USER GUIDE

Manual Process Line / Manual Production Counter

What is Factbird manual process line and manual production counter?

Manual process line

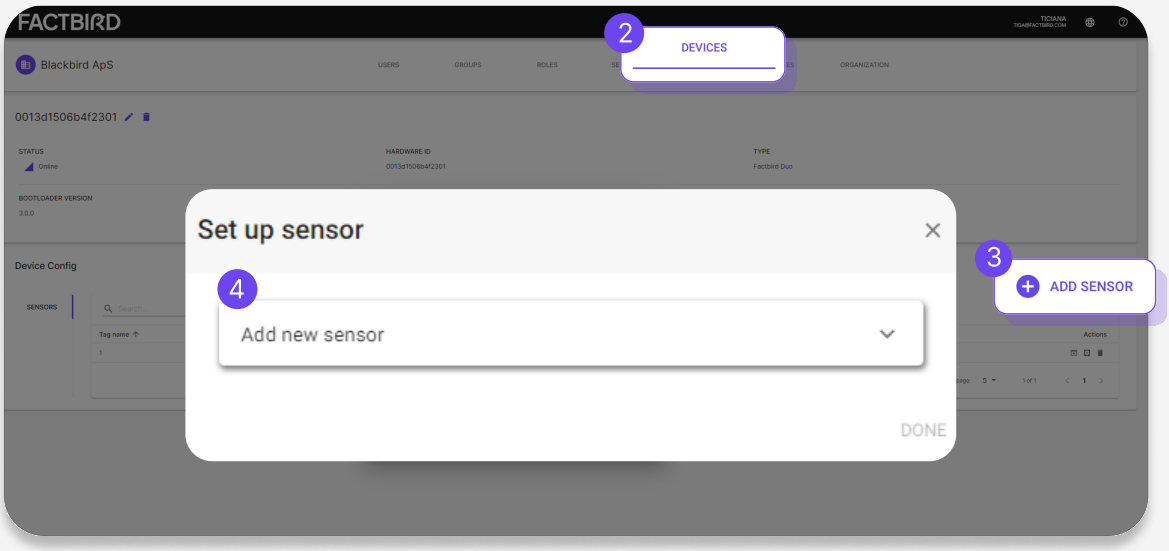
- The Factbird manual process line feature is ready-to-use web-based software where operators can easily and intuitively log downtime, part or product counts, scrap, and scrap reasons. The data is analyzed and visualized in the Factbird Cloud Application, which is accessible on any device with a browser.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

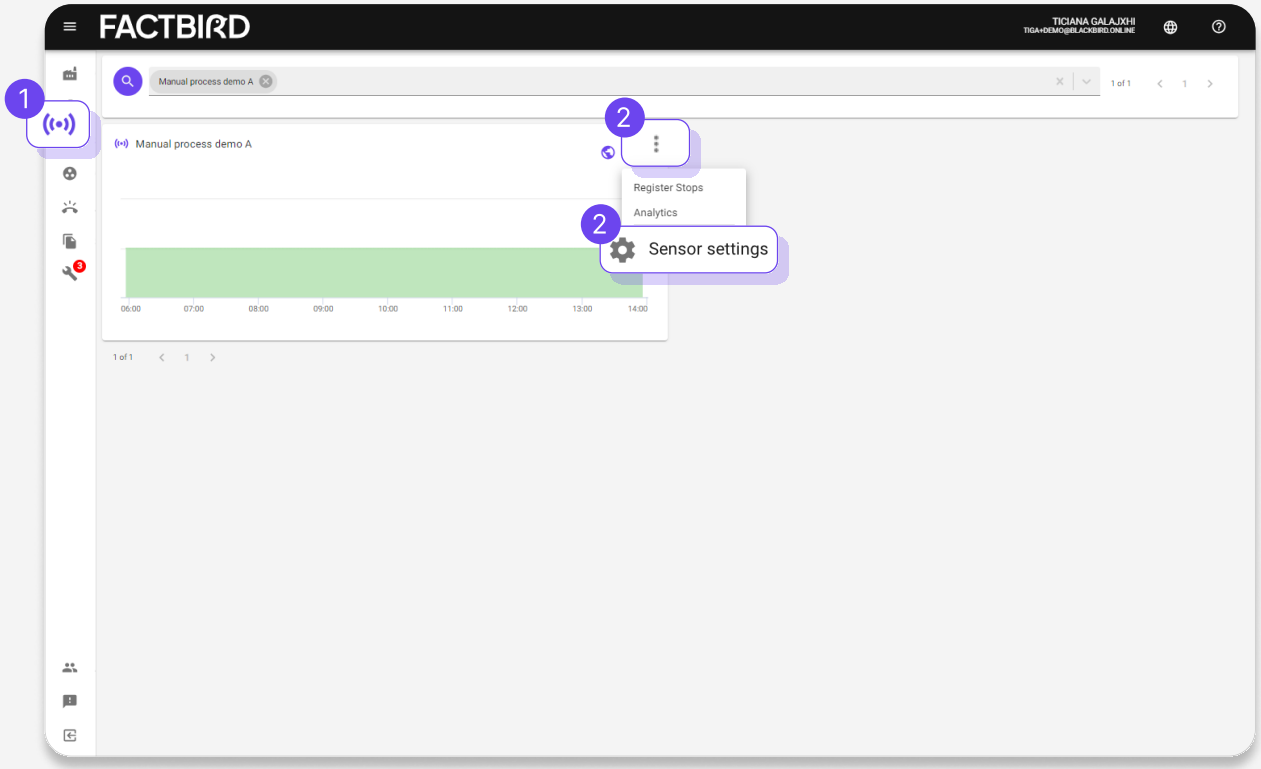
1. Go to **“Administration”** page.
2. Go to the **“DEVICES”** tab.
3. Click on the device labeled “**VIRTUAL**” under the “**Type**” category, then click on “**ADD SENSOR**”.
4. Click on “**Add new sensor**”, complete the information, and then click “**CREATE SENSOR**”.
5. It will be marked as **“Created”**.



