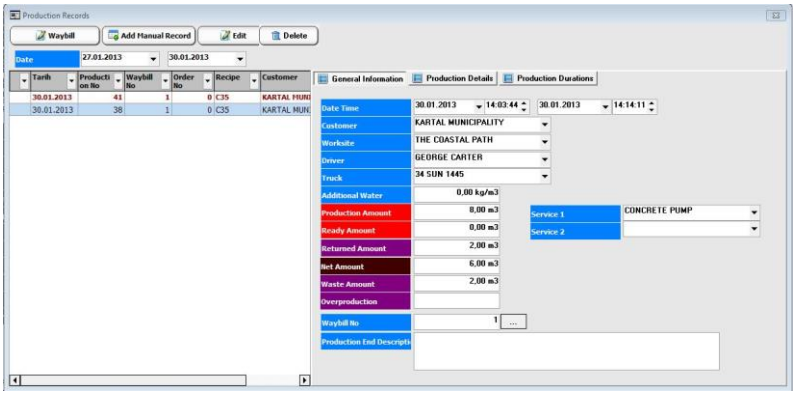
If required, the entire production defined as returned may be transferred to a different customer without making a new production. Thus clicking on “Prepare Waybill for Other Customer”, “manual production screen” appears, information is arranged and recording and waybill transactions are carried out.

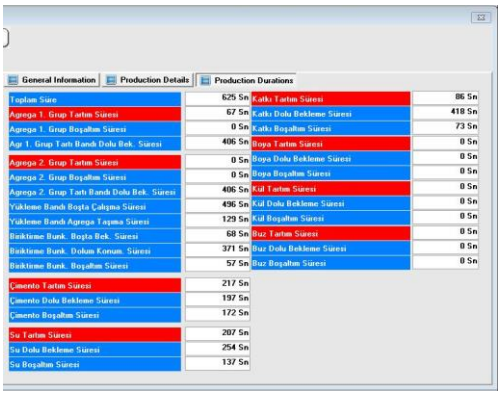
“Transfer Data” transaction is detailed in “Entries-Stock Entry”. Screen is closed by clicking on red “X” in the top right-hand corner.

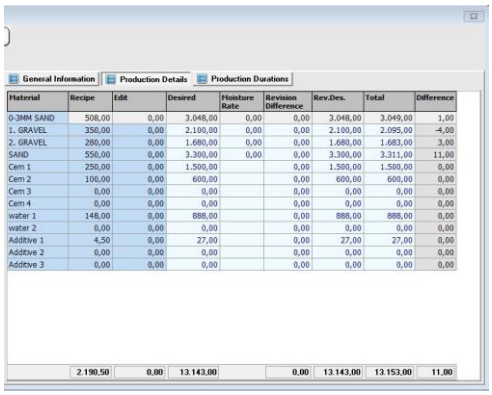
Production Records

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.



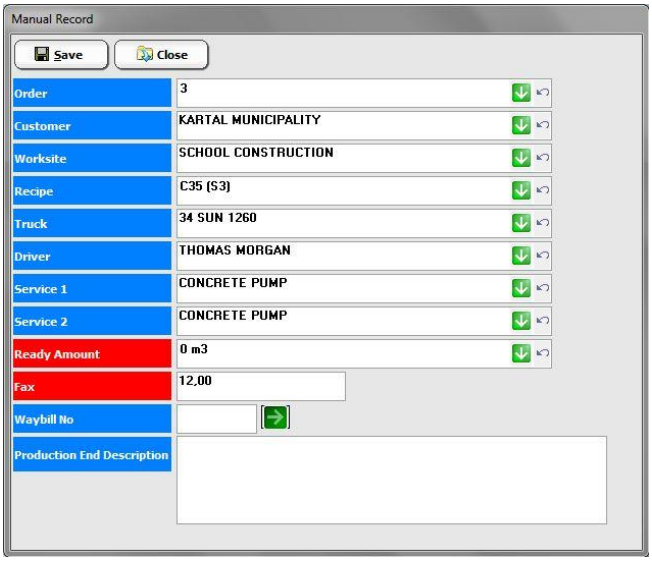




Buttons taking place at upper part;

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.



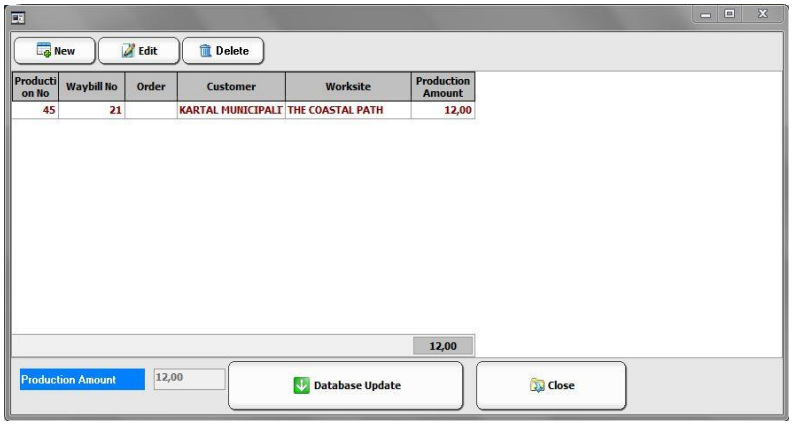
When “correct” button is clicked on, “Save” button is displayed. Requested information modification is made and saved by clicking on “Save”.

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

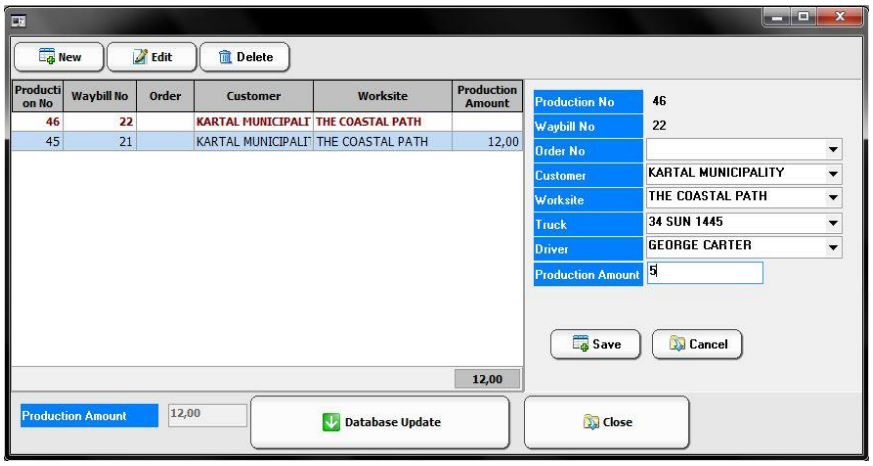
Any record is right clicked on, transaction menu is displayed.

Waybill Splitting

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



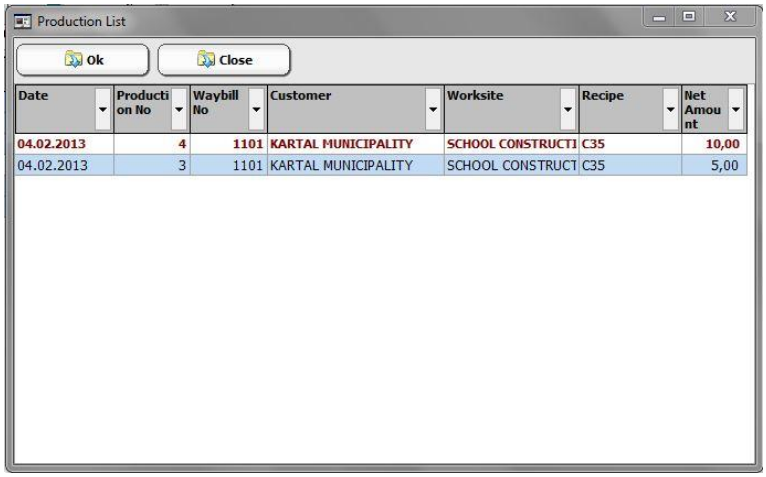
In the opening window, “New” is clicked on. At the right part new waybill information to be created is displayed. After amount entry and modification of other information, they are saved by clicking on “Save” and right section is closed by clicking on “Cancel”.



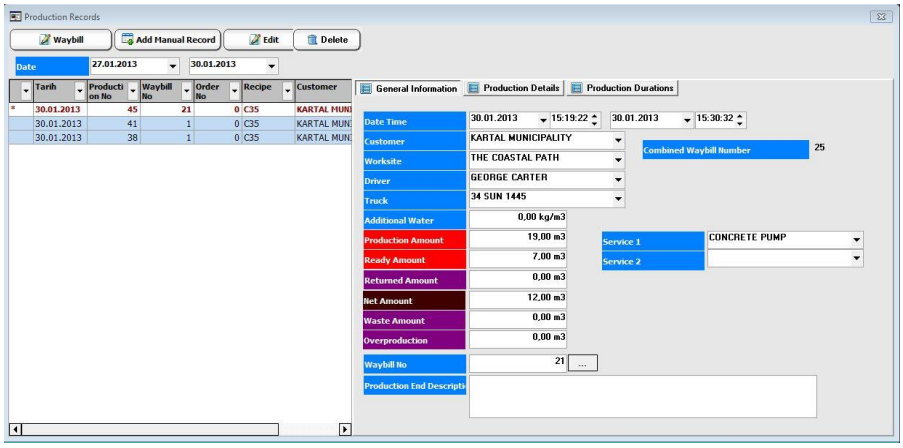
Clicking “Correct” and “Delete” buttons, it is possible to make modification on the records created. Information is saved by clicking on “Ok”. Screen is “Closed” by clicking on “Close” without saving.

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.



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



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

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.

