GRID OPTIMIZER

USERS MANUAL

INTRODUCTION

The Grid Optimizer interface is designed to accept input from a glass export program that saves grid information in the form of grid type , grid size , grid colour and aligning information, and breaks out this information into usable files for processing by the Auto Grill .

STEP 1
Upon launch the user is presented with the screen shown below:
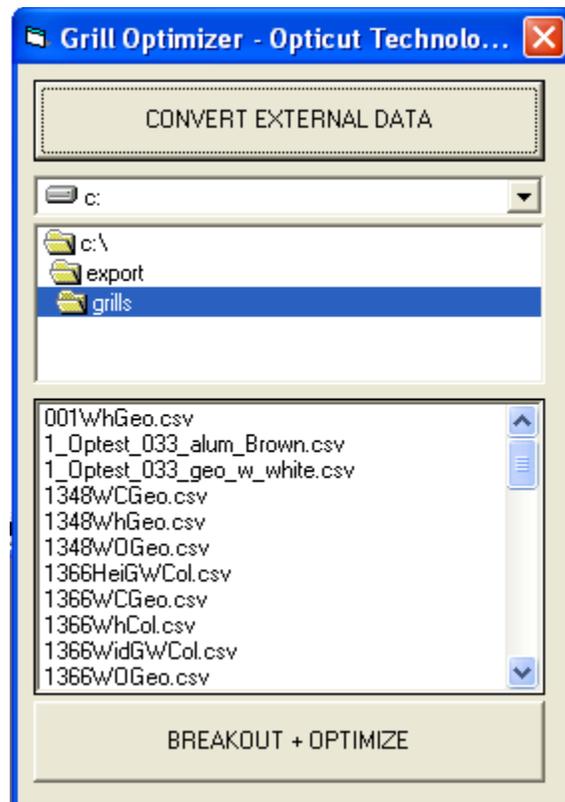
Clicking "CONVERT EXTERNAL DATA" , will open a second screen where the user can select the file to be processed by clicking "IMPORT FILE". Typically this will reside on a network folder or on a floppy drive.
A dialog box will appear and the user can navigate to the desired location whereby selecting the desired file will generate the various files that will be required to fulfill the entire work order.

All the grid types recognized will be included in these files and no other action on the part of the user is required.
The configuration file that identifies the grid material to be processed, has the following information:

mat=Flat in-Glass Alum 5/8BRONZE,Col,BRONZE,144,0.925,2.625,0.625,0.625,0,0,0,Col3_16_Bronze,0

The first part identifies the material , the color, the stock length , and some machine parameters to calculate the various indexes required. The last part of the line specifies the material to be used and is the output name for the files to be processed.

After clicking "EXPORT FILES" the user is brought back to the starting screen where the exported files will be available for optimizing.

The files in the list box with the extension ".csv" are now available to be Optimized.
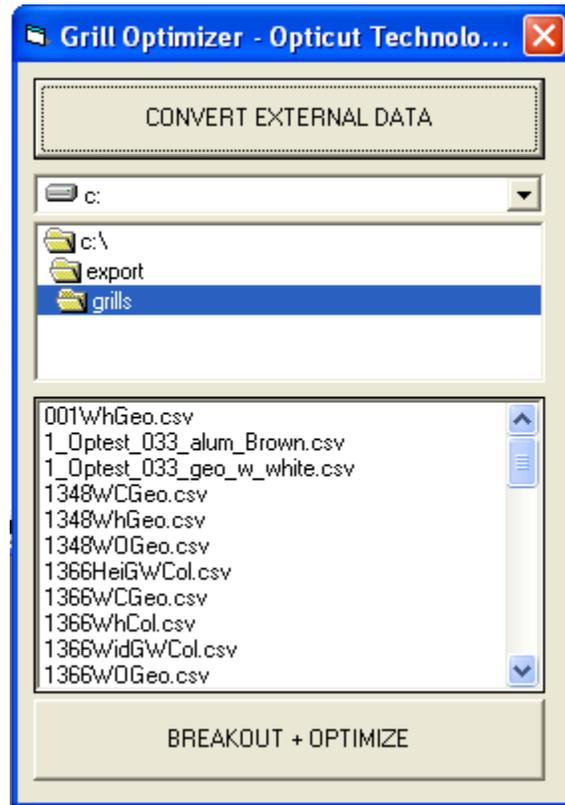
By selecting each file individually the user can then click "BREAKOUT + OPTIMIZE" and will be presented with the results of the breakout

The breakout form displays all the combinations found in the chosen file that can be processed simultaneously. That is, the program searches and groups together grid bars that belong to the same glass in combinations of up to 4 pieces and displays them for the user to choose from.

The user can accept this choice or unselect certain combinations in which case the user must click reprocess to display the new combinations.

Click "OPTIMIZE" in order to optimize and generate the "CUT" file to be processed on the Auto Grill machine.

The program will generate the required separate files to fulfill the order requirements. In the above example it will generate 1 file called 1_Optest_033_alum_White.cut. This file refers to the 1's , that is it requires that the machine be loaded with 1 stick at a time until the file is complete.

The second file generated will be named 2_ Optest_033_alum_White.cut. This file refers to the 2's , that is it requires that 2 sticks be loaded on the machine simultaneously until the file is complete.

The process is repeated for all the "CSV" file extension until all the grid types and colours are completed. The spacer bar will also be processed in the same manner as the grids.