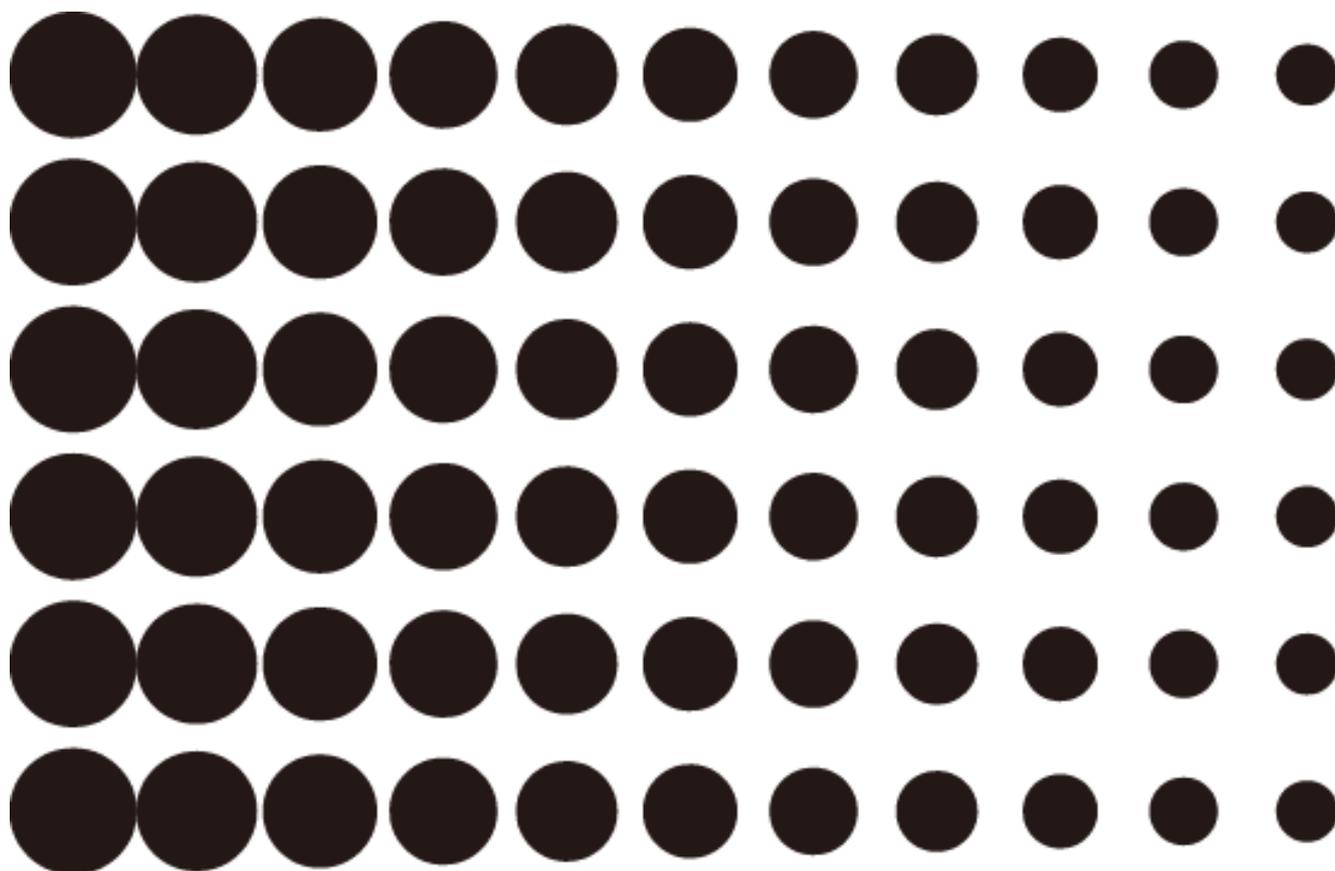


Happy PMS OPERATION MANUAL

Ver. 1.0.0.5~



EF191028

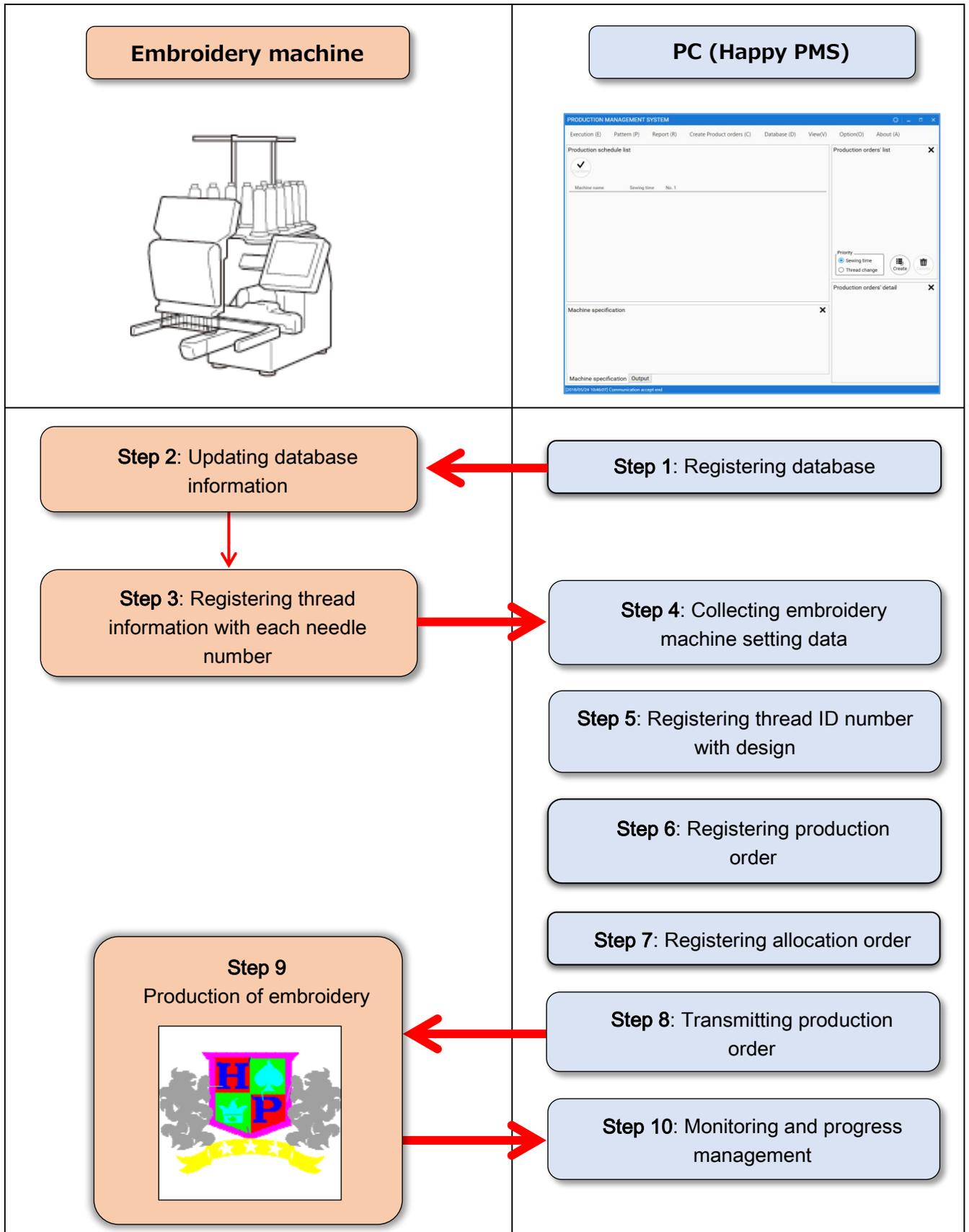
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chapter 1. **System Outline**

A glance at Happy PMS

System flow chart and task



Brief illustrations about steps

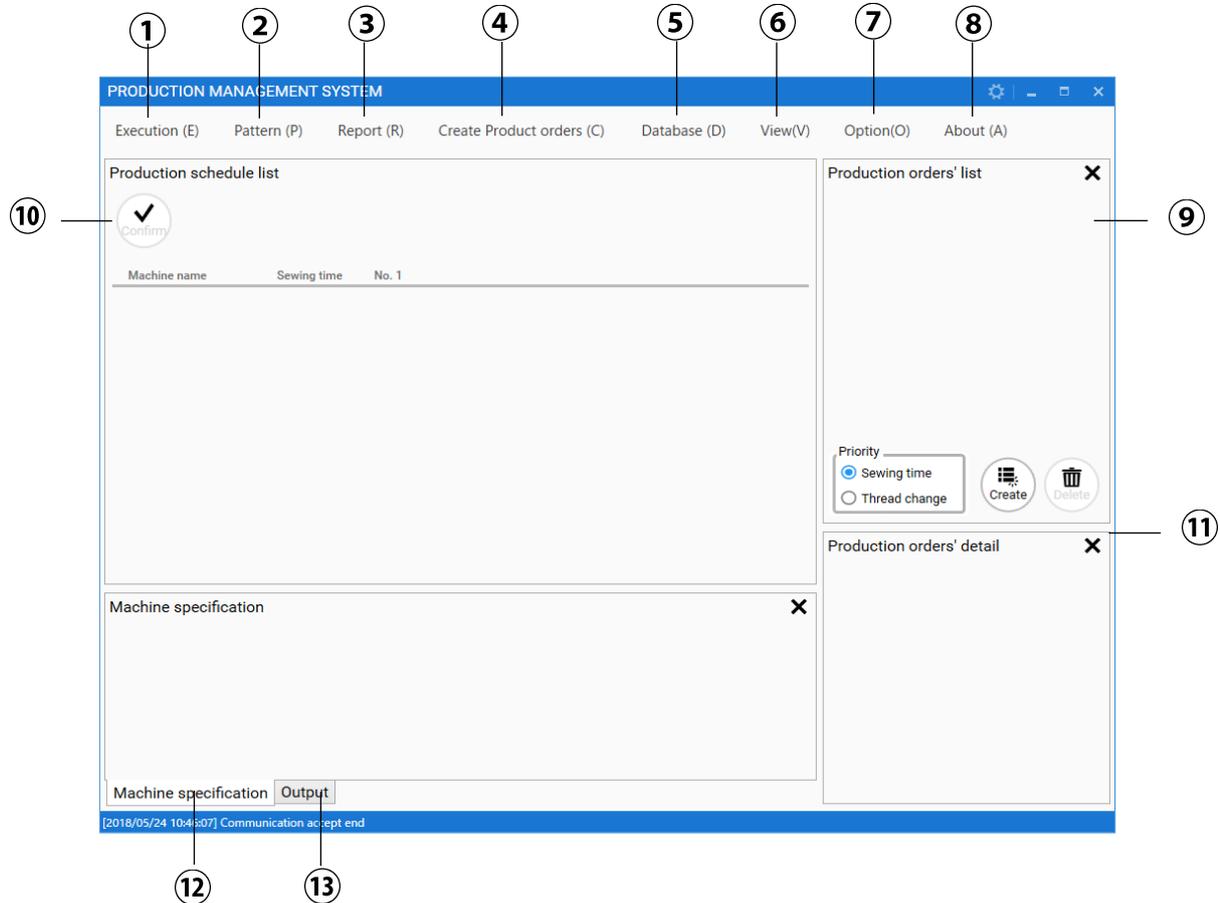
Here are brief illustrations about the system flow.

Embroidery machine
Happy PMS

Step 1: Registering database information	Register the database information such as “Threads”, “Frames”, “Fabrics” and “Material” etc.	P. 12
Step 2: Updating database information	The database information which is registered in the section Step 1 is transmitted to the machine. ※ Transferred database will automatically be registered at an embroidery machine.	P. 35
Step 3: Registering thread information with each needle number	The thread information which is stored in the section Step 2 is registered with the each needle number of the machine. (The currently standing thread location)	P. 40
Step 4: Collecting embroidery machine setting data and thread location	The system collects the embroidery machine’s setting data and the current thread location data which is registered in the section Step 3. ※ Registered data will automatically be shared by an embroidery machine.	P. 44
Step 5: Registering thread ID number with embroidery design	Create embroidery data for using as source of production order. In this step, only the thread ID number is registered.	P. 45
Step 6: Registering production order	Add the order information to the design data which is made in the section, c then register the production order. (“Production order,” Quantity” etc.)	P. 57
Step 7: Registering allocation order	The production order which is registered in the section Step 6 is allocated to the machine and the estimated production time is also calculated. ※ The allocation work can be done by drag and drop operation.	P. 62
Step 8: Transmitting production order	The production order is transmitted to the machine in accordance with the allocation order which is registered in the section number Step 7. ※ To be automatically sent by Happy PMS	P. 65
Step 9: Production of embroidery	Start embroidery with using the production order which is received from the PC. The production result is sent to the PC after each embroidery.	P. 68
Step 10: Monitoring and progress management	Result will be sent by an embroidery machine. Progress will be updated. Then, it will appear at main screen of Happy PMS. ※ It will automatically be shared by Happy PMS.	P. 76

Main form of HAPPY PMS

Here are illustrations about main screen of Happy PMS.



- ① **Execution**...To connect between Happy PMS and an embroidery machine. To send production order to an embroidery machine.
- ② **Pattern**...Create embroidery data.
- ③ **Report**...To output progress with production order within a specified time.
- ④ **Create Product Orders**...Create Product Order.
- ⑤ **Database**...Register information of thread, frame, fabric and Material for using embroidery machine.
- ⑥ **View**...View of window in main screen is changed.
- ⑦ **Option**...To select a language.
- ⑧ **About**...Version information is shown.
- ⑨ **Production orders' list**...Registered production order is shown.

Priority _____ Priority order

Sewing time _____ Displayed with sew time priority

Thread change _____ Displayed with color change number priority

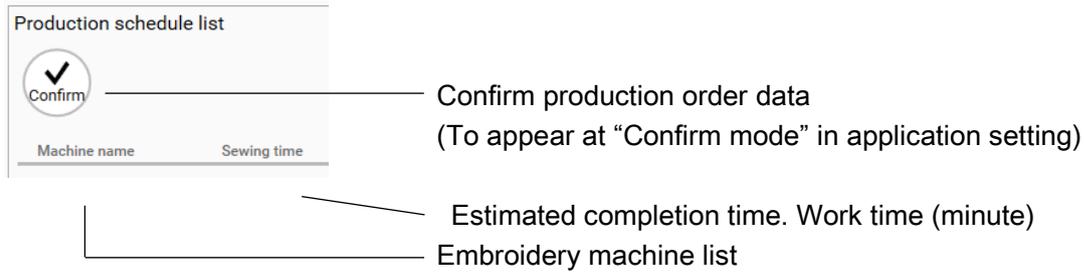


Create Product Order.

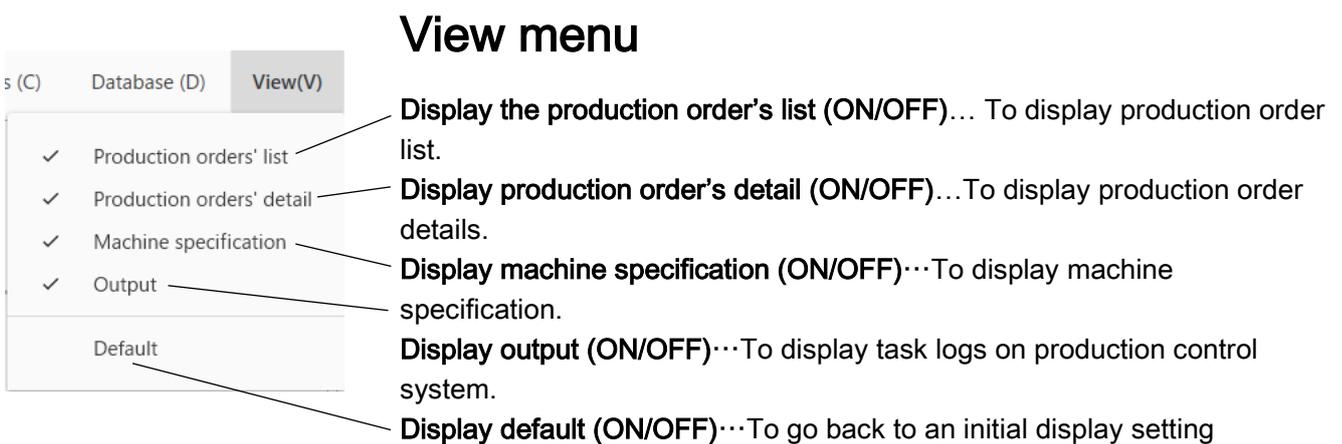
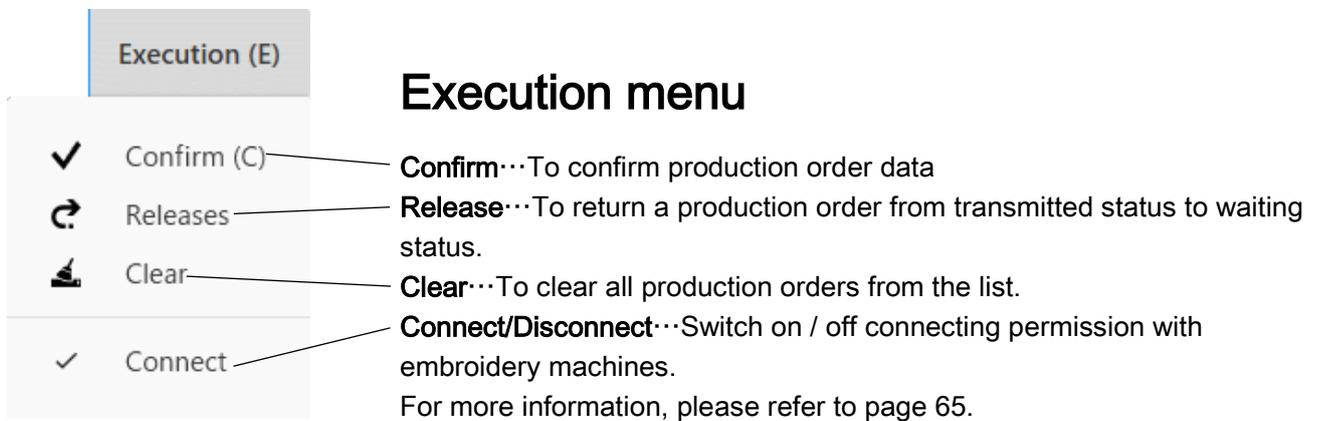


Delete Product Order.

- ⑩ **Production schedule list**...Operational status of connected embroidery machine and production order that is allocated to connected embroidery machine are shown.

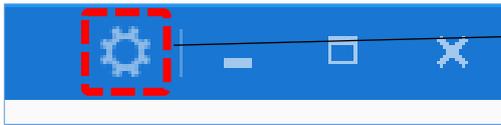


- ⑪ **Production orders' detail**...Selected production order's detail is shown.
- ⑫ **Machine specification**...Specification of selected embroidery machine is shown.
- ⑬ **Output**...Connection state of embroidery machine can be checked.

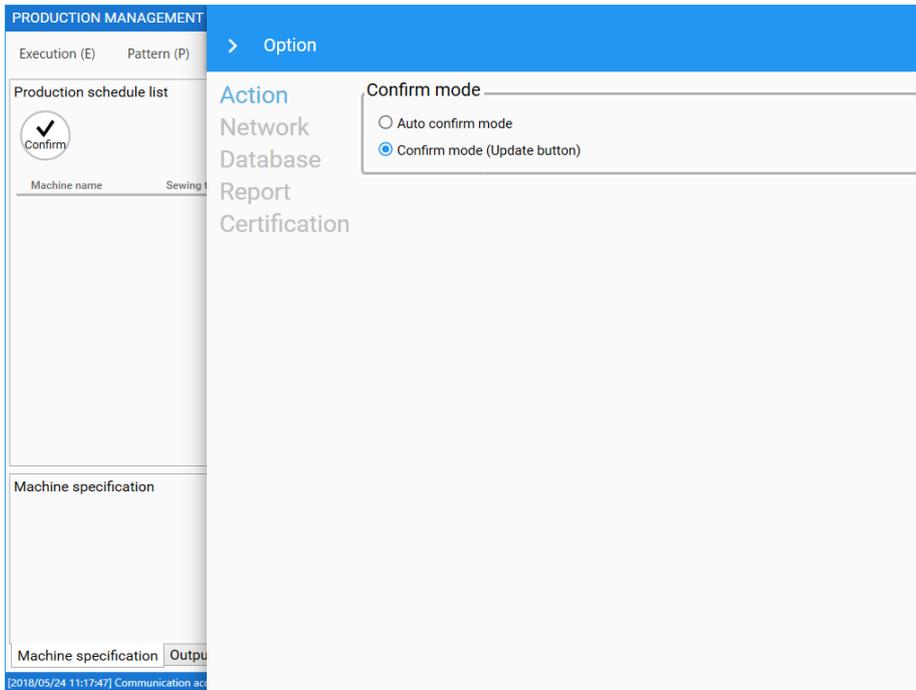


Details in Option

Please select  in the upper right at main screen.

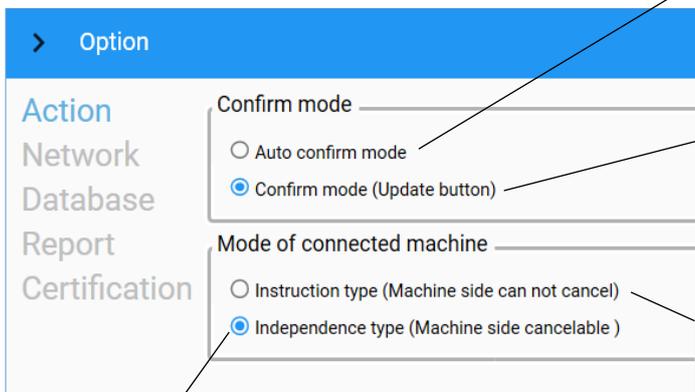


Setting...To set a various of applications



Action

Please specify motion mode of Happy PMS.



Auto confirm mode

...To confirm automatically in allocating production order

Confirm mode

...To allocate production order in a normal motion

Instruction type (Machine side cannot cancel)

This will disable cancellation of an order to have been transferred.

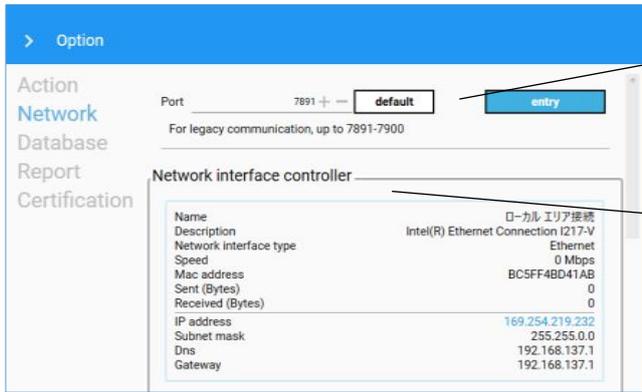
Independence type (Machine side cancelable)

This will enable cancellation of an order to have been transferred.

Network

Network setting of application is changeable.

(To be changeable when communication at an embroidery machine is off.)



Port ...

To change port number of network

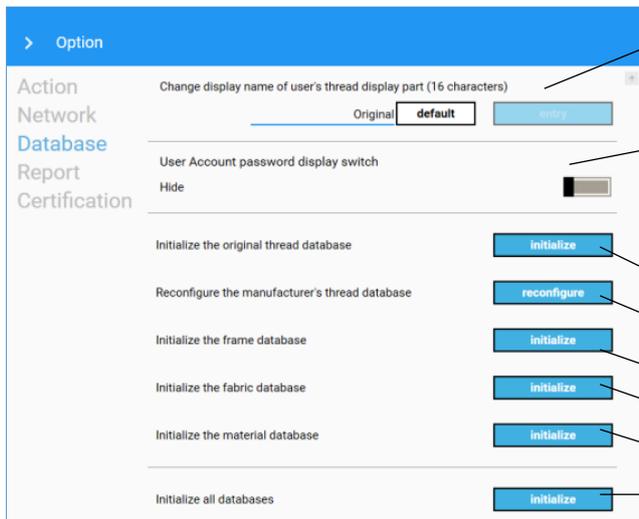
Confirm mode ...

To show a list of network of a computer in use

Database

Setting of database editing screen is changeable.

(To be changeable when database change screen does not open)



To change "Detail Name" of multi-purpose of thread database (Initial setting: Original)

To display a password of user account

To initialize original thread database

To re-set supplier's thread database

To initialize frame database

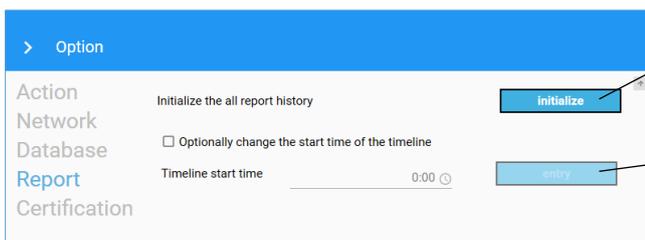
To initialize material database

To initialize **secondary material** database

To initialize all database

Report

Report records can be deleted.



To initialize all of report records

To change a start time of time line
(Start time of time line to be changeable on purpose)

Certification

Deign (confirm) cannot be sent until certification is done.

Please input machine model, machine serial number and certification key.

Please refer to Happy PMS set-up manual for more information about certification key.

The screenshot shows a mobile application interface with a blue header bar containing a back arrow and the text "Option". Below the header is a menu with the following items: "Action", "Network", "Database", "Report", and "Certification" (which is highlighted in blue). To the right of the menu is a warning icon (a triangle with an exclamation mark) and the text "Please authenticate the application" and "Functions are restricted when authentication is not performed". Below this warning are three input fields: "Model" (with a blue cursor), "Machine No (Serial No)", and "Authentication key". Each input field has a label to its left. To the right of the form, three lines of text with arrows point to the input fields: "Model" points to the first field, "Machine No (Serial No)" points to the second field, and "Authentication" points to the third field. At the bottom right of the form is a blue button labeled "authentication".

chapter 2. Operation

Step 1 Registering database

The thread, frame, fabric, and material information is registered in Database. It is possible to add information.

With pressing "Send" button in each screen, the registered thread, frame, and material information is transmitted to all connected embroidery machine.

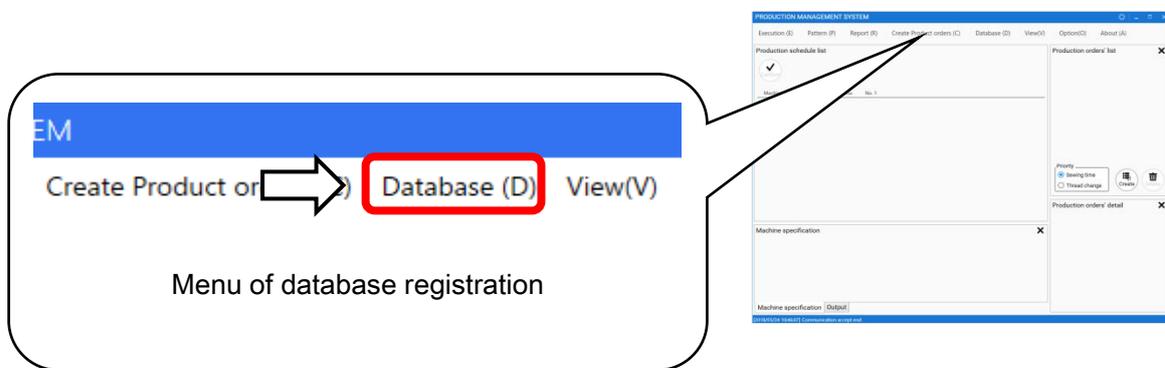
Thread

(This information is to be used in Step 6 Registering production order.)

Register thread information for setting in embroidery data.

Thread information can be newly added to "Original".

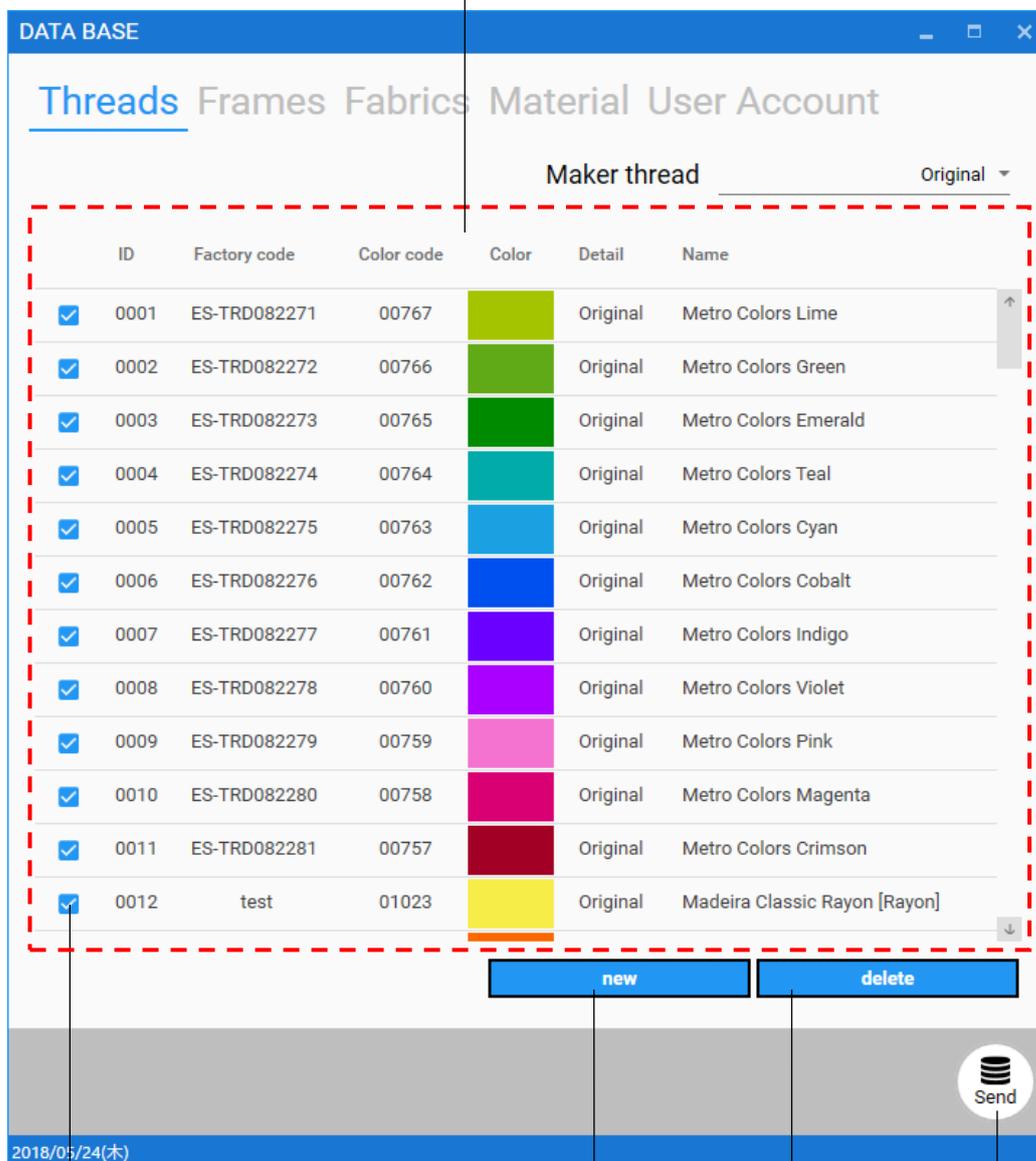
1. Please select "Database" to let database registration screen appear.



