webMIP

web-based Management In Production of plastics industry

Database oriented web application

Management tool for increasing product quality and productivity

Describing Version 2.14

1.0 – Welcome page with licensing and language selection

Increasing productivity and quality

- Recording the produced quantities, material usage and the continuous throughput
- Evaluation of downtime and machine utilization, together with the shift personnel based on specific reports
- Daily updated reports, even per e-mail
- Availability of qualitative production data such as film weight and thickness profile

Your benefits

- Permanent overview of the production process, inside or outside the production facility
- Evaluations of the current production up-to-the-minute
- Intuitive user interface and the use of common browsers allows immediate use of the system without extra installation and training period
- With an existing network connection to the database server, access from any place is possible
- Extensions, including and especially individual adjustments to given structures are possible at any time with minimal effort.
- Connection and integration of gravimetric third-party systems can be done upon request

1. Base package

- Control center function with display of recorded production data
- Reports for all machines and any time periods, included graphics and downtime
- Material database and tracking
- Automatic daily report by email
- Commissioning of the webMIP server

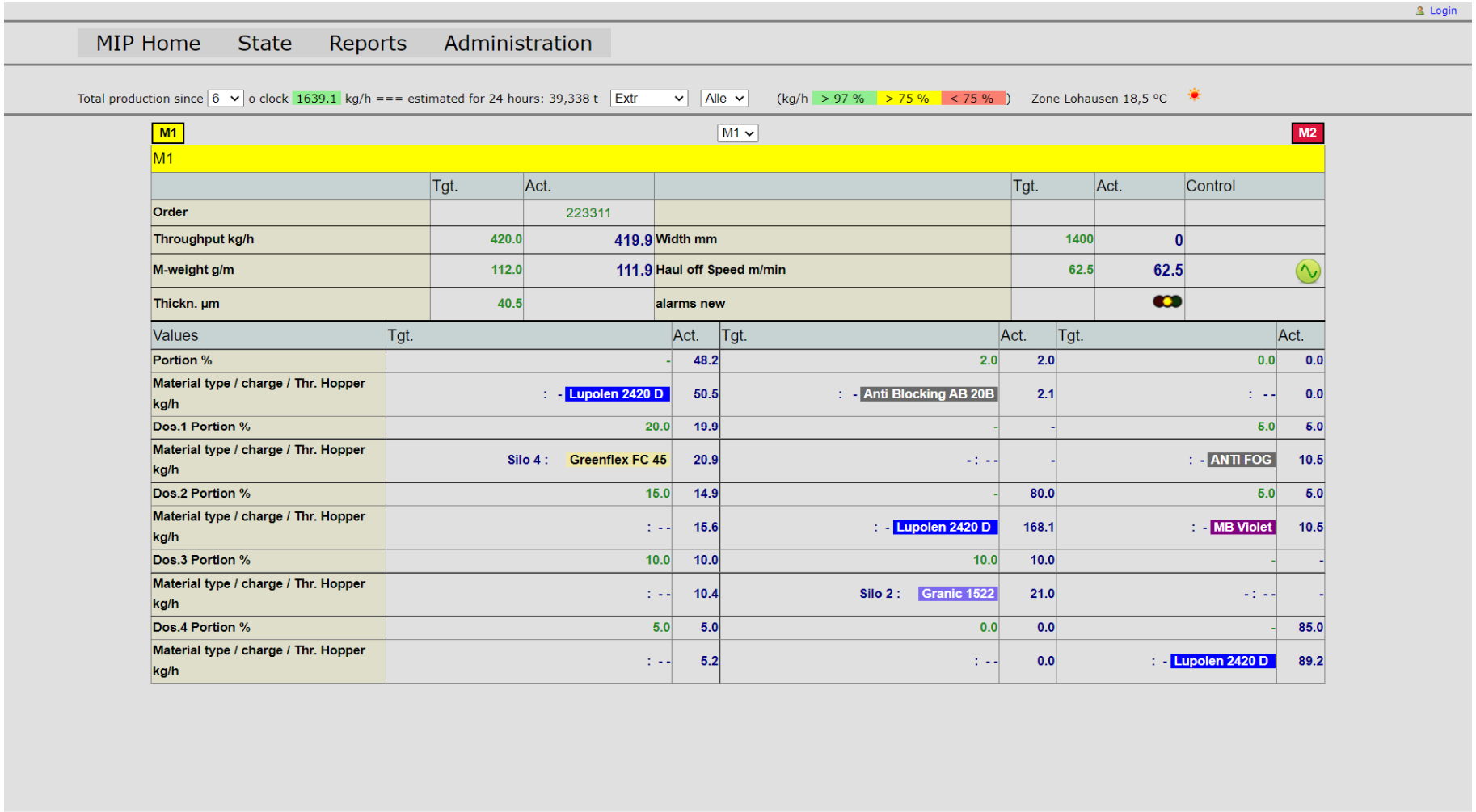
Login

MIP Home | State | Reports | Administration

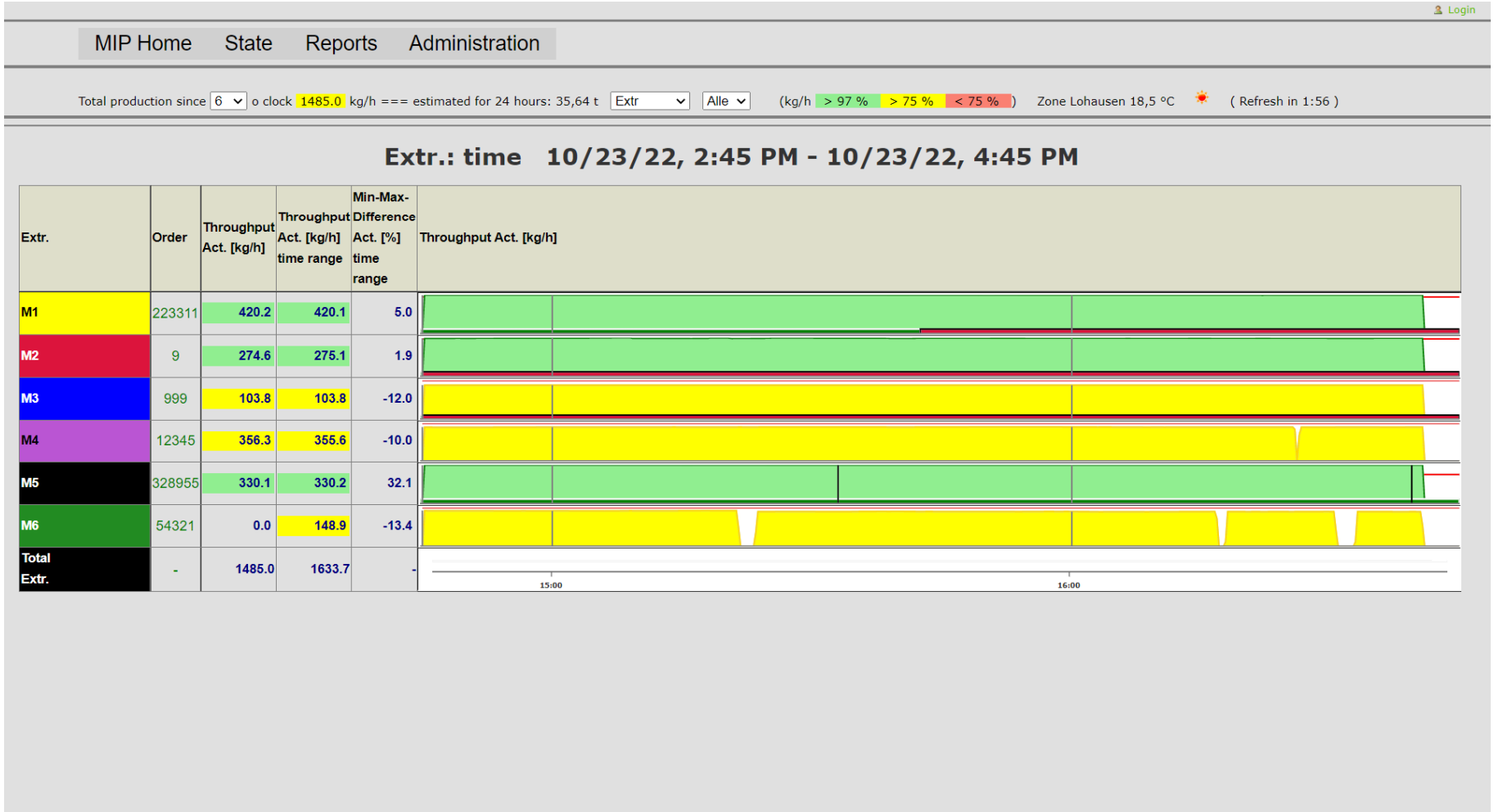
Total production since 6 o clock 1639.6 kg/h === estimated for 24 hours: 39,35 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C (Refresh in 1:56)

Extr.	M1 K22	M2 BLN	M3 K22	M4 BLN	M5 BLN	M6 BLN	Total Extr.
Throughput Act. [kg/h]	420.2	274.6	103.8	356.3	330.1	154.6	1639.6
Throughput Tgt. [kg/h]	420.0	275.0	105.0	-	330.0	-	1130.0
Plan Tgt. [kg/h]	400.0	270.0	118.0	395.0	250.0	172.0	1605.0
Order [Status]	-	-	-	Good	-	Scrap	-
Order	223311	9	999	12345	328955	54321	-
Finishing time End [h:min]	-	-	-	-	-	-	-
Tube Reel Act.	0	3	0	-	0	-	-
Width Tgt. [mm]	1400	1630	1205	-	712	-	-
Width Act. [mm]	0	0	-	-	0	-	-
M-weight Tgt. [g/m]	112.0	112.0	97.0	-	102.0	-	-
M-weight Act. [g/m]	112.0	111.9	97.6	-	102.0	-	-
Thickn. Tgt. [µm]	40.5	37.1	-	-	77.8	-	-
Thickn. Act. [µm]	40.5	37.0	43.4	-	77.9	-	-
Profile Act. [%]	1.8	-	-	-	-	-	-
Haul off Speed Tgt. [m/min]	62.5	40.9	18.0	-	53.9	-	-
Haul off Speed Act. [m/min]	62.5	40.9	17.7	0.1	53.9	0.0	175.1
Haul off Speed Control							-
alarms new Alarm							-
Traction winder Act. [kg]	-	-	-	-	-	-	-

