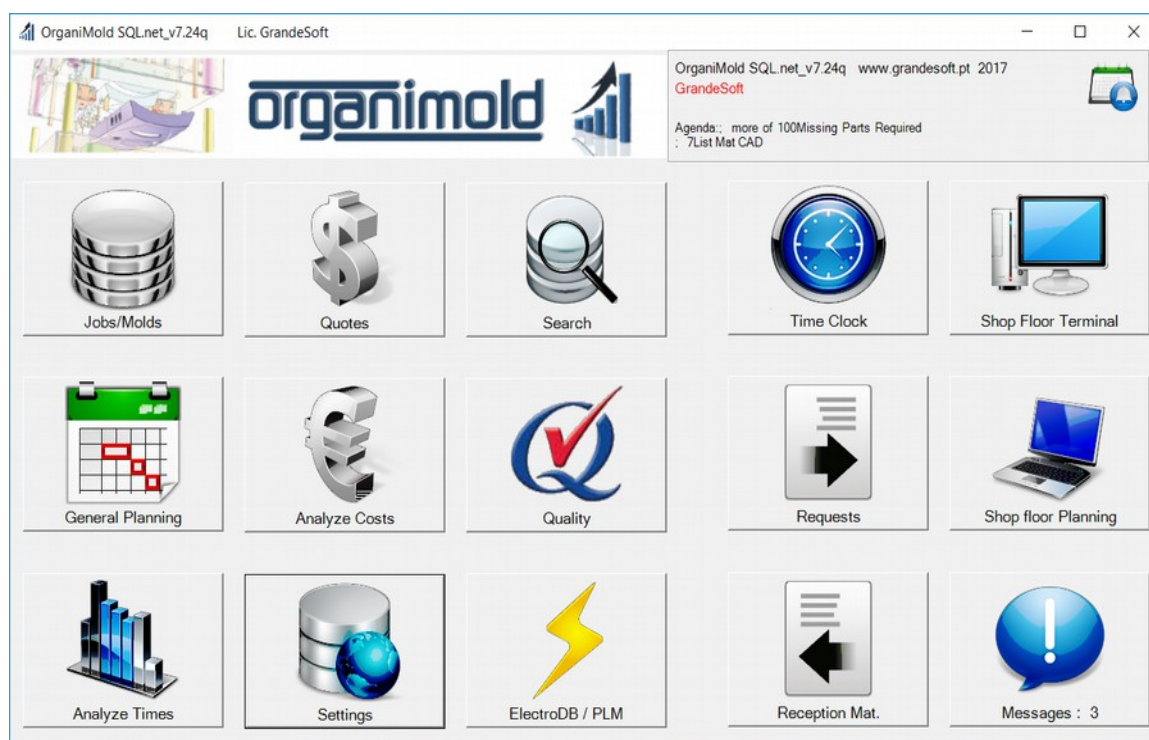


organimold

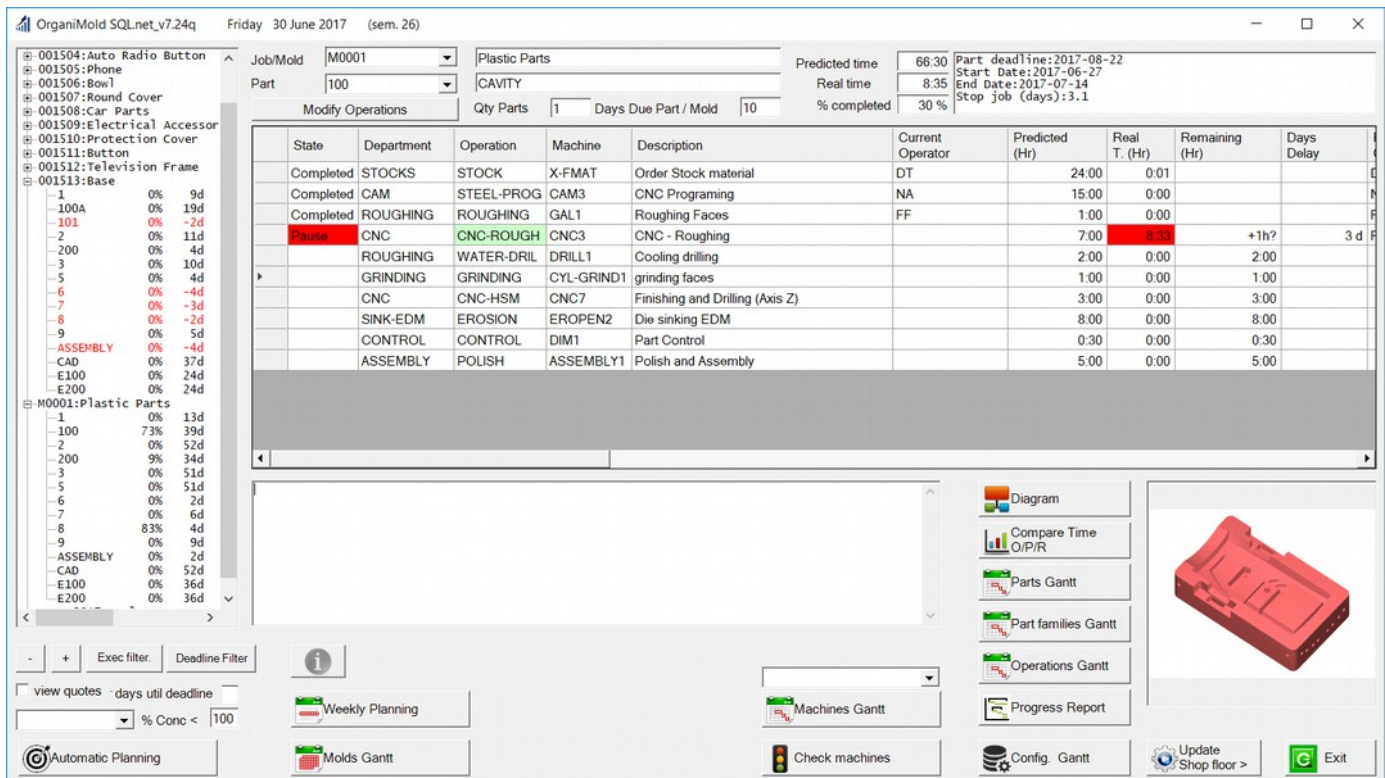


GrandeSoft | Advanced Software Solutions | www.grandesoft.pt



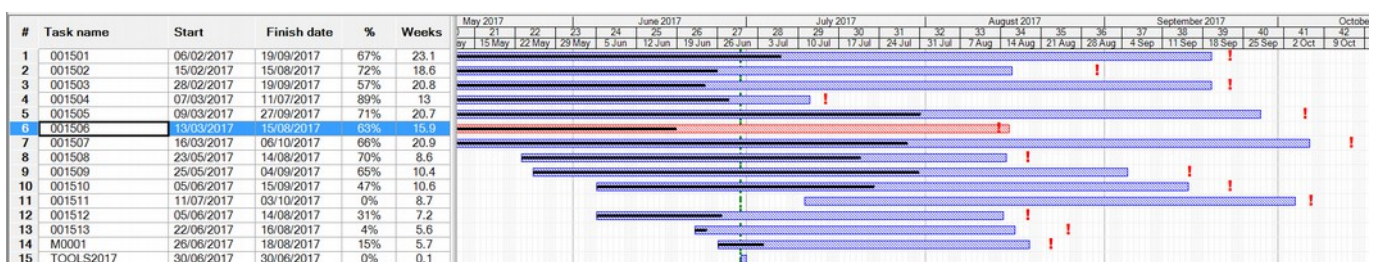


General Planning



Visualize progress

For each specific part as well as for each Mold, progress, deadlines, predicted and real starting and conclusion dates can be displayed graphically for a more quick and easy evaluation.