2. Thread database screen will appear.

ID	Factory code	Color code	Color	Detail	Name
<input checked="" type="checkbox"/>	0001	ES-TRD082271	00767	Original	Metro Colors Lime
<input checked="" type="checkbox"/>	0002	ES-TRD082272	00766	Original	Metro Colors Green
<input checked="" type="checkbox"/>	0003	ES-TRD082273	00765	Original	Metro Colors Emerald
<input checked="" type="checkbox"/>	0004	ES-TRD082274	00764	Original	Metro Colors Teal
<input checked="" type="checkbox"/>	0005	ES-TRD082275	00763	Original	Metro Colors Cyan
<input checked="" type="checkbox"/>	0006	ES-TRD082276	00762	Original	Metro Colors Cobalt
<input checked="" type="checkbox"/>	0007	ES-TRD082277	00761	Original	Metro Colors Indigo
<input checked="" type="checkbox"/>	0008	ES-TRD082278	00760	Original	Metro Colors Violet
<input checked="" type="checkbox"/>	0009	ES-TRD082279	00759	Original	Metro Colors Pink
<input checked="" type="checkbox"/>	0010	ES-TRD082280	00758	Original	Metro Colors Magenta
<input checked="" type="checkbox"/>	0011	ES-TRD082281	00757	Original	Metro Colors Crimson
<input checked="" type="checkbox"/>	0012	test	01023	Original	Madeira Classic Rayon [Rayon]

List of registered thread.
Double-clicking can change thread information.



Send the database information to connected embroidery machine (Send), then close dialog box.

Delete button (Delete selected line)

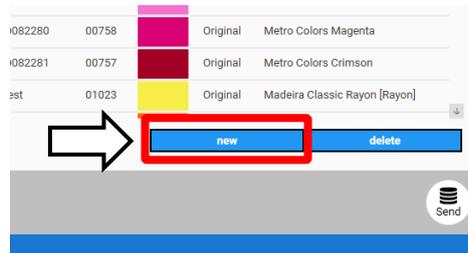
Add thread information.

Each thread information can be set to embroidery data when check the each checkbox.

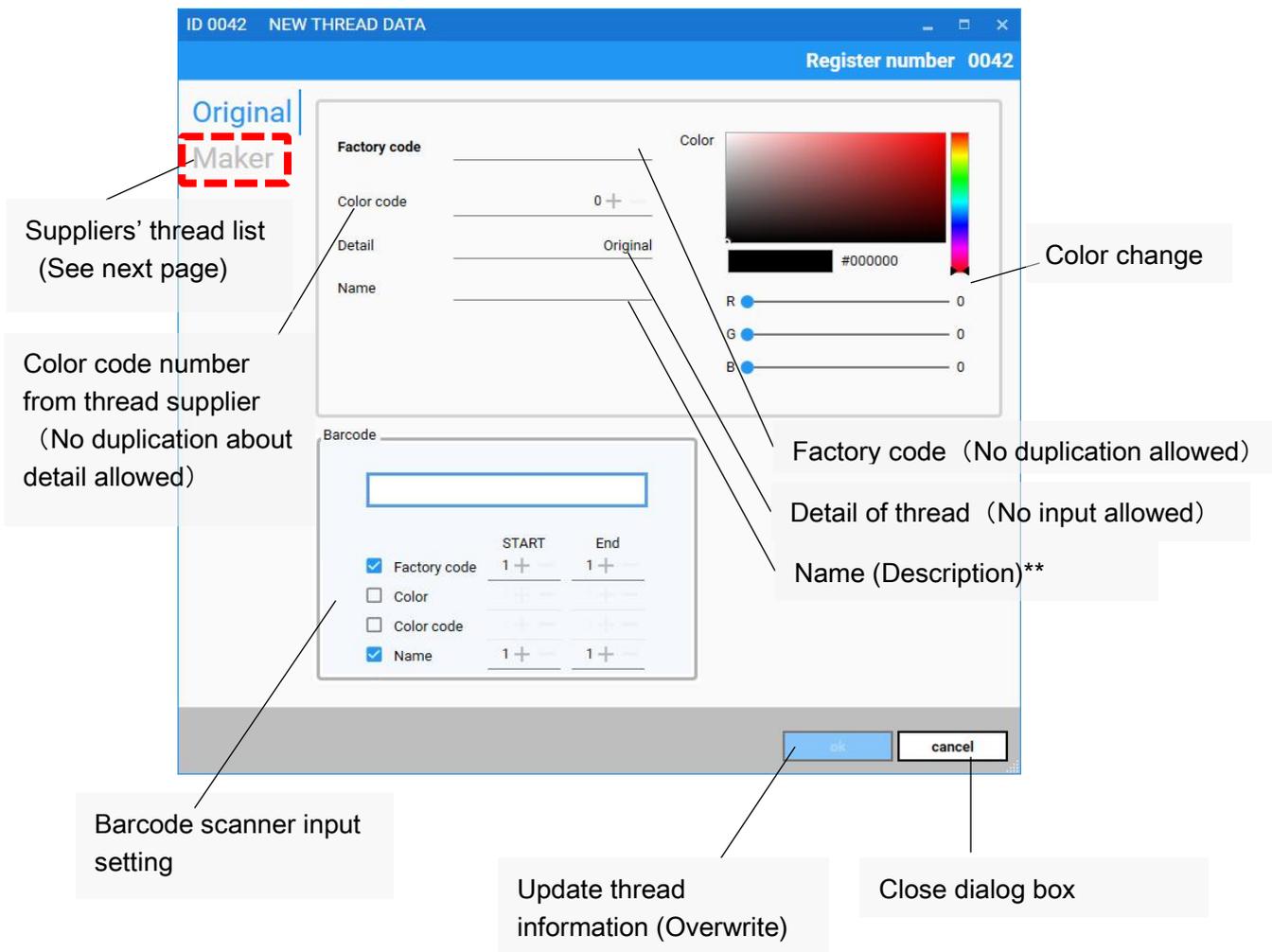
Registering thread information

Additional thread information can be registered from “New” button.

1. Please select “New”.



2. The new dialog box for color entry appears. “Color”, “Color number from thread supplier”, “Detail of thread”, “Name of thread (Description)”and “Factory code” can be registered in optional selections.

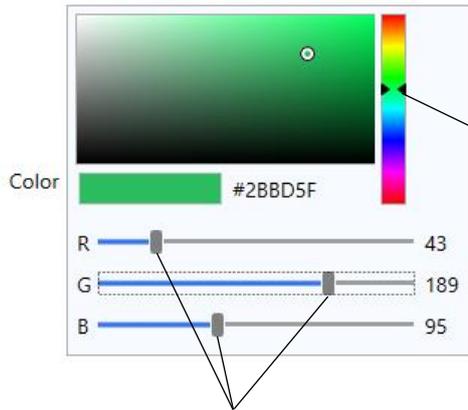


* Color code…Range : 1~65535

** Name…Half-width alphanumeric only. No limit of number of letters.

*** Factory code…Half-width alphanumeric only. Up to 16 letters.

Color change



Required color can be selected if you click your required color portion.

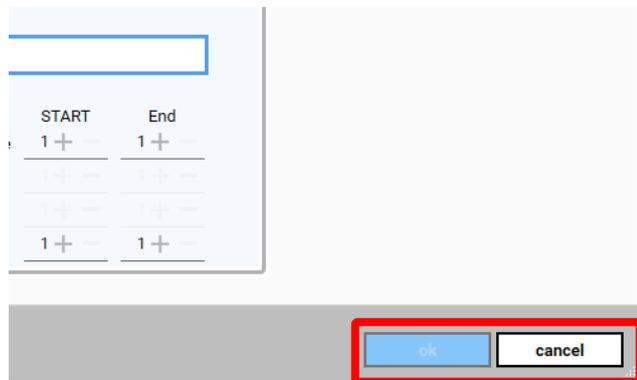
Required color can be selected by scrolling up and down.

Required color can be selected by scrolling from side to side.

3. Please close the screen.

If "OK" is selected, input data will be updated and saved in database. Then, the screen will close.

If "Cancel" is selected, input data will not be updated and saved in database. Then, the screen 「Cancel」 will close. ("OK" will not be allowed to be selected until required information is input.)



Bar-code input

Database relating to threads will be created by means of a bar-code scanner.

The screenshot shows a 'Barcode' input window. At the top is a large empty rectangular box. Below it is a table with four rows of checkboxes and two columns of numeric input fields labeled 'START' and 'End'. Each input field contains the number '1' and a '+' sign. Callout lines point from the text labels on the right to the corresponding elements in the interface.

	START	End
<input checked="" type="checkbox"/> Factory code	1 +	1 +
<input type="checkbox"/> Color	1 +	1 +
<input type="checkbox"/> Color code	1 +	1 +
<input checked="" type="checkbox"/> Name	1 +	1 +

Item to be input by a bar-code scanner

"Factory Code" input (Up to 16 letters)

"Color" input (Up to 5 digit numbers)

"Color code" input
(Up to the number 4294967295)

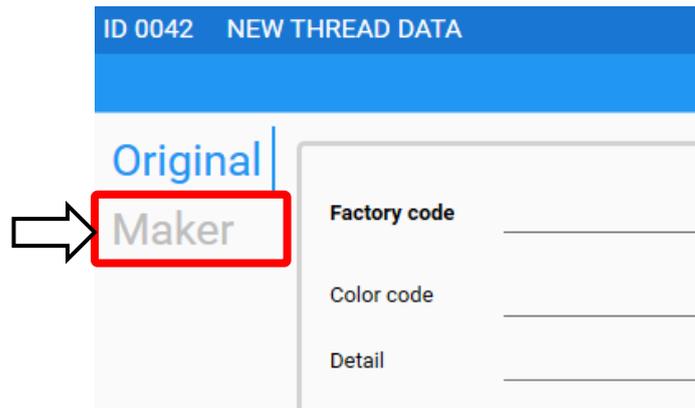
"Name" input

Please put a check mark in an individual check box and specify an initial number and a last number.

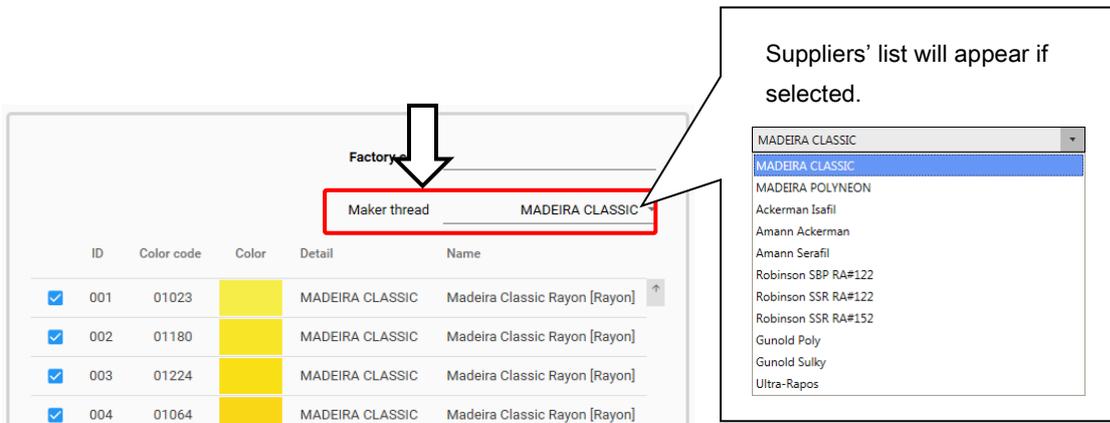
Please go to the above "Item to be input by a bar-code scanner". Then, bar-code data will automatically be input once a bar-code is scanned.

Thread information can be registered, referring to thread lists of suppliers. This registration will be added to “Original”.

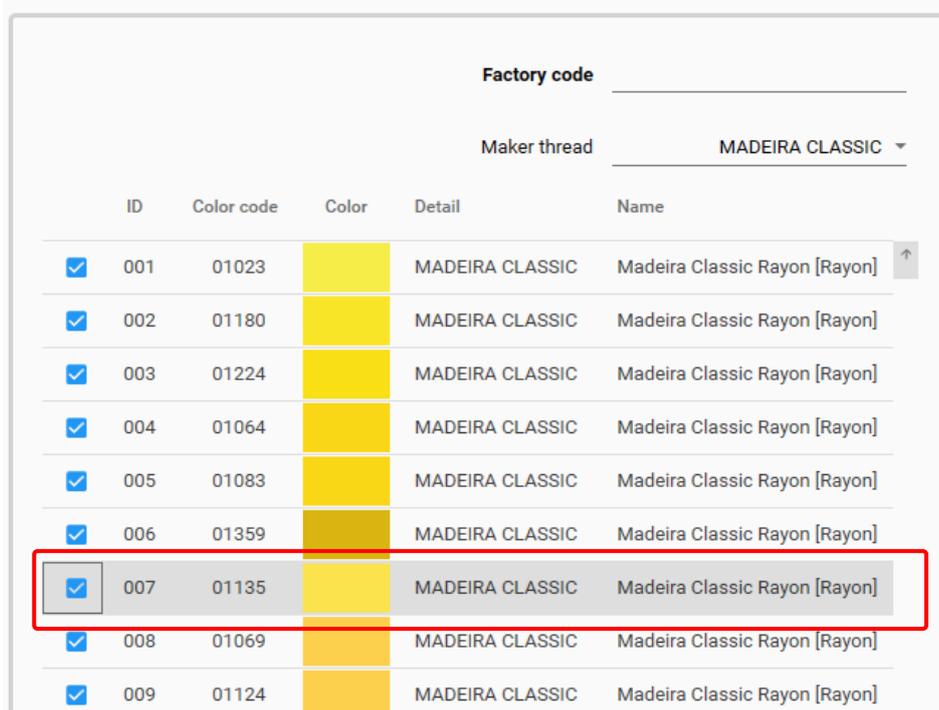
1. Please select “Maker”.



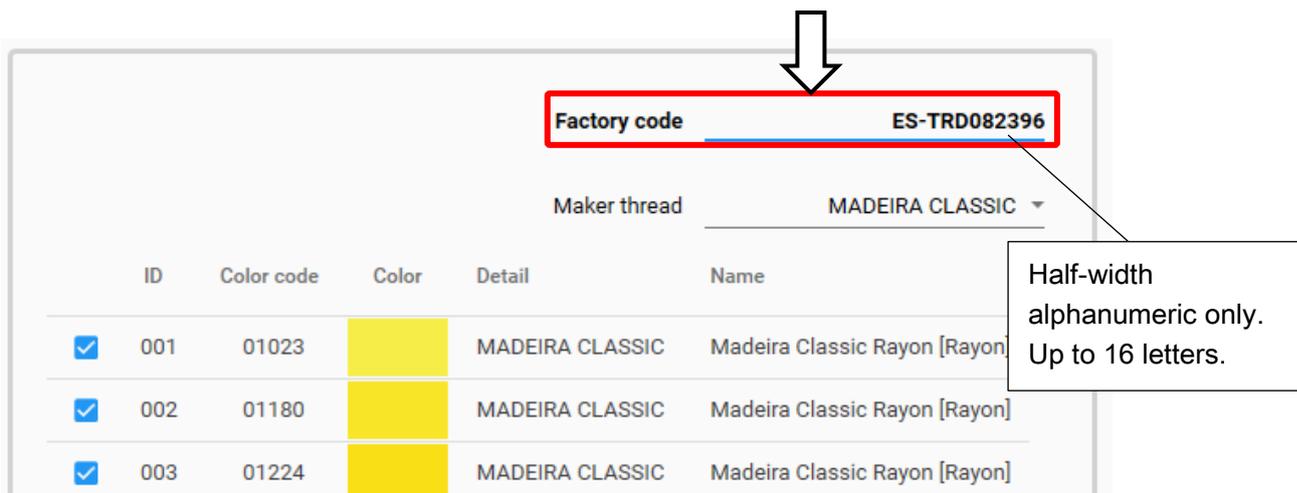
2. Please select “Maker thread”.



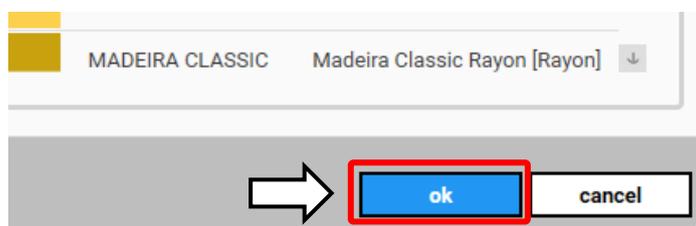
3. Please select thread information which you would like to register.



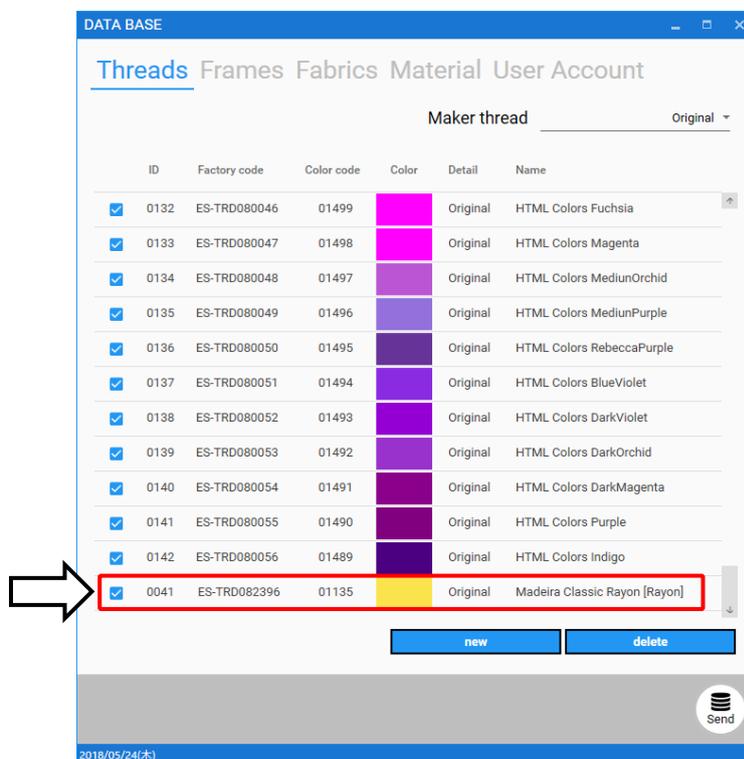
4. Please input "Factory code".



5. Please select "OK".



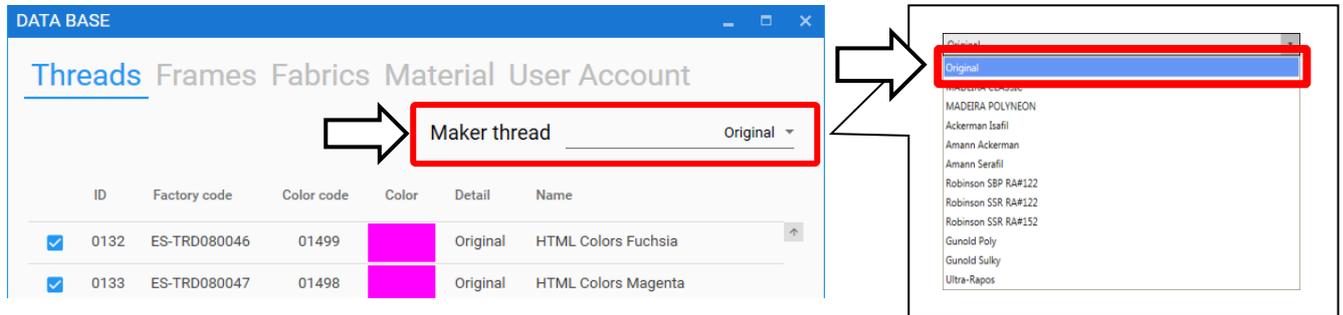
6. Thread information to be newly registered will be added.



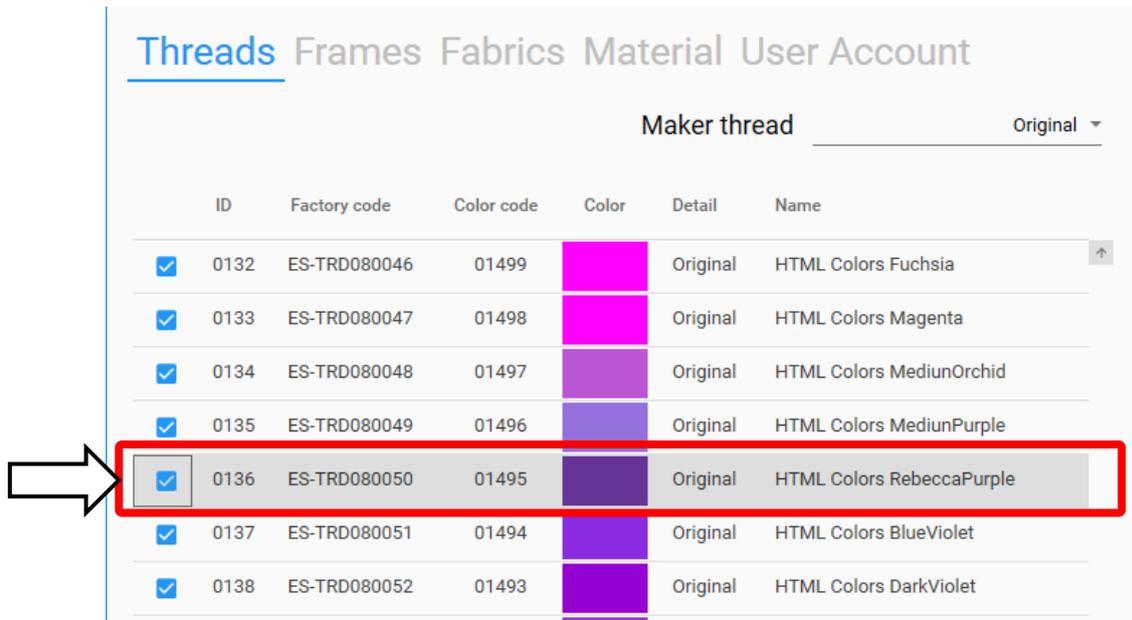
Change in thread information (Original)

Original thread information to be saved in database can be changed.

1. Please select "Maker thread", and then select "Original" in the list.



2. Please double-click thread information which you would like to change.



3. Warning message will appear. Please select "OK".

Note: Previously used thread may not be reflected if any embroidery is made by using the thread.



4. Item which you would like to change can be changed. Please select “OK” after change is done.

Note: Thread data may not be reflected to registered design data if you edit (change) “Color code” and “Factory code”. Please pay attention in editing (changing).

Original Maker

Factory code ES-TRD080050

Color code 1495 + -

Detail Original

Name HTML Colors RebeccaPurple

Color #663399

R 102

G 51

B 153

Barcode

	START	End
<input checked="" type="checkbox"/> Factory code	1 + -	1 + -
<input type="checkbox"/> Color	+ -	+ -
<input type="checkbox"/> Color code	+ -	+ -
<input checked="" type="checkbox"/> Name	1 + -	1 + -

ok cancel

No change about "Detail" allowed

Color code...Range : 1~65535

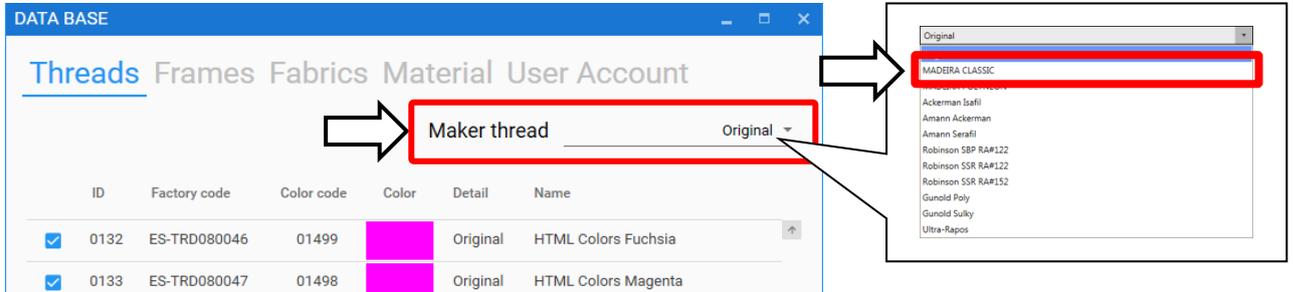
Name...Half-width alphanumeric only. No limit of number of letter.

Factory code...Half-width alphanumeric only. Up to 16 letters.

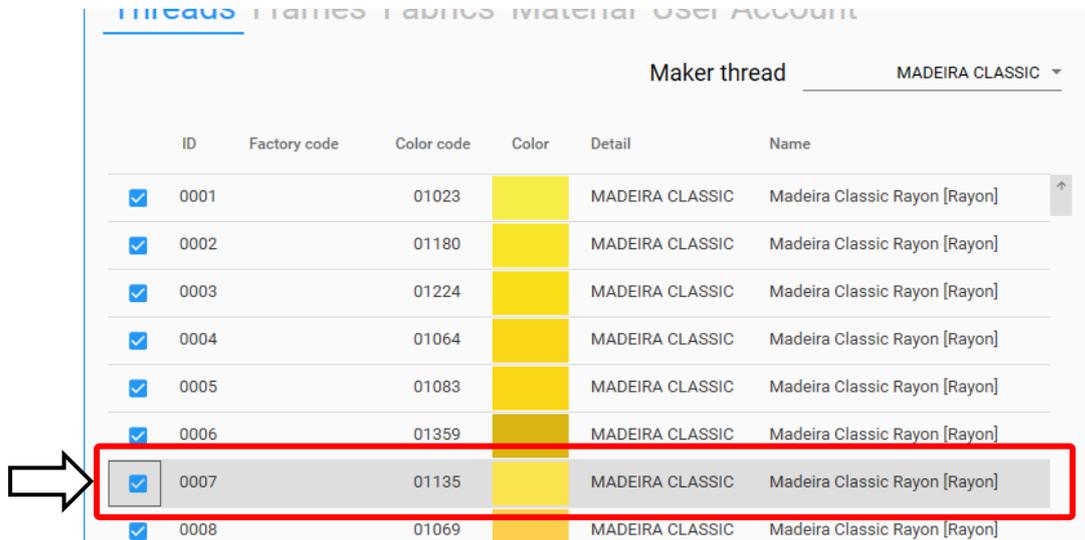
Change in thread information (Except for “Original”)

Thread information, except for “Original” to be saved in database can be changed.
 “Factory code” only can be changed.

1. Please select the triangle in “Maker thread”, and then select your required supplier.



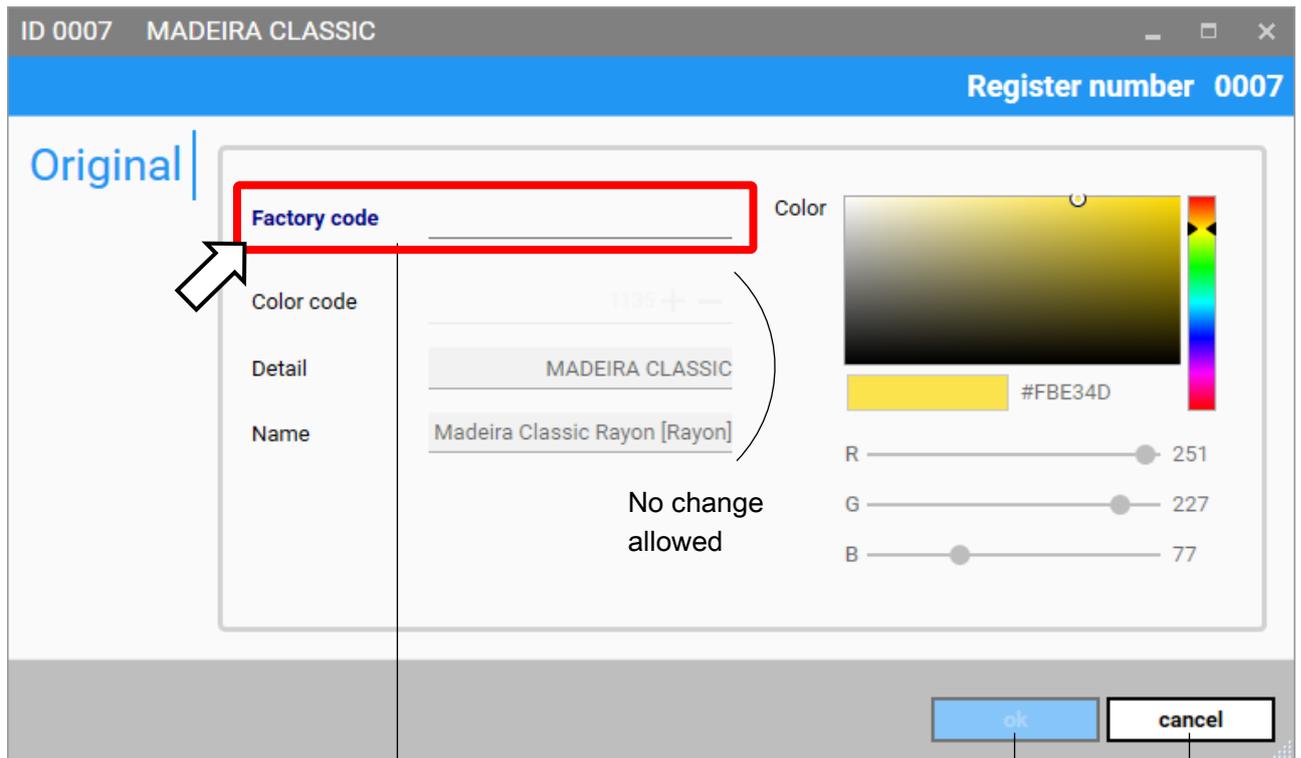
2. Please double-click thread information which you would like to change.



3. Warning message will appear. Please select “OK”.
 Note: “Factory code” only works for edition of supplier’s thread.



4. "Factory code" can be changed. Please select "OK" after change is done.



Control number (No duplication allowed) Half-width alphanumeric only. Up to 16 letters.

