What is Factbird manual process line and manual production counter?

Manual process line

- The Factbird manual process line feature is ready-to-use web-based software where operators can easily and intuitively log downtime, part or product counts, scrap, and scrap reasons. The data is analyzed and visualized in the Factbird Cloud Application, which is accessible on any device with a browser.
- Manual process line consists of manual production counter for good count and scrap count and manual downtime logging.

Manual production counter

• The Factbird manual production counter can be integrated as a scrap counter into production lines or equipment that have sensors for automated production counting. This scrap counter can be configured to track scrap by different types, automatically generating visualized scrap analytics. The Factbird Cloud Application allows viewing both manual and automated processes within the same standard.

1

Create sensors

- 1. Go to "Administration" page.
- 2. Go to the "DEVICES" tab.
- 3. Click on the device labeled "VIRTUAL" under the "Type" category, then click on "ADD SENSOR".
- 4. Click on "Add new sensor", complete the information, and then click "CREATE SENSOR".
- 5. It will be marked as "Created".

FACTBIRD			2			ТІСІАЛА ТІСАДИАСТИВО.СОМ			• 0			
Blackbird ApS			USERS	GROUPS	ROLES	se	DEVICES	ES	ORGANIZATION			
0013d1506b4f2301 🖍 🔳												
STATUS			HARDWARE ID 0013d1506b4f230					TYPE Factbird Duo				
BOOTLOADER VERSION 3.0.0	Se	t up sensor							>	3		
SENSORS Q. Search.		4 Add new senso	or						~	0400 5 *	+ ADD	Actions
			_	_		_			DON	IE		

*If you can not find a device labeled "VIRTUAL", please contact Factbird.

USER GUIDE Manual Process Line / Manual Production Counter



3a

Create Manual process line

- 1. Toggle the "Manual production count" and "Manually enter downtime" sliders on the "BASIC INFORMATION" tab
 - a. Turning on the "**Manual production count**" slider activates the counter for good counts..
 - b. Turning on the "**Manually enter downtime**" slider enables manual logging of downtime.
- 2. Go to the **"LINE SETUP"** tab and click on "**CREATE LINE**" to create a line with the sensor by following the instruction.

	FACTBIRD		TICIANA GALAJAH TIGAHCLOGREJCHER DIE NE	⊕	0
mi	Manage sensor settings	3		×	>
((+))	BASIC	Sensor name *			
ø	SPEEDS	Manual process demo A			
*	LINE SETUP	Sensor description			
		Sensor type * Manual Process	•		
	[Manual production count Manually enter downtime			
		All fields marked with an asterisk (*) are required.			
*			X DISCARD CHANGES 🗸 UPDATE SENSOR CONFIG	JRATION	
	_				
E					

3. On the "**REGISTER STOPS**" tab, you can view the main counter and manual downtime logging function.

←	LIVE REGISTER STOPS BATCHES	ANALYTICS > :	"Manual production count" slider and "Manually enter downtime"
EDIT INPUT	ADD QUANTITY	+1	slider are on.
< 30M 1H 4H 8H 12H	24H 48H 72H >		
Selected, 5/12/2024, 1.22 PM IO1IOW	LINSERT STOP	► BEGIN STOP	
1930 1400 1430 1500 1530	1600 1630 1700 1730 1800 1830	1900 1930 2000 2030 2100	
← ⁴ usermanualline1 ~ <	LIVE REGISTER STOPS BATCHES	ANALYTICS > ;	
▲ 4H 8H 12H 24H 48H	72H 1W 🛱 🗲	•••• •	"Manually enter downtime" slider
Selected: 3/12/2024, 1:23 PM to now	INSERT STOP	▶ BEGIN STOP	13 011.
13:30 14:00 14:30 15:00 15:30 7	16:00 16:30 17:00 17:30 18:00 18:30 1	9:00 19:30 20:00 20:30 21:00	

