

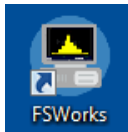
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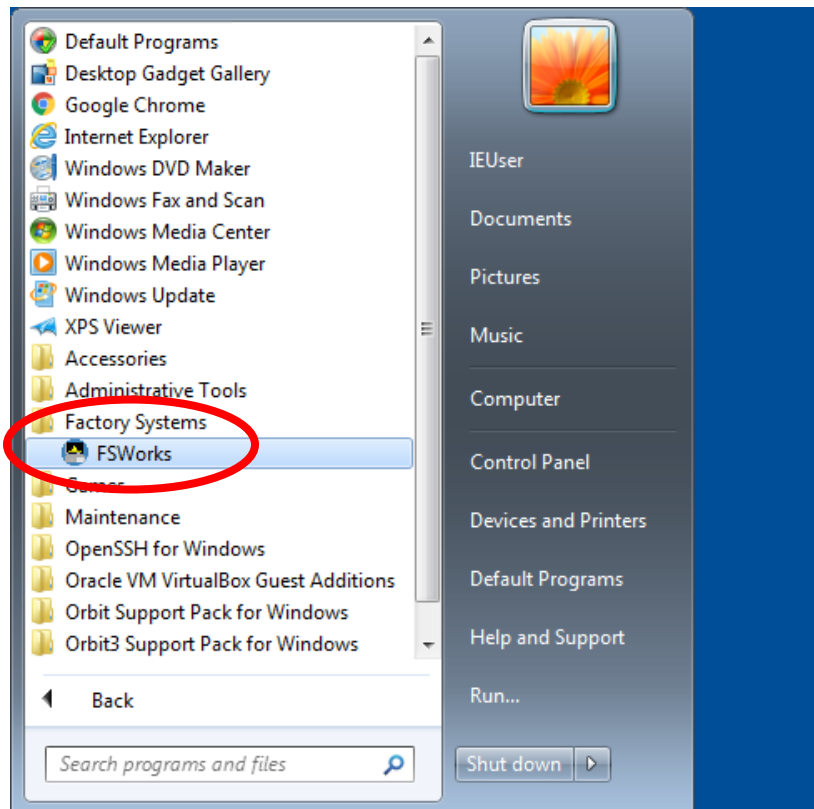
Launching FSWorks™

1) FSWorks™ can be launched either from the desktop or the start menu.

From the desktop, double click FSWorks™ shortcut.



From the start menu, Click START>>ALL PROGRAMS>>FACTORY SYSTEMS>>FSWORKS.



Accessing Supervisor Mode in FSWorks™

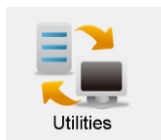
- 1) Click the Supervisor button. Enter the password (by default it is 711) and hit ENTER or click OK. You will notice the icon change to a badge.



Uploading Images

The upload images function is important for backing up the configuration of the FSWorks™ workstation. The image only contains the information relative to the FSWorks™ software and will not contain a copy of the operating system or related files.

- 1) Press the “Utilities” button on the main screen. You must be in supervisor mode.



- 2) Click the “Upload Image” button. You will be presented with the screen illustrated below. Click “Create New Image”. This will give you an option to name the image and add comment. Click “OK” to complete the upload.

You are about to upload the entire Workstation image from your local PC to the server.
Please select the image name you wish to overwrite or select Create New.

Dept	Network	Address	Image Name	Date	Comments

Images for this Workstation

Images for this Department

Source (From) :

Destination (To) :

Keyboard

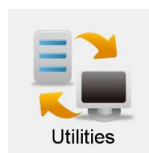
Upload Now

Create New Image

Cancel

Downloading Images

Download images is critical for restoring the settings for a Factory Systems™ workstation. Note: the settings that are restored are only relevant to the FSwork™ software. Setting related to the operating system and associated files is not included in an FSWorks™ image download.



- 1) Press the UTILITIES button on the main screen.
(mode)

(You must be in supervisor

- 2) Click the DOWNLOAD IMAGES button. You will now see a screen that lists all the available images for the workstation. Note: you have the option of copying images from other workstations and/or departments as well.