General Planning

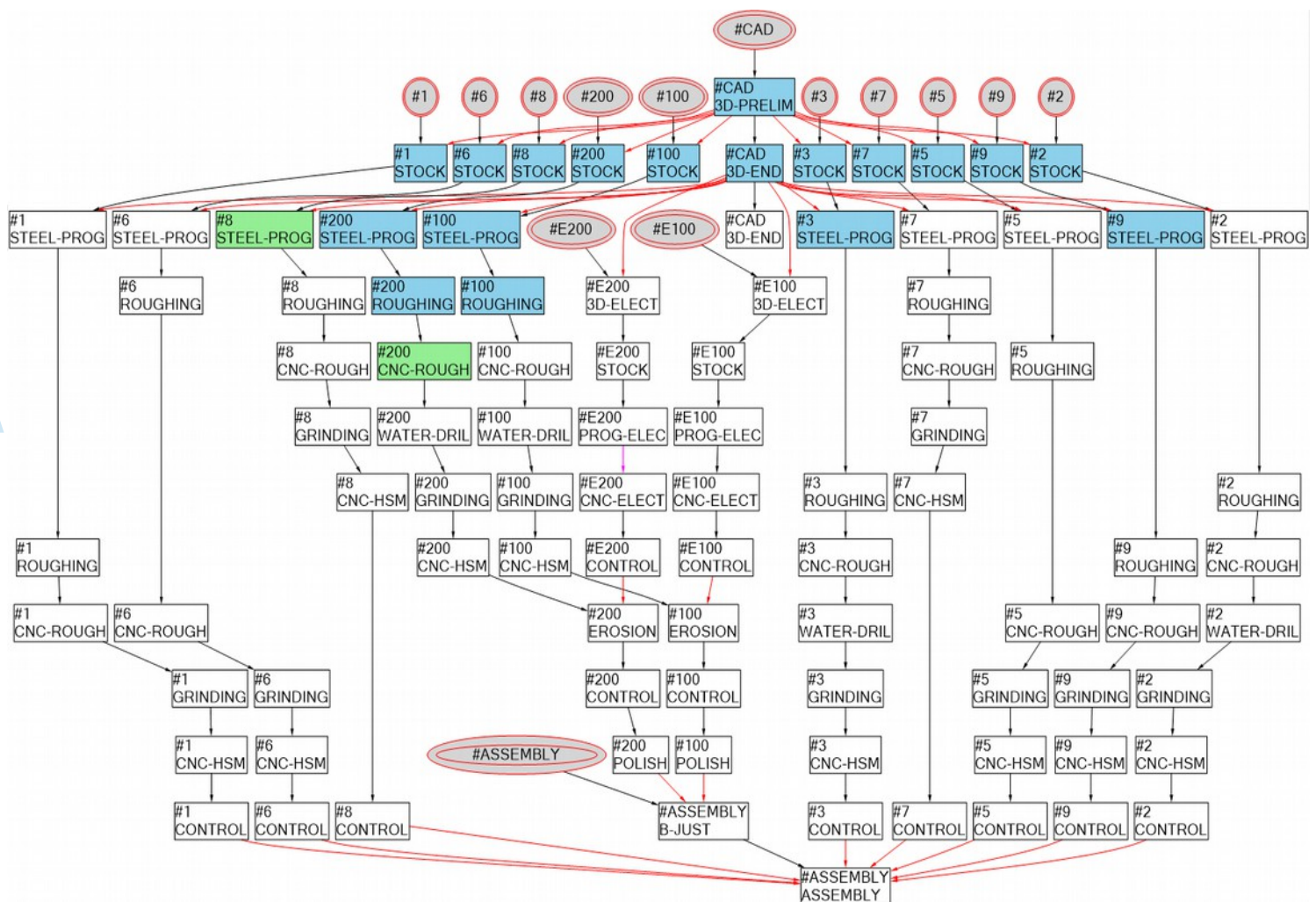
Stay on schedule

The software OrganiMold calculates automatically the priority of Jobs/Molds in order to stay on schedule, but allows the manual override of priorities.

When staying on schedule is just not possible, the software can identify which parts and operations are causing the most delay and deliver solutions by simulating sub-contracts or overtime.

From start to finish

Visualize every single operation and part with complete diagrams



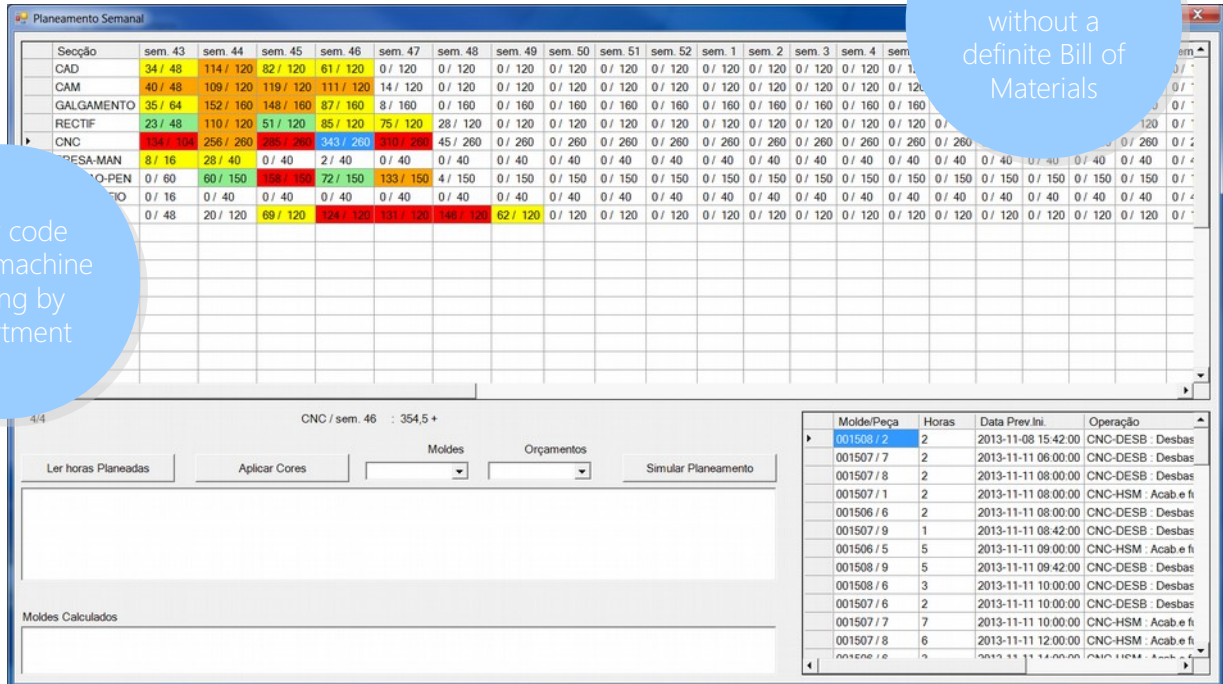
organimold





General Planning

Weekly planning



Part operations

Outubro de 2013					Novembro de 2013					Dezembro de 2013					Janeiro de 2014		
40	41	42	43	44	45	46	47	48	49	50	51	52	1	2	3		
30 Set	7 Out	14 Out	21 Out	28 Out	4 Nov	11 Nov	18 Nov	25 Nov	2 Dez	9 Dez	16 Dez	23 Dez	30 Dez	6 Jan	13 Jan		
<div> <div>STOCKS</div> <div>STOCK</div> <div>Verificar Stock</div> <div>STOCKS1</div> <div>48:00h</div> </div> <div> <div>8</div> <div>CAM</div> <div>PROG-ACOS</div> <div>Programa_o geral</div> <div>CAM2</div> <div>1:00h</div> </div> <div> <div>6</div> <div>GALGAMENTO</div> <div>GALGAR</div> <div>Galgamento geral</div> <div>GAL1</div> <div>8:00h</div> </div> <div> <div>0</div> <div>CNC</div> <div>CNC-DESB</div> <div>Desbastes Suportes_ Etc.</div> <div>CNC3</div> <div>3:00h</div> </div> <div> <div>RECTIF</div> <div>R-PLANO</div> <div>Rectificar faces</div> <div>RECPLA1</div> <div>1:00h</div> </div> <div> <div>CNC</div> <div>CNC-HSM</div> <div>Acab.e fura_es (eixo Z)</div> <div>CNC5</div> <div>6:00h</div> </div> <div> <div>5</div> <div>CONTROLO</div> <div>CONTROLO</div> <div>Controlo da pe_a</div> <div>DIM1</div> <div>0:30h</div> </div>																	





Shop Floor Terminal

Shop Floor Terminal : OrganiMold SQLNet_v7.24q

Friday 30 June 2017 (sem. 26)

CNC 18:57

Req. Stk Sel. Mult. Opers.

Job/Mold	Part	Operation	Description	Machine	Operator	T.Prev.	T.Real	Dt. Est. Start	Priority / Day	Classif.	Last Operator
001502	1	CNC-HSM	Finishing and Drilling (Axis Z)	CNC4	FR	10.0	7.9	05 Jul 08:56	X.99		FR
001502	9	CNC-ROUGH	Supports Roughing	CNC5	MJ	5.0	5.2	03 Jul 06:00	X.98		MJ
M0001	200	CNC-ROUGH	General Roughing	CNC2	PAULO	10.7	8.0	27 Jun 12:11			PAULO
M0001	100	CNC-ROUGH	CNC - Roughing	CNC3		7.0	8.6	27 Jun 12:11			FR
001501	E200	CNC-ELECT	Group Electrodes Milling	CNC1	FR	4.0	0.2	06 Jul 22:28			PAULO
001502	6	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		6.0	0.0	18 Aug 09:04	X.97		
001502	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		3.0	0.0	29 Jun 15:58		A1	
001502	100	CNC-ELECT	Group Electrodes Milling	CNC2	FR	11.0	0.0	30 Jun 08:00			
001502	100	CNC-ROUGH	Roughing	CNC3	MJ	2.0	0.0	30 Jun 15:11			
001502	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		2.0	0.0	30 Jun 16:58			
001502	100	CNC-ELECT	Group Electrodes Milling	CNC1		6.0	0.0	30 Jun 16:58			
001502	100	CNC-ELECT	Group Electrodes Milling	CNC2	MJ	10.0	0.0	03 Jul 08:00			
001502	100	CNC-ROUGH	Roughing	CNC3		5.8	0.0	03 Jul 09:04			
001502	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC5	FR	2.0	0.0	03 Jul 10:00			
001502	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		3.0	0.0	03 Jul 14:56			
001502	100	CNC-ROUGH	Roughing	CNC3		8.7	0.0	03 Jul 15:52			
001502	200	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		22.1	0.0	04 Jul 09:13			
001502	81	CNC-HSM	Finishing	CNC2		4.0	0.0	04 Jul 14:30			
001502	2	CNC-HSM	Finishing and Drilling (Axis Z)	CNC5	?	8.0	0.0	04 Jul 14:56			

Job/Mold Part Operation Filter Create Operation

Refresh All molds / View All Operations Last operator Machine

30/06/2017 Op. Initiated Exit

Processing status is color coded for quick evaluation of the current situation in the Shop Floor.

