

TrueChem's traditional scheduling capabilities are time-based. For example, perhaps you'd like to perform a pH test every Monday at 1pm.

But sometimes you may want to schedule a test (or a Remake of the tank, or a filter change, etc.) *based on usage* and not time. For instance, perhaps you'd like to perform that pH test after 1,000 amp-hours have been used in the tank. Or maybe you'd like to schedule a new makeup after 500 parts have been run through the tank. TrueChem's Group Input Feature can accomplish this.

*Note: instead of "Groups", your facility may refer to them as "Lines" or as in these examples, "Processes". Also note that this feature requires the use of TrueChem's "DataServer" which is a copy of TrueChem running at all times.*

## **Step 1: Create a "Process Input"**

The first step in scheduling something to be done based on, say, the number of parts that have moved through a tank is to create up a Process Input. This is done by selecting a Process in TrueChem's main tree, then clicking the Process Setup button, and then the Inputs tab. You can then click the green plus sign to create a new Process Input for that Process. See figure 1 below.

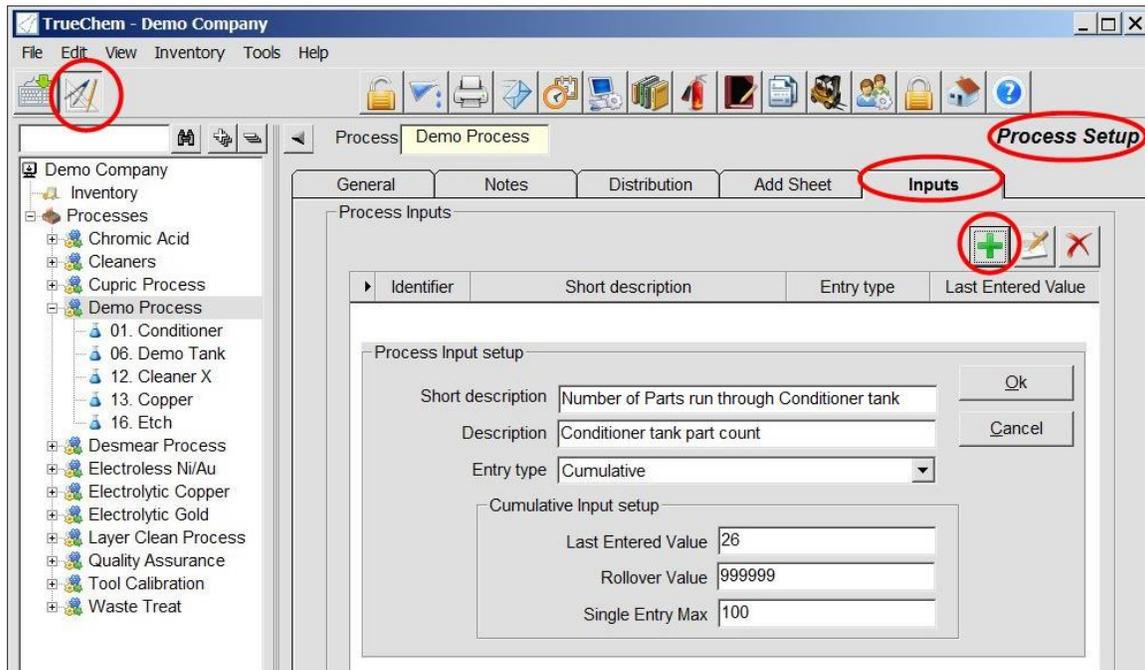


Figure 1

## **Step 2: Create a "Process Input Trigger"**

Next you'll create one or more places where the newly created Process Input will be used. Thus, you will be creating a schedule "trigger" for something to occur.

You'll do this in a fashion similar to creating one of TrueChem's time-based schedules. Thus, you would highlight a tank in TrueChem's main tree, click the Tank Setup button, and then click the Schedule tab. In this example, we are creating a schedule for a Remake to occur. So you'd click the green plus sign in the Other Schedules area. See figure 2 below.

