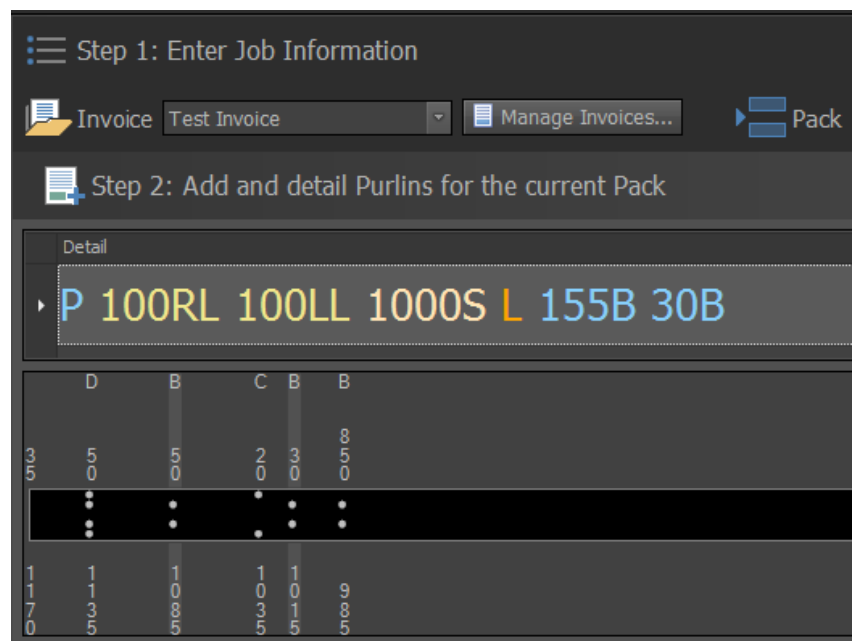


PURLIN DETAILER

Quick Start Guide

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1. Introduction
2. Installation
3. Getting Started
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Appendix A: Extended Examples

1. Introduction

This program is designed to provide an efficient means of detailing purlins according to the customer's invoice data. The purlins are further arranged into packs and feed material properties to allow the mill to enforce production requirements. Each invoice is structured in the following way:

Details of the Invoice:

- Invoice Number
- Customer Name
- Destination
- Date Required

Packs of purlins grouped by Feed

- Reference Code
- Profile Code
- Gauge Thickness
- Strip Width
- Feed Description (Optional)
- Surface Finish/Treatment (Optional)
- Material Colour (Optional)
- Weight per metre (Optional)

List of Detailed Purlins each containing:

- Mark Number/ String
- Purlin Hole Pattern
- Quantity
- Standard Comment
- Custom Comment
- Length (Calculated)
- Weight (Calculated)

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2. Installation Options

1. Local Database Storage (Default)

This option allows individual users to configure and maintain their own list of production invoices, packs and feeds with a single sign-in.

User Name: purlindetailer
Password: purlin2016

2. Network Database Storage (On Request)

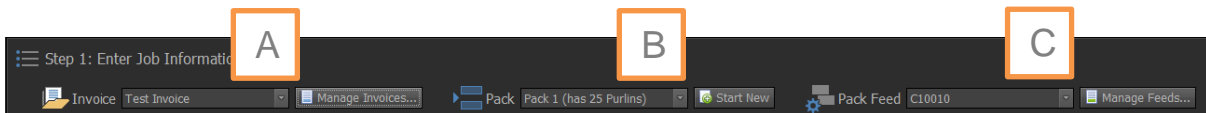
This option is available on request and will allow each user to access a central dataset of invoices, packs and feeds for shared access to the detailing workflow. Each user is provided a separate login under a role based security system to allow both office and production staff to access the data. An administrator account is provided in this case to configure and manage user accounts.

3. Getting Started

Step 1

The first step which has to be performed before detailing individual purlins is to enter the job information in the following sections:

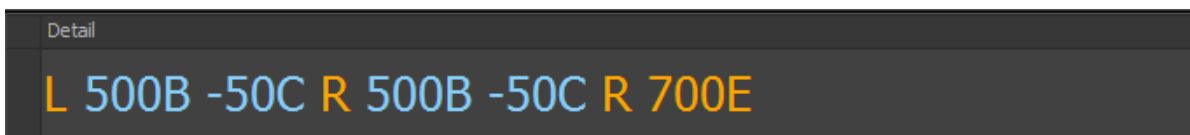
- A. Invoice
- B. Pack
- C. Feed



Invoice entries and feed material definitions will need to be created as needed.

Step 2

The second step allows the purlins to be detailed according to a hole punch pattern letter coding system which is described in the next section



Step 3

The third step displays a summary of the current job information and detailed purlins. The Export to CSV function creates a structured machine file in the local directory which can be used to produce the job on the mill.