PRODUCTION DETAIL

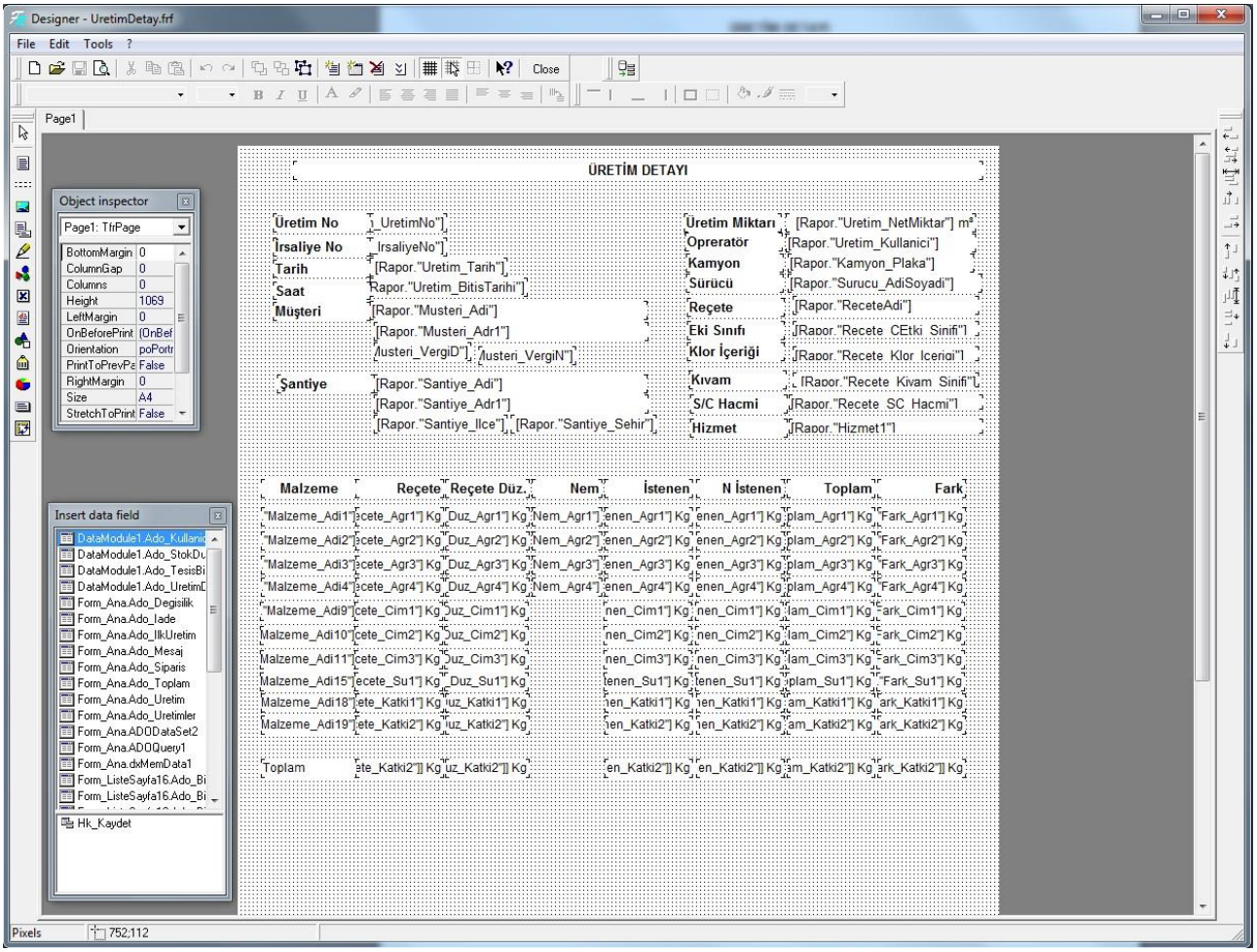
Production No	3	Production Amount	5 m³
Waybill No	1101	Oprerator	admin
Date	04.02.2013	Truck	34 SUN 1259
Time	14:07:41	Driver	GEORGE CARTER
Customer	KARTAL MUNICIPALITY THE COASTAL PATH	Reoipe	C35
		Effect Class	22
		Chlorine Content	XC3
Worksite	SCHOOL CONSTRUCTION	Consistency	S3
		W/C Volume	0,43
	TUZLA İSTANBUL	Service	CONCRETE PUMP

Material	Reoipe	Reoipe	Moisture Rate	Desired	N Desired	Total	Differen	Fark (%)
Agr 1	520 Kg	Kg	-0,03	2600 Kg	2599 Kg	2594 Kg	-5 Kg	% -0,19
Agr 2	580 Kg	Kg	-0,03	2900 Kg	2899 Kg	2894 Kg	-5 Kg	% -0,17
Agr 3	270 Kg	Kg		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	% -0,19
	Kg	Kg		Kg	Kg	Kg	Kg	%
	Kg	Kg		Kg	Kg	Kg	Kg	%
	Kg	Kg		Kg	Kg	Kg	Kg	%
	Kg	Kg		Kg	Kg	Kg	Kg	%
Cim 1	135 Kg	Kg		675 Kg	675 Kg	675 Kg	Kg	%
Cim 2	120 Kg	Kg		600 Kg	600 Kg	600 Kg	Kg	%
Cim 3	90 Kg	Kg		450 Kg	450 Kg	450 Kg	Kg	%
Cim 4	110 Kg	Kg		550 Kg	550 Kg	551 Kg	1 Kg	% 0,18
Su 1	120 Kg	Kg		600 Kg	600 Kg	600 Kg	Kg	%
Su 2	80 Kg	Kg		400 Kg	400 Kg	399 Kg	-1 Kg	%
Katkı 1	1,5 Kg	Kg		7,5 Kg	7 Kg	8 Kg	1 Kg	% 14,29
Katkı 2	1,8 Kg	Kg		9 Kg	9 Kg	9 Kg	Kg	%
Katkı 3	2 Kg	Kg		10 Kg	10 Kg	10 Kg	Kg	% 14,29
	Kg	Kg		Kg	Kg	Kg	Kg	%
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”


Designer - UretimDetay.frf
File Edit Tools ?
Close
Page1
Object inspector
Page1: TfrPage
BottomMargin 0
ColumnGap 0
Columns 0
Height 1069
LeftMargin 0
OnBeforePrint (OnBef
Orientation poPortr
PrintToPrevPa False
RightMargin 0
Size A4
StretchToPrint False
Insert data field
DataModule1.Ado_Kullanic
DataModule1.Ado_StokDu
DataModule1.Ado_TesisBi
DataModule1.Ado_UretimD
Form_Ana.Ado_Degisilik
Form_Ana.Ado_Iade
Form_Ana.Ado_IlkUretim
Form_Ana.Ado_Mesaj
Form_Ana.Ado_Siparis
Form_Ana.Ado_Toplam
Form_Ana.Ado_Uretim
Form_Ana.Ado_Uretimler
Form_Ana.ADODataSet2
Form_Ana.ADOQuery1
Form_Ana.dxMemData1
Form_ListeSayfa16.Ado_Bi
Form_ListeSayfa16.Ado_Bi
Hk_Kaydet
ÜRETİM DETAYI
Üretim No
İrsaliye No
Tarih
Saat
Müşteri
Şantiye
Üretim Miktarı
Opreratör
Kamyon
Sürücü
Reçete
Eki Sınıfı
Klor İçeriği
Kıvam
S/C Hacmi
Hizmet
Malzeme
Reçete
Reçete Düz.
Nem
İstenen
N İstenen
Toplam
Fark
Toplam
Pixels
752;112

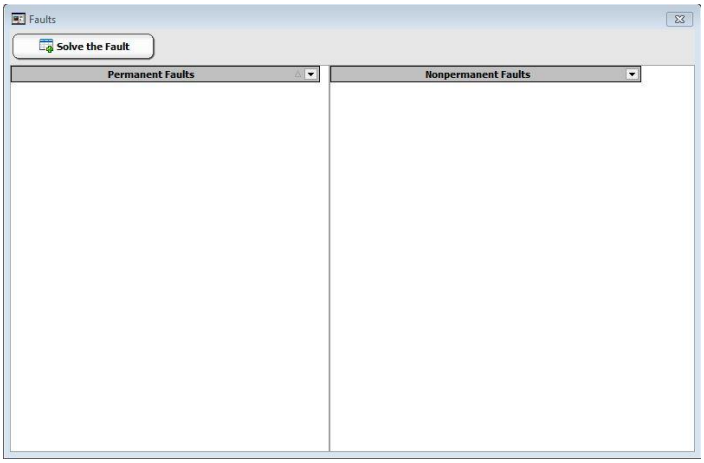
Monitoring

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



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.

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

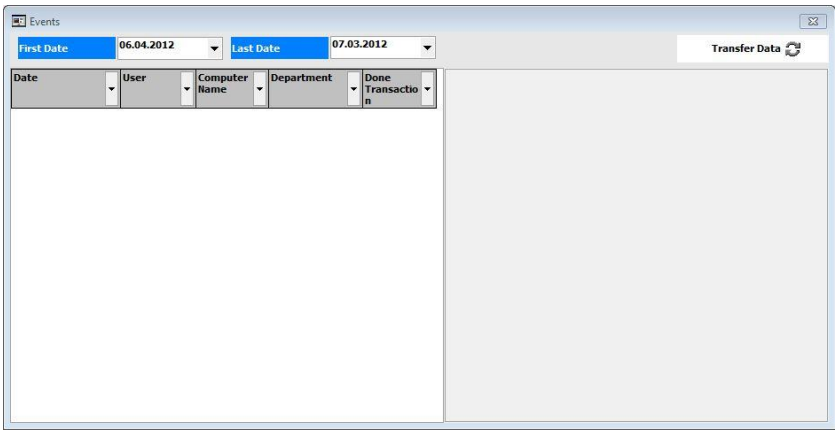
Monitoring

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.

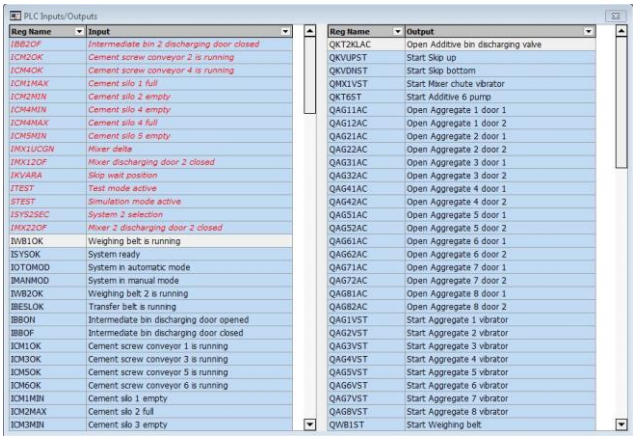


Screen is closed by clicking on red “X” in the top right-hand corner.

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
IBB2OF	*Intermediate bin 2 discharging door closed*
ICM2OK	*Cement screw conveyor 2 is running*
ICM4OK	*Cement screw conveyor 4 is running*
ICM1MAX	*Cement silo 1 full*
ICM2MIN	*Cement silo 2 empty*
ICM4MIN	*Cement silo 4 empty*
ICM4MAX	*Cement silo 4 full*
ICM5MIN	*Cement silo 5 empty*
IMX1UCGN	*Mixer delta*
IMX12OF	*Mixer discharging door 2 closed*
IKVARA	*Skip wait position*
ITEST	*Test mode active*
STEST	*Simulation mode active*
ISYS2SEC	*System 2 selection*
IMX22OF	*Mixer 2 discharging door 2 closed*
IWB1OK	Weighing belt is running
ISYSOK	System ready
IOTOMOD	System in automatic mode
IMANMOD	System in manual mode
IWB2OK	Weighing belt 2 is running
IBESLOK	Transfer belt is running
IBBON	Intermediate bin discharging door opened
IBBOF	Intermediate bin discharging door closed
ICM1OK	Cement screw conveyor 1 is running
ICM3OK	Cement screw conveyor 3 is running
ICM5OK	Cement screw conveyor 5 is running
ICM6OK	Cement screw conveyor 6 is running
ICM1MIN	Cement silo 1 empty
ICM2MAX	Cement silo 2 full
ICM3MIN	Cement silo 3 empty

Reg Name	Output
QKT2KLAC	Open Additive bin discharging valve
QKVUPST	Start Skip up
QKVDNST	Start Skip bottom
QMX1VST	Start Mixer chute vibrator
QKT6ST	Start Additive 6 pump
QAG11AC	Open Aggregate 1 door 1
QAG12AC	Open Aggregate 1 door 2
QAG21AC	Open Aggregate 2 door 1
QAG22AC	Open Aggregate 2 door 2
QAG31AC	Open Aggregate 3 door 1
QAG32AC	Open Aggregate 3 door 2
QAG41AC	Open Aggregate 4 door 1
QAG42AC	Open Aggregate 4 door 2
QAG51AC	Open Aggregate 5 door 1
QAG52AC	Open Aggregate 5 door 2
QAG61AC	Open Aggregate 6 door 1
QAG62AC	Open Aggregate 6 door 2
QAG71AC	Open Aggregate 7 door 1
QAG72AC	Open Aggregate 7 door 2
QAG81AC	Open Aggregate 8 door 1
QAG82AC	Open Aggregate 8 door 2
QAG1VST	Start Aggregate 1 vibrator
QAG2VST	Start Aggregate 2 vibrator
QAG3VST	Start Aggregate 3 vibrator
QAG4VST	Start Aggregate 4 vibrator
QAG5VST	Start Aggregate 5 vibrator
QAG6VST	Start Aggregate 6 vibrator
QAG7VST	Start Aggregate 7 vibrator
QAG8VST	Start Aggregate 8 vibrator
QWB1ST	Start Weighing belt