You are about to download image from the server to the local PC.
Please select the image name you wish to download then click Download. This action will overwrite the current image and restart FSWorks.

Dept	Network	Address	Image Name	Date	Comments
S E A R C H	Manufacturing				

Images for this Workstation

Images for this Department

Local Backup Images

Source (From)

Destination (To)

Local Measurement Data
 Workstation Image Data

Download Now

Cancel

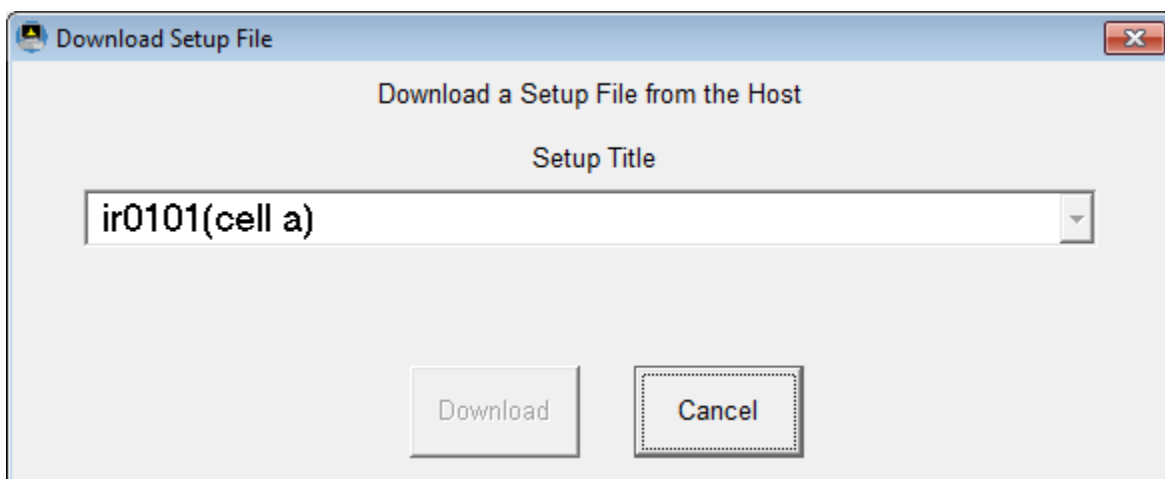
Downloading Setups

Setups contain the Specs (POMF groups) that are used to organize variable/attribute data collected at the FSWorks™ station. The Setups are configured from the FACS™ web interface

- 1) Press the DOWNLOAD SETUP button on the main screen.

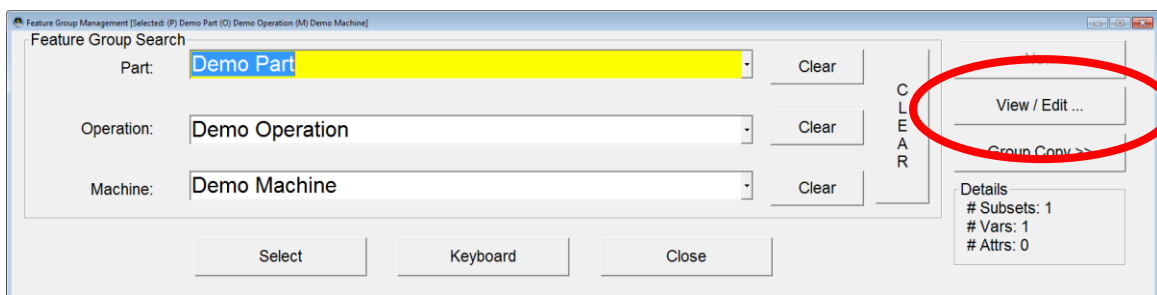


- 2) You will see the screen below. You can now select the setup designated for your workstation (usually there's only one). Click the DOWNLOAD button to start the download. Once the download completes, you will be prompted to select the POM you would like to use. Remember to hit CLEAR if you don't see the POM you are looking for.