4. Hole Patterns

A Purlin is created by specifying a description consisting of hole types with corresponding length specifications. The hole types which are available are A, B, C, D. Then length specification for each hole determines the position of the hole along the length of the Purlin. These lengths can be specified from particular reference points on the Purlin as explained in detail below.

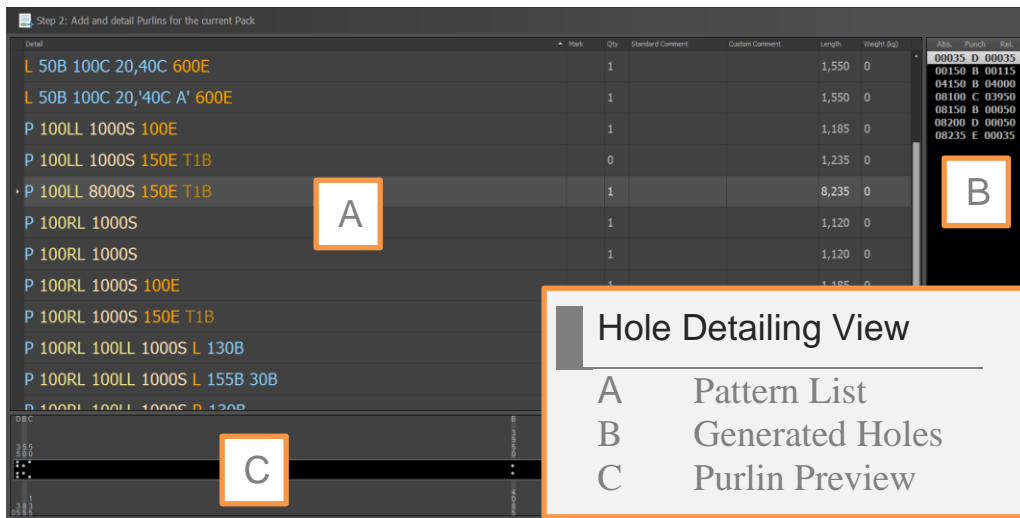


FIG 1 HOLE PUNCH PATTERNS (BHP SYSTEM)

The hole patterns shown are those used by the standard BHP System, which is commonly used in the industry. It is important to note however that the system for detailing in the office and the controller in the factory are absolutely oblivious to what punch patterns are actually installed in the punch die sets. For example, the 'D' punch could be fitted with an oval service hole, instead of a centreline hole.

For a complete list of the available letter codes see the mapping tables contained the settings section of the program. Extended examples are also provided in the appendix section as a practical guide.

The types of references which are available are 'L' – Left End or 'R' – Right End DYNAMIC reference markers. If neither of these references has been invoked, the default reference will be the last hole that was specified. Somewhere within the description of the Purlin the overall length must be specified. This is done by either specifying a length from a particular end or but consecutively specifying each hole position then terminating the detailing with an 'E' to designate the location of the end of the Purlin.

Failure to specify the end of a Purlin will result in an incomplete description of the Purlin. The only exception to this is when certain interior and end bay Purlin are created using the LL and RL commands in conjunction with the S – Span command.

In all cases, the end of the Purlin must only be specified once.

The first specification given to the structure is the inclusion of Standard End holes. If 'P' is specified then Standard End holes will be inserted 35mm for either end, otherwise these holes will be excluded.

The next specification is the first reference point e.g. R or L. If interior or end bay Purlins commands are to be used, then R or L should not be specified.

FIGS 2a and 2b show a basic example of a Purlin description with the inclusion and exclusion of Standard End holes.