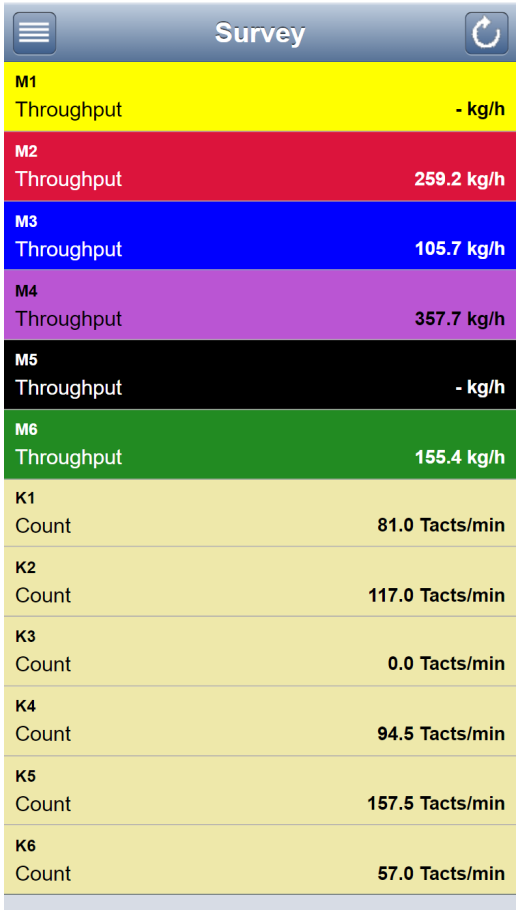
1.1.1 – Overall status

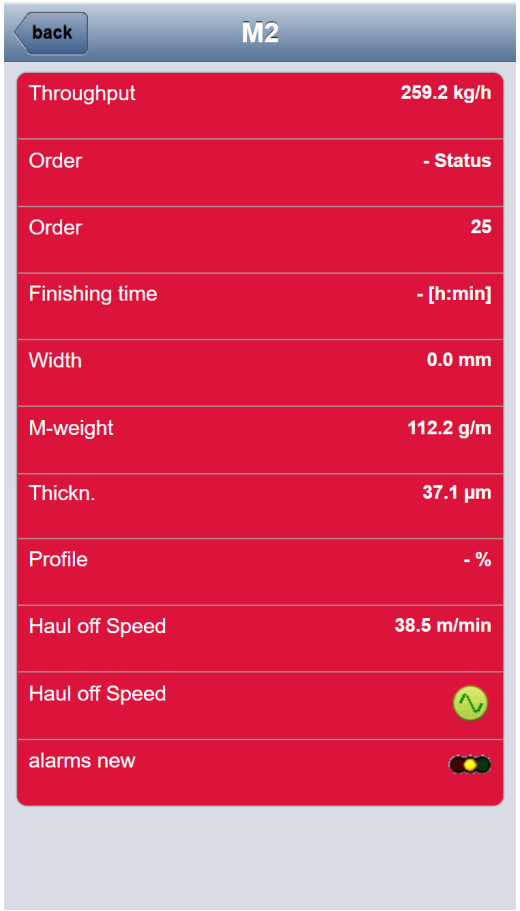


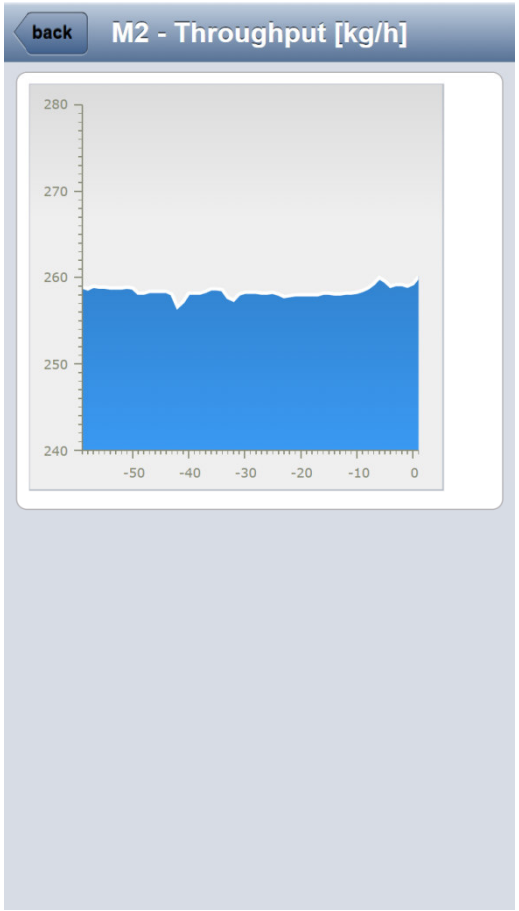
1.1.2 – Machine State (coex machine)



1.1.3 – Production Status – dashboard


Survey
M1
Throughput - kg/h
M2
Throughput 259.2 kg/h
M3
Throughput 105.7 kg/h
M4
Throughput 357.7 kg/h
M5
Throughput - kg/h
M6
Throughput 155.4 kg/h
K1
Count 81.0 Tacts/min
K2
Count 117.0 Tacts/min
K3
Count 0.0 Tacts/min
K4
Count 94.5 Tacts/min
K5
Count 157.5 Tacts/min
K6
Count 57.0 Tacts/min


back
M2
Throughput 259.2 kg/h
Order - Status
Order 25
Finishing time - [h:min]
Width 0.0 mm
M-weight 112.2 g/m
Thickn. 37.1 µm
Profile - %
Haul off Speed 38.5 m/min
Haul off Speed
alarms new


back
M2 - Throughput [kg/h]
280
270
260
250
240
-50
-40
-30
-20
-10
0

1.1.4 mobile

1.2 Time reports

- Sums and averages of the production lines
- pre-defined periods such as day, week, shift
- Order reports (when entering the order number at the machine)
- Material amounts (only with material package)
- Trends/Charts
- Chronological data with export to Excel

Login

MIP Home | State | Reports | Administration

Total production since 6 o clock 1640.2 kg/h === estimated for 24 hours: 39,365 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C (Refresh all in 9:54)

Machine: All none M1 M2 M3 M4 M5 M6

Reports: day report 6:00 AM - 6:00 AM show

from (date): 10/23/2022

day report 6:00 AM - 6:00 AM 10/23/22

Extr.	Throughput Act. [kg/h] Day	Plan Tgt. [kg/h]	Min-Max-Difference Act. [%] Day	Consump. Act. [t] Day	Good Act. [t] Day	Scrap Act. [t] Day	Scrap Act. [%] Day	Duration Act. [h:min] Day	Down time Act. [h:min] Day	ON time Act. [h:min] Day
M1	421.1	400.0	5.3	2.951	0.000	0.000	0.0	7:00	0:00	7:01
M2	275.0	270.0	1.9	2.936	0.000	0.000	0.0	10:41	0:00	10:41
M3	103.9	118.0	-11.9	0.736	0.000	0.000	0.0	7:05	0:00	7:05
M4	346.6	395.0	-12.3	3.694	1.760	1.910	50.4	10:25	0:14	10:39
M5	330.0	250.0	32.0	3.523	0.000	0.000	0.0	10:41	0:00	10:41
M6	148.6	172.0	-13.6	1.588	0.679	0.892	53.8	10:14	0:27	10:41
Total Extr.	1625.2	1605.0	-	15.428	2.439	2.802	9.4	-	-	-

1.2.1 – Time report Overview

Login

MIP Home | State | Reports | Administration

Total production since 6 o clock 1640.2 kg/h === estimated for 24 hours: 39,365 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C