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

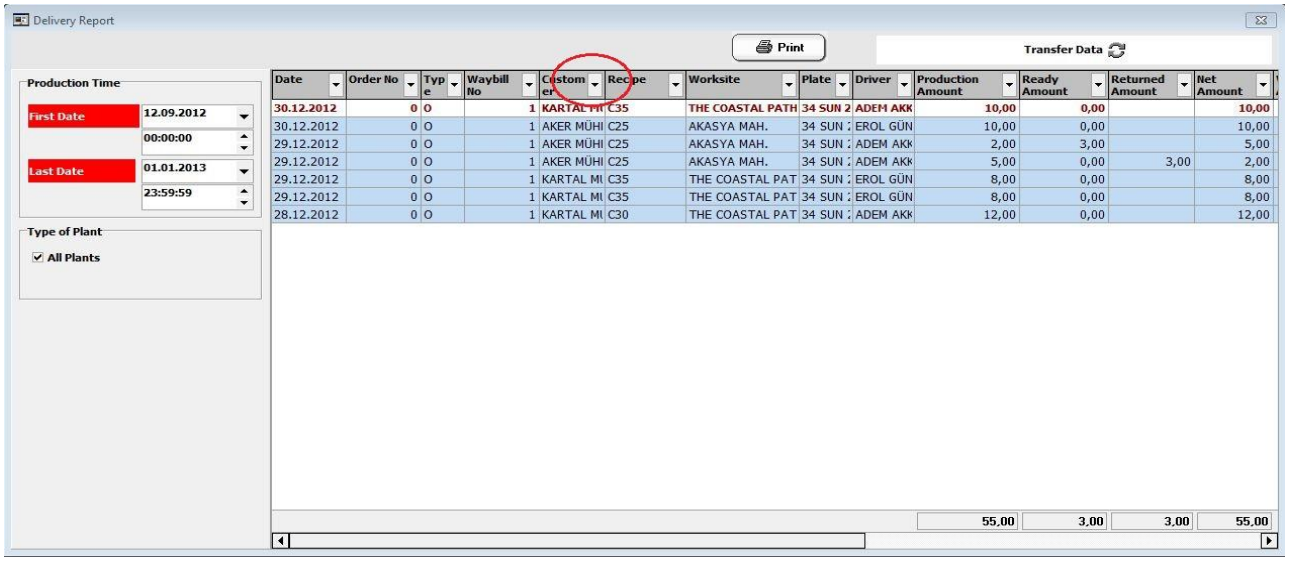
Reports

Delivery Report

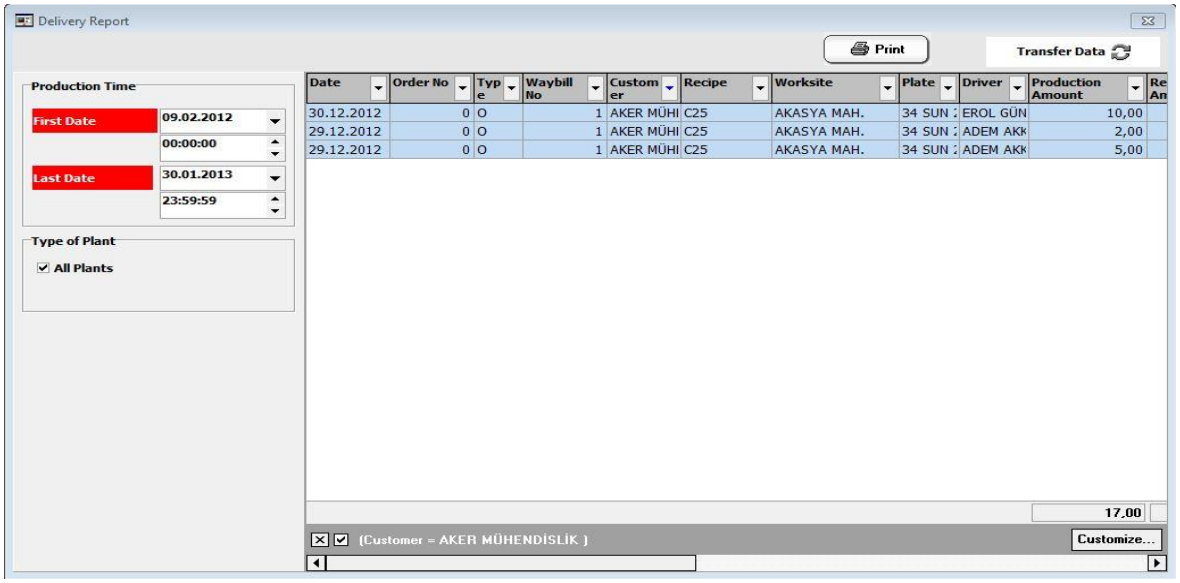
Changing “First Date” and “Last Date” at the upper part, productions made may be listed between two dates and sent to Printer by clicking on “Print”.

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

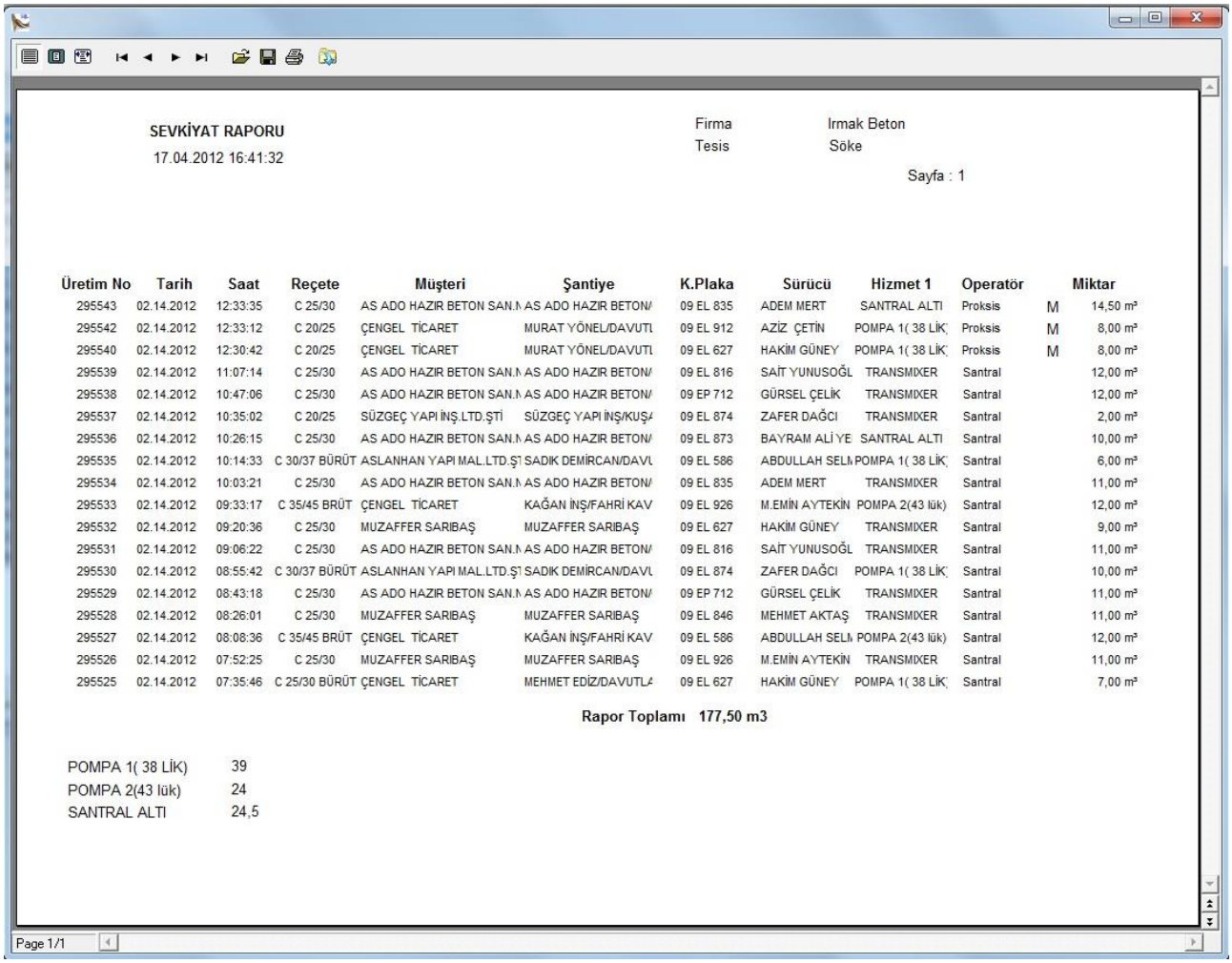
Screen is closed by clicking on red “X” in the top right-hand corner.



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



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



SEVKİYAT RAPORU
17.04.2012 16:41:32

Firma Irmak Beton
Tesis Söke

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.N	AS ADO HAZIR BETON/	09 EL 835	ADEM MERT	SANTRAL ALTI	Proksis	M	14,50 m³
295542	02.14.2012	12:33:12	C 20/25	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTL	09 EL 912	AZİZ ÇETİN	POMPA 1(38 LİK)	Proksis	M	8,00 m³
295540	02.14.2012	12:30:42	C 20/25	ÇENGEL TİCARET	MURAT YÖNEL/DAVUTL	09 EL 627	HAKİM GÜNEY	POMPA 1(38 LİK)	Proksis	M	8,00 m³
295539	02.14.2012	11:07:14	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EL 816	SAİT YUNUSOĞL	TRANSMIXER	Santral		12,00 m³
295538	02.14.2012	10:47:06	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EP 712	GÜRSEL ÇELİK	TRANSMIXER	Santral		12,00 m³
295537	02.14.2012	10:35:02	C 20/25	SÜZGEÇ YAPI İNŞ.LTD.ŞTİ	SÜZGEÇ YAPI İNŞ/KUŞA	09 EL 874	ZAFER DAĞCI	TRANSMIXER	Santral		2,00 m³
295536	02.14.2012	10:26:15	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EL 873	BAYRAM ALİ YE	SANTRAL ALTI	Santral		10,00 m³
295535	02.14.2012	10:14:33	C 30/37 BÜRÜT	ASLANHAN YAPI MAL.LTD.ŞT	SADIK DEMİRCAN/DAVU	09 EL 586	ABDULLAH SELM	POMPA 1(38 LİK)	Santral		6,00 m³
295534	02.14.2012	10:03:21	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EL 835	ADEM MERT	TRANSMIXER	Santral		11,00 m³
295533	02.14.2012	09:33:17	C 35/45 BRÜT	ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ KAV	09 EL 926	M.EMİN AYTEKİN	POMPA 2(43 lük)	Santral		12,00 m³
295532	02.14.2012	09:20:36	C 25/30	MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	09 EL 627	HAKİM GÜNEY	TRANSMIXER	Santral		9,00 m³
295531	02.14.2012	09:06:22	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EL 816	SAİT YUNUSOĞL	TRANSMIXER	Santral		11,00 m³
295530	02.14.2012	08:55:42	C 30/37 BÜRÜT	ASLANHAN YAPI MAL.LTD.ŞT	SADIK DEMİRCAN/DAVU	09 EL 874	ZAFER DAĞCI	POMPA 1(38 LİK)	Santral		10,00 m³
295529	02.14.2012	08:43:18	C 25/30	AS ADO HAZIR BETON SAN.N	AS ADO HAZIR BETON/	09 EP 712	GÜRSEL ÇELİK	TRANSMIXER	Santral		11,00 m³
295528	02.14.2012	08:26:01	C 25/30	MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	09 EL 846	MEHMET AKTAŞ	TRANSMIXER	Santral		11,00 m³
295527	02.14.2012	08:08:36	C 35/45 BRÜT	ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ KAV	09 EL 586	ABDULLAH SELM	POMPA 2(43 lük)	Santral		12,00 m³
295526	02.14.2012	07:52:25	C 25/30	MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	09 EL 926	M.EMİN AYTEKİN	TRANSMIXER	Santral		11,00 m³
295525	02.14.2012	07:35:46	C 25/30 BÜRÜT	ÇENGEL TİCARET	MEHMET EDİZ/DAVUTLA	09 EL 627	HAKİM GÜNEY	POMPA 1(38 LİK)	Santral		7,00 m³