Ability to create small unplanned operations

Filter operations by Job/Mold, part or operator

Terminal Zoom

Job/Mold: M0001 Plastic Parts
Part: 100 CAVITY
Operation: CNC-ROUGH CNC - Roughing
Department: CNC CNC
Machine: CNC3 CNC3 - Roughing and Drilling
Classification:

Estimated Time: 3
Real time: 24.6
1st Operator: FR
Latest Operator: FR

List of Parts Operations
Notes AutoControl
Part deadline: 2017-08-22
Date Last Start: 2017-06-27 12:11

CNC - Roughing

Running
Operator: FR
Password:
Pause Conclude
State:
Confirm
Stay logged in
Create new occurrence
Operator messages
Attachments: 0

Delayed

Start and finish operations

Conclude Operation

Job/Mold: M0001 Department: CNC Machine: CNC3
Part: 100 Operation: CNC-ROUGH Operator: FR

Mold	Part	Operation	Description	Machine	Operator	Date Last Start
M0001	100	CNC-ROUGH	CNC - Roughing	CNC3	FR	27/06/2017 12:11:09

Total Parts / Lot: 1
Nr Parts Mach. Prev.: 0
Nr Parts Executed: 0
N.P. Rejected:

Notes Auto Control
Auto Control: OK?
Yes No

Time:

Cancel Conclude ? Confirm



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Shop Floor Planning

Control priorities

The Shop Floor Planning allows the Head of Department to define the priorities for the day, send processing orders and correct expected times of conclusion.

The planning will be re-calculated according to those changes.

Shop Floor Planning : OrganiMold SQLnet_v7.24q

CNC

Req. Stocks

Recep. Stocks

Daily plann.

Graph with all operations in the department

Job/Mold	Part	Operation	Description	Machine	Operator	T.Prev.	T.Real	Classif.	Prev.Inicio	Prev.Fim
001502	1	CNC-HSM	Finishing and Drilling (Axis Z)	CNC4	FR	10.0	7.9		05 Jul 09:04	05 Jul 16:58
001502	9	CNC-ROUGH	Supports Roughing	CNC5	MJ	5.0	5.2		03 Jul 08:00	03 Jul 13:00
001502	6	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		6.0	0.0		18 Aug 09:04	18 Aug 16:58
M0001	100	CNC-ROUGH	CNC - Roughing	CNC3		7.0	8.6		27 Jun 12:11	27 Jun 16:58
M0001	200	CNC-ROUGH	General Roughing	CNC2	PAULO	10.7	8.0		27 Jun 12:11	29 Jun 16:58
001504	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		3.0	0.0	A1	29 Jun 15:58	29 Jun 18:58
001502	E100	CNC-ELECT	Group Electrodes Milling	CNC2	FR	11.0	0.0		30 Jun 08:00	01 Jul 17:00
001502	2	CNC-ROUGH	Roughing	CNC3	MJ	2.0	0.0		30 Jun 15:11	03 Jul 08:11
001501	9	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		2.0	0.0		30 Jun 16:58	30 Jun 18:58
001502	E200	CNC-ELECT	Group Electrodes Milling	CNC1		6.0	0.0		30 Jun 16:58	30 Jun 22:58
001503	E100	CNC-ELECT	Group Electrodes Milling	CNC2	MJ	10.0	0.0		03 Jul 08:00	04 Jul 14:00
M0001	3	CNC-ROUGH	Roughing	CNC3		5.8	0.0		03 Jul 09:04	03 Jul 15:52
001502	100A	CNC-HSM	Finishing and Drilling (Axis Z)	CNC5	FR	2.0	0.0		03 Jul 10:00	03 Jul 12:00
M0001	100	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		3.0	0.0		03 Jul 14:56	03 Jul 17:56
M0001	2	CNC-ROUGH	Roughing	CNC3		8.7	0.0		03 Jul 15:52	04 Jul 16:32
M0001	200	CNC-HSM	Finishing and Drilling (Axis Z)	CNC7		22.1	0.0		04 Jul 09:13	05 Jul 11:47
001509	81	CNC-HSM	Finishing and Drilling (Axis Z)	CNC2		4.0	0.0		04 Jul 14:30	04 Jul 18:30
001502	2	CNC-HSM	Finishing and Drilling (Axis Z)	CNC5	?	8.0	0.0		04 Jul 14:56	04 Jul 22:56

The head of department can override automatic planning and edit annotations for the operator

Job/Mold

Part

CNC

Operações

Exit

Refresh

Aberto

Sair





Organimold SQLNet_v7.24q

Wednesday 28 June 2017 (sem. 26)

M0001 - Plastic Parts

Job/Mold

Datashwet

Bill of Materials

Parts to Manufacturer

Materials

Services

Tests

CAD

Quotes

Costs

Job/Mold

M0001

Manufacture (Not Completed)

Concluded

All

Designation

Plastic Parts

Sort by Name

GSOFT

Grandesoft

Client

2017-09-01

Friday 01 September 2017 (sem. 35)

Deadline

2017-06-14

Start Date for Planning

Mounting Days

Start Date / Contract

2017-06-14

Start Date for Planning

Mounting Days

Customer Mold Nr.

Purchase Order

Associate to Mold

Designer

Programmer

Mounting Tech.

Deadline 1st Samples

Deadline for Shipping

Date Order

Date Proj. Preliminar

Date Cutting Steel

Date Transportation Guide

Guide Transport Nr

Start manuf. (1st of

End Fab. (Last Op

Fab. Stage

Events of the Mold

Create New / Duplicate

State

New

Null / Delete

Wait for Customer Info.

Manufacture

Suspended

Concluded

Update Status

2017-06-27 12:29:05

List NC's

List of Associated Jobs

Attachments

0

Exit

Organimold SQLNet_v7.24q

001501 - Front Computer

Job/Mold

Datashwet

List of materials

Parts to Manufacturer

Materials

Services

Tests

CAD

Quotes

Costs

Manufacturer

GRANDES/ST

Type Mold

EXIT

N. Cavities

1

Den. Mold

1000X100X100

List of Articles: Reference / Length x Width x Height

Weight Mold

6.000.00

Final client

GSOFT

Industry Type

ELECTRONIC

Dim. Max. Articles positioned in the mold

Length

600.00

Width

200.00

Height

40.00

Provided by Client

2D Article

3D Article

Raw material

Others

Engravings

Part Number

Nr. Cav

Date

Recycle

Customer Logo

Others

Part type	Material	Heat Treatment	Hardness	Surface Finish	Qty
Buchas	1.2311				0
Cavidades	1.2311				0
Extrusoras	1.1730				0
					0
					0
					0
					0
					0
					0

Notes Technical file:

Attachments

0

Standard Accessories

DME

Injection Type

Carbador

Extraction Type

Extracciones redondas

Sliders / Mov.

Mecanicos

Cooling

Cavidade / Buchas

Ejection Accessories

DME

Air Circuit

Nilo

Oil Circuit

SM

Security Systems

Micro Switch

Insulating Plates

Parquejo / Extraccio

Screens Screens

MM

Thread Locks

MM

Refrigeration Threads

RSPT

Material to Inject

PP

Language List Materials

Ingles

Contraction Factor

1.02

Inq. Machine

Negni Bossi VSE 180

Refresh

Open

Back

Forward

Stop

Home

Delete

Print

PDF

1 / 17

Exit

Organimold SQLNet v7.24p

001501 - Front Computer

Job/Mold | Datasheet | List of materials | Parts to Manufacturer | Materials | Services | Tests | CAD | Quotes | Costs

Import Bill of Materials | ☒ List Mat. Control | ☒ Update Parts to be Manufactured | 0 | dim.xyz = 0 | ☐ Manufacture ☐ Purchase ☐ All | Sort by Part

Part	Description	State	Notes Status	Qty	Received Qty	Reference	Standard	Material	Heat Treatment	Manuf Part	Deadline Stock
2	CAVITY PLATE	RECEBIDO		1	1	696X446X136		12312			<input checked="" type="checkbox"/>
20	CAM PIN	REQUISICAO		2	0	201/18X160	HASCO				<input type="checkbox"/>
200	CORE	RECEBIDO		1	1	520X160X79.38		12344	TEMP. 48 RC		<input checked="" type="checkbox"/>
200A	CORE INSERT	RECEBIDO		1	1	32X13X57.21		12767	TEMP. 52 RC		<input checked="" type="checkbox"/>
200A1	CORE INSERT			1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
200A2	CORE INSERT			1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
200A3	CORE INSERT	STOCK		1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
200B	CORE INSERT			1	0	4.18X12.6X58.52		12767	TEMP. 52 RC		<input type="checkbox"/>
200C	CORE INSERT	STOCK		1	0	12.6X4.18X58.52		12767	TEMP. 52 RC		<input type="checkbox"/>
200D	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
200D1	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
200D2	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
200D3	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
201	CORE	RECEBIDO		1	1	520X160X79.38		12344	TEMP. 48 RC		<input checked="" type="checkbox"/>
201A	CORE INSERT	RECEBIDO		1	1	32X13X57.21		12767	TEMP. 52 RC		<input checked="" type="checkbox"/>
201A1	CORE INSERT	STOCK		1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
201A2	CORE INSERT			1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
201A3	CORE INSERT			1	0	32X13.5X57.21		12767	TEMP. 52 RC		<input type="checkbox"/>
201B	CORE INSERT			1	0	4.18X12.6X58.52		12767	TEMP. 52 RC		<input type="checkbox"/>
201C	CORE INSERT			1	0	12.6X4.18X58.52		12767	TEMP. 52 RC		<input type="checkbox"/>
201D	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
201D1	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
201D2	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>
201D3	CORE INSERT	REQUISICAO		1	0	Z40/4X63	HASCO				<input type="checkbox"/>

Refresh | Open | | Delete | | CB | PDF | 1 / 17 | Exit

Bills of Materials can be imported into CAD software or from .x

organimold





Budgets/Quotes

The budget is calculated using a virtual list of materials as source. The manufacturing simulation calculates the costs of workforce, machine operation and the cost of the materials used.