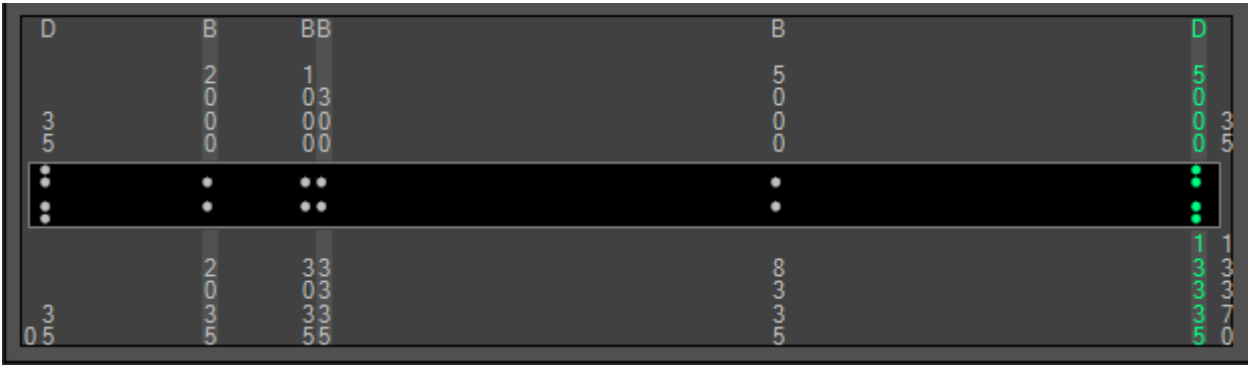


FIG 2a Purlin Pattern - PL2035B1000B300B5000B5035E

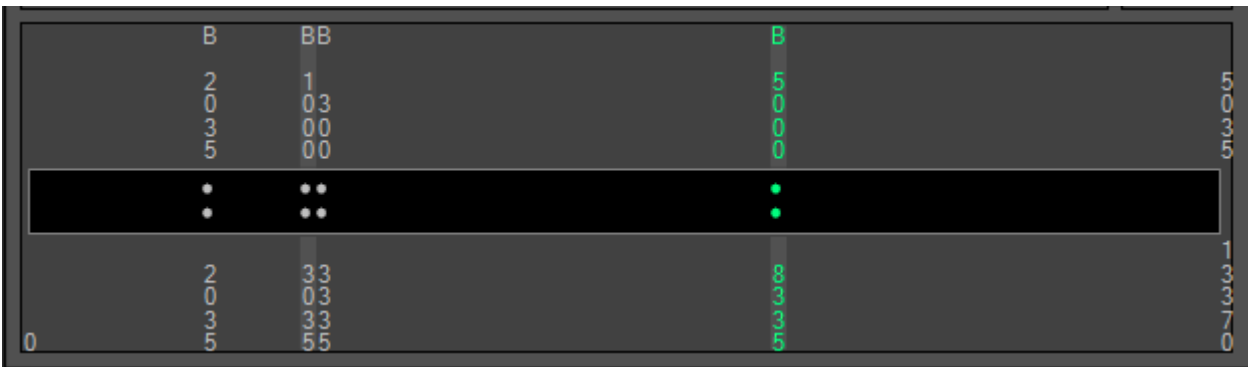


FIG 2b Purlin Pattern - L2035B1000B300B5000B5035E

If necessary, the hole distances can be specified using the “ONBOARD” calculator. The calculator has the following set of commands available:

1. Add Lengths: + , e.g. 4567+3456
2. Subtract Lengths: - , e.g. 3456-2456

NOTE: The total length of the Purlin must not exceed 99000mm. The type of example which might involve the use of the “ONBOARD” calculator is illustrated in FIG 3.

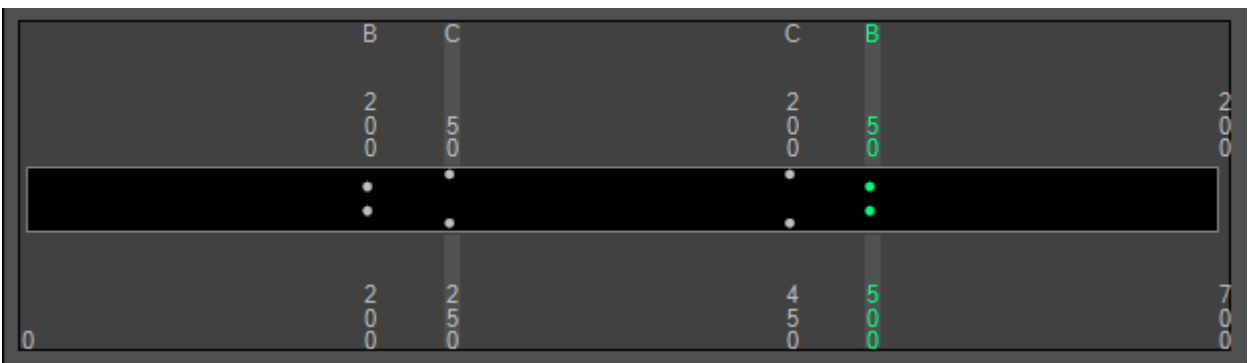


FIG 3 Purlin Pattern - L350+150B-50CR350+150B-50CR700E

Appendix A: Extended Examples

Extended Command List

1. L – LEFT END:
Sets the reference position to the left end of the purlin
2. R – RIGHT END:
Sets the reference position to the right end of the purlin
3. Sets the reference position to the right end of the purlin
4. RL – RIGHT LAP:
Generates the right lap hole configuration
5. LL – LEFT LAP:
Generates the left lap hole configuration
6. S – SPAN:
Gets the span length
7. OL – OFFSET LEFT SPAN REFERENCE:
Enables the user to pivot from the left span position
8. OR – OFFSET RIGHT SPAN REFERENCE:
Enables the user to pivot from the right span position
9. T – TOTAL BRIDGING COMMAND:
Places a user specified number of holes to be placed at equal distances between the right and left span references.