Rapor Toplamı 177,50 m3

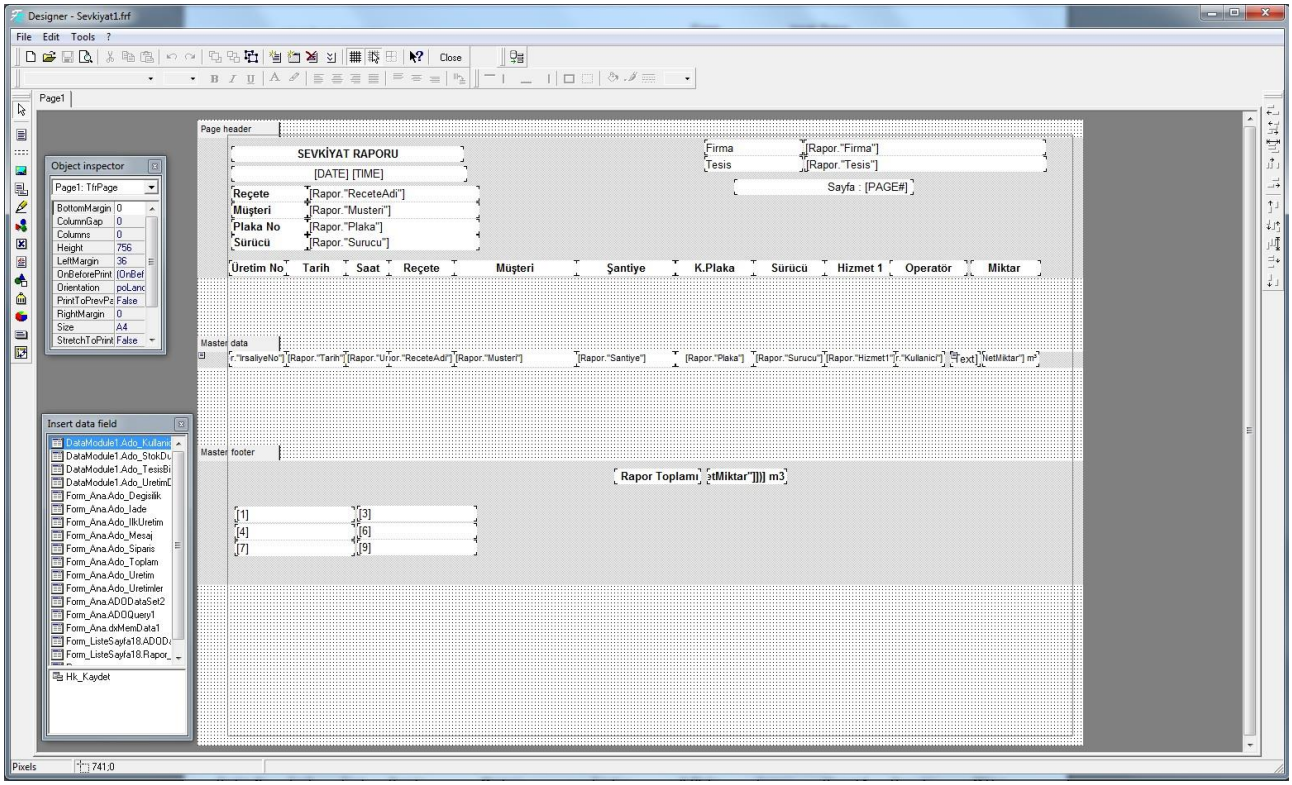
POMPA 1(38 LİK)	39
POMPA 2(43 lük)	24
SANTRAL ALTI	24,5

Page 1/1

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” without saving, and design screen is switched back to by clicking on “Cancel”.


Designer - Sevkiyat1.frf
File Edit Tools ?
Close
Page1
Object inspector
Page1: TfrPage
Insert data field
Page header
SEVKİYAT RAPORU
[DATE] [TIME]
Reçete
Müşteri
Plaka No
Sürücü
[Rapor."ReceteAdi"]
[Rapor."Musteri"]
[Rapor."Plaka"]
[Rapor."Surucu"]
Firma
Tesis
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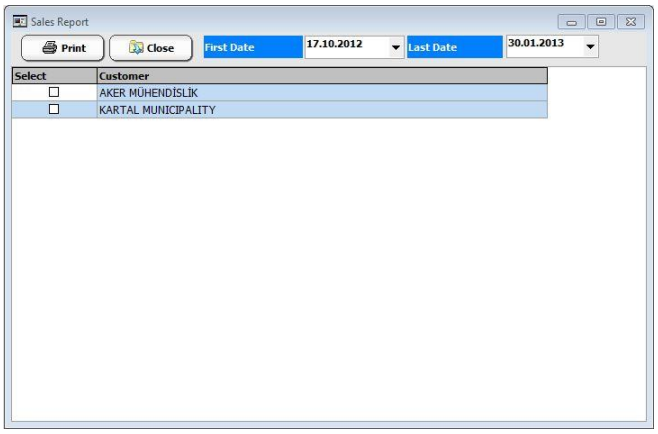
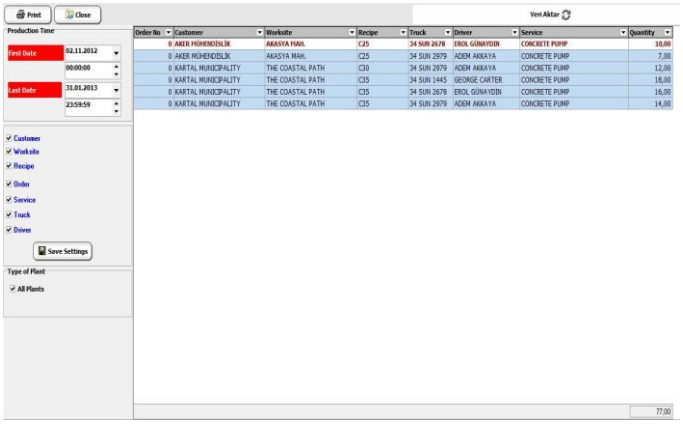
Sayfa : [PAGE#]
Üretim No
Tarih
Saat
Reçete
Müşteri
Şantiye
K.Plaka
Sürücü
Hizmet 1
Operatör
Miktar
Master data
Master footer
Rapor Toplamı
m3
Pixels
741:0

Reports

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.

MÜŞTERİ SATIŞ RAPORU

Şirket	Irmak Beton
Tesis	Söke
Rapor Başlangıç Tarihi	14.02.2012
Rapor Bitiş Tarihi	14.02.2012

Müşteri	ASLANHAN YAPI MAL.LTD.ŞTİ
Şantiye	SADIK DEMİRCAN/DAVUTLAR DAVUTLAR ÇIKIŞI AYTEMİZ PETROL KARŞISI
Teslim Şekli	POMPA 1(38 LİK)

Üretim Tarihi	İrsaliye No	Ürün	Miktar (m3)
14.02.2012 08:55:42	295530	C 30/37 BÜRÜT	10
14.02.2012 10:14:33	295535	C 30/37 BÜRÜT	6

Toplam :16 m3

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”

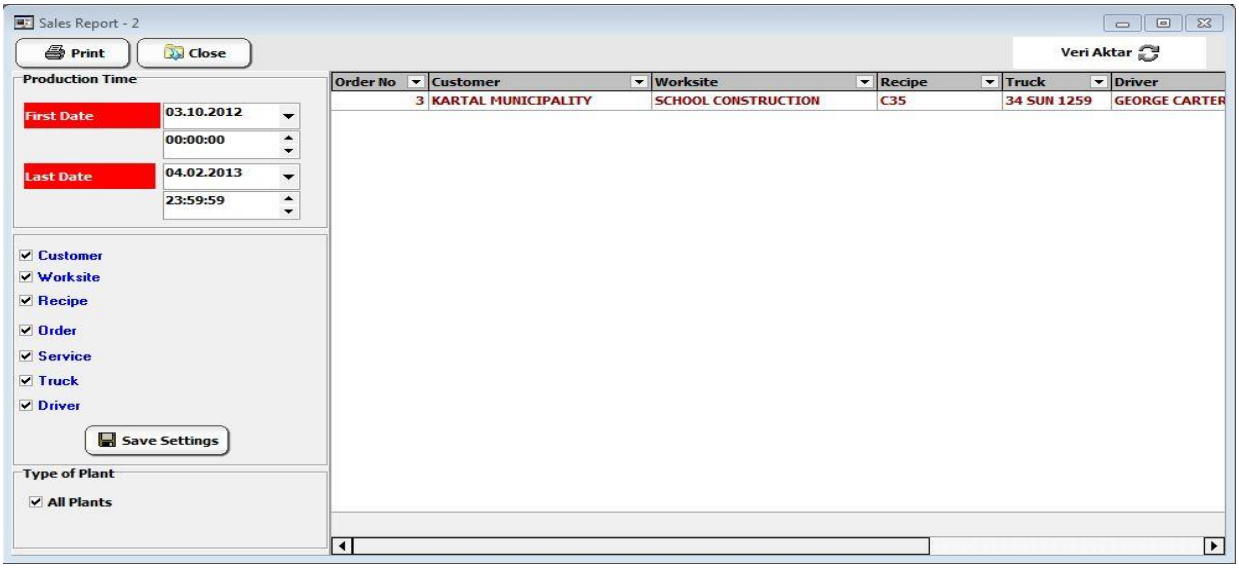
Reports

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.



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”.

Irmak Beton
Söke

Satış Raporu

Baş. Tarih : 14.02.2012
Son Tarih : 14.02.2012

Müşteri	Şantiye	Reçete	Miktar
ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ	C 35/45 BRÜT	12 m³
ÇENGEL TİCARET	KAĞAN İNŞ/FAHRİ	C 35/45 BRÜT	12 m³
ÇENGEL TİCARET	MEHMET EDİZ/DAVUTLAR	C 25/30	7 m³
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	9 m³
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	11 m³
MUZAFFER SARIBAŞ	MUZAFFER SARIBAŞ	C 25/30	11 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	23 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	23 m³
ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMİRCAN/DAVUTLAR	C 30/37	6 m³
ASLANHAN YAPI MAL.LTD.ŞTİ	SADIK DEMİRCAN/DAVUTLAR	C 30/37	10 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	14,5 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	10 m³
AS ADO HAZIR BETON SAN.NAK.TİÇ.AŞ	AS ADO HAZIR	C 25/30	11 m³
SÜZGEÇ YAPI İNŞ.LTD.ŞTİ	SÜZGEÇ YAPI İNŞ/KUŞADASI	C 20/25	2 m³
ÇENGEL TİCARET	MURAT YÖNEL/DAVUTLAR	C 20/25	8 m³
ÇENGEL TİCARET	MURAT YÖNEL/DAVUTLAR	C 20/25	8 m³
		Toplam	177,5 m³

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”.

