



**Interreg**

Austria-Hungary

European Union – European Regional Development Fund



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## **SIF 401 WORKING INSTRUCTION**

**WP5 T5.2.1 TRAINING AND DEMONSTRATION MODULES  
DEVELOPED**

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**Version 1**

**Boldizsár Könczöl/Pannon Business Network**

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## 1 Power on

### 1.1 Check

- Remove all product from conveyor
- Remove all product from working space
- Connect to the compressor
- Put the emergency stop buttons to default position
- Switch off all electrical switch
- Check the connection with the main power

### 1.2 Power system

#### Task



Rotate the key to position 1



Turn on the computer





Rotate the power switch to position 1

### 1.3 Air system

#### Task



Rotate the main switch to position sup





Rotate the station air switch to position sup

After the swich on (approximetly 70 secounds) the machine make a self test and calibration. If the station is ready, the HMI show it.



## 2 Power off

### 2.1 Deactivate air system

Task



Rotate the main switch to position sup



## 2.2 Electrical system switching off

### Task



Rotate the electrical switch to position 0



Rotate the electrical switch to position 0

## 3 Machine operation

The machine can work manual and automatic mode. In manual mode the machine work standalone, it is not connected to the other machines. In automatic mode the SIFMES software control the entire production line.

### 3.1 Raw material filling

The raw material filling only allowed in stopped machine

### 3.2 Palette filling

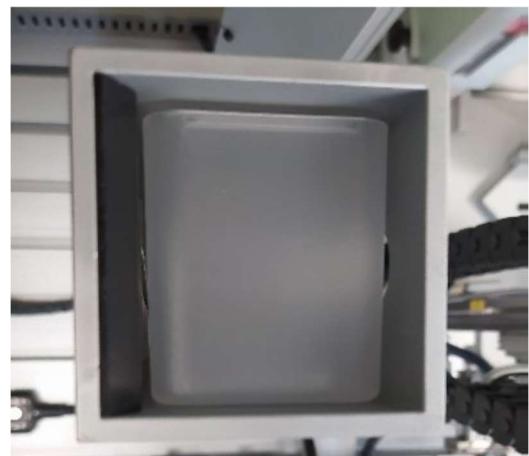
The blue palettes should place as in the picture





### 3.3 Container filling

The containers should be placed only in the dedicated place. The top of the container position is irrelevant, the machine will place it in the proper way.



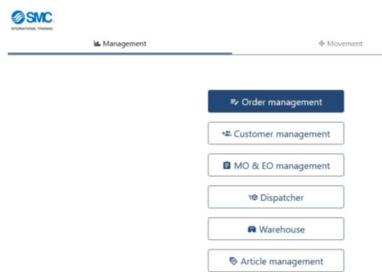
### 3.4 In manual mode the choices are:

- Palette + square container
- Palette + round container
- Empty palette



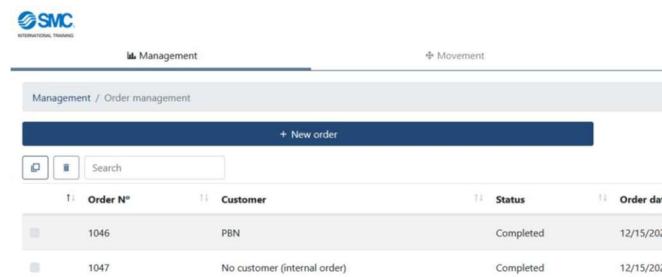
## 4 SIF Mes

In integrated mode the production line can produce the ordered product. All cell should be switched on, and in resetted state. To order, open the SIFMES software in the browser:



### 4.1 Order management

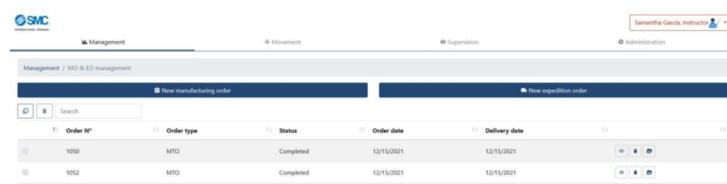
In the Management -> Order management we can create a customer order with a New order button. To select the Stock order option the product will go to the warehouse, and will not be assigned with customer. If it is not selected, it will go to delivery.



Management / Order management				
<a href="#">+ New order</a>				
<a href="#">Search</a>	Order N°	Customer	Status	Order date
	1046	PBN	Completed	12/15/2022
	1047	No customer (internal order)	Completed	12/15/2022

### 4.2 EO&MO management

In this menu we have two options. The first is a New manufacturing order, where we can produce a previous production order. The second option is the New expedition order, where we can deliver a product from a warehouse. We can choose one of these two options, and below the Order lines we should choose the products and push the Add and the Save button.

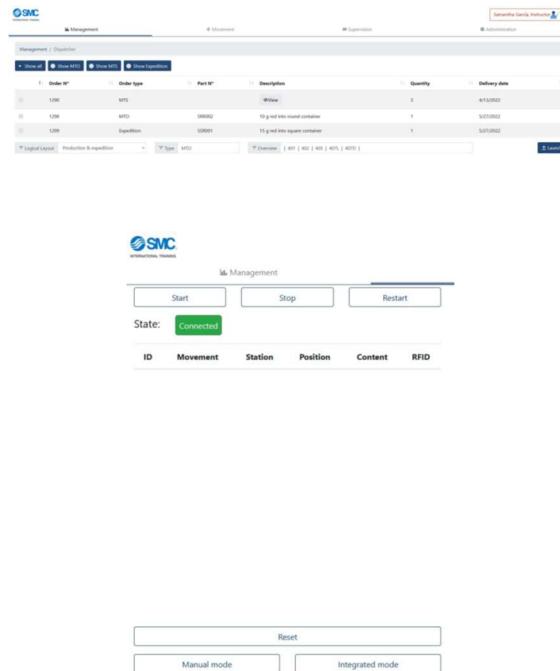


Management / MO & EO management						
<a href="#">New manufacturing order</a>			<a href="#">New expedition order</a>			
Order N°	Order type	Status	Order date	Delivery date		
1050	MTO	Completed	12/15/2021	12/15/2021		
1052	MTO	Completed	12/15/2021	12/15/2021		



#### 4.3 Dispatchet

In the Management -> Dispatcher menu we can start the production. We can choose the mode in the upper part (Show MTO - show the productions for delivery, Show MTS - show the productions for warehouse, Show Expedition - show the delivery for warehouse), then we can choose the lines what we want to produce, and push the Launch button. Then in the Movement - System status menu push the Integrated mode button.



## 5 Documentation

### More information

- Operation Manula SIF-400 Integrated mode
- Operation Manula SIF-400 Manual mode
- Operation Manula SIF-400 Software manual