Overwrite to close the screen

Cancel to close the screen.

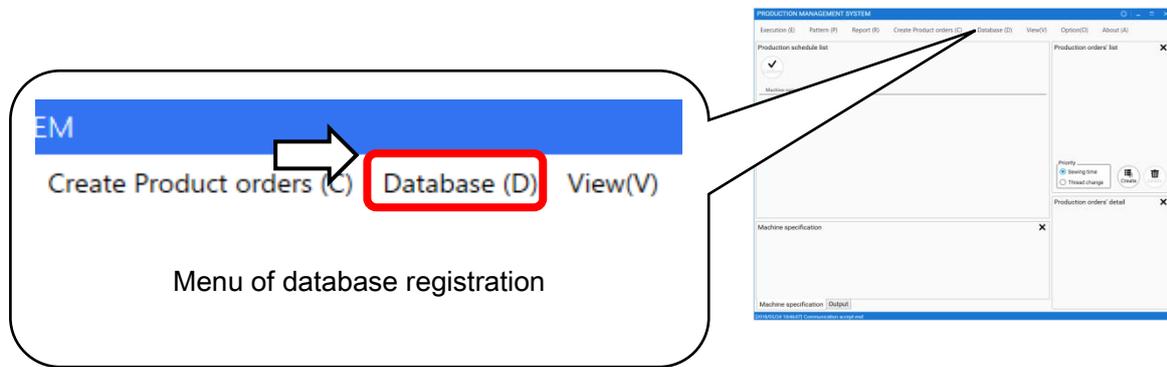
Frame

(This information is to be used in Step 6 Registering production order.)

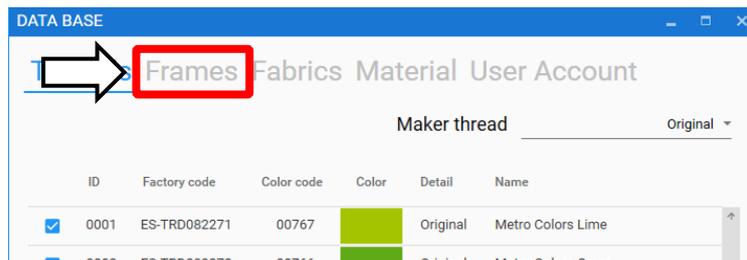
Default frame data can't be changed nor deleted.

For production order with default frame data, embroidery machines will change the frame automatically. (only matching frame)

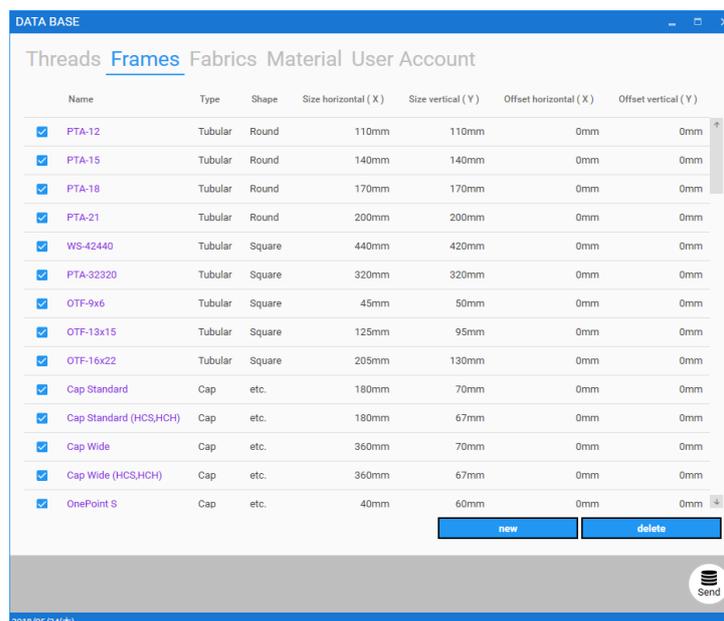
1. Please select "Database" to let database registration screen appear.



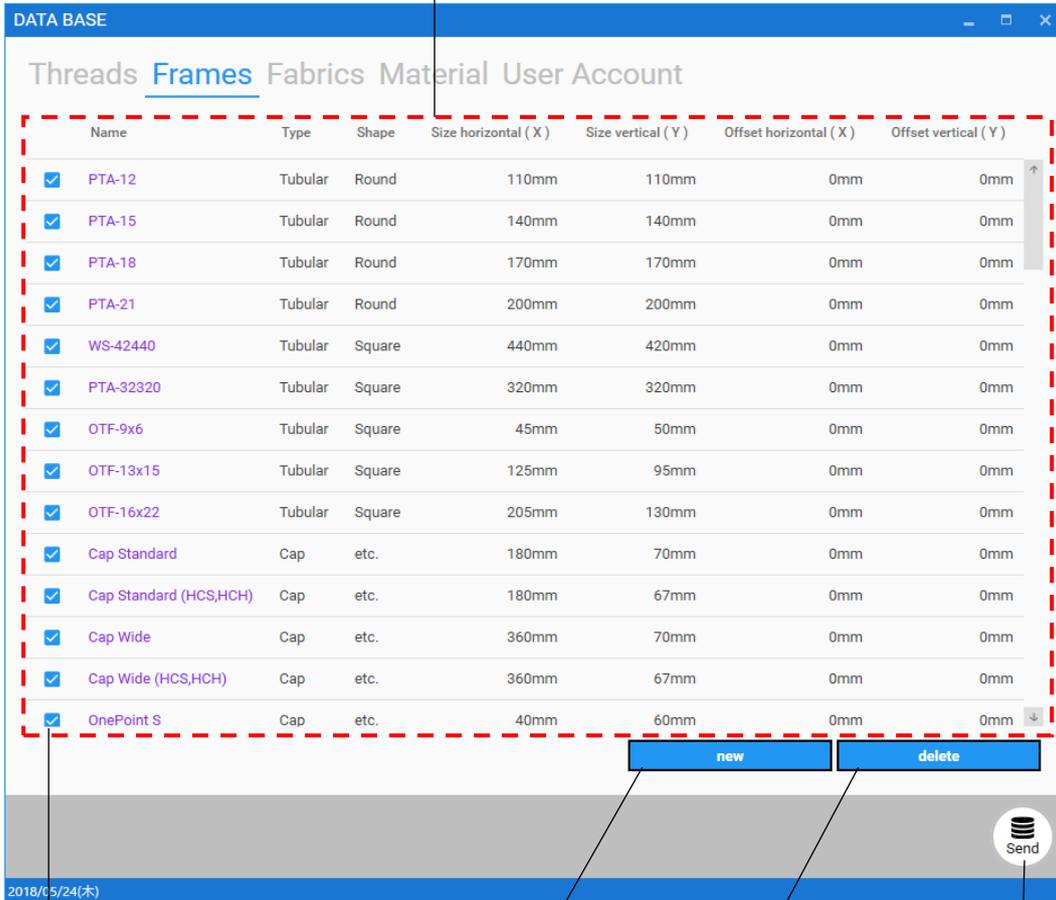
2. Thread database screen will appear. Please select "Frame".



3. Frame database screen will appear.



List of registered frame.
 Double-clicking can change frame information.



Each frame information can be set to embroidery data when check the each checkbox.

Add frame information (one item)

Delete button (Delete selected line)

Send the database information to connected embroidery machine (Send), then close dialog box.

Default frame will appear in purple.

<input checked="" type="checkbox"/>	Name	Type	Shape	Size horizontal (X)	Size vertical (Y)
<input checked="" type="checkbox"/>	Border/Alternate (HFR 600x1200)	Border	etc.	1,200mm	600mm
<input checked="" type="checkbox"/>	Border/Alternate (HFR 400x1200)	Border	etc.	1,200mm	400mm
<input checked="" type="checkbox"/>	Border/Alternate (HFR 300x1200)	Border	etc.	1,200mm	300mm
<input checked="" type="checkbox"/>	KTA-2 SOCK	etc.	etc.	60mm	80mm
<input checked="" type="checkbox"/>	EMS SLIM LINE-1 6x5	Clamp	Square	150mm	130mm
<input checked="" type="checkbox"/>	EMS SLIM LINE-1 5x3	Clamp	Square	130mm	76mm
<input checked="" type="checkbox"/>	EMS SLIM LINE-1 4x4	Clamp	Square	100mm	100mm

Default frame (Standard frame of HappyJapan)

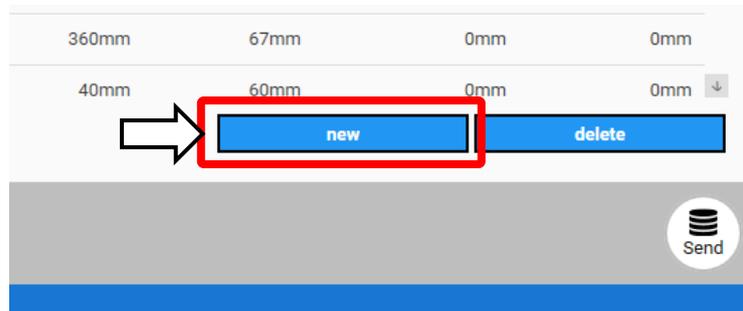
Frame which is not default frame

Registering embroidery frame

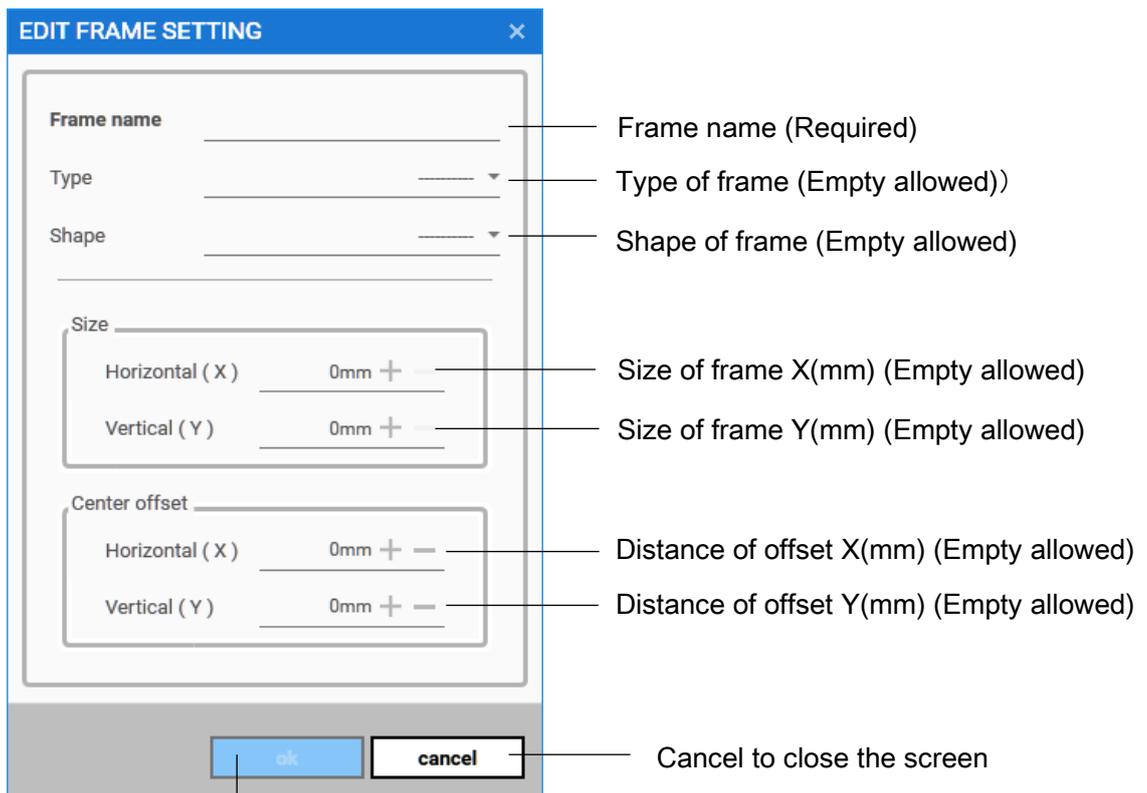
Frame to be used at customer’s plant can be registered by Happy PMS.

When newly added frame information is defined in production order, embroidery machine will not update setting of frame automatically.

1. Press “New” button.



2. A dialog box to for additions appears.



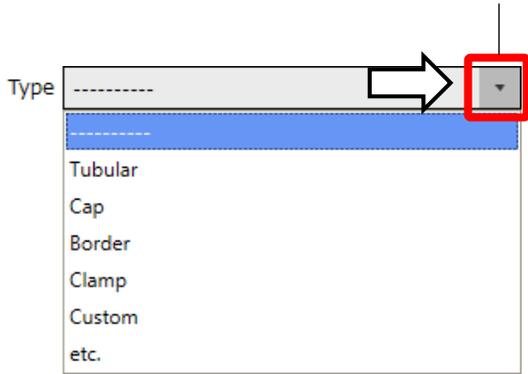
Add registered frame information and close the screen. (1 item)

* Frame name...Half-width alphanumeric only. Up to 32 letters.

** X/Y(mm)...Range : 0mm through 10000mm

Type

Frames will appear if selected.



Items	Description
-----	Not selected
Tubular	Tubular frame
Cap	Cap frame
Border	Border frame
Clamp	Clamp frame
Custom	Custom frame
etc.	Other frame

Shape

Shapes will appear if selected.



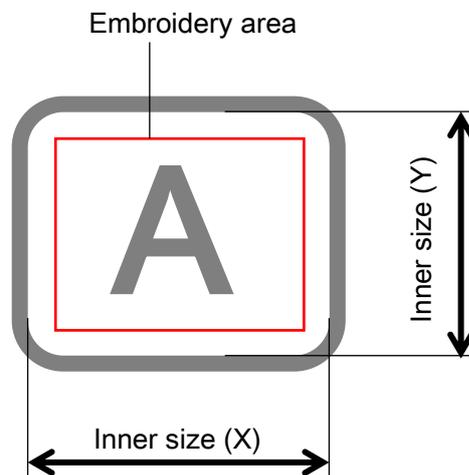
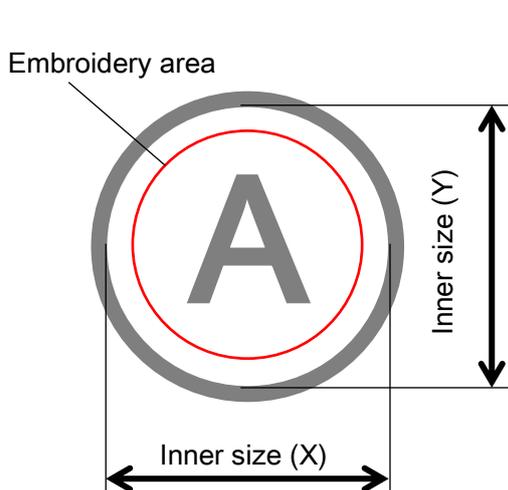
Item	
-----	Not selected
Round	Round frame
Square	Square frame
etc.	Other frame

Size



Round frame

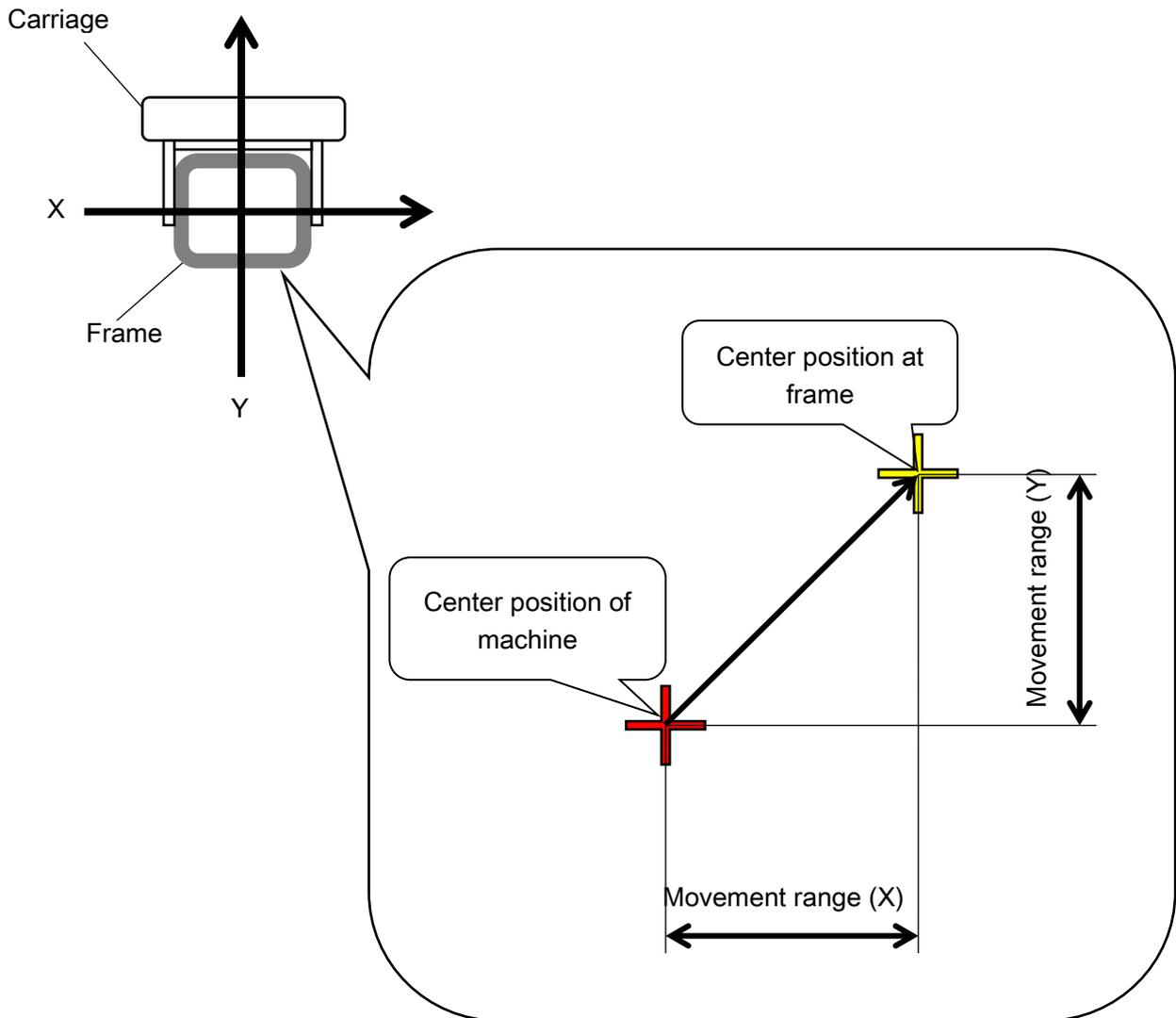
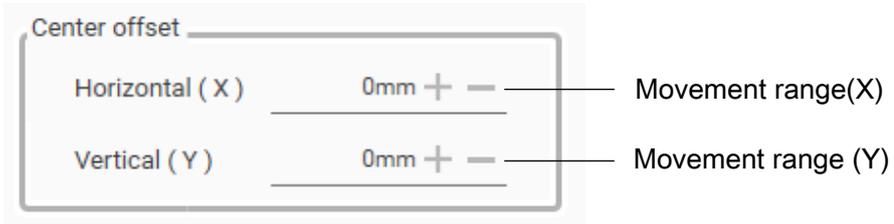
Square frame



Center offset

The center of a frame can be set.

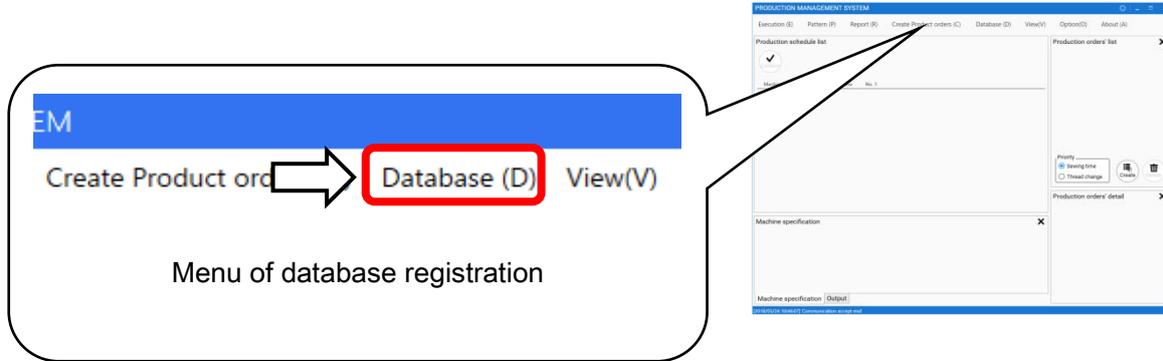
Movement range from the center of a machine to the center of a frame will be input. The Center of a machine will corresponds to a location by executing “Center” at “Frame move” in operation screen.



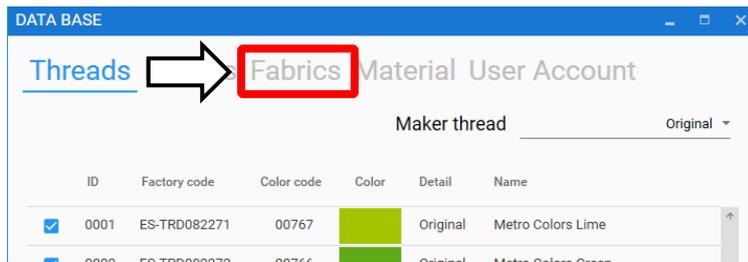
Fabric

(This information is to be used in Step 6 Registering production order.)
 To make the fabric data in database for Production order.

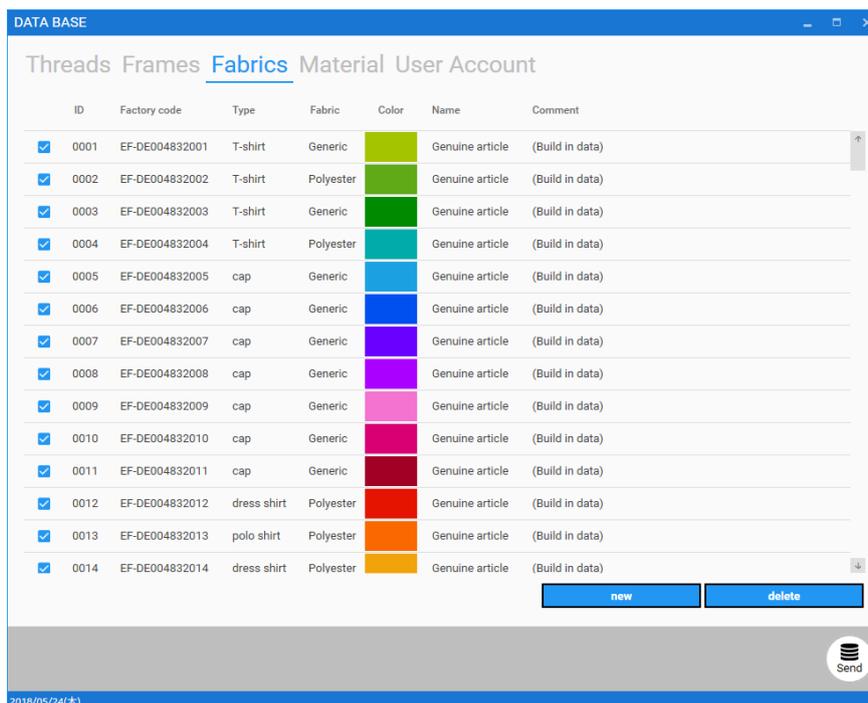
1. Please select “Database” to let database registration display appear.



2. Thread database display will appear. Please select “Fabrics”.



3. Fabrics database display will appear.



List of registered Fabric.
 Double-clicking can change fabric information.

ID	Factory code	Type	Fabric	Color	Name	Comment
<input checked="" type="checkbox"/>	0001	EF-DE004832001	T-shirt	Generic	Light Green	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0002	EF-DE004832002	T-shirt	Polyester	Dark Green	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0003	EF-DE004832003	T-shirt	Generic	Green	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0004	EF-DE004832004	T-shirt	Polyester	Teal	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0005	EF-DE004832005	cap	Generic	Light Blue	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0006	EF-DE004832006	cap	Generic	Blue	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0007	EF-DE004832007	cap	Generic	Purple	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0008	EF-DE004832008	cap	Generic	Magenta	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0009	EF-DE004832009	cap	Generic	Pink	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0010	EF-DE004832010	cap	Generic	Red-Pink	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0011	EF-DE004832011	cap	Generic	Dark Red	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0012	EF-DE004832012	dress shirt	Polyester	Red	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0013	EF-DE004832013	polo shirt	Polyester	Orange	Genuine article (Build in data)
<input checked="" type="checkbox"/>	0014	EF-DE004832014	dress shirt	Polyester	Yellow-Orange	Genuine article (Build in data)

Each fabric information can be set to embroidery data when check the each checkbox.

Add fabric information (one item)

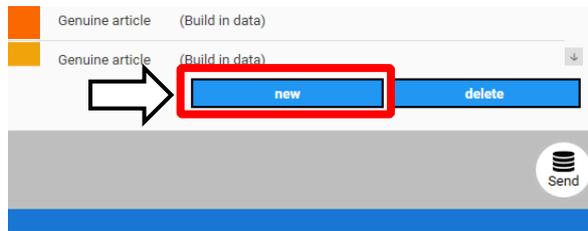
Send the database information to connected embroidery machine (Send), then close dialog box.

Delete fabric information (one item)

Registering fabric

Please register your own material.

1. Please select "new".



2. Registration form will appear.

EDIT FABRIC SETTING ×

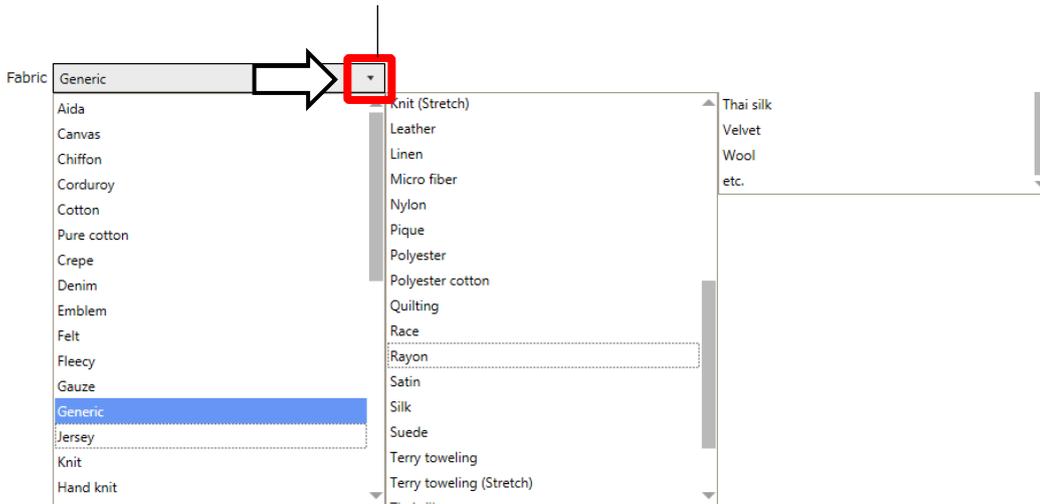
Register number 0221

- Factory code _____ Code name of fabric (Required)
- Type _____ Material (Non-input allowed)**
- Fabric _____ Generic Material of fabric (Non-input allowed)
- Name _____ Material name (Non-input allowed)***
- Color: #000000 (R: 0, G: 0, B: 0)
- Comment _____ Comment about fabric (Non-input allowed)****
- ok / cancel Close dialog box

Add fabric information (one item)

- * Factory code...Half-width alphanumeric only. Up to 16 letters.
- ** Type...Half-width alphanumeric only. Up to 16 letters.
- *** Name...Half-width alphanumeric only. Up to 32 letters.
- **** Comment...Half-width alphanumeric only. Up to 32 letters.

Fabric list will appear once it is selected.



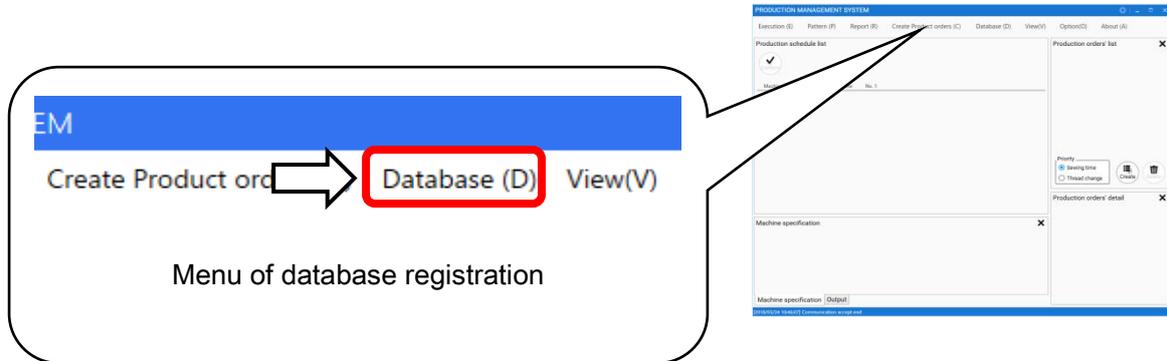
Indication	
Aida	Micro fiber
Canvas	Nylon
Chiffon	Pique
Corduroy	Polyester
Cotton	Polyester cotton
Pure cotton	Quilting
Crepe	Race
Denim	Rayon
Emblem	Satin
Felt	Silk
Fleecy	Suede
Gauze	Terry toweling
Generic	Terry toweling(Stretch)
Jersey	Thai silk
Knit	Velvet
Hand knit	Wool
Knit (Stretch)	etc. (Other fabrics)
Leather	
Linen	

Material

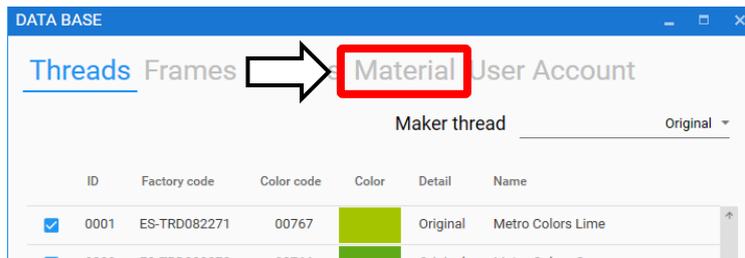
(This information is to be used in Step 6 Registering production order.)

Data to select a secondary material to be used in production order will be created.