Create Manual process line - add scrap sensors

- 1. Repeat step 1 to create another sensor, this time for scrap. The "**Name**" you assign to the sensor will be displayed as the name of the scrap sensor. For example, if you name the sensor "shape error scrap," the button for counting will display "shape error scrap."
- 2. Go to the "Line Setting" of the line created in step 3.
- 3. Select the scrap sensor and specify its placement.
 - "Scrap sensors prior to the bottleneck" means the quantity of the scrap sensors is not subtracted from the good parts count.
 - "Scrap sensors after the bottleneck" means the quantity of the scrap sensors is subtracted from the good parts count and shown as quality loss on the OEE page.
 - The scrap sensor's value will be displayed in the KPI "Scrap" on the "LIVE" page.



4. On the "REGISTER STOPS" tab, you can view the scrap counter.

Scrap ‡ ① RESET 22 pcs Main ‡ ② RES EDIT INPUT ADD QUANTITY +1 EDIT INPUT ADD QUANTITY +1 30M 1H 4H 8H 12H 24H 48H 72H 1W 1 1 1 Image: Compare the second	+	💪 Manual test	• <	LIVE		REGISTER ST	OPS	BATC	HES	ANALYTIC	s	OEE	TRENDS	\$	>	:
EDIT INPUT ADD QUANTITY +1 EDIT INPUT ADD QUANTITY +1 SIM 1H 4H BH 12H 24H 4BH 72H 1W C The second se	Scrap	٥				€S F	ESET 22	2 pcs	Main	۵				Ð	RESET	38 pcs
30M 1H 4H BH 12H 24H 4BH 72H 1W C ► Selected 2/20/2024, 8:30 AM to now Image: selected		EDIT INPUT	ADD C	QUANTITY		+1				EDIT INPUT		ADD QU	ANTITY	+	1	
	30M Selecte	1H 4H 8H d: 2/20/2024, 8:30 AM to no	12H 24H	I 48H 72	н 1	w _ 🛱 _	2				□ INSERT ST	'OP	► BEGIN STOP	v e <u>c</u>	ANDON	(4)
uesau uesau uesau iusau iusau iisau iisau iisau 1230 1330 1830 1430 1430 1830 1830 1830 1830	08:30	09:00 09:30	10:00	10:30	11:00	11:30	12:00	12.3)	13:00 13:30	14:00	14:30	15:00	18.30 16:0	0	16:30

3b

Create a scrap sensor for an existing line

- In step 1, the "Name" you assign to the sensor will be displayed as the name of the scrap sensor. For example, if you name the sensor "shape error scrap," the button for counting will display "shape error scrap."
- 2. Turn on the "Manual production count" slider and turn off the "Manually enter downtime" slider on the "BASIC INFORMATION" tab.
- 3. Click on "UPDATE SENSOR CONFIGURATION".

	FACTBI	RD	TICIANA GALAJXHI TIGA+DEMO@BLACKBRD.ONLINE	ENGLISH (US) 🌐 🛛 (?
I	Manage sensor se	ttings		×	
ľ	BASIC INFORMATION	Sensor name * Missing component - no fitting			
L.	SPEEDS	Sensor description			
I	LINE SETUP	Sensor type * Manual Process		•	
l		Manual production count Manually enter downtime			
l		All fields marked with an asterisk (*) are required.			
		X DI	SCARD CHANGES 🗸 UPDA	TE SENSOR CONFIGURATIO	IN
	200				

$\mathbf{4}_{b}$

Add a scrap sensor to an existing line

- 1. Go to the "Line Settings" of the line you want to add the scrap sensor to.
- 2. Select the scrap sensor and specify its placement.
 - a. "**Scrap sensors before the bottleneck**" means the quantity of scrap sensors is not subtracted from the good parts count.
 - b. "Scrap sensors after the bottleneck" means the quantity of scrap sensors is subtracted from the good parts count and shown as quality loss on the OEE page.
 a. The agree sensor's value will be displayed in the KDI "Scrap" on the "LIVE" page.
 - c. The scrap sensor's value will be displayed in the KPI " $\ensuremath{\textbf{Scrap}}$ " on the " $\ensuremath{\textbf{LIVE}}$ " page.