Editing a Spec (POMF)

- 1) Click on the SETUP button from the main screen then click on SPEC MANAGEMENT
- 2) Select the POM you would like to work with. Remember, click the clear button to refresh the list if you don't see the POM you want to work with.
- 3) Click the View/Edit button



- 4) You will now see the features for the POM you have selected. By clicking on the features, you can change the specifications for the features. When you are finished modifying the features, click CLOSE. You will be prompted to save changes.

Demo Part - Demo Operation - Demo Machine

Feature Group

- Default Subset
 - Demo Feature

New Subset

Rename Subset

Delete Subset

New Var Feature

New Attr Feature

Rename Feature

Delete Feature

Move Up

Move Down

Move to Subset ...

Save

Close

Feature Properties

Specs | Extra Limits | Inputs | Part Present / Confirm | Secondary Parameters | Alarms | Logic

Specs

Feature	Title	User Defined Field
Demo Feature		User

Spec Limits	Preset Ctrl Limits	Feature Code
USL <input type="text" value="10.000"/>	UCLxp <input type="text" value="8.750"/>	1
LSL <input type="text" value="0.000"/>	LCLxp <input type="text" value="1.250"/>	Nominal
TOL <input type="text" value="10.000"/>	TOLxp <input type="text" value="7.500"/>	<input type="checkbox"/> Custom
<input type="text" value="0.000"/>	Calculate @ 75 %	<input type="text" value="5.000"/>

Preset r Limits	Preset s Limits	Parameters
UCLrp <input type="text" value="10.000"/>	UCLsp <input type="text" value="10.000"/>	Subgroup Size <input type="text" value="5"/>
LCLrp <input type="text" value="0.000"/>	LCLsp <input type="text" value="0.000"/>	Precision <input type="text" value="3"/>
TOLrp <input type="text" value="10.000"/>	TOLsp <input type="text" value="10.000"/>	Moving Sub Size <input type="text" value="2"/>

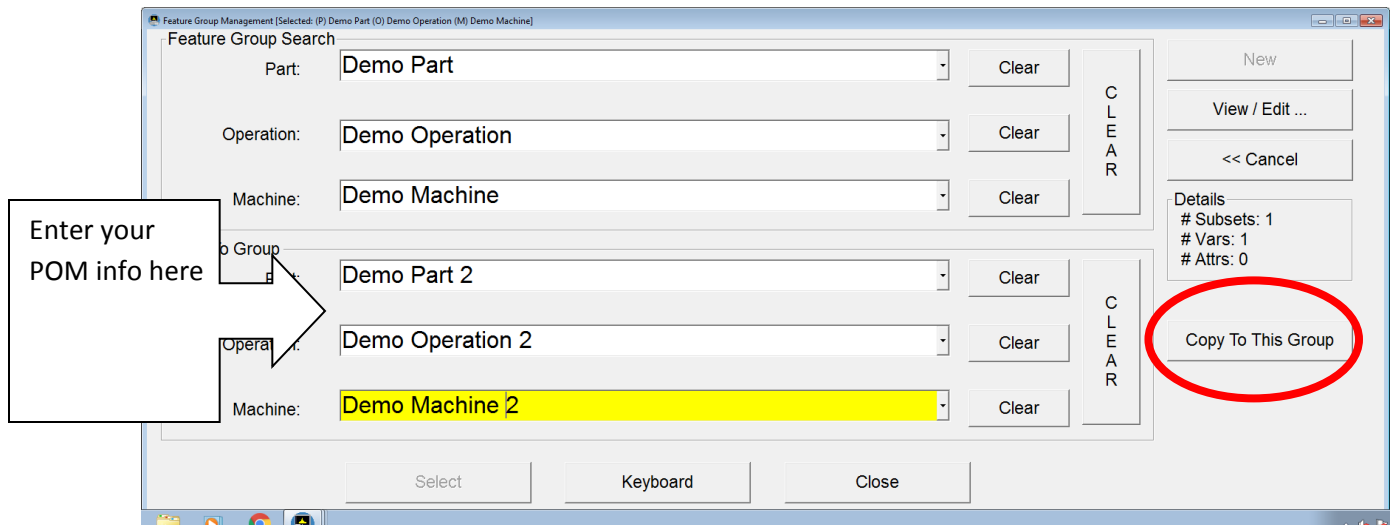
Offset + Deviation
 Master Actual
 Unilateral USL Normal Non-Normal

