

FeneTech, Inc.

FeneVision[®] Opti-Break User Manual



FeneVision® Opti-Break User Manual

v. 8.0

July 2022

FeneVision® is a registered trademark of FeneTech, Inc.

FeneTech, Inc.
32125 Solon Road, Suite #100
Solon, OH 44139
Phone 330-995-2830 • Fax 330-954-7008
www.fenetech.com

Table of Contents

TABLE OF CONTENTS.....	3
OVERVIEW	4
USING OPTI-BREAK	4
STARTING.....	4
RUNNING THE SELECTED PART TYPE / RELEASE	5
<i>Part / Release Selection</i>	5
<i>Using the Pattern Editor</i>	12
<i>Remake Rack (Dynamic Mode Only)</i>	16
<i>Rejecting</i>	17
<i>Store and Restock</i>	19
COMPLETING A RUN.....	21
BATCH AND DYNAMIC MODE.....	21
<i>Batch Mode</i>	21
<i>Dynamic Mode</i>	22
<i>Generating Files</i>	24
THE GEOGRAPHY OF THE RUN / SELECTION SCREEN	24
<i>Filters and Processes</i>	25
<i>Buttons</i>	26
<i>Release and Part Types Grid</i>	27
<i>Patterns and Rack List</i>	28
REMAKES SCREEN	30
INVENTORY SCREEN.....	34
STORE SCREEN	36
RACK GROUPS SCREEN ('DYNAMIC' MODE ONLY).....	39
MATERIALS SELECTION SCREEN	40
<i>Stock / Restock Selection Grid</i>	41
<i>Store Selection Grid</i>	42
<i>Settings ('Dynamic' Mode Only)</i>	43
CONFIRM LOTS SCREEN	48
PATTERNS SCREEN ACTIONS	50
<i>Loading Patterns with Opti-Load</i>	51
<i>Lite Colors</i>	56
EDIT LOT INFO	57
EXITING	58
SETUP	58
SYSTEM REQUIREMENTS	58
INSTALLATION	58
<i>Program</i>	59
INITIAL SETUP	59
SETTINGS	59
<i>Database Tab</i>	60
<i>Settings Tab</i>	61
<i>Interface</i>	67
ABOUT	67
HELP	68

Overview

FeneVision Opti represents an integrated glass optimization system that maximizes yields when cutting and batch tempering glass, as well as an application that integrates with glass loading machinery. Graphical patterns are displayed within FeneVision Opti, and both reports and glass labels can be generated. This unique system handles rectangular or standard shapes, but also allows users to optimize any non-standard shapes, such as digitized templates and DXF files generated from FeneVision CAD. The system can operate in either 'Batch' or 'Dynamic' optimization mode. Additionally, FeneVision Opti can interface to many manufacturers' cutting lines.

FeneVision Opti-Break retrieves the part optimization data from FeneVision Opti-Glass and cuts it at manufacturer's cutting tables using breakout stations. Opti-Break can be run in either 'Batch' or 'Dynamic' mode. Users select the release or part type to be cut, run the glass or interlayer through the breakout station, and accept the successfully broken out lites.

Using Opti-Break

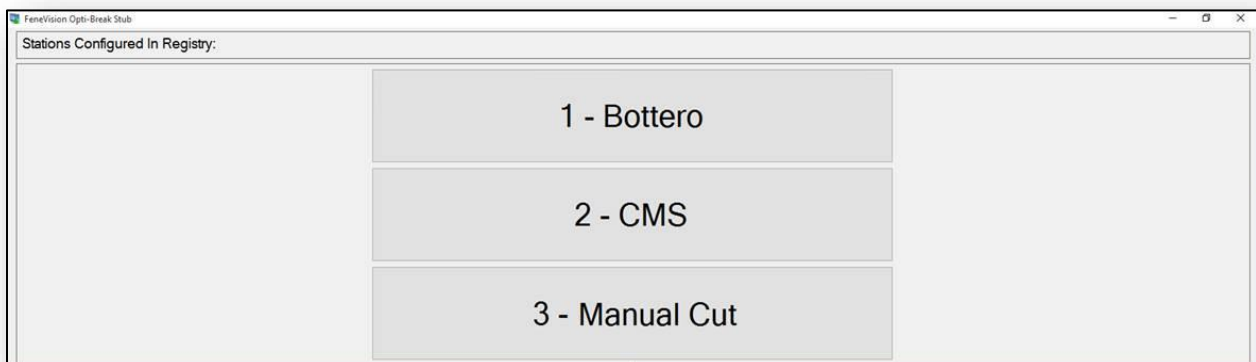
The use of the FeneVision Opti-Break involves selecting the release or glass / interlayer type that is to be cut. Next, the user will generate the machine files (when in 'Online' mode) and run the release. The final step is the physical cutting and breaking out of the glass / interlayer.

Starting

Double-click on the Opti-Break icon to start the application.



Alternately, the user can open Opti-Break on a single PC with multiple preconfigured station settings using 'Opti-Break Stub'. Once the user double clicks on the STUB application, the following will display:

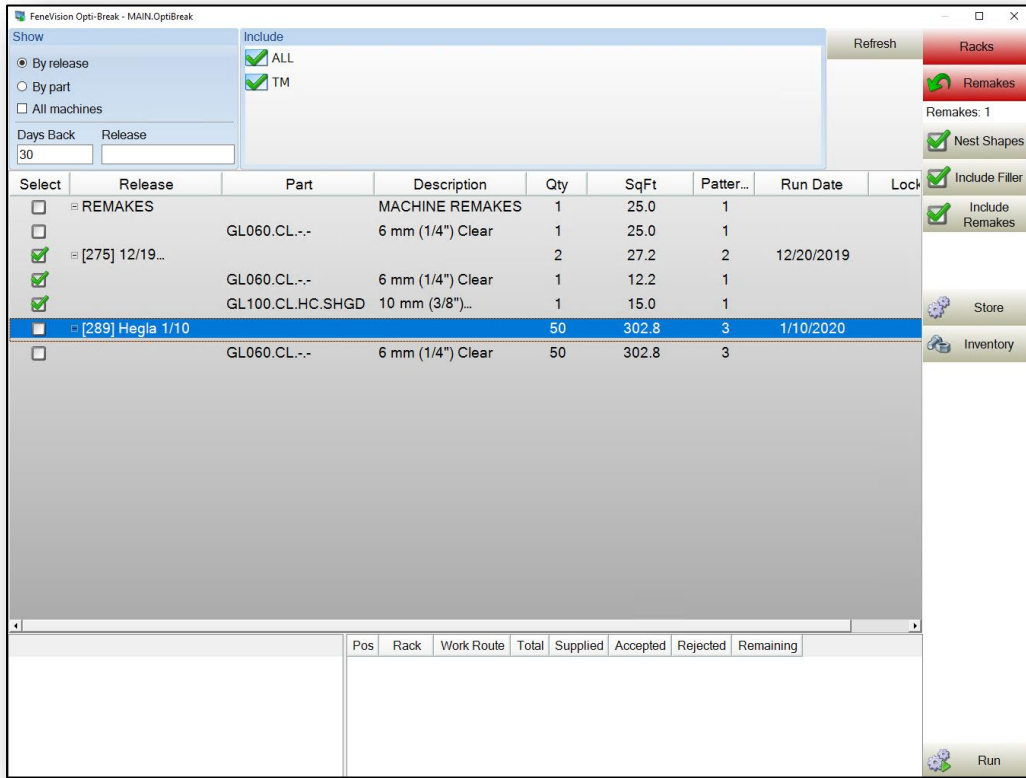


Note: After Opti-Break has loaded, select 'Alt-S'. This will take the user to the 'Settings' screen. For additional details on configuring the Opti-Break settings, see the 'Settings' section.

When opening the Opti-Break application, the user has a choice of how to view the production for the day.

Running the Selected Part Type / Release

Once setup of FeneVision Opti-Break is complete, the user can begin the process of running the selected glass / interlayer or releases through the breakout process. The following sections will outline the steps of the breakout process.



Part / Release Selection

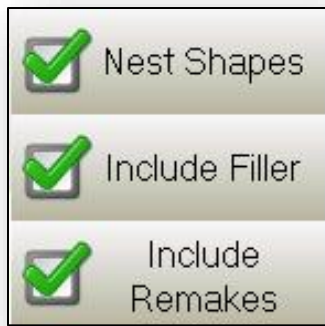
The following steps outline the selection process in 'Dynamic' mode.

Dynamic Mode

To begin breaking out the glass in 'Dynamic' mode:

Configure the filters and processes.

Check or uncheck the following ('Dynamic' mode only):



1. Use the checkbox to select the releases or glass types to be run.

Select	Part	Release	Description	Qty	SqFt	Drops
<input checked="" type="checkbox"/>	GN-S14BL	[11616] 616 S2	Dynamic Mode...	84	532.1	8
<input checked="" type="checkbox"/>	GN-S14BL	[11641] Store S2	Step 200	1	6.3	1

2. Select 'Run' on the left column of the dialog. This takes the user to the 'Rack Groups' screen.

Select	Plan Date	Rack	Release	Schedule	Work Route	Total	Accepted	Rejected
<input checked="" type="checkbox"/>	12/06/2014	47-...	[11599]...	12647 ...	AI	4	3	0
<input checked="" type="checkbox"/>	12/06/2014	47-...	[11599]...	12647 ...	AI	4	2	0
<input checked="" type="checkbox"/>	12/06/2014	47-...	[11599]...	12647 ...	AI	2	1	0
<input checked="" type="checkbox"/>	13/06/2014	49-M1	[11602]...	12649 ...	AI	22	0	0
<input checked="" type="checkbox"/>	13/06/2014	50-M3	[11602]...	12650 ...	AI	20	0	0
<input checked="" type="checkbox"/>	13/06/2014	51-M5	[11602]...	12651 ...	AI	18	0	0
<input checked="" type="checkbox"/>	13/06/2014	62-M1	[11615]...	12662 ...	AI	26	4	0
<input checked="" type="checkbox"/>	13/06/2014	61-M59	[11616]...	12661 ...	AISH	28	0	0
<input checked="" type="checkbox"/>	13/06/2014	63-M62	[11616]...	12663 ...	AI	28	0	0
<input checked="" type="checkbox"/>	13/06/2014	63-M65	[11616]...	12663 ...	AISH	28	0	0
<input checked="" type="checkbox"/>	13/06/2014	63-M66	[11616]...	12663 ...	AISH	26	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0
<input checked="" type="checkbox"/>	17/06/2014	84-...	[11634]...	12684 ...	AISH	2	0	0

3. Select the rack groups to run.

- a. Use the Move Up and Move Down arrows to re-sequence the racks.
- b. To reposition the group splitters, simply select it by selecting the blue arrow in the left side margin. This will turn the arrow and splitter green to indicate it is selected.
- c. Using the mouse drag and drop the splitter to the desired location. The image below illustrates this functionality:

Select	Plan Date	Rack
<input checked="" type="checkbox"/>	1/17/2014	93-LR1
<input checked="" type="checkbox"/>	1/16/2014	94-LR3
<input checked="" type="checkbox"/>	1/21/2014	02-LR1

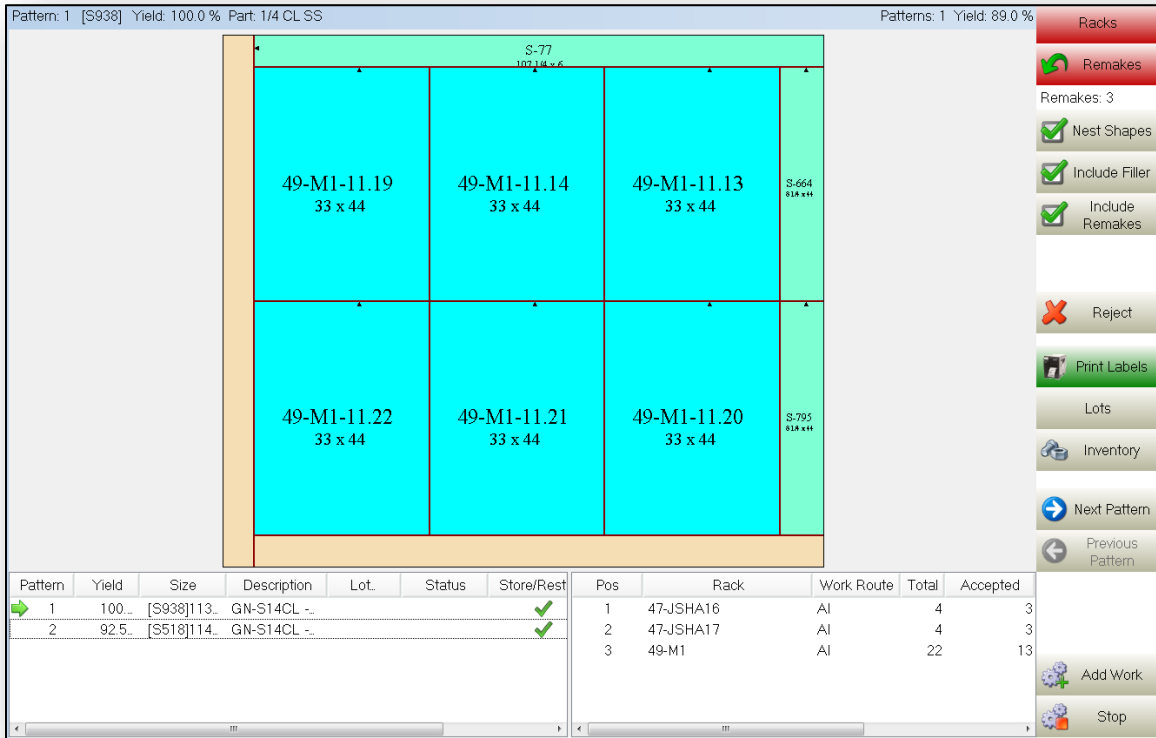
4. Select 'Run'. The 'Stock Selection / Materials Selection' screen will appear.