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

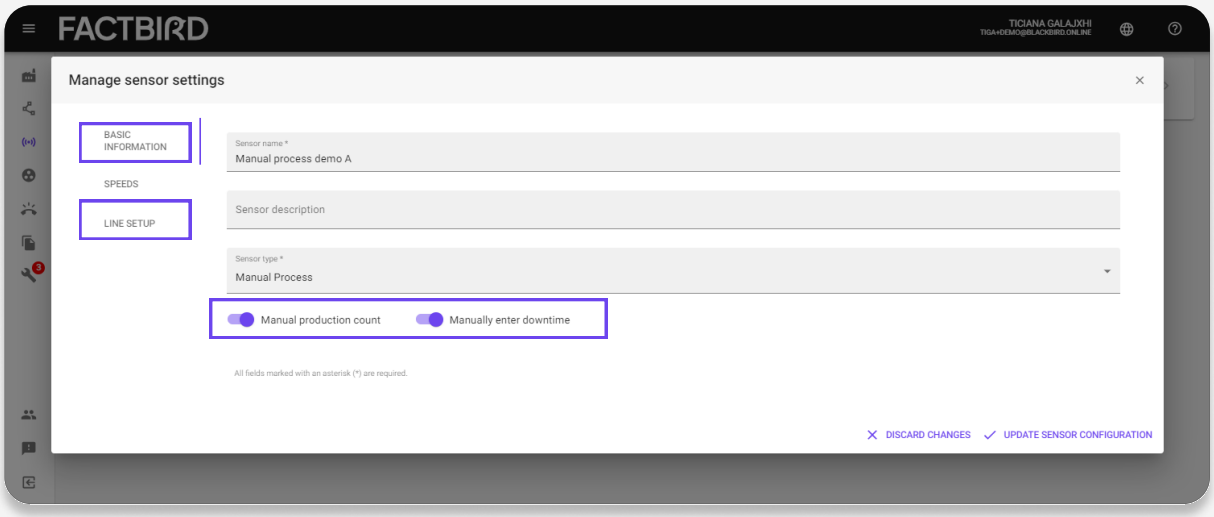
2 Go to sensors settings

1. Click on **“Sensors”** from the menu on the left side of the view
2. Click on the three dots and select **“Sensor settings”**