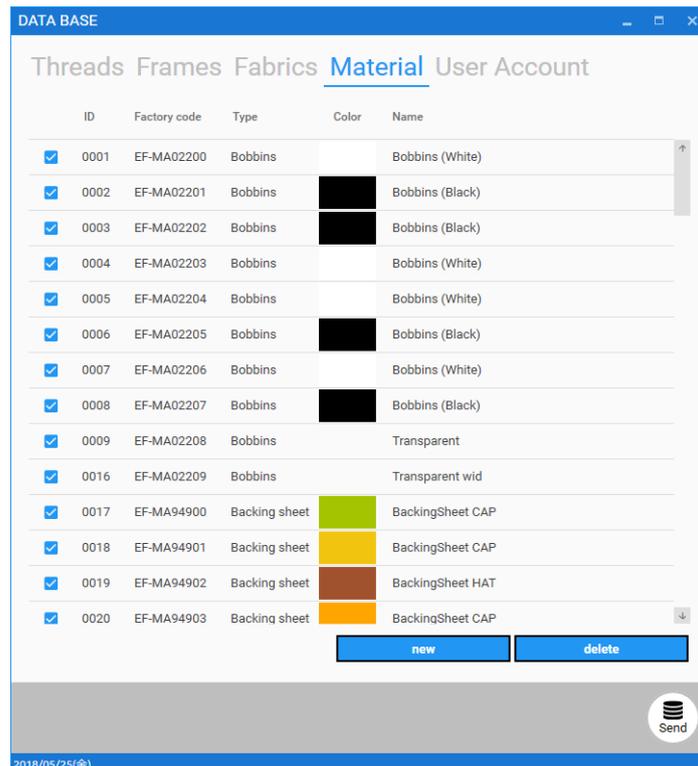
1. Please select "Database". Database registration screen will appear.



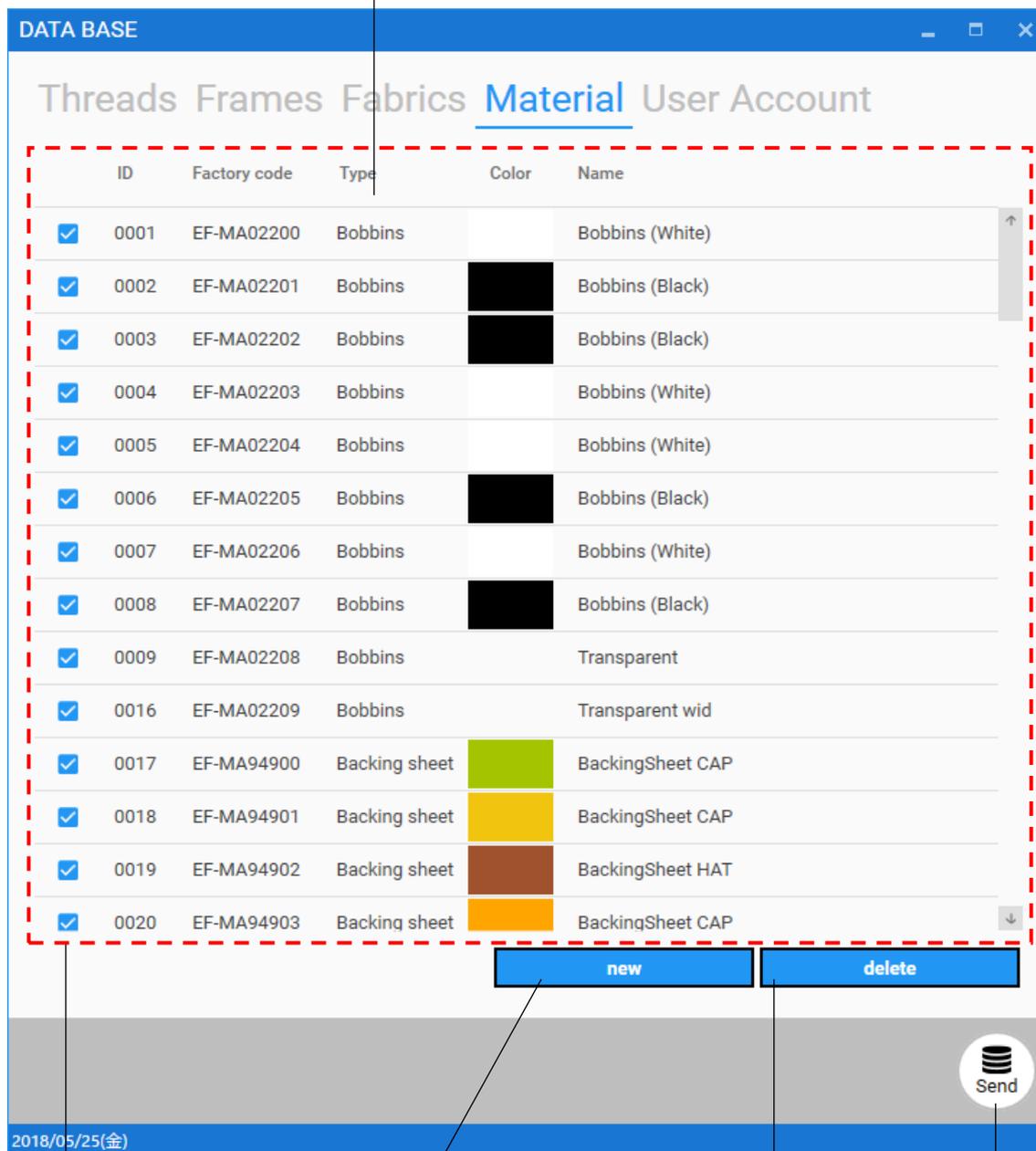
2. Thread database screen will appear. Please select "Material".



3. Secondary material database screen will appear.



List of registered Material.
 Double-clicking can change fabric information.



Add fabric information
(one item)

Send the database
 information to connected
 embroidery machine
 (Send), then close dialog
 box.

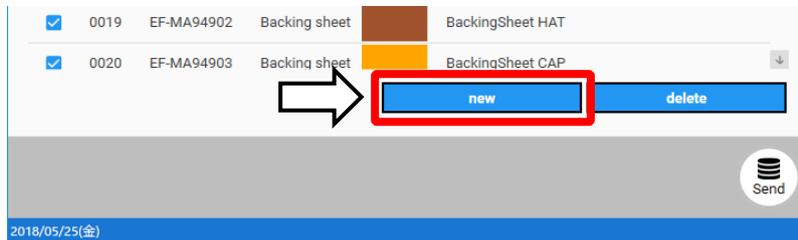
Delete fabric information
(one item)

Each fabric information can be set to embroidery data when check the each checkbox.

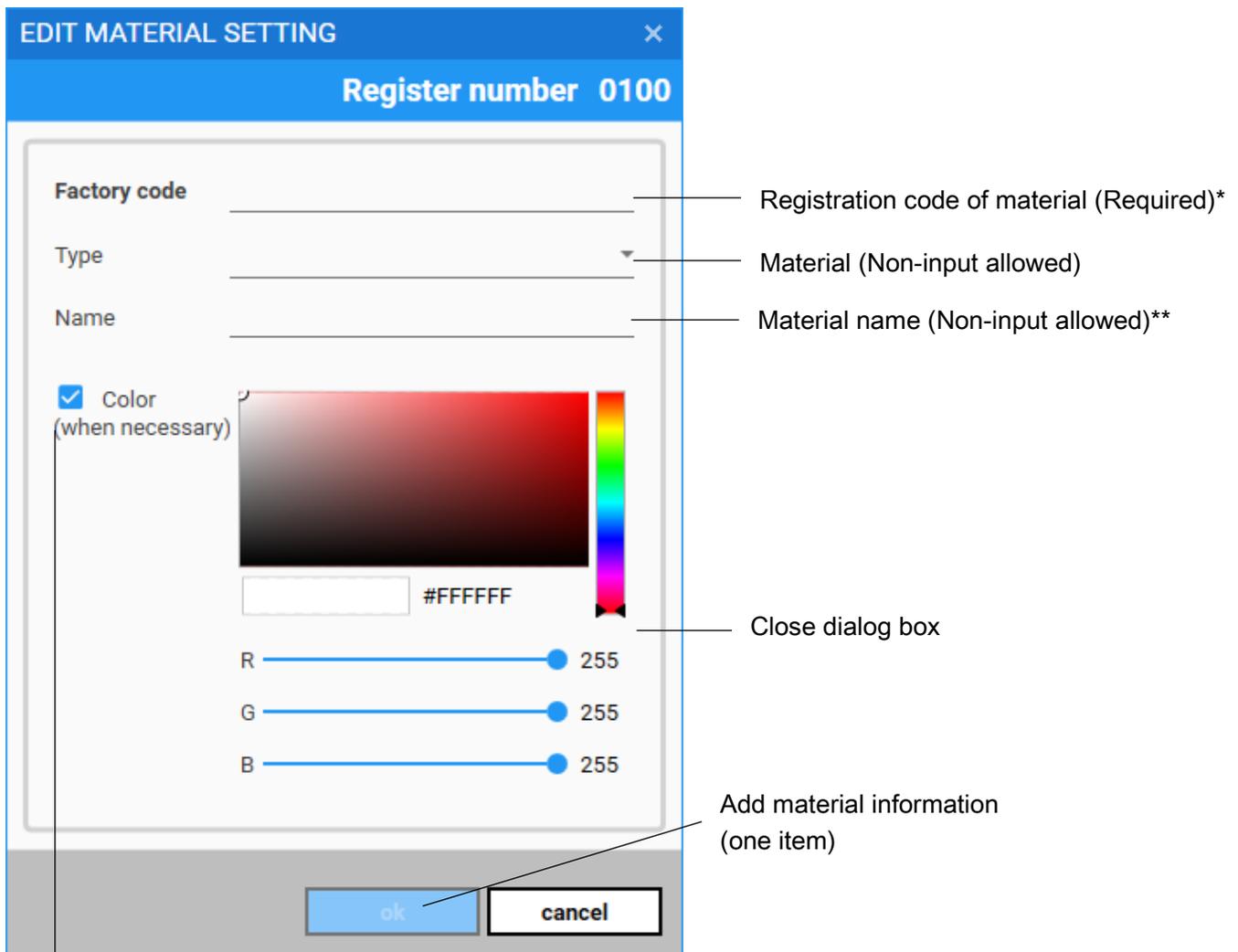
Registering material

Please register your own secondary material via Happy PMS.

1. Please select "new".



2. Registration form will appear.



Check mark can be deleted. Color will not be reflected once check mark is deleted.

* Factory code...Half-width alphanumeric only. Up to 16 letters.

** Name...Half-width alphanumeric only. Up to 32 letters.

Type list will appear if it is selected.

Type

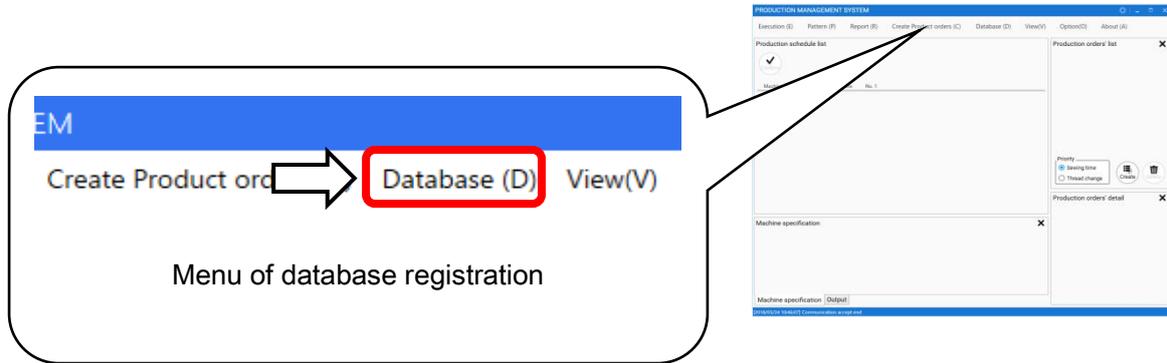
Indication	Indication
Bobbins	Bobbins
Backing sheet	Backing sheet
Topping sheet	Topping sheet
Needles	Needles
Ribbon	Ribbon
Sequin	Sequin
Cord	Cord
Adhesive	Adhesive
Transfer film	Transfer film
etc.	Adhesive

Transfer film
etc. (Other secondary materials)

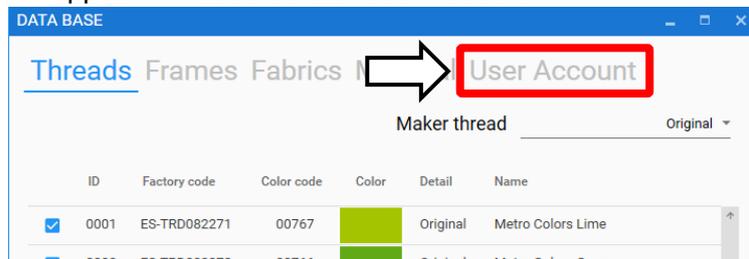
Indication
Bobbins
Backing sheet
Topping sheet
Needles
Ribbon
Sequin
Cord
Adhesive
Transfer film
etc. (Other secondary materials)

User Account

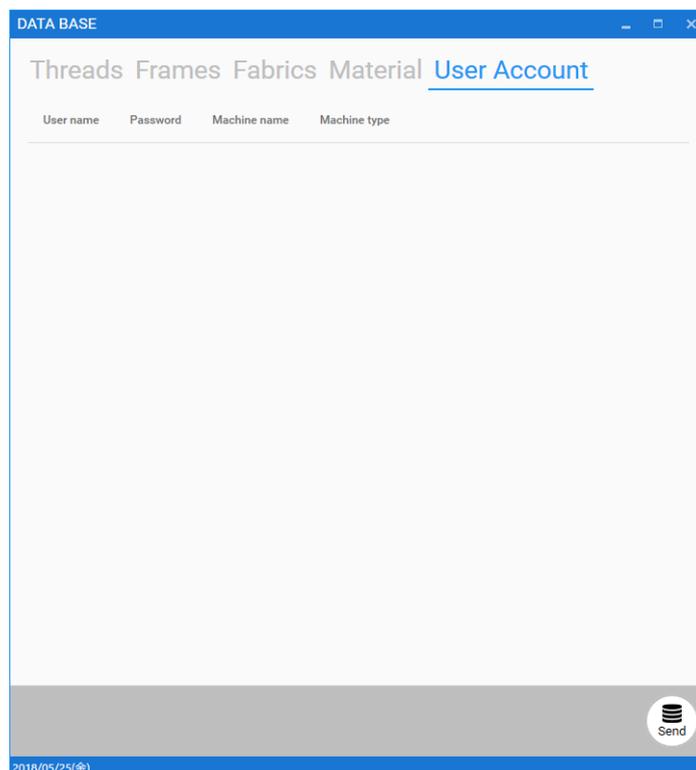
User information on an embroidery machine to be communicated will appear. Please select “Database”. Database register screen will appear.



4. Database screen will appear. Please select “User Account”.



5. Secondary database screen will appear.



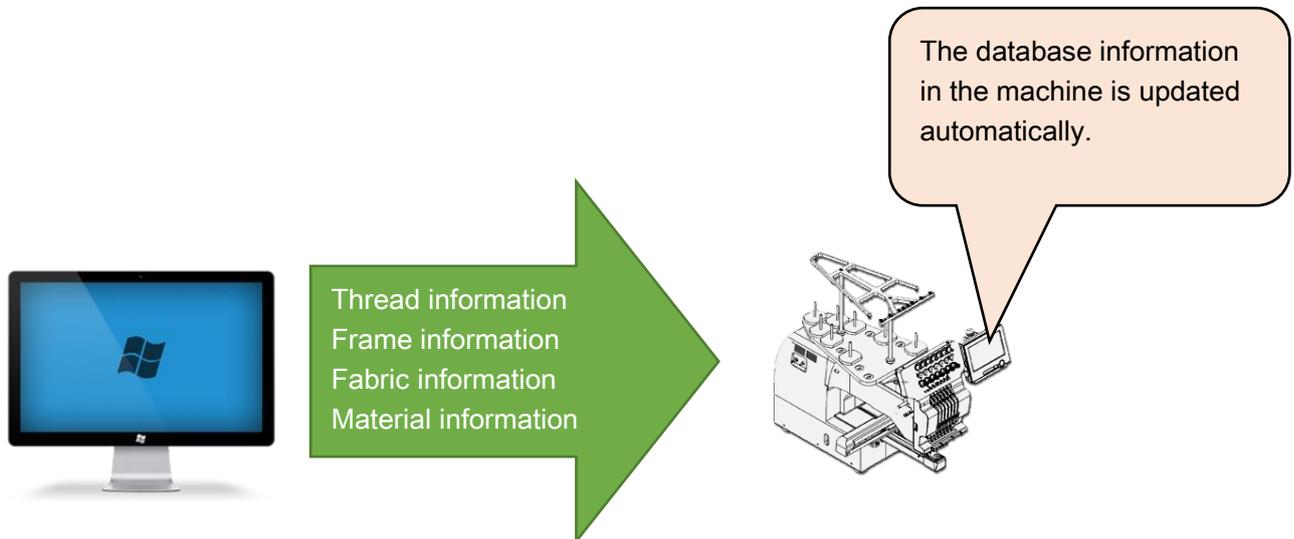
Here is user information on an embroidery machine to be communicated with Happy PMS.
Display or non-display of "Password" will be selectable by setting.

User name	Password	Machine name	Machine type
Owner	*****	DEMO-9M2443	HCH
AAA	*****	DEMO-9M2443	HCH
BBB	*****	DEMO-9M2443	HCH
CCC	*****	DEMO-9M2443	HCH

2018/05/25(金)

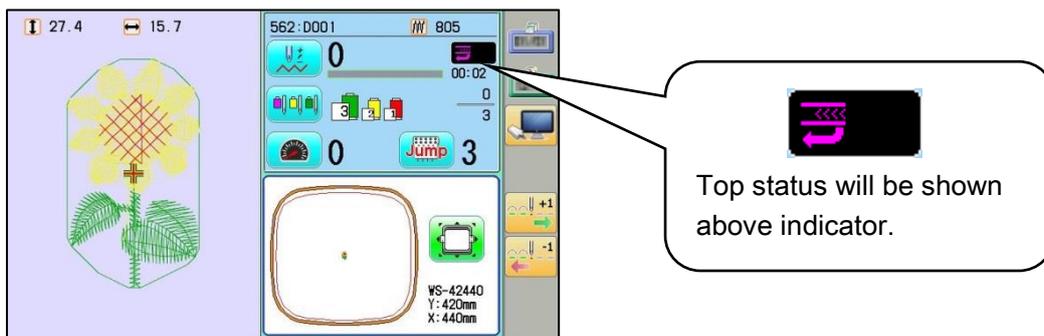
Step 2 Updating database information

Once database registration (Step 1) completes, data will be sent to an embroidery machine. Data relating to thread, frame, material and secondary material will be sent to the machine. The data will be sent to all of machines to be communicated with Happy PMS.



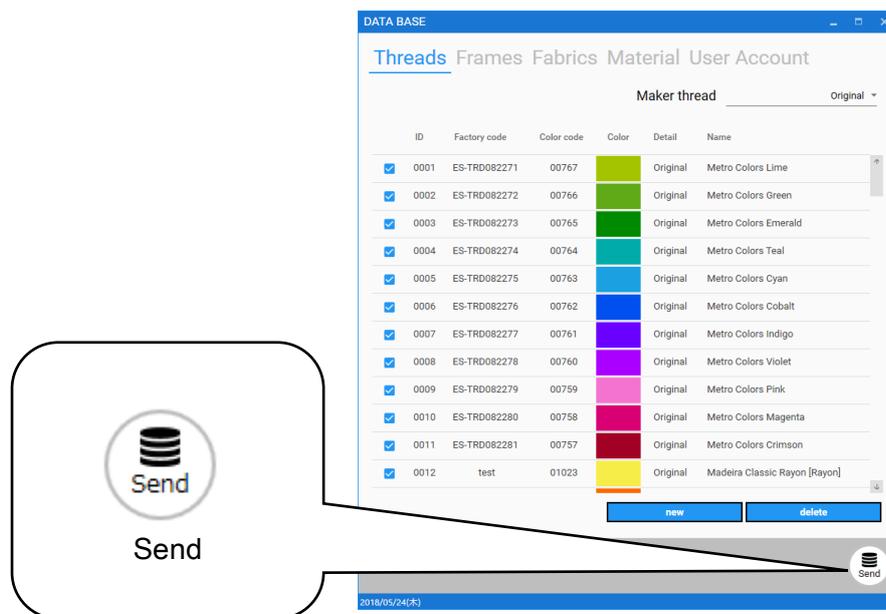
Note the following when the information list is transmitted.

- Embroidery machine is Drive mode.
- Design data status is "Top".

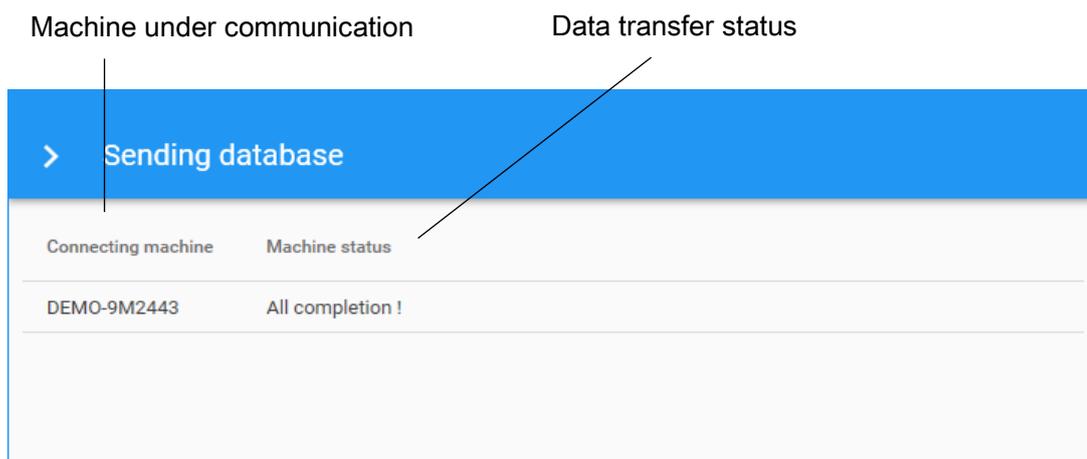


Drive mode

1. Please push “Send” in any of database registration screens.



2. Sending database will appear.



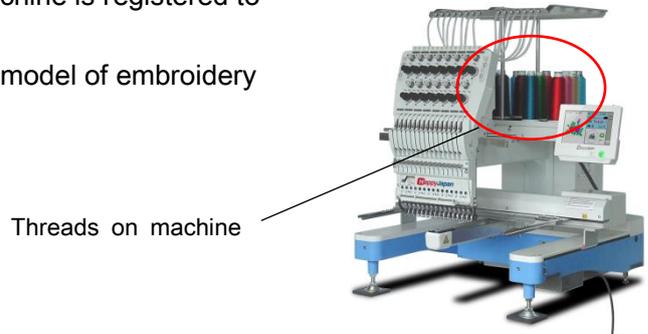
Indication	Meaning
Waiting ...	Connecting
All completion!	All has been updated.
The embroidery machine is in operation or work instruction is being executed	Machine is in operation, or production order is being executed.

Communication will not be available except for “All completion!”. Please check a machine status and update again.

Step 3 Registering thread information with each needle number

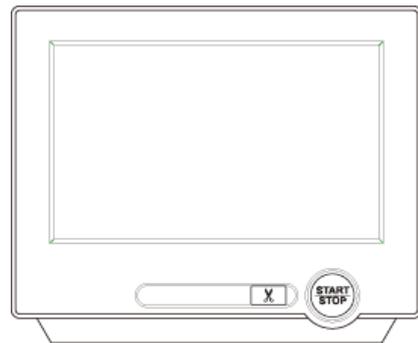
Thread information which is allocated embroidery machine is registered to each needle number - an example case of HCD2.

Numbers of needle bar are varied, depending on the model of embroidery machines.



1. At first, select "THREAD SET" from the menu of the embroidery machine.

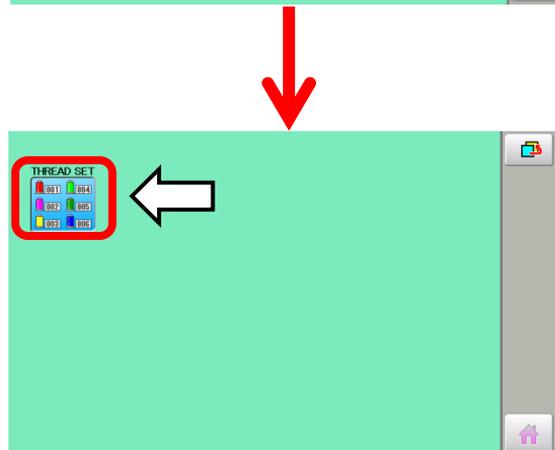
In case of 7 inch LCD module:



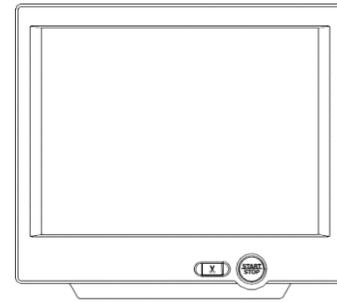
To open the next page, press the menu switching button on the right side of the screen.



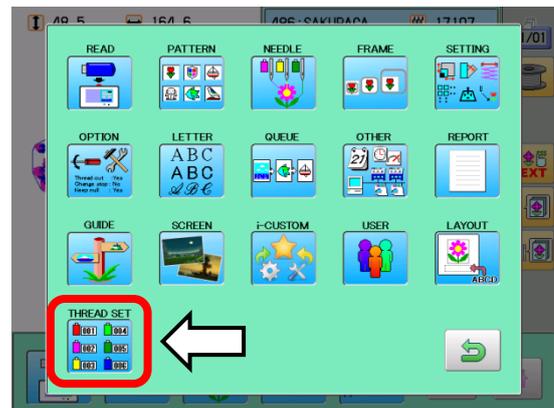
Select "THREAD SET".



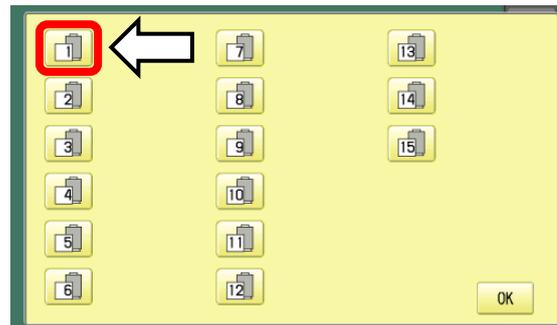
In case of 10.4 inch LCD module:



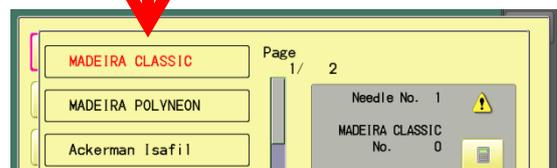
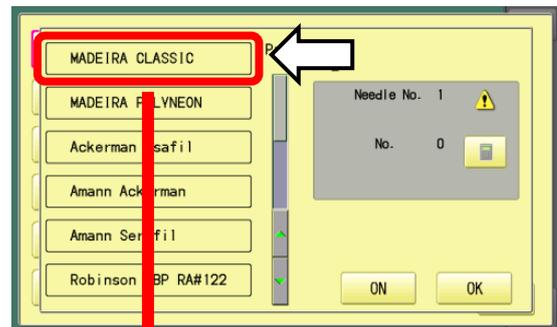
Select "THREAD SET" from the menu of the embroidery machine.



- Assign thread ID number from database to each needle number of the embroidery machine. e.g. 1 to 15.
Thread selection display will appear.
Thread database needs to be set in advance.

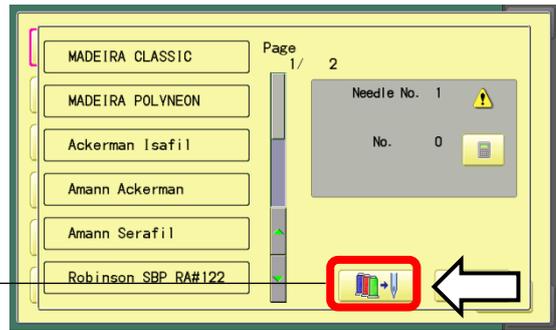


- Please select thread supplier.
Thread maker name that is selected is changed red.

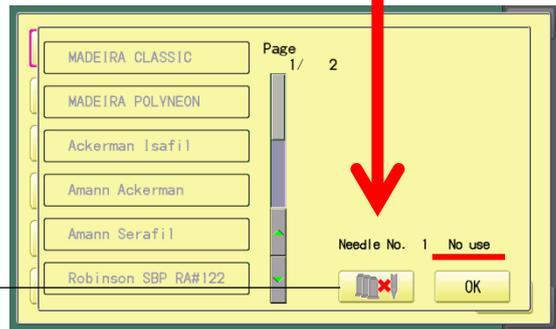


Please select "ON" if a thread is not desired to be set to a selected needle bar. Then, it becomes off. After that, "No use" will appear.

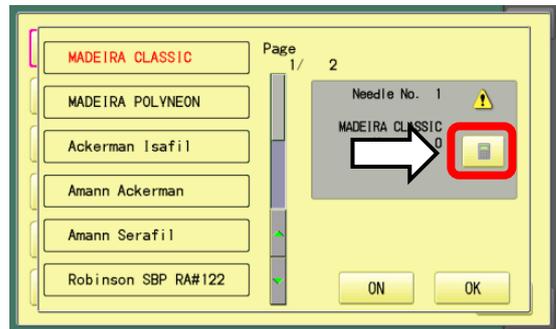
ON



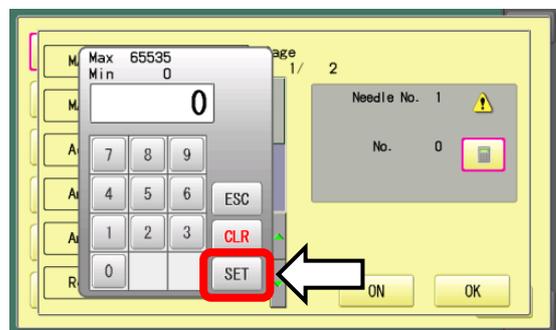
OFF
(No use)



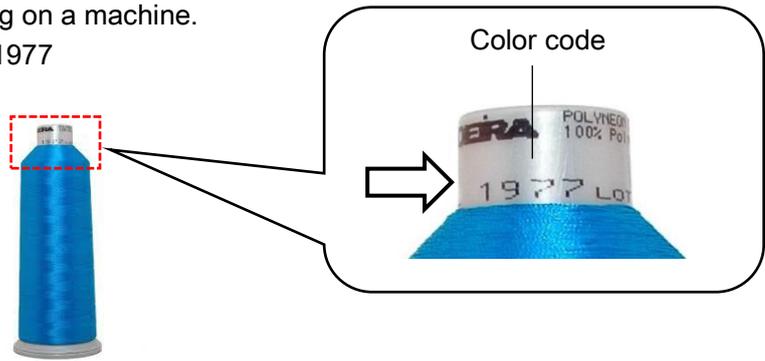
4. Please select "value input" button.