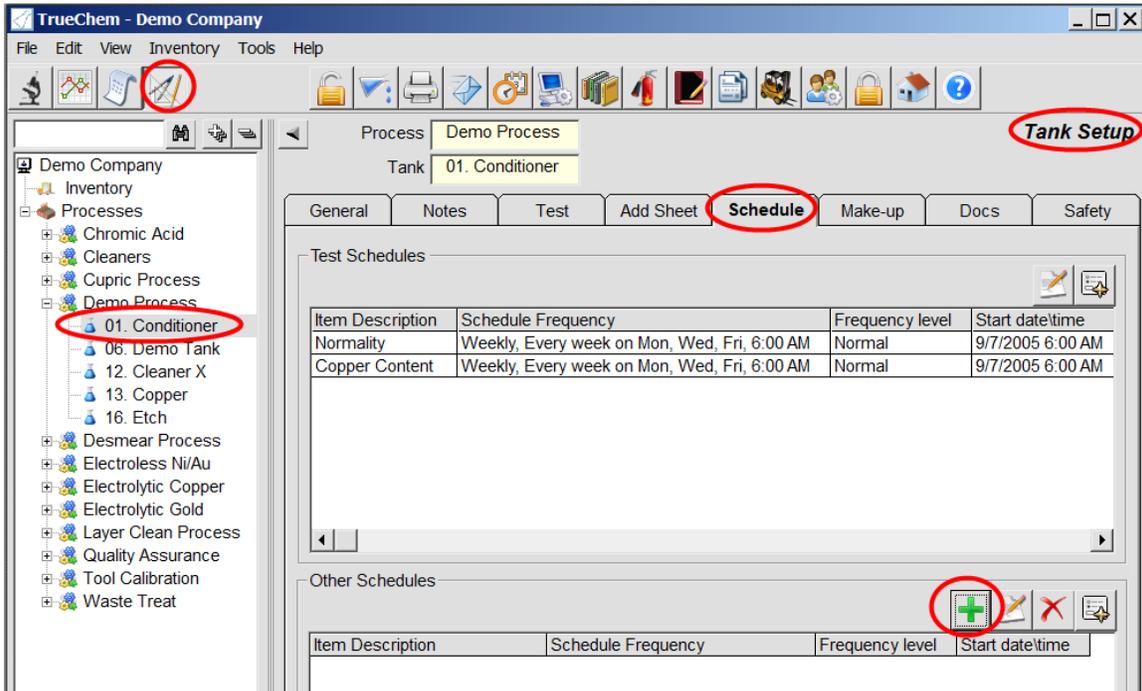


Figure 2

After clicking the green plus button in the above step, the Schedule Setup screen will be displayed. See figure 3 below. After filling out the top section of information for the scheduled Remake, you would click the new Process Input Triggers tab, and then click the green plus button to create a new Process Input Trigger.

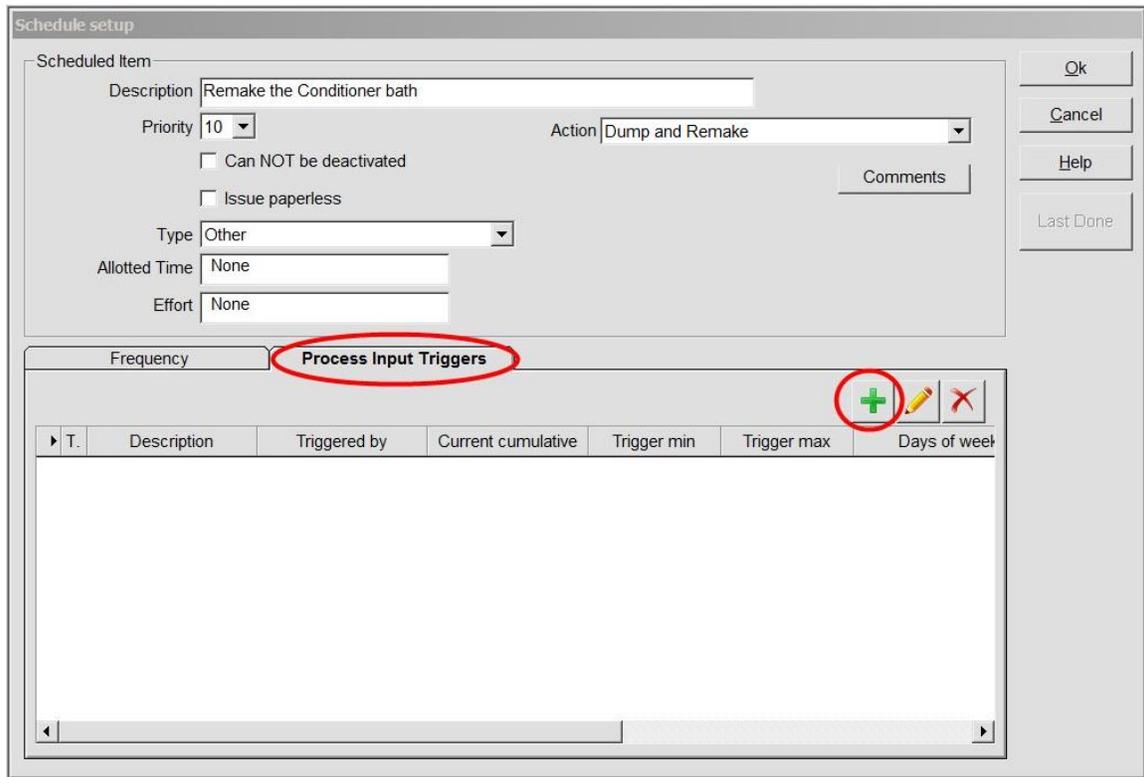


Figure 3

After clicking the green plus button in the above step, the Process Input Triggers screen appears. See figure 4 below. On that screen you'd select the Process Input of interest and fill out the remaining options. Once the number of parts has reached the Trigger Min and the current day is one of the days that have been selected, then this scheduled Remake will be deemed "Due" on the schedule. If the Trigger Max is reached, then this scheduled Remake will be deemed "Due" regardless of the day.