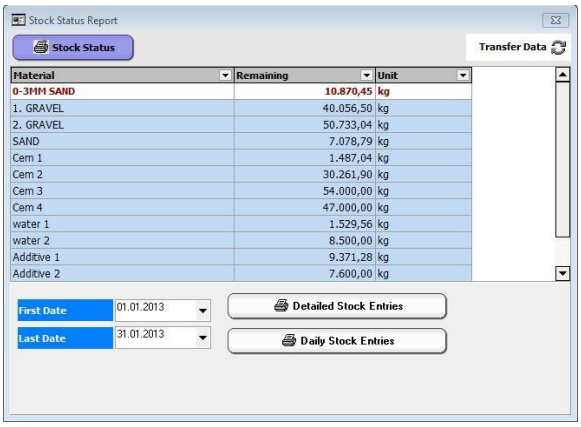
Reports

Stock Report

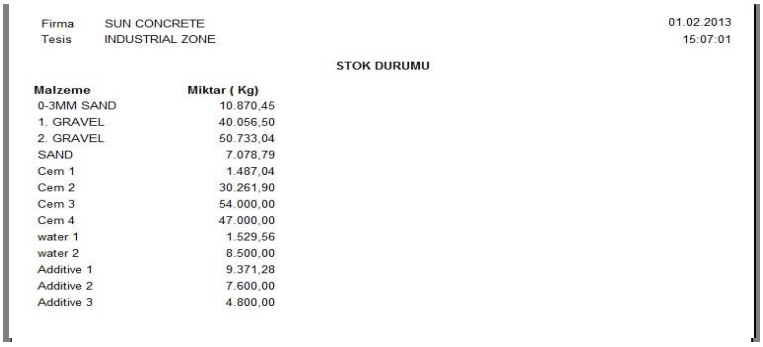
Instantaneous stock status, detailed stock entries and stock entries on daily basis may be displayed and printed.

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.



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

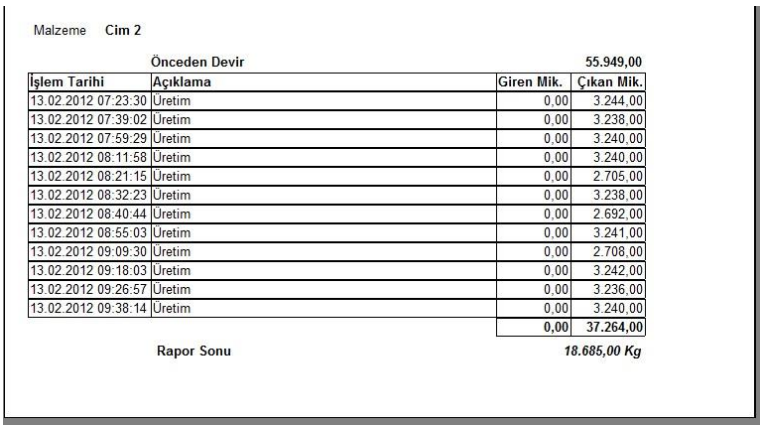


Firma SUN CONCRETE 01.02.2013
Tesis INDUSTRIAL ZONE 15:07:01

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.



Malzeme Cim 2

Önceden Devir 55.949,00

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 18.685,00 Kg

Setting date range at the subpart and clicking on

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

Firma Irmak Beton — Başlangıç Tarihi : 14.02.2012 — 17.04.2012
Tesis Söke — Bitiş Tarihi : 14.02.2012 — 16:59:45

İKİ TARİH ARASI STOK RAPORU

Malzeme **5/15**

Önceden Devir **-825.591,00**

İşlem Tarihi	Açıklama	Giren Mik.	Çıkan Mik.
14.02.2012	Çıkış	0,00	82.957,00
		0,00	**82.957,00**

Rapor Sonu ***-908.548,00 Kg***

Malzeme **05**

Önceden Devir **-2.297.156,00**

İşlem Tarihi	Açıklama	Giren Mik.	Çıkan Mik.
14.02.2012	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 Tarihi	Açıklama	Giren Mik.	Çıkan Mik.
14.02.2012	Çıkış	0,00	70.426,00
		0,00	**70.426,00**

Rapor Sonu ***-1.305.849,00 Kg***

Malzeme **Cim 1**

Önceden Devir **45.248,00**

İşlem Tarihi	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.

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”.

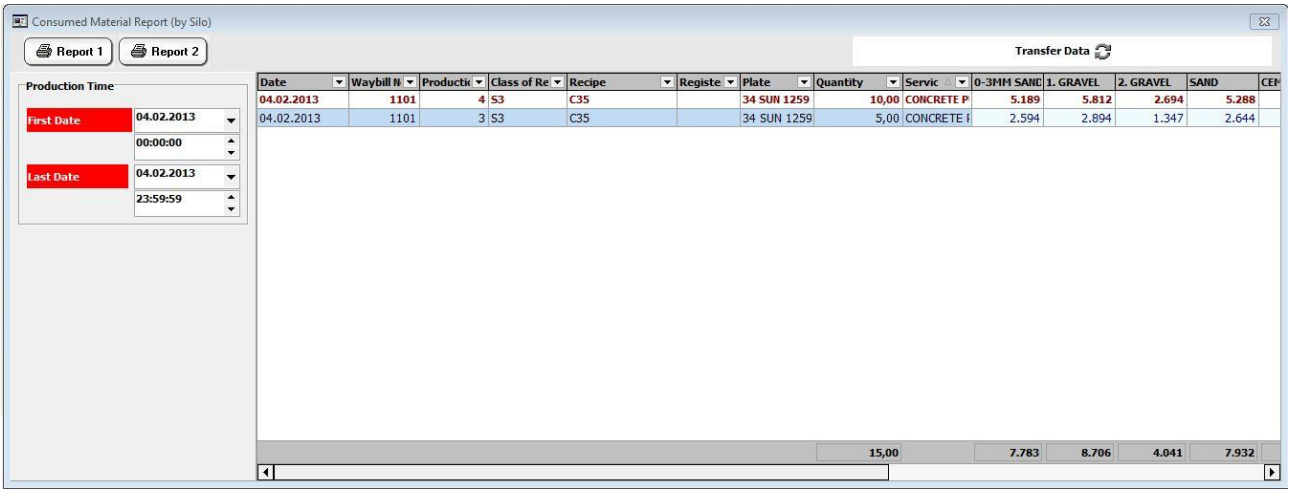
Reports

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.



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 RAPORU

Firma Irmak Beton
Tesis Söke

Başlama Tarihi : 14.02.2012
Bitiş Tarihi : 14.02.2012

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

HARCANAN MALZEME RAPORU

Firma Irmak Beton
Tesis Söke

Başlama Tarihi : 14.02.2012
Bitiş Tarihi : 14.02.2012

Üretim No	İrsaliye	Tarih Saat	Reçete	Hizmet	Agr1	Agr2	Agr3	Agr4	Cim1	Cim2	Cim3	Su1	Katki1	Katkı 2	Katkı 3	Mik (m³)
5035	295542	14.02.2012 12:33:12	C 20/25	POMPA 1(38 LIK)	2880	4240	4240	4720	1800			1440	18,00			8,00 m³
5033	295540	14.02.2012 12:30:42	C 20/25	POMPA 1(38 LIK)	2880	4240	4240	4720	1800			1440	18,00			6,00 m³
5028	295535	14.02.2012 10:14:33	C 30/37 BÜRÜT	POMPA 1(38 LIK)	4916	3179	3198		1921			959		23,00		6,00 m³
5023	295530	14.02.2012 08:55:42	C 30/37 BÜRÜT	POMPA 1(38 LIK)	8177	5309	5220		3196			1573		38,00		10,00 m³
5018	295525	14.02.2012 07:35:46	C 25/30 BÜRÜT	POMPA 1(38 LIK)	5657	3914	3802		2029			1237	20,00			7,00 m³
				Toplamlar	24.510	20.882	20.700	9.440	10.746	0	0	6.649	56	61	0	37,00 m³
				Kg / m3	628	535	531	242	**276**			170	1,51	1,65	0,00	
				Su / Çim Oranı					**0,62**							

Firma Irmak Beton
Tesis Söke

17.04.2012
17:14:55

STOK DURUMU

Malzeme	Miktar (Kg)
05	-2.486.107,00
15/25	-1.318.749,00
5/15	-915.998,00 Kg
Cim 1	-9.247,00 Kg
Cim 2	55.949,00 Kg
Cim 3	60.941,00 Kg
Su 1	-396.887,00 Kg
Antifiriz	0,00 Kg
Katkı 1S	6.611,47 Kg
Katkı 2H	6.661,96 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 and design screen is switched back to by clicking on “Cancel”.

Reports

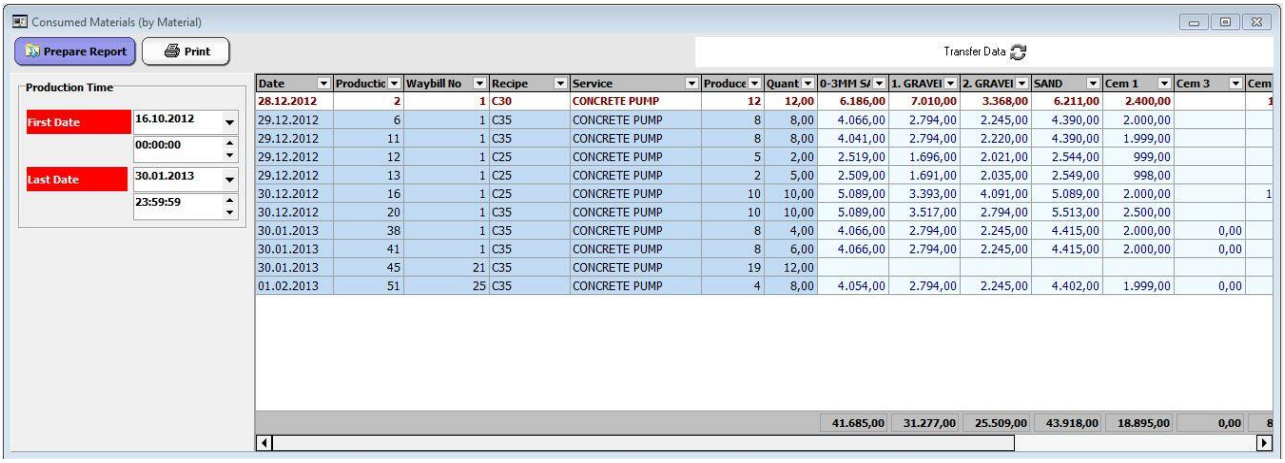
Consumed Material Report (On Material Basis)

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.