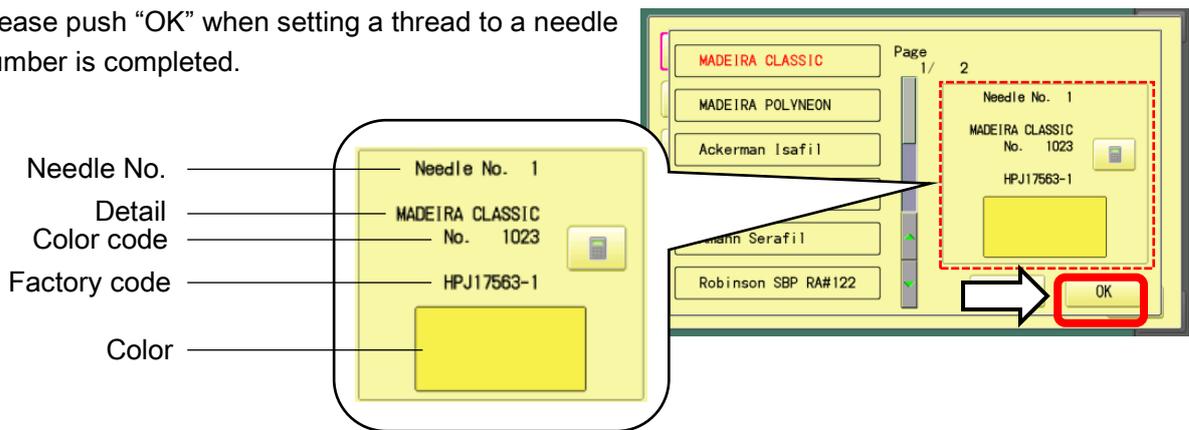
5. Please select thread color code. Then, please push "SET".



Please check a spool of thread staying on a machine.
 Example : MADEIRA POLYNEON 1977



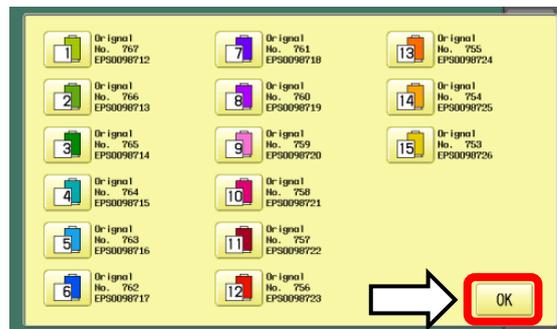
6. Please push “OK” when setting a thread to a needle number is completed.



7. An example image of thread registrations for all 15 needles.

The right picture shows that each needle is assigned to thread ID number from 1 to 15. Numbers of needle bar are varied, depending on the model of embroidery machines.

Press 「OK」, after registering.

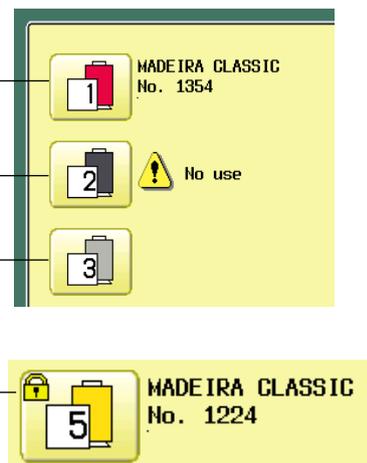


Thread setting is ON.  (Registered thread number is set to a needle bar.)

Thread setting is OFF. 

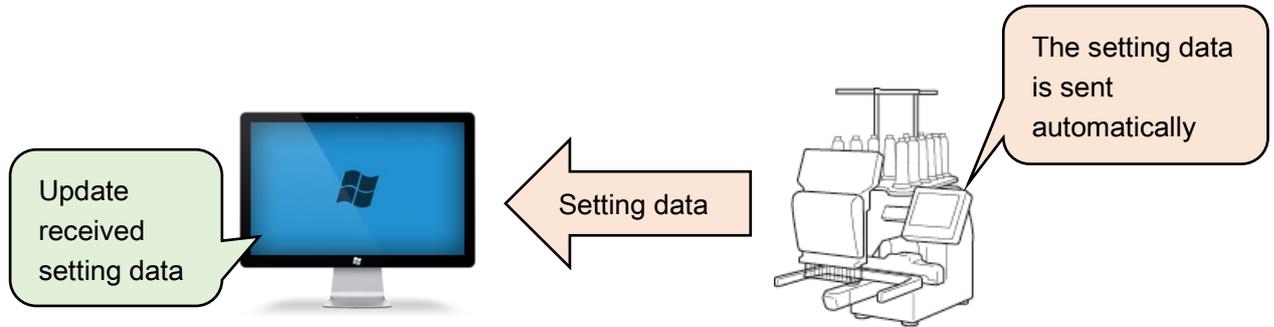
Thread setting is ON.  (Registered thread number is not set to a needle bar.)

Disable thread change. It can be useful when you want not to change thread of specified needle bar.
 For setting, lock by pressing and holding the button.



Step 4 Collecting embroidery machine setting data and thread location

Collect setting data from the machine, including needle information (previous section)
 Further operation is not required because this system transmits automatically.



Machine setting data

Machine specification

Name	DEMO-9M2443	Status	Waiting	Needles	7	Heads	1
Max.speed	1000	Cap.speed	600	Frame type	Custom5	Design	BAPE
User	AAA						

Update date [DataBase] 2018/05/25

Machine threads

1
2
3
4
5
6
7

Machine specification Output

Exclamation mark may appear in speed section. The mark will disappear when communication is done in a few seconds.

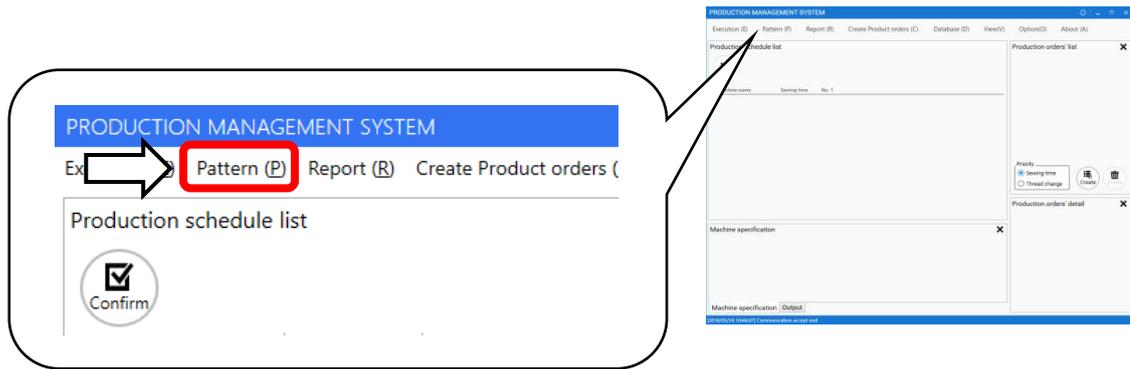
Max.speed	⚠	Cap.speed	⚠
-----------	---	-----------	---

Exclamation Mark

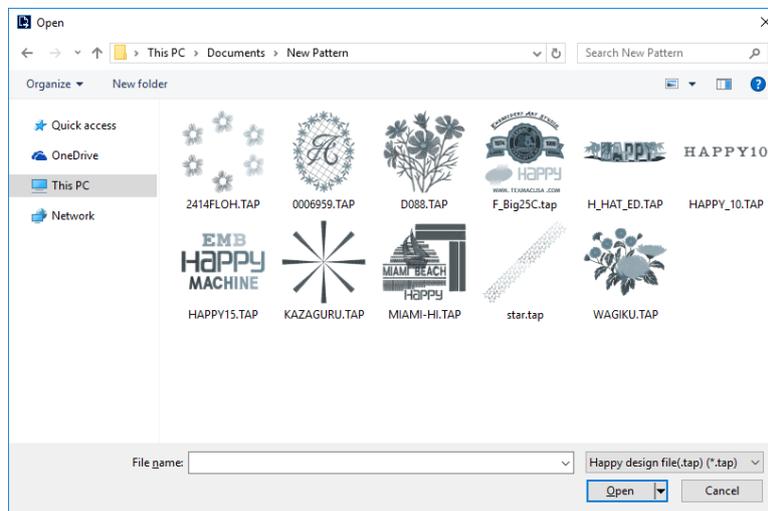
Step 5 Registering thread ID number with embroidery designs

Through procedures to set thread(s) to match color(s) in accordance with design data, adjust design, repeat, offset, get out of a frame, embroidery data (.tth data) can be created in this section. Embroidery data that had been created already can be read it also in this section.

1. Click "Patter" from the main menu.



2. Select a design from the stored folder.

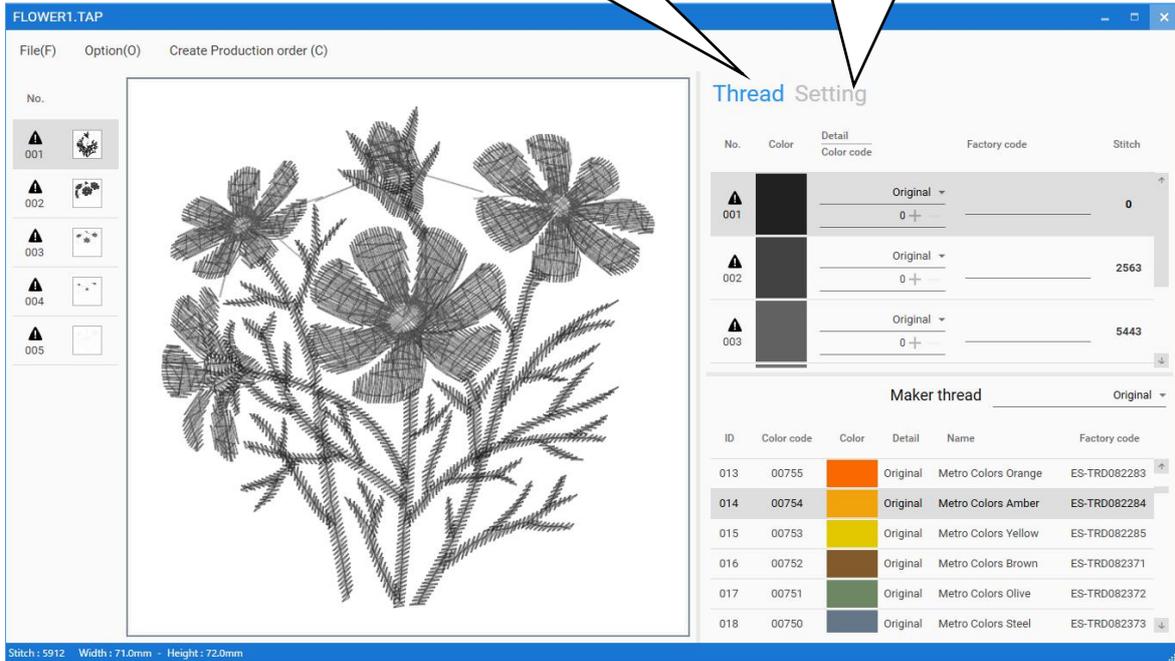


Design data can be selected from any of .tap, .dst, .dsb, .dsz.

3. Screen for creating embroidery data is displayed.

Thread Setting Display
Thread(s) to match color(s) to be changed can be set.

Design Setting Display
Adjustment on design, repeat, offset and out of frame can be set.



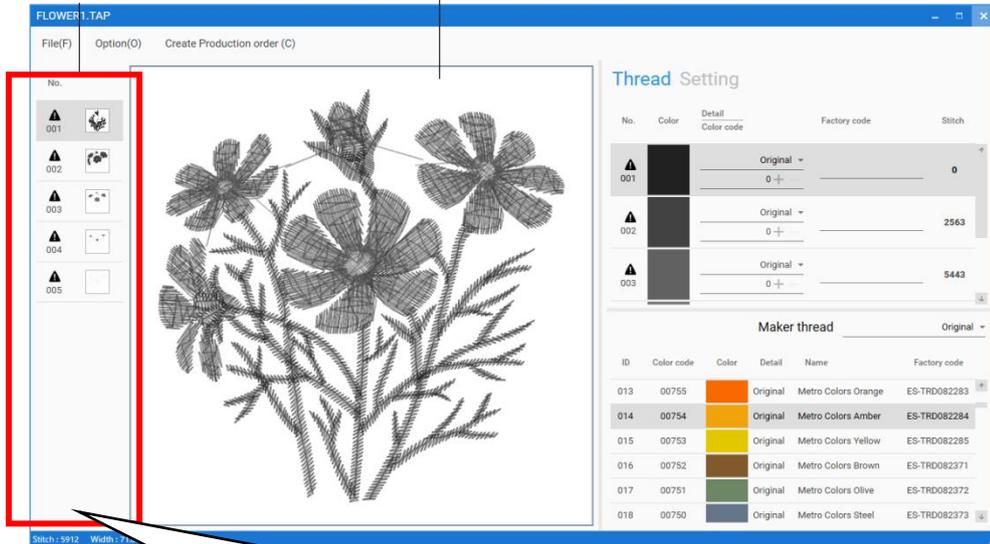
Thread Setting

In thread setting display, thread(s) in the thread list to have been registered at Step 1 can be assigned to match color(s) to be changed in accordance with design data.

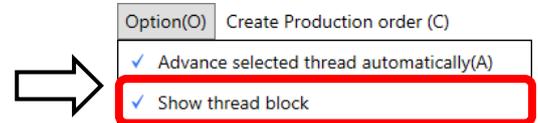
Embroidery data cannot be saved if all color change number is assigned color code.

Color change number of the design data

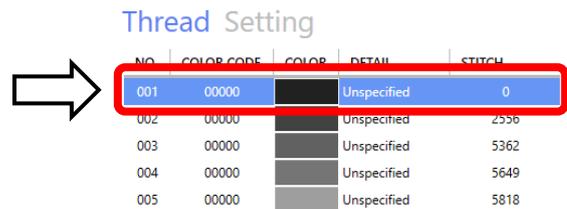
Preview of design data



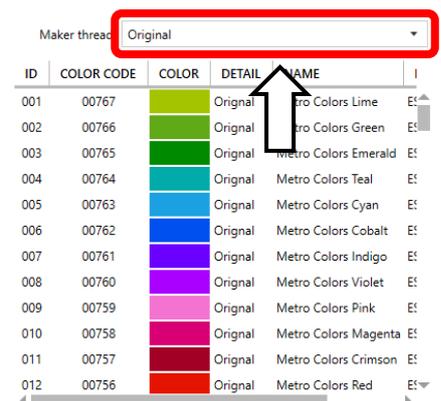
Please delete a check mark at "Show thread block" in Option if you do not want to let color change number appear.



1. Please select voluntary color change number.



2. Please select a supplier.



3. Please double-click thread(s) which you would like to assign.

Maker thread Original

ID	COLOR CODE	COLOR	DETAIL	NAME	I
001	00767		Original	Metro Colors Lime	ES
002	00766		Original	Metro Colors Green	ES
003	00765		Original	Metro Colors Emerald	ES
004	00764		Original	Metro Colors Teal	ES
005	00763		Original	Metro Colors Cyan	ES
006	00762		Original	Metro Colors Cobalt	ES
007	00761		Original	Metro Colors Indigo	ES
008	00760		Original	Metro Colors Violet	ES
009	00759		Original	Metro Colors Pink	ES
010	00758		Original	Metro Colors Magenta	ES
011	00757		Original	Metro Colors Crimson	ES
012	00756		Original	Metro Colors Red	ES

4. Thread(s) will be assigned to voluntary color change number.

Once thread(s) is assigned to color change number, a next color change number will be automatically selected.

Thread Setting

NO.	COLOR CODE	COLOR	DETAIL	STITCH
001	00000		Unspecified	0
002	00000		Unspecified	2556
003	00000		Unspecified	5262

Next color change number will be automatically selected.

Thread Setting

NO.	COLOR CODE	COLOR	DETAIL	STITCH
001	00765		Original	0
002	00000		Unspecified	2556
003	00000		Unspecified	5262

Please delete a check mark in "Advance selected thread automatically" in "Option", if you would like to cancel this function.

Option(O) Create Production order (C)

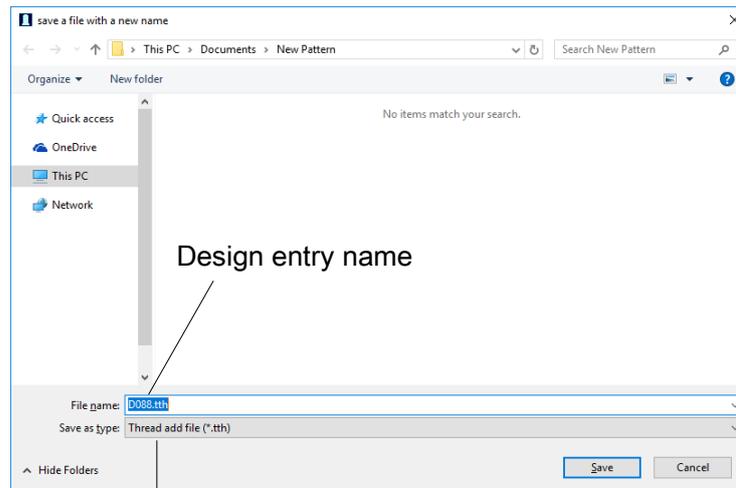
Advance selected thread automatically(A)

Show thread block

5. Once threads are assigned to all of color change numbers, please select "Save" from "File".

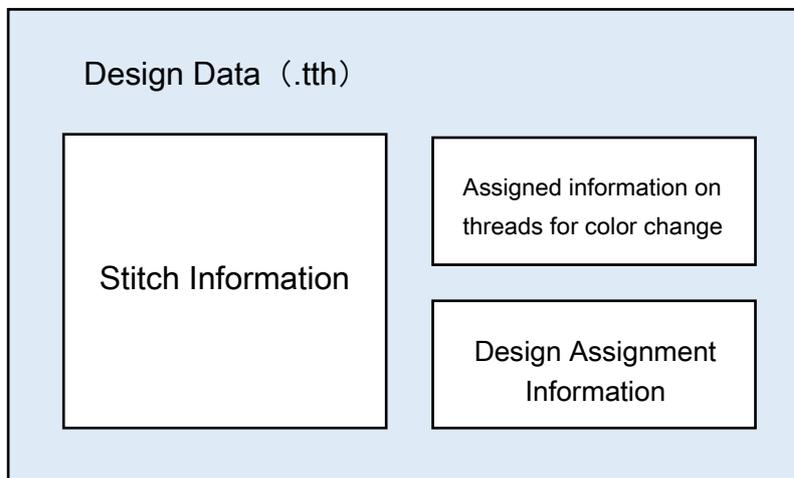
The screenshot shows the software interface for 'FLOWER1'. The 'File' menu is open, and the 'Save(S)' option is highlighted with a red box. The 'Thread Setting' panel on the right shows three threads assigned to color change numbers 001, 002, and 003. The 'Maker thread' dropdown is set to 'Original'. The 'File' menu also shows 'Option(O)' and 'Create Production order (C)'.

6. Please determine a file name and save.



Embroidery data is saved as .tth data.

.tth consists of the following items.

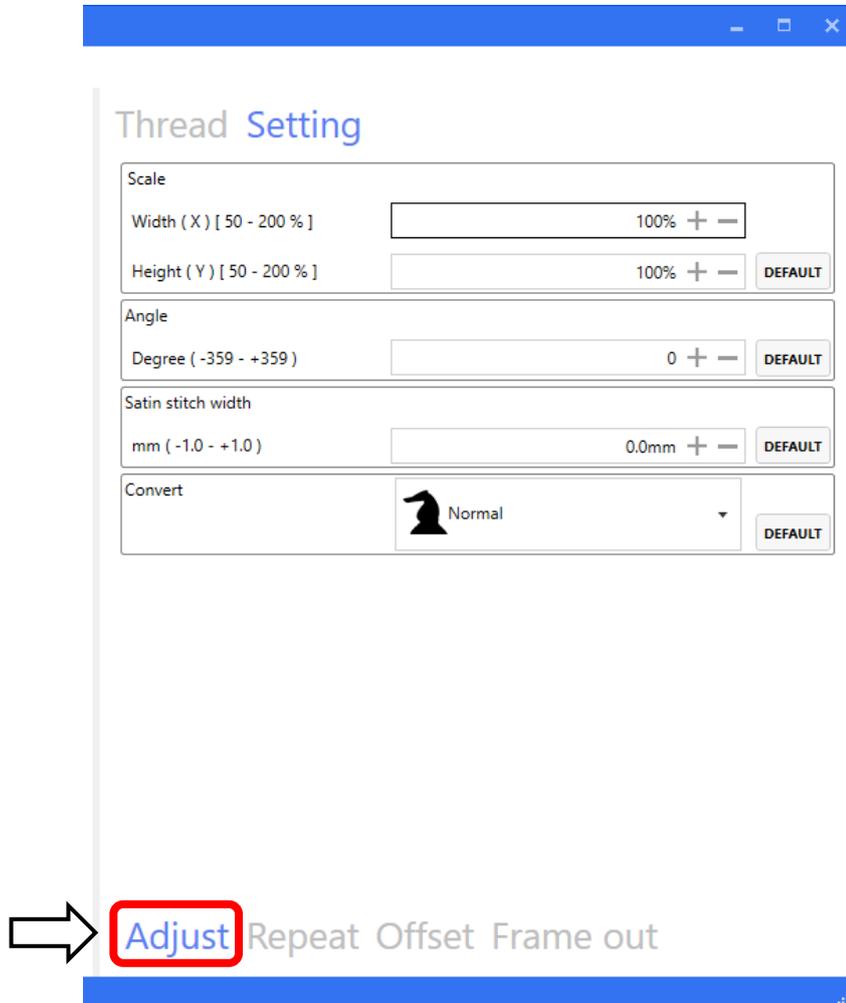


.tth configuration

Setting design data

Adjust

This menu contains settings such as scaling, width adjustment, angle and convert design.



Scaling

This adjusts the scale of the selected design data.



To get back to default.
(100%)

Angle

This adjusts the angle of the selected design data.



To get back to default.
(0)

Width adjustment

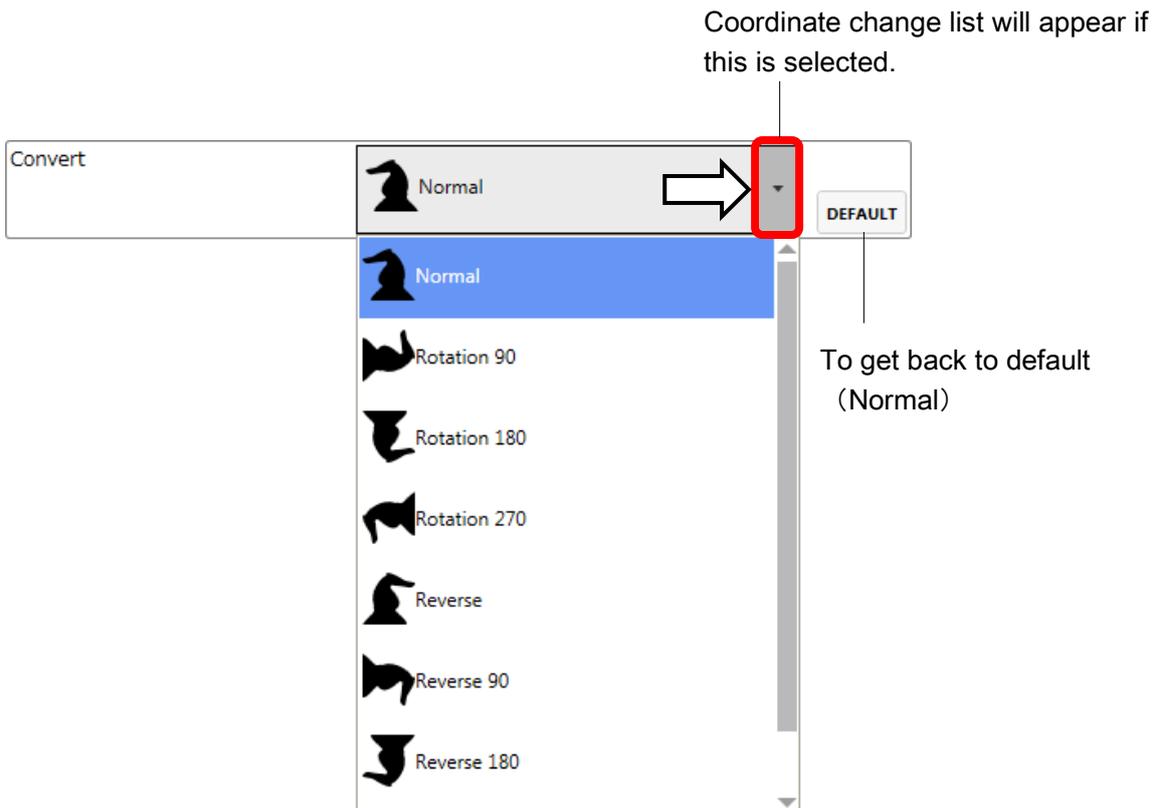
This adjusts the width of the selected design data.



To get back to default.
(0.0mm)

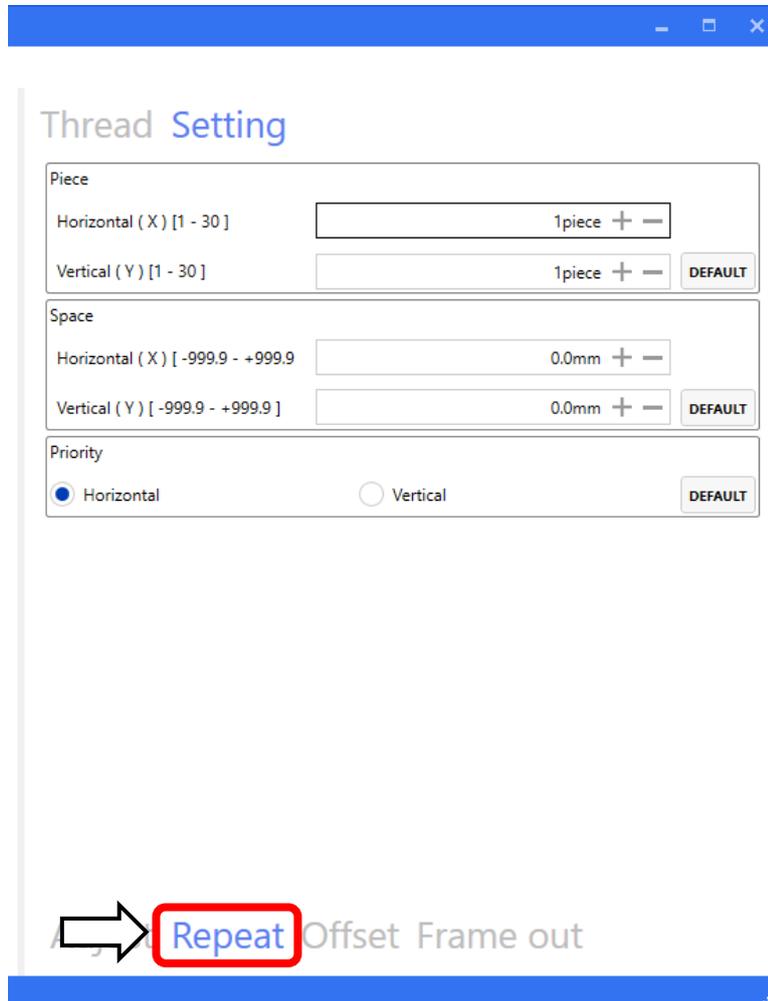
Convert design

This sets the rotation of the selected design data in increments of 90 degrees, normal or reversed.



Repeat sewing

The machine repeats the design data a number of times in the X and Y directions as set by the user.



Piece

This sets number of pieces side wise and length wise when you perform repeat.

The number of pieces to be embroidered is product obtained by multiplying numbers in X and Y.



To get back to default
(1piece)

Space

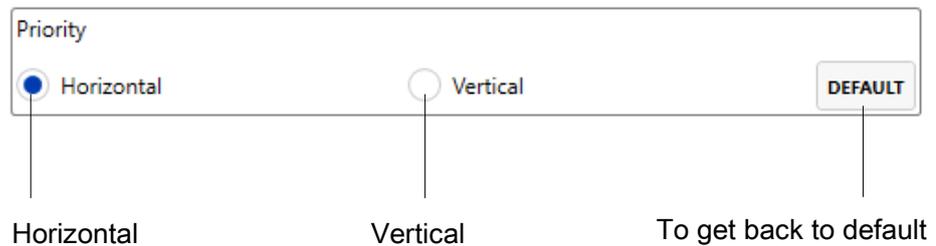
This sets side and length wide distance between start point of each design when you perform repeat. When plus number of horizontal is input, the machine makes repeat toward right. In case of minus number, toward left.

When plus number of vertical is input, the machine makes repeat upward. In case of minus number, downward.



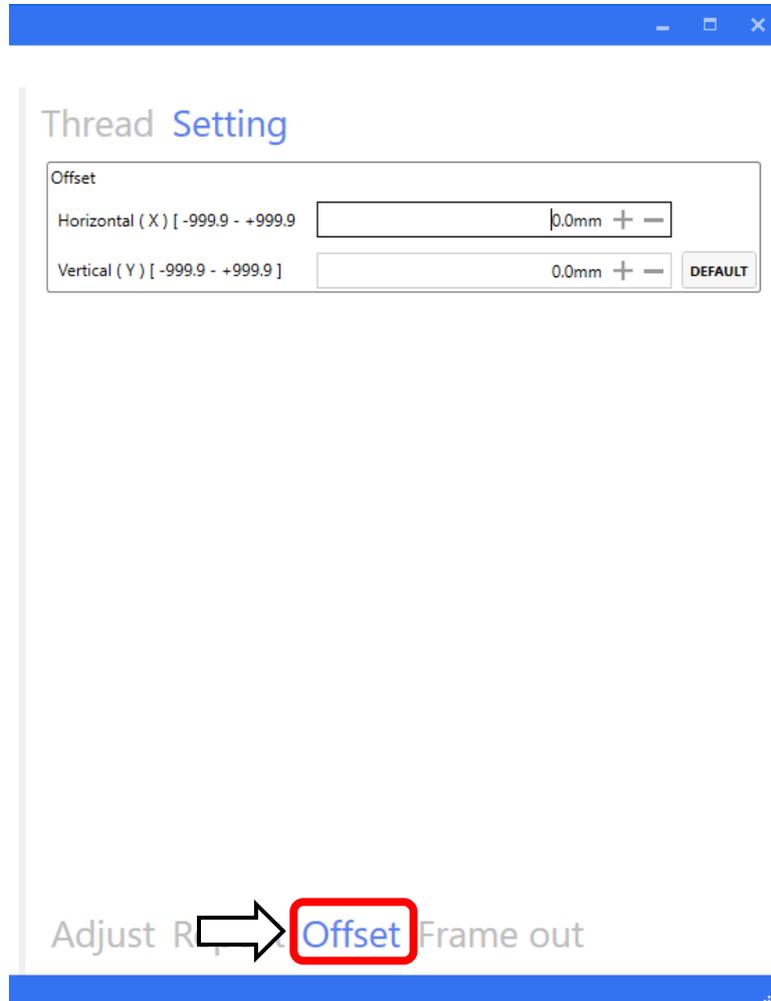
Priority

When you set more than 2 pieces for repeat length wise and side wise, this selects direction to embroider 2nd piece.