Machine: All none

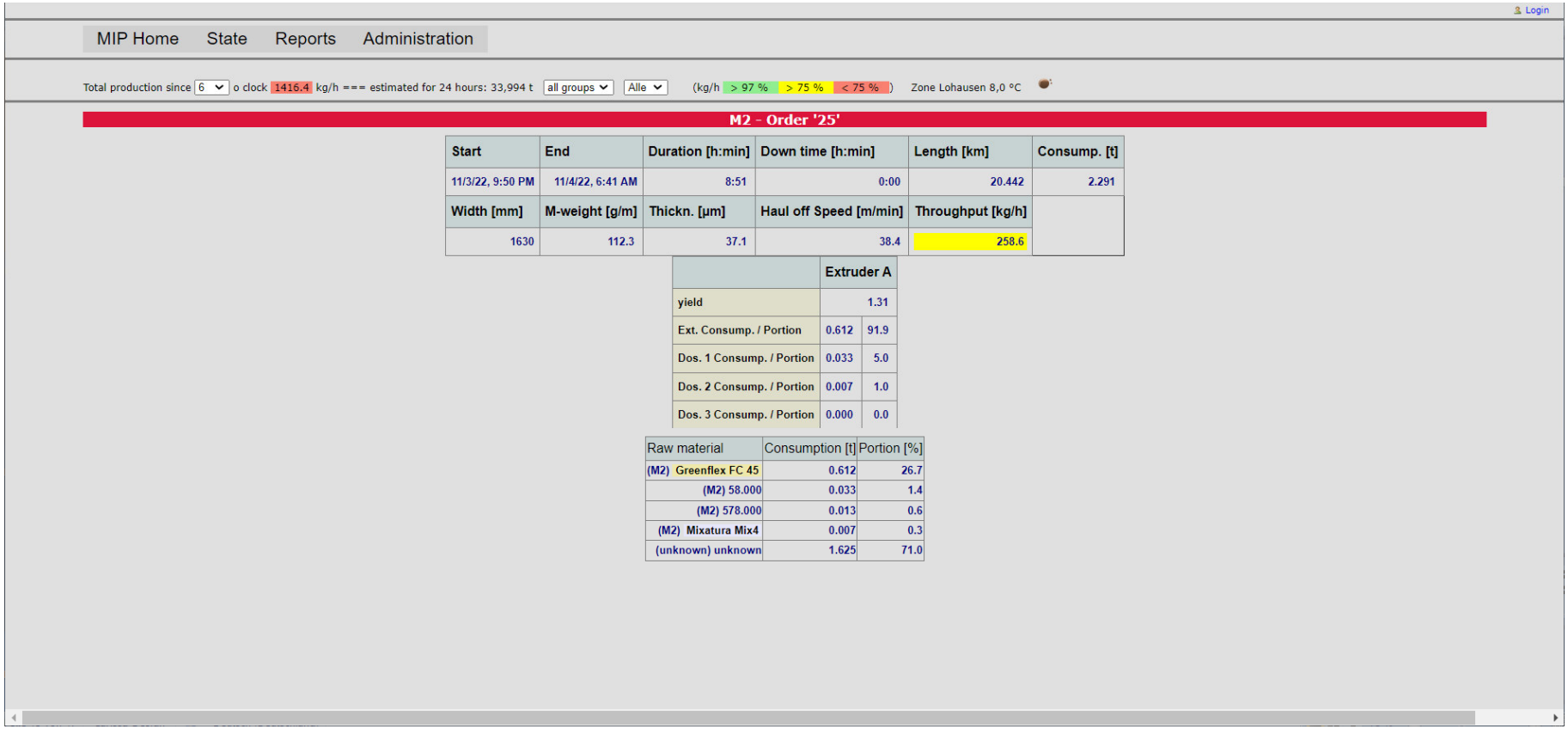
M1 M2 M3 M4 M5 M6

from (date): 10/23/2022 Week Month show

Order Product

Machine	Start	End	Order	State	Duration [h:min]	Down time [h:min]	Throughput [kg/h]	Haul off Speed [m/min]	Width [mm]	M-weight [g/m]	Thickn. [µm]	Profile [%]	Temp. Film MWT [°C]	Consump. [t]	Length [km]
M5 Detailed State	10/23/22, 3:33 PM	10/23/22, 4:41 PM	328955	active	1:08	0:00	330.3	53.9	712	102.2	78.0	0.0	0.0	0.372	3.276
M5 Detailed State	10/23/22, 1:41 PM	10/23/22, 3:33 PM	328954	finished	1:52	0:00	329.9	53.9	712	102.0	77.8	0.0	0.0	0.613	6.006
M5 Detailed State	10/23/22, 11:50 AM	10/23/22, 1:41 PM	328953	finished	1:51	0:00	329.9	53.9	712	102.1	77.9	0.0	0.0	0.612	5.994
M5 Detailed State	10/23/22, 9:59 AM	10/23/22, 11:50 AM	328952	finished	1:51	0:00	330.3	53.9	712	102.1	77.9	0.0	0.0	0.612	5.994
M5 Detailed State	10/22/22, 10:51 PM	10/23/22, 12:42 AM	328946	finished	1:51	0:00	330.0	53.9	712	102.1	77.9	0.0	0.0	0.612	5.994
M3 Detailed State	10/22/22, 12:33 PM	10/23/22, 4:41 PM	999	active	12:42	0:01	104.4	17.9	1205	96.8	43.0	0.0	0.0	1.327	14.034
M1 Detailed State	10/22/22, 11:18 AM	10/23/22, 4:41 PM	223311	active	13:38	0:00	420.5	62.3	1400	112.7	40.7	2.5	0.0	5.733	48.954
M2 Detailed State	10/22/22, 11:14 AM	10/23/22, 1:42 AM	8	finished	14:28	0:00	275.1	40.8	1630	112.5	37.2	0.0	0.0	3.979	35.442
M4 Detailed State	10/21/22, 12:33 PM	10/23/22, 4:41 PM	12345	active	1-18:57	1:18	344.6	0.4	0	0.0	0.0	0.0	0.0	15.249	0.996
M6 Detailed State	10/21/22, 12:33 PM	10/23/22, 4:41 PM	54321	active	1-19:00	1:15	150.0	0.4	0	0.0	0.0	0.0	0.0	6.638	1.026

1.2.2 – Order report overview

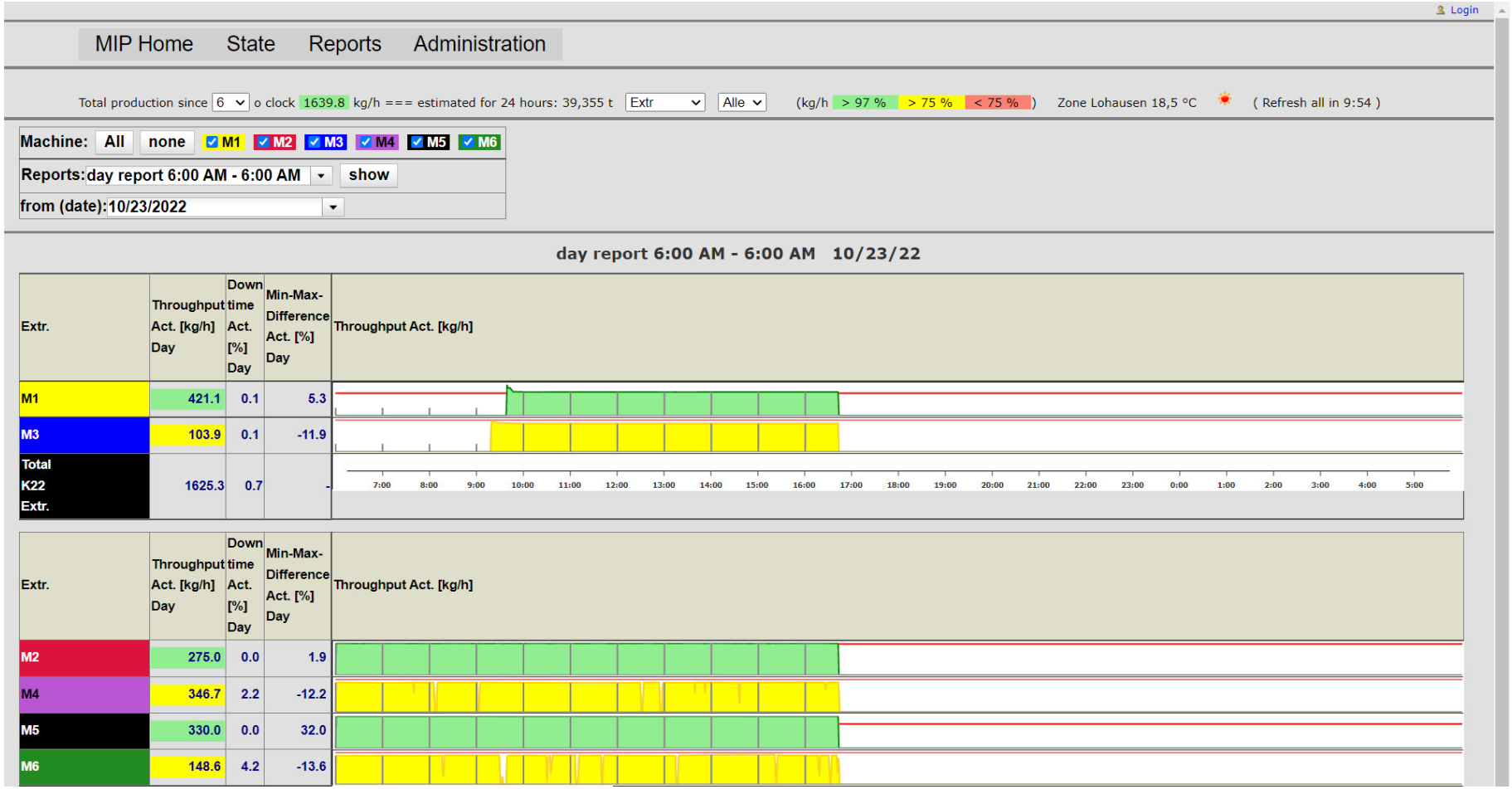


Start	End	Duration [h:min]	Down time [h:min]	Length [km]	Consump. [t]
11/3/22, 9:50 PM	11/4/22, 6:41 AM	8:51	0:00	20.442	2.291
Width [mm]	**M-weight [g/m]**	**Thickn. [µm]**	**Haul off Speed [m/min]**	**Throughput [kg/h]**	
1630	112.3	37.1	38.4	258.6	

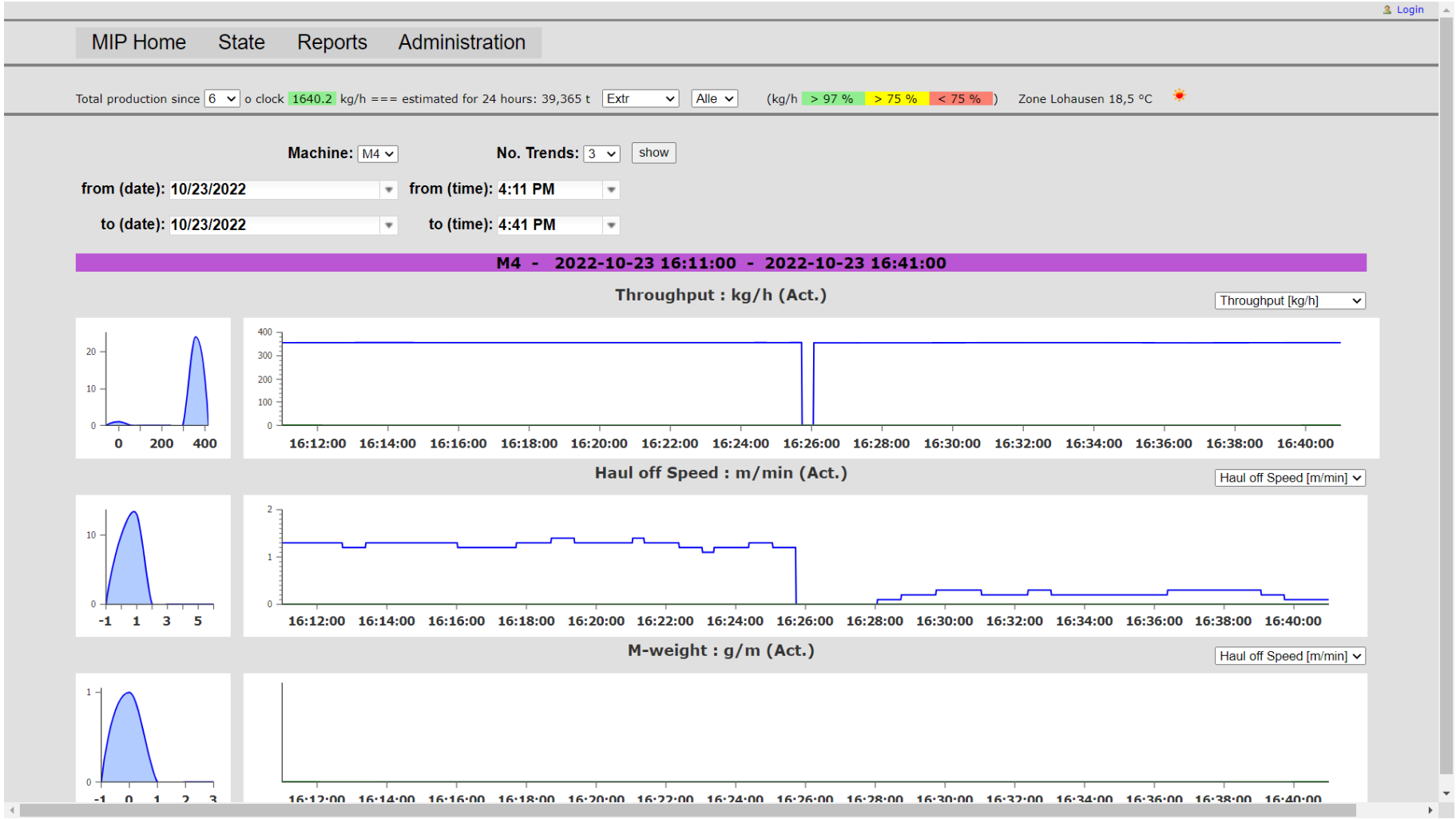
	Extruder A	
yield	1.31	
Ext. Consump. / Portion	0.612	91.9
Dos. 1 Consump. / Portion	0.033	5.0
Dos. 2 Consump. / Portion	0.007	1.0
Dos. 3 Consump. / Portion	0.000	0.0