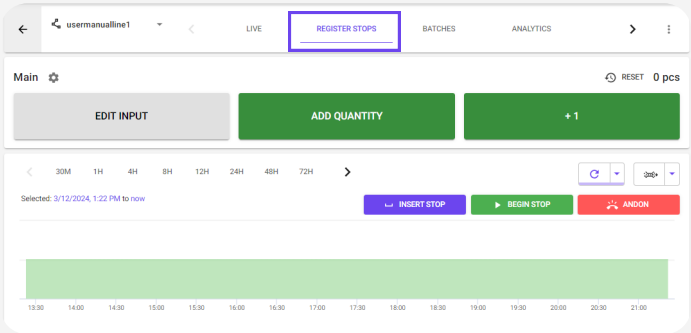


3a Create Manual process line

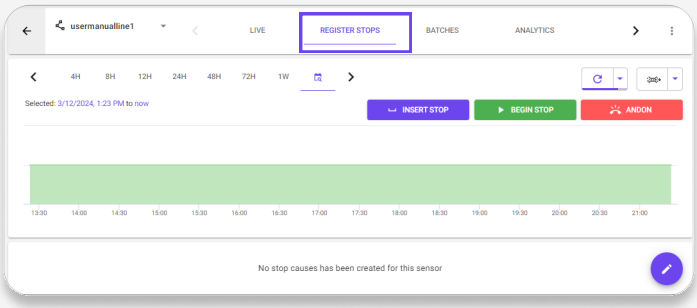
1. Toggle the "**Manual production count**" and "**Manually enter downtime**" sliders on the "**BASIC INFORMATION**" tab
   a. Turning on the "**Manual production count**" slider activates the counter for good counts..
   b. Turning on the "**Manually enter downtime**" slider enables manual logging of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



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



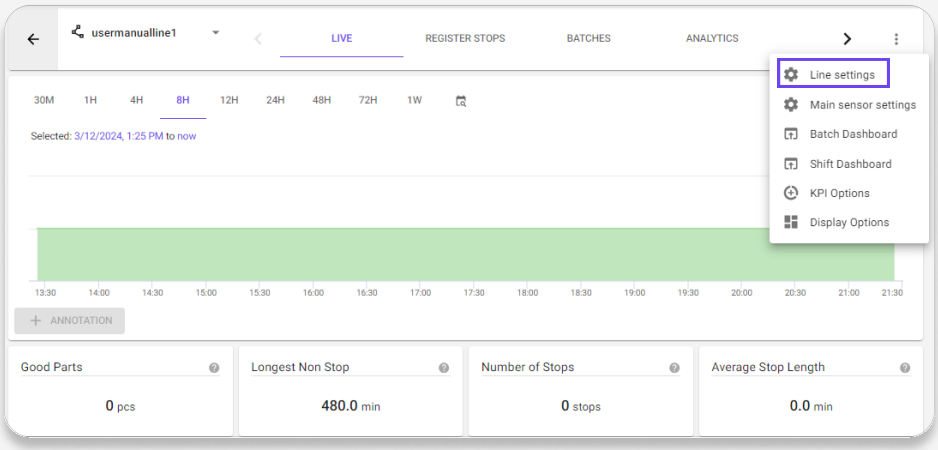
"**Manual production count**" slider and "**Manually enter downtime**" slider are on.

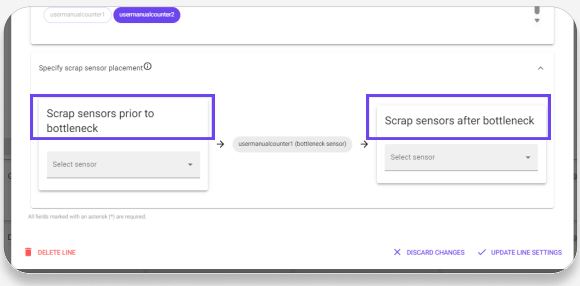


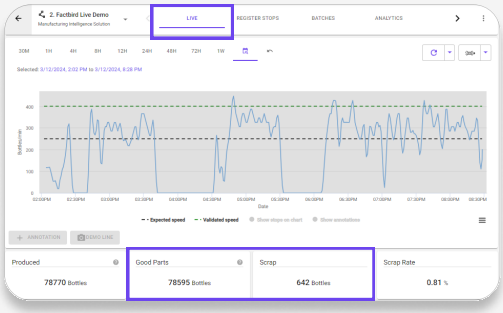
"**Manually enter downtime**" slider is on.