The software can also show the time/costs for each department. These values can be modified manually.

Organimold SQLnet_v7.24p

0003001 : FRENTE COMPUTADOR

Quote Datasheet List of materials Parts to Manufacturer Materials Services CAD Quote

Part	Qty	Part description	Material	heat treat.	Length	Width / Diam.	Height
1	1	Chapa de aperto da injeção	1.1730		350	300	300
100	1	Cavidade	1.2311		200	150	30
100A	10	Postiço cavidade	1.2311		30	30	30
2	1	Chapa das cavidades	1.1730		350	250	100
200	1	Buchas	1.2311		200	150	0
3	1	Chapa das Buchas	1.1730		350	250	100
320	2	Balanço	1.2344	TEMPERA	20	30	50
4	1	Chapa de reforço das buchas	1.1730		350	250	0

Times and costs per Department

Department	Time (Hr)	Cost (MP+Mach)	Notes
CAD	18	219.00	
CAM	72	1,008.00	
GALGAMENTO	41	775.00	
RECTIF	215	6,000.00	
CNC	122	2,440.00	
FRESA-MAN	24	570.00	
EROSAO-PEN	50	1,675.00	
EROSAO-FIO	0	0.00	
BANCADA	50	1,241.00	
(MO+MAQ)	616	14,561.00	Total
(MAT)	0	6,648.00	Total
(SERV)	0	3,010.00	Total
(SUBC)	0	1,000.00	Total
(IND)	0	722.00	Total
CONTROLO	24		
SERVIÇOS	0		

Manpower+Machinery 14 561.00 56%

Materials 6 648.00 26%

Services 3 010.00 12%

Subcontracts 1 000.00 4%

Indirect 722.00 3%

Quote manuf. (B) 25 941.00

Quote Client (A) 30 000.00

Update

Notes Quote:

Budget

Article

Comp. Width Height

Advanced Search

Search

TipoPeca	Material	Heat Treatment	Hardness	AcabSurface	Qty	Comp	Width
Buchas	1.2311			POLIDO	1	200	
Cavidades	1.2311			BRILHO	1	200	
Chapa Buchas	1.1730				1	0	
Chapa Cavidades	1.1730				1	0	
Elem. Moveis	1.2344	TEMPERA			2	40	
Balanços	1.2344	TEMPERA			2	20	
Postiços	1.2311			POLIDO	10	30	
Estrutura	1.1730				0	0	
Electrodos	GRAFITE				30	50	

Job/Mold Import List Exit





Budgets/Quotes

Generate automatically translated reports

After filling in all of the specific information for the client, the software can generate an automatic translation of the report to the Client's language.

Orçamentos Cliente

Código: 0003001
Nossa Ref.: 1253365
Data: 2011-05-09
De: Manuel
Para: GSOF
Alt:
Notas:

Designação Peça: FRENTE COMPUTADOR
Custo Total p/Cliente: 80.00
Moeda: C
Lingua: pt
Cond. Pagamento: 1/3 Encomenda; 1/3 Amostras; 1/3 Entrega
Data Prazo: 2011-08-09
Prazo Amostras: 12
Incoterm:
Cabeçalho Report:
Rodapé Report:

☒ Não Importar Dados da Ficha Técnica

Tipo Molde: INJEÇÃO
Num. Cav.: 1
Dim. Molde: 1000x650x462
Peso Molde: 2 200.00
Standard Acessórios: HASCO
Tipo Injeção: Canal quente
Tipo Extração: Extractores redondos
Tipo Movimentos: Mecânicos
Tipo Refrigeração: Cavidade / Bucha
Material a Injectar: PP
Factor Contração: 1,002
Máquina de Injecção: Negri Bossi VSE
Ref Artigos: 500x200x35

A Fornecer p/ Cliente
☐ 2D Artigo
☒ 3D Artigo
Mat. Prima:
Outros:
Gravações:
☐ Num. Peça
☐ Num. Cav.
☒ Datador
☐ Reciclagem
☐ Logo Cliente

Peças:

Tipo Peça	Material	Trat. Térmico	Dureza	Acab. Superfície
Buchas	1.2311			POLIDO
Cavidades	1.2311			BRILHO
Chapa Buchas	1.1730			
Chapa Cavidades	1.1730			
Elem. Moveis	1.2344	TEMPERA		POLIDO
Balances	1.2344	NITRURAR		POLIDO
Postigos				
Estrutura				
Electrodos				

Refresh Aberto

Procurar Lingua: uk 2 / 7

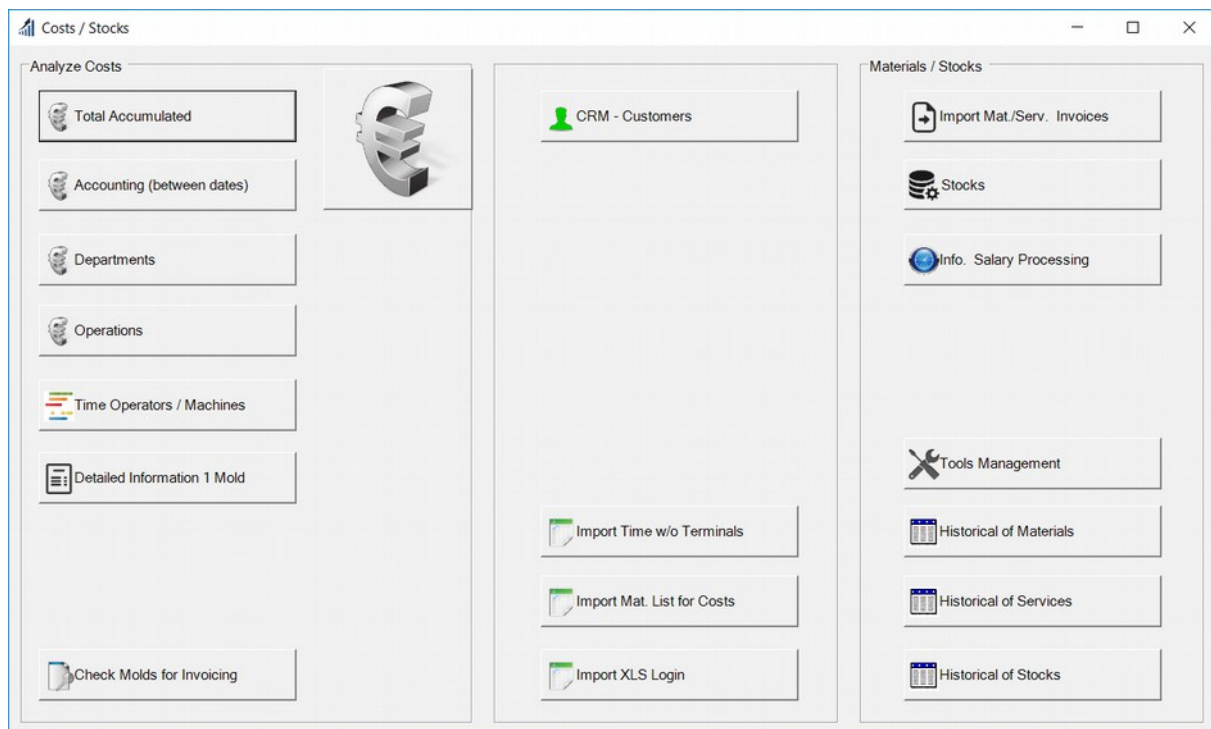
Part Type	Material
Core	1.2311
Cavity	1.2311
Core Plate	1.1730
Cavity Plate	1.1730
Cam Slide	1.2344
Sliders	1.2344
Inserts	1.2311
Moldbase	1.1730
Electrodes	GRAFITE

Acessories	HASCO
Cooling	Cavity / Core
Injection	Hot Channel
Extraction	Ejector Pins
Movements	Mechanical
Mat Injectar	PP
Shrink	1,002
Injection Machine	Negri Bossi VSE





Analyze Costs



Job/Mold Costs by Department in Period 2000-01-01 - 2017-06-23

Obra/Molde:	001500					
Secção	T. MO(Hr)	Custo MO	T. Maq(Hr)	Custo Maq	Indirectos	Total
CAD	6:02	84.93	6:02	0.00	0.00	84.93
ROUGHING	13:44	86.93	13:44	172.21	25.91	285.05
-----	-----	-----	-----	-----	-----	-----
TOTAL	19:46	171.86	19:46	172.21	25.91	369.98
Obra/Molde:	001501					
Secção	T. MO(Hr)	Custo MO	T. Maq(Hr)	Custo Maq	Indirectos	Total
ASSEMBLY	6:27	83.89				
CAD	14:01	172.16				
CAM	35:09	473.68				
CNC	39:25	563.66				
CONVENT	9:21	91.20				
RECTIF	20:47	370.73				
ROUGHING	16:03	129.46				
-----	-----	-----	-----	-----	-----	-----
TOTAL	141:17	1 884.79				
Obra/Molde:	001502					
Secção	T. MO(Hr)	Custo MO	T. Maq(Hr)	Custo Maq	Indirectos	Total
ASSEMBLY	10:20	87.42				
CAD	26:12	322.05				
CAM	31:17	467.24				
CNC	60:20	841.83				
RECTIF	3:30	47.43	3:30	63.13	11.06	121.62
ROUGHING	21:24	140.44	21:24	278.23	41.87	460.54
-----	-----	-----	-----	-----	-----	-----
TOTAL	153:06	1 906.41	199:27	2 648.25	422.26	4 976.92