GN-S14CL													
Enabled	Part	Machine	Description	Size	Use	T	L	R	T	B	I	Parent Part	Vendor Part ID
<input checked="" type="checkbox"/>	S14CL072084		[Description Pending]	72 x 84	-1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	
<input checked="" type="checkbox"/>	S14CL072130		1/4 CL SS 72 X 130	130 x 72	-1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	
<input checked="" type="checkbox"/>	S14CL096130		1/4 CL SS 96 x 130	130 x 96	-1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	
<input checked="" type="checkbox"/>	S14CL108144		1/4 CL SS 108 X 144	144 x 108	-1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	
<input checked="" type="checkbox"/>	S14CL072084 BW..		[Description Pending]	55 x 5	1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	
<input checked="" type="checkbox"/>	S14CL108144 BW..		1/4 CL SS 108 X 144	108 x 6	1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	2
<input checked="" type="checkbox"/>	S14CL072084 BW..		[Description Pending]	84 x 3 1/4	1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL	UE

Store: BW CUTTER															
Enabled	Store	Slot	Parent Part	Part	Description	Size	T	L	R	T	B	I	Vendor Part ID	Lot Number	Date
<input checked="" type="checkbox"/>	BW..	11	GN-S14CL	S14CL108144	1/4 CL SS 108 X 144	108 x 43 7/32	<input checked="" type="checkbox"/>	25/32	25/32	25/32	25/32	25/32		12	11/..

- a. From this screen, the user can select stock pieces, 'Store' pieces, and 'Online Store' and 'Restock' pieces to be used in the optimization. The 'Stock Selection' grid (located at the top) contains stock sheets and 'Restock' sheets; the 'Store Selection' grid (located at the bottom) contains 'Store' and 'Online Store' pieces.
 - b. Select the material to allow the algorithm to use during optimization.
 - c. Check whether trims are to be included. Trims can be edited here.
 - d. Open the 'Settings' screen to confirm the settings are configured as desired (optional).
5. Select 'Run'.

- If 'Lot Tracking' is enabled, the 'Confirm Lots' screen will appear to prompt the user to select the lot number(s) to be used during the run. Once the user has selected or confirmed the lots, the patterns will begin optimizing.
- If 'Lot Tracking' is *not* enabled, Opti-Break will begin optimizing as soon as 'Run' is selected and display the first pattern generated. At this point the operator may begin the breaking out the glass.



Note: Clicking and holding over a particular lite will reveal a larger-scale view of the lite's dimensions.

Changing users

Users can change the active user while running a release by selecting the 'Log Off' button. This icon will only be visible when 'Logon Required' is selected in the 'Setup' menu. Doing this will allow a new user to resume working on a release in progress without having to start a new run.

Rack Move ('Dynamic' mode only)

The 'Rack Move' screen will appear at any point when the 'Rack List' in the bottom right will be updated. When the first pattern is generated, the 'Rack Move' screen appears to tell the user what racks need to be moved into the rack positions. When a rack has been completed, the screen will appear again showing the user two things:

- The rack that should be moved *out*.
- The rack that should be moved *in* to replace it.

This screen can be accessed at any time by selecting the gray space outside of the stock sheet. The 'Rack Moves' screen will reappear.

The following steps outline the use of the 'Rack Move' functionality:

- When starting the run, the 'Rack Move' screen will appear to tell the user how to position the racks around the table.

Rack Move		
	Out	In
1	Empty	41-M1 
2	Empty	47-JSHA16 
3	Empty	47-JSHA17 
4	Empty	47-JSHA18 
5	Empty	49-M1 
N6	Empty	50-M3 
N7	Empty	51-M5 
N8	Empty	62-M1 
		

- The user should position the racks according to the 'Rack Move' screen. The 'Racks List' at the bottom right of the screen will update to show each rack and its position around the cutting table.

Pos	Rack
1	50-M3
2	47-JSHA16
3	47-JSHA17
4	47-JSHA18
5	49-M1

- As the user breaks out patterns, racks will begin to fill up. Once every lite designated for a rack has been completed, the rack move screen will reappear to inform the user to move that rack out and move a new rack in. If there are buffer racks a buffer rack will be moved up to the vacant rack position and a new rack will be pulled into the vacant buffer position.


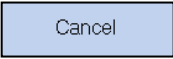
Rack Move			
	Out		In
1	 41-M1	50-M3	
2		47-JSHA16	
3		47-JSHA17	
4		47-JSHA18	
5		49-M1	
N6	 50-M3	61-M59	
N7		51-M5	
N8		62-M1	
			

4. Based on the 'Rack Move' screen, the following changes are indicated:
 - a. Rack Position 1 (41-M1) and Rack Position N6 (50-M3) must be moved out. Rack 41-M1 has been completed.
 - b. Rack Position N6 (50-M3) is moved up to Rack Position 1 so it will now be optimized with priority rather than being optimized as buffer.
 - c. A new rack (61-M59) is pulled into the buffer position of Rack Position N6.
 - d. Rack Positions 2, 3, 4, 5, N7, and N8 are not moved at all.
5. Select the green checkmark, removing the 'Rack Move' screen from view.
6. The cutter can now continue with the next patterns.

Adding Work

During a run, users can add work to the process by using the 'Add Work' button on the right. Selecting 'Add Work' will take the user back to the 'Run / Selection' screen where the user can add glass types / releases to the current run.

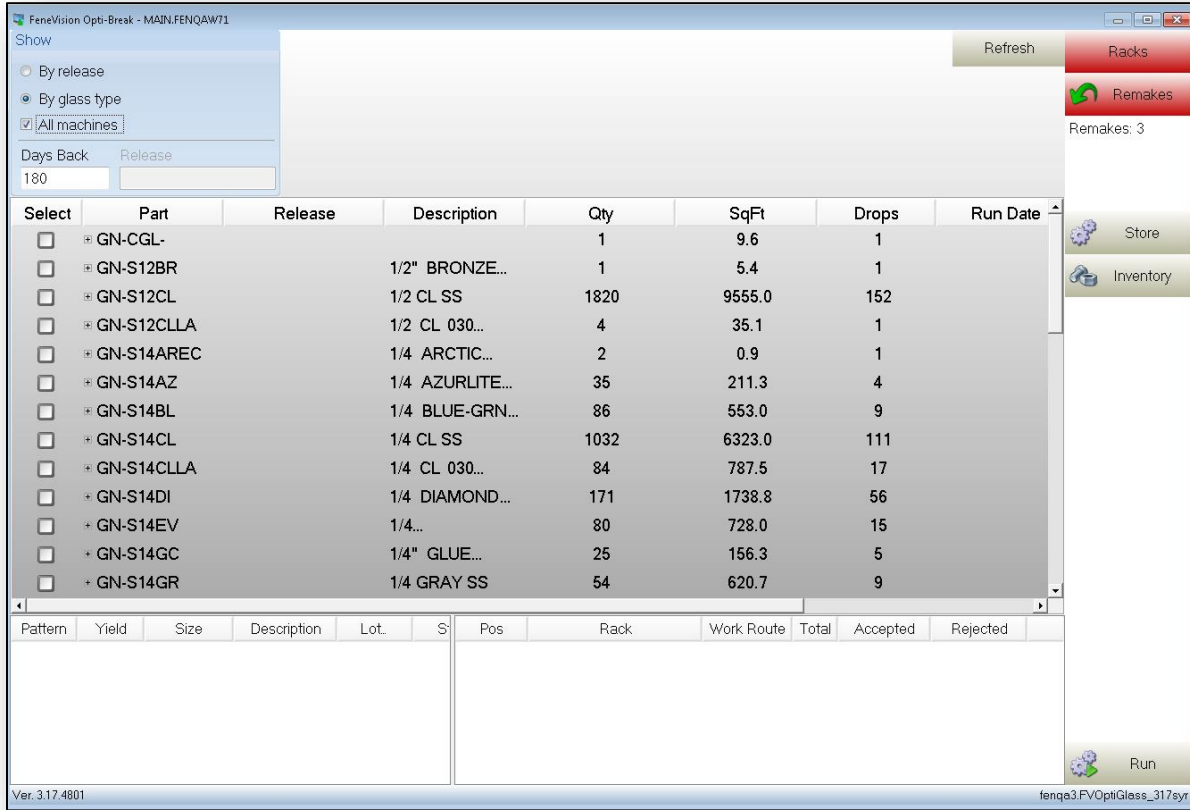
The user will follow the same steps described earlier. The user will select one of the following options after selecting the desired glass type(s) / release(s):


-  Selecting 'Add' takes whatever the user is adding and appends it to the end of the run, so more patterns could be generated after the working patterns from the user's first selections.
-  Allows the user to cancel the process of adding work.

Batch Mode

To begin processing glass / interlayer in 'Batch' mode:

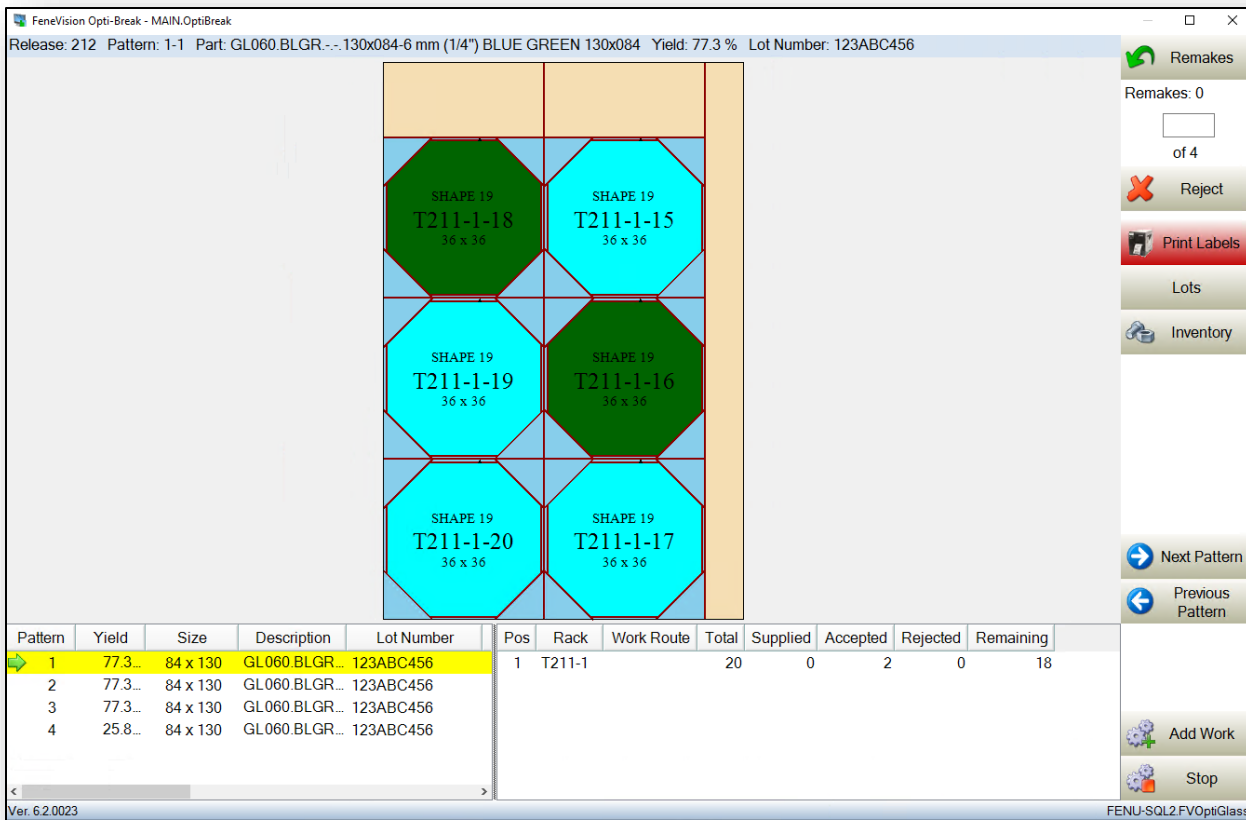
1. Configure the filters.



2. Use the  checkbox to select the releases or glass / interlayer types to run.

Select	Part	Release	Description	Qty	SqFt	Drops	Run Date
<input checked="" type="checkbox"/>	GN-S12CLLA		1/2 CL 030...	4	35.1	1	
<input checked="" type="checkbox"/>	GN-S12CLLA	[11951] BM11973		4	35.1	1	11/09/2014
<input type="checkbox"/>	GN-S14AREC		1/4 ARCTIC...	2	0.9	1	

3. Select 'Run'. If 'Lot Tracking' is enabled, the 'Confirm Lots' screen will appear. If not, the first pattern will appear on the screen.



- Complete the pattern, accepting and rejecting lites as needed. Accepted lites will turn green. Rejected lites will turn red.
- Once the user has finished with the pattern, select the 'Next Pattern' button on the left column of the dialog. The right arrow in the 'Patterns Grid' will indicate the move to the next pattern (many patterns are identical, and this arrow alleviates any confusion).

Note: Clicking and holding over a particular lite will reveal a larger-scale view of the lite's dimensions.

Using the Pattern Editor

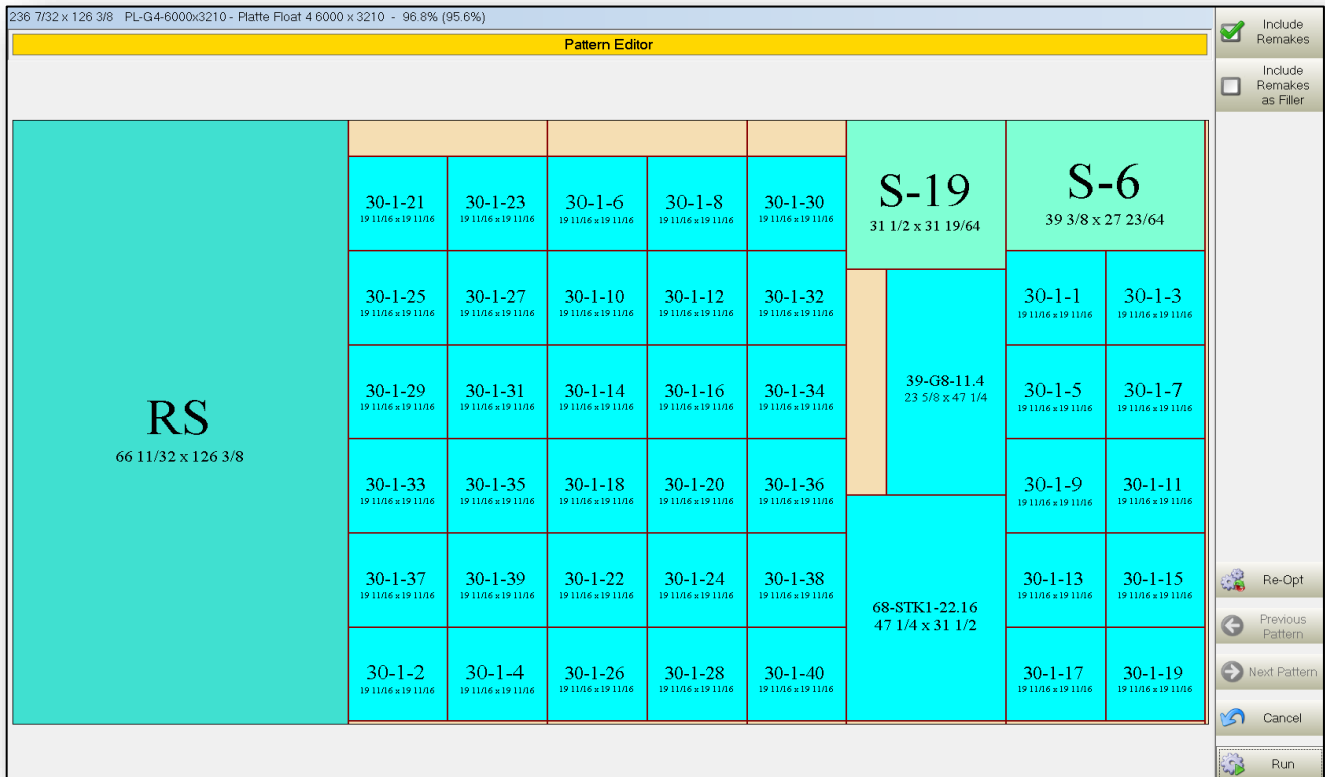
The 'Pattern Editor' allows the user to re-optimize patterns "on the fly". This function is helpful when the user sees that there are remakes that can be pulled onto the pattern, or the user wishes to clear space in the storage system.