If the "Auto-execute the action" option is checked, then instead of being deemed Due on the schedule, the scheduled item would be automatically executed at the designated time. So in our example, an addsheet for the Remake would be automatically created at the designated time.

Process Input Triggers

Inputs from: Current Process

Demo Process - GIN1 - Number of Parts run through Conditioner ta...

Description: Conditioner remake trigger

Trigger min: 500

Preferred days: Sun  Mon  Tue  Wed  Thur  Fri  Sat

Trigger max: 700

Current cumulative: 0

Auto-execute the action

Schedule allotted time: 8 hours

Ok

Cancel

Figure 4

### **Step3: Inputting a value for a Process Input**

To input a new value for a Process Input (e.g. a cumulative part count), highlight the desired Process in the main tree, and click the Process Input button. Doing this causes the Process Input window to be displayed. See figure 5 below.

In this example, the new cumulative part count is 34, so that number was typed into the text box. The previous cumulative value was 26, so 8 will be added to all triggers that uses that Process Input. The trigger we created for the scheduled Remake in the Conditioner tank uses this Process Input, so that trigger will be bumped by 8. Once that trigger reaches 500 (and the current day matches one of the selected days), the scheduled Remake will be deemed "Due" on the schedule. When the scheduled Remake is completed, that trigger's Current Cumulative will be reset to zero.

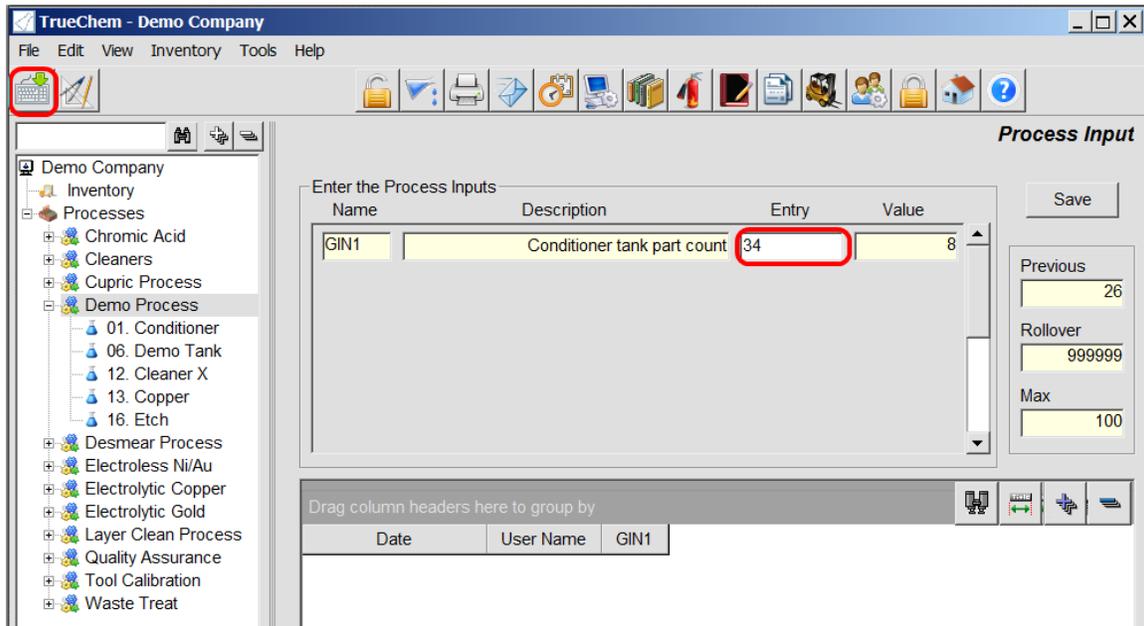


Figure 5

## TrueChem Variables

There are several TrueChem variables related to the Group Input Feature that can be used in various places in TrueChem.

[GINxxx.Value] – the production value of the most recent Group Input for the Group Input designated by xxx. In the example from figure 5 above, [GIN1.Value] would return 8.

[GINxxx.Date] – the date when the most recent Group Input for input xxx was entered.

[GINxxx.Age] – the number of minutes since the most recent Group Input for input xxx was entered.

[TRGxxx.Cum] – the current cumulative for the xxx trigger.

[TRGxxx.Min] – the minimum (a.k.a. trigger point) for the xxx trigger.

[TRGxxx.Max] – the maximum for the xxx trigger.

[TRGxxx.Name] – the description for the xxx trigger.

[TRGxxx.SchedName] – the description of the scheduled item associated with the xxx trigger.

---

If you have any questions or need any help, please contact technical support at 1-800-448-2548 ext. 2