



Production Tools

This section describes the features found in the Production Tools of the eDART™ System software.

In this section

- Lot Number
- Part Sampling

Lot Number

Current Lot Number

Shows text for current lot number. When the job first starts, this is “none”. You may change the lot number with the Change Lot Number button. This button brings up a dialog box where you can enter a new text. The new text is saved as a note in the summary data.



NOTE
If this job was run before, the lot number will be restored from the previous run.

New Lot Number

Enter any text you want for a new lot number. When you click the Accept button, the program enters a new lot number as a note in the summary data.



NOTE
You are not required to enter anything in the “Comment” dialog box. If you do enter text here, it will be added to the summary note below the “Lot Number” line.

Part Sampling

Use this tool to mark parts in the data files for later correlation to physical measurements of the parts. The tool places notes in the data files that tell the Parts Measurement tool in the Analyzer to make a space for inserting measurements.

This tool can be dragged onto a specific mold or all "Molds" using the Architect. Or it can be placed on the system menu for starting and stopping at will. It can also be launched from the Summary Graph menu bar.

The screenshot shows the 'Part Sampling' window with the following callouts:

- Number of shots to group for measurement entry and X & R charts:** Points to the 'Mark next 5 shots as a group' input field.
- Group name is usually a run number and tells what was set for this group:** Points to the 'Group Name: High Hold' text box.
- Notes typed here are part of the sample note as seen on the Analyzer's Summary Graph:** Points to the 'Additional Notes' text area.
- Check for interval sampling, un-check for longer DOE runs:** Points to the 'Take the shot in the machine (sample #1)' section.
- Divertor rejects all sampled parts:** Points to the 'Reject samples' checkbox.
- Tells you when to start keeping samples and each sample's date and time:** Points to the 'Shot Time Stamps' list.
- Parts sampled - you should have this many taken:** Points to the '4 Samples Taken' green bar.
- Allows you to stop sampling and does not record the samples taken:** Points to the 'Stop Sample' button.
- Start a new file before and after a fill DOE run:** Points to the 'Start new data file' button.

Mark Next # Shots

This is the number of "holes" that will be available in your data into which you can put part measurements. Generally, once you start the sampling (Start button), you collect and measure the next # of parts and enter their part measurements into the data later.

Group Name

This becomes part of the note describing the parts. When you bring up the Part Measurements tool in RJG's Windows-based Analyzer program, each group will have the name you enter here as a tag. This helps you keep groups separate (e.g. "Run 1", "Run 2" or "Hold P=3000", "Hold P=4000" etc.).

Additional Notes

Here you can add additional information to the sample. This extra information is visible in the Analyzer Summary Graph as extra text on the notes. These samples are actually saved as notes and picked up (because of special formatting) by the Part Measurements tool in the Analyzer.

You can also start a group by adding a note to the summary data and starting the note with a group name.

Parts Sampling List

This window informs you of what the Part Sampling tool is doing after you click the Start button. It lets you know just when to actually grab the parts and the date/time stamp for each one.

Status Box

Shows the number of parts sampled with a green color bar indicating how long (percentage-wise) until the end.

Make a separate file for each group

If this box is ticked, the data file will "break" and start a new file each time the sampler completes a group. You should use this method if you have remote users editing the part measurements using a windows computer. This is because you must NOT edit part measurements in a file while data storage in progress.

Normally this switch is off if you want to save several groups in a single file for a designed experiment. Then the summary, notes and measurements can all be transported easily in small files.

If you sample on a regular interval (say hourly +/- a random window) then this box should be ticked. Then each file for the sampling will be small and can be uploaded or edited with parts measurements immediately. Also, the FTP file up-load can be set up to limit copying of cycle data (the large stuff) to only those files with notes on them.

Start new data file

If you are running a designed experiment you will normally turn off the "Make a separate file..." switch. Then just before you start the run, press this switch. This will end the current data file which may have setup and stabilization data in it that is not pertinent to the experiment. Then after the experiment is finished press the "Start new data file" switch again. This will end the file with the experimental data in it so that the whole experiment is contained in that one file.

When you press this switch a message pops up saying which file is about to be completed at the end of the current cycle.

Reject Samples

When ticked then the Part Diverter Control is told to reject every cycle during the part sampling. The parts are counted as rejects since that is the bin to which they go. If you are using InsightPro's Scrap Entry (on the eDART™ or Windows) you can later restore them after they have been measured.

Part Sampling tool operates a "Sorting Output", "Sample Parts" signal to an OR2-D relay if you have one defined in Sensor Locations. This signal stays on during the entire cycle for which the parts are sampled. You might use it to tell a robot to place the parts in a special sample location for measurement.

Stop Sample

Lets you stop sampling in mid-group. You might want to do this if something goes wrong and you don't want the note added to the data. The note (which tags the data for later part measurement entry) is not actually added until the total number of samples finishes normally.

Start Sample

Starts part sampling. The note containing the number, group name, and notes is not inserted into the data until the end of the sample. When finished, the note gets inserted on the first sample in the group.