END BAY PURLIN (LEFT SIDE)

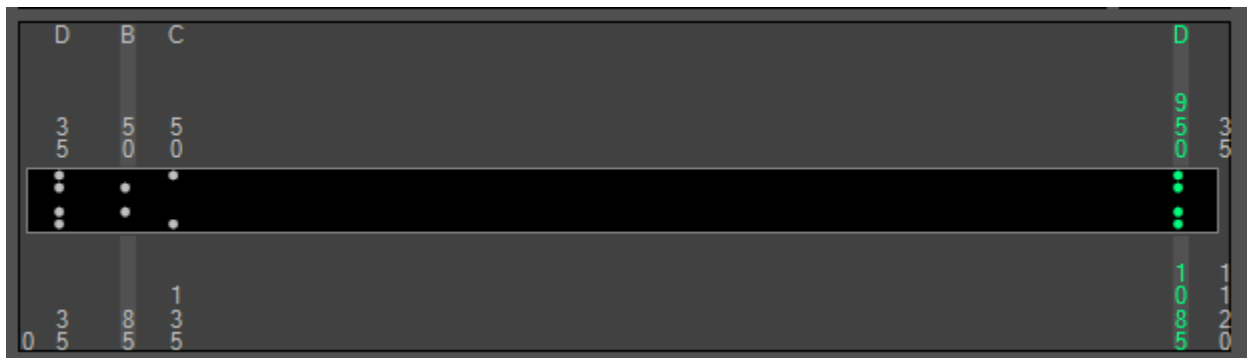


FIG 4 Purlin Pattern - P100LL1000S

END BAY PURLIN (RIGHT SIDE)

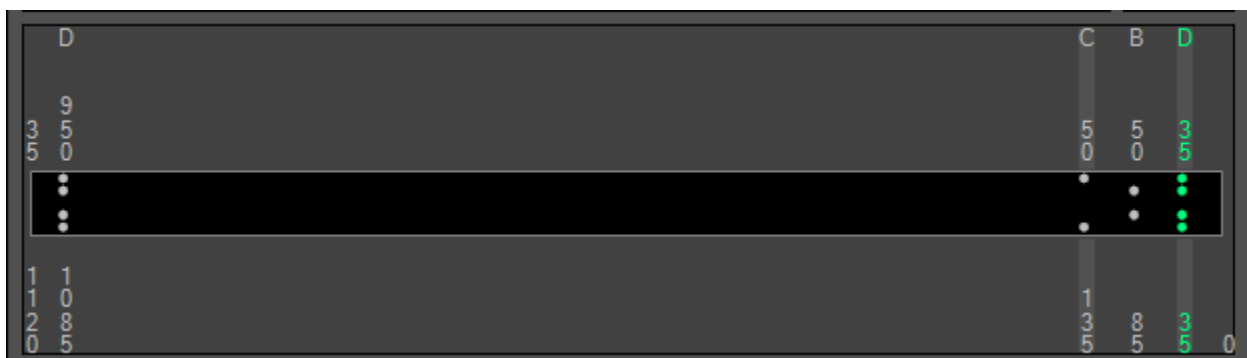


FIG 5 Purlin Pattern - P100RL1000S

END BAY PURLIN WITH OVERHANG (LEFT SIDE)