Cost of Jobs/Molds (total accumulated)

Gsoft

Obra/Molde	Mão d'Obra	Maquinas	Indirectos	Materiais	Servicos	SubCont.	Total Custos	Orçamento	Desvio	%Desv	Tempo MO	Tempo Maq	%Conc
001501 *	2 132.57	2 297.66	420.54	18 050.00	1 510.00	800.00	25 210.77	58 600.00	33 389.23	57%	141:17	182:39	28%
001502 *	1 906.41	2 648.25	422.26	4 550.00	0.00	0.00	9 526.92	25 000.00	15 473.08	62%	153:06	199:27	53%
001503 *	6 387.84	549.39	672.67	2 108.05	0.00	0.00	9 717.95	28 000.00	18 282.05	65%	25:08	38:09	8%
001504 *	889.85	1 318.22	205.87	2 621.85	0.00	0.00	5 035.79	28 000.00	22 964.21	82%	58:27	81:18	80%
001505 *	13 511.60	13 391.00	2 521.69	0.00	0.00	3 266.70	32 690.99	60 000.00	27 309.01	46%	603:43	707:09	55%
001506 *	4 694.42	4 669.41	907.14	1 787.88	0.00	0.00	12 058.85	28 000.00	15 941.15	57%	224:01	236:06	23%
001507 *	289.60	214.65	45.69	0.00	0.00	0.00	549.93	28 000.00	27 450.07	98%	19:01	19:01	14%
001508 *	224.08	115.50	26.60	456.00	0.00	0.00	822.18	25 000.00	24 177.82	97%	10:00	10:00	1%
001509 *	115.16	74.25	14.29	0.00	0.00	0.00	203.70	30 000.00	29 796.30	99%	9:04	9:04	1%
001510	432.25	293.25	55.93	0.00	0.00	0.00	781.43	28 000.00	27 218.57	97%	32:00	32:15	3%
001511 *	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0%	0:00	0:00	0%
001512 *	70.45	0.00	0.00	0.00	0.00	0.00	70.45	0.00	- 70.45	0%	7:02	7:02	1%
001513 *	0.00	0.00	0.00	0.00	0.00	0.00	0.00	25 000.00	25 000.00	100%	0:00	0:00	0%
M0001 *	0.00	0.00	0.00	0.00	0.00	0.00	0.00	35 000.00	35 000.00	100%	0:00	0:00	0%
TOOLS2017	0.00	0.00	0.00	1 165.00	0.00	0.00	1 165.00	0.00	- 1 165.00	0%	0:00	0:00	0%
TOTAL	30 654.23	25 571.58	5 292.68	30 738.78	1 510.00	4 066.70	97 833.96	398 600.00	300 766.04	75%	1 282:49	1 522:10	





Time Clock and Salary Processing

Processamento Salários

Código: BE | Calcular | Todos Operadores

Mês: 10 | Ano: 2013 | Tot. Horas Mês: 200.4 | Dias Completos: 20

Outubro | Tot. Horas Extra Mês: 0.0 | Dias Incompletos: 6

Data Inicio: 25-09-2013 | Tot. Dif. Horas Mês: -7.7

Data Fim: 24-10-2013

Excluir dias sem pontos | Desvio Horário: 0.30 | 1.00 | 4.00 | 8.00

Operador	Data	Total H.	H. Extras	Diferença	Gravar	Entrada 1	Saída 1	Entrada 2	Saída 2	Entrada 3	Saída 3	Entrada 4	Saída 4	Cod. Justific.
BE	25 - qua	08:07		00:07	✓	07:55 E(07:55)	12:19 S(12:19)	13:25 E(13:25)	17:08 S(17:08)					
BE	26 - qui	10:12		02:12	✓	07:53 E(07:53)	12:20 S(12:20)	13:26 E(13:26)	19:11 S(19:11)					
BE	27 - sex	10:10		02:10	✓	07:53 E(07:53)	12:19 S(12:19)	13:26 E(13:26)	19:10 S(19:10)					
BE	28 - sáb	03:40		04:20	✓	08:50 E(08:50)	12:30 S(12:30)							
BE	29 - dom													
BE	30 - seg	09:38		01:38	✓	07:54 E(07:54)	12:21 S(12:21)	13:30 E/OK(13:27)	18:41 S(18:41)					
BE	01 - ter	10:15		02:15	✓	07:56 E(07:56)	12:31 S(12:31)	13:30 E/OK(13:28)	19:10 S(19:10)					
BE	02 - qua	10:41		02:41	✓	07:26 E(07:26)	12:30 S(12:30)	13:30 E/OK(13:26)	19:07 S(19:07)					
BE	03 - qui	09:42		01:42	✓	07:58 E(07:58)	12:30 S(12:30)	13:30 E/OK(13:25)	18:40 S(18:40)					
BE	04 - sex	05:10		02:50	✓	07:56 E(07:56)		13:30 E/OK(13:27)	18:40 S(18:40)					
BE	05 - sáb	03:16		04:44	✓	08:48 E(08:48)	12:04 S(12:04)							
BE	06 - dom													
BE	07 - seg				✓	07:26 E(07:26)	12:30 S(12:30)	13:30 E/OK(13:26)	17:00 S(17:00)					
BE	08 - ter				✓	07:56 E(07:56)	12:31 S(12:31)	13:30 E/OK(13:25)	17:10 S(17:10)					
BE	09 - qua				✓	08:00 E(08:00)	12:31 S(12:31)	13:30 E/OK(13:25)	18:40 S(18:40)					
BE	10 - qui				✓	07:54 E(07:54)	16:08 S(16:08)							
BE	11 - sex				✓	08:23 E(08:23)	16:45 S(16:45)							
BE	12 - sáb				✓	09:53 E(09:53)	12:41 S(12:41)							
BE	13 - dom													
BE	14 - seg				✓	07:54 E(07:54)	12:31 S(12:31)	13:26 E(13:26)	17:00 S(17:00)					
BE	15 - ter				✓	07:53 E(07:53)	12:19 S(12:19)	13:30 E/OK(13:27)	17:10 S(17:10)					

Refresh | Aberto

Color coded for easier tracking

OrganiMold SQLnet_v7.24q

Time Clock

Tuesday 27 June 2017 (sem. 26)

15:01

Login

Operator: DT

Password: *

Login

Donnald

Timetable

NORMAL

08:00 | 13:00 | 14:00 | 17:00

☒ In
☐ Out
☐ Extra Hr.

Cancel Confirm

Analyze Time Clock | Messages

Analyze Data Terminals

Send a Message to Salary processing

Code Justification

Donnald
Last: 'Entry': 2017-06-27

Annotations for salary processing

Clock-out

Operations initiated by the operator are automatically interrupted when the operator leaves the factory.

In Manual Machines, operations stay paused until next clock-in.

In Automatic Machines, the operations can keep going without an operator.

Clock-in

After lunchtime (or any other pause) while still in the operator's shift, by clocking-in, operations that were automatically interrupted before can be automatically re-started (depending on the company's preference).