Raw material	Consumption [t]	Portion [%]
(M2) Greenflex FC 45	0.612	26.7
(M2) 58.000	0.033	1.4
(M2) 578.000	0.013	0.6
(M2) Mixatura Mix4	0.007	0.3
(unknown) unknown	1.625	71.0

1.2.3 – order report (detail view)



1.2.4 – down time report


Login
MIP Home
State
Reports
Administration
Total production since 6 o clock 1640.2 kg/h === estimated for 24 hours: 39,365 t
Extr
Alle
(kg/h > 97 % > 75 % < 75 %)
Zone Lohausen 18,5 °C
Machine: M4
No. Trends: 3
show
from (date): 10/23/2022
from (time): 4:11 PM
to (date): 10/23/2022
to (time): 4:41 PM
M4 - 2022-10-23 16:11:00 - 2022-10-23 16:41:00
Throughput : kg/h (Act.)
Throughput [kg/h]
Haul off Speed : m/min (Act.)
Haul off Speed [m/min]
M-weight : g/m (Act.)
Haul off Speed [m/min]

1.2.5 – Trend

webMIP

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Total production since 6 o clock 785,7 kg/h === estimated for 24 hours: 18,857 t all groups all (kg/h > 95 % > 75 % < 75 %)

Machine: M3 Mono tc show

from (date): 2017-08-07 from (time): T18:39:23 Generate Excel

to (date): 2017-08-07 to (time): T18:49:23

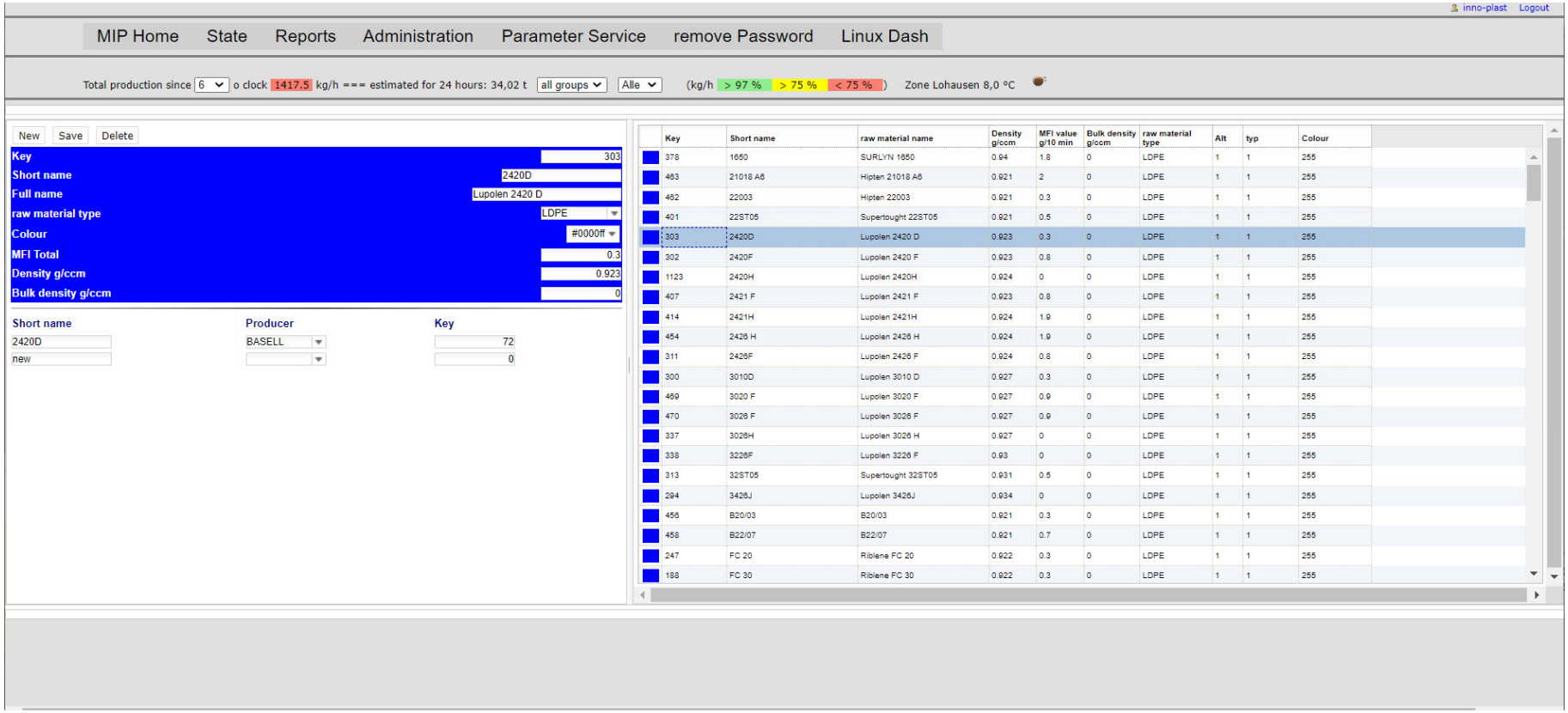
M3 Mono tc 2017-08-07 18:39:23 - 2017-08-07 18:49:23

time	Throughput [Tgt. kg/h]	Throughput [Act. kg/h]	Width [Tgt. mm]	Width [Act. mm]	M-weight [Tgt. g/m]	M-weight [Act. g/m]	Thickn. [Tgt. µm]	Thickn. [Act. µm]	Profile [Act. %]	Haul off Speed [Tgt. m/min]	Haul off Speed [Act. m/min]
2017-08-07 18:48:49	110,0	109,9	1.001,0	0,0	133,1	133,4	60,0	60,2	7,9	13,8	13,7
2017-08-07 18:48:25	110,0	109,9	1.001,0	0,0	133,1	133,5	60,0	60,2	7,9	13,8	13,7
2017-08-07 18:48:19	110,0	109,9	1.001,0	0,0	133,1	133,6	60,0	60,2	7,9	13,8	13,7
2017-08-07 18:48:13	110,0	109,9	1.001,0	0,0	133,1	133,5	60,0	60,2	7,9	13,8	13,7
2017-08-07 18:48:07	110,0	110,0	1.001,0	0,0	133,1	133,5	60,0	60,1	7,9	13,8	13,7
2017-08-07 18:48:01	110,0	110,0	1.001,0	0,0	133,1	133,4	60,0	59,7	7,9	13,8	13,7
2017-08-07 18:47:55	110,0	110,1	1.001,0	0,0	133,1	133,3	60,0	59,5	7,9	13,8	13,8
2017-08-07 18:47:49	110,0	109,4	1.001,0	0,0	133,1	132,3	60,0	59,5	7,9	13,8	13,8
2017-08-07 18:47:43	110,0	109,2	1.001,0	0,0	133,1	131,9	60,0	59,9	7,9	13,8	13,8
2017-08-07 18:47:37	110,0	110,0	1.001,0	0,0	133,1	132,8	60,0	59,9	7,9	13,8	13,8
2017-08-07 18:47:31	110,0	110,1	1.001,0	0,0	133,1	133,0	60,0	59,9	7,9	13,8	13,8
2017-08-07 18:47:19	110,0	110,1	1.001,0	0,0	133,1	133,0	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:47:13	110,0	110,2	1.001,0	0,0	133,1	133,1	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:47:01	110,0	110,1	1.001,0	0,0	133,1	133,0	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:46:49	110,0	110,1	1.001,0	0,0	133,1	132,9	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:46:43	110,0	110,1	1.001,0	0,0	133,1	132,9	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:46:37	110,0	110,1	1.001,0	0,0	133,1	132,9	60,0	59,9	7,9	13,8	13,8
2017-08-07 18:46:31	110,0	110,1	1.001,0	0,0	133,1	133,0	60,0	60,0	7,9	13,8	13,8
2017-08-07 18:46:25	110,0	110,1	1.001,0	0,0	133,1	133,1	60,0	60,1	7,9	13,8	13,8
2017-08-07 18:46:19	110,0	110,1	1.001,0	0,0	133,1	133,3	60,0	60,1	7,9	13,8	13,8
2017-08-07 18:46:13	110,0	110,1	1.001,0	0,0	133,1	133,3	60,0	60,1	7,9	13,8	13,8
2017-08-07 18:46:01	110,0	110,1	1.001,0	0,0	133,1	133,5	60,0	60,1	7,9	13,8	13,8
2017-08-07 18:45:55	110,0	110,1	1.001,0	0,0	133,1	133,5	60,0	60,2	7,9	13,8	13,7
2017-08-07 18:45:49	110,0	110,1	1.001,0	0,0	133,1	133,6	60,0	60,3	7,9	13,8	13,7
2017-08-07 18:45:43	110,0	110,1	1.001,0	0,0	133,1	133,8	60,0	60,3	7,9	13,8	13,7
2017-08-07 18:45:37	110,0	110,1	1.001,0	0,0	133,1	133,8	60,0	60,5	7,9	13,8	13,7
2017-08-07 18:45:31	110,0	110,1	1.001,0	0,0	133,1	134,2	60,0	60,5	7,9	13,8	13,7

1.2.6 – chronological report

1.3 Material tracking

- Centralized management of materials (raw materials)
- automatic synchronization to the machines
- Display of current materials and totals in status and reports
- Expanding reports for product-related evaluations



1.3.1 – Editor of raw materials

Login

MIP Home State Reports Administration

Total production since 6 o clock 1485.4 kg/h === estimated for 24 hours: 35,65 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C

State

Raw material	Consumption kg/h
LDPE - Lupolen 2420 D	307,9
EVA - Greenflex FC 45	96,9
??? - unknown	31,4
ADD - Anti Blocking AB 20B	2,1
CaCO3 - Granic 1522	21,0
ADD - ANTI FOG	10,5
MB - MB Violet	10,5
??? - unknown	10,3
---- - Mixatura Mix4	1,5
??? - unknown	3,1
??? - unknown	175,3
??? - unknown	6,2
??? - unknown	0,3
??? - unknown	2,1
LDPE - Ipethene 113	422,6
MB - MB Orange	3,6
ADD - Processing Aid 60004	2,1
ADD - Additive H2O	5,8
Total	1113,2

Component

Machine Component	Raw material	Consumption kg/h
M1 Extr.A	LDPE - Lupolen 2420 D	50,5
M1 Dos.A1	EVA - Greenflex FC 45	21,0
M1 Dos.A2	??? - unknown	15,7
M1 Dos.A3	??? - unknown	10,5
M1 Dos.A4	??? - unknown	5,2