Follow these steps to re-optimize using the 'Pattern Editor':


- To access the 'Pattern Editor', double-click on the pattern number in the 'Pattern List' at the bottom of the screen.

Pattern	Yield	Size	Description	Lot Number
1	90.9...	130 x 96	S14ST09613...	1
2	91.1...	130 x 96	S14ST09613...	1

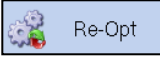
The 'Pattern Editor' screen will appear:

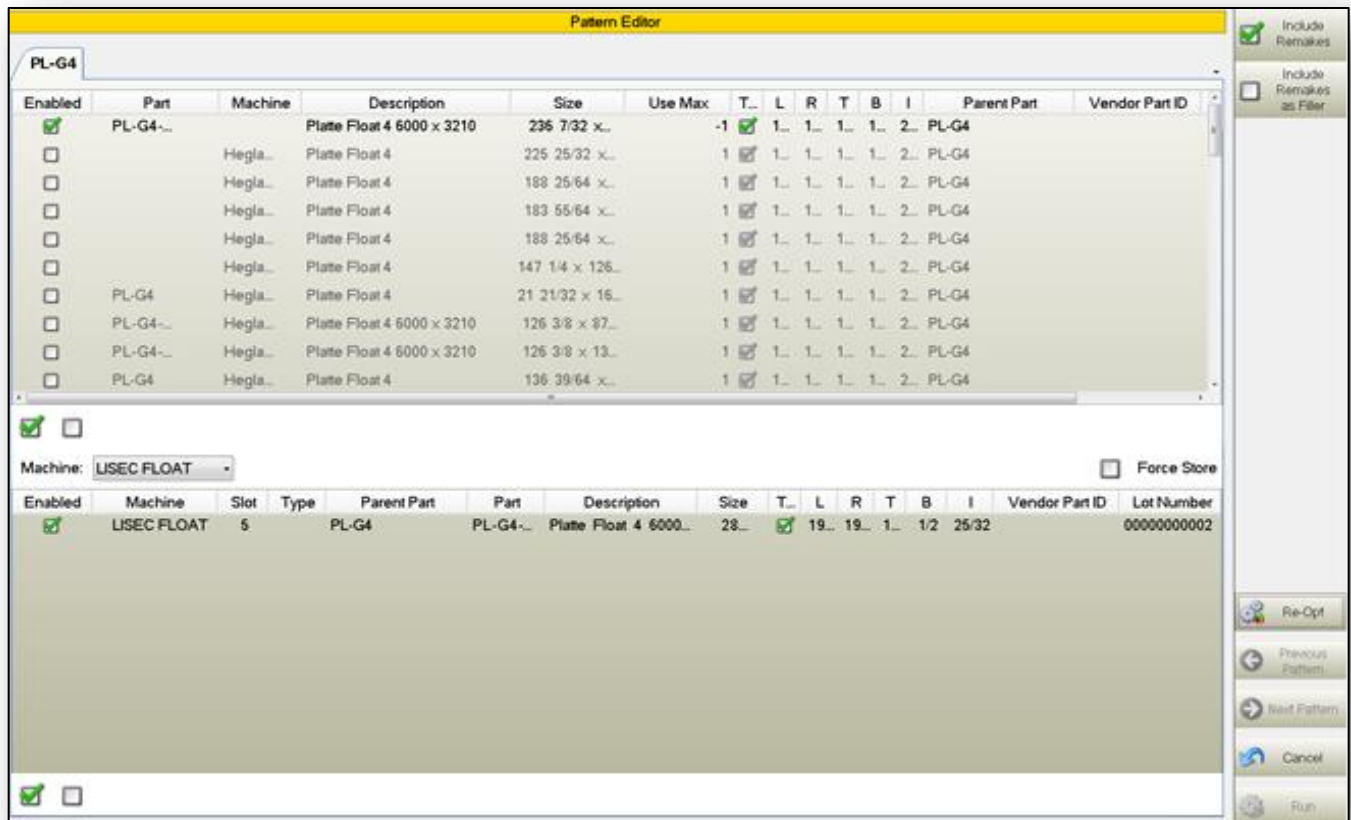


2. The user can choose to include remakes in the re-optimization. To do this, check the  checkbox at the top right of the screen. Checking 'Include Remakes' will force the 'Pattern Editor' into including every remake in the

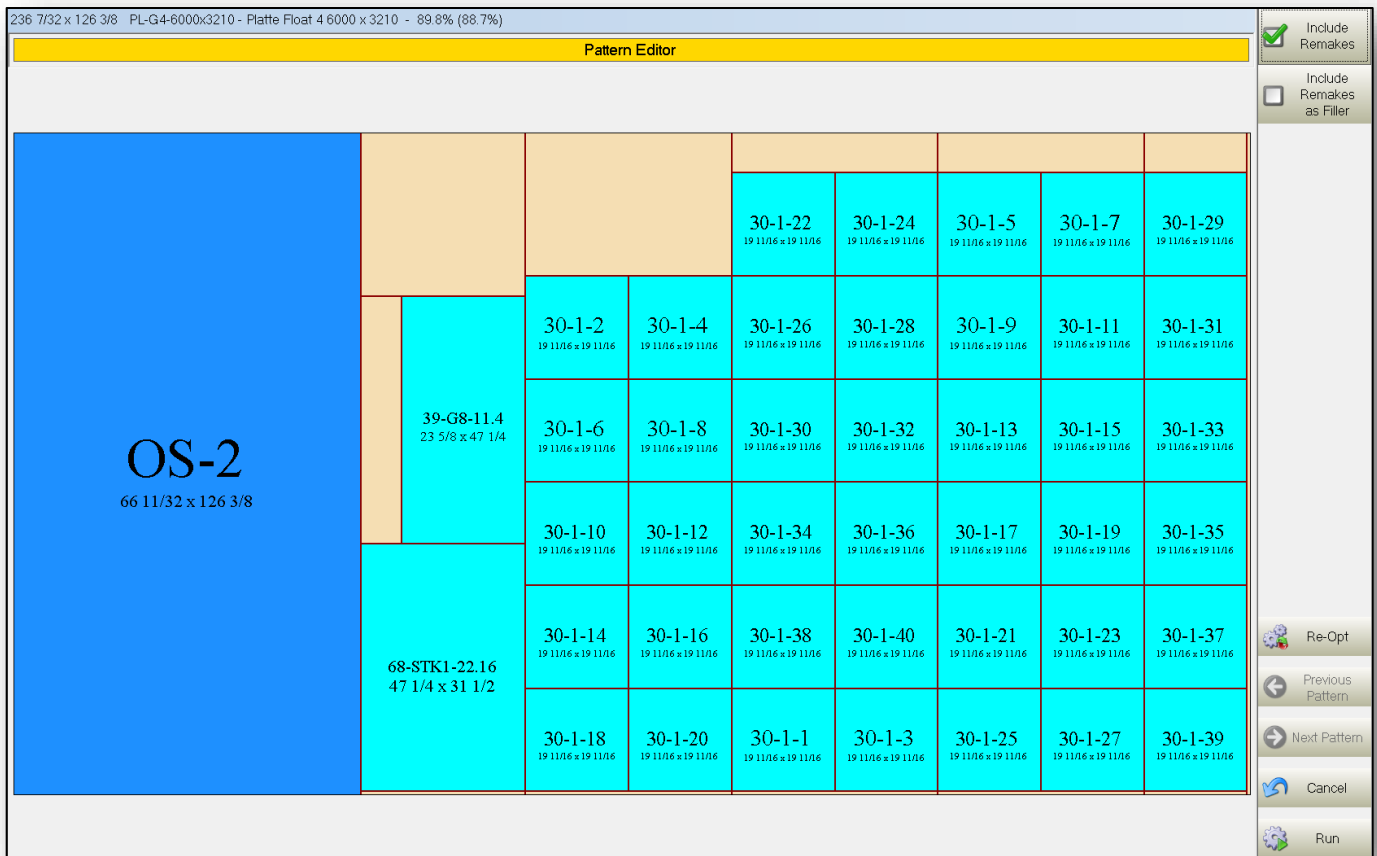
re-optimization. By checking the  checkbox, 'Pattern Editor' will optimize only with the required lites then place remakes in the left-over space if it can.

Note: If a remake is already included on the pattern that the user is attempting to re-optimize, the 'Pattern Editor' does not view this as a remake—instead, it is considered a lite that must be optimized on this pattern. Therefore, when the user re-optimizes, it will still include the remake even if 'Include Remakes' is not checked. By selecting 'Include Remakes', only the remakes that were not included on the pattern will be included in the re-optimization.

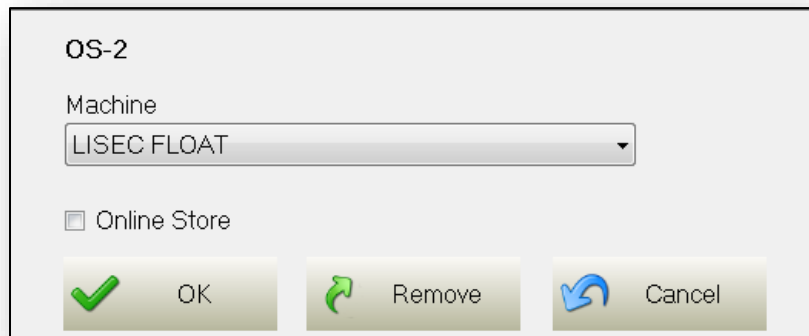
3. Once in the 'Pattern Editor', select the  button in the column on the right. This will return the user to the 'Stock Selection / Materials Selection' screen.



4. The user can choose another 'Stock' sheet or a remnant piece on which to optimize.
5. Once Opti-Break re-optimizes the pattern, the user will be presented with the new pattern(s).



- To remove or cancel a 'Store' piece, or to switch a 'Store' piece to / from 'Online Store' select the lite. The following screen will appear:



- If more than one pattern exists, the 'Next Pattern' button and the 'Previous Pattern' button will allow you to move between them.
- Once the new patterns are found to be satisfactory, select 'Run'. The following screen will appear:

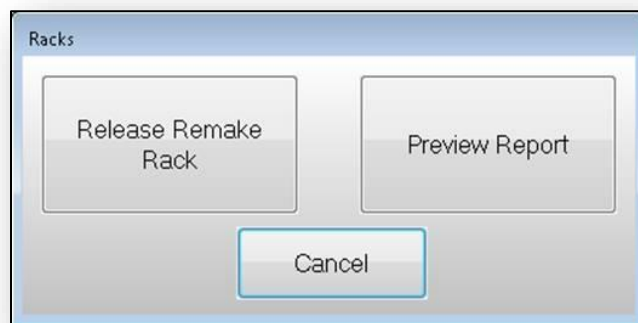


9. Once the user is satisfied with the new pattern, select 'Yes'.
10. To cancel the re-optimization, select 'Cancel'.

Note: If the user selects 'Yes' and replaces a pattern then stops the run prior to accepting or rejecting any lite on the pattern the pattern will revert to its original version. The next time the user starts the run, the original pattern will appear. However, once a lite on the new pattern has been given a status, the pattern is committed, and the user will see the new pattern(s) in place of the original pattern(s) in the 'View Releases' screen in FeneVision Opti-Glass.

Remake Rack (Dynamic Mode Only)

In 'Dynamic Mode', above the 'Remakes' button, exists the 'Racks' button. This is used for releasing the 'Remake Rack'. Remakes that are cut after their rack has left the table are placed on the 'Remake Rack'. As these remakes are cut, they are assigned slots in a 'Remake Rack', which are denoted with an 'R' in the tag (e.g., R.4, indicating 'Remake Rack' slot 4). The user will select the 'Racks' button when the determination has been made that remade lites are to proceed to the next production station.



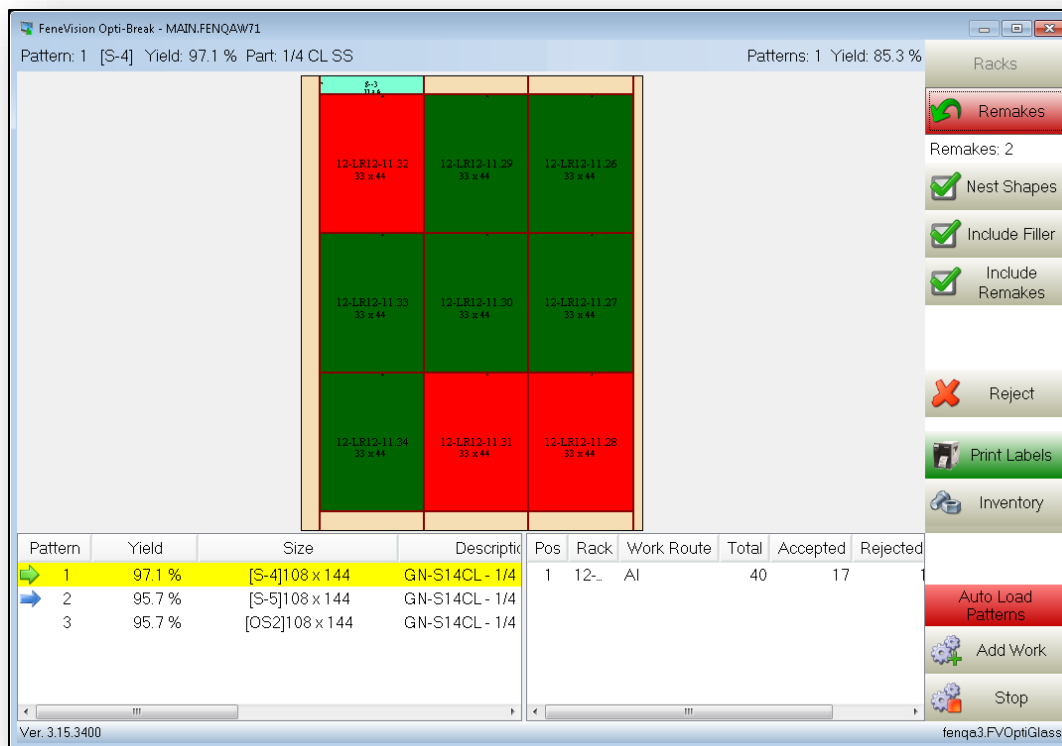
Selecting 'Racks' brings up this prompt which allows the user to release the 'Remake Rack', indicating that the rack is no longer at cutting. At this point a new 'Remake Rack' is started. The next remake that will appear will be assigned to Slot 1 of the new remake rack. This feature also allows the user to print a report of the remake rack being released, providing a list of which piece is in which slot of the 'Remake Rack'. The image below shows the 'Remake Rack' report. This report can be accessed from the 'Racks' dialog adjacent to the 'Release Remake Rack' button.