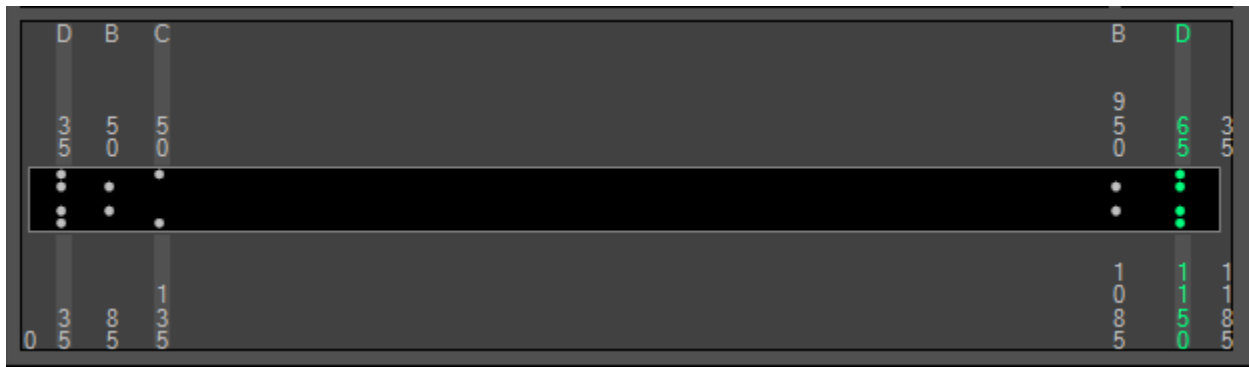


FIG 6 Purlin Pattern - P100LL1000S100E

END BAY PURLIN WITH OVERHANG (RIGHT SIDE)