Visible
 Automated
 Host Storage
 Include in seq

Valid? Keyboard

Copying a Spec (POMF)

- 1) Click SETUP on the main screen then click SPEC MANAGEMENT
- 2) Select the POM you want to work with, then hit GROUP COPY. The screen will convert to the view below.

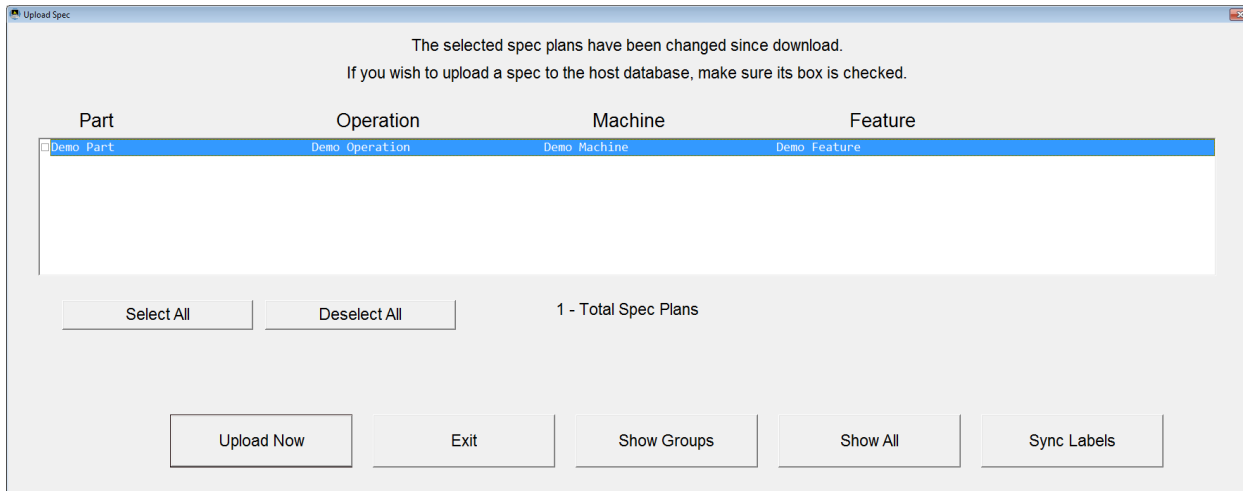


- 3) Now type in the information for the new POM group. Note: if the new POM group has something similar to an existing POM, just click the dropdown and select the matching component. For example: if the new POM has a new part and operation but the same machine, then type in the new part and operation and select the machine from the dropdown list.
- 4) Once you are complete with entering the new POM, click COPY TO THIS GROUP

Uploading a Spec (POMF)

This function is important for the FACS™ web interface. If you make changes to your spec plans at the FSWorks™ workstation, it's important to upload said specs so the changes will reflect properly in FACS™.

- 1) Click on UTILITIES on the main menu then click on UPLOAD SPEC. You will see the screen below. You can select the POM's that you want to upload then click UPLOAD NOW. When the upload is complete click OK.



The selected spec plans have been changed since download.
If you wish to upload a spec to the host database, make sure its box is checked.