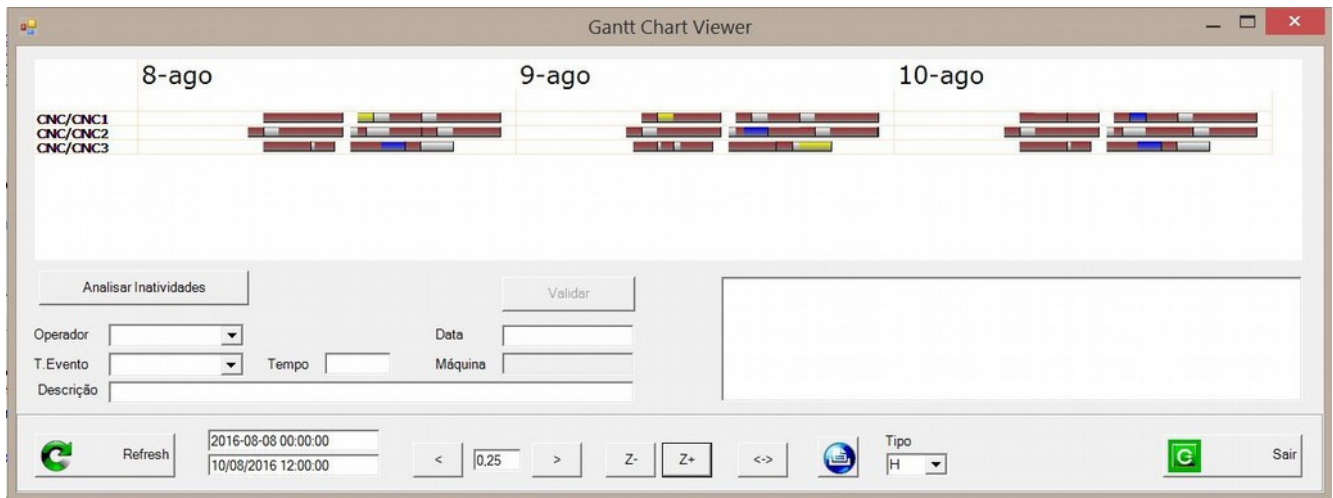
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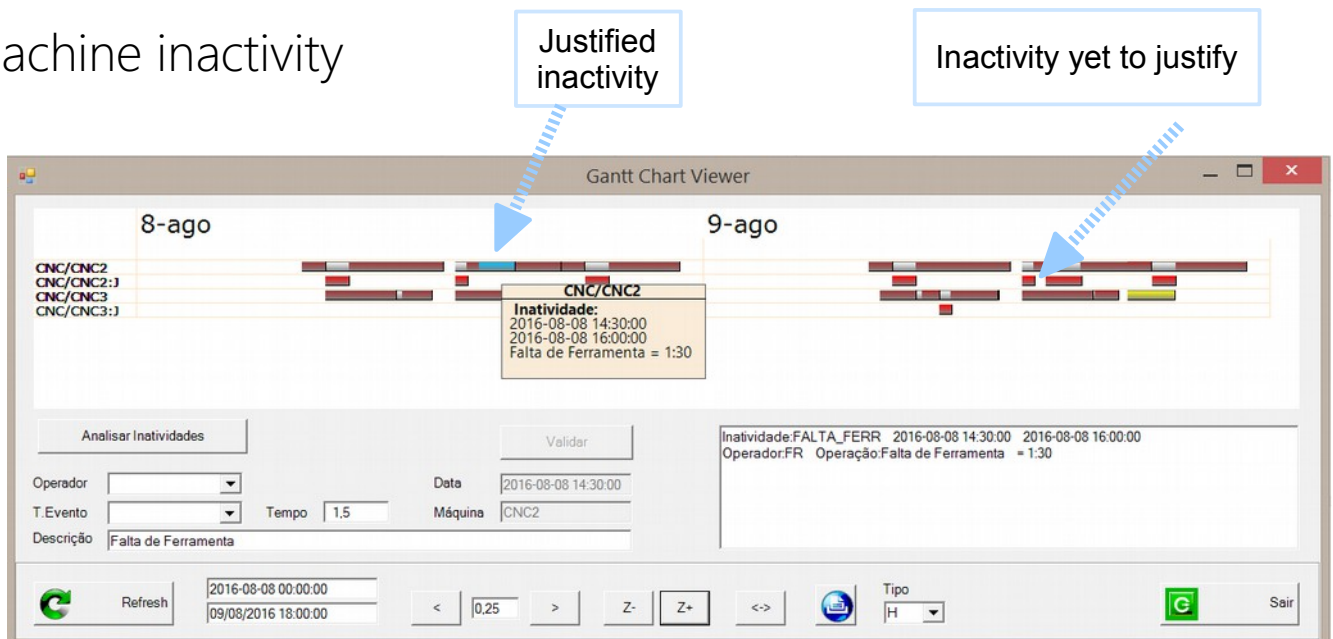
Analysis of Machine Productivity

Machine productivity graph

Includes the machine timetable, operations done with an operator, operations done without an operator and inactivity.

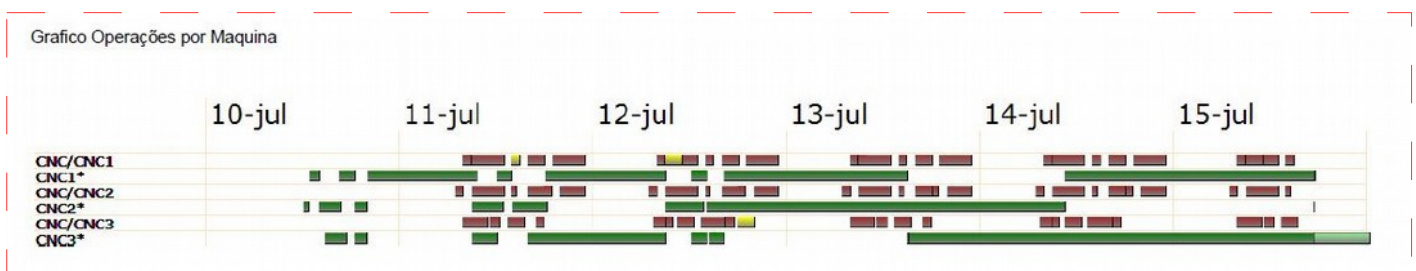


Machine inactivity



Interface for analysis and justification of machine inactivity:

- Clicking on the red bar allows the creation of a justification automatically





Requests

Make requests and quote demands using the Bill of Materials

Requisições: Lista de Peças

Obra/Molde: 001501
Operador: BE

☒ Requisição
☐ Guia
☐ Pedido Orçamento
☐ adicionar a Guia/Req. Existente

Lista de Peças

Peças em Fabricação Lista Materiais (Compras) Lista Materiais (Peças a Fabricar)

☐ Excluir peças já requisitadas
☐ Selec. apenas peças com Qt.Recebida < Qt. da Lista Materiais

☐ Adicionar à Lista

Lista de Peças
1; 100; 100A; 101; 2; 200; 200A; 201; 3; 5; 7; 8; 80; 81; 81S; 9;

Opções p/ Descrição

Criar/Adicionar Guia
Consultar
Requisição Interna
Sub Contratar

Requisições

Requisição: REQ R000015 Nova Duplicar ☒ Req ☐ P.Orç. Stocks Agrupar Peças Iniciar Operação

FMATSERV ☐ Cliente ☒ Fornecedor ☐ Ordenar nome ☐ add. Lista Forn.

Nome: Materiais e Serviços, Lda
Morada:
Localidade:
Código Postal:
País:
Nº Contribuinte: Att:
Notas Internas:

CARGA: Local N/ Morada Data 2013-10-10 Hora 12:19 Viatura:
DESCARGA: Local V/ Morada Data 2013-10-11 Data Reg. 2013-10-10 Operador BE

Notas p/ Imprimir: Prazo Entrega 2013-10-25

Obra/Molde	Peça	Quant.	Descrição	Valor	Prazo Entrega	Classificação	Rec.	Estado	Notas
001501	1	1,00	CHAPA DE APERTO DE INJECCÃO 696X446X46 1.1191				<input type="checkbox"/>	REQUISIÇÃO	
001501	100	1,00	CAVIDADE 520X160X89 23 1.2344 temp. 48 Rc				<input type="checkbox"/>	REQUISIÇÃO	
001501	100A	1,00	POSTIÇO CAVIDADE 30X30X30 1.2311				<input type="checkbox"/>	REQUISIÇÃO	
001501	101	1,00	CAVIDADE 520X160X89 23 1.2344 temp. 48 Rc				<input type="checkbox"/>	REQUISIÇÃO	
001501	2	1,00	CHAPA DAS CAVIDADES 696X446X136 1.2312				<input type="checkbox"/>	REQUISIÇÃO	
001501	200	1,00	BUCHA 520X160X79 38 1.2344 temp. 48 Rc				<input type="checkbox"/>	REQUISIÇÃO	
001501	200A	1,00	POSTIÇO DA BUCHA 32X13X57 21 1.2767 Temp. 52 Rc				<input type="checkbox"/>	REQUISIÇÃO	
001501	201	1,00	BUCHA 520X160X79 38 1.2344 temp. 48 Rc				<input type="checkbox"/>	REQUISIÇÃO	
001501	3	1,00	CHAPA DAS BUCHAS 696X446X146 1.2312				<input type="checkbox"/>	REQUISIÇÃO	
001501	5	2,00	CALÇO 696X30X116 1.1191				<input type="checkbox"/>	REQUISIÇÃO	
001501	7	1,00	CHAPA DOS EXTRACTORES 696X282X27 1.1191				<input type="checkbox"/>	REQUISIÇÃO	
001501	8	1,00	CHAPA DE AP. DOS EXTRACTORES 696X282X36 1.2312				<input type="checkbox"/>	REQUISIÇÃO	
001501	80	1,00	ELEMENTO MOVEL 128X100X46 1.2344 temp. 48 Rc				<input type="checkbox"/>	REQUISIÇÃO	

Analisar Requisições

Obra/Molde: Código/Peça: Guia/Req: Data Inicio: 2000-01-01
Visto: Estado: Fornecedor: Data Final: 2013-10-28

☒ Falta Actualizar Lista Mat. ☒ Apenas Requisições
☐ C/ Molde ☐ Falta Enviar p/ Custos ☐ Apenas Stocks (Req.Int.)
☐ Apenas Electrodos