Date	Productic	Waybill No	Recipe	Service	Produce	Quant	0-3MM S/	1. GRAVEI	2. GRAVEI	SAND	Cem 1	Cem 3	Cem
28.12.2012	2	1	C30	CONCRETE PUMP	12	12,00	6.186,00	7.010,00	3.368,00	6.211,00	2.400,00		1
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		
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		
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		
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		1
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	
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	
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	
							41.685,00	31.277,00	25.509,00	43.918,00	18.895,00	0,00	8

HARCANAN MALZEME RAPORU

Firma SUN CONCRETE
Tesis INDUSTRIAL ZONE

Başlama Tarihi : 03 10 2012
Bitiş Tarihi : 01 02 2013

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

HARCANAN MALZEME RAPORU

Firma Irmak Beton
Tesis Söke

Başlama Tarihi : 17.04.2012
Bitiş Tarihi : 17.04.2012

Üretim No	İrsaliye No	Reçete	Hizmet	Miktar (m³)	5/15	05	15/25	Cim 1	Cim 2	Cim 3	Su 1	Katkı 1S
5037	295544	C 35/45	POMPA 2(43 lük)	10	3600	9200	6200	3400			1550,00	
				Toplamlar	3.600	9.200	6.200	3.400	0	0	1550,00	0
				Kg / m3	360	360	620	340	0	0	155,00	0

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”.

Reports

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.

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”.

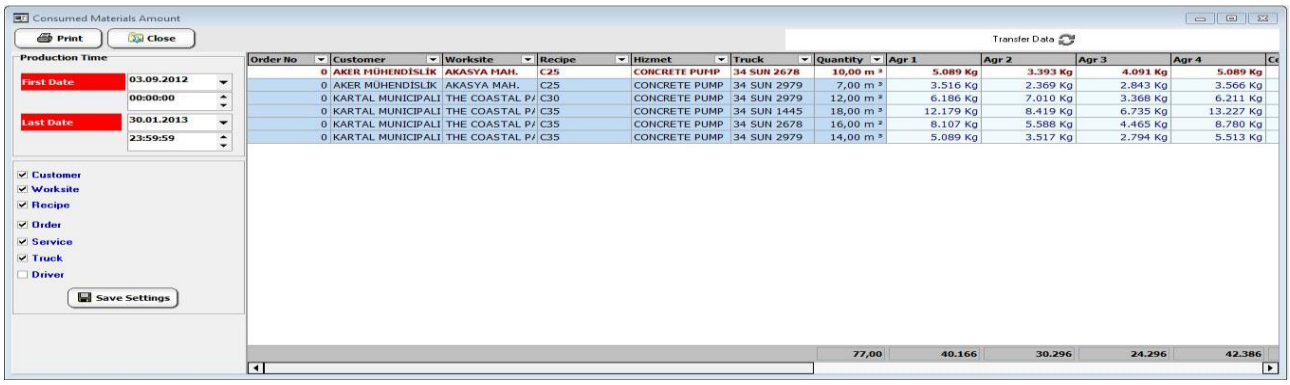
Reports

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.



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”.

Harcanan Malzeme Raporu

Firma :SUN CONCRETE
Tesis :INDUSTRIAL ZONE

Baş. Tarih :03 07 2012
Bit. Tarih :30 01 2013

Müşteri	Şantiye	Reçete	Üretim Mik.	Agr 1	Agr 2	Agr 3	Agr 4	Cem 1	Cem 2	Cem 3	water 1	Additive 1	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	316	550	**345**			152	4,47	0,00
						Su / Çim Oranı		**0,44**					

Report Design

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

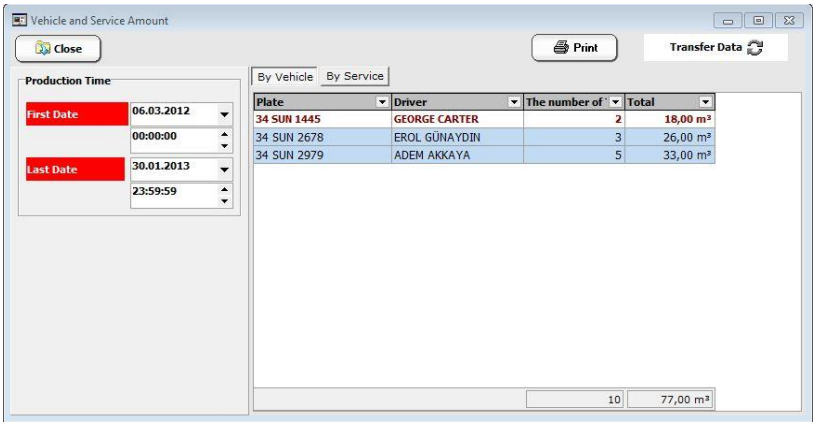
After requested design modifications, screen is closed by clicking on red “X” in the top right-hand corner. On exit, confirmation screen is displayed. Modifications are saved by clicking on “Yes”, screen is exited by clicking on “No and design screen is switched back to by clicking on “Cancel”.

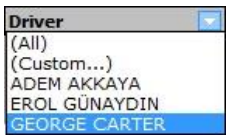
Reports

Vehicle and Service Amount

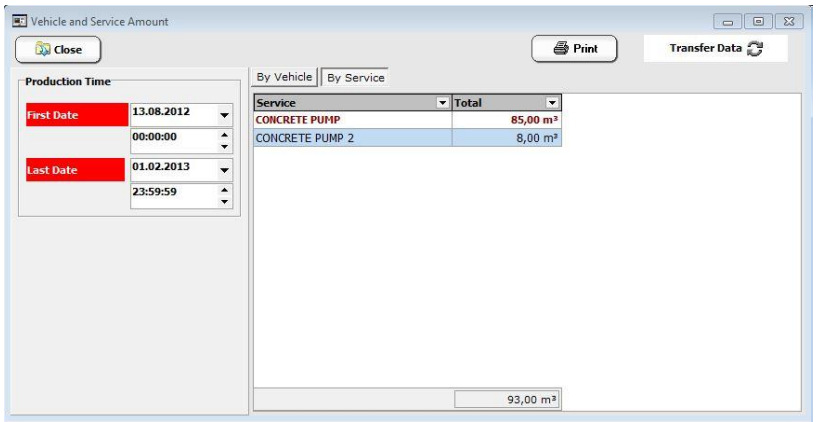
Within the requested date range, truckmixer (by vehicle) and trip number of pumps (by service) and cubic meter information may be listed and “Transfer Data” feature may be saved in a different way. “Transfer Data” transaction is detailed in “Entries-Stock Entry” part.

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





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



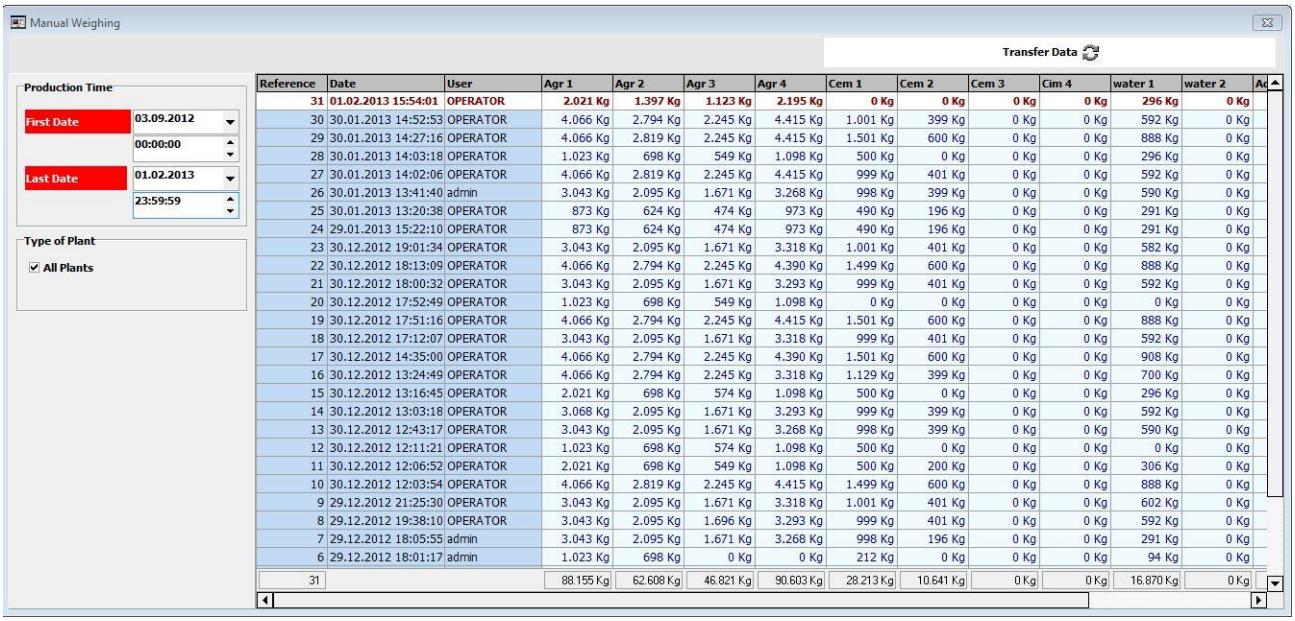
Reports

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.

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

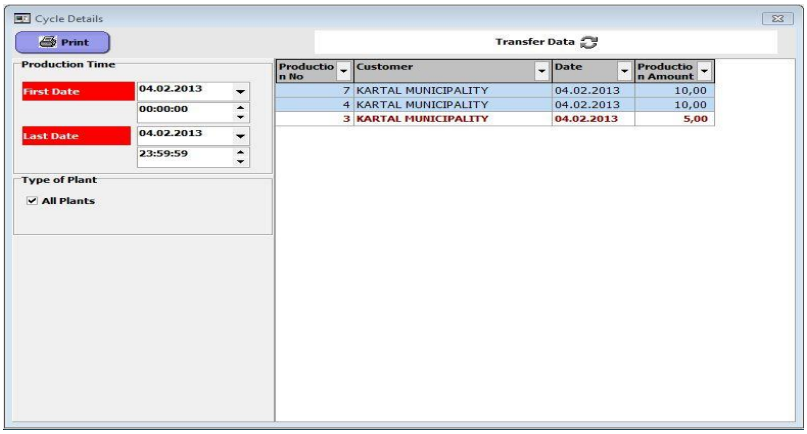


Reference	Date	User	Agr 1	Agr 2	Agr 3	Agr 4	Cem 1	Cem 2	Cem 3	Cim 4	water 1	water 2	Ad
31	01.02.2013 15:54:01	OPERATOR	2.021 Kg	1.397 Kg	1.123 Kg	2.195 Kg	0 Kg	0 Kg	0 Kg	0 Kg	296 Kg	0 Kg	
30	30.01.2013 14:52:53	OPERATOR	4.066 Kg	2.794 Kg	2.245 Kg	4.415 Kg	1.001 Kg	399 Kg	0 Kg	0 Kg	592 Kg	0 Kg	
29	30.01.2013 14:27:16	OPERATOR	4.066 Kg	2.819 Kg	2.245 Kg	4.415 Kg	1.501 Kg	600 Kg	0 Kg	0 Kg	888 Kg	0 Kg	
28	30.01.2013 14:03:18	OPERATOR	1.023 Kg	698 Kg	549 Kg	1.098 Kg	500 Kg	0 Kg	0 Kg	0 Kg	296 Kg	0 Kg	
27	30.01.2013 14:02:06	OPERATOR	4.066 Kg	2.819 Kg	2.245 Kg	4.415 Kg	999 Kg	401 Kg	0 Kg	0 Kg	592 Kg	0 Kg	
26	30.01.2013 13:41:40	admin	3.043 Kg	2.095 Kg	1.671 Kg	3.268 Kg	998 Kg	399 Kg	0 Kg	0 Kg	590 Kg	0 Kg	
25	30.01.2013 13:20:38	OPERATOR	873 Kg	624 Kg	474 Kg	973 Kg	490 Kg	196 Kg	0 Kg	0 Kg	291 Kg	0 Kg	
24	29.01.2013 15:22:10	OPERATOR	873 Kg	624 Kg	474 Kg	973 Kg	490 Kg	196 Kg	0 Kg	0 Kg	291 Kg	0 Kg	
23	30.12.2012 19:01:34	OPERATOR	3.043 Kg	2.095 Kg	1.671 Kg	3.318 Kg	1.001 Kg	401 Kg	0 Kg	0 Kg	582 Kg	0 Kg	
22	30.12.2012 18:13:09	OPERATOR	4.066 Kg	2.794 Kg	2.245 Kg	4.390 Kg	1.499 Kg	600 Kg	0 Kg	0 Kg	888 Kg	0 Kg	
21	30.12.2012 18:00:32	OPERATOR	3.043 Kg	2.095 Kg	1.671 Kg	3.293 Kg	999 Kg	401 Kg	0 Kg	0 Kg	592 Kg	0 Kg	
20	30.12.2012 17:52:49	OPERATOR	1.023 Kg	698 Kg	549 Kg	1.098 Kg	0 Kg	0 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	
9	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	
6	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			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	