The screenshot shows a software window titled "Remake Rack". The window has a standard toolbar with navigation and utility icons. Below the toolbar, the text "Machine: BRETT CUTT" is displayed. The main content area contains a table with the following columns: Slot, Rack, Slot, Unit ID, Part, Size, Release, and Work Route. The table lists 11 rows of data, all of which have "John Reject Test" in the Release column and "AI" in the Work Route column.

Slot	Rack	Slot	Unit ID	Part	Size	Release	Work Route
1	12-LR12	11.2	25	GN-S14CL	33 x 44	Reject Testing	AI
2	12-LR12	11.1	25	GN-S14CL	33 x 44	Reject Testing	AI
3	94-BH29	2002	2	GN-S14CL	36 x 28	John Reject Test	AI
4	94-BH29	1002	1	GN-S14CL	36 x 28	John Reject Test	AI
5	94-BH29	1002	1	GN-S14CL	36 x 28	John Reject Test	AI
6	94-BH29	10.2	10	GN-S14CL	36 x 28	John Reject Test	AI
7	94-BH29	4002	4	GN-S14CL	36 x 28	John Reject Test	AI
8	94-BH29	10.2	10	GN-S14CL	36 x 28	John Reject Test	AI
9	94-BH29	8002	8	GN-S14CL	36 x 28	John Reject Test	AI
10	94-BH29	8001	8	GN-S14CL	36 x 28	John Reject Test	AI
11	94-BH29	5002	5	GN-S14CL	36 x 28	John Reject Test	AI

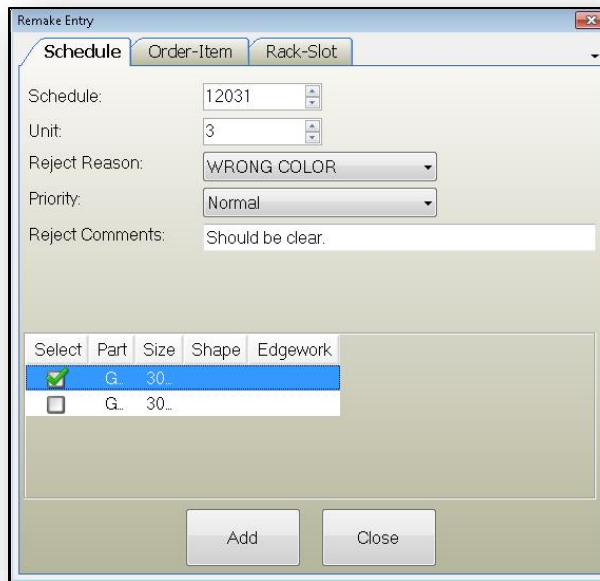
Rejecting

When something is wrong with a lite, the user can reject the item.



To reject a lite during a run, select 'Reject' (in red) then select the lite to be rejected. Once the 'Reject' option is selected, it will stay enabled until a lite is rejected. Once a lite is rejected, 'Reject' mode will become automatically disabled after two seconds. To add a remake outside of the run, select 'Remakes' then select 'Add Remake'. To return to the main screen, select 'Remakes' (in green).

To add a remake, select 'Add Remake'. The 'Remake Entry' screen will appear.



The user can enter a remake by 'Schedule', 'Order-Item', or 'Rack-Slot'. See the 'Remakes Screen' for descriptions of each of the fields in the 'Remake Entry' screen.

Store and Restock

When a remnant is large enough to save, FeneVision Opti-Break can store the remnant piece.

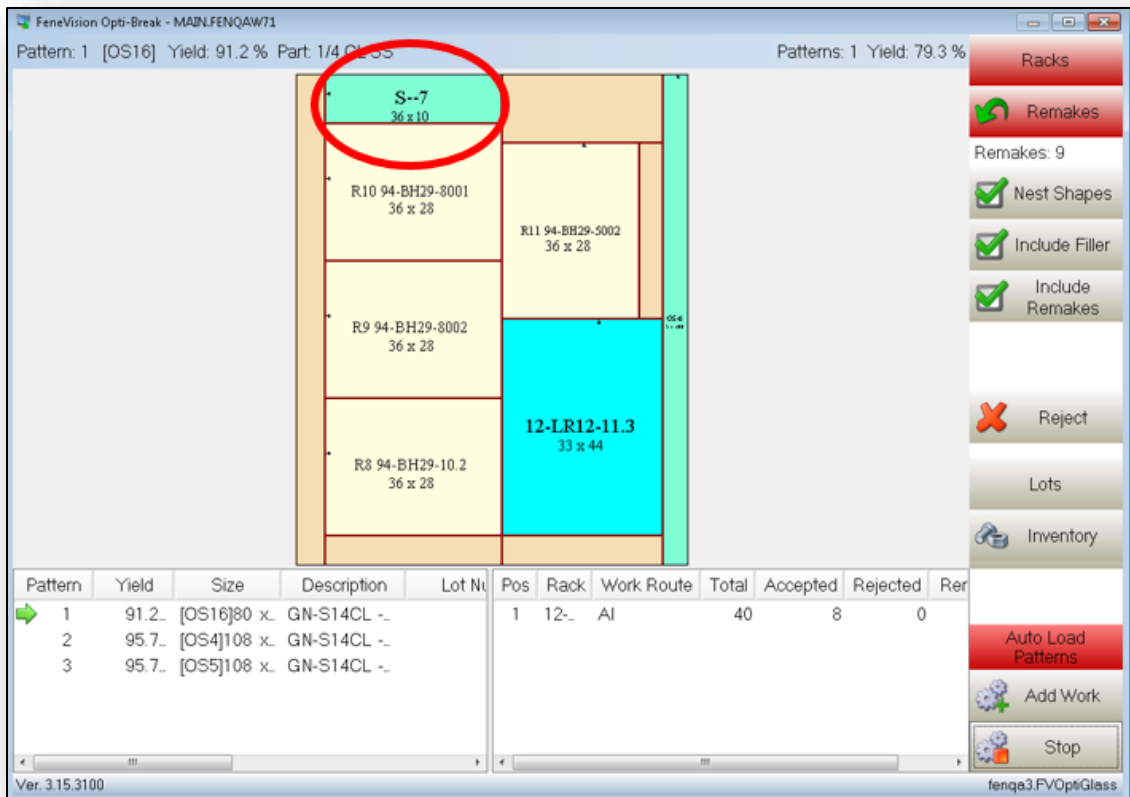
Generating and Consuming Remnants

When *generating remnants*, Opti-Break will automatically

1. Try to allocate a 'Restock' piece (the last unused X-plate on the last pattern of a batch).
2. With remaining scrap, Opti-Break will try to allocate 'Online Store' (*'Online Store' can only be full X-plates*).
3. With remaining scrap, Opti-Break will try to allocate offline 'Store'.

Note: In 'Dynamic' mode, the 'Store' and 'Restock' pieces are generated and consumed in FeneVision Opti-Break. When running in 'Batch' mode, this process occurs during optimization in FeneVision Opti-Glass.

A 'Store' piece can be accepted or rejected, just like a production lite. The 'Store' piece will display on the lite with 'S' followed by the slot number (e.g., S-7 which indicates that the remnant is 'Store' and will be placed in Rack Slot 7).



When *consuming remnants*, Opti-Break will automatically

1. Try to consume any type of 'Store (offline or 'Online)', but the target yield must be met.
2. If some lites are not optimized Opti-Break will use a 'Restock' piece regardless of yield.
3. If some lites still are not optimized, Opti-Break will begin using 'Stock' pieces.

Because the remnant data is stored in both the Opti-Glass and the Opti-Break applications, 'Store' changes made in one application will apply to the other application.

In the Opti-Break application, the 'Store' can be viewed by selecting the 'Store' button on the 'Run / Selection' screen. From here, the user can add, edit, and delete the store information.

In the 'Store Selection' section, follow these steps to indicate which store pieces are to be included in the optimization:

1. Check **Force Store** to force store.
2. Using the **Machine: LISEC FLOAT** drop-down, indicate in the drop-down the cutting machine from which store pieces will be taken.
3. Check **Enabled** to indicate which store pieces are to be considered in the optimization.
4. Select 'Run'. This will take the user to the 'Part / Lot Number' screen (if 'Lot Tracking' is enabled'), or to the first pattern.

Note: The previous steps describe the process in 'Dynamic' mode, unless the user is running the 'Remakes' release in 'Batch' mode (which follows 'Dynamic' mode rules).

In the FeneVision Opti-Glass application, the lite is stored in the proper slot of the remnant rack for later use. The next time that part type is optimized, it will try to use that remnant to increase the yield. When this occurs, the remnant and slot number will be displayed in the pattern window.

Pattern	Yield	Size	Description
➔ 1	100.0 %	[S-4]108 x 144	GN-S14CL - 1/4 CL SS
2	98.6 %	[S-5]108 x 144	GN-S14CL - 1/4 CL SS
3	92.8 %	[OS2]108 x 144	GN-S14CL - 1/4 CL SS

In the example above, Opti-Break is indicating that the cutter is to use the 'Store' piece from slot 4. The size of this remnant is 108 x 144.

Completing a Run

When a release is completed, and all of the patterns have been cut, the 'Stop' button will return the user to the 'Run / Selection' screen. As the releases are completed, they will be removed from this screen.

Batch and Dynamic Mode

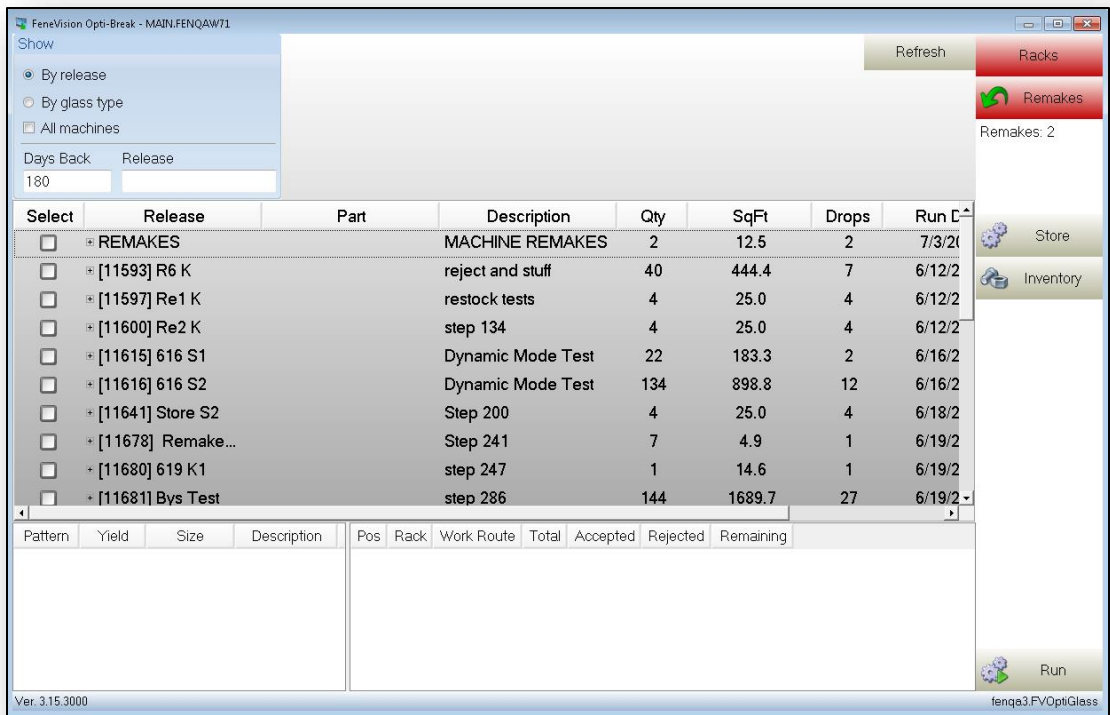
There are two modes of running production using the FeneVision Opti-Break application. For each machine, users will indicate the desired mode of production by setting the appropriate settings in the 'Machine Setup' screen in FeneVision Opti-Glass.

To access this screen in Opti-Glass, go to 'Settings' >> 'Machines'. Choose the machine name from the menu on the left. Select the 'Optimization' tab. Check the box labeled 'Enable' under the 'Dynamic Optimizer'. This will set that machine to 'Dynamic' mode. To retain 'Batch' mode, uncheck the 'Enable' box.

Note: The mode used should be determined by functionality the user desires, and capabilities of each machine.