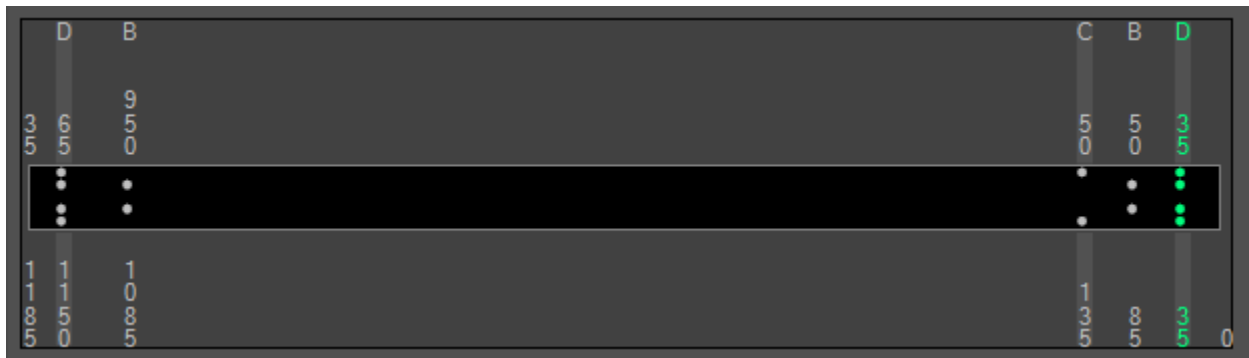


FIG 7 Purlin Pattern - P100RL1000S100E

REFERENCING FROM RIGHT END

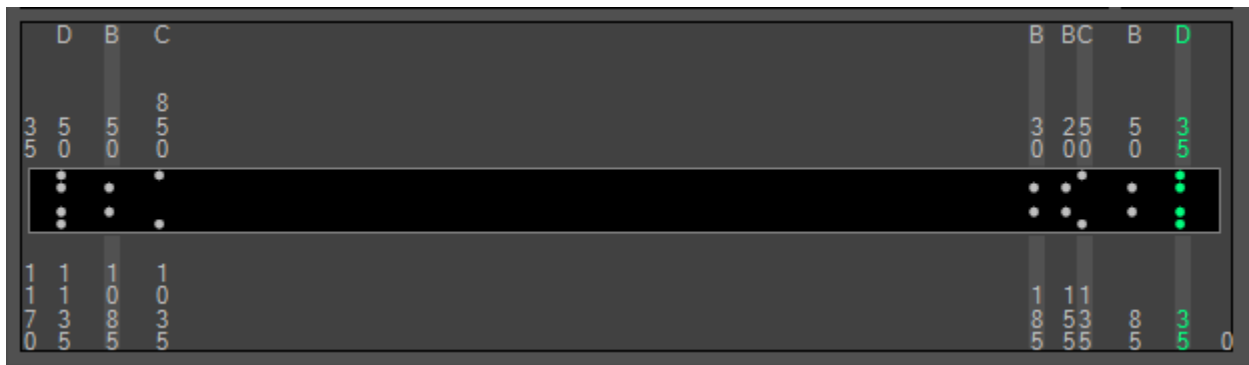


FIG 8 Purlin Pattern - P100RL100LL1000SR155B30B

REFERENCING FROM LEFT END

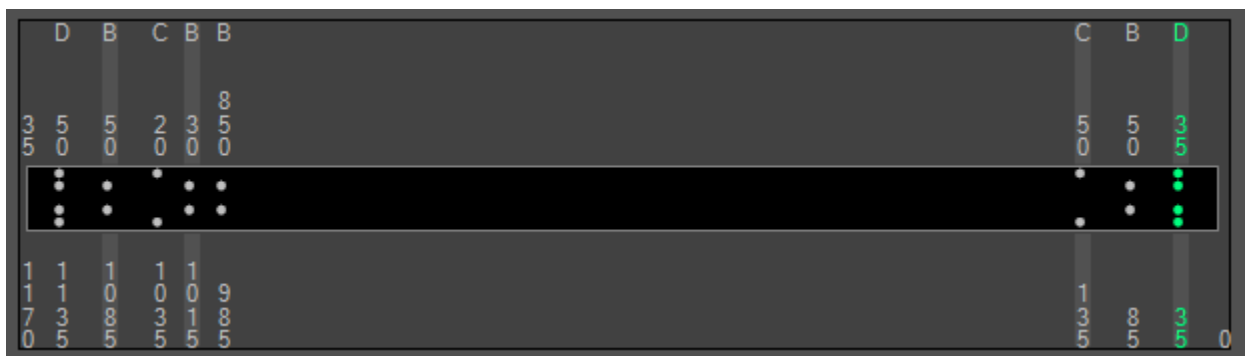


FIG 9 Purlin Pattern - P100RL100LL1000SL155B30B

REFERENCING FROM RIGHT SPAN

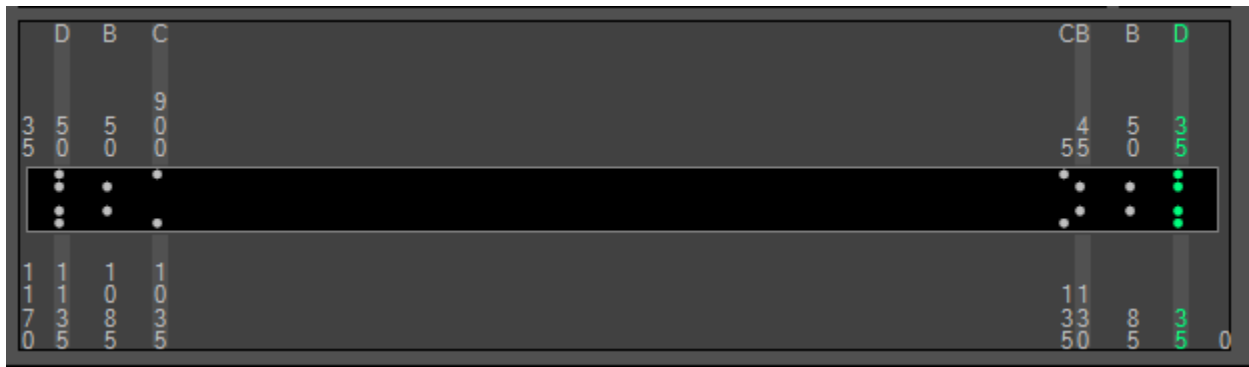


FIG 10 Purlin Pattern - P100RL100LL1000SR130B