Reports

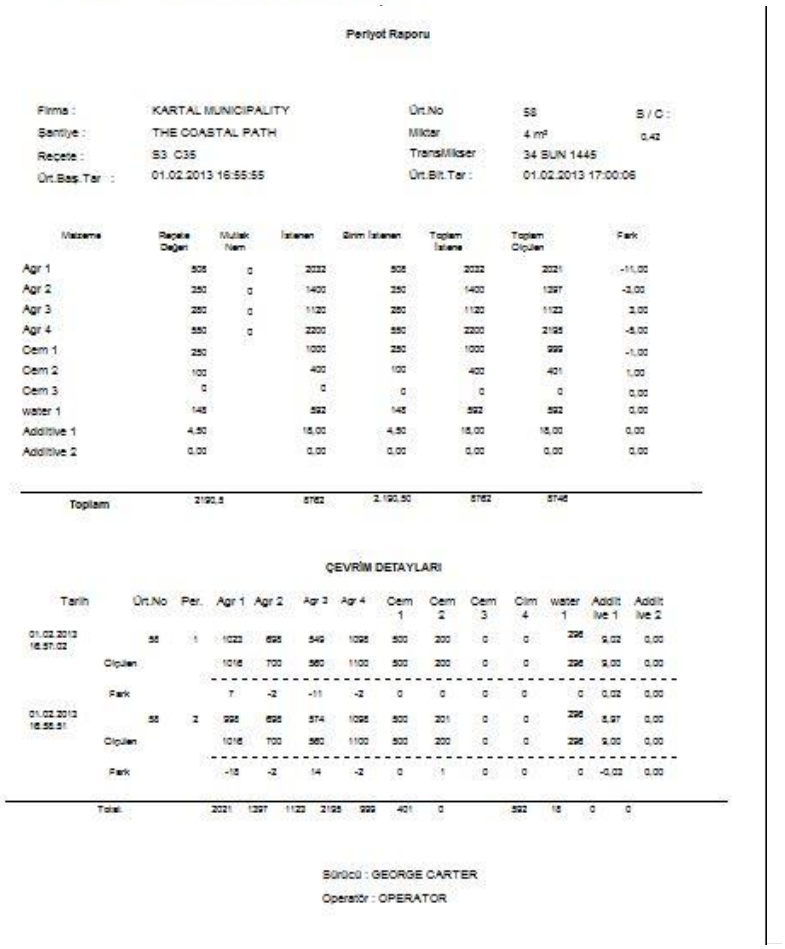
Cycle Details

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



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

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



Periyot Raporu

Firma :	KARTAL MUNICIPALITY	Ürt.No	58	S / C :
Santiye :	THE COASTAL PATH	Miktar	4 m³	0,42
Reçete :	S3 C35	TransMikser	34 BUN 1445	
Ürt.Bas.Tar :	01.02.2013 16:55:55	Ürt.Bit.Tar :	01.02.2013 17:00:06	

Malzeme	Reçete Değeri	Mutlak Nem	İstenen	Birim İstenen	Toplam İstene	Toplam Ölçülen	Fark
Agr 1	506	0	2032	506	2032	2021	-11,00
Agr 2	350	0	1400	350	1400	1397	-3,00
Agr 3	280	0	1120	280	1120	1123	3,00
Agr 4	550	0	2200	550	2200	2195	-5,00
Cem 1	250		1000	250	1000	999	-1,00
Cem 2	100		400	100	400	401	1,00
Cem 3	0		0	0	0	0	0,00
water 1	148		592	148	592	592	0,00
Additive 1	4,50		18,00	4,50	18,00	18,00	0,00
Additive 2	0,00		0,00	0,00	0,00	0,00	0,00
Toplam	2190,5		8762	2.190,50	8762	8746	

ÇEVRİM DETAYLARI

Tarih	Ürt.No	Per.	Agr 1	Agr 2	Agr 3	Agr 4	Cem 1	Cem 2	Cem 3	Cim 4	water 1	Additive 1	Additive 2
01.02.2013 16:51:03	58	1	1023	698	549	1098	500	200	0	0	296	9,02	0,00
Ölçülen			1016	700	560	1100	500	200	0	0	296	9,00	0,00
Fark			7	-2	-11	-2	0	0	0	0	0	0,02	0,00
01.02.2013 16:55:51	58	2	998	698	574	1098	500	201	0	0	296	8,97	0,00
Ölçülen			1016	700	560	1100	500	200	0	0	296	9,00	0,00
Fark			-18	-2	14	-2	0	1	0	0	0	-0,03	0,00
Total:			2021	1397	1123	2195	999	401	0		592	18	0	0

Sürücü : GEORGE CARTER

Operatör : OPERATOR

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” without saving, design screen is switched back to by clicking on “Cancel”.

Reports

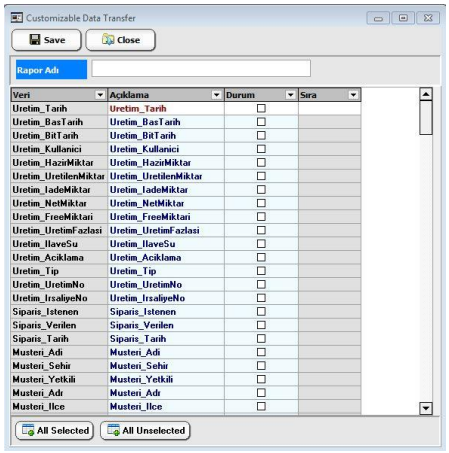
Customizable Data Transfer

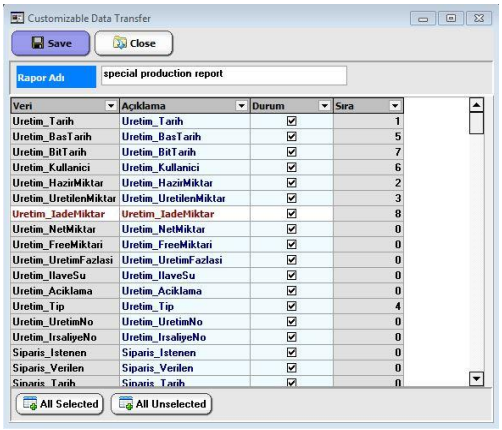
Special Reports are prepared and saved in a different form.

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

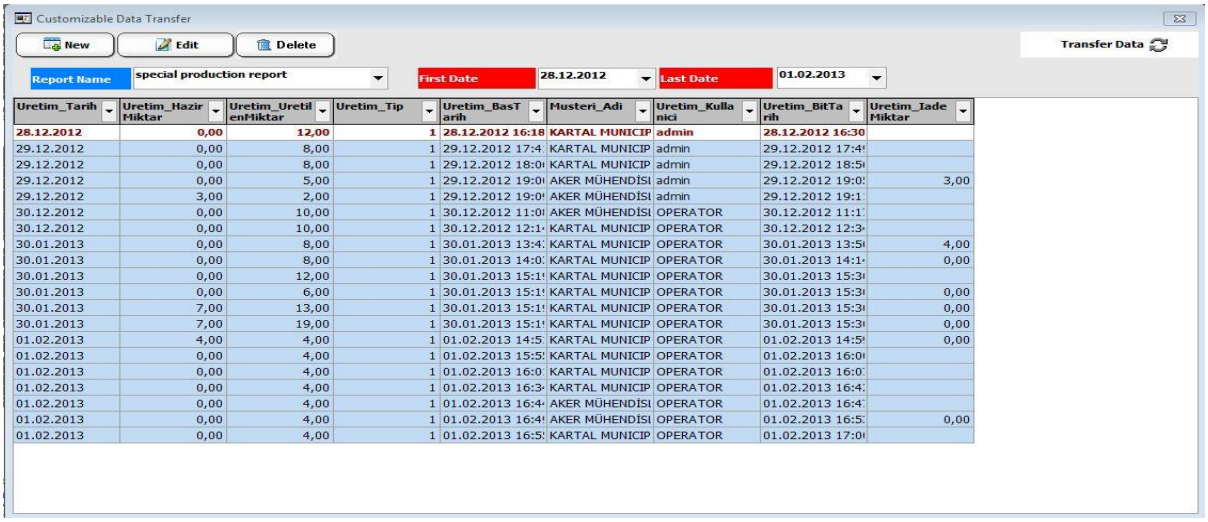
Modifications requested to take place in report may be selected on the list. All variables may be selected or removed by clicking on “All Selected” or “All Unselected”

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





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



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.

Reports

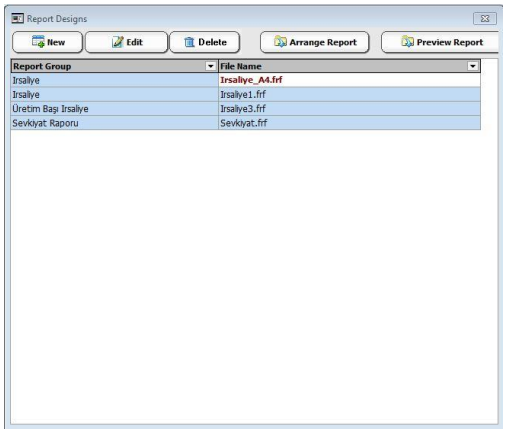
Report Design

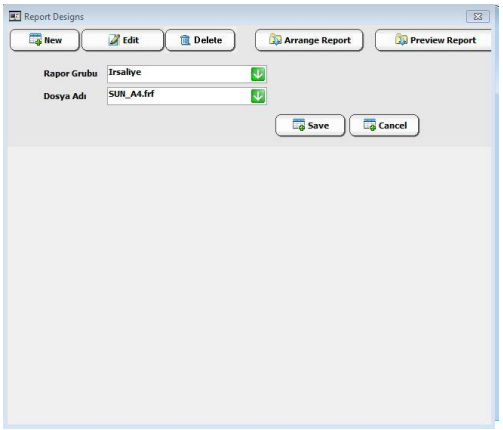
Modifications may be made in waybill forms and new forms may be created.

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.