Batch Mode

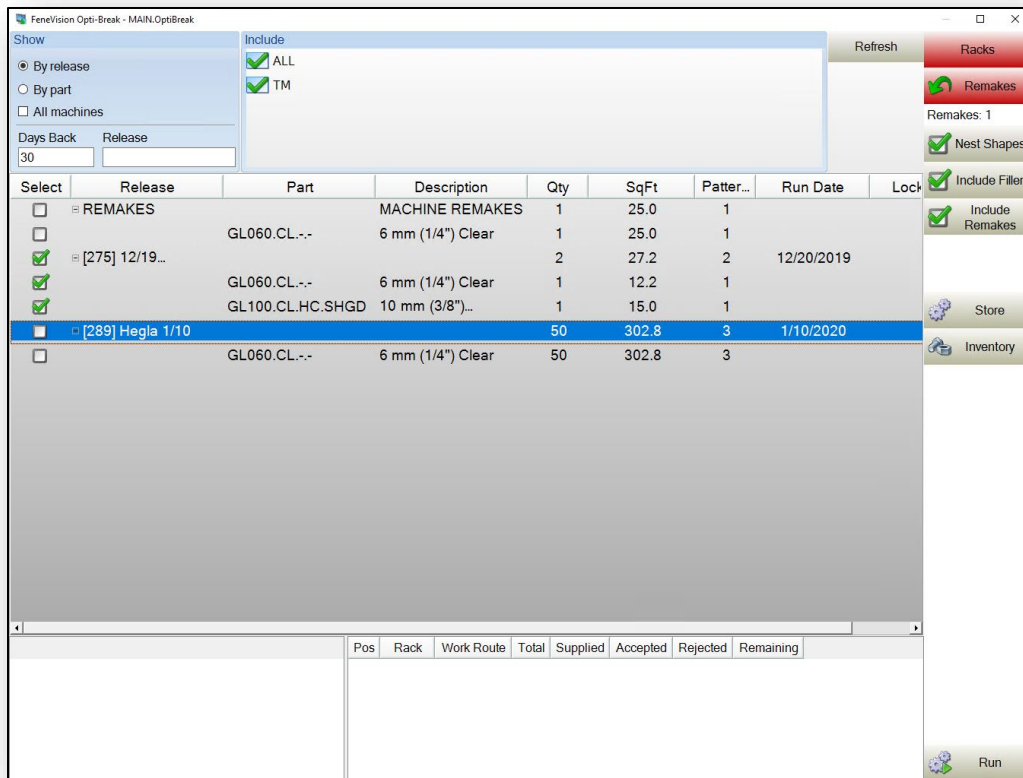
The image below displays the 'Run / Selection' screen as it appears in 'Batch' mode.



In this mode, the *patterns* that are generated when the 'Cutting' release is optimized in FeneVision Opti-Glass will be the exact same patterns that are displayed and cut at Opti-Break.

Dynamic Mode

The image below displays the 'Run / Select' screen as it appears in 'Dynamic' mode.



In this mode, the *patterns* generated when the ‘Cutting’ release is optimized in FeneVision Opti-Glass will not necessarily be the same patterns that get cut at Opti-Break. In ‘Dynamic’ mode, each pattern is re-optimized before being cut. This can improve yields if something changes during production (e.g., lite is rejected and needs re-cut).

When one pattern is completed, one more pattern will be optimized and added to the pattern queue. The user can select ‘Previous Patterns’ to see past patterns. If the user attempts to view the next pattern prior to completing the current pattern, the remaining un-accepted lites will all be marked as accepted. Remakes can be continuously fed into the current run if ‘Include Remakes’ feature is enabled. Rather than having to re-optimize remakes through Opti-Glass, any remakes that are not automatically re-optimized while processing a pattern will show up in a ‘Remakes’ release that is automatically generated in Opti-Break.

Note: If the parameter ‘RackPriorityMinimumPatterns’ is set through FeneVision Core, the optimizer will choose the next pattern based on which available pattern has the most glass pieces on the next rack.

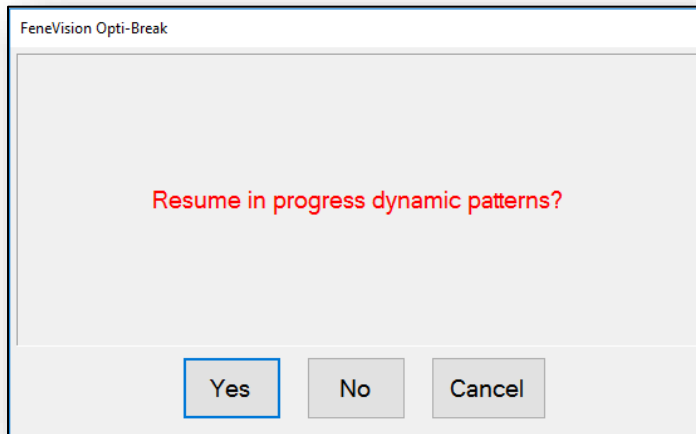
‘Dynamic’ mode has the capability of combining releases and optimizing them together for the best yields.

Note: To enable dynamic mode settings in FeneVision Opti-Glass, users must be activated using an activation code. Contact FeneTech for assistance.

Recalling a Dynamic Pattern

When using dynamic mode, users have the ability to recall patterns that were in progress when starting an Opti-Break run. This occurs when files have been generated from the dynamic machine, and the run has been stopped without completing.

The next time the user begins a run on the machine, Opti-Break will ask if the user would like to recall the previous dynamic pattern. This helps to save glass that may have already been loaded on the cutting machine when the run was stopped unexpectedly. The following message will appear:



Users may choose the following options:

- **Yes** – Users will be able to continue with the in progress dynamic release, before running the selected release.
- **No** – The dynamic pattern will be discarded, and a new run will begin.
- **Cancel** – Will take the user back to the main Opti-Break releases screen without running the release.

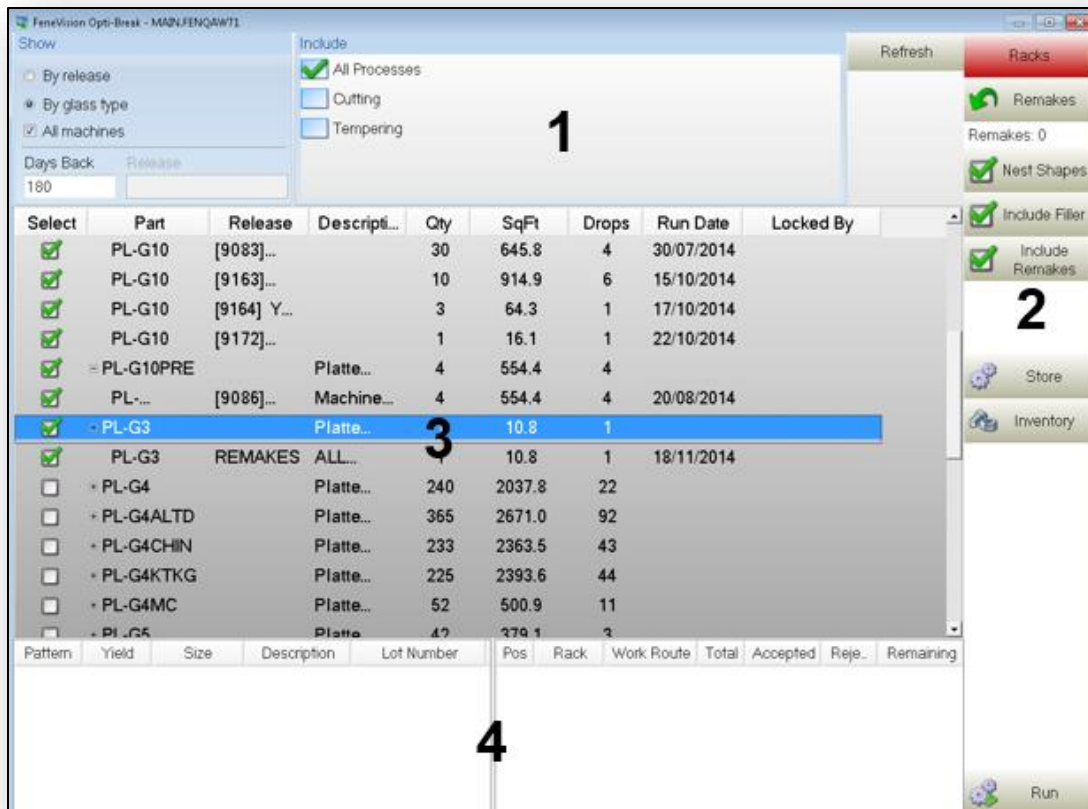
Note: The rack change screen will not show for the recalled patterns if there are any rack changes on those patterns.

Generating Files

When running an optimization machine files can be generated in both 'Batch' mode and 'Dynamic' mode. The generation of files out of Opti-Break occurs in two distinct modes:

- **Online** – Fully interfaced. This means that files can be generated "on the fly" at Opti-Break. FeneVision Opti-Glass will communicate with the cutting machine, so the user will not have to manually load each file at the cutting table. To enable this mode, the 'Online Mode' parameter must be enabled, and the 'Job File' parameter must be set to a valid path where a job file exists (or will exist) in Opti-Glass. Not all interfaces or cutting machines support 'Online' mode.
- **Semi-Online** – Partially interfaced. Opti-Break generates the files, but the operator must manually load them into the machine. Not all interfaces support 'Semi-Online' mode.

The Geography of the Run / Selection Screen



The screen is divided into four distinct parts:

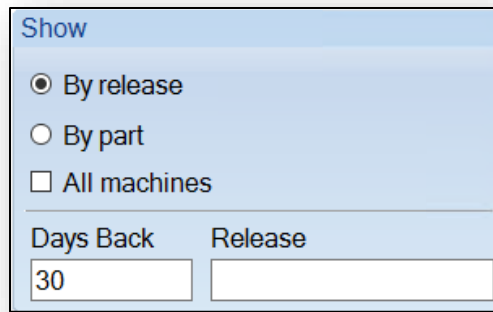
1. Filters and Processes
2. Buttons
3. Release and Glass / Interlayer Type Grid
4. Pattern / Rack List.

Filters and Processes

The top portion (1) of the 'Run Selection' screen allow users to filter the glass / interlayer shown on the screen at Opti-Break. One or more processes can be selected to filter the list.

Show

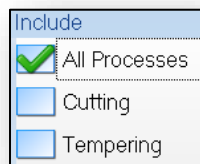
The following settings allow users to group and filter incoming data from FeneVision Opti-Glass.



- **By release** – Check ‘By release’ to group lites first by release, then by glass / interlayer type. Examples where this would be beneficial would be to cut by importance, customer, or chronological ordering.
- **By part** – Check ‘By part’ to group lites first by glass / interlayer type, then by release. Examples where this would be beneficial would be if the user wishes to run all patterns for a specific glass / interlayer type.
- **All Machines** – Check to see releases for all cutting machines in Opti-Glass.
- **Days Back** – From today’s date, indicate the number of calendar days back to view releases. Goes off the ‘Run Date’ of the release.
- **Release** – Indicated by the arrow, the field to enter the release identifier (enabled only when ‘By release’ is checked).




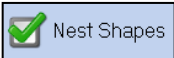

Include Process Filter





This section shows the various glass processes available when running a release. The ‘Release and Glass Type Grid’ will be filtered to only show releases that belong to the process(es) selected.



Buttons

The second section (2) of the ‘Run’ screen contains the various buttons used in the breakout process. The functions of the buttons shown in this screen are described below:

-  – Refreshes the ‘Release and Glass / Interlayer Type’ grid.
-  – Used to manage racking remakes. Allows Opti-Break to know when a remake rack has been taken away and a new one will start.
-  – Opens the ‘Remakes’ screen, which shows remakes that have yet to be marked complete.
-  – Allows shapes to nest during optimization. (‘Dynamic’ mode only).
-  – Allow lites from filler releases to be pulled onto patterns. This can increase the yields. (‘Dynamic’ mode only).

- 
 – Allows remakes to be pulled onto patterns. This can increase the yields. ('Dynamic' mode only).
- 
 – Opens the 'Store' screen, which shows all offline or online store slots and any remnant pieces that exist in the slot. From the 'Store' screen, users can transfer store pieces to the selected machine.
- 
 – Takes the user to the 'Inventory' screen, allowing users to relieve inventory. When integrating inventory, relieved inventory will display in FeneVision Core and FeneVision Opti-Glass.
- 
 – Runs the selected release or releases from 'Releases and Glass / Interlayer Types' grid. Once this button is selected, the user will be taken to the next step in the breakout process.

Release and Part Types Grid

Select	Part	Release	Descripi...	Qty	SqFt	Drops	Run Date	Locked By
<input checked="" type="checkbox"/>	PL-G10	[9083]...		30	645.8	4	30/07/2014	
<input checked="" type="checkbox"/>	PL-G10	[9163]...		10	914.9	6	15/10/2014	
<input checked="" type="checkbox"/>	PL-G10	[9164] Y...		3	64.3	1	17/10/2014	
<input checked="" type="checkbox"/>	PL-G10	[9172]...		1	16.1	1	22/10/2014	
<input checked="" type="checkbox"/>	- PL-G10PRE		Platte...	4	554.4	4		
<input checked="" type="checkbox"/>	PL-...	[9086]...	Machine...	4	554.4	4	20/08/2014	
<input checked="" type="checkbox"/>	- PL-G3		Platte...	3	10.8	1		
<input checked="" type="checkbox"/>	PL-G3	REMAKES	ALL...		10.8	1	18/11/2014	
<input type="checkbox"/>	- PL-G4		Platte...	240	2037.8	22		
<input type="checkbox"/>	- PL-G4ALTD		Platte...	365	2671.0	92		
<input type="checkbox"/>	- PL-G4CHIN		Platte...	233	2363.5	43		
<input type="checkbox"/>	- PL-G4KTKG		Platte...	225	2393.6	44		
<input type="checkbox"/>	- PL-G4MC		Platte...	52	500.9	11		
<input type="checkbox"/>	- PL-G5		Platte...	47	379.1	3		

The third section (3) of the 'Run' screen features the list of releases / glass types available to be run. Prior to a run, users will select the glass / interlayer to be run from this list. The columns can be displayed or hidden by right clicking anywhere inside of the grid and checking the appropriate columns to view.

<input checked="" type="checkbox"/>	Part
<input checked="" type="checkbox"/>	Release
<input checked="" type="checkbox"/>	Description
<input checked="" type="checkbox"/>	Qty
<input checked="" type="checkbox"/>	Area
<input checked="" type="checkbox"/>	Drops
<input checked="" type="checkbox"/>	RunDate
<input checked="" type="checkbox"/>	LockedBy

- Select** – Checkbox to select either the release or part type to cut.

- **Part** – Identifier of the part to be optimized (Release’ will show before ‘Part’ if ‘By release’ is chosen in the ‘Show’ area).
- **Release** – User-generated identifier of the release to be optimized.

Note: Selecting the + beside either the part identifier (by part type) or the release identifier (by release) will expand all part types associated with that release.