Ver Peças Requisitadas em Falta

Guia	Fornecedor	Molde	Peça	Quant.	Qt. Rec.	Descrição	Vi.	Estado	Classificação	Preço	Notas
R000001	GSOFT	001501	1	1	1	CHAPA DE APERTO DE INJECCÃO 696X446X46 1.1191	✓	RECEBIDO	1234		
R000001	GSOFT	001501	100	1	0	CAVIDADE 520X160X89 23 1.2344 temp. 48 Rc	✓	RECEBIDO	100		
R000001	GSOFT	001501	2	1	1	CHAPA DAS CAVIDADES 696X446X136 1.2312	✓	RECEBIDO	122		
R000001	GSOFT	001501	200	1	0	BUCHA 520X160X79 38 1.2344 temp. 48 Rc	✓	RECEBIDO			
R000001	GSOFT	001501	3	1	1	CHAPA DAS BUCHAS 696X446X146 1.2312	✓	RECEBIDO			
R000001	GSOFT	001501	5	2		CALÇO 696X30X116 1.1191	✓	RECEBIDO			
R000001	GSOFT	001501	7	1	1	CHAPA DOS EXTRACTORES 696X282X27 1.1191	✓	RECEBIDO			
R000001	GSOFT	001501	8	1	1	CHAPA DE AP. DOS EXTRACTORES 696X282X36 1.2312	✓	RECEBIDO			
R000001	GSOFT	001501	80	1	0	ELEMENTO MOVEL 128X100X46 1.2344 temp. 48 Rc	✓	REQUISIÇÃO			
R000001	GSOFT	001501	81	1	0	ELEMENTO MOVEL 123.98X78X62 1.2767 temp. 52 Rc	✓	REQUISIÇÃO			
R000001	GSOFT	001501	9	1	0	CHAPA DE APERTO DA EXTRACÇÃO 696X446X46 1.1191	✓	REQUISIÇÃO			
R000005	FMATSERV	001501	*	1	0	Molde					
R000005	FMATSERV	001501	1	1	1	CHAPA DE APERTO DE INJECCÃO 696X446X46 1.1191	✓	RECEBIDO			
R000005	FMATSERV	001501	100	1	0	CAVIDADE 520X160X89 23 1.2344 temp. 48 Rc	✓	RECEBIDO			
R000005	FMATSERV	001501	2	1	0	CHAPA DAS CAVIDADES 696X446X136 1.2312	✓	REQUISIÇÃO			

Actualizar Lista Mat/Stocks

Operador: Refresh Aberto 130 max. 1000 A data do filtro é a Data de criação da Requisição Sair



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Tool Management / Requests

Selecionar Stocks / Ferramentas

Familia: FERRAMENTA Sub-Familia: >= Comp. Larg/D. Alt. Material: Pesq. Descrição: Fornecedor: Pesq. Stock: E.I.

Familia	Sub-Familia	Código Stock	Qt. Total	Qt. Stk	Unid	Descrição
FERRAMENTA	FRESAS	F-D8-ESF	6	6	Un	Fresa D8 Esférica
FERRAMENTA	FRESAS	F-D8-RC08X100	8	8	Un	Fresa D8 Raio Canto 08
FERRAMENTA	FRESAS	F-D8-RC08X60	8	8	Un	Fresa D8 Raio Canto 08
FERRAMENTA	PASTILHAS	P-D20-ESF	15	15	Un	Pastilha de D20 Esférica
FERRAMENTA	PASTILHAS	P-QUAD-8-RC-0.8	40	40	Un	Pastilha quadrada 8 com raio de canto 0.8
FERRAMENTA	S-FRESAS	SF-D16-RC	6	6	Un	Suporte Fresa D16 Raio Canto
FERRAMENTA	S-FRESAS	SF-D20-ESF	1	1	Un	Suporte Fresa Esférica D20 ESF
FERRAMENTA	S-FRESAS	SF-D20-RC	5	5	Un	Suporte Fresa D20 Raio Canto

Código Stock sel. p/ Req. Descrição Qt. Req. add. à Lista

Cod. Stock	Qt.	Descrição	Obra/Mr
F-D4-ESF	1,00	Fresa D4 Esférica	FERR_2
F-D6-ESF	1,00	Fresa D6 Esférica	FERR_2
P-D20-ESF	2,00	Pastilha de D20 Esférica	FERR_2
P-QUAD-8-RC-0.8	4,00	Pastilha quadrada 8 com raio de canto 0.8	FERR_2
SF-D20-ESF	1,00	Suporte Fresa Esférica D20 ESF	FERR_2
SF-D16-RC	1,00	Suporte Fresa D16 Raio Canto	FERR_2

Obra/Molde: FERR_2016 Permitir req. Stock negativo Operador: BE Requisitar Requisição

Refresh ☐ Calc. Qt. Total (+ Qt. Recebida recente) ☒ max. 1000 19 Devolver Ferramentas Sair

Stock management of tools, measure instruments, etc:

- Allows request and return of tools to/from the warehouse
- Defines categories and sub-categories (entering length and diameter is optional)
- For some types of tools, the exit is recorded but the amount in stock remains unchanged because the tools are to be used and then to returned to the warehouse. It will be then deducted from stock if it is marked as returned in damaged condition.



Machine Maintenance Alerts

Scheduling of maintenance for each machine

Notifies the operator of the maintenance scheduled for the current and previous days

Obra/Molde: 001505 TELEFONE

Peça: 100A POSTIÇO CAVIDADE

Operação: CNC-HSM CNC - Maquinação de alta velocidade

Secção: CNC CNC

Máquina: CNC3 CNC3 - Desbastes e furações

Classificação:

Tempo Previsto: 2

Tempo Real: 0

1.º Operador:

Último Operador:

Prazo Peça: 2017-02-03

Data Ult.Inicio:

Lista de Operações da Peça

Notas AutoControlo

Operador: FR

Password:

Iniciar

Estado:

Confirmar

Manter Login

Criar nova Ocorrência

Mensagens Operador

Anexos: 0

Quant. Peças: 1

Qt. Peças M: 0

Manutenção

CNC3 info

	+	Tipo Evento	Data Agenda	Descrição	Data Execução	Tempo	Custo	Operador	Resolvido	Repetir (dias)	Fornecer
		Preventiva	2016-11-14	Mudar Correia		0,00	0,00				
		Preventiva	2016-11-21	Mudar Óleo		0,00	0,00			7	
*											

Refresh Bloqueado Resolvido 0 Sair

Scheduling at 'X' day intervals: next maintenance is scheduled after being marked as 'solved'



CRM

Customer Relationship Management

Allows scheduling of activities and pending subjects, logs phone calls, visits, expenses and distances (Km).
All the pending subjects are visible until they're marked as solved

The image displays three overlapping windows from a CRM application:

- CRM Window:** Shows a list of activities with columns: Resol, T.C., Empresa, Quem, DataHora, Produto, Assunto, N/Tecnico, Solução, and Notas/Pendente. The table contains several rows of data, including activities for 'Software', 'Correios', 'Formação', 'Manutenção', and 'Visita Comercial'.
- Contacto Window:** A form for editing a contact record. Fields include Empresa (JA), T. Contacto (I), Quem (FR), N/Tecnico (BE), Produto (Manutenção), Data Hora (17/08/2016 17:45:23), Assunto/Problema (Avaria Máquina), Solução, Tempo, KM, Portagens, Refeições, Documento, and Notas/Pendente.
- Clientes Window:** A form for editing a client record. Fields include Código (GSOFT), Nome (Grandesoft, Lda), Morada (Rua Ilha do Corvo, Nº 10 - Loja), Localidade (Marinha Grande), Cod Postal (2430-143 Marinha Grande), Pais (Portugal), Telefone (244561650), Fax (244561651), Email (comercial@grandesoft.pt), Web (www.grandesoft.pt), Contribuinte (PT504019538), Zona, Tipo Cliente, Pasta, Cod Cliente Fact, Cond. Pagamento, Desconto (0.00), Expedição(ex-works), Gestor Mercado, Gestor Cliente, and Estado Cliente. It also has a table for functions (Func1, Func2) and a bottom toolbar with various icons.

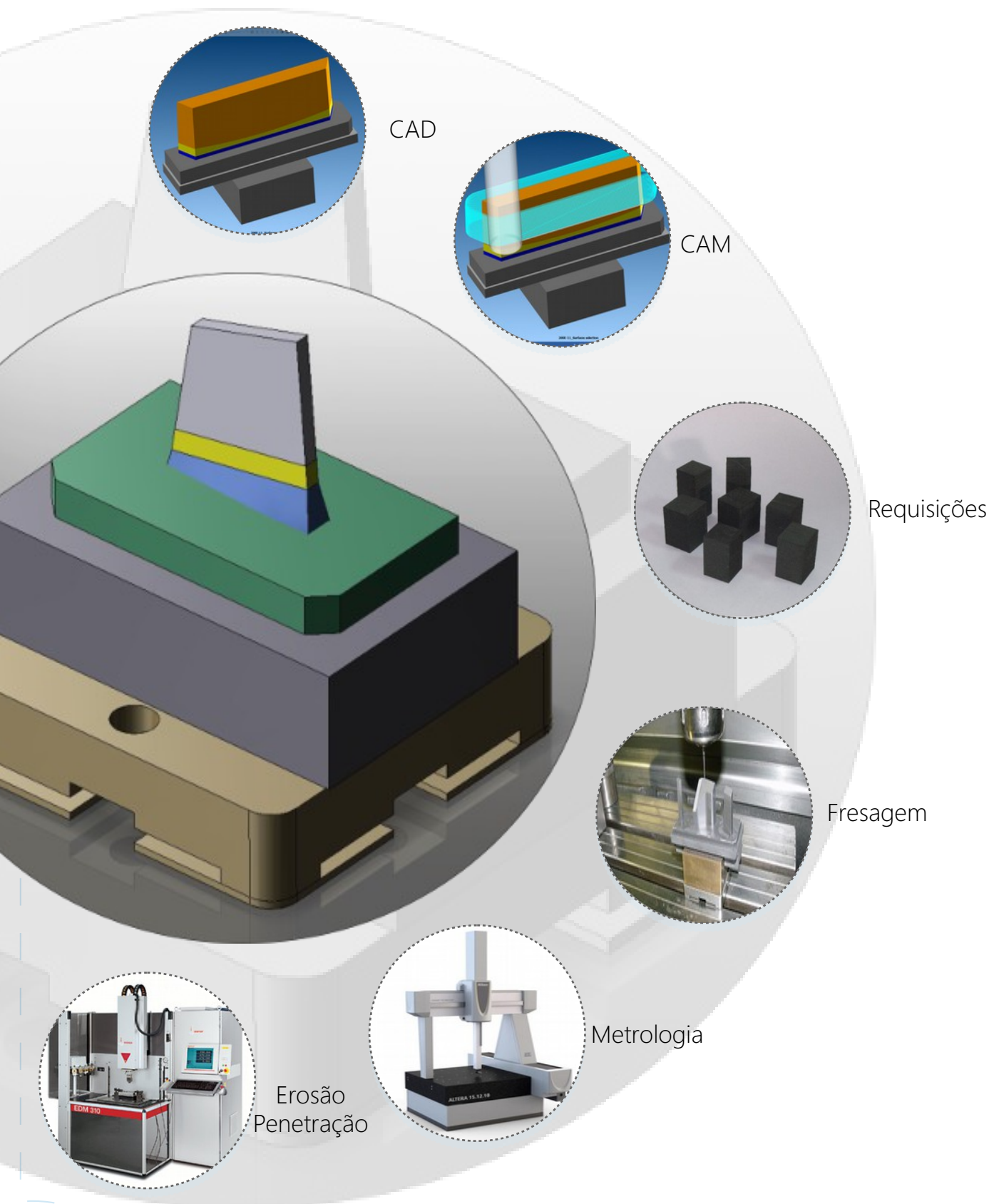
A blue circular callout points to the 'Clientes' window with the text: "Clients table with more data, contacts and commercial information".