1.3.2 – Material consumption status

Login

MIP Home | State | Reports | Administration

Total production since 6 o clock 1639.6 kg/h === estimated for 24 hours: 39,35 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C

Machine: All none M1 M2 M3 M4 M5 M6

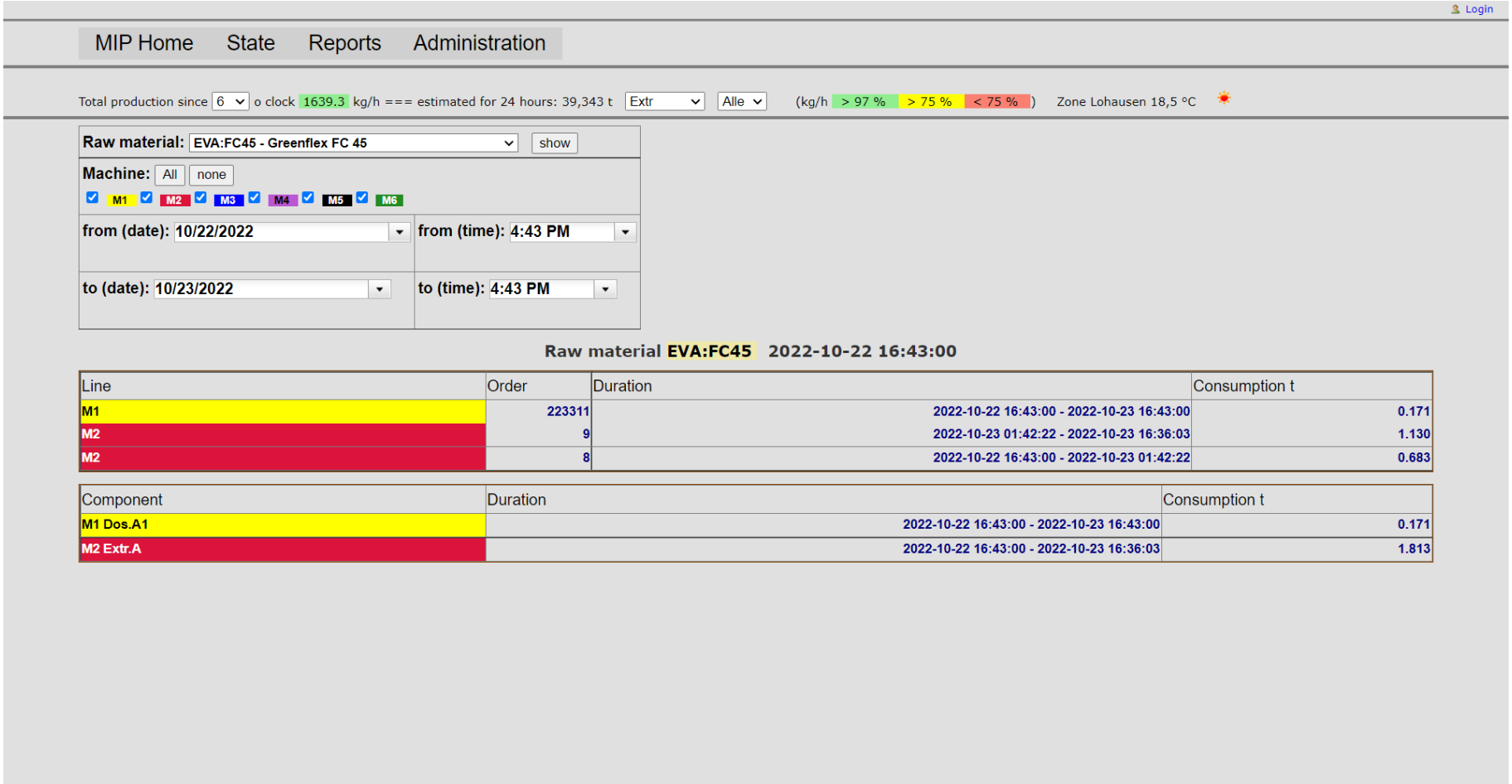
Reports: day report 6:00 AM - 6:00 AM show

from (date): 10/23/2022

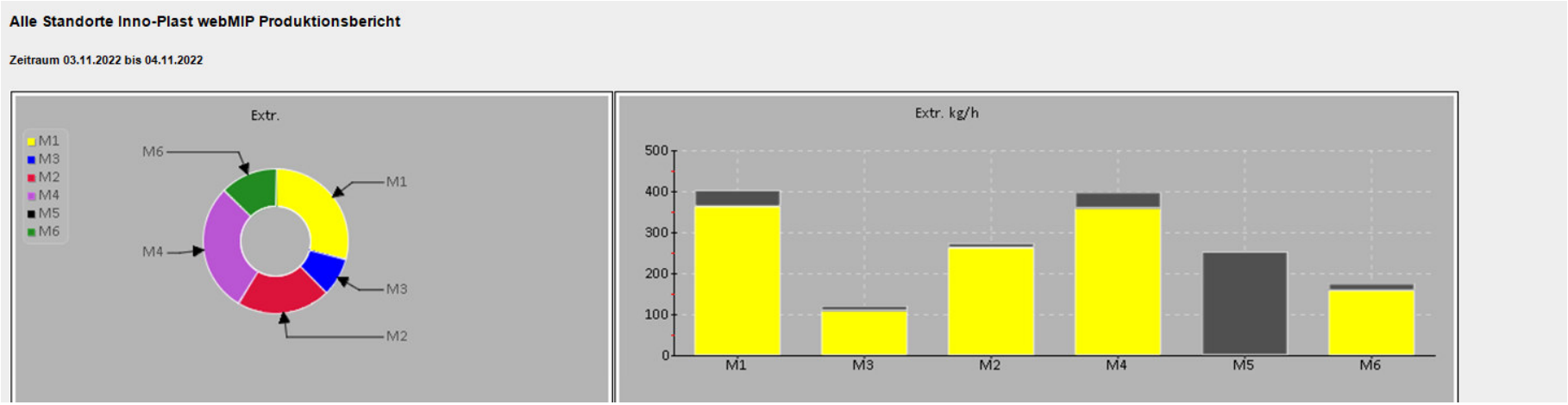
day report 6:00 AM - 6:00 AM 10/23/22

Raw material	Consumption t	€
----:MIXER4 - Mixatura Mix4	0.009	0.00
ADD:AB 20B - Anti Blocking AB 20B	0.015	0.00
ADD:AF - ANTI FOG	0.071	0.00
ADD:PA 60004 - Processing Aid 60004	0.015	0.00
CaCO3:1522 - Granic 1522	0.141	0.00
EVA:FC45 - Greenflex FC 45	0.947	0.00
LDPE:2420D - Lupolen 2420 D	2.083	0.00
LDPE:IPE113 - Ipethene 113	1.544	0.00
MB:ORANGE - MB Orange	0.026	0.00
MB:VIOLET - MB Violet	0.071	0.00
Mat. 0	0.214	0.00
Mat. 58	0.044	0.00
Mat. 578	0.017	0.00
Total	5.195	0.00

1.3.3 – Material consumption report



1.3.4 – Find material in lines and orders



1.4.1 – daily report sent via e-mail

Übersicht Messe K2022 - Extr.

Früh 06:00 - 14:00 / Spät 14:00 - 22:00 / Nacht 22:00 - 06:00

Maschine	Extr.	M1	M3
Plan [kg/h]	518,0	400,0	118,0
Durchsatz Ist Auftrag [kg/h]	465,4	359,7	105,7
Verbrauch Ist [t]	3,339	0,806	2,533
Stillstand Ist [T:h:min]		0:00	0:02
Laufzeit Ist [T:h:min]	1-02:12	2:14	23:58
Früh Plan [kg/h]	518,0	400,0	118,0
Früh Durchsatz Ist Auftrag [kg/h]	465,4	359,7	105,7
Früh Verbrauch Ist [t]	1,647	0,806	0,842
Früh Laufzeit Ist [T:h:min]	10:12	2:14	7:58
Spät Plan [kg/h]	518,0	400,0	118,0
Spät Durchsatz Ist Auftrag [kg/h]	105,7	0,0	105,7
Spät Verbrauch Ist [t]	0,846	0,000	0,846
Spät Laufzeit Ist [T:h:min]	8:00	0:00	8:00
Nacht Plan [kg/h]	518,0	400,0	118,0
Nacht Durchsatz Ist Auftrag [kg/h]	105,7	0,0	105,7
Nacht Verbrauch Ist [t]	0,846	0,000	0,846
Nacht Laufzeit Ist [T:h:min]	8:00	0:00	8:00

Übersicht Berlin - Extr.

Früh 06:00 - 14:00 / Spät 14:00 - 22:00 / Nacht 22:00 - 06:00

Maschine	Extr.	M2	M4	M5	M6
Plan [kg/h]	1087,0	270,0	395,0	250,0	172,0
Durchsatz Ist Auftrag [kg/h]	769,5	258,9	355,7	0,0	154,8
Verbrauch Ist [t]	18,248	6,214	8,425	0,000	3,609
Stillstand Ist [T:h:min]		0:00	0:19	0:00	0:41
Laufzeit Ist [T:h:min]	2-23:00	24:00	23:41	0:00	23:19
Früh Plan [kg/h]	1087,0	270,0	395,0	250,0	172,0
Früh Durchsatz Ist Auftrag [kg/h]	769,5	258,9	355,7	0,0	154,9
Früh Verbrauch Ist [t]	6,083	2,071	2,796	0,000	1,216
Früh Laufzeit Ist [T:h:min]	23:43	8:00	7:52	0:00	7:51
Spät Plan [kg/h]	1087,0	270,0	395,0	250,0	172,0
Spät Durchsatz Ist Auftrag [kg/h]	770,2	259,0	356,4	0,0	154,8
Spät Verbrauch Ist [t]	6,073	2,072	2,818	0,000	1,183
Spät Laufzeit Ist [T:h:min]	23:33	8:00	7:54	0:00	7:39
Nacht Plan [kg/h]	1087,0	270,0	395,0	250,0	172,0
Nacht Durchsatz Ist Auftrag [kg/h]	768,7	258,9	355,1	0,0	154,7
Nacht Verbrauch Ist [t]	6,092	2,071	2,811	0,000	1,210
Nacht Laufzeit Ist [T:h:min]	23:44	8:00	7:55	0:00	7:49

1.4.2 – daily report sent via e-mail

1.5 Commissioning

- Installation of webMIP system in existing Ubuntu Server or from scratch
- Connection of all existing Inno-Plast VIP machines
- Online training from remote
- Training on site at extra request
- three month of remote service included

1.6 Requirements

Recommended machine:

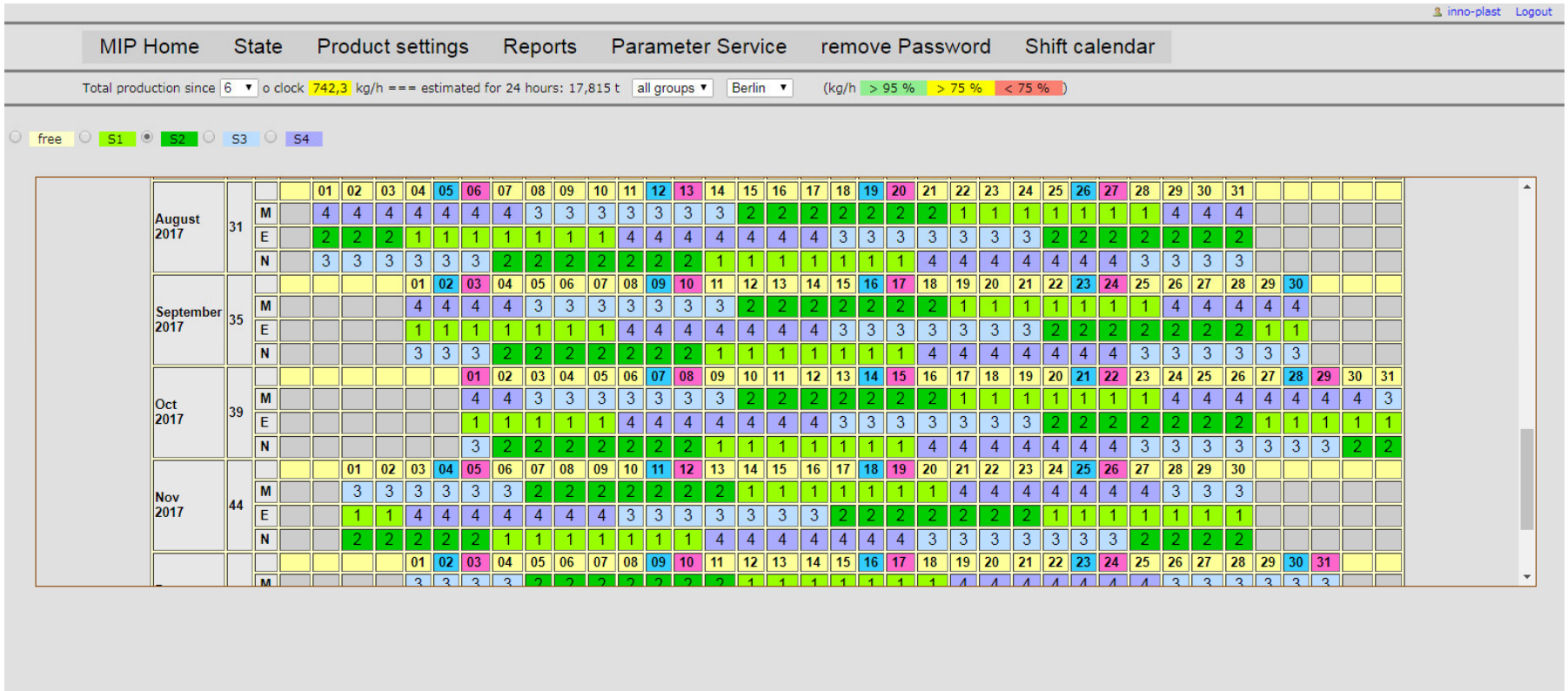
- Server with XEON processor
- 8 GB RAM
- 2x 1TB drive
- Alternatively virtual machine possible
- Permanent remote access to machine in customer local network (incoming SSL, outgoing some ports for service purpose)

2. Expansion Packs

- Shift calendar - Assignment of production data to specific shift-teams
- Silo status, level and tracking
- Record material charges
- Include of bag making and printing devices
- Weather at all locations

2.1 Shift calendar

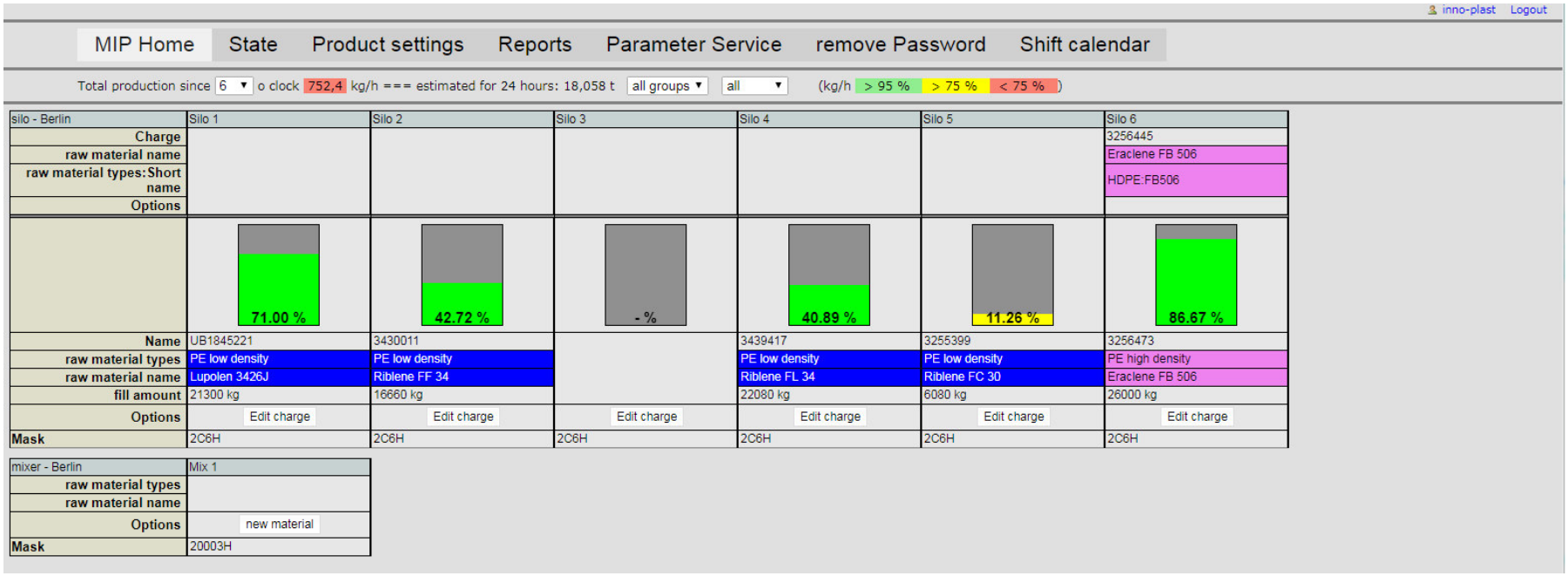
- To assign the process data to each shift team, there is a shift calendar available
- Allows comparison of each team with each other and creating a constructive competition
- Includes monthly report broken down by individual teams



2.1.1 – Shift calendar

2.2 Silo level and Status

- Assignment of material to the silos
- Access in VIP machines for silo/material selection
- Reading of existing fill level sensors
- Silo status and trend



2.2.1 – Silo status with current fill level

Login

MIP Home State Reports Administration

Total production since 6 o clock 1639.0 kg/h === estimated for 24 hours: 39,336 t Extr Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C

All

Machine	Component	silo	Charge	Act. Portion	Throughput kg/h	raw material name	material
M1	Extr.A	-	-	48,0	50,4	unknown	??? - unknown
M1	Dos.A1	Silo 4	-	20,0	21,0	unknown	??? - unknown
M1	Dos.A2	-	-	15,0	15,7	unknown	??? - unknown
M1	Dos.A3	-	-	10,0	10,5	unknown	??? - unknown
M1	Dos.A4	-	-	5,0	5,2	unknown	??? - unknown
M1	Extr.B	-	-	2,0	2,1	unknown	??? - unknown
M1	Dos.B2	-	-	80,0	168,1	unknown	??? - unknown
M1	Dos.B3	Silo 2	-	10,0	21,0	unknown	??? - unknown
M1	Dos.C1	-	-	5,0	10,5	unknown	??? - unknown
M1	Dos.C2	-	-	5,0	10,5	unknown	??? - unknown
M1	Dos.C4	-	-	85,0	89,4	unknown	??? - unknown
M2	Extr.A	-	-	91,9	75,9	unknown	??? - unknown
M2	Dos.A1	-	-	5,0	4,1	unknown	??? - unknown
M2	Dos.A2	-	-	1,0	0,8	unknown	??? - unknown
M2	Dos.A4	-	-	2,0	1,7	unknown	??? - unknown
M2	Extr.B	-	-	90,0	111,2	unknown	??? - unknown
M2	Dos.B1	-	-	5,0	6,2	unknown	??? - unknown
M2	Dos.B4	-	-	5,0	6,2	unknown	??? - unknown
M2	Extr.C	-	-	93,6	64,3	unknown	??? - unknown
M2	Dos.C1	-	-	0,5	0,3	unknown	??? - unknown
M2	Dos.C2	-	-	3,0	2,1	unknown	??? - unknown
M2	Dos.C3	-	-	1,0	0,7	unknown	??? - unknown
M2	Dos.C4	-	-	2,0	1,4	unknown	??? - unknown
M3	Extr.A	Silo 1	-	94,5	98,1	unknown	??? - unknown
M3	Dos.A1	-	-	3,5	3,6	unknown	??? - unknown
M3	Dos.A2	-	-	2,0	2,1	unknown	??? - unknown
M5	Extr.A	-	-	97,0	80,0	unknown	??? - unknown

