ITMProcess2

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.

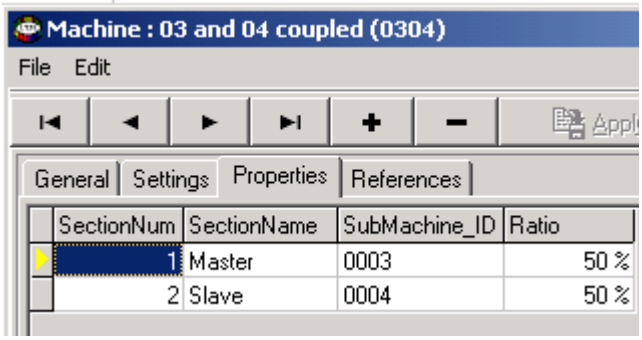
Current document has been written at ITMProcess v2.3.1.

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 …



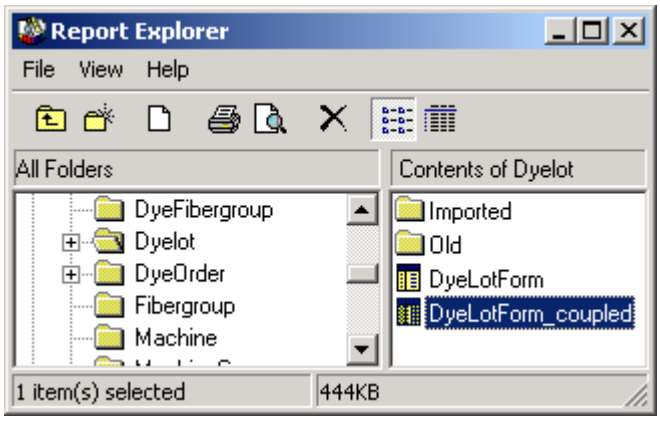
Production report

You must use the report from the ITMReportExplorer.

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

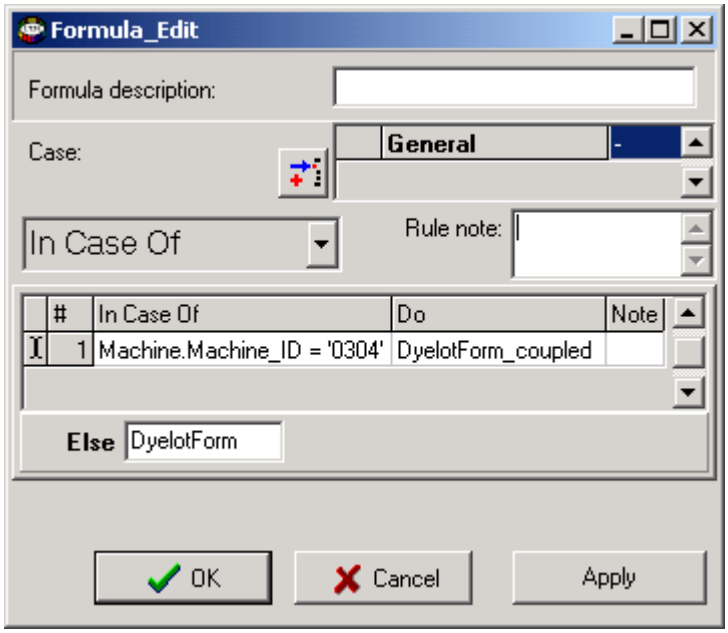
In ITMReportExplorer, in folder Dyelot, create a new report and load the existing report from the file
\Datacolor\Common Files\ITMReports\DyeLotForm_coupled.rtm

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.