REFERENCING FROM LEFT SPAN

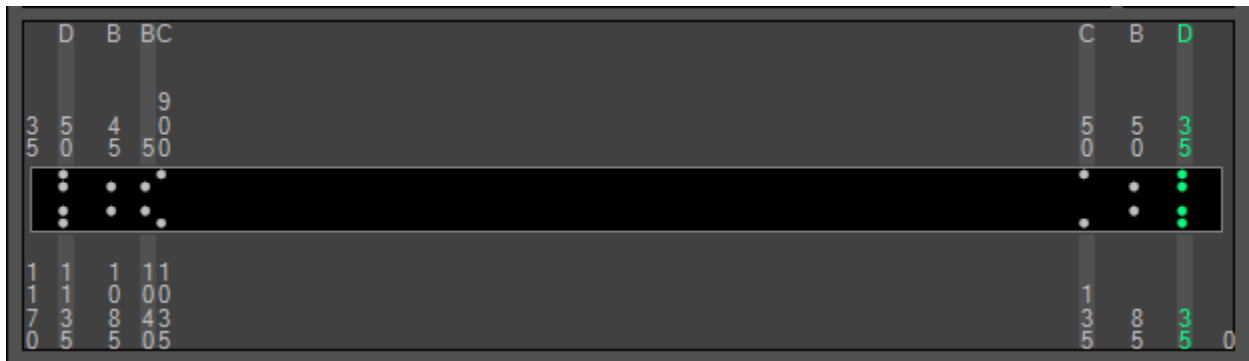


FIG 11 Purlin Pattern - P100RL100LL1000SL130B

INTERIOR BAY WITH 1 BRIDGING HOLE

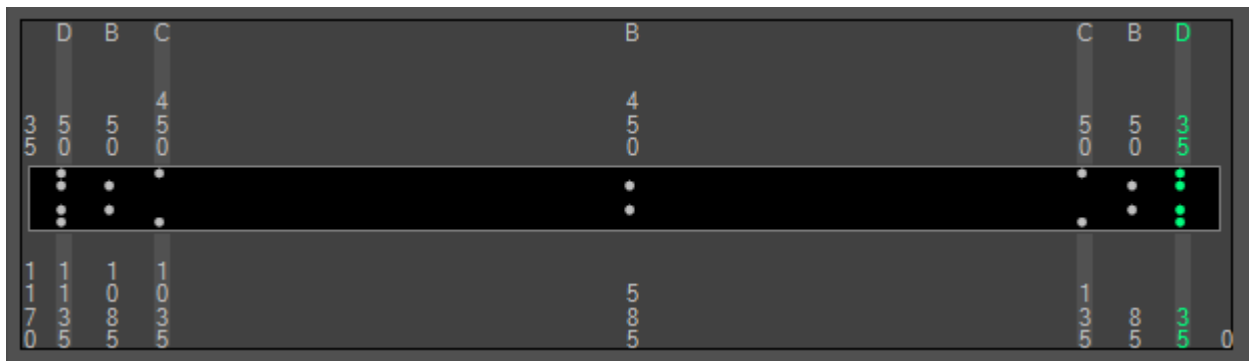


FIG 12 Purlin Pattern - P100RL100LL1000ST1B

INTERIOR BAY WITH 2 BRIDGING HOLES

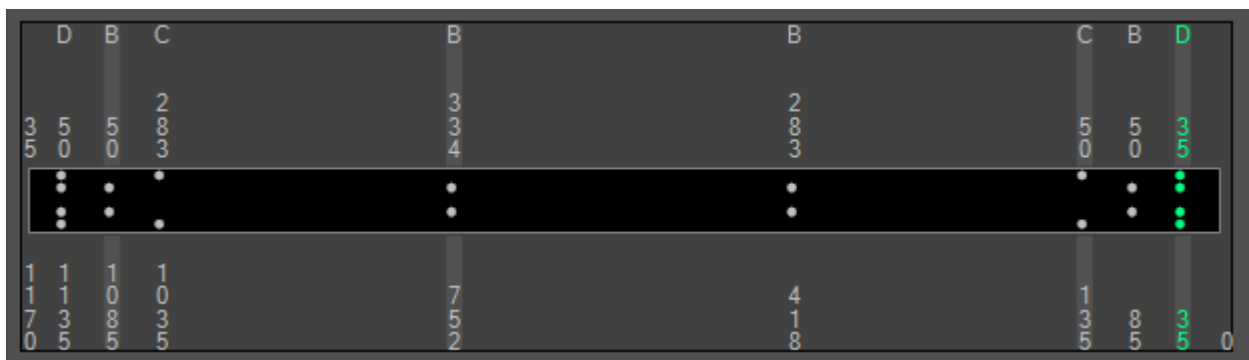


FIG 13 Purlin Pattern - P100RL100LL1000ST2B

END BAY (RIGHT END) WITH 1 BRIDGING HOLE / OVERHANG