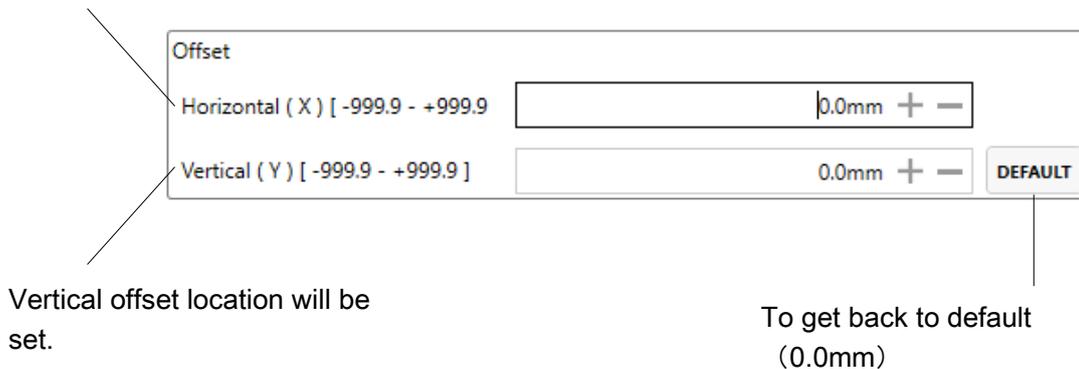


Offset

Sets the start point of the frame in the selected design.

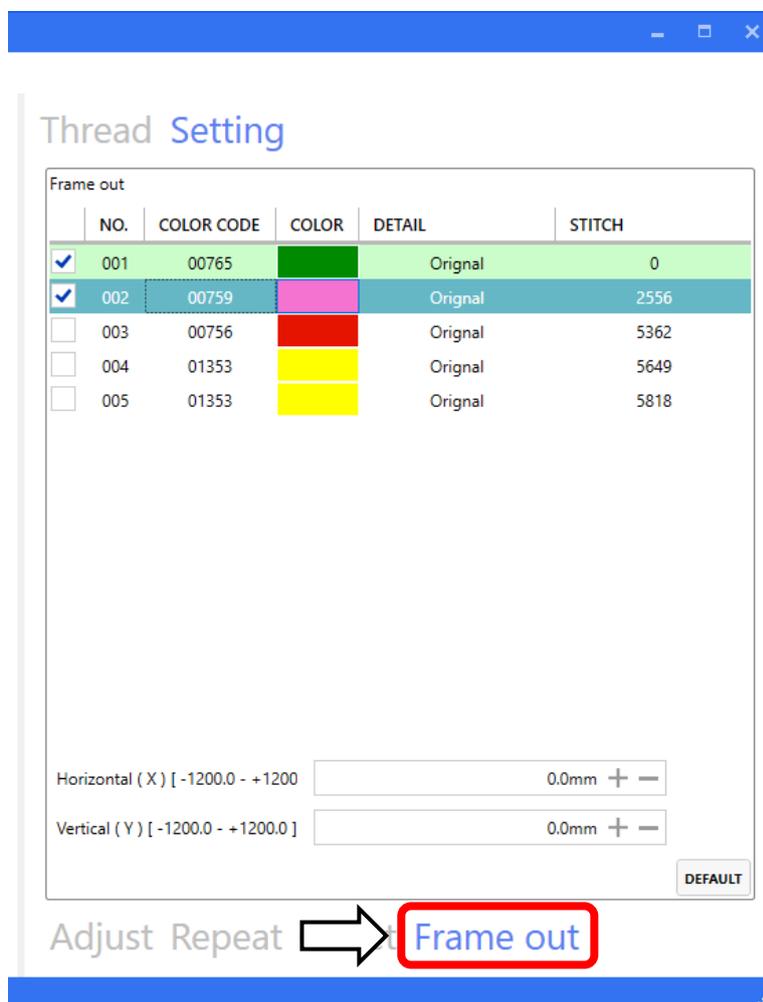


Horizontal offset location will be set.

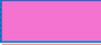


Frame out

Insert a frame command in the selection pattern.



Color change number will be frame out when check the each checkbox.

	NO.	COLOR CODE	COLOR	DETAIL	STITCH
<input checked="" type="checkbox"/>	001	00765		Original	0
<input checked="" type="checkbox"/>	002	00759		Original	2556
<input type="checkbox"/>	003	00756		Original	5362
<input type="checkbox"/>	004	01353		Original	5649
<input type="checkbox"/>	005	01353		Original	5818

Horizontal offset location will be set.

Horizontal (X) [-1200.0 - +1200]

Vertical (Y) [-1200.0 - +1200.0]

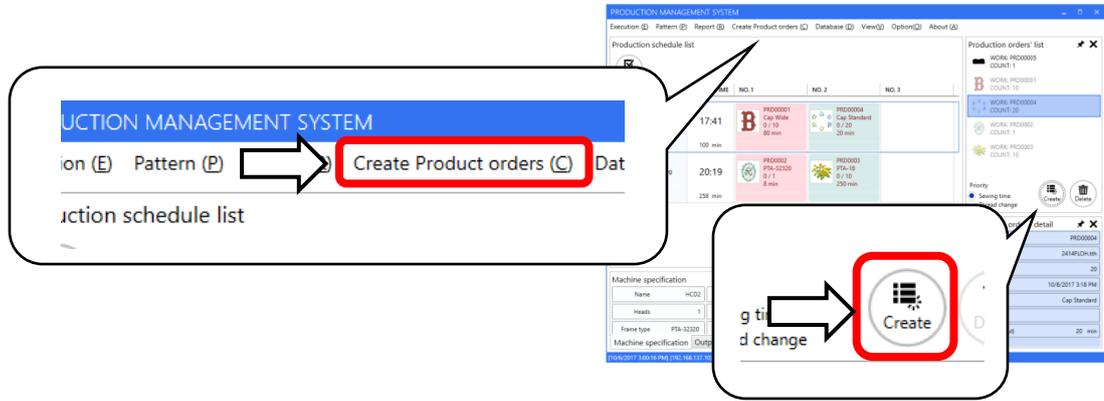
Vertical offset location will be set.

To get back to default (0.0mm)

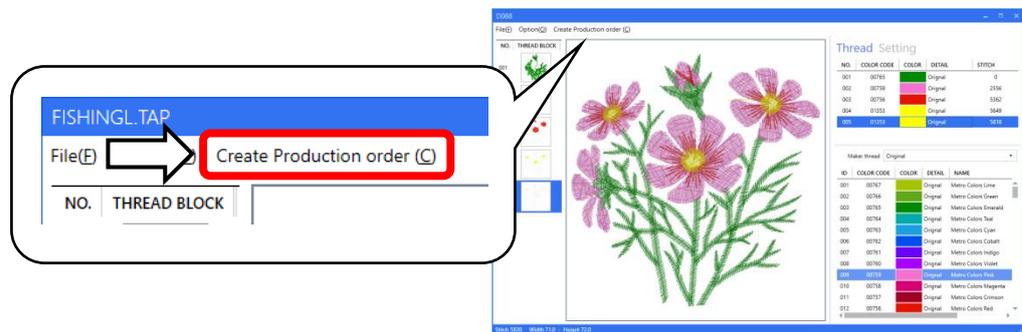
Step 6 Registering production order

Production order will be registered by inputting production order code, finish date and time and so on.

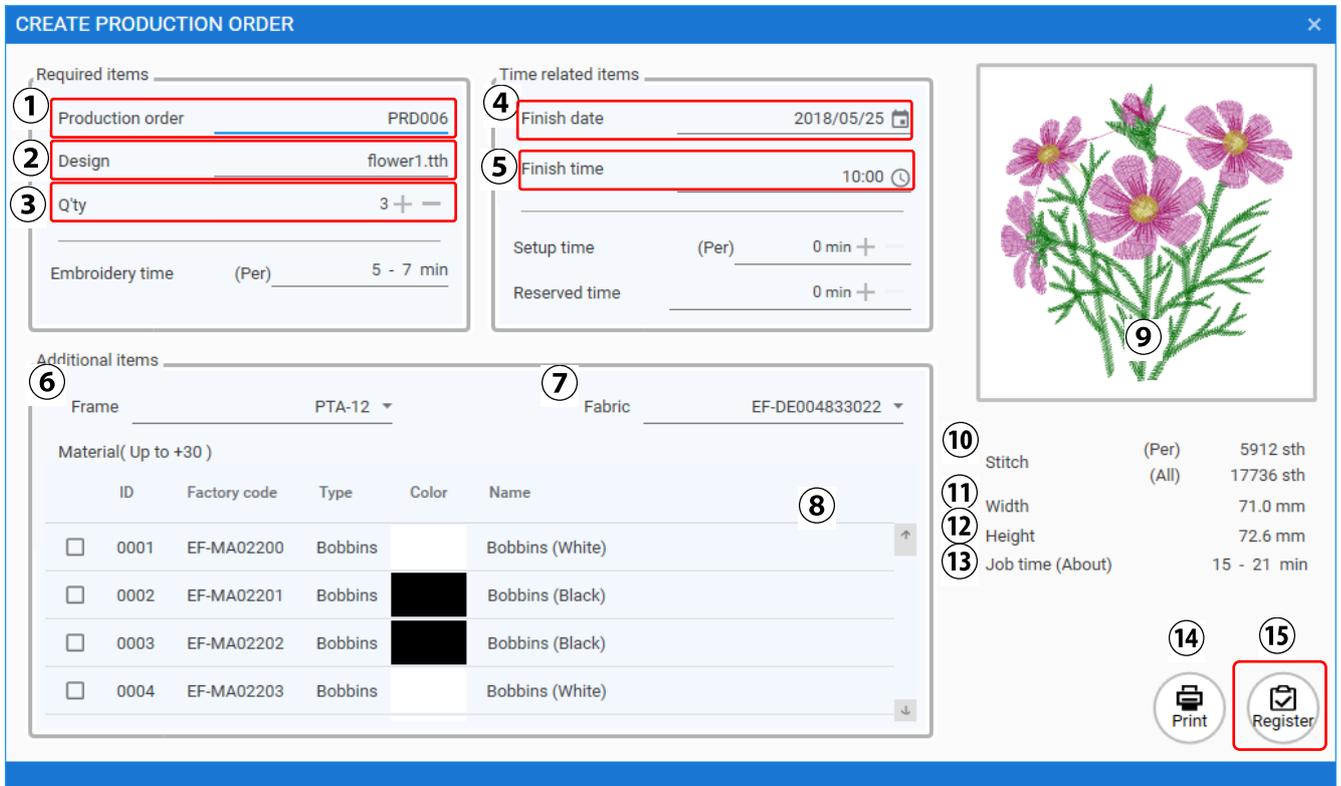
1. Select "Create Product orders" from the main menu, or select "Create" button in the "Production orders' list" window, or select "Create Production order" in section Step 5.



Or

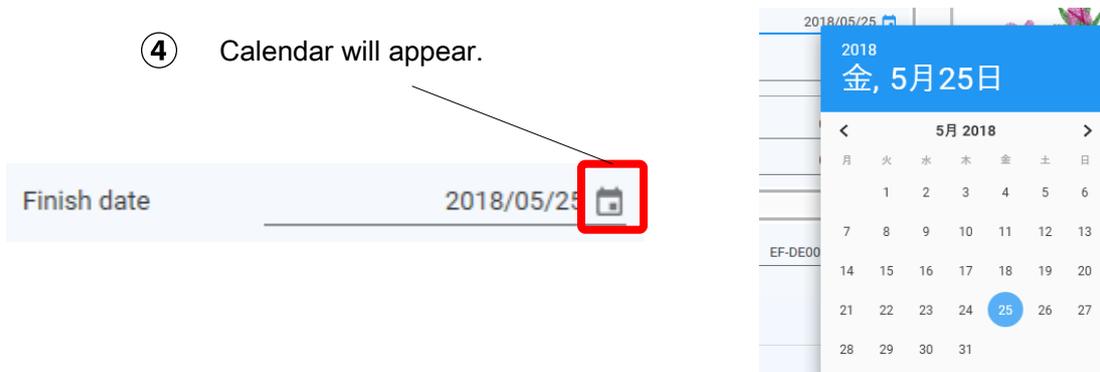


2. Create production order to be sent embroidery data to embroidery machine.
 Enter ①"Production order", ②"Design", ③"Q'ty", ④"Finish data", and ⑤"Finish time", then click ⑮"Register" button.
 Setting of ⑥"Frame", ⑦"Fabric", and ⑧"Material" as option will be available.

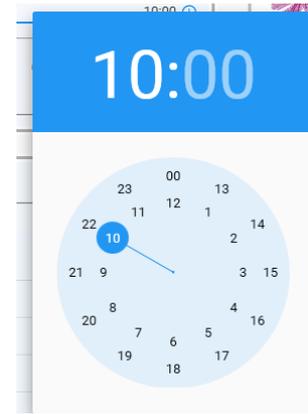


- ① Production order will be required . (Up to half-width alphanumeric 32 letters)
- ② Design (Design data to be made at Step 5) will be required.
- ③ Quantity will be required.
- ④ Finish date will be required.

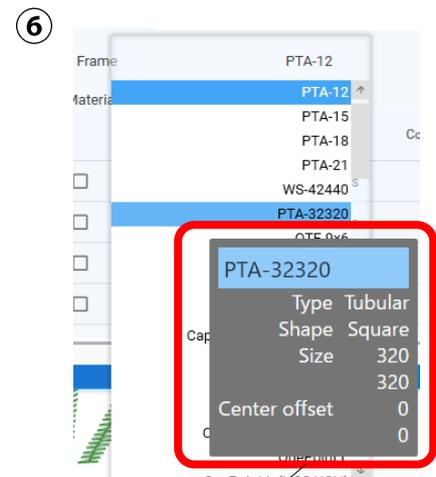
④ Calendar will appear.



⑤ Finish time will be required.

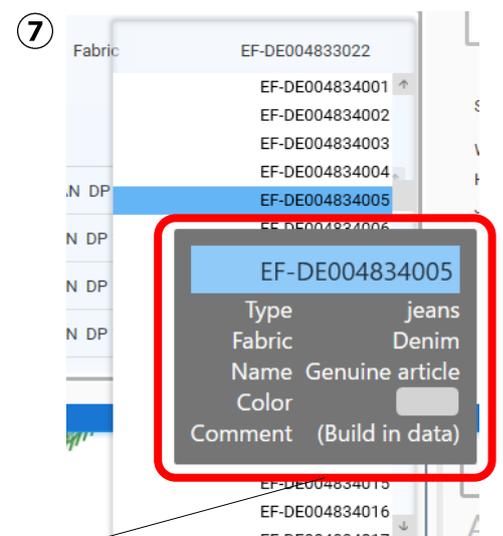


⑥ Frame
Information on “Frame” to be registered at Step 1 will be able to be added to production order. Frame will automatically be changed at an embroidery machine if a frame is specified and set. Other frames which cannot be accommodated by an embroidery machine will not be changed automatically.



Information on material will appear if a pointer comes up on material's name.

⑦ Fabric
Information on material to be registered at Step 1 will be able to be added to production order.



Information on frame will appear if a pointer comes up on frame's name.

⑧ Material

Secondary material to be registered at Step 1 will be able to be added to production order.

Registered information on secondary material to be checked will be sent.

⑧

ID	Factory code	Type	Color	Name
<input checked="" type="checkbox"/> 0005	EF-MA02204	Bobbins		Bobbins (White)
<input type="checkbox"/> 0006	EF-MA02205	Bobbins		Bobbins (Black)
<input type="checkbox"/> 0007	EF-MA02206	Bobbins		Bobbins (White)
<input type="checkbox"/> 0008	EF-MA02207	Bobbins		Bobbins (Black)

⑨ Design preview

⑩ Stitch

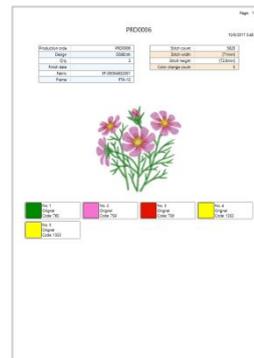
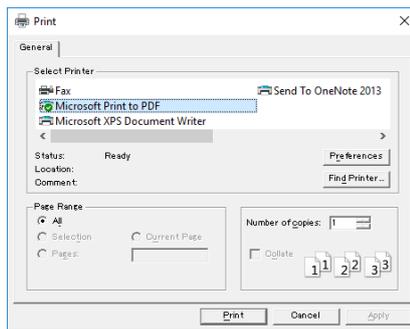
⑪ Width

⑫ Height

⑬ Job time(About)

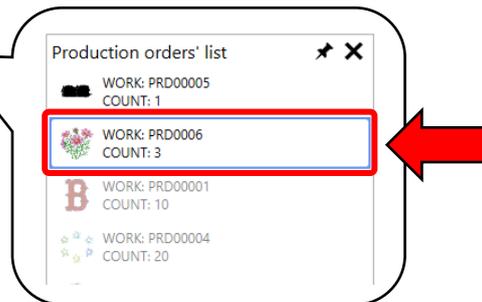
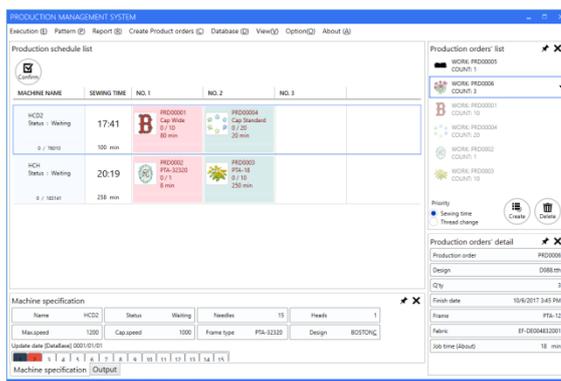
⑭ Print button

Production order will be able to be printed out.



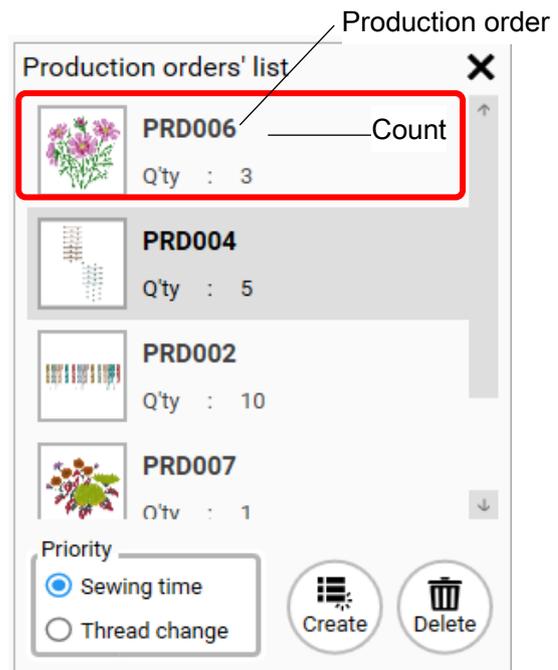
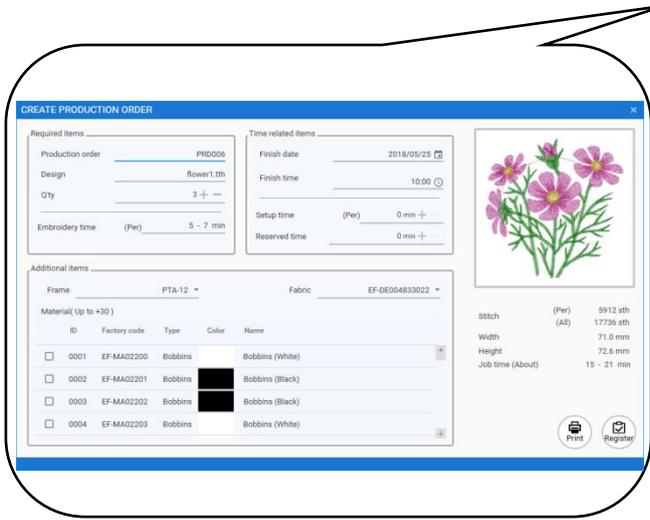
⑮ Register button

3. After registration, the registered order is displayed in "Production orders' list" on the main menu. (It will be listed up at the last portion in production order list.)



Production order in production orders' list

“CREATE PRODUCTION ORDER” screen will appear if an item to order is double-clicked.

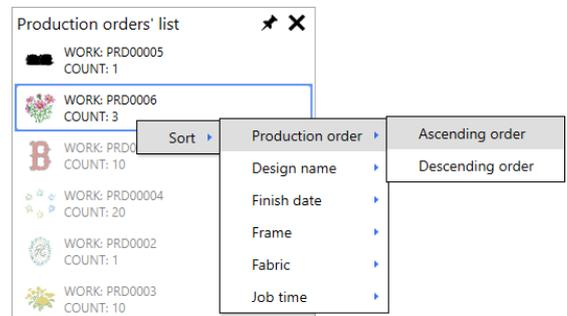


Exclamation mark will appear next to an ordered item if stitch data is re-saved in a different location.



Exclamation Mark

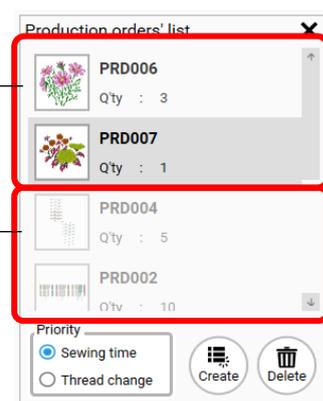
Screen appearing in the right side will appear if you right-click on a cell. Production orders will be changeable in order.



Colors relating to allocated orders to embroidery machine(s) become pale.

Orders waiting for allocation to machine

Orders to have been allocated



Step 7 Registering allocation order

Allocate registered production orders to have been created at Step 6 to embroidery machines in connection with Production Management System.

1. Drag a production order from Production order list and drop it to Embroidery machine's side.

After dropping production orders to task waiting lines, each order will be located in orderly of completion time or color changes.

PRODUCTION MANAGEMENT SYSTEM

Execution (E) Pattern (P) Report (R) Create Product orders (C) Database (D) View(V) Option(O) About (A)

Production schedule list

Confirm

Machine name	Sewing time	No. 1	No. 2	No. 3
DEMO-9M2443 Status : Waiting 0 / 17625	2018/05/25 12:04 45 min	PRD002 PTA-21 0 / 10 40 min	PRD004 SQ clamp L (HCS,H 0 / 5 5 min	
HCH-DEBUG-90654 Status : Waiting 0 / 104268	2018/05/25 13:37 138 min	PRD008 0 / 6 78 min	PRD012 FTA-32320 0 / 10 60 min	

Production orders' list

- PRD006 Q'ty : 3
- PRD007 Q'ty : 1
- PRD004 Q'ty : 5
- PRD002 Q'ty : 10

Priority

- Sewing time
- Thread change

Create Delete

Machine specification

Name DEMO-9M2443 Status
Max speed 1000 Cap speed
Needles
Frame type

Job time (About) 40 min

When the production order is dragged, the cell starts blinking and either a completion time or color change number is displayed.

Priority order
 Sewing time Displayed with sew time priority
 Thread change Displayed with color change number priority

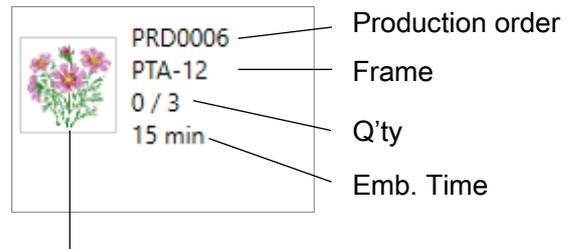
Items in Production order's list can be moved to Production schedule list. On the other hand, items in Production schedule list can be returned to Production order's list.

Note: Some items can be moved, some items not.

	○ Possible	× Impossible
 <p>Allocate orders from Production order's list to Production schedule list</p>	<p>○ Order(s) not to have been allocated yet</p> <p>○ Order(s) whose stitches' area stay in allowable area at a machine</p>	<p>× Order(s) to have already been allocated</p> <p>× Order(s) whose stitches' area does not stay in allowable area at a machine</p>
 <p>Return orders from Production schedule list to Production order's list</p>	<p>○ Order(s) not to wait to be transferred to a machine*</p> <p>○ Order(s) to be in process to be transferred to a machine*</p>	<p>× Order(s) to have been already transferred to a machine*</p>

* P.66. Please refer to the status in allocating production order(s).

2. Order data will appear in Production schedule list.



Preview of stitches design

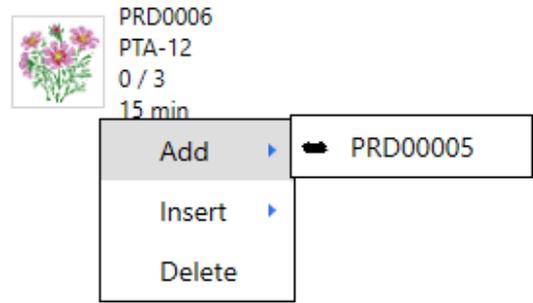
Expected completion time will be updated.

Machine name	Sewing time	No. 1	No. 2	No. 3
<p>DEMO-9M2443 Status : Waiting</p> <p>0 / 17625</p>	<p>2018/05/25 12:09</p> <p>45 min</p>	<p>PRD002 PTA-21 0 / 10 40 min</p>	<p>PRD004 SQ clamp L (HCS,H 0 / 5 5 min</p>	
<p>HCH-DEBUG-90654 Status : Waiting</p> <p>0</p>	<p>18/05/25 13:42</p> <p>Expected completion time at a machine</p>	<p>PRD008 0 / 6 8 min</p>	<p>PRD012 PTA-32320 0 / 10 60 min</p>	

Order to be processed

Order allocation in production schedule list

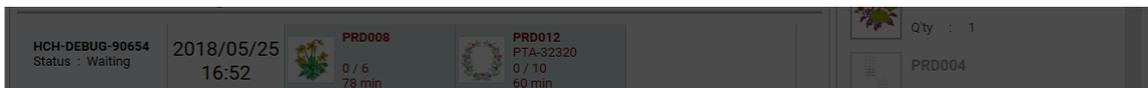
Display in the right will appear if it is right-clicked on a cell. Production order can be added, inserted and deleted in this display. It should be noted that production order to have been transferred to a machine cannot be deleted.



Please push "Delete" with "Shift" pushed to delete production order, if you would like to unavoidably delete production order to have been transferred.

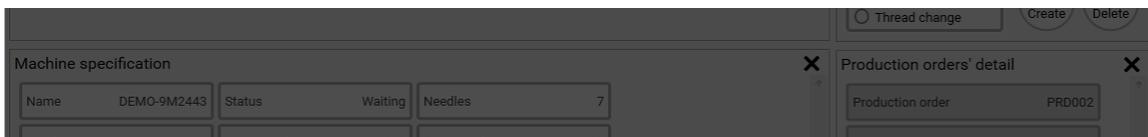
It should be noted that production order to have been transferred to a machine cannot be deleted. Please delete production order existing in a machine manually.

	Sewing time	No. 1	No. 2	No. 3
0654 g	2018/05/25 16:57 138 min	PRD012 PTA-32320 0 / 10 60 min	PRD008 0 / 6 78 min	
13 ing	2018/05/25 15:24 45 min	PRD002 PTA-21 0 / 10 40 min	PRD004 SQ clamp L (HCS,H 0 / 5 5 min	



Warning

Are you sure to force-delete the production orders that is in operation?
(When executing compulsory deletion, manually delete the production instruction of the transmitted embroidery machine.)



Step 8 Transmitting production order

After locating production orders in tasks and confirming to start, Happy PMS automatically transmits data (Design data + Order data) to embroidery machines connected with this system.

1. Please find "Confirm" button from "Execution" in the main form menu.

Otherwise, please select "Confirm" in "Production schedule list".

*"Confirm" is not available without authentication. Please authenticate in advance (See page 10).

PRODUCTION MANAGEMENT SYSTEM

Execution (E) Pattern (P) Report (R) Create Product orders (C) Database (D) View(V) Option(O) About (A)

Production schedule list

Machine name	Sewing time	No. 1	No. 2	No. 3
HCH-DEBUG-90654 Status : Waiting o / 104268	2018/05/25 17:00 138 min	PRD012 PTA-32320 0 / 10 60 min	PRD008 0 / 6 78 min	
DEMO-9M2443 Status : Waiting o / 17625	2018/05/25 15:27	PRD002 PTA-21 0 / 10 40 min	PRD004 SU clamp L (HCSH) 0 / 5 5 min	

Machine specification

Name	HCH-DEBUG-90...	Status	Waiting	Needles	7
Heads	1	Max. speed	1000	Cap. speed	600
Frame type	PTA-21	Design	QW	User	BERRY HELL

Update date [DataBase] 2018/05/15

Machine specification | Output

Production orders' list

- PRD004 Qty : 5
- PRD002 Qty : 10
- PRD008 Qty : 6
- PRD012 Qty : 10

Production orders' detail

Production order PRD008

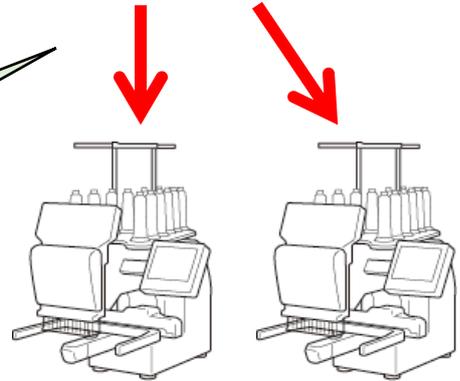
Design flower2.tth

Qty 6

Finish date 2018/05/25

Order confirmation with Production management

After the order confirmation, the system checks if machines are ready, and then the system transmits the data.



Production order cannot be transmitted as following situation.

- Embroidery machine is Drive mode.
- Design status isn't Top.