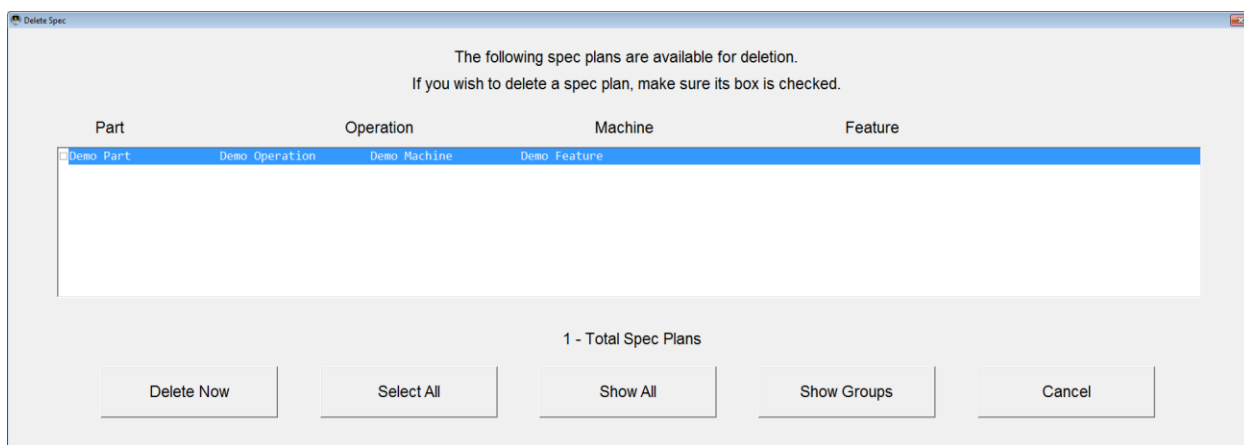
Part	Operation	Machine	Feature
<input checked="" type="checkbox"/> Demo Part	Demo Operation	Demo Machine	Demo Feature

Select All Deselect All 1 - Total Spec Plans

Upload Now Exit Show Groups Show All Sync Labels

Deleting a Spec (POMF)

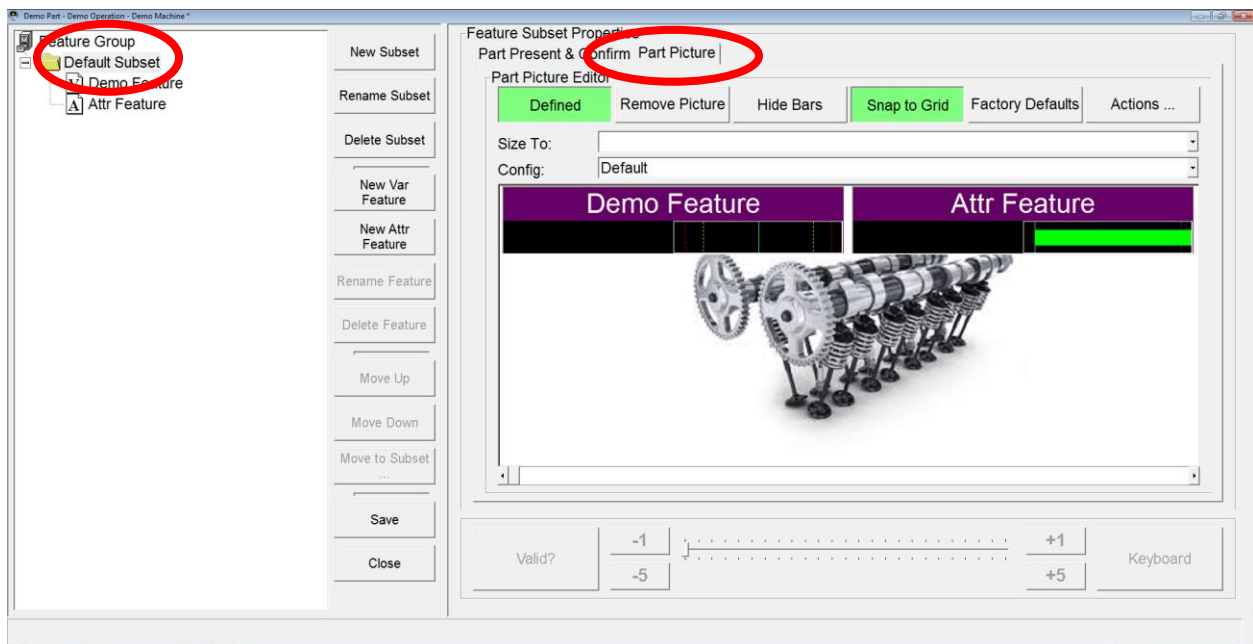
- 1) Click on UTILITIES on the main menu then click on DELETE SPEC
- 2) You will now see a list of all the specs. Click on each spec you want to delete