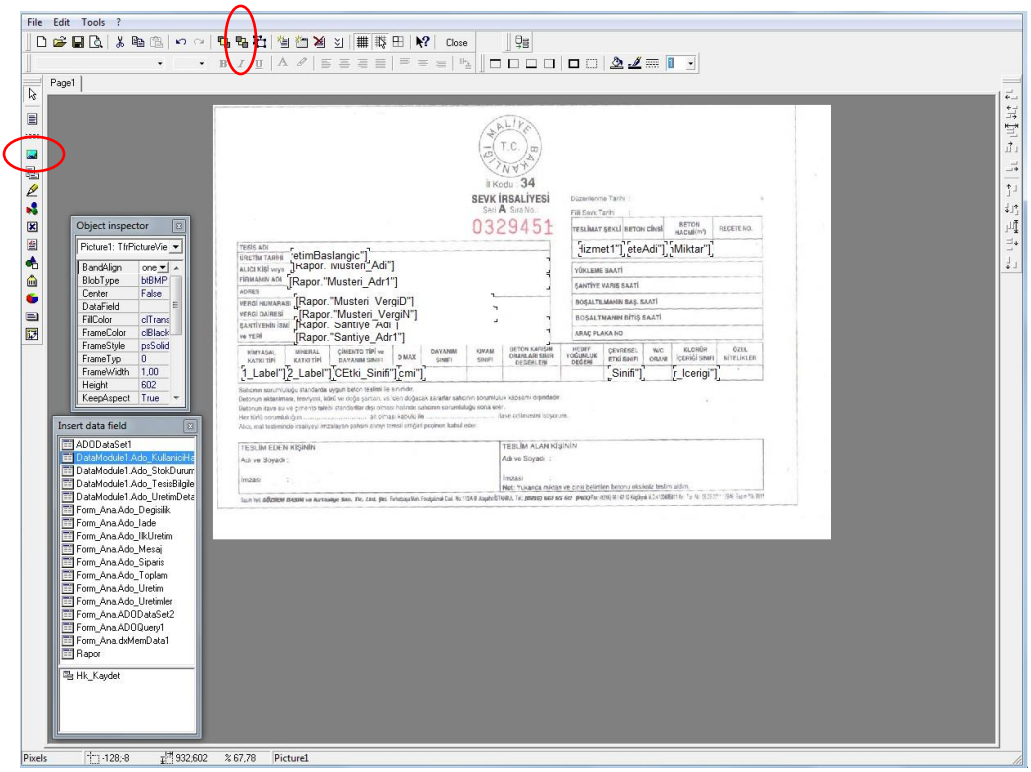
Report group is made up of two categories; “Waybill” and “Waybill (Production Start)”. “Waybill” is a form printed at the end of production and from production records and other one is form printed at the beginning of production.

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.

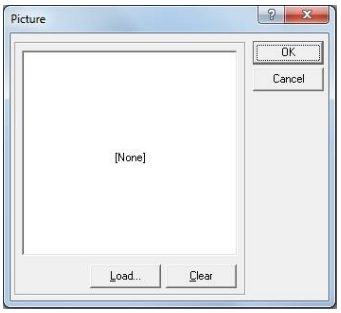




Clicking on “Arrange Report”, design part is switched to. On this screen waybill form to be designed is scanned and may be placed on background and a quick design may be made by placing fields to requested places on picture.

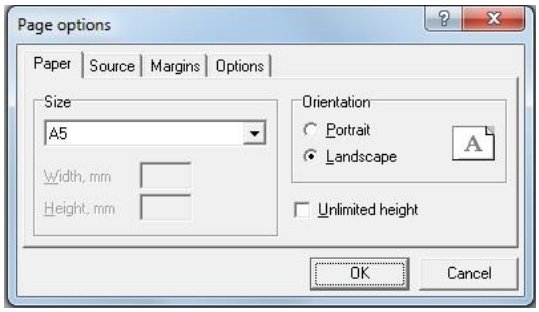


To place the scanned picture, “Insert Picture” is selected at the left part is selected. On the appearing screen, picture is selected by clicking on “Load” and the “Ok” is clicked on.



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.



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.

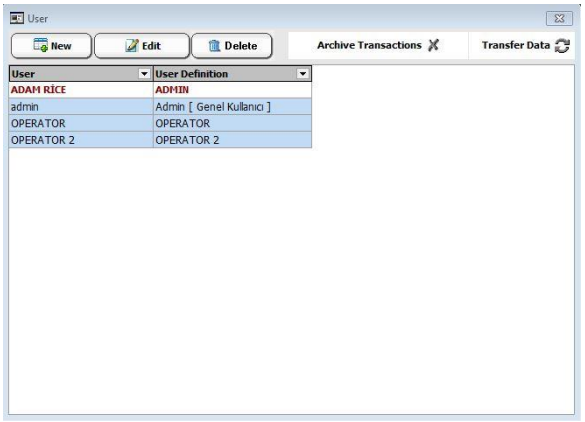
Screen is closed by clicking on red “X” in the top right-hand corner.

System

User

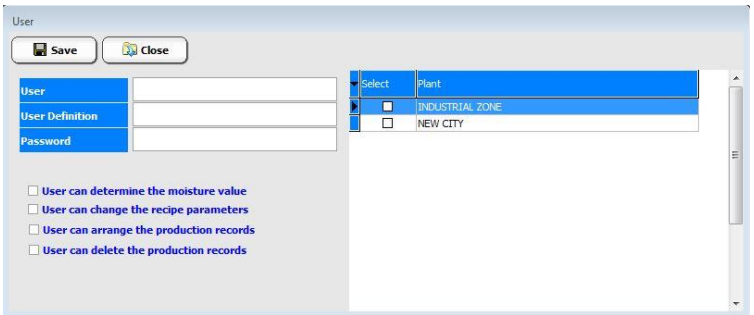
Adding user and arrangement may be performed with the authority of “admin”.

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”.



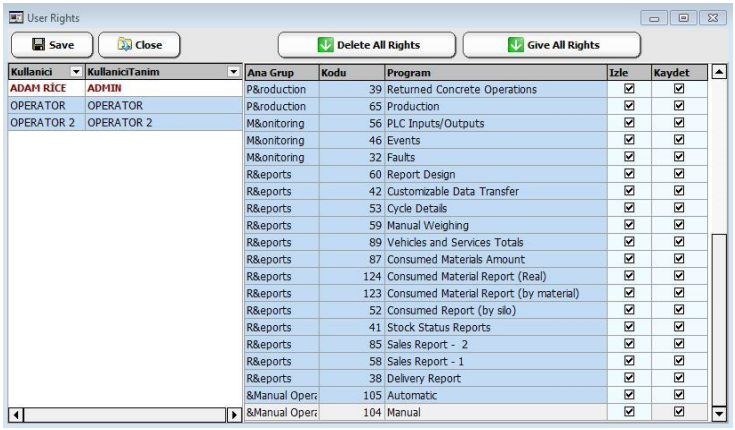
“Archive and Transfer Data Transactions” are detailed in “Entries-Stock Entry”.

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

System

User Rights

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



Kullanici	KullaniciTanim
ADAM RİCE	ADMIN
OPERATOR	OPERATOR
OPERATOR 2	OPERATOR 2

Ana Grup	Kodu	Program	Izle	Kaydet
P&roduction	39	Returned Concrete Operations	☑	☑
P&roduction	65	Production	☑	☑
M&onitoring	56	PLC Inputs/Outputs	☑	☑
M&onitoring	46	Events	☑	☑
M&onitoring	32	Faults	☑	☑
R&eports	60	Report Design	☑	☑
R&eports	42	Customizable Data Transfer	☑	☑
R&eports	53	Cycle Details	☑	☑
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)	☑	☑
R&eports	123	Consumed Material Report (by material)	☑	☑
R&eports	52	Consumed Report (by silo)	☑	☑
R&eports	41	Stock Status Reports	☑	☑
R&eports	85	Sales Report - 2	☑	☑
R&eports	58	Sales Report - 1	☑	☑
R&eports	38	Delivery Report	☑	☑
&Manual Opera	105	Automatic	☑	☑
&Manual Opera	104	Manual	☑	☑

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”.

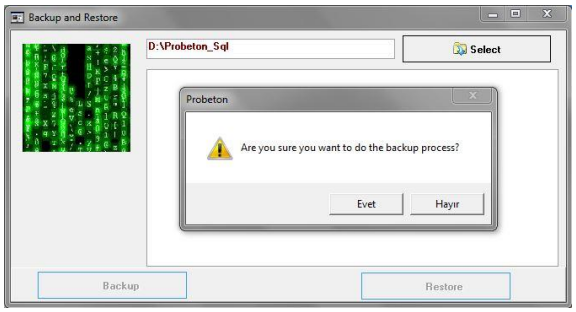
Information is saved by clicking on “Save” or screen is exited without saving by clicking on “Close”.

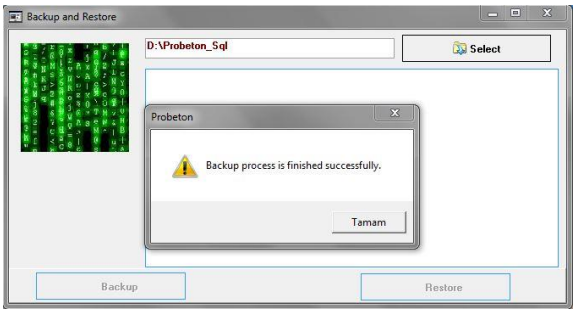
System

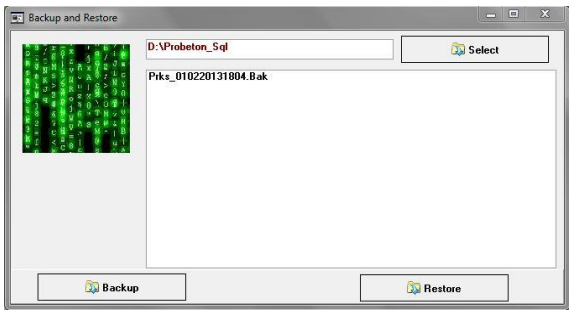
Backup and Restore

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.

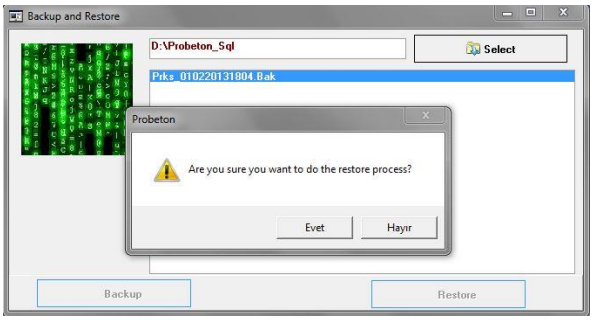
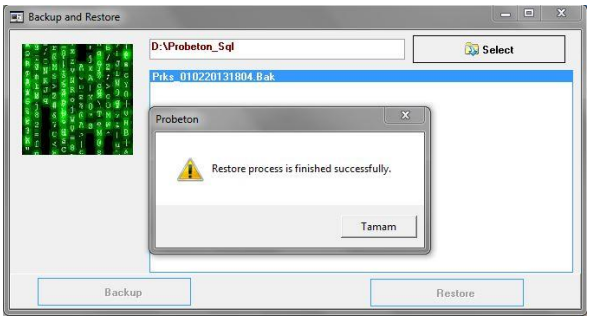
After clicked on “Ok” on the appearing confirmation screen, a screen showing the completion of transactions is displayed. When clicked on “Ok” again, a backup record bearing current date is created.







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.