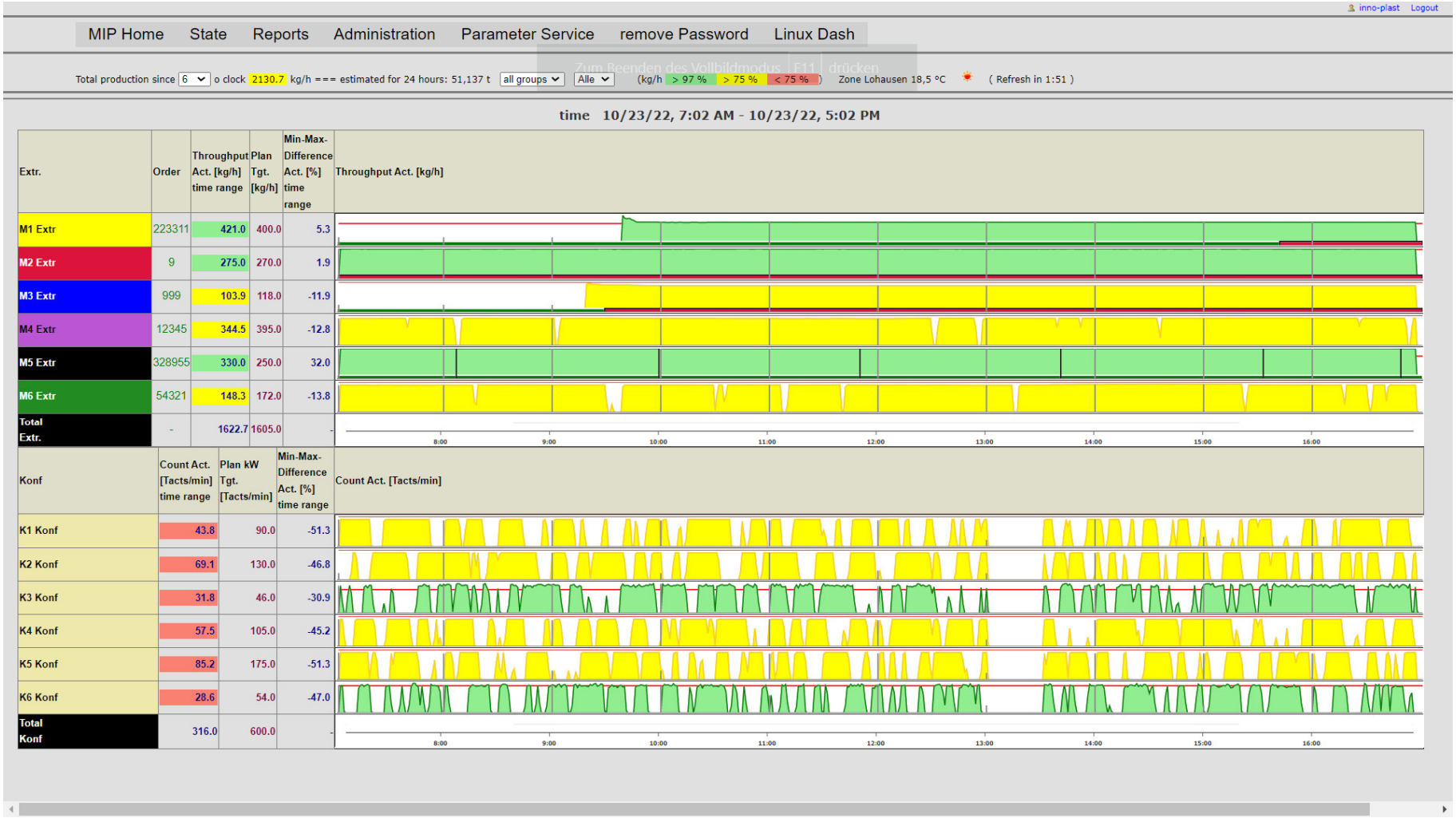
2.2.2 – Silo attachment

2.3 Material charges

- Assignment of material charge to the silos
- Reference of charge in reports
- Select new charge at machine level
- Tracking of charge consumption

2.3 Bag making / printing

- Counting of meters and/or tact signals
- Calculation of m/min or tacts/min
- reports over time and order



2.3.1 – Status with making machines

inno-plast Logout

MIP Home | State | Reports | Administration | Parameter Service | remove Password | Linux Dash

Total production since 6 o clock 2130.0 kg/h === estimated for 24 hours: 51,12 t all groups Alle (kg/h > 97 % > 75 % < 75 %) Zone Lohausen 18,5 °C (Refresh all in 9:52)

Machine: All none M1 M2 M3 M4 M5 M6 K1 K2 K3 K4 K5 K6

Reports: day report 6:00 AM - 6:00 AM show

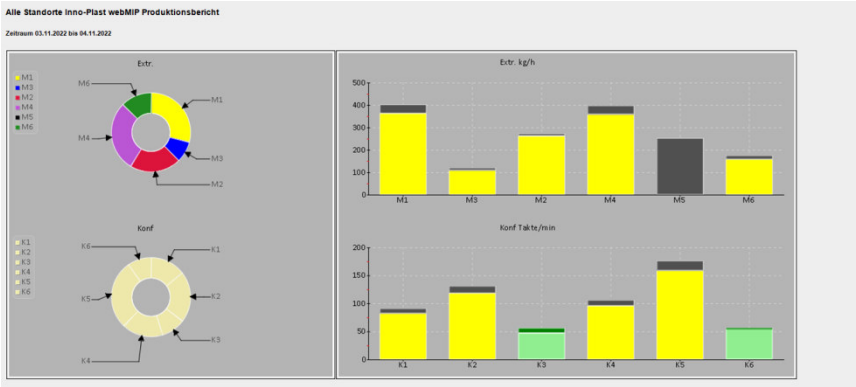
from (date): 10/23/2022

day report 6:00 AM - 6:00 AM 10/23/22

Extr.	Throughput Act. [kg/h] Day	Plan Tgt. [kg/h]	Min-Max-Difference Act. [%] Day	Consump. Act. [t] Day	Good Act. [t] Day	Scrap Act. [t] Day	Scrap Act. [%] Day	Duration Act. [h:min] Day	Down time Act. [h:min] Day	ON time Act. [h:min] Day
M1 Extr	421.0	400.0	5.3	3.023	0.000	0.000	0.0	7:11	0:00	7:11
M2 Extr	275.0	270.0	1.9	3.011	0.000	0.000	0.0	10:57	0:00	10:57
M3 Extr	103.9	118.0	-11.9	0.771	0.000	0.000	0.0	7:25	0:00	7:25
M4 Extr	345.5	395.0	-12.5	3.789	1.792	1.962	50.4	10:41	0:17	10:58
M5 Extr	330.0	250.0	32.0	3.570	0.000	0.000	0.0	10:49	0:00	10:49
M6 Extr	148.8	172.0	-13.5	1.633	0.692	0.924	54.3	10:32	0:27	10:58
Total Extr.	1624.2	1605.0	-	15.797	2.484	2.886	9.5	-	-	-

Konf	Count Act. [Tacts/min] Day	Duration Act. [h:min] Day	Down time Act. [h:min] Day
K1 Konf	44.0	5:56	4:58
K2 Konf	69.7	6:30	4:25
K3 Konf	33.0	5:51	5:07
K4 Konf	58.8	6:48	4:08
K5 Konf	86.6	5:58	4:52
K6 Konf	28.8	5:48	5:06
Total Konf	320.9	-	-

2.3.2 – time report with making machines



Übersicht Berlin - Konf

Früh 06:00 - 14:00 / Spät 14:00 - 22:00 / Nacht 22:00 - 06:00

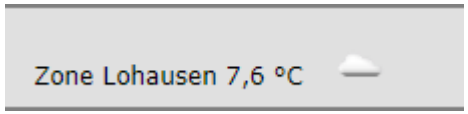
Maschine	Konf	K1	K2	K3	K4	K5	K6
Plan [Takte/min]	600,0	90,0	130,0	46,0	105,0	175,0	54,0
Anzahl Ist Auftrag [Takte/min]	559,0	81,0	117,0	55,0	94,5	157,5	54,0
Produktion Ist [Takte]	316656	44688	64032	32736	60048	83808	31344
Stillstand Ist [T:h:min]		14:48	14:52	15:05	13:24	15:08	14:20
Laufzeit Ist [T:h:min]	2-08:24	9:12	9:08	8:55	10:36	8:52	9:40
Früh Plan [Takte/min]	600,0	90,0	130,0	46,0	105,0	175,0	54,0
Früh Anzahl Ist Auftrag [Takte/min]	559,0	81,0	117,0	55,0	94,5	157,5	54,0
Früh Produktion Ist [Takte]	144240	21264	28464	14976	26352	36960	16224
Früh Laufzeit Ist [T:h:min]	1-02:06	4:23	4:04	4:06	4:39	3:55	5:00
Spät Plan [Takte/min]	600,0	90,0	130,0	46,0	105,0	175,0	54,0
Spät Anzahl Ist Auftrag [Takte/min]	558,9	81,0	117,0	55,0	94,5	157,5	53,9
Spät Produktion Ist [Takte]	151008	20400	31344	15504	28800	41472	13488
Spät Laufzeit Ist [T:h:min]	1-02:31	4:12	4:28	4:12	5:05	4:24	4:10
Nacht Plan [Takte/min]	600,0	90,0	130,0	46,0	105,0	175,0	54,0
Nacht Anzahl Ist Auftrag [Takte/min]	559,2	81,0	117,0	55,0	94,5	157,5	54,2
Nacht Produktion Ist [Takte]	21408	3024	4224	2256	4896	5376	1632
Nacht Laufzeit Ist [T:h:min]	3:46	0:37	0:36	0:37	0:52	0:34	0:30

Produktion > 97% vom Soll
Produktion > 75% vom Soll
Produktion < 75% vom Soll

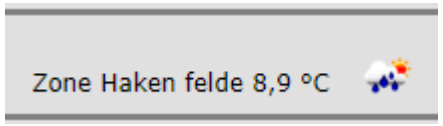
2.3.3 – daily report sent via e-mail with making machines

2.4 Weather

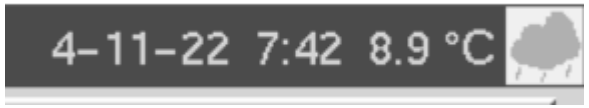
- Current weather in all factory locations
- Connected to VIP if available
- Implementing openweathermap.org