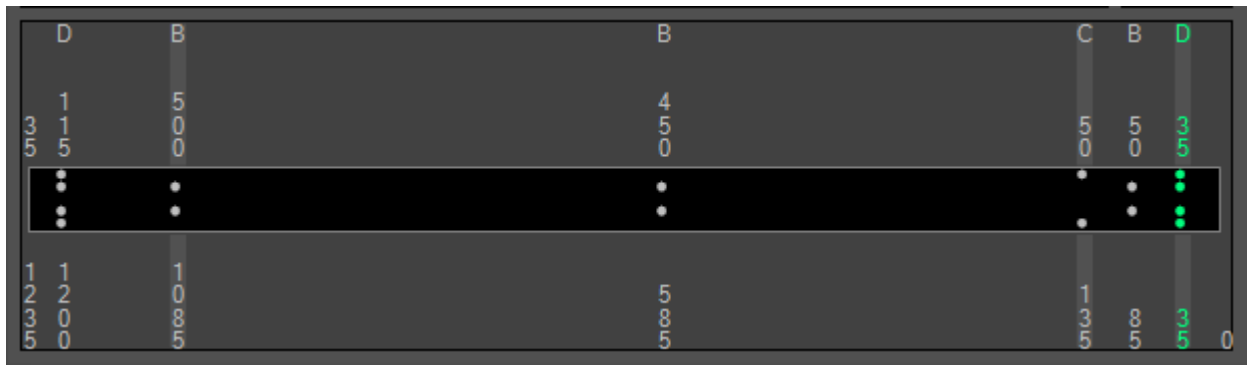


FIG 14 Purlin Pattern - P100RL1000S150ET1B

END BAY (LEFT END) WITH 1 BRIDGING HOLE / OVERHANG

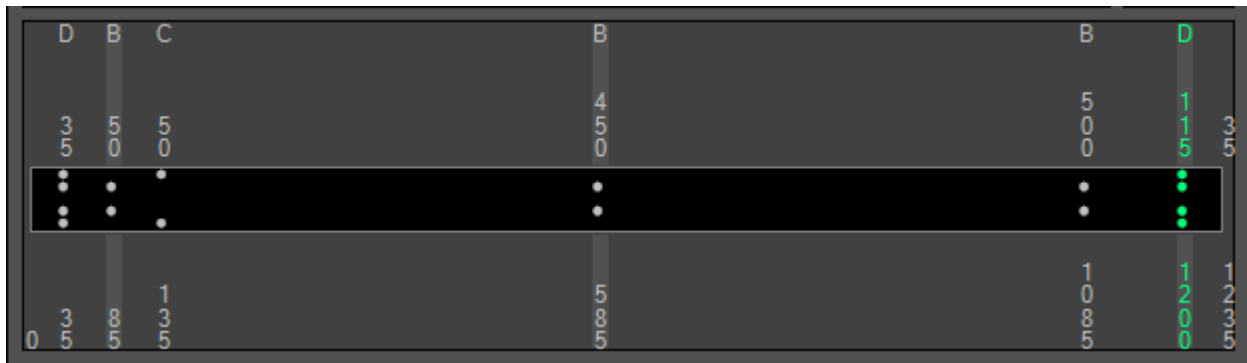


FIG 15 Purlin Pattern - P100LL1000S150ET1B

REPEATED HOLES

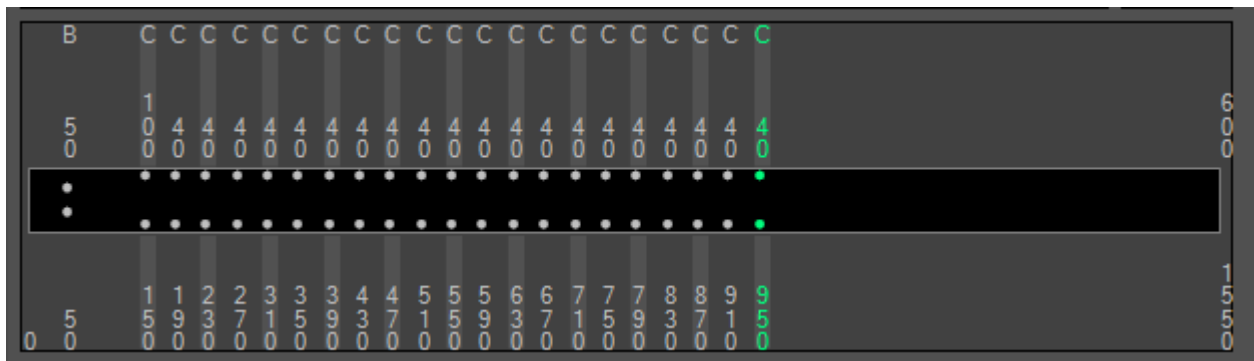


FIG 16 Purlin Pattern - L50B100C20,40C600E

REPEATED HOLE GROUPS

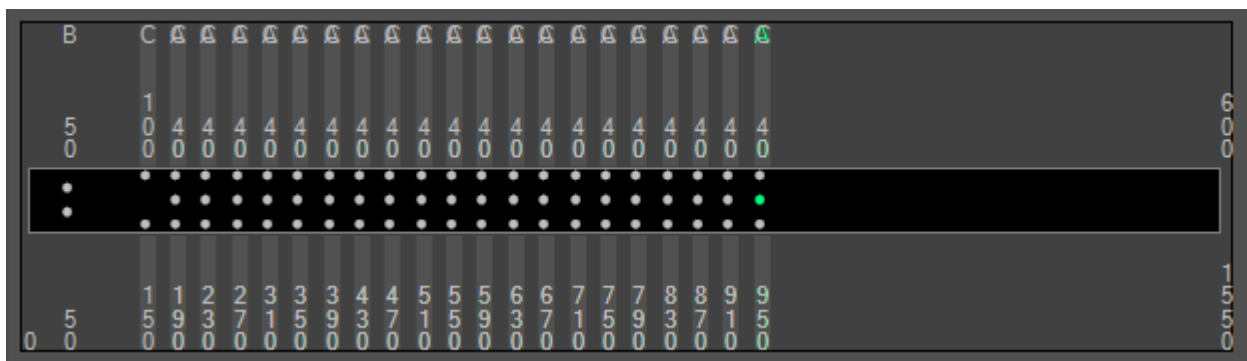


FIG 17 Purlin Pattern - L50B100C20,40CA'600E