

Software Step-in Solves Palletizing Dilemma

Container Manufacturer



Pallet Labeling Software

View Production Line Information Stop Production Exit

LINE	PRODUCTION NUMBER	PRODUCT NUMBER	SEQ#	STATUS
6	47003524	471000075	0002	Printed at 2:16:59 F
6	47003524	471000075	0001	Printed at 2:16:44 F
6	47003524	471000075	0001	Printed at 2:16:09 F
6	47003524	470000075		No Label Printed. Ir
0		471000075		No Label Required
7		471000075		No Label Printed. Ir
4	47003559	471000075	0122	Printed at 2:12:50 F
4	47003559	471000075	0121	Printed at 2:12:32 F
4	47003559	471000075	0121	Printed at 2:12:06 F
4	47003559	471000075	0120	Printed at 2:11:27 F
1	47002954	471000002	0002	Printed at 2:10:24 F
1		471000056		No Label Printed. Ir

Previous Pallet Information

Manufacture Date: 07/15/16
Qty: 1 Unit: 0002 Shift: 2
Production #: 47003524

20 OZ FLUTED SHORT PUB MIX BAR

Product Number: 471000075
Lot #: 4760715F
CM #: 34-31272

Label Software Setup
Label Format: C:\c00524-klabels1
Printer: Zebra ZE500-4 RH (203dpi)->10.47.5.186.9100

PLC Data
Connected to PLC
Data Sent to Printer

LabelPLC.Line	6	OPC ServerName
LabelPLC.ProductRun	471000075	Expansive IEP/Planner/EX/VS
LabelPLC.LabelType		OPC HostName
		OPC GroupName
		FOXIV

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The ability for FOX IV's software experts to step in on a project lead to a satisfied customer with software that exceeded expectations.

Growth & Impact



Flexibility
to program for competitive units as well as own.



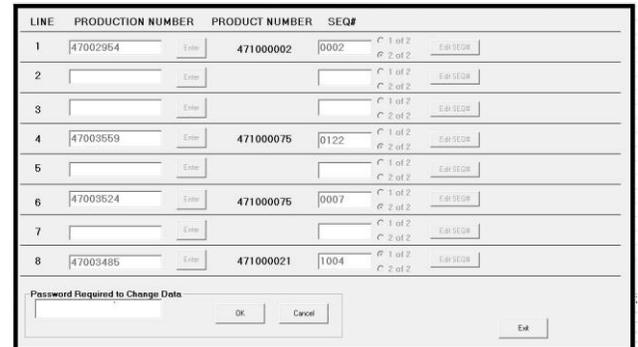
Middleware
compatibility.



Completion
of initial palletizing line within time frame

Software Step-in Solves Palletizing Drama

FOX IV's ability to program for competitive equipment and work with the customer's OPC Server lead to the completion of a project following unforeseen circumstances.



Background

A large container manufacturer contacted FOX IV regarding a palletizing project installation using existing non-FOX IV equipment. While the Zebra-based print and apply equipment had been installed, the software portion of the project could not be completed due to unforeseen circumstances. The manufacturer asked if FOX IV could step in to do the software to complete the project.

APPLICATION:

Multiple palletizing lines would be merged into one line where the pallets would be labeled on the front and side with 4" x 6" labels. A PLC would communicate with the labeling station PC identifying which line the pallet came from. The software would determine what was running on the line, merge the data from the customer's SQL database with the label format, and send labels to the print and apply unit. The customer was using Kepware as the OPC Server to communicate between their PLC and the labeling station PC.

ENVIRONMENT/SPECIAL CONDITIONS:

Temperature controlled factory environment. Zebra-based print and apply systems from a different manufacturer.

Solution

FOX IV provided a custom software solution to work with the Kepware OPC and existing equipment.

The software is hosted on a dedicated PC for the palletizing line. The software communicates through Kepware to pull the line information from the PLC. When that data is received, the program looks at the information entered for that line and searches the customer database to validate the data and retrieve the remainder of the label information. If information is invalid, a warning screen appears and labels are not printed until the operator corrects the information through a View/Edit process, which can be password protected.

As part of the software dashboard, information such as line, production number, product number, sequential number, and shift. It also displays the previous pallet information and status of each pallet. There is also a Test Print/Reprint option which is used to print and label without updating the sequential number. This would be used if a label was damaged and needed to be reprinted or if tests were being run on the line.

Following the first installation, the software was purchased and installed in two additional plant locations. Since that time, the customer has purchased FOX IV software for palletizing lines in 6 other plants. Software was modified per location requirements. Adjustments were made to accommodate more production lines, adding the Line and Production number, sequential numbering, or accommodating printing to a tabletop printer.

VIDEO LINK: https://youtu.be/3fg_oz1n9gs

“Our software experience enabled us to step-in to finish the installation and create a satisfied customer in the process.”

Patty Remo, VP Technology, FOX IV Technologies, Inc.