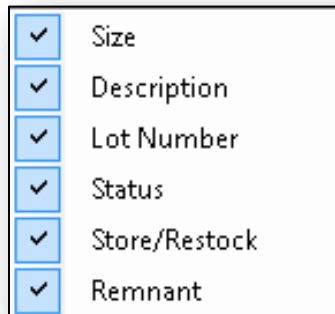
- **Description** – Detailed description of the part.
- **Qty** – Number of lites that have been optimized on a release and are available to cut.
- **Area** – Total area of the lites that have been optimized on a release and are available to cut. Defaults to ‘Imperial’.
- **Drops** – Estimate of how many sheets are needed for the particular release / part type. The estimate is made using the largest enabled size for the part type and assuming 80% yield.
- **Run Date** – Date on which the release or part type is to be run. Set in FeneVision Opti-Glass when the release is created.
- **Locked By** – Indicates the individual responsibility for the locked release or part type.

Patterns and Rack List

The bottom of each screen in Opti-Break is the ‘Patterns List’ and ‘Rack List’. This section will not be populated until the user is at the first pattern and is ready to accept or reject lites in a pattern.

Patterns List

The ‘Patterns List’ is found in the lower left and provides pattern details, displaying the current pattern that is being broken out (indicated by the green arrow). Right clicking on the column headers will reveal the column heading options:



Pattern	Yield	Size	Description	Lot Number	Status	Store/Restock	Remnant
➔ 1	90.0..	126 3/8 x..	PL-G4CHIN-..			✓	
2	56.2..	126 3/8 x..	PL-G4CHIN-..				
3	57.3..	126 3/8 x..	PL-G4CHIN-..				

- **Pattern (fixed column)** – Pattern number. In the image above, three patterns are shown each with the same dimensions and the same part description; however, multiple patterns can be included on a release.

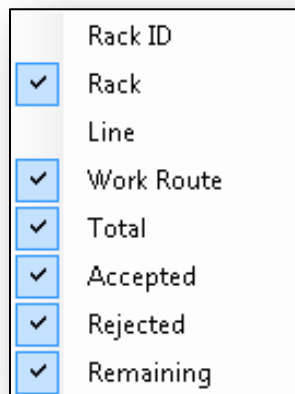
Note: Double-clicking on a pattern will reveal the 'Pattern Editor' screen where users can re-optimize patterns "on the fly". See 'Using Pattern Editor' under the 'Using' section for steps on how to use the 'Pattern Editor' functionality.

- **Yield (fixed column)** – Configured in FeneVision Opti-Glass, indicates the percentage of stock pieces that are not scrap generated per pattern. Will flicker in orange if the yield falls below the yield threshold, which is set up in Opti-Glass 'Machines' setup.
- **Size** – Size of the sheet used to cut the individual pattern. Patterns that are generated from on 'Restock' will have their 'Size' prefixed by 'RS'. Patterns generated on 'Store' or 'Online Store' will show each size prefixed by 'S[X]' or 'OS[X]' respectively where 'X' is the slot number where the remnant piece is currently being stored.
- **Description** – Part description. This is typically configured in FeneVision Core and synced to Opti-Glass.
- **Lot Number** – Identifier of the lot from which the part originated. If 'Lot Tracking' is enabled for the machine or on the part from Core, this lot number is assigned by the Opti-Break user.
- **Status** – Displays the pattern file name when generating files from Opti-Break. If an interface requires a status, the pattern file name's status will appear in this column. Not all interfaces will update the pattern status.
- **Store / Restock** – A check will appear if there is store or restock piece generated on the pattern.
- **Remnant** – The width of the last X-plate that does not contain production lites of glass or pieces of interlayer. This field will be blank if the piece is smaller than 10% of the stock width.

Note: The 'Remnant' field will also flicker in orange if the optimizer detects that it is possible to re-optimize that pattern using online store. This is only true of 'Online Store', not 'Offline Store' or 'Restock'.

Rack List

The section on the right provides a rack list. Right clicking on the column headers will reveal the column header options:



Pos	Rack	Work Route	Total	Accepted	Rejected	Remaining
1	38-G3	ISO2	24	0	1	20
2	38-G4	ISO2	15	0	0	6
3	45-G3	ISO2	39	0	0	21
4	56-G1	ISO2	4	0	0	4
5	17-9	ISO2	4	0	0	4

- **Pos (fixed column)** – Position of the rack around the cutting table. The position is determined by rack sequencing in FeneVision Opti-Glass.
- **Rack ID (hidden by default)** – Numeric identifier used internally by FeneVision. This ‘Rack ID’ does not match the ‘Rack ID’ generated in FeneVision Core.
- **Rack** – Rack tag comprised of the last two digits of the Schedule ID–Container prefix from Core (by default but can be customized).
- **Line (hidden by default)** – FeneVision Opti production line similar to the ‘Work Route’ from FeneVision Core. Intended for use when Opti-Glass is being used as a standalone product.
- **Work Route** – Identifies the work route to which the rack is assigned. Generated from ‘Work Route’ setup in Core.
- **Total** – Total number of lites that will go on the rack.
- **Accepted** – Number of lites on the rack that have been accepted.
- **Rejected** – Number of lites on the rack that have been rejected.
- **Remaining** – Total number of lites that have not been broken out that will go on the rack.

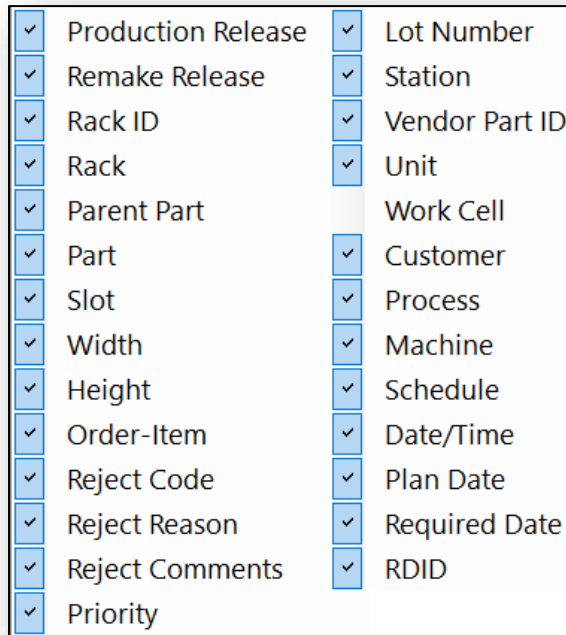
Remakes Screen

Select the ‘Remakes’ button.

Select	Production Release	Remake Release	Order-Item	Unit	Rack ID	Rack	Slot	Parent Part	Part
<input type="checkbox"/>	MDI		JS 1	1	26387	MDI	57	PL-G4	
<input type="checkbox"/>	MDI		JS 2	1	26387	MDI	58	PL-G4	
<input type="checkbox"/>	[9743] JS 4/8 Opt	[9745] JS 4/11 Opt	M-312573-1	6	34440	04-G1	12.1	PL-G8	PL-G8-6000x3210
<input type="checkbox"/>	[9743] JS 4/8 Opt		M-312573-1	6	34440	04-G1	11.1	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	MDI		BM16936	1	26387	MDI	61	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	[9743] JS 4/8 Opt		M-312573-1	7	34440	04-G1	12.2	PL-G8	PL-G8-6000x3210
<input type="checkbox"/>	[9743] JS 4/8 Opt		M-312573-1	8	34440	04-G1	11.3	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	MDI		JS 80	1	26387	MDI	62	BM9890Par..	
<input type="checkbox"/>	MDI	[9750] JS 4/13 Opt	JS 81	1	26387	MDI	63	PL-G4	
<input type="checkbox"/>	[9743] JS 4/8 Opt		M-312573-1	9	34440	04-G1	11.4	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	MDI		JS 82	1	26387	MDI	64	PL-G6	
<input type="checkbox"/>	[9754] JS 4/15 Opt	[9755] JS 4/18 Opt	M-312586-1	1	34453	15-G1	11.1	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	[9754] JS 4/15 Opt	[9755] JS 4/18 Opt	M-312586-1	1	34453	15-G1	11.2	PL-G4	PL-G4-6000x3210
<input type="checkbox"/>	[9743] JS 4/8 Opt		M-312573-1	10	34440	04-G1	12.5	PL-G8	PL-G8-6000x3210

On the right, the ‘All Machines’ filter exists allowing the user to only view remakes per release or remakes from all machines.

Right click in the column headers to reveal the available columns for the 'Remakes' grid.




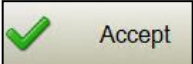

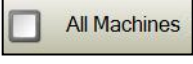
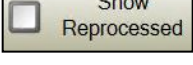
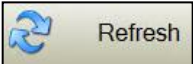



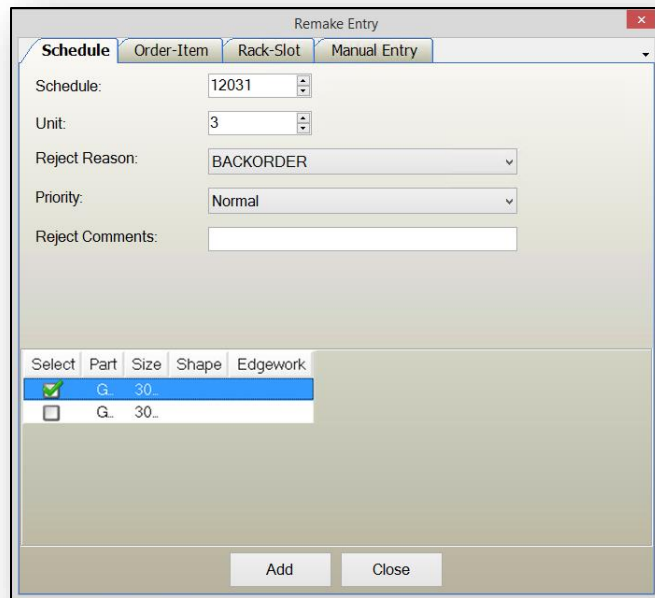
The remake screen displays the following:

- **Production Release** – Release on which the lite was originally optimized in Opti-Glass.
- **Remake Release** – Release on which the remake has been optimized in Opti-Glass.
- **Rack ID (*hidden by default*)** – Opti rack ID. This field can be used when writing SSRS reports. This does not match the rack ID generated through FeneVision Core. Used internally by FeneVision.
- **Rack** – Rack prefix configured in Core in 'Containers' setup and part of the Schedule ID.
- **Parent Part** – This indicates the 'Parent' part for the glass / interlayer type of the remake.
- **Part** – Alternative alphanumeric identifier of the lite (glass / interlayer type) of the remake.
- **Slot** – The position the remake will be placed on the rack once it is cut.
- **Width** – Width of the remake.
- **Height** – Height of the remake.
- **Order-Item** – Order number combined with item number from that order.
- **Reject Code** – Code that was used when the lite was rejected.
- **Reject Reason** – Reason the lite was rejected.
- **Reject Comments** – Comments entered when the lite was rejected. To get a 'Reject Comment', the station must be assigned a 'Reject Code' in Core.
- **Priority** – 'Reject Priority' selected when the lite was rejected (not required). To be able to assign a priority, the station must be assigned 'Reject Codes' in Core.
- **Lot Number** – If 'Lot Tracking' is enabled for the machine, this is the numeric identifier selected by the user. This number will be associated with the pattern, any remakes, and any store / restock that it generates.
- **Station** – Station ID that generated the remake.
- **Vendor Part ID** – Alpha-numeric identifier of the 'Vendor' part. This is different from the 'Part' number because parts could potentially have the same ID. The 'Vendor Part ID', however, distinguishes the same parts that are from different vendors

- **Unit** – Identifier of the unit being remade.
- **Work Cell (*hidden by default*)** – Work cell assigned to the rack.
- **Customer** – Customer who ordered the unit that is being remade.
- **Process** – Process under which this particular lite falls. Configured in the database. Contact FeneTech for more information.
- **Machine** – Cutting machine where lite was originally cut. The machine is assigned to the lite when it is accepted or rejected at Opti-Break. If the lite was rejected in FeneVision Opti-Temp, it will still show the cutting machine. If the lite was cut using a different machine than it was optimized for it will still be assigned the machine that cut it.
- **Schedule** – Schedule from Core containing the lite that needs remade.
- **Date/Time** – Identifier noting the date and time of the lite was rejected.
- **Plan Date** – Plan date associated with the original release. Manual remakes will not receive a ‘Plan Date’ as it was not processed in Core.
- **Required Date** – Date that the item is expected to arrive at the customer. This date is pulled from Order Entry in the Core application.
- **RDID** – Rack Detail ID number. This number is used as a unique identifier in the RackDetail table.

The following buttons appear in the ‘Remakes’ screen:

-  – **(Dynamic Mode Only)** If checked, only remakes that have the same ‘Vendor Part ID’ as the material being used to optimize will be included in the optimization.
-  – **(Dynamic Mode Only)** If checked, only remakes that have the same ‘Lot Number’ as the material being used to optimize will be included in the optimization.
-  – Allows the user to reset previously accepted remakes.
-  – Allows the user to manually accept remakes.
-  – Prints labels for the selected remakes.
-  – If checked, the list of remakes will contain remakes from all machines.
-  – If checked, reprocessed remakes will appear in addition to the unprocessed remakes. Reprocessed remakes will be highlighted in green.
-  – Refreshes the screen in case a remake has been added since the screen was initially opened.
-  – Allows the user to add a remake. Selecting this option will take the user to the following screen where the user can add a remake by ‘Schedule’, ‘Order-item’, ‘Rack-slot’, or ‘Manual Entry’:



- **Schedule Tab**
 - **Schedule** – Schedule ID number. This is pulled from ‘Production Scheduling’ in FeneVision Core.
 - **Unit** – Unit identification number.
 - **Reject Reason** – Allows user to indicate the ‘Reject Reason’ in the drop-down. These are set up in Core.
 - **Priority** – Drop-down to assign the remake a priority for how the remake will be reprocessed.
 - **Reject Comments** – Field to enter any comments associated with the remake.
 - **Grid** – The grid at the bottom will display the lite(s) matching the values selected above. Use the ‘Select’ checkboxes to select the lite(s) to add as remakes.

- **Order-Item Tab**
 - **Order** – Enter the Order number
 - **Item** – Enter the Item number
 - **Unit** – Enter the Unit identifier.
 - **Reject Reason** – Allows user to indicate the ‘Reject Reason’ in the drop-down. These are set up in Core.
 - **Priority** – Drop-down to assign the remake a priority for how the remake will be reprocessed.
 - **Reject Comments** – Field to enter any comments associated with the remake.
 - **Grid** – The grid at the bottom will display the lite(s) that meet match the above-selected values. Use the ‘Select’ checkboxes to select the lite(s) to add as remakes.

