

Setting Up Email Production Reports

Version 6 of the stuga software has a facility for emailing a daily production report to nominated email addresses

 Difficulty **Medium**

 Duration **2 minute(s)**

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Step 1 - Set up the shift pattern for the company

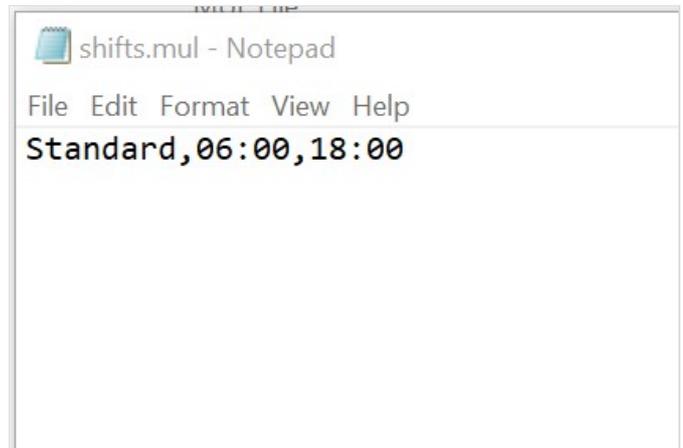
Exit winMulti and set up the shift pattern in the file:

c:\DDRIVE\shifts.mul

Enter a line for each. shift - [Name of Shift],[Start time],[End Time]

For example:

Day,08:00,18:00
Night,18:00,03:00



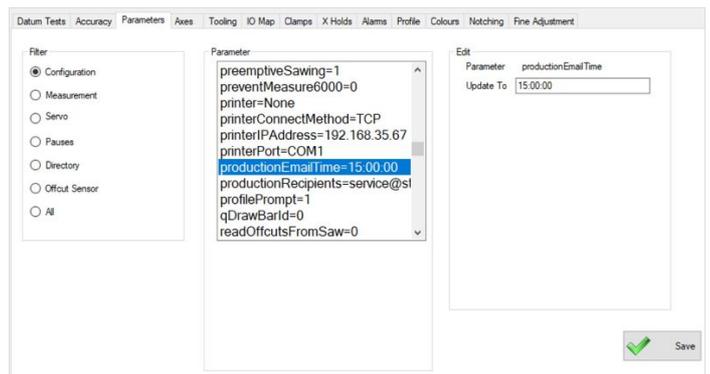
Step 2 - Restart winMulti

Navigate to Settings->Parameters

Step 3 - Enter the email send time

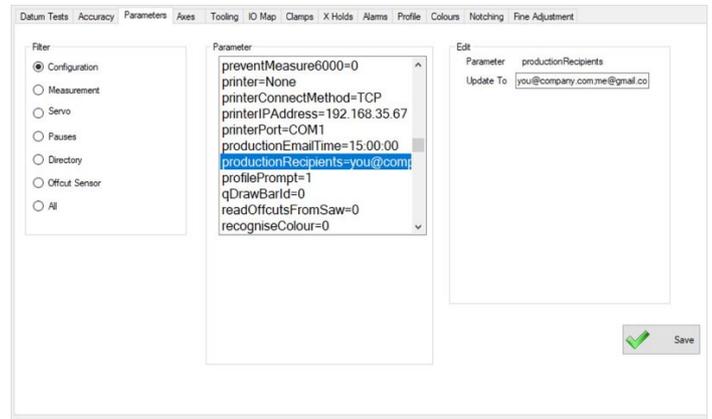
Enter the time you would like the email sending in the parameter 'productionEmailTime'

Click Ok to update the parameter



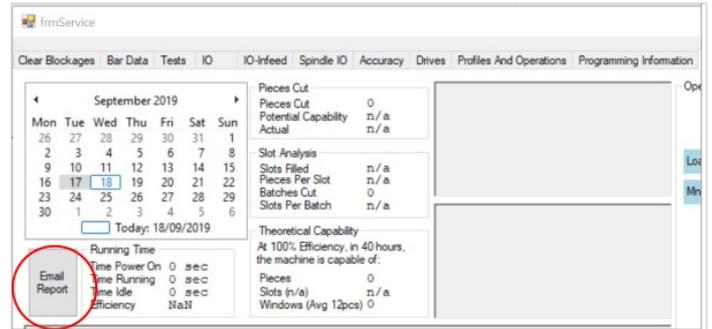
Step 4 - Enter the email addresses to send to

Enter the email addresses of the recipients in 'productionRecipients'
Separate multiple email addresses with semicolons.



Step 5 - Test the delivery

Test the system by sending a report from the Output timings screen (on service tab)
Choose yesterday as a production date (the default is today which often does not have any data yet)
Click on the button "Email Report" and it should send an email to the recipient list



Step 6 - Potential Delivery Problem

It is possible that the email system will be blocked by some customer server setups. If the test does not work, contact GG



Step 7 - ADVANCED - Location of database

If the data is required to be queried from an external source, the source data is written to a SQLite database located on the HDD of the machine.

```
c:\DDRIVE\_machine\diagnostic.db3
```

Table Name: runningMHArchive

The records in the table are running data processed into 15 minute date and time stamped segments. For each segment there are a number of fields:

- **pieces** - Number of pieces cut
- **frames** - Number of slots finished (number of frames)
- **running** - Number of seconds that the machining head was running
- **loading** - Number of seconds that the machining side was loading a bar (and not running)
- **idle** - Number of seconds where the machining side was doing nothing (infeed table had run out or no batch loaded)
- **sawwait** - Number of seconds where the transfer table is full, waiting for the operator to start sawing
- **operatorwait** - number of seconds waiting for the operator to press start to continue

