
Coupled machines

Overview

Concerned User, Supervisor

Subject Use of the coupled machines feature.

In ITMProcess, it is not possible to create a dyelot that uses two or more machines at the same time. You have to create a virtual machine that has the total volume of the machines you want to couple.

The coupled-machines feature is nothing else than a production report that will print a production card for each machine and that distributes chemicals quantities on each production card.

Links!

If ITMProcess is linked to other systems (PPS or DMSS), be sure that your link is compatible with coupled machines before to use this feature.

General

Version

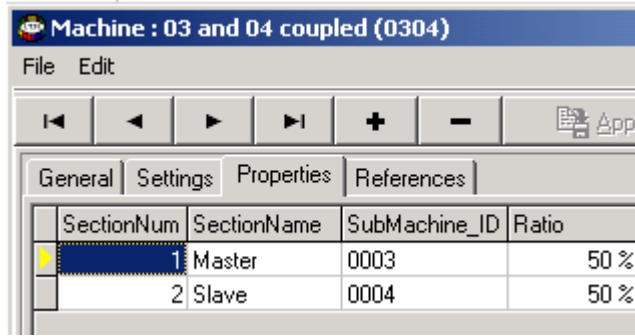
The coupled machine feature is available since ITMProcess v2.3.1.
Current document has been written at ITMProcess v2.3.1.

Configure

Machines

- Check that the single machines exist.
- Create a new machine and, in tab Properties, add a row for each single machine.
- Select first, in field **SubMachine_ID**, the master single machine
Fill **SectionNum** with 1 (1 indicates to ITMProcess that it is the master)
Fill **SectionName** (not mandatory)
Fill **Ratio** with the volume percentage

- Then add the slave machines with SectionNum 2,3 ...



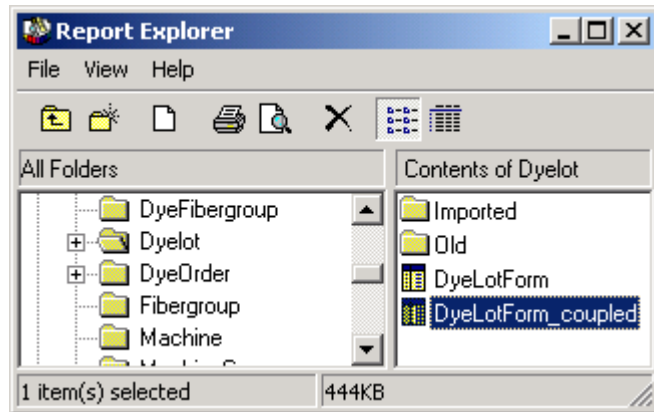
Production report

You must use the report from the ITMReportExplorer.

Be sure that ITMRegistry | User Setting | Use old print template format = No.

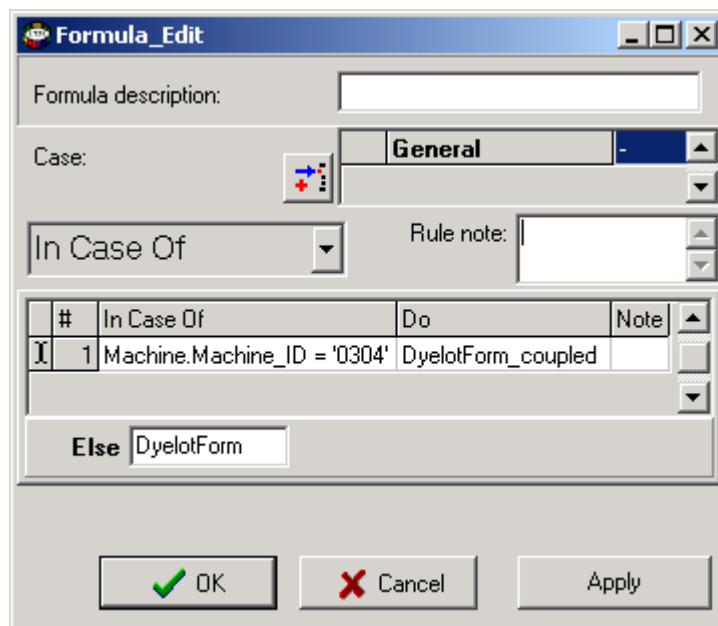
In ITMReportExplorer, in folder Dyelot, create a new report and load the existing report from the file
 \Datacolor\Common Files\ITMReports\DyeLotForm_coupled.rtm

Save the report.



PrintForm formula

You can use the same report for non-coupled and coupled machines or you can introduce a PrintForm formula like this one.




Use


Create a dyelot on the coupled machine.

When you print the dyelot, the production card is composed by one card by machine.

The master machine card contains the general header and all details (chemicals and parameters).

2003-0006	0		0	600 kg
		2003-0006		
1079-002 Production Form DCI 2003-04-01 14:27:15				
Recipe Rec ORANGE Acryl2		Pac-Dolan-X56		Preparation
Color type STD ORANGE PL		Quality Pac-Dolan-X56		SpecialRequest
Customer		vWarpDesc		LabRecipe ID
		vVertDesc		
		Density		vWidth
BAS-Acryl BAS-Acryl		Expert		
JET	0304	03 and 04 coupled	Volume 6000 l	
Basic98			Liquor ratio 1/10	
1	Master	50 %	Weight 300 kg	
	0003	03	Volume 3000 l	
BAS-ACRYL				
1			Dissolve separately Avolan IW	
A-IW	Avolan IW	0,5000%	1500 g	
ACAC	Acetic Acid	0,3mM	900 ml	
NaAc	Sodium acetate	0,5000g/l	1500 g	
	<i>pH value</i>	5		
2	AY5GL Astrazon Yellow 5GL 200	0,2911%	873,16 g	
	ABRRG Astrazon Brilliant Red G 200	0,2370%	711 g	
	ABL3RL Astrazon Blue 3RL 200	0,0164%	49,16 g	
	<i>Astragal Calculation</i>	0,23		
AS-RMA	Astragal RMA	1,7437%	5231 g	C(retarder)= (Sf - Sum(f.c)) / f(retarder))
	<i>Starting Temperature</i>	65°C		
	<i>Heating Speed</i>	1°C/min		

The slave machine card contains the sub header and the chemicals.

2003-0006	0		0	600 kg
		2003-0006		
2	Slave	50 %	Weight 300 kg	
	0004	04	Volume 3000 l	
BAS-ACRYL				
1			Dissolve separately Avolan IW	
A-IW	Avolan IW	0,5000%	1500 g	
ACAC	Acetic Acid	0,3mM	900 ml	
NaAc	Sodium acetate	0,5000g/l	1500 g	
2	AY5GL Astrazon Yellow 5GL 200	0,2911%	873,16 g	
	ABRRG Astrazon Brilliant Red G 200	0,2370%	711 g	
	ABL3RL Astrazon Blue 3RL 200	0,0164%	49,16 g	
AS-RMA	Astragal RMA	1,7437%	5231 g	C(retarder)= (Sf - Sum(f.c)) / f(retarder))
			Drain	
Warm Rinse Overflow				
Cold Rinse Overflow				
Total Time				