27.4 15.7

562: D001 805

0 00:02

3 3

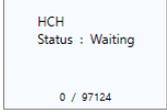
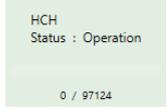
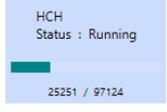
Jump 3

WS-42440
Y: 420mm
X: 440mm

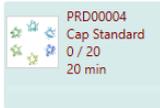
Top status will be shown above indicator.

Status of the production order

The status of the production order can be checked with color of the cell.

display	Status	Details
	Waiting	<p>Machine is waiting for starting. “Running” will appear when a machine starts to embroider.</p> <p>Exclamation mark will appear if design data to have been transferred to a machine are deleted.</p> 
	In Operation	LCD module display is in operation. Otherwise, other display except for operation display is on in LCD module.
	In Running	
	Sending	Database is under transmission. Otherwise, production order(s) is under transmission.
	Machine Stop Due to Thread Break	
	Machine Stop Due to Error	
	Non-Registered	PMS is connected to machine(s) which is not compatible with PMS.

Production order status about an individual color

Display/Status	Details
 <p>Transmission is done</p>	<p>The production order (design data) has been transmitted already.</p> <p>Can't use [Move] (drag-and-drop) nor [Delete] operation in this state. (The system is waiting completion of embroidering.)</p>  <p>Progress Bar</p>
 <p>Transmission Reservation</p>	<p>Transmission of the production order (design data) has been scheduled.</p> <p>Can use [Move] (drag-and-drop) or [Delete] operation in this state. (The system will transmit the data one by one after the previous task is completed)</p>
 <p>Under Allocation</p>	<p>The production order (design data) is only allocated on the waiting list.</p> <p>Can use [Move] (drag-and-drop) and [Delete] operation in this state. (The system will not transmit the data to the embroidery machine.)</p>

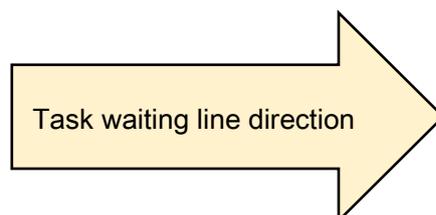
Notice for allocating production order

Since the system will not transmit [White] state data to the embroidery machine, do not leave [White] state cell before [Blue] cell.

Click the [Confirm] and change the status to [Blue] for transmitting the production order to the embroidery machine.

MACHINE NAME	SEWING TIME	NO. 1	NO. 2	NO. 3	NO. 4
HCD2 Status : Waiting 0 / 76010 100 min	17:48	PRD00001 Cap Wide 0 / 10 80 min	PRD00004 Cap Standard 0 / 20 20 min		
HCH Status : Waiting 0 / 200601 279 min	20:47	PRD00002 PTA-32320 0 / 1 8 min	PRD00006 PTA-12 0 / 3 21 min	PRD00003 PTA-18 0 / 10 250 min	

MACHINE NAME	SEWING TIME	NO. 1	NO. 2	NO. 3
HCD2 Status : Waiting 0 / 76010 100 min	17:49	PRD00001 Cap Wide 0 / 10 80 min	PRD00004 Cap Standard 0 / 20 20 min	
HCH Status : Waiting 0 / 193520 271 min	20:40	PRD00006 PTA-12 0 / 3 21 min	PRD00003 PTA-18 0 / 10 250 min	

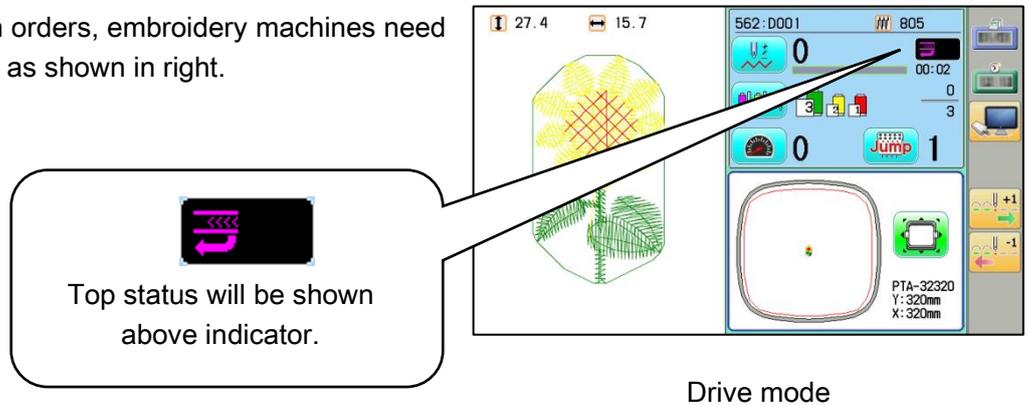


Step 9 Production of embroidery

How to operate

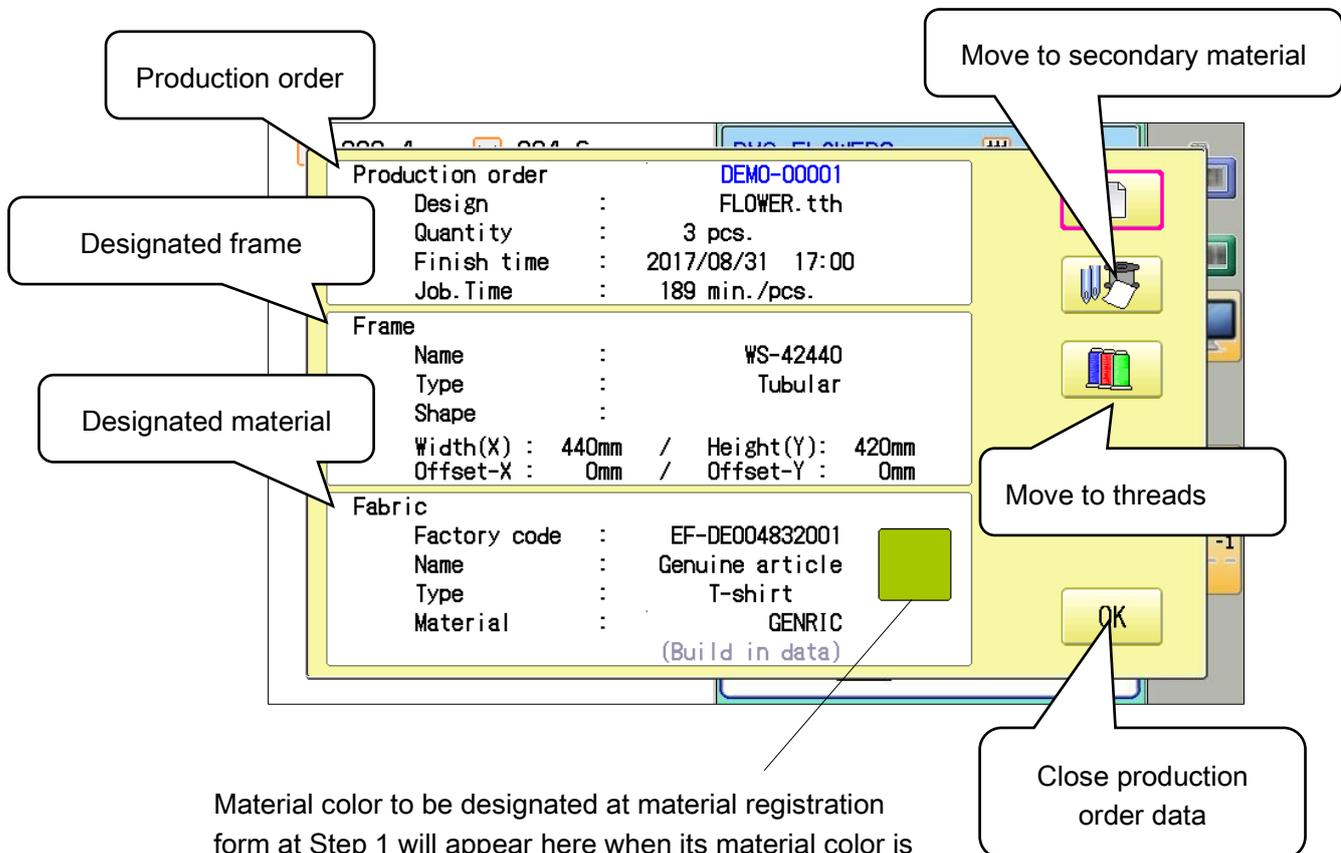
How to operate embroidery machines after machines receive production orders.

1. To receive production orders, embroidery machines need to be operation mode as shown in right. Be Top status.



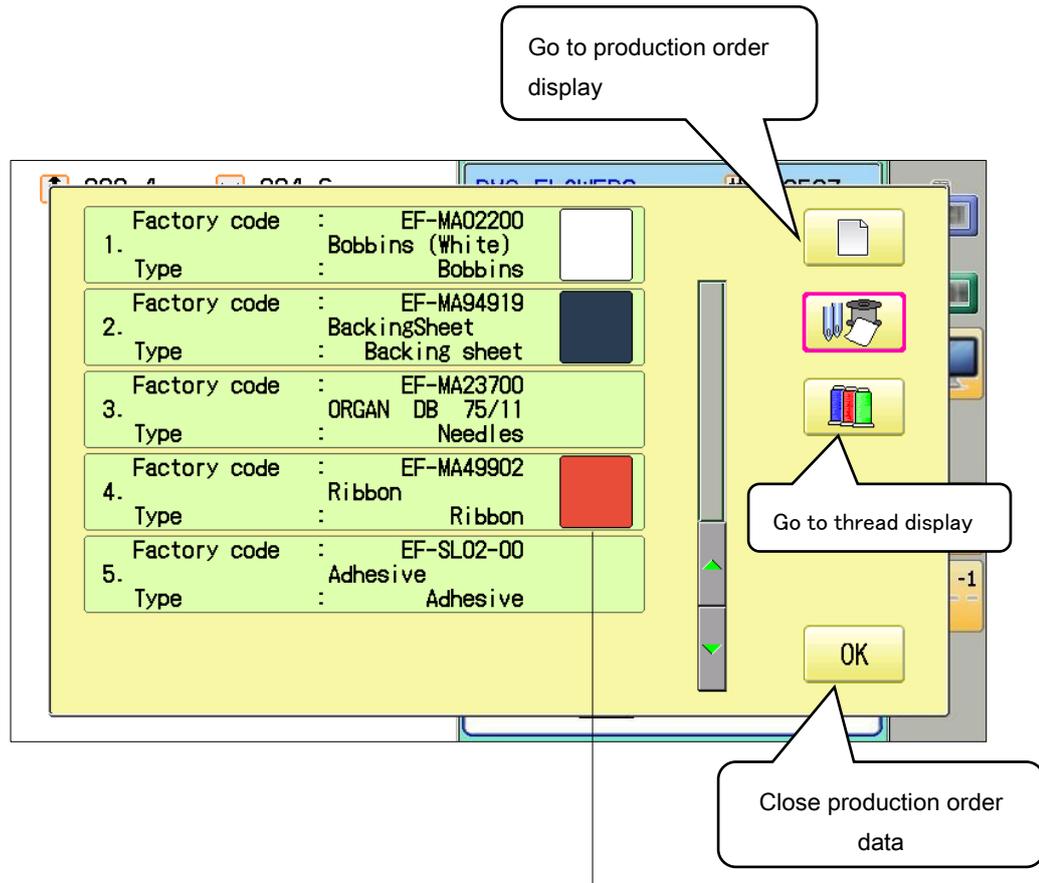
2. The machine display shows details of the order after receiving. Order number, Design name, Quantity, Embroidery time, and Frame type, etc. As an example, the production order 「DEMO-00001」 is received. Information on designated frame and designated material will appear if designated frame and designated material are set at Step 6.

Production order display



Material color to be designated at material registration form at Step 1 will appear here when its material color is selected at Step 6.

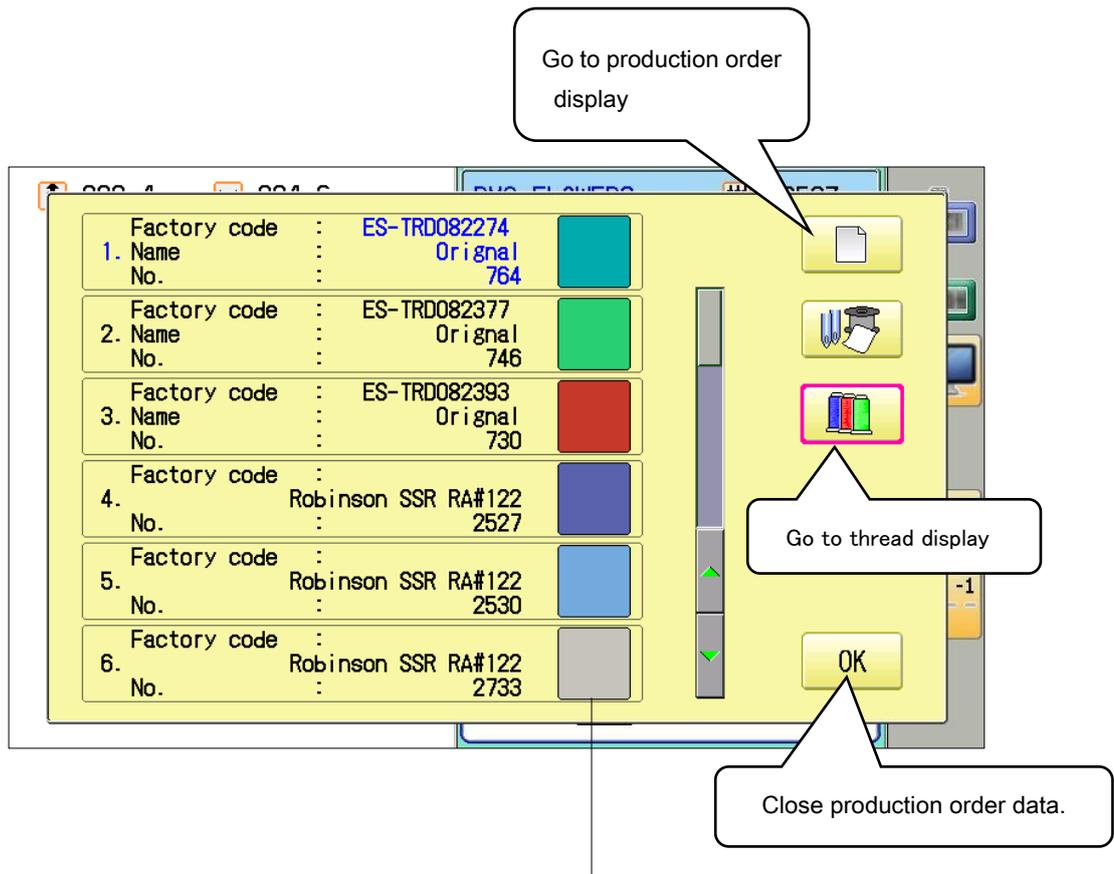
Display of Secondary Material Information



Color(s) for secondary material(s) to have been registered at Step 1 will appear here if the secondary material(s) is selected at Step 6 for production order.

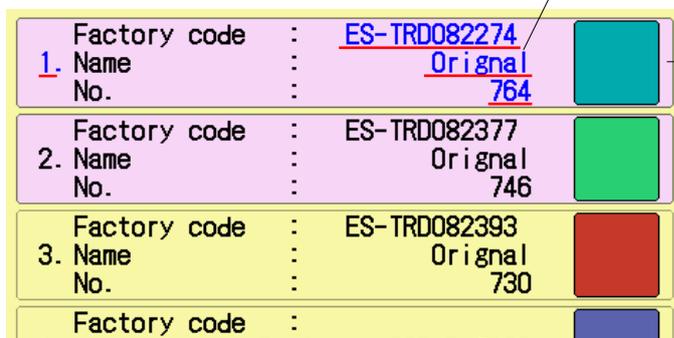
Color(s) for secondary material(s) to have been registered at Step 1

Display of Thread Information



Color(s) of thread(s) to have been registered at Step 1 will appear here if the thread(s) is selected at Step 6 for production order.

Thread being used in embroidering appears in blue.

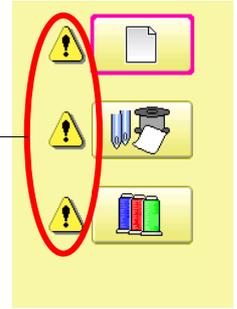


Background for threads which stand on a machine will appear in pink.

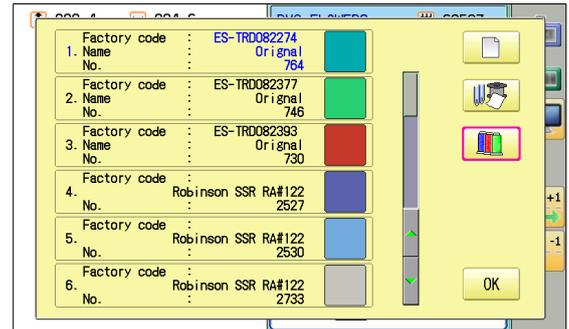
Exclamation mark(s) will appear if database is not updated. In this case, please update the database.

(For more information, please refer to Step 2 Updating Database Information at page 38.)

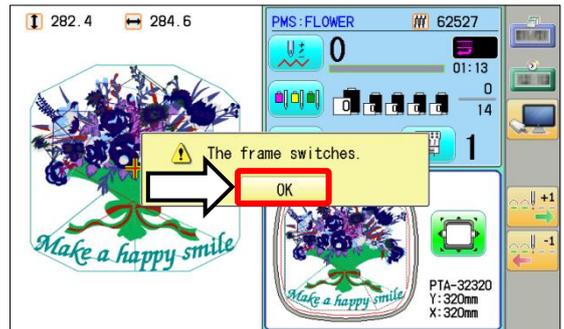
Exclamation Mark



3. Please select “OK” after confirmation.

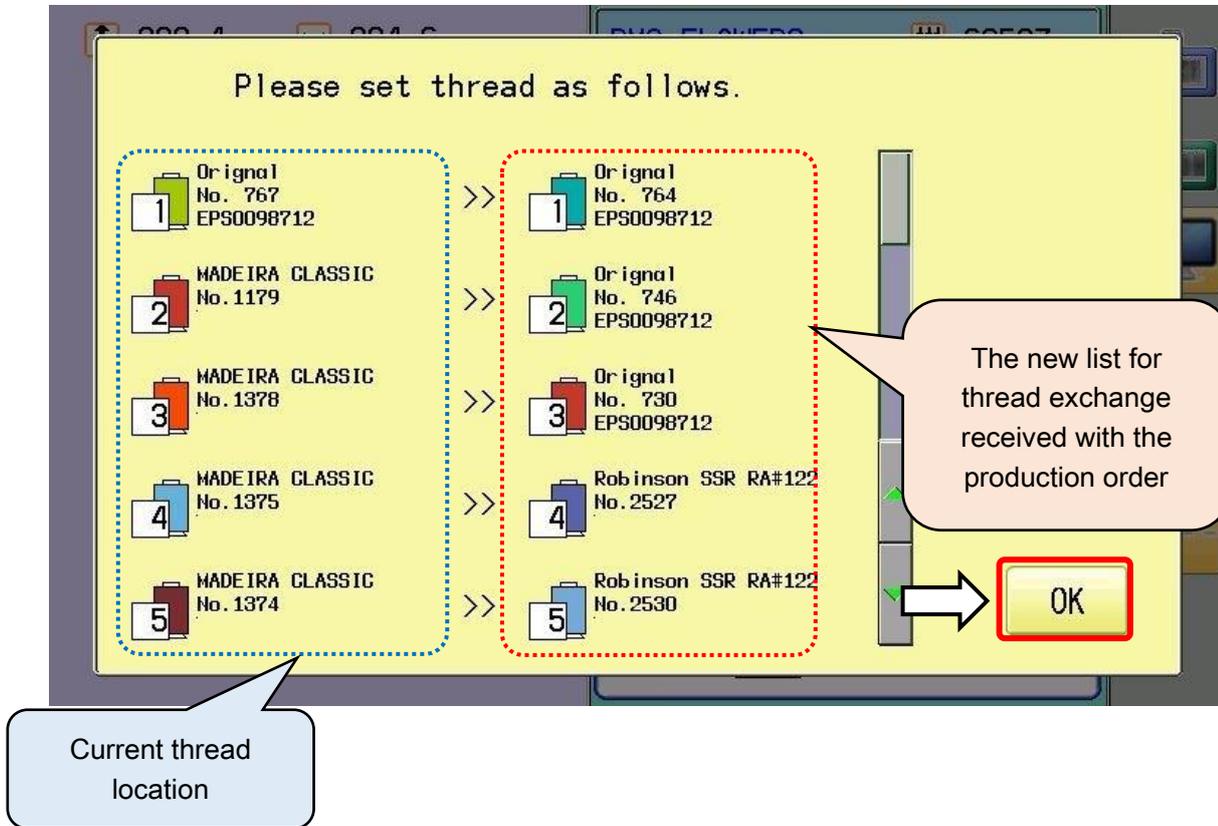


4. An applicable frame only will automatically appear if a frame is assigned to work for production order.



5. After showing the production order details, thread information will be on the display. Press "OK" after exchange the thread.

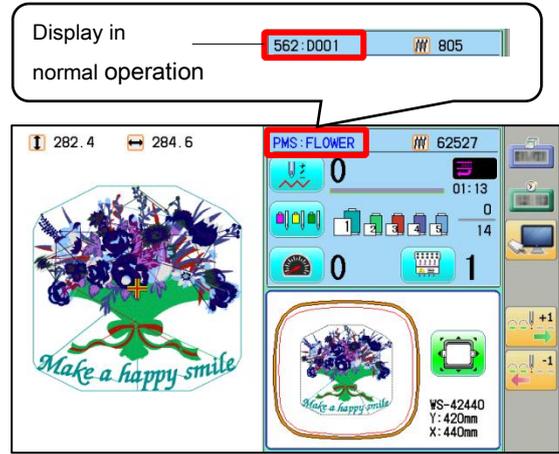
In the case of thread exchange is required



When the "OK" is pressed, the machine recognizes that the thread exchange completes, then the thread information is updated automatically.

(The updated thread information can be checked through "THREAD SET" from the main menu.)

- After updating the thread information (location), the screen returns to be ready for starting the task.
ID(PMS) and design name and number of stitched of design data that is transmitted from production management system is shown blue.

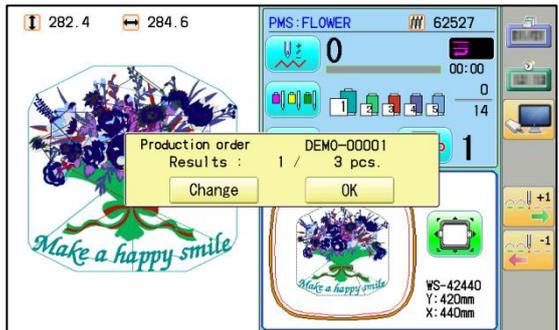


- A machine will start to embroider.

The screen in the preceding page will be appeared when exchanging thread is needed in the middle of embroidery.



- The number of production is displayed on the machine screen when each production has been completed.
The production result can be checked through Production management system as well. (Step 10: Monitoring and progress management)

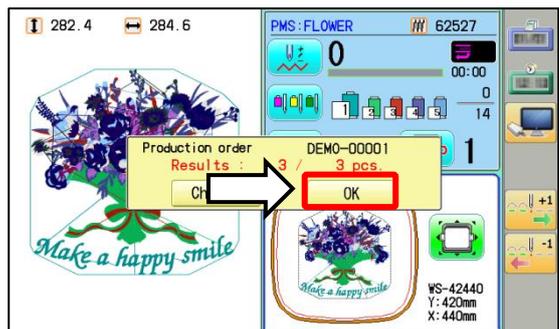


Quantities of productions can be changed by clicking "Change" button in the production result dialog.

Press "OK" to continue the embroidery.
The number of production about "DEMO-00001" is 3 pieces.

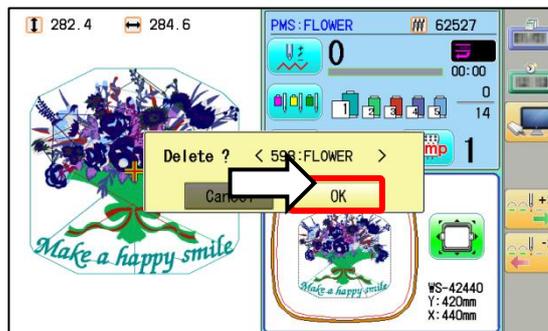
- When numbers of completion reach order quantities, the text color becomes red.

Press "OK" to complete the production.



10. After “OK” is pressed for the task completion, the screen shows another dialog box to delete the design just finished.

Press “OK” to delete the design.



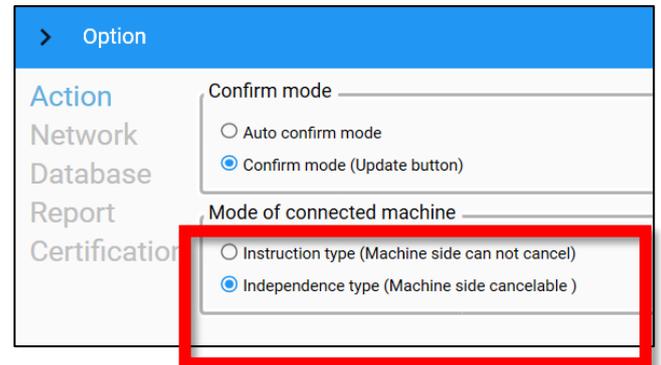
The instructions about design data listed below must be followed.

- Do not make any changes to the memorized design data, when the received production order is displayed on the machine screen. Production information will not be able to be managed by PMS.
- Needle bar setting and design setting in design data to have been transferred by PMS will not be able to be changed, because these settings are secured.
- Do not use “Pattern” management menu for deleting the received production order (design data) which is sent from Product management system.
Make sure to use the dialog box to delete the design data after completion of the production order.

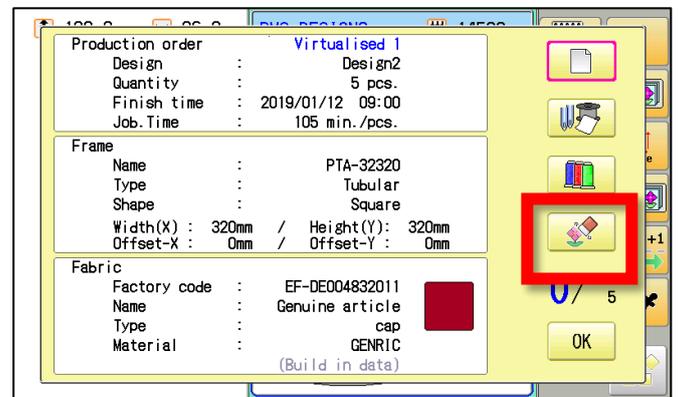
Cancellation

Order(s) to have been transferred from a computer can be cancelled. Please be noted that order(s) will be cancelled and deleted even if required order(s) is not completed when cancellation activates.

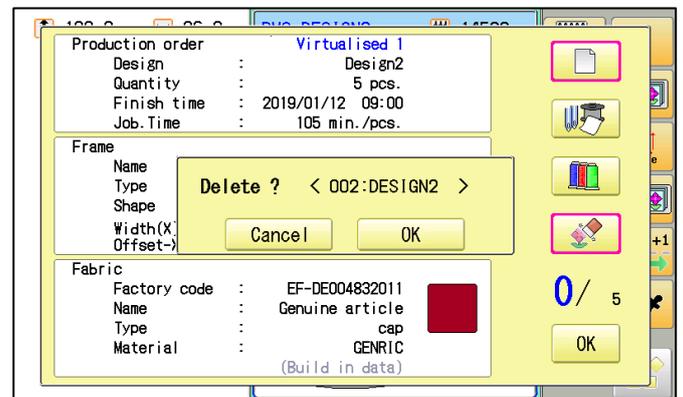
1. Please select “Independence type (Machine side Cancelable)” appearing in “Mode of connected machine” in “Option” through Happy PMS if you would like to cancel order(s).



2. Cancellation icon will appear in production order display at an embroidery machine when order(s) is transferred with “Independence type” activated.



3. Order(s) can be deleted when cancellation icon is selected. Cancellation will also be reflected in a computer (with Happy PMS in) to delete order(s) automatically after order(s) is deleted.



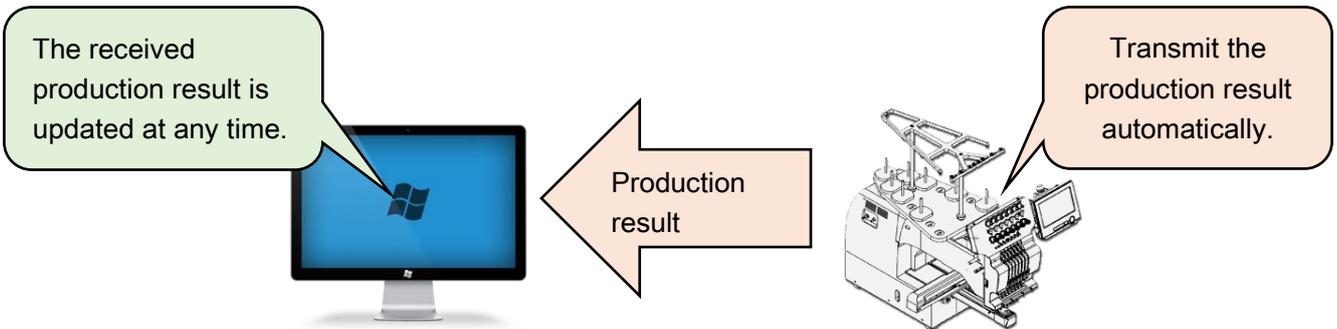
4. Cancellation will also be reflected at an embroidery machine when order(s) to have been transferred is forcibly cancelled and deleted at a computer (with Happy PMS in). In this case, an announcement message will appear if operation display appears at an embroidery machine.

*The above mentioned cancellation will be available at both “Instruction type” and “Independence type” in “Mode of connected machine”.



Step 10 Monitoring and progress management

No additional operation is required for receiving a production result from an embroidery machine to PC because the data is transmitted automatically.



Production schedule list

The status of the production orders can be checked in the system window as well.

PRODUCTION MANAGEMENT SYSTEM						
Execution (E)		Pattern (P)	Report (R)	Create Product orders (C)	Database (D)	View(V)
Production schedule list						
Confirm						
Machine name	Sewing time	No. 1	No. 2	No. 3		
HCH-DEBUG-90654 Status : Waiting 0 / 104268	2018/05/25 17:00 138 min	PRD012 PTA-32320 0 / 10 60 min	PRD008 0 / 6 78 min			
DEMO-9M2443 Status : Waiting 0 / 17625	2018/05/25 15:27 45 min	PRD002 PTA-21 0 / 10 40 min	PRD004 SQ clamp L (HCS,H 0 / 5 5 min			

After completing a production order, the finished task will be deleted automatically.