- **Rack-Slot Tab**
 - **Rack** – Enter the ‘Rack Tag’ of the lite to be remade.
 - **Rack ID** – Opti rack ID. This field can be used when writing SSRS reports. This does not match the rack ID generated through Core. Use the up / down arrows in the ‘Rack ID’ field to change the ‘Rack ID’
 - **Slot** – Enter the slot that the lite to be remade is assigned.
 - **Sched-Unit (read only)** – Schedule ID / Unit ID.
 - **Reject Reason** – Allows user to indicate the ‘Reject Reason’ in the drop-down. These are set up in Core.
 - **Priority** – Drop-down to assign the remake a priority for how the remake will be reprocessed.

- **Reject Comments** – Field to enter any comments associated with the remake.
- **Manual Entry**
 - **Customer** – Lists all customers from FeneVision Core
 - **Qty** – Enter the desired quantity to remake. Defaults to '1'.
 - **Components** – Number of components being remade. Defaults to '1'.
 - **Item Tag** – Identifier for the item
 - **Item Comment** – Field to enter any comments associated with the item.
 - **Machine** – Dropdown of available machines this remake will be performed on.
 - **Work Route [Line]** – Dropdown to identify which work route the item is to go through
 - **Reject Reason** – Allows user to indicate the 'Reject Reason' in the drop-down. These are set up in Core.
 - **Priority** – Drop-down to assign the remake a priority for how the remake will be reprocessed.
 - **Reject Comments** – Field to enter any comments associated with the remake.



- **All Machines** – When checked, remakes will be shown for all machines. This is helpful when there is excess glass / interlayer, but the current cutting table does not have any remakes of that glass / interlayer type. The operator can manually cut remakes from another table with the excess glass / interlayer then use this screen to mark the remakes as 'Cut' by tapping on them. This will turn them green.

Note: The 'All Machines' checkbox does not actually make these remakes available to be pulled into a 'Dynamic' optimization. 'Dynamic' optimization only allows remakes from the same machine to be reprocessed.



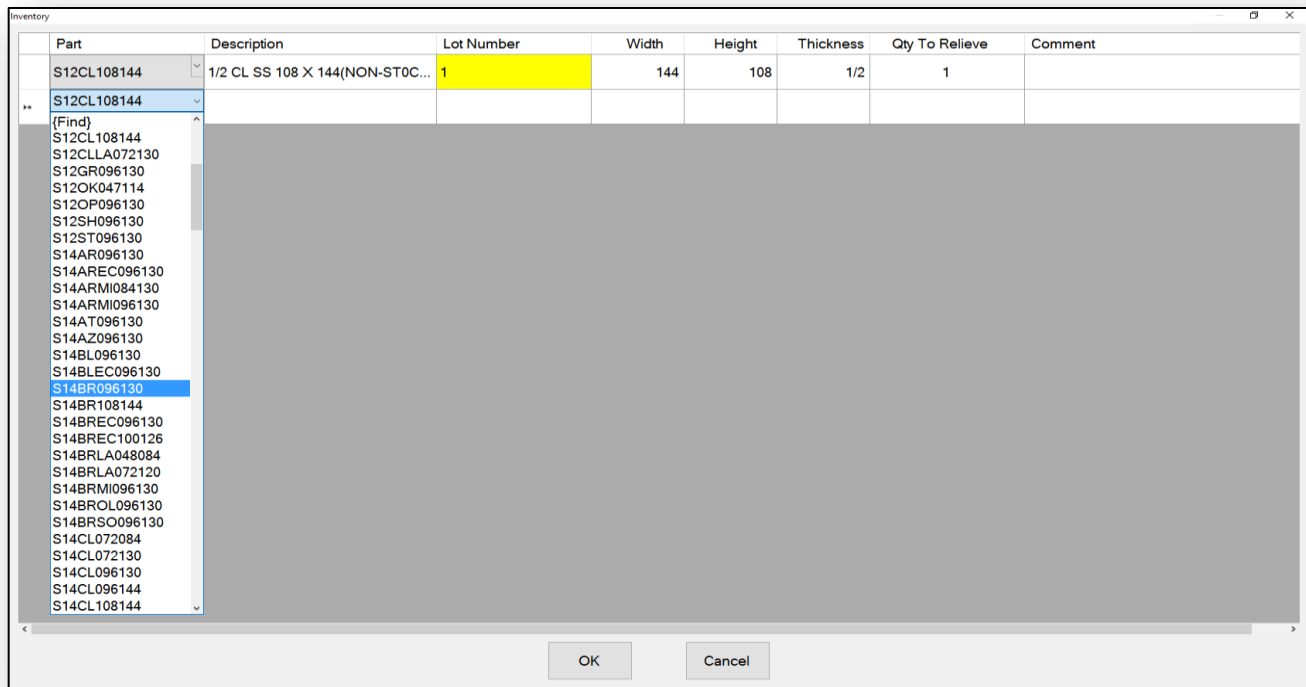
- **Refresh** – Refreshes the screen in case a remake appears while the user is in the 'Remakes' screen.

Within the 'Remakes' screen the operator has the ability to mark remakes as reprocessed by tapping on them. Once tapped the line will turn green but remain on the screen until the 'Remakes' screen is closed, or 'Refresh' is selected. This provides a chance to correct remakes that were accidentally accepted. If a remake was accidentally tapped simply tap it again to remove the reprocessed status. It will no longer be green. When a remake is marked complete, the remake count will decrease. Selecting 'Remakes' again will return the user to the 'Run / Selection' screen.

Note: The 'Remakes' screen can still be opened after the user as started a run. At this point, any remake that cannot be included in the run because it is a different glass / interlayer type, different lot number (if 'Filter Lot Number' is enabled), or a different 'Vendor Part ID' (if 'Filter Vendor Part ID') is enabled will appear grayed out indicating that the optimizer is not attempting to place this lite.

Inventory Screen

The 'Inventory' screen allows the user to relieve a part from inventory.

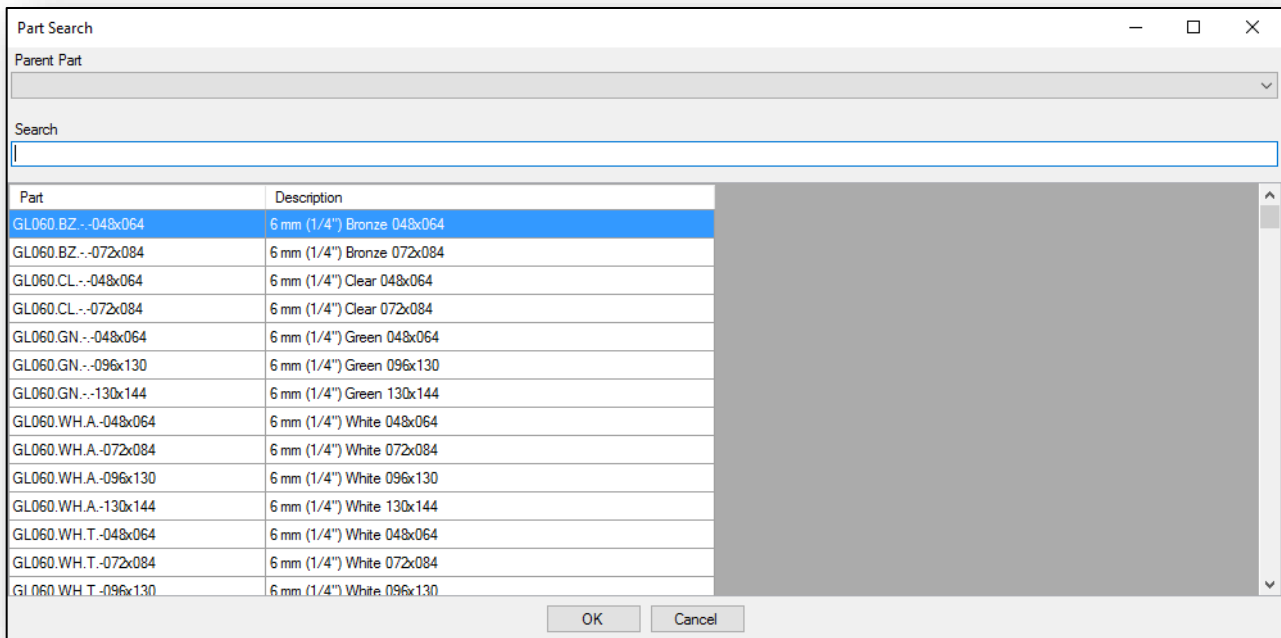


The following fields exist in the 'Inventory' screen:

- **Part** – Drop-down to choose which stock sheet to relieve. Part drop-down is populated from FeneVision Core.
- **Description** – Description of the part including width and height.
- **Lot Number** – Identifier of the lot from which the glass / interlayer originated. If 'Lot Tracking' is enabled for the machine or on the part from FeneVision Core, this lot number is assigned by the Opti-Break user.
- **Width** – Exact width of the stock sheet.
- **Height** – Exact height of the stock sheet.
- **Thickness** – Thickness of the stock sheet.
- **Qty To Relieve** – Field to indicate how many of each part to relieve from inventory.
- **Comment** – Any comments associated with relieving the part.

To relieve a part from inventory:

1. Use the drop-down in the 'Part' column to choose a stock sheet to relieve from inventory. Typing in this drop down will take focus to the first part number matching what is typed. Also, use the {Find} selection to open the 'Part Search' dialog (shown below). In this dialog, filter by parent part or search by typing part number.



2. Select the 'Description' field in the grid. The part information will populate.
3. The default 'Qty To Relieve' is 1. This number can be changed.
4. Insert any comments associated with relieving the part in the 'Comment' field.
5. Select 'OK'. To cancel, select 'Cancel'. Relieved quantities will be updated in Core.

Note: If CORE is configured to not allow inventory to drop below 0 from a manual adjustment, then the user will be prevented from finishing a relief that would cause either a part's quantity on hand, bin quantity, or lot quantity to go negative.

Store Screen

This feature is used to store remnants from sheets that are not fully consumed. Machines can be set up to use 'Store' or 'Online Store'. These settings operate independent of each other. To access the 'Store' screen, select the 'Store' button while in the 'Run' screen. The image below represents a machine with 'Online Store' available.

Store Online Store

Column: (All)

Select	Slot	Parent Part	Part	Description	Width	Height	Thickness	Lot Number	Vendor Part ID	Date	Status	Locked By
<input checked="" type="checkbox"/>	1	GN-S14CL	S14CL072084	1/4 CL SS	24 1/4	19 1/4	1/4			9/10/2015	Pending...	
<input type="checkbox"/>	2	GN-S14CL		1/4 CL SS	100	80	1/4			7/11/2014	Optimize...	
<input type="checkbox"/>	3	GN-S316CL	S316CL108144	3/16 CL SS	108	60	3/16	1		8/19/2014	Pending...	
<input type="checkbox"/>	4	GN-S316CL	S316CL108144	3/16 CL SS	108	60	3/16	1		8/19/2014	Pending...	
<input type="checkbox"/>	5	GN-S14CL	S14CL096130	1/4 CL SS	200	160	1/4			9/21/2015	Optimize...	
<input type="checkbox"/>	6	GN-S14CL	GN-S14CL	1/4 CL SS	126 27...	88 37/64	1/4			9/21/2015	Pending...	
<input type="checkbox"/>	7	GN-S14CL	GN-S14CL	1/4 CL SS	126 27...	71 27/64	1/4			9/21/2015	Pending...	
<input type="checkbox"/>	8	GN-S14CL	S14CL072084	1/4 CL SS	50	4 1/2	1/4			6/10/2015	Pending...	
<input type="checkbox"/>	9	GN-S14EN	S14EN096130	1/4 LOWE SS	50	36	1/4			6/10/2015	Pending...	
<input type="checkbox"/>	10	GN-S14GR	S14GR096130	1/4 GRAY SS	35	10	1/4			6/10/2015	Pending...	
<input type="checkbox"/>	11	GN-S14CL	S14CL108144	1/4 CL SS	108	43 7/32	1/4	12		11/19/20...	Availabl...	
<input type="checkbox"/>	12	GN-S14CL	S14CL072084	1/4 CL SS	84	61 9/64	1/4			1/25/2016	Pending...	

Pattern	Yield	Size	Description	Lot Number	Status	Pos	Rack	Work Route	Total	Supplied	Accepted	Rejected	Remaining

Run

Transfer Racks

Remove Remakes

Remakes: 27

Print Nest Shapes


Include Filler

Include Remakes

Refresh Inventory

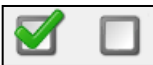
Note: Contact FeneTech for more information on enabling 'Store' functionality in Opti-Break.

The Opti-Break 'Store' screen displays the following functions:

- **Transfer** – Performs the transfer to the other cutting machine. Once the user confirms the transfer, that store slot will become empty.
- **Remove** – Remove selected store pieces.
- **Print** – Prints the store label for 'Available' store pieces.
-  – Refresh button.
- **Store Tab** – Displays all offline storage slots. Allows the user to add, edit, or remove 'Available' store pieces, view 'Pending' or 'Optimized' store pieces, print store labels, and transfer 'Available' store pieces to another machine.
- **Online Store Tab** – This tab is hidden if a machine does not support the 'Online Store' functionality. The image below displays the 'Online Store' tab.

Select	Slot	Parent Part	Part	Description	Width	Height	Thickness	Lot Number	Vendor Part ID	Date	Status	Locked By
<input checked="" type="checkbox"/>	1	GL060.BZ.-.-	GL060.BZ.-.-0...	6 mm (1/4") Bronze	40	90	1/4			10/7/2016	Availabl...	
<input type="checkbox"/>	2	Empty										
<input type="checkbox"/>	3	Empty										
<input type="checkbox"/>	4	Empty										
<input type="checkbox"/>	5	Empty										
<input type="checkbox"/>	6	Empty										
<input type="checkbox"/>	7	Empty										
<input type="checkbox"/>	8	Empty										
<input type="checkbox"/>	9	Empty										
<input type="checkbox"/>	10	Empty										
<input type="checkbox"/>	11	Empty										
<input type="checkbox"/>	12	Empty										

Pattern	Yield	Size	Description	Lot Number	Status	Pos	Rack	Work Route	Total	Supplied	Accepted	Rejected	Remaining



- – Select All / Deselect all store pieces with a status of ‘Available’.
- **Select** – Checkbox to individually select store pieces to move or transfer.
- **Slot** – Slot number of ‘Store’ piece. These remain static.
- **Parent Part** – The ‘Parent’ glass / interlayer part of the store piece. Typically, this would be the ‘Part Type’ (required).
- **Part** – Stock sheet from which the store piece originated (optional).
- **Description** – Description of the part. If this is blank, this will be populated with a description of the ‘Parent Part’ (automatically filled based on ‘Parent Part’ and ‘Part’).
- **Width** – Store piece’s width.
- **Height** – Store piece’s height.
- **Thickness** – Thickness of the store piece. Auto-filled based on the ‘Parent Part’ and ‘Part’.
- **Vendor Part ID** – Alphanumeric identifier of the ‘Vendor’ part from which the ‘Store’ piece was generated. This is different from the ‘Part’ number in that parts could potentially have the same number; the ‘Vendor Part ID’, however, distinguishes two of the same parts from different vendors.
- **Lot Number** – Identifier of the lot from which the glass / interlayer originated. If ‘Lot Tracking’ is enabled for the machine or on the part from FeneVision Core, this lot number is assigned by the Opti-Break user.
- **Status** – The status of the ‘Store’ piece.
 - **Pending** – The ‘Store’ piece has been generated on a release, but the release has not yet been cut. Therefore, the slot is reserved for this store piece (which has yet to be broken out). The release number indicates what release generated this ‘Store’ piece.