4a Create Manual process line - add scrap sensors

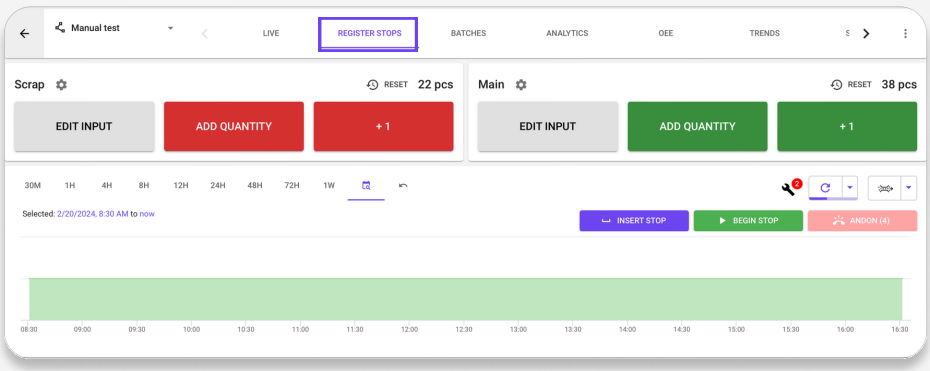
1. Repeat step 1 to create another sensor, this time for scrap. The "**Name**" you assign to the sensor will be displayed as the name of the scrap sensor. For example, if you name the sensor "shape error scrap," the button for counting will display "shape error scrap."
2. Go to the "**Line Setting**" 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.





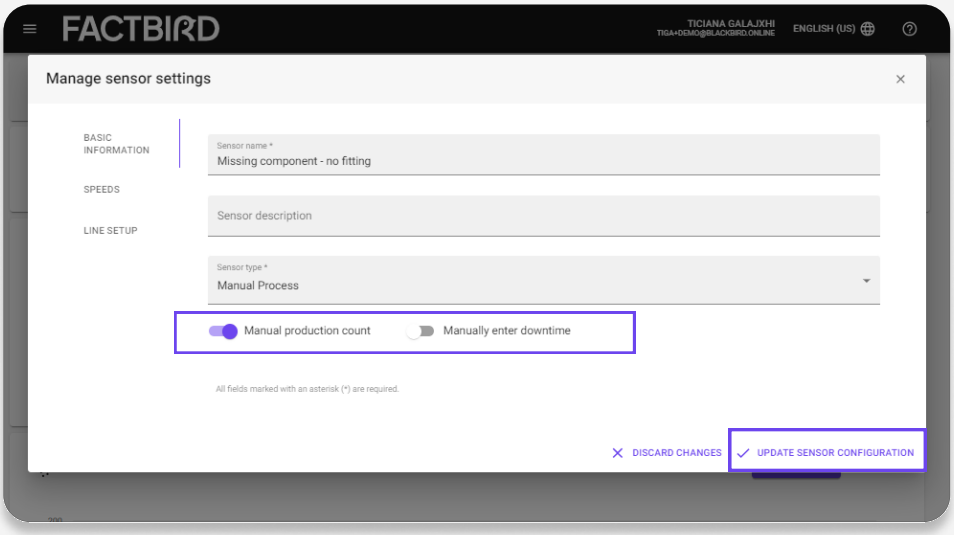


4. On the "**REGISTER STOPS**" tab, you can view the scrap counter.



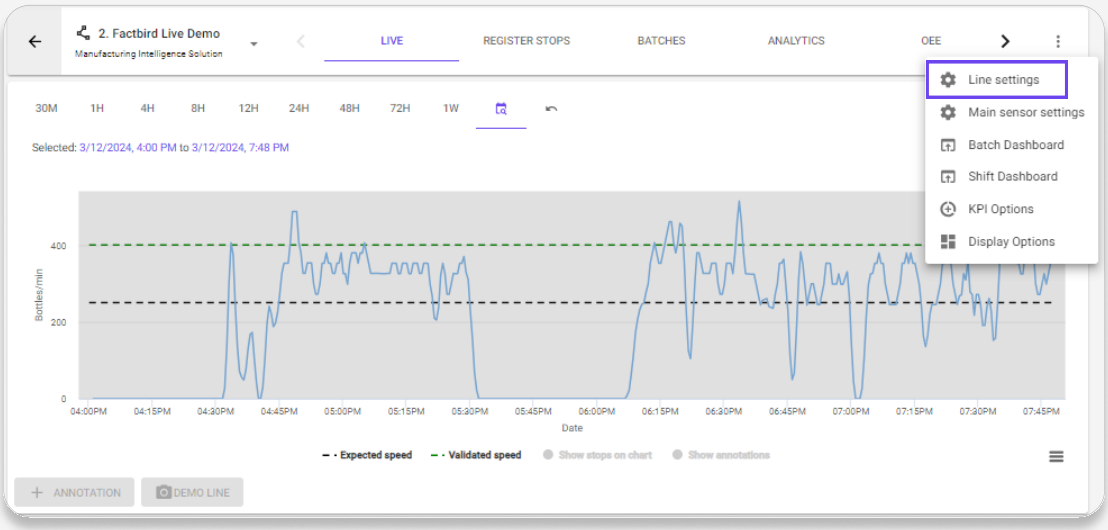
3b Create a scrap sensor for an existing line

