

# TB0403 Issues Arising from Bloated Saw Bar Queue

On a flowline / ZX with separate winSaw program on saw side, the software works by continually increasing the Bar Queue with every bar cut. An issue has been found that if the operator rarely resets the program, it can build up in size and get “bloated” to the point where it does not perform correctly with the following symptoms: • Missing / delayed labels • Slow updates / performance • Long time to start cutting a bar after loading • Reprinting label delays

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## Problem

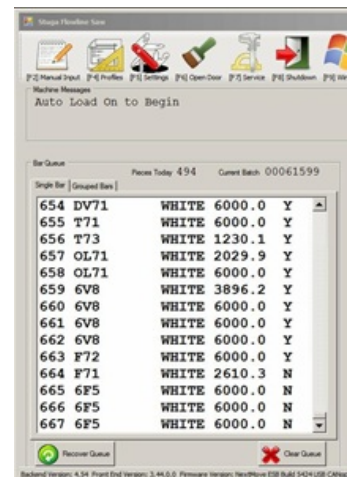
Picture shows a queue where the saw software has not been restarted for 2 days, with a queue of 667 bars. This machine was increasingly missing labels as the queue size increased.

## Solution

The solution is very simple.

Keep the bar queue below 200 bars by exiting to windows and restarting the saw software. Note: You do not need to restart windows or switch the machine off, just restart the saw software.

This normally happens naturally on daily basis, because the operator shuts the machine is shut down. However, in some cases, the machine is left on overnight, and the bar queue is then not cleared and builds up day by day.



The screenshot shows the winSaw software interface. At the top, there are several icons for manual print, poller, settings, open door, service, shutdown, and help. Below these is a 'Machine Message' section with the text 'Auto Load on to Begin'. The main part of the interface is a 'Bar Queue' table. The table has columns for 'Single Bar', 'Grouped Bars', 'Pieces Today', and 'Current Batch'. The 'Current Batch' is 00061599. The table contains 13 rows of data, with the last row being 667 6F5 WHITE 6000.0 N. At the bottom of the interface, there are buttons for 'Recover Queue' and 'Clear Queue', and a footer with version information: 'Backend Version: 4.34 Front End Version: 3.44.0.0 Firmware Version: NextPhase USB Build 3424 USB C4142'.

| Single Bar | Grouped Bars | Pieces Today | Current Batch |
|------------|--------------|--------------|---------------|
| 654        | DV71         | WHITE 6000.0 | Y             |
| 655        | T71          | WHITE 6000.0 | Y             |
| 656        | T73          | WHITE 1230.1 | Y             |
| 657        | OL71         | WHITE 2029.9 | Y             |
| 658        | OL71         | WHITE 6000.0 | Y             |
| 659        | 6V8          | WHITE 3896.2 | Y             |
| 660        | 6V8          | WHITE 6000.0 | Y             |
| 661        | 6V8          | WHITE 6000.0 | Y             |
| 662        | 6V8          | WHITE 6000.0 | Y             |
| 663        | F72          | WHITE 6000.0 | Y             |
| 664        | F71          | WHITE 2610.3 | N             |
| 665        | 6F5          | WHITE 6000.0 | N             |
| 666        | 6F5          | WHITE 6000.0 | N             |
| 667        | 6F5          | WHITE 6000.0 | N             |