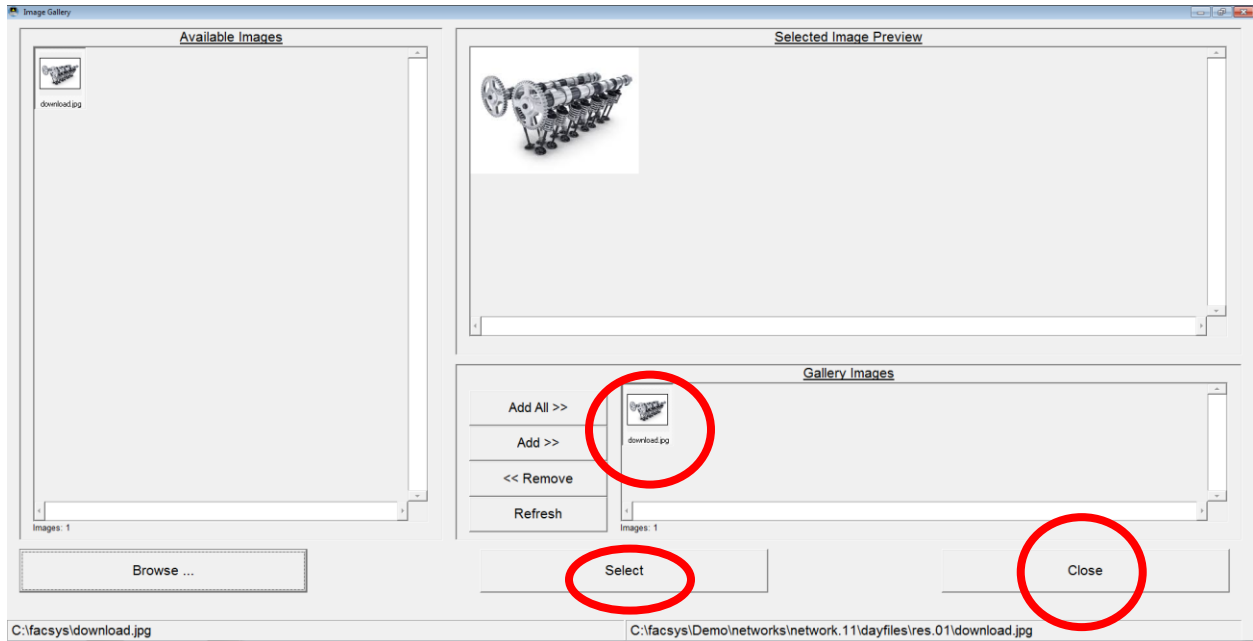
- 3) Click DELETE NOW to remove the specs from the list of available spec plans. Answer all of the warnings accordingly. After the specs are deleted you can click CANCEL.

Adding Part Pictures to a spec (POMF)

- 1) Locate the POM you want to edit in SPEC MANAGEMENT then click VIEW/EDIT
- 2) Click on the subset folder(s) to set the part picture. After clicking the subset folder, you must click the PART PICTURE tab on the top right side of the screen.