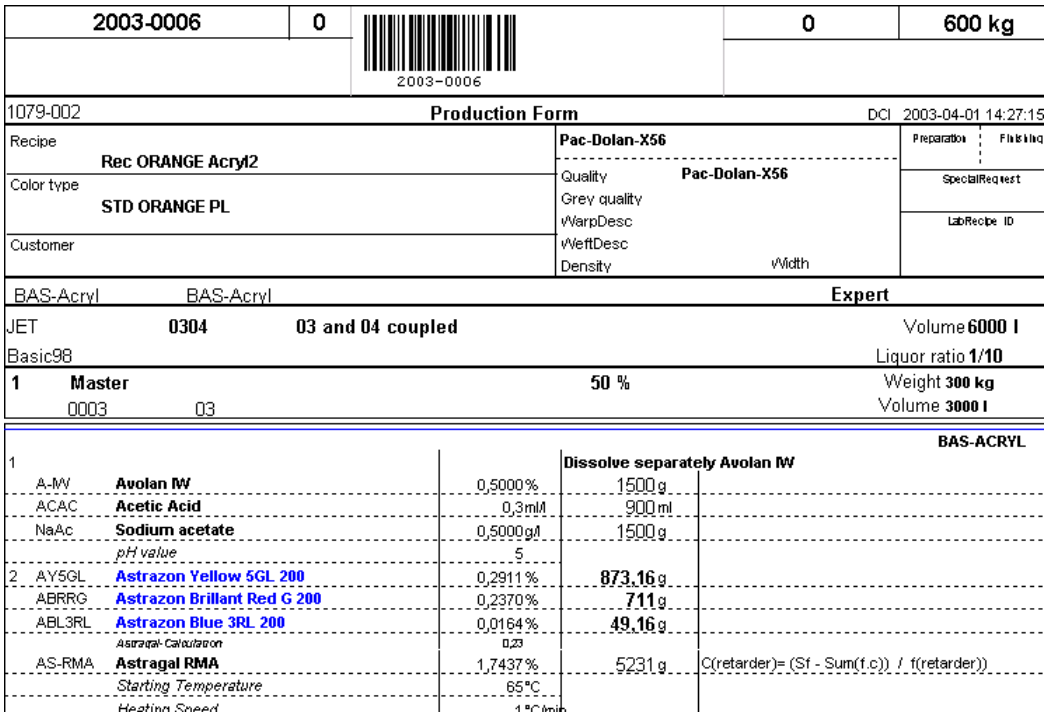


Use

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	2003-0006	0	600 kg

1079-002 **Production Form** DCI 2003-04-01 14:27:15

Recipe **Rec ORANGE Acryl2**	**Pac-Dolan-X56**	Preparation	Finishing
Color type **STD ORANGE PL**	Quality **Pac-Dolan-X56**	SpecialRequest	
Customer	Grey quality	LabRecipe ID	
	WarpDesc		
	WeftDesc		
	Density Width		

BAS-Acryl BAS-Acryl **Expert**

JET **0304** **03 and 04 coupled** Volume **6000 l**

Basic98 Liquor ratio **1/10**

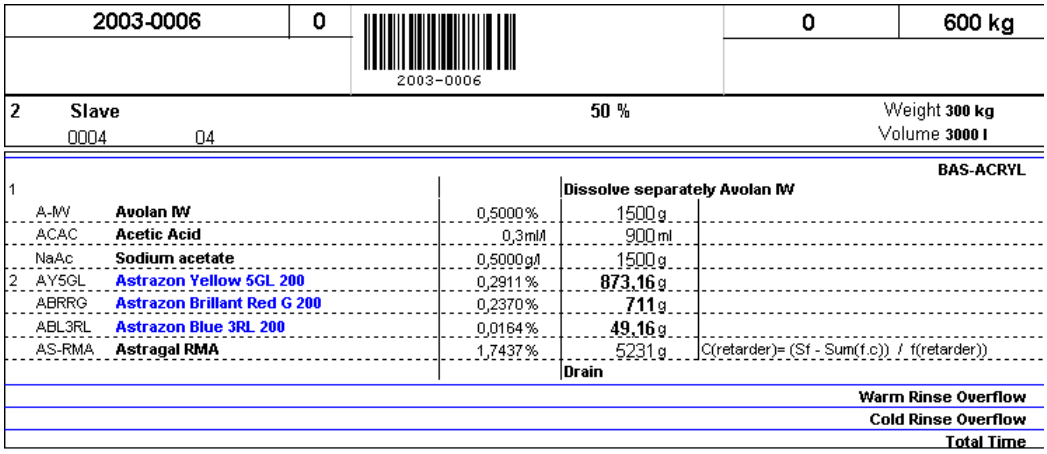
1 Master **50 %** Weight **300 kg**

0003 03 Volume **3000 l**

BAS-ACRYL

1				**Dissolve separately Avolan IW**	
	A-IW	**Avolan IW**	0,5000 %	1500 g	
	ACAC	**Acetic Acid**	0,3 ml/l	900 ml	
	NaAc	**Sodium acetate**	0,5000 g/l	1500 g	
		pH value	5		
2	AY5GL	**Astrazon Yellow 5GL 200**	0,2911 %	**873,16** g	
	ABRRG	**Astrazon Brillant Red G 200**	0,2370 %	**711** g	
	ABL3RL	**Astrazon Blue 3RL 200**	0,0164 %	**49,16** g	
		Astragal Calculation	0,23		
	AS-RMA	**Astragal RMA**	1,7437 %	5231 g	C(retarder)= (Sf - Sum(f.c)) / f(retarder))
		Starting Temperature	65°C		
		Heating Speed	1,5°C/min		

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



2003-0006	0	2003-0006	0	600 kg

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**	0,3 ml/l	900 ml	
	NaAc	**Sodium acetate**	0,5000 g/l	1500 g	
2	AY5GL	**Astrazon Yellow 5GL 200**	0,2911 %	**873,16** g	
	ABRRG	**Astrazon Brillant 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