



Shop Floor Bar-coding

An Application Note

The MISys Bar-coding System can be used quite effectively to record transactions on the shop floor, thereby speeding operations and reducing keying errors to a statistical minimum (one in 4 million). The Bar-coding System is an extra-cost option for the MISys Manufacturing System consisting of hardware and software components required to print and collect bar-coded data in a manufacturing environment.

Hardware Options

For a Shop Floor Control application, two hardware options of the MISys Bar-coding System are



available: 1) a hand-held, battery-powered, portable collection device (PCD) functioning in non-portable mode, or 2) a laser scanner functioning as a keyboard wedge.

The advantage of the laser scanner option is that it can read bar-coded labels from a distance of up to 10 inches, whereas the PCD's bar-code reading wand requires near-contact with the bar-code label. The advantage of the PCD option is that it can also function in portable mode to collect physical inventory data (see over). The laser scanner option is preferred for Shop Floor applications.

Software Components

The software components of the Bar-coding System communicate with the host computer and print bar-code labels and reports.

The Bar-coding System's laser scanner connects to your keyboard via a Y-cable. The great advantage of this "keyboard wedge" arrangement is that the MISys program need not distinguish between characters being typed and those being scanned. Any scanned characters appear to the program as though they had been typed.

Bar-coded Shop Traveler

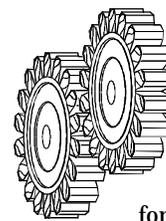
The key to using the MISys Bar-coding System for Shop Floor Control is to print a bar-coded Shop Traveler for each Manufacturing Order (MO) currently in production. When the Bar-coding System is installed, a bar-code enabled Shop Traveler replaces the standard traveler and a Code 3 of 9 bar-code font is loaded. Thereafter, MISys prints travelers with bar-code information inserted for the MO and Operation number.

Recording Shop Operations

The Shop Operations icon, located on the MISys Production Desktop, opens a window in which progress on a specific Manufacturing Order is recorded. Required inputs for the MO number, Operation number, and Operator are normally entered

manually, but can be scanned quickly and accurately from the bar-code enabled Shop Traveler.

For example, the first operator scans the traveler for the MO number, then the operation he has just performed. The focus moves from the MO number field to the Operation number field, stopping in the Operator field. At this point the operator's name can be entered



manually, or a bar-coded employee badge can be scanned.

Additional fields for quantity and time information are entered manually. Materials related to the first operation are automatically moved from Stock to WIP. When the first operation has been completed, the traveler is passed to the next operator who records the completion of his operation. When the last operation is completed and the traveler is scanned, MISys removes all remaining WIP and updates the MO with the actual costs incurred in the production of the MO.

For Further Information

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