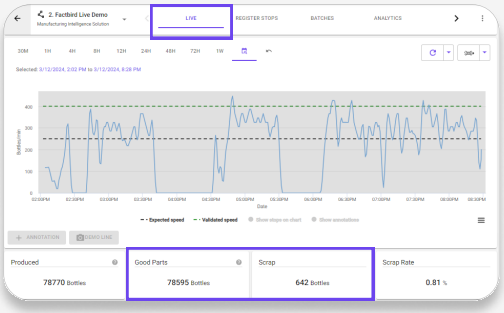
1. In step 1, the "**Name**" you assign to the sensor will be displayed as the name of the scrap sensor. For example, if you name the sensor "shape error scrap," the button for counting will display "shape error scrap."
2. Turn on the "**Manual production count**" slider and turn off the "**Manually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



4b Add a scrap sensor to an existing line

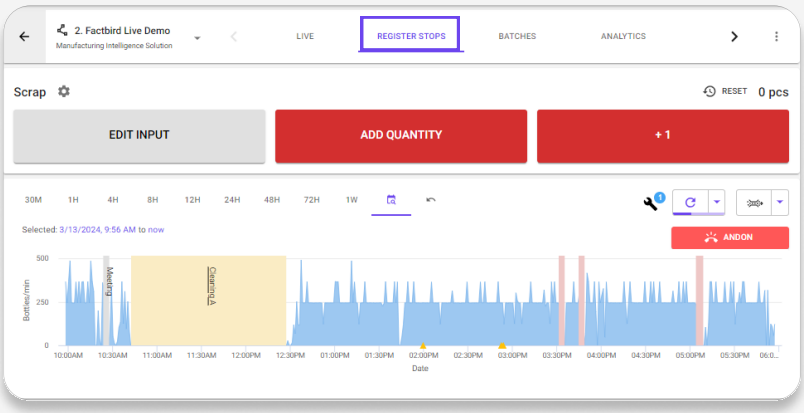
1. Go to the "**Line Settings**" of the line you want to add the scrap sensor to.
2. Select the scrap sensor and specify its placement.
   a. "**Scrap sensors before the bottleneck**" means the quantity of scrap sensors is not subtracted from the good parts count.
   b. "**Scrap sensors after the bottleneck**"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





KPI "**Scrap**" on "**LIVE**" page.

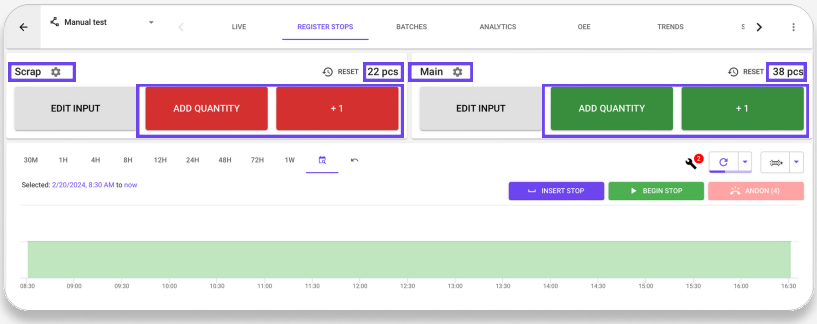
3. On the "**REGISTER STOPS**" tab, you can view the scrap counter.



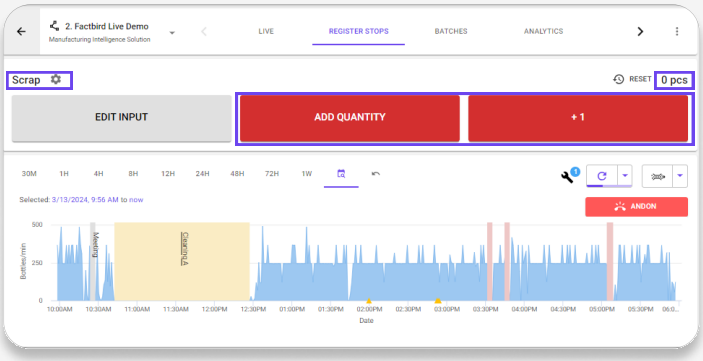
5 Use manual production counter

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.