KPI "Scrap" on "LIVE" page.

3. On the "**REGISTER STOPS**" tab, you can view the scrap counter.

+	4 2. Factbird Live Demo Manufacturing Intelligence Solution	↓ <	LIVE	REGISTER STOPS	BATCHES	ANALYTICS	> :
Scrap	\$						S RESET 0 pcs
	EDIT INPUT		AD	D QUANTITY		+1	
30M Select	1H 4H 8H ed: 3/13/2024, 9:56 AM to now	12H 24H 48H	72H 1W	5 S		~ 0	ANDON
50 Bottles/min 25	Meeting	ClearingA					
	10:00AM 10:30AM 11:00AM	11:30AM 12:00PM 1	2:30PM 01:00PM 01:	30PM 02:30PM 02:30PM Date	03.00PM 03:30P	м 04:00РМ 04:30РМ 05:0	OPM 05:30PM 06:0

5

Use manual production counter

- 1. With a manual production counter you can count good parts and scraps manually.
 - a. Good parts counters: The green counter represents the "bottleneck sensor" shown as "**Main**", counting the number of produced parts on the line. This is only on manual process line.
 - b. **Scrap** counters: If an additional virtual sensor is added as a "**scrap sensor**" in the "**Line settings**", it will be displayed as a scrap counter. Multiple scrap sensors can be added on a line, providing multiple options for different types of scraps. When the counting button is pressed, the operator will be prompted to choose from the available reasons.
- 2. Press the "ADD QUANTITY" or "+1" button to record counts.
 - a. When you add a count, it may take up to 30 seconds before it becomes visible in other areas of the system, such as the "LIVE" page or the "BATCHES" page. However, the local value next to "**RESET**" icon will immediately display the changing value on the screen. This feature helps operators track their production, such as the amount produced since the beginning of a shift or batch.



USER GUIDE Manual Process Line / Manual Production Counter

6

Use manual production counter - set primary quantity

The primary counting quantity "+1" button can be adjusted by clicking the gear icon.



Use manual production counter - edit inputs

Press the "**EDIT INPUT**" button to view previously submitted counts. In the dialog, you can make changes or delete counts. Please note that it may take up to 30 seconds for new data to appear.

Scrap a	\$	Recent counts			×	RESET 38 pcs
	EDIT INF	S There may be a delay of	up to 30 seconds before new data is shown. Currently showing data	from the last 10 minutes.	C	+ 25
2014	114	Timestamp	Quantity			
Selected:	2/20/2024	2/20/2024, 5:13:36 PM	1		/ 🔋	
		2/20/2024, 5:13:38 PM	1		/ 🔋	ANDON (4)
		2/20/2024, 5:13:39 PM	1		/ =	
		2/20/2024, 5:13:45 PM	12		/	
09	9.30				Total Rows: 4	17:00
UNPLAN	NED		CANCEL	CONFIRM	л	
UNPLAN	NED DOWNT	TIME				

7

Use manual downtime logging - This is only for manual process line

On **Sensor setting**, turning on the "**Manually enter downtime**" slider enables manual downtime logging.

There are two ways to log downtime on a Manual process line.

- "BEGIN STOP" button: You can either use the "BEGIN STOP" button to indicate that the process has stopped. Afterwards, you will be prompted to choose a stop cause from the available options. The line will be marked as stopped, and the button will change to an "END STOP" button. When the process is running again, click the "END STOP" button to end the stop.
- 2. "INSERT STOP" button: If you want to insert a stop that happened in the past, you can use the "INSERT STOP" button. When you click it, you'll be shown a dialog where you can select a stop cause and enter the "Start" and "End' times of the stop. If the stop is still ongoing, you can toggle the checkbox "Ongoing".

