## 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.							
	<b>Links!</b> 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							
	The coupled machine feature is available since ITMProcess v2.3.1.							
	Current document has been written at ITMProcess v2.3.1.							
	Configure							
	- 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 <b>SubMachine ID</b> the master 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

Machines

Version

- Then add the slave machines with SectionNum 2,3 ...

Machine : 03 and 04 coupled (0304)									
File Edit									
H I I I I I I I I I I I I I I I I I I I									
General Settings Properties References									
Se	SectionNum SectionName			SubMa	chine_ID	Ratio			
	🕨 1 Mas		ſ	0003		50 %			
2 Slav				0004		50 %			

#### **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.

😻 Report Explorer	
File View Help	
🖻 💣 🗅 🖨 🚨	× 🖽 🏛
All Folders	Contents of Dyelot
📄 📄 DyeFibergroup	Imported
庄 🔄 Dyelot	bio 🧰
主 💼 DyeOrder	💴 🔢 DyeLotForm
Fibergroup	DyeLotForm_coupled
Machine	
1 item(s) selected	444КВ //.

#### **PrintForm formula**

You can use the same report for non-coupled and coupled machines or you can introduce a PrintForm formula like this one.

🧟 Formula_Edit		
Formula description:		
Case:	General	- A
In Case Of	Rule note:	4
# In Case Of   I 1 Machine.Machine.	Do _ID = '0304' DyelotForm_coupled	Note
Else DyelotForm		
✓ 0K	🗶 Cancel 🛛 🗛	pply

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## 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).

2	2003-0006	0				0	600 kg	
			2003-0	0006				
1079-002			Pi	roduction Fo	rm	D	CI 2003-04-01 14:23	7:15
Recipe					Pac-Dolan-X56		Preparation Find	shinq
	Rec ORANGE Acryl2				∩usity Pi	ac-Dolan-X56		
Color type					Grev quality		Specialized (est	;
	STD ORANGE PL				WarpDesc		LabRecipe ID	
Customer					WeftDesc			
					Density	Width		
BAS-Acryl	BAS-Acryl					Expe	rt	
JET	0304	03 and	104 couple	d			Volume <b>6000  </b>	
Basic98			•				Liquor ratio 1/10	
1 Mas	ter				50 %		Weight <b>300 kg</b>	
	3 03				<b>50</b> <i>n</i>		Volume 3000 I	
								_
1			1		Discolus constat	ah: Aualaa Mi	BAS-ACRY	L
A-NA/	Avolan M			0.5000%	1500 a			
ACAC	Acetic Acid			0.3mM	900 g			
NaAc	Sodium acetate			0.5000a/	1500 a			
	pH value			5				
2 AY5GL	Astrazon Yellow 5GL 2	00		0,2911%	873,16g			
ABRRG	Astrazon Brillant Red (	5 200		0,2370%	711g			
ABL3RL	Astrazon Blue 3RL 200			0,0164%	49,16g			
	Astragal-Calculation			0,23	1	]		
AS-RMA	Astragal RMA			1,7437%	. 5231g	C(retarder)=(Sf-Sum(f.c	:)) / f(retarder))	
	Starting Temperature			65°C				
	Hegting Sheed			1°C (m	in the second	1		

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

	2	003-0006	0	- 2003-	-0006		0	600 kg
2	Slav	/e				<b>50</b> %	V	Veight 300 kg
	0004	04					V	olume 3000 I
								BAS-ACRYL
1						Dissolve separa	tely Avolan IW	
	A-W	Avolan IW			0,5000%	1500 g		
	ACAC	Acetic Acid			0,3ml/l	900 ml		
L	NaAc	Sodium acetate			0,5000g/l	1500 g		
2	AY5GL	Astrazon Yellow 5GL 20	0		0,2911 %	873,16g		
	ABRRG	Astrazon Brillant Red G	200		0,2370%	711g		
	ABL3RL	Astrazon Blue 3RL 200			0,0164%	<b>49,16</b> g		
	AS-RMA	Astragal RMA			1,7437%	5231g	C(retarder)= (Sf - Sum(f.c))	/ f(retarder))
						Drain		
	Warm Rinse Overflow							
							Co	ld Rinse Overflow
								Total Time