Weather at the K-show



Weather at Inno-Plast, Berlin



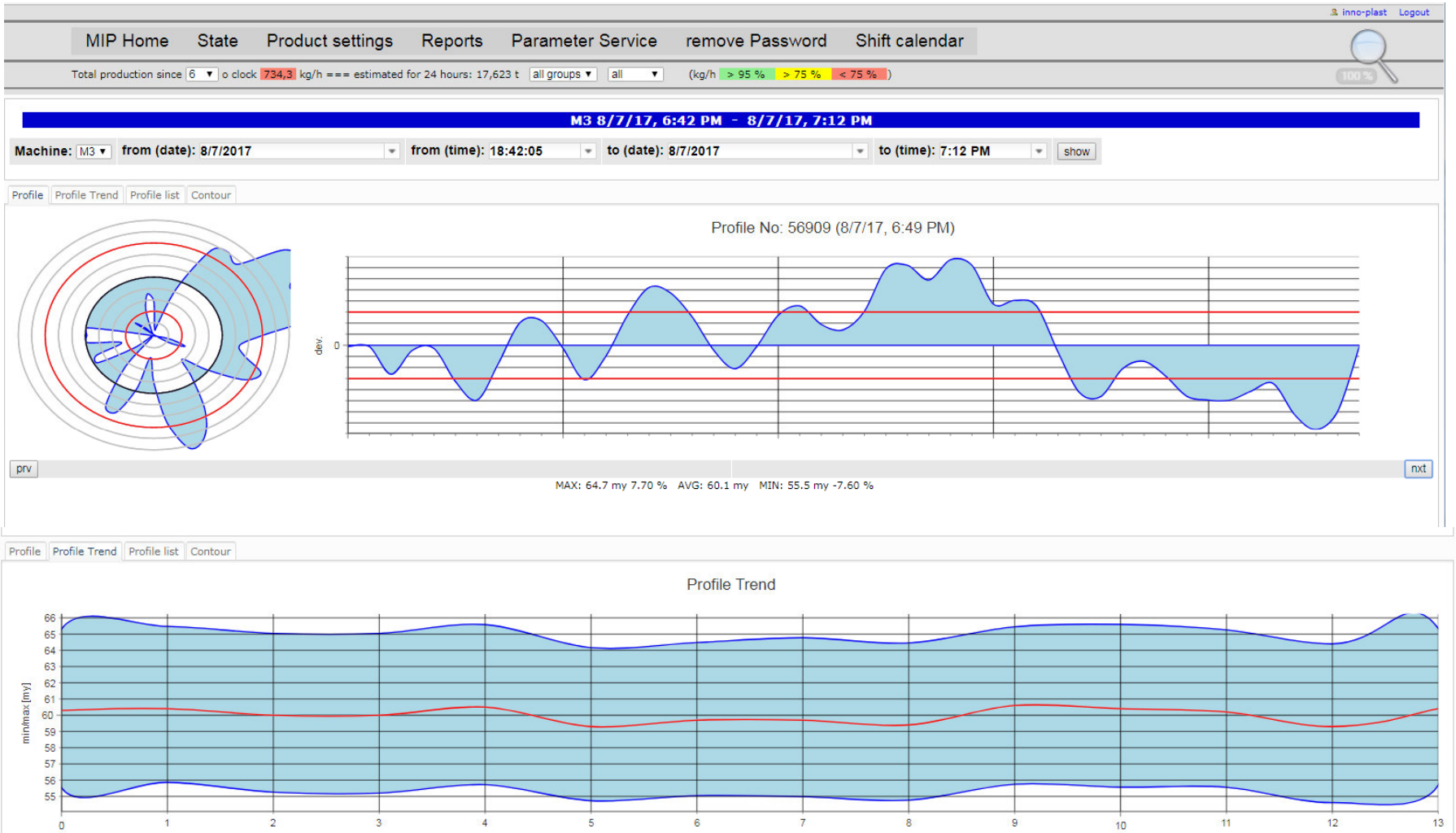
VIP display

3. Quality enhancements

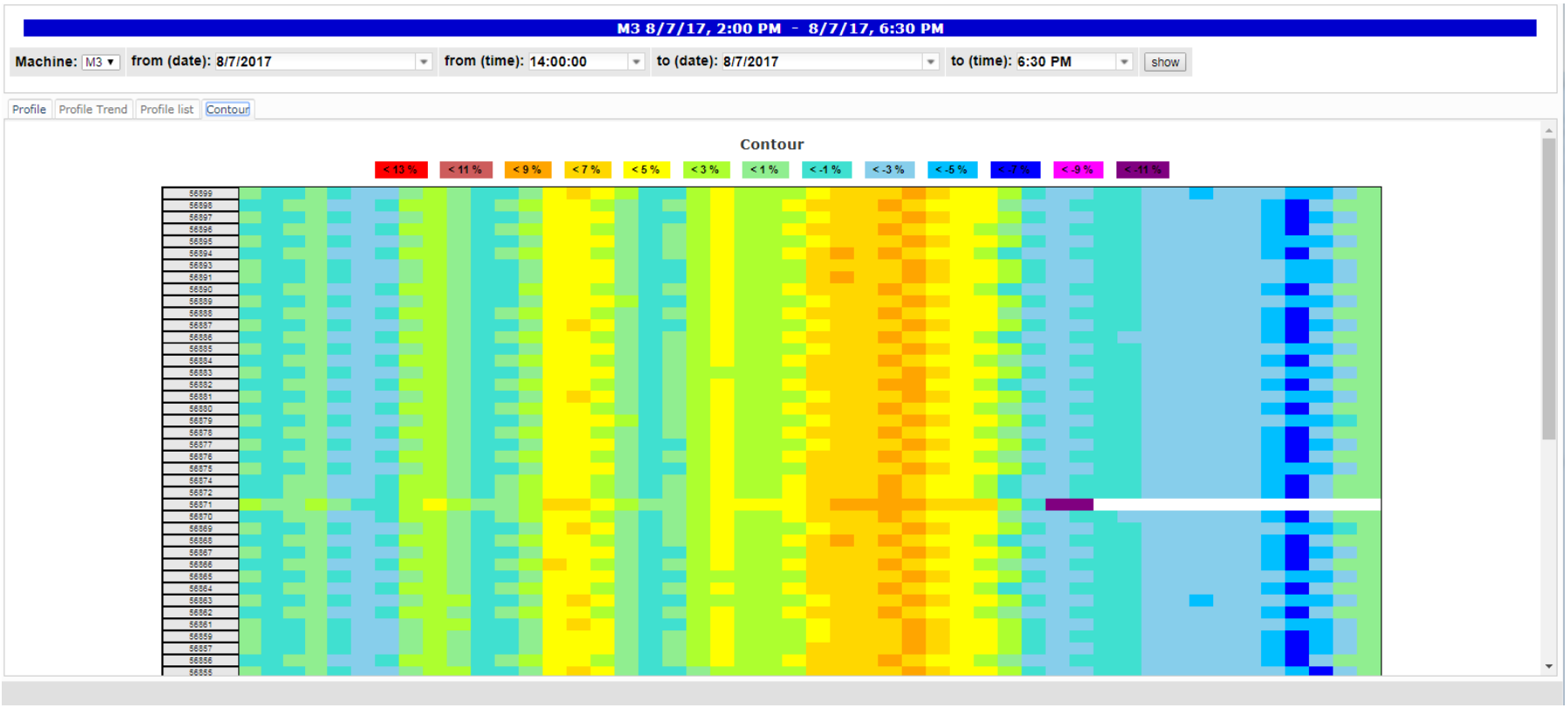
- Cross-tolerance profile trends, averages, contour representation
- Quality analysis of typical variations in produced and shipped orders
- Assignment of quality parameters to the reels produced
- Energy data

3.1 Cross-tolerance-profile

- Trends of thickness tolerances measured by profile measuring systems
- Contour map for the assessment of longitudinal fluctuations
- Averaging over any period of time, e.g. roll/order/shift
- Simplified analysis of rolls and orders in subsequent quality inquiries



3.1.1 – Profile report



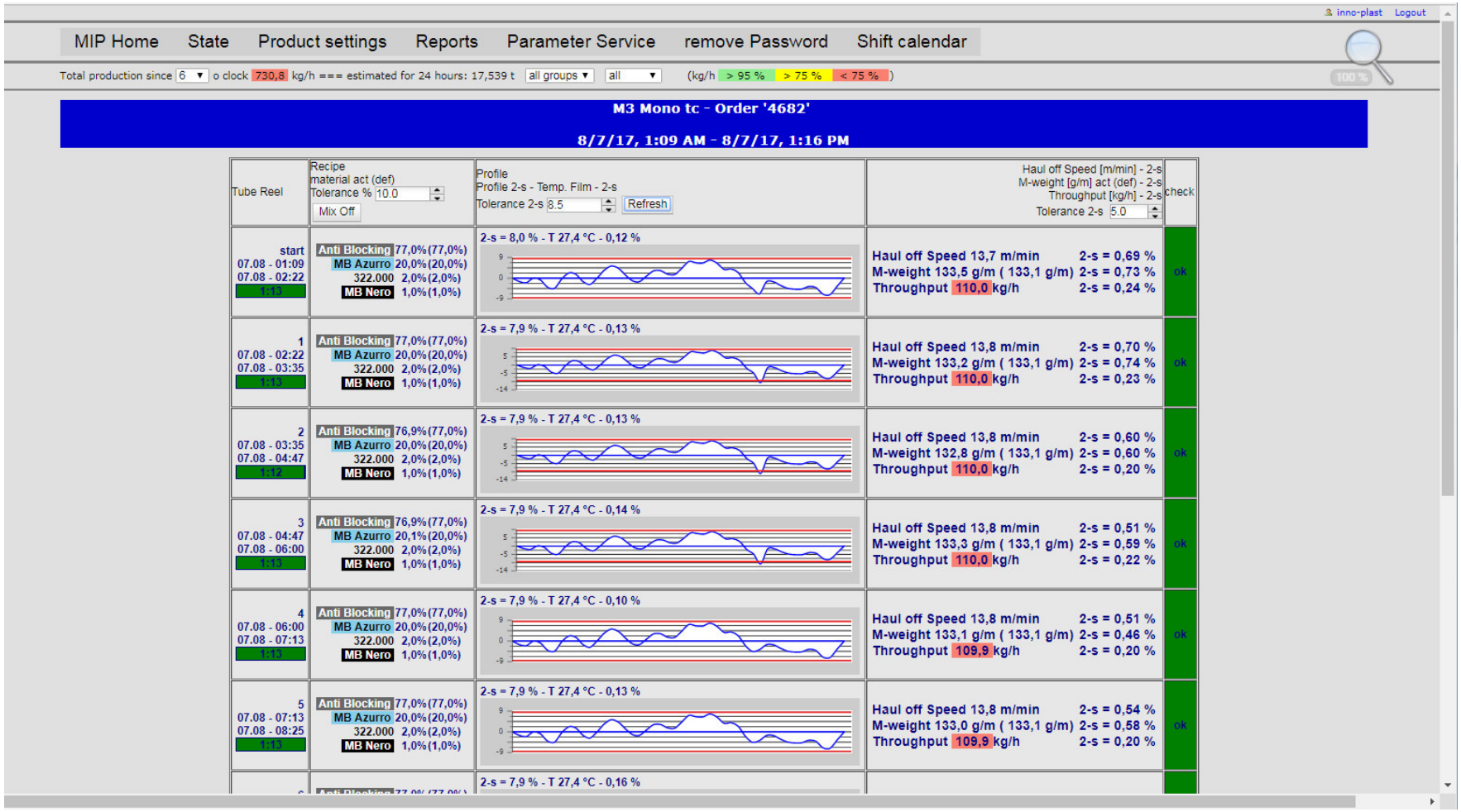
3.1.2 – Profile report (Contour)

3.2 Quality analysis

- Analysis of typical deviations
- Representation of the quality produced (linear meter weight, film thickness, percentage of material composition of the film) of produced and delivered orders

3.3 Reel / Target change

- New entry on each reel cur or target change
- Analysis of each cut with averaged profile and 2-sigma of production variables



3.3.1 – Reel report including profile

3.4 Energy data

- Reading existing energy data
- Referencing energy consumption in the time or order reports and trends

4 Connectivity

- Connect to any Inno-Plast system
- Read data from Modbus or OPC/UA
- Individual interfaces on demand
- Automatic sending production mails
- Social media connection on request