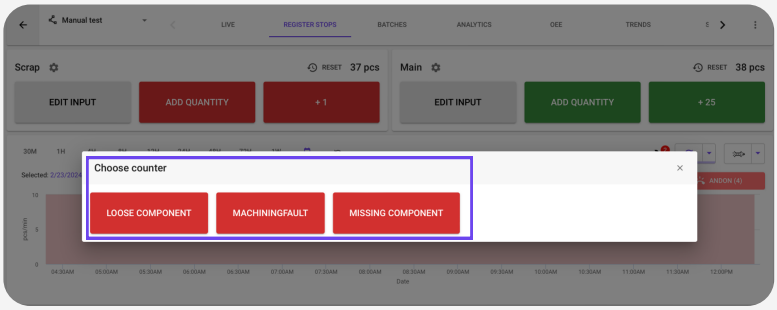
2. Press the “**ADD QUANTITY**” or “**+1**” button to record counts.
   a. When you add a count, it may take up to 30 seconds before it becomes visible in other areas of the system, such as the “LIVE” page or the “BATCHES” page. However, the local value next to “**RESET**” icon will immediately display 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.



A good parts counter and scrap counter on a manual process line.



Scrap counter on an existing line.

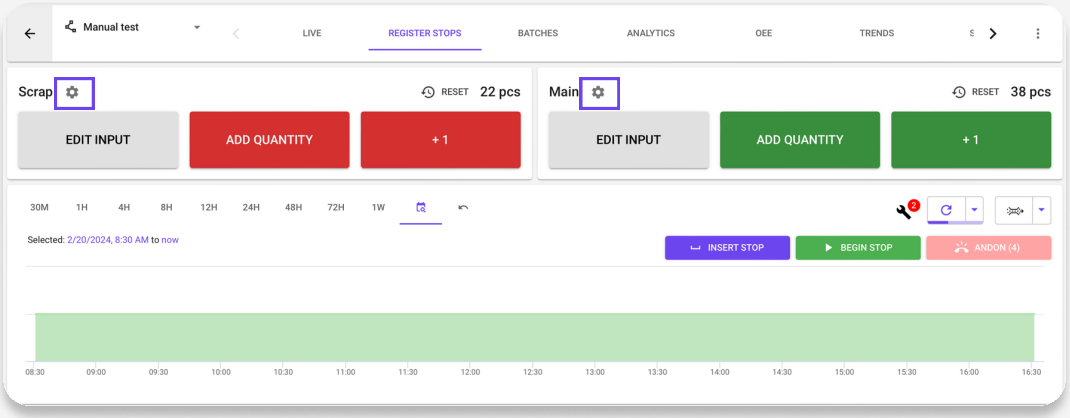


Choosing scrap reasons

6

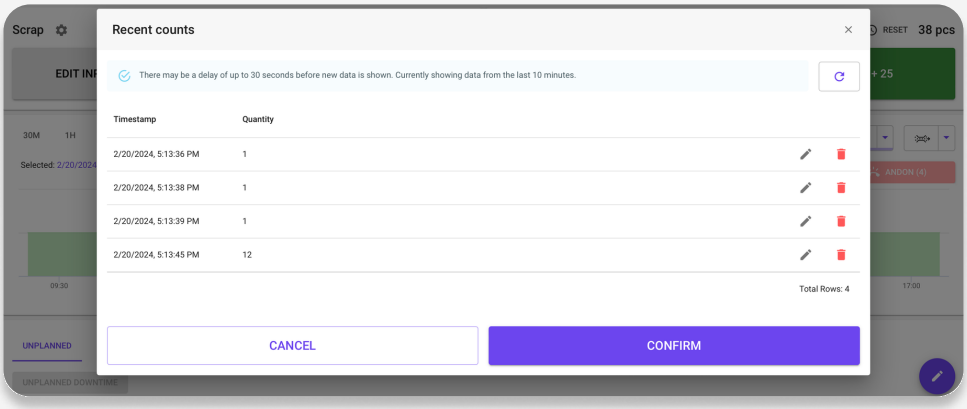
Use manual production counter - set primary quantity

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.



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.

1. **“BEGIN STOP”** button: You can either use the “**BEGIN STO**P” 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**”.