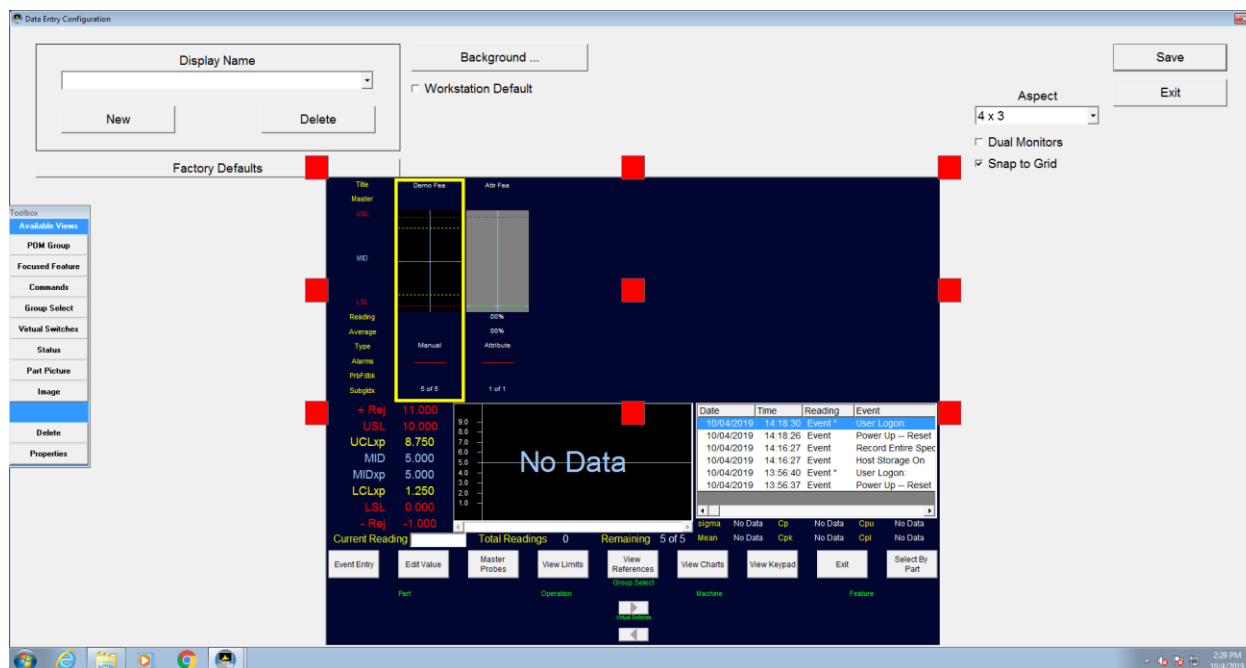
- 3) Click the DEFINED button, and then click the SELECT PICTURE button to access your pictures. You will now be able to browse to the folder that contains your pictures. After browsing, the pictures will show up on the left-hand side of the screen. Click the pictures you would like to be contained in the library then click ADD. Now select the picture you would like to show up for the feature from the library and click SELECT



- 4) You can click the CLOSE button now, which will prompt you to save. Please Note: The part picture will not show up unless you have the data entry screen configured to show the part picture. Refer to the “configuring a data entry screen” section of this document.

Configuring a data entry screen

- 1) Click OPTIONS then click SCREEN CONFIGURATION then click VARIABLE ENTRY
- 2) You will now see the components that can be added or removed. Note: if you click on any of the available views, the associated object will highlight with red blocks. You can click on PROPERTIES button to see the options for that object.



- 3) After making changes, you must enter name in the DISPLAY NAME field. You also have the option to set the current screen as the default by clicking WORKSTATION DEFAULT.

FSWorks™ Functional Limits

- Probes: 200
- Solartron switches or probes per Orbit network: 31
***this limitation is imposed by Solartron. If more than 31 probes are to be connected an additional Solartron interface is needed for FSWorks™**
- Keyence Ethernet probes are limited to 15 probes per main unit
***this limitation is imposed by Keyence. If more than 15 probes are to be connected an additional Keyence interface is needed for FSWorks™**
- Ports: 16
Ports are used to accept data from files, RS232 devices as well as virtual devices
- Virtual, physical and logical Switches: 128
Switches are used to facilitate human or programmatic logic triggering
- Timers: 32
Timers are used by FSWorks™ for internal logic triggering
- Total Specification plans (in FSWorks™): 2000
If more than 2000 specs plans are needed on one workstation, the current spec plans must be cleared and a new setup downloaded to FSWorks™.