Note: ‘Store’ generated in ‘Dynamic’ mode will not receive a ‘Pending’ status because it is generated at the time of processing.

- **Available** – Store piece is available to be used in another optimization. The release number indicates what release generated this ‘Store’ piece.
- **Optimized** – The store piece has been optimized on another release. The release number indicates what release has consumed this ‘Store’ piece.

Note: Users will not always see a release number following the status. If ‘Manual’ or ‘Dynamic’ follows the release status, this means that the store piece was manually added or that it was generated through a ‘Dynamic’ optimization. Neither of these secondary statuses will appear on pieces with a status of ‘Optimized’.

Rack Groups Screen (‘Dynamic’ Mode Only)

Once the user selects ‘Run’ in the ‘Run / Selection’ screen (and before the ‘Material Selection’ screen when operating in ‘Dynamic’ mode) the ‘Rack Groups’ screen will appear. The ‘Rack Groups’ screen allows the user to group together racks in the desired manner. If racks are grouped, then racks from the first group will be given priority and optimized first before racks from the next group.


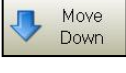



Select	Plan Date	Rack	Rack ID	Release	Schedule	Line	Work Route	Total	Accepted	Rejected	Available	Selected	
<input checked="" type="checkbox"/>	1/10/2014	67-LR1	47795	[11385]	12167	DEF	AI	20	0	0	20	20	Move Up
<input checked="" type="checkbox"/>	1/10/2014	68-LR3	47796	[11385]	12168	DEF	AI	10	0	0	10	10	Move Down
<input checked="" type="checkbox"/>	1/10/2014	69-LR7	47797	[11385]	12169	DEF	AI	20	0	0	20	20	
<input checked="" type="checkbox"/>	1/10/2014	70-LR9	47798	[11385]	12170	DEF	AI	20	0	0	20	20	
<input checked="" type="checkbox"/>	1/10/2014	71-LR11	47799	[11385]	12171	DEF	AI	20	0	0	20	20	
<input checked="" type="checkbox"/>	1/10/2014	72-LR13	47800	[11385]	12172	DEF	AI	10	0	0	10	10	Insert Group
<input checked="" type="checkbox"/>													Remove Group

In the ‘Rack Groups’ screen, the following columns are available:

- Release
- Schedule
- Line
- Work Route
- Rack ID
- Plan Date
- Rack
- Area
- Total
- Accepted
- Rejected
- Available
- Selected

- **Release** – Release the rack was optimized on in FeneVision Opti-Glass. It will appear as “[ReleaseID] Release Name”.
- **Schedule** – Schedule ID / schedule description. This is pulled from ‘Production Scheduling’ in FeneVision Core.
- **Line (hidden by default)** – FeneVision Opti production line similar to the ‘Work Route’ from FeneVision Core. Intended for use when Opti-Glass is being used as a standalone product.
- **Work Route** – Work route the rack is assigned to.
- **Rack ID (hidden by default)** – Opti rack ID. This field can be used when writing SSRS reports. This does not match the rack ID generated through Core.
- **Plan Date** – Planned date to cut the rack. This date is generated one of two ways:
 - When ‘Work Route Release’ is overridden by plan date in ‘Production Scheduling’ in Core, or
 - The date to which the schedule was released.
- **Rack** – Rack prefix configured in Core ‘Containers’ setup and part of the Schedule ID.
- **Area (SqFt or SqM)** – Total area of glass / interlayer on the rack. Calculated based on the dimensions of the lites on the rack.
- **Total** – Total number of lites on this rack of the selected glass / interlayer types.
- **Accepted** – Lites on the rack that have been accepted.
- **Rejected** – Lites on the rack that have been rejected.
- **Available** – Number of lites on the rack for the selected glass / interlayer types that are not on a release.
- **Selected** – The number of lites on the rack for the selected glass / interlayer types that are on this release.

The following buttons appear on the right side of the ‘Rack Groups’ screen:

-  – Navigational arrows to move among the rack groups. This enables the user to move racks up and down so that groups can be positioned in the desired manner.
-  – Navigational arrows to move among the rack groups. This enables the user to move racks up and down so that groups can be positioned in the desired manner.
-  – Adds another rack group split into the grid. Selecting this button will insert a new group split above the currently selected rack.
-  – Removes the selected group splitter. To select a group splitter, select the arrow in the row header.
-  – Reset groups. Any changes the user has made to groups will be undone (inserted groups, removed groups, manually moved groups).

Note: Even when the user is in ‘Dynamic’ mode, the ‘Rack Groups’ screen will remain hidden when the user is running the ‘Remakes’ release.

Materials Selection Screen

From this screen, the user can select stock pieces, store pieces, and restock pieces to be used in the optimization. The ‘Stock Selection’ grid is located at the top of the screen. This grid allows the user to select which stock sheets and ‘Restock’ sheets to use in the optimization. The ‘Store Selection’ grid is located at the bottom (if the machine is set to ‘Consume Store’). This grid allows the user to select ‘Available’, ‘Store’, and / or ‘Online Store’ pieces to use in the optimization.



GN-S14CL															GN-S14CLLA		GN-S14DI	
Enabled	Part	Machine	Description	Size	Use...	T...	L	R	T	B	I	Parent Part	Vendor Part ID	Lot Number				
<input checked="" type="checkbox"/>	S14CL072084		[Description Pending]	72 x 84	-1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL						
<input checked="" type="checkbox"/>	S14CL072130		1/4 CL SS 72 X 130	130 x 72	-1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL						
<input checked="" type="checkbox"/>	S14CL096130		1/4 CL SS 96 x 130	130 x 96	-1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL						
<input checked="" type="checkbox"/>	S14CL108144		1/4 CL SS 108 X 144	144 x 108	-1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL						
<input checked="" type="checkbox"/>	S14CL072084 BW...		[Description Pending]	55 x 5	1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL						
<input checked="" type="checkbox"/>	S14CL108144 BW...		1/4 CL SS 108 X 144	108 x 6	1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL		2				
<input checked="" type="checkbox"/>	S14CL072084 BW...		[Description Pending]	84 x 3 1/4	1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL		UE				
<input checked="" type="checkbox"/>	BW...		1/4 CL SS	84 x 42	1	<input checked="" type="checkbox"/>	2...	2...	2...	2...	2...	GN-S14CL		UE				
<input checked="" type="checkbox"/>	BW...		1/4 CL SS	84 x 42	1	<input checked="" type="checkbox"/>	2	2	2	2	2	GN-S14CL		UE				

Enabled	Store	Slot	Type	Parent Part	Part	Description	Size	T...	L	R	T	B	I	Vendor Part ID	Lot Number
<input checked="" type="checkbox"/>	BW...	11		GN-S14CL	S14CL108144	1/4 CL SS 108 X 144	108 x 43 7/32	<input checked="" type="checkbox"/>	25/32	25/32	25/32	25/32	25/32		12

Note: Each part type on a release is separated into a different tab. The tabs are listed across the top with the part identifier of the part type on the tab.

Stock / Restock Selection Grid

The following required columns are shown in the 'Stock Selection' (top) portion of the screen:

- Enabled** – Check to enable the specific part to be used within the optimization. In the ribbon above the grid, check   (left box) to enable all; check right box to disable all. This can be defaulted by enabling or disabling the 'Stock Sizes Selected by Default' checkbox in the Settings Tab of the station's settings.
- Part** – Identifies the part from the 'Inventory' settings in FeneVision Opti-Glass. This is the stock sheet that will be used during optimization. For remnants this is the stock sheet from which the remnant originated. This can be blank for remnants.
- Machine** – Name of the cutting machine that generated the remnant. In this portion of the screen, when a machine name is displayed, it indicates that the part is a restock piece.
- Description** – Description of the part. The description is generated from FeneVision Core.
- Size** – Dimensions of the sheet. Displayed as length x width.
- Use Max** – How many sheets the optimizer can use. Defaults to the 'Quantity On Hand' for that part. Unlike the Use Max field when optimizing in Opti-Glass, it ignores the 'Quantity Allocated' in Opti-Break. This is because optimizing in Opti-Break is right when a release will start being run. So it intentionally considers only the actual Quantity on Hand. Setting this to '-1', allows the optimizer to use unlimited sheets. For 'Restock' sheets this should always be '1'.
- Trims** – Checkbox to indicate if specified stock trims will be applied to this stock / restock sheet.
- L** – Left trim. Amount taken off the left side of the sheet.
- T** – Top trim. Amount taken off the top of the sheet.
- R** – Right trim. Amount taken off the right side of the sheet.
- B** – Bottom trim. Amount taken off the bottom of the sheet.

- **I** – Internal trim. Assures that no two scores are within a certain distance of each other. Would be set to the smallest piece that can be safely broken out.

Note: All trims are relative to the 'Pattern Zero Location' being in the lower left corner; therefore, setting a left trim and then setting the 'Pattern Zero Location' to be on the right will result in the left trim always appearing on the right.


- **Parent Part** – This indicates the 'Parent' part for the 'Stock/Restock' sheet. This will typically be the 'Glass / Interlayer Type'. Generated from the 'Inventory' settings screen in FeneVision Opti-Glass.
- **Vendor Part ID** – Alpha-numeric identifier of the 'Vendor' part. This is different from the 'Part' number in that parts could potentially be the same physically, but never the same part number. The 'Vendor Part ID' distinguishes two of the same parts from different vendors.
- **Lot Number** – Identifier of the lot from which the glass / interlayer originated. If 'Lot Tracking' is enabled for the machine or on the part from Core, this lot number is assigned by the Opti-Break user (*only applies to 'Restock' pieces since 'Stock' pieces have not yet been assigned a lot number*).

Store Selection Grid

In 'Dynamic' mode, the bottom screen will contain a list of the store sheets available. The fields and fixed columns shown in the 'Materials Selection' (bottom) portion of the screen indicate the following:

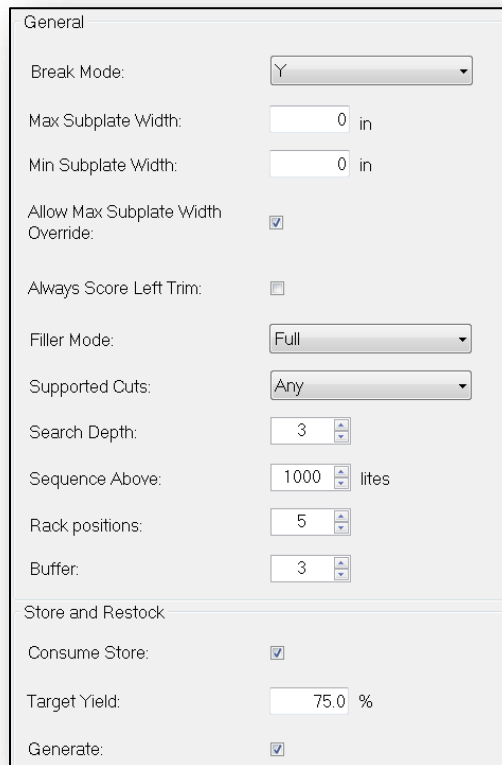
- **Force Store** – Checkbox to indicate whether to force store to be consumed. When this is checked, the target store yield will be set to 0.01 in order to always consume store. When unchecked store consumption will use the normal target yield.
- **Machine:** – Drop down to indicate which cutting machine from which to pull the store pieces. This will default to the machine running Opti-Break. This drop down will be hidden if 'Consume' store is not checked in the 'Settings' screen.
- **Enabled** – Check to enable. In the ribbon above the grid, check (left box) to enable all; check right box to disable all.
- **Machine** – Name of the cutting machine.
- **Slot** – Slot number of intended 'Store' piece. These remain static.
- **Type** – Designates which type of store piece the lite is, e.g., piece ABC is placed in slot 1 of offline storage; piece DEF is placed in slot 1 of online storage.
 - **Online** – Selected interface supports online storage and has an online parameter 'Store Capacity' set at > 0.
 - **Offline** – Online parameter store is not enabled for that machine (this option is not visible).
- **Parent Part** – The 'Parent' glass / interlayer part of the store piece. Typically, this would be the 'Glass / Interlayer Type' (required).
- **Part** – Stock sheet from which the store piece originated (optional).
- **Description** – Description of the part. If this is blank, this will be populated with a description of the 'Parent Part' (automatically filled based on 'Parent Part' and 'Part').
- **Size** – Length x width dimensions.
- **Trims** – Checkbox to include or exclude the trims when optimizing on this sheet of glass / interlayer.
- **L** – Left trim. Amount taken off the left side of the sheet.
- **T** – Top trim. Amount taken off the top of the sheet.
- **R** – Right trim. Amount taken off the right side of the sheet.
- **B** – Bottom trim. Amount taken off the bottom of the sheet.
- **I** – Internal trim. Assures that no two scores are within a certain distance of each other. Would be set to the smallest piece that can be safely broken out.

Note: All trims are relative to the 'Zero Pattern Location' being in the lower left corner; therefore, setting a left trim and then setting the 'Zero Pattern Location' to be on the right will result in the left trim always appearing on the right.

- **Vendor Part ID** – Alpha-numeric identifier of the Vendor part. This is different from the Part number in that parts could potentially be the same physically but should never have the same part number. This is the identifier pulled from 'Inventory' setup in FeneVision Opti-Glass. The Vendor Part ID distinguishes two of the same parts from different vendors.
- **Lot Number** – Identifier of the lot from which the glass / interlayer originated. If 'Lot Tracking' is enabled for the machine or on the part from FeneVision Core, this lot number is assigned by the Opti-Break user.
-  – Delete store piece.

Settings ('Dynamic' Mode Only)

Select the 'Settings' button to access the 'Settings' screen. This button is only available in the 'Material Selection Screen' when starting a run.