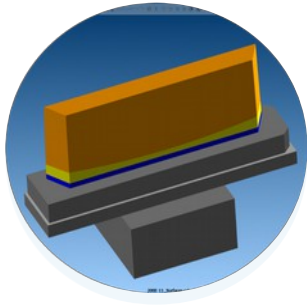
ElectroDB / PLM

Gestão do ciclo de vida dos electrodos
Programação automática das maquinas de Erosão penetração



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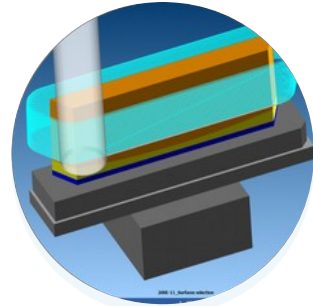




CAD

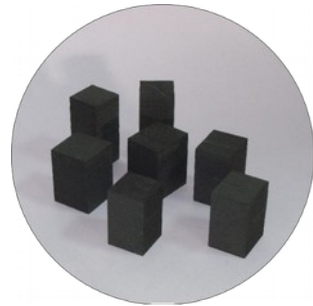
Os electrodos são importados dos sistemas CAD (Mastercam, Cimatron, TopSolid, PowerShape, WorkNC, etc.)

- Pode incluir a posição XYZC, dimensões do material bruto, gap, Tipo de material, imagens, etc.



CAM

Identificar electrodos já programados e registar programas individuais de cada electrodo



Requisições

Gestão de Materiais/Stocks (blocos de material em bruto em Cobre ou Grafite)

- Ao fazer a requisição dos blocos de material em bruto, permite agrupar os electrodos, e controla o estado (Requisitado/Recebido) de cada electrodo.



Fresagem

Encadeamento dos programas CNC para fresagem com sistema de paletização.

- Definição da altura dos blocos de grafite
- Permite rodar electrodo para montagem na paleta
- Simulação de colisões na montagem dos electrodos na paleta
- Impressão de Etiquetas



Metrologia

Controlo dimensional do electrodo

- Permite controlar a altura do electrodo, o gap, e desvios em X, Y, Z, C
- Importação de dados de medição das máquinas de medir ou colunas de medição
- Validação dos valores medidos mediante tolerâncias



Erosão Penetração

Automatiza a programação das máquinas de Erosão de Penetração

- Máquinas: Charmilles, AGIE, ONA, Sodick, Exeron, JSEDM, etc.
- Simulação de colisões na montagem dos electrodos no carrocel
- Suporta electrodos Duplos/180graus e varias origens





ElectroDB / PLM

Electrodos

Obra/Molde: 1350 Peça: 200 Electrodo: Reordenar Ver apenas não Prog.: Fresa Erosão

Ver Todos Elect. Molde

Electrodo	Material	Gap	Num	Duplo	Z.Justai	CAD	CAM	Requisi	Recebi	Fresag	CQ	OK	Progar	GapMedic	CorrX	CorrY	Ang.CorrC	CorrZ	Z.Subs.Hol	Lista
200E-1	G	0.1	1																	1:2:3
200E-1	G	0.1	2																	1:2:3
200E-1	G	0.15	2																	1:2:3
200E-1	G	0.3	1																	1:2:3
200E-1	G	0.15	1																	1:2:3

200E-1 G : 0.1 : 1

Teste-coment-Geral

Notas Operadores

Editar Electrodo

Electrodos CAD CAM Req/Stocks Fresagem Metrologia Erosão

Não verificar conclusão das operações nas secções anteriores

N Pt	Sele	Pos. X	Pos. Y	Pos. Z	Pos. Ang	Comentario
1		-65.5	-88.3	20.61	0	
2		-95.5	-88.3	20.61	0	
3		-125.5	-88.3	20.61	0	
4		-155.5	-88.3	20.61	0	
5		-65.5	88.3	20.61	180	
6		-95.5	88.3	20.61	181	
7		-125.5	88.3	20.61	180	Pl 6
8		-155.5	88.3	20.61	180	

Refresh Aberto 25 PDF G RS232

Medir Pontos : 1241 / 200 / K-03 / G / Gap=0.4 / N1 : E:\EDB\Import\Metrologia\PCDMIS\Moldenel\1241-200-xp-K-03

Ponto	X	Y	Z	XM	YM	ZM	Gap
1	-41.5	23.0	61.0	-41.497	23.0	57.389	-0.2
2	X+1	42.0	11.75	57.0	41.808	11.748	56.999
3	X+2	42.0	-11.75	57.0	41.813	-11.753	56.999
4	Y+1	21.0	-23.5	57.0	20.998	-23.318	57.0
5	Y+2	-21.0	-23.5	57.0	-21.002	-23.31	57.002
6	X-1	-42.0	-11.75	57.0	-41.769	-11.746	57.0
7	X-2	-42.0	11.75	57.0	-41.775	11.751	57.002
8	Y+1	-21.0	23.5	57.0	-20.998	23.274	57.0
9	Y+2	21.0	23.5	57.0	21.004	23.27	57.001

Facas	Gap Pt1	Gap Pt2	Angulo
X+	-0.192	-0.187	90.012
X-	-0.231	-0.225	90.015
Y+	-0.226	-0.23	179.995
Y-	-0.182	-0.19	179.989

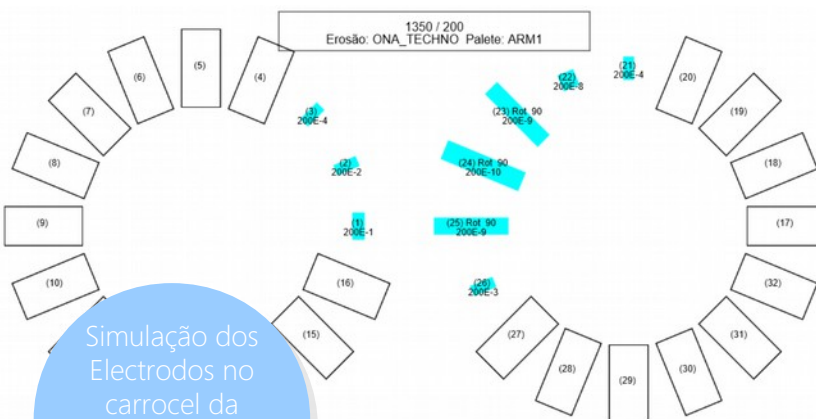
Dim Faces X	Dim Faces Y	Rotação	Gap/lado
Teorico	84.0	47.0	0.0
Calculado	83.582	46.586	-0.008

Desvio Cent.	dX Inc	dY Inc	dC Inc	Z	Gap total
	0.02	0.022	-0.008		
				57.389	0.416

Alt Z 57.389 Gap 0.416 Corr X 0.02 Corr Y 0.022 Corr C -0.008 PROG2 ADMIN 2017-07-10 17:45:54

Sair

Relatório de medição



Simulação dos Electrodos no carrocel da máquina de Erosão de Penetração

```

1 %
2 G54X0
3 M80
4 M06X1
5 G00Z119.500
6 M80
7 G00X-65.500Y-88.300C0.000
8 M40
9 G00Z108.875
10 G17
11 G69X37U3W6
12 G11X80.260F40
13 G69X35U3W6
14 G23X80.240
15 G69X34U3W6
16 G23X80.220
17 G69X33U2W6
18 G23X80.200
19 G69X32U2W6
20 G23X80.190
21 G69X31U2W6
22 G23X80.180
23 G69X29U2W6
24 G23X80.170
25 G69X27U1W6
26 G23X80.160
27 G69X25U1W6
28 G23X80.150
  
```

Programa



organimold