Then new production order is transmitted automatically if next production order is already registered with the system.

Report

Completed order(s) can be monitored.

REPORT

File(F) View(V)

Report

Start: 2017年7月31日 End: 2018年5月25日

Machine	Date	Production orders	User	Starting	Finish	Total time	Total machine stop time	Total machine stop time
DEMO-9M2443	2018/05/22	cune	AAA	09:08	09:09	00:00:28	00:00:28	99
HCH-DEBUG-90654	2018/05/23	BAPE		10:25	10:27	00:01:44	00:01:44	99
HCH-DEBUG-90654	2018/05/23	BAPE		10:27	10:27	00:00:14	00:00:14	99
HCH-DEBUG-90654	2018/05/23	BAPE		10:27	10:27	00:00:07	00:00:06	98
DEMO-9M2443	2018/05/24	test	AAA	10:43	10:44	00:00:11	00:00:11	99
DEMO-9M2443	2018/05/25	PRD002	AAA	14:33	14:34	00:00:43	00:00:43	99

DEMO-iMX512

- Sewing time (%)
- Total machine stop time (%)
- Thread break stop (%)
- Error stop (%)

DEMO-9M2443

- Sewing time (%)
- Total machine stop time (%)
- Thread break stop (%)
- Error stop (%)

HCH

- Sewing time (%)
- Total machine stop time (%)
- Thread break stop (%)
- Error stop (%)

Time line

Time line day: 2018年5月9日

DEMO-iMX512

09:00	10:00	11:00	12:00	13:00	14:00	15:00
800		MANS-DESIGN				
		09:44	10:38			
		10:18	12:15			

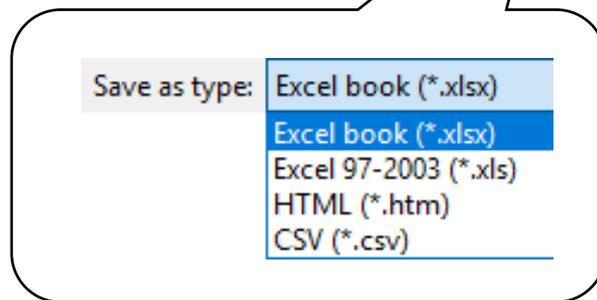
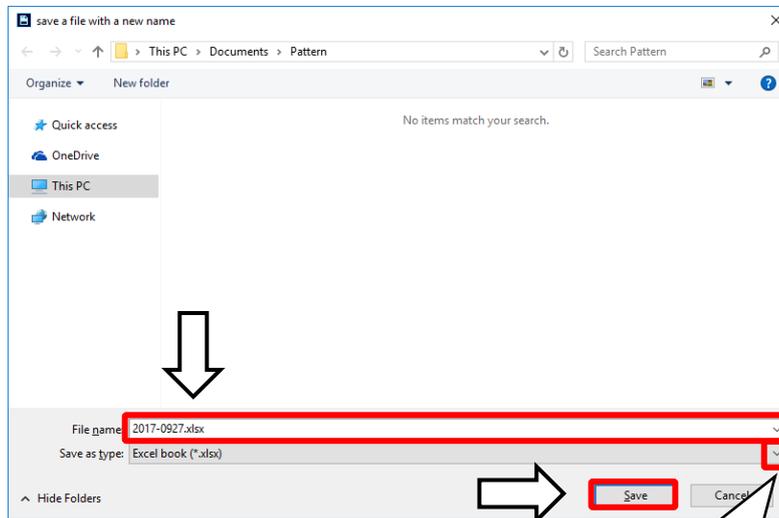
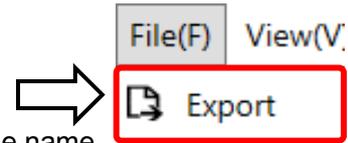
DEMO-9M2443

09:00	10:00	11:00	12:00	13:00	14:00	15:00
apple2		HANABI2				
		09:07	10:48			
		10:20	11:55			

Report Output

Report can be output in a specified file format.

1. Please select "File".
2. Please select "Export".
3. Please select a format in which a report should be saved with a file name.



Save as type:

Excel book(*.xlsx)	Extension of excel book to have been generated by Excel 2007 or its subsequent version
Excel 97-2003(*.xls)	Extension of excel book to have been generated by Excel 95, 97, 2000, 2002 and so on
HTML(*.htm)	Extension in a format to write web page
CSV(*.csv)	Extension of text data and text file in which some items are separated by comma “,”

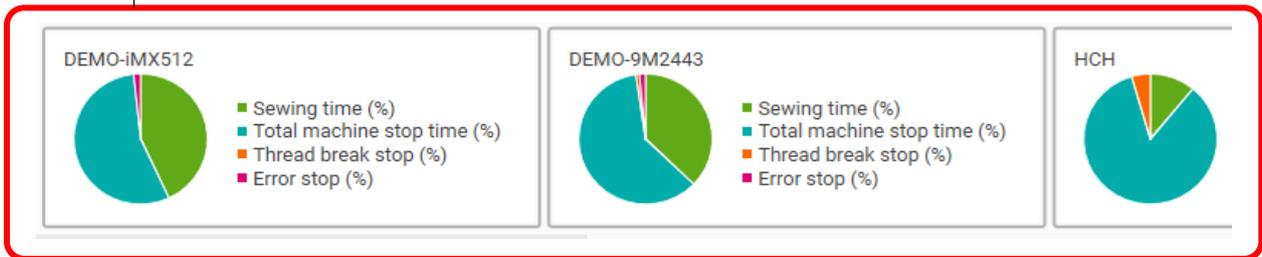
Display

Report can be output in a specified file form.

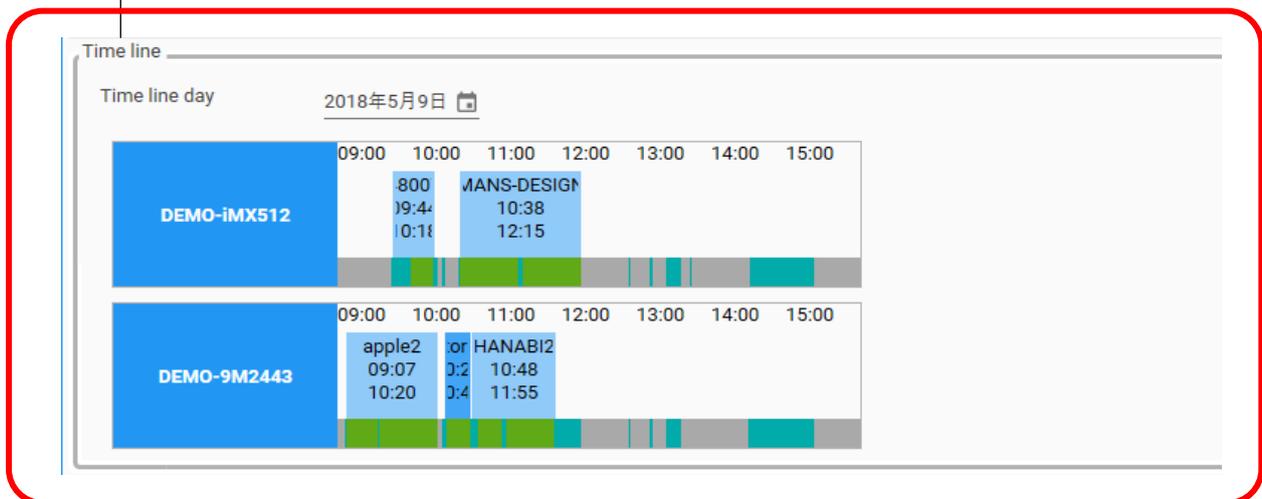
1. Please select "View".
2. Please put a check mark in.
3. Your selected information will appear.



Pie



Time line



Report

Duration Selection

Please specify a start date and an end date which you would like to monitor.

Delete Button

Selected line can be deleted.

The screenshot shows a 'Report' window with a date selection area at the top (Start: 2017年7月31日, End: 2018年5月25日) and a table of production data. A pie chart below the table shows 'Sewing time (%)', 'Total machine stop time (%)', 'Thread break stop (%)', and 'Error stop (%)'. A callout box points to a row in the table with the text 'Some lines can be selected.' and shows a detailed view of that row's data.

MACHINE	DATE	PRODUCTION ORDERS	STARTING	FINISH	TOTAL TIME	TOTAL MACHINE STOP TIME	TOTAL MACHINE STOP TIME (%)	SEWING TIME
HCH	9/26/2017	PRD0010	08:35	08:50	00:15:14	00:02:50	18	00:12
HCH	9/26/2017	PRD0011	08:50	08:54	00:03:59	00:02:12	55	00:01
HCH	9/26/2017	PRD0012	08:54	11:28	02:33:35	01:29:27	58	01:02
HCH	9/26/2017	PRD0012	11:29	11:42	00:13:27	00:09:21	69	00:04
HCH	9/26/2017	PRD0013	11:42	12:00	00:18:03	00:02:47	15	00:15
HCH	9/26/2017	PRD0013	12:46	14:49	02:03:48	02:03:48	99	00:00

Item

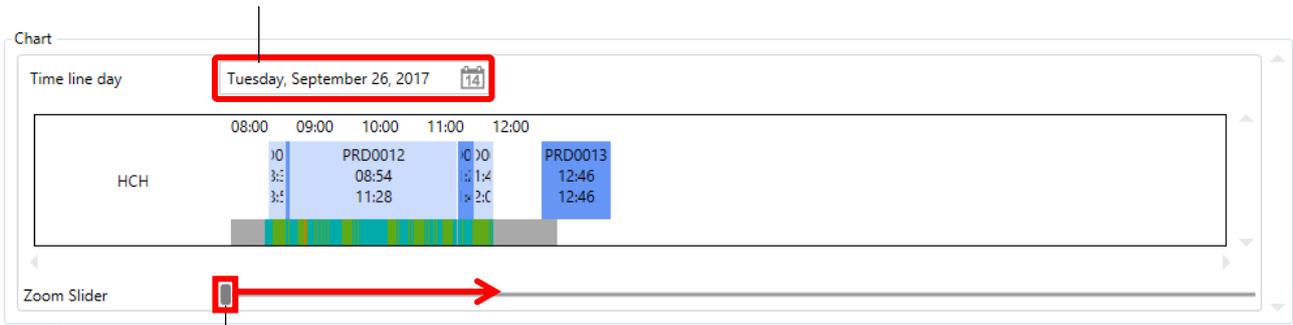
- [MACHINE] : Machine name
- [DATA] : Date
- [PRODUCTION ORDERS] : Production order(s)
- [USER] : An operator who carry out production order(s)
- [STARTING] : Stitch start time *1
- [FINISH] : Stitch completion time
- [TOTAL TIME] : Total time of stitches
- [TOTAL MACHINE STOP TIME] : Total time of machine stop *2
- [TOTAL MACHINE STOP TIME (%)] : Total time of machine stop time to be divided by a total time of stitches
- [SEWING TIME] : Stitch time
- [SEWING TIME (%)] : Stitches time to be divided by a total time of stitches
- [FINISH Q'TY] : Completed production quantity
- [ERROR STOP] : Emergency stop time
- [ERROR STOP (%)] : Emergency stop time to be divided by a total time of stitches
- [ERROR COUNT] : Emergency stop frequency
- [THREAD BREAK STOP] : Machine stop time due to thread break
- [THREAD BREAK STOP (%)] : Machine stop time due to thread break to be divided by a total time of stitches
- [THREAD BREAK COUNT] : Machine stop frequency due to thread break

*1 : It will start to count when a machine receives a production order.

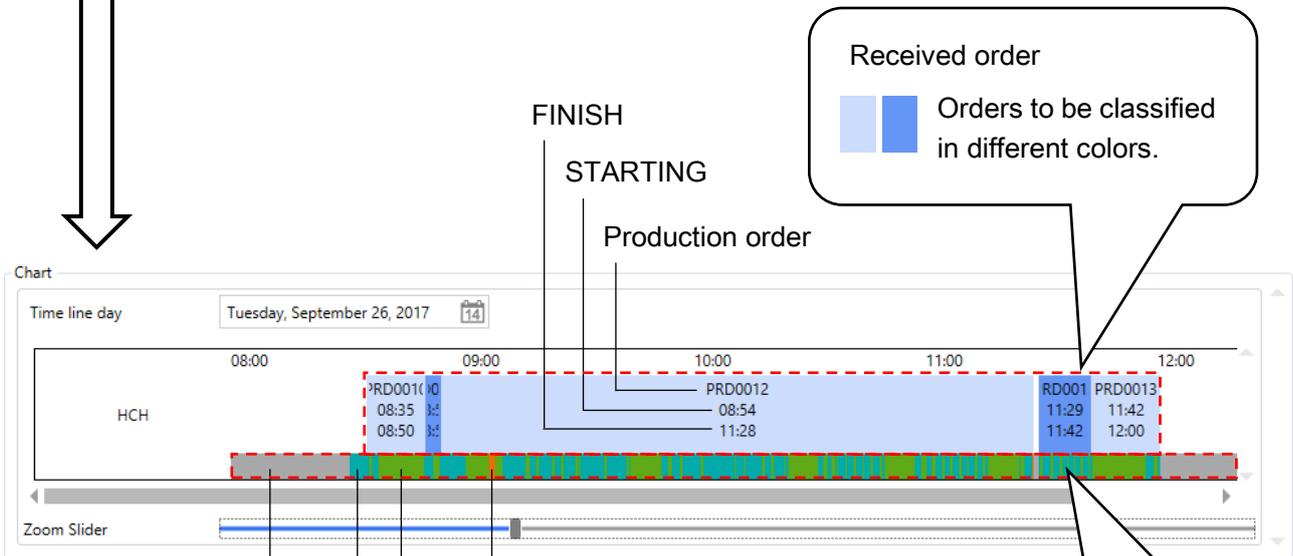
*2 : Changeover time excluding emergency stop

Chart (Time line day)

Please specify a date to be displayed

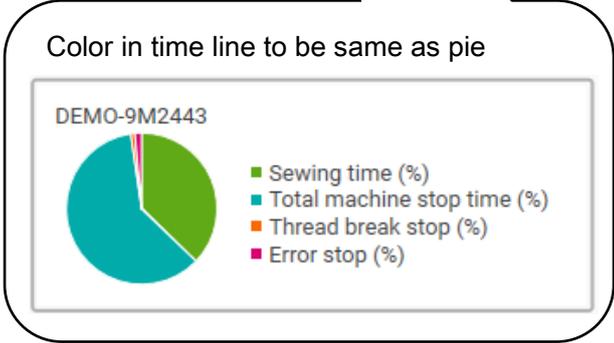


Time line will become large or small.



Received order
 Orders to be classified in different colors.

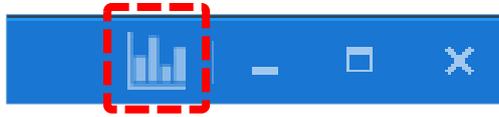
- Thread break stop
- Sewing time
- Total machine stop time
- Embroidery machine and Happy PMS are disconnected.



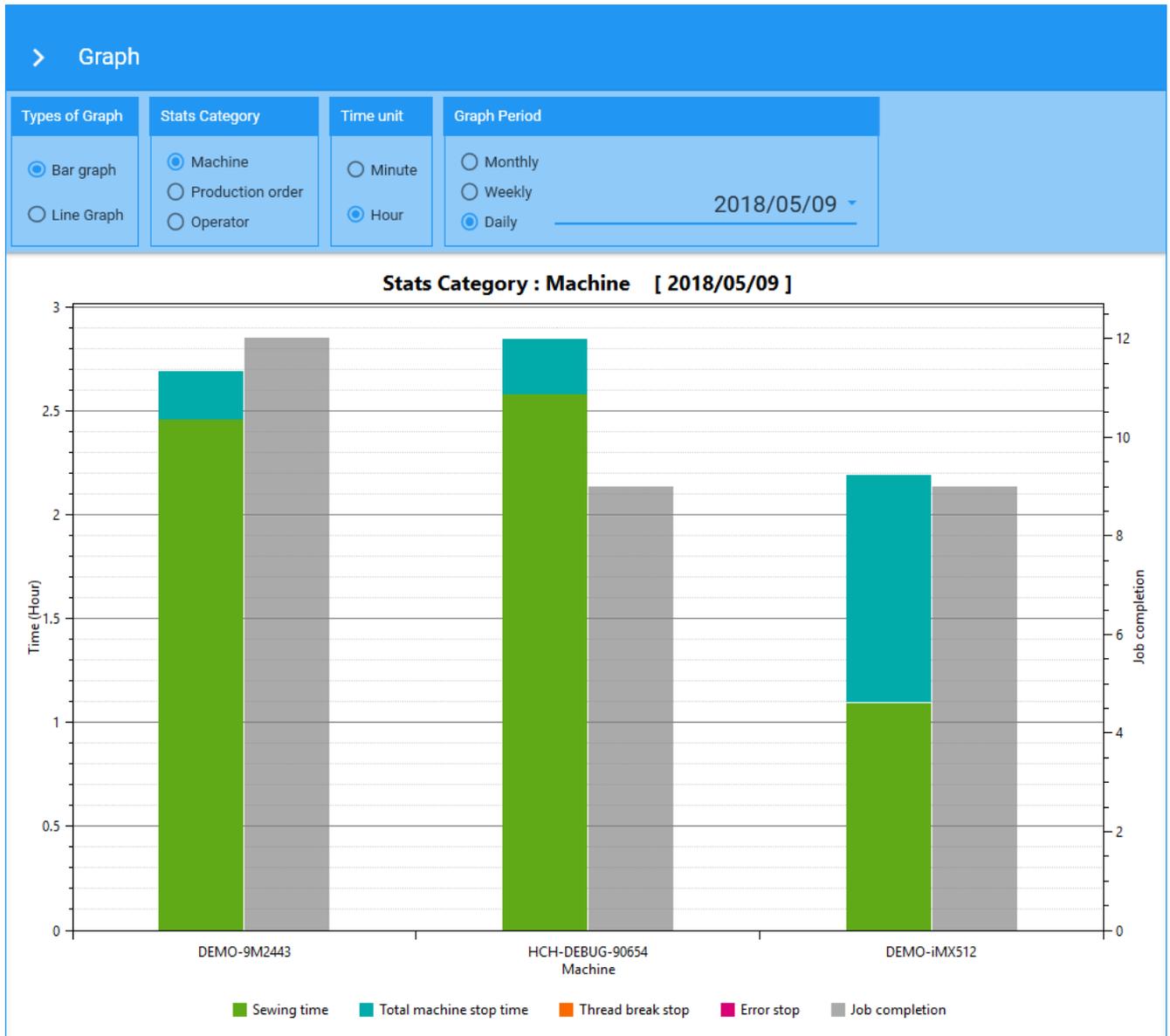
Graph

Report can be displayed with a graph.

1. Please select  in the upper right side to let a graph appear.



2. Graph will appear.



Setting items for graph

Graph forms to be selectable
1. Bar graph
2. Line graph

Unit in time to be selectable
(Available in a bar graph)
1. Minute
2. Hour

Types of Graph	Stats Category	Time unit	Graph Period
<input checked="" type="radio"/> Bar graph <input type="radio"/> Line graph	<input checked="" type="radio"/> Machine <input type="radio"/> Production order <input type="radio"/> Operator	<input type="radio"/> Minute <input checked="" type="radio"/> Hour	<input type="radio"/> Monthly <input type="radio"/> Weekly <input checked="" type="radio"/> Daily 2018/05/25 ▾

Categories to be selectable
(Available in a bar graph)
1. Machine
2. Production order
3. Operator

Duration to be selectable
(Available in bar graph)
1. Monthly
2. Weekly
3. Daily
+ specified date (date, week and month)

Graph setting will not be available if "Line graph" at "Type of Graph" is selected.
(To be colored in grey in selecting "Line graph")

Types of Graph	Stats Category	Time unit	Graph Period
<input type="radio"/> Bar graph <input checked="" type="radio"/> Line graph	<input checked="" type="radio"/> Machine <input type="radio"/> Production order <input type="radio"/> Operator	<input type="radio"/> Minute <input checked="" type="radio"/> Hour	<input type="radio"/> Monthly <input type="radio"/> Weekly <input checked="" type="radio"/> Daily 2018/05/09 ▾

Bar graph

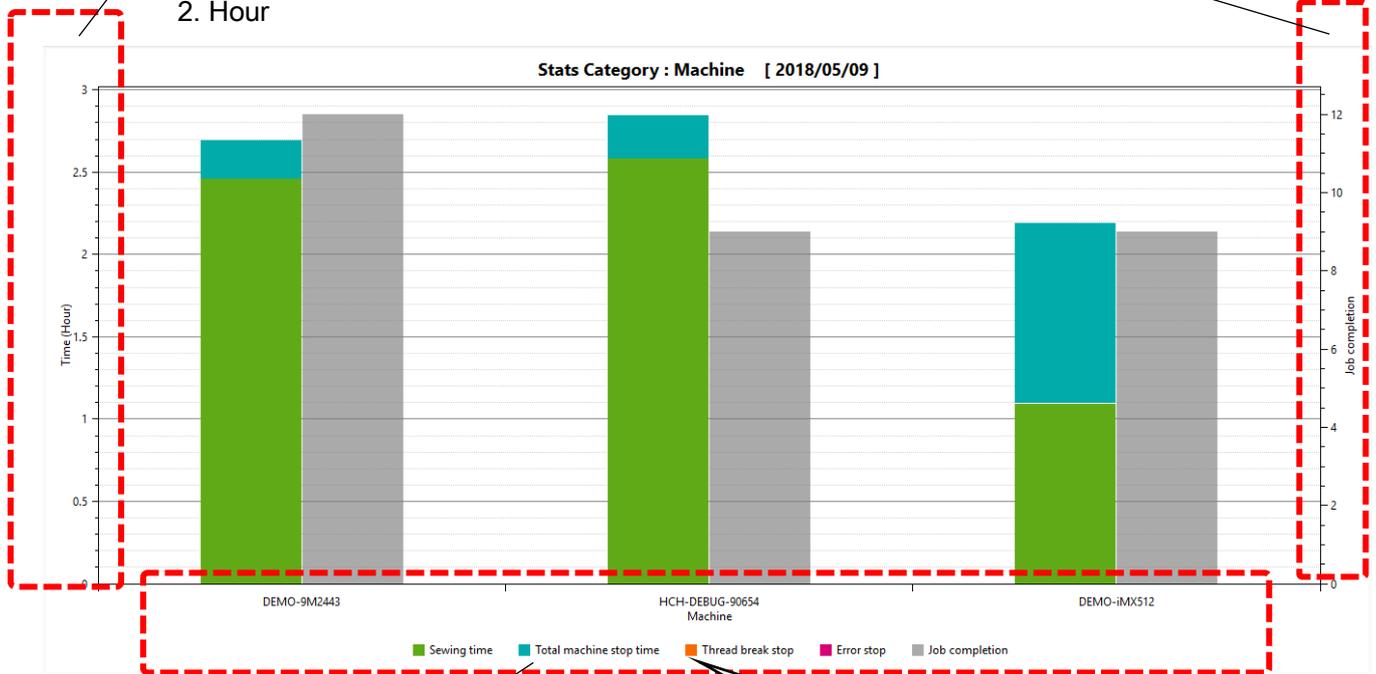
Time (xxxxx)

Unit in time to appear in a vertical way

- 1. Minute
- 2. Hour

Job completion

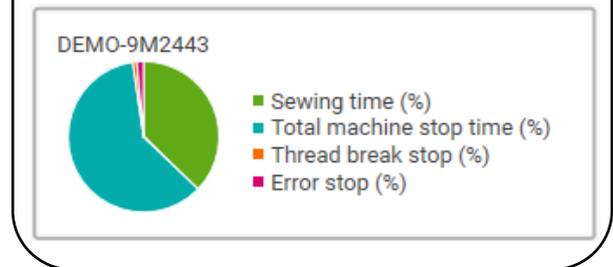
Completed quantity to appear in a vertical way



Categories to appear in a lateral way

- 1. Machine
- 2. Production order
- 3. Operator

Color in a graph to be same as pie



- Sewing time
- Total machine stop time
- Thread break stop
- Error stop

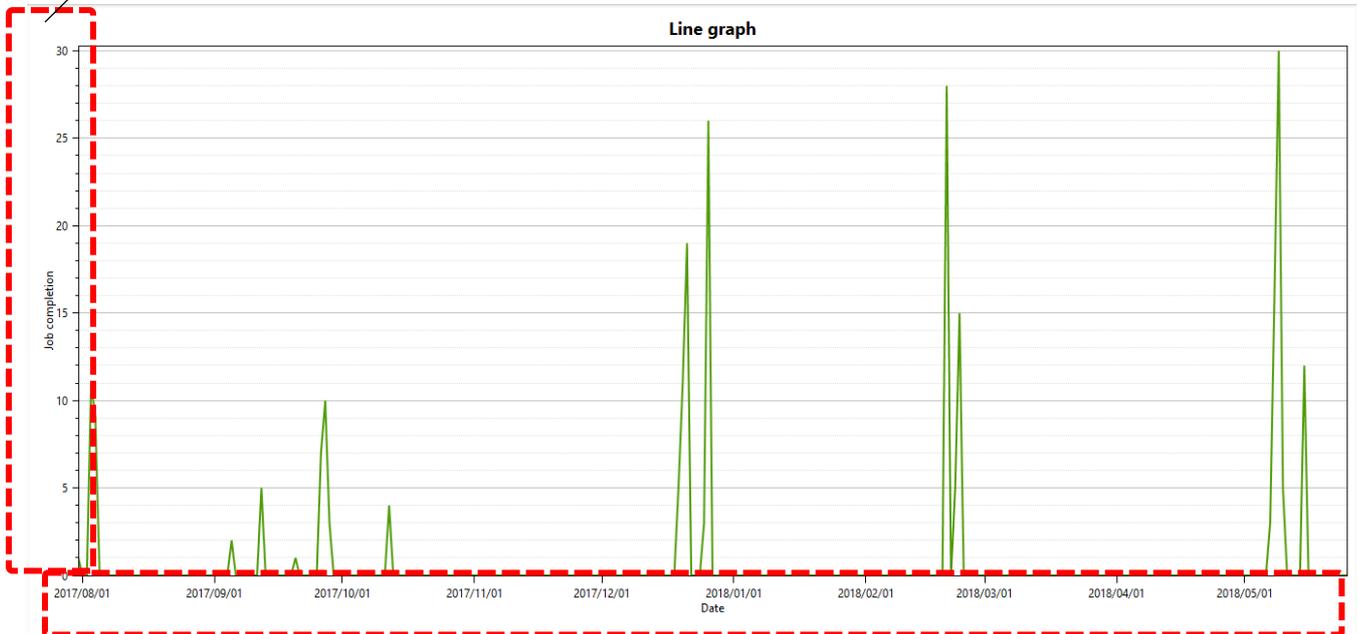
Time (xxxxx)

Job completion

- Completed quantity

Line graph

Job completion
Completed quantity to appear in a vertical way



Date to appear in a lateral way

chapter 3. Help

Trouble shooting

No.	Problem	Cause	Correction
1.	Cannot transmit database information.	<ul style="list-style-type: none"> Embroidery machine isn't Drive mode. Design data status isn't "Top". Displaying error message. 	<ul style="list-style-type: none"> Go to Drive mode. Confirm that there is indication of "Top" in the display.
2.	Cannot set thread information in THREAD SET screen.	<ul style="list-style-type: none"> There is not Database in embroidery machine. 	<ul style="list-style-type: none"> Refer to P.38.
3.	Cannot register production order.	<ul style="list-style-type: none"> Thread data isn't entered to all color change of the design data. 	<ul style="list-style-type: none"> Enter thread data to all color change of the design data.
4.	Cannot choose frame in production order data.	<ul style="list-style-type: none"> No check the frame data checkbox in Database. 	<ul style="list-style-type: none"> Check the frame data checkbox in Database.
5.	Cannot choose fabric in production order data.	<ul style="list-style-type: none"> No check the fabric data checkbox in Database. 	<ul style="list-style-type: none"> Check the fabric data checkbox in Database.
6.	Cannot choose material in production order data.	<ul style="list-style-type: none"> No check the material data checkbox in Database. 	<ul style="list-style-type: none"> Check the material data checkbox in Database.
7.	Cannot allocate production order data to production schedule list from production order list.	<ul style="list-style-type: none"> The production order data has been allocated already. 	<ul style="list-style-type: none"> Newly register or back production order to production order list then allocate again.
8.	When frame information is defined in production order, embroidery machine doesn't update setting of frame automatically.	<ul style="list-style-type: none"> Frame that is defined in production order isn't matching frame. 	<ul style="list-style-type: none"> Refer to P.23, 57
9.	Cannot transmit production order.	<ul style="list-style-type: none"> Embroidery machine isn't Drive mode. Design data status isn't "Top". Displaying error message. "confirm" isn't selected. 	<ul style="list-style-type: none"> Go to Drive mode. Confirm that there is indication of "Top" in the display. Select "confirm".

Initialization of Happy PMS (Embroidery Machine)

Please delete data relating to Happy PMS existing in LCD module. Initialization of Happy PMS will be required if you find that content(s) of production order(s), assigned color(s) and so on to have been transferred from a computer does not match content(s) of production order(s), assigned color(s) and so on at machine side. Please delete design data at design data management if there is any design data left in a machine.

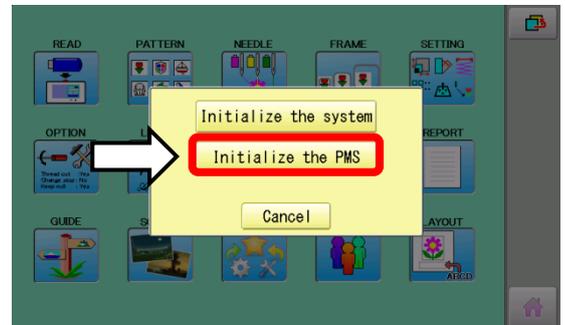
1. Select [OTHER] from menu of the embroidery machine.



2. Select [Version].



3. Please select "Initialize the PMS" in system display. Once it is selected, Happy PMS data existing in LCD module will be able to be initialized.



Terms

- design data...Data is belonged to .tap, .dst, .dsb, or .dsz format.
- embroidery data...tth data that is set thread information to color change number of design data.
- production order data...The data is contained embroidery data, production order number, quantity, and etc. to send embroidery machine.
- database...This is the group of thread, frame, and fabric information for using production order.
- thread location data...This is thread information with each needle number.
- allocation order...This is allocating production order data to connected embroidery machine with PC(Happy PMS).
- defined frame...This is frame that is defined to production order data
- default frame...This is standard frame for Happy embroidery machine.
- matching frame...This is frame that is matched to each type embroidery machine in default frame.