

Control Masters Application Case Study

Downtime Tracking

DOWNTIME SELECTION

CHOOSE
Dt CODE
###

DOWNTIME

###MIN : ##SEC

Mechanical

DtCode	Primary
3	Mixer
4	Divider
5	Rounder
7	Sheeter
8	Moulder
10	Proofer
14	Oven
15	Depanner
18	Pan Unstacker
19	Pan Stacker
20	Moline Line
21	Other Reason - Mech
72	Ishida
73	Overhead Proofer
74	Proofer feed conveyor
75	Proofer exit conveyor
76	Oven feed conveyor

Non-Mechanical

DtCode	Primary
23	No Dough
24	Addback Dough
25	Additional Fermentation Needed
28	Additional Proofing Needed
33	Idle Time
38	Other Reason - Non Mech
77	Bad weights
78	Changeover
79	Dough jam - Rounder
80	Dough jam - Overhead proofer
81	Dough jam - Sheeter
82	Pan jam - Proofer feed
83	Pan jam - Oven feed
84	Pan jam - Oven exit
85	Proofer dwells
86	Slow / No pans - Operator issue

PREVIOUS SCREEN

Services Provided

Database Integration & Consultation
PLC &HMI Programming

Software Utilized

Rockwell Software RSSQL
Microsoft Access
Panelbuilder 32

Project Description

A local bakery required a simple and inexpensive method for logging equipment downtime.

The existing logging involved the manual collection of downtime during the shift with subsequent data entry into a custom Microsoft Access database after the shift was over by the supervisors. The process was time consuming and prone to inaccuracies.

A more automated system was needed that fit into the existing infrastructure.

Since there was an existing PLC and line computer, all that was needed was RSSQL to finish the link between the existing database and the equipment.

Now when the equipment stops, the operator must select a downtime code from the HMI prior to restarting the equipment. If no downtime code is entered, the equipment does not run.

Once the customer saw the possibilities in RSSQL, additional items were added. Product codes are entered at the start of the run and all the conveyor drive speeds for that product are downloaded from the database to the drives. The start and end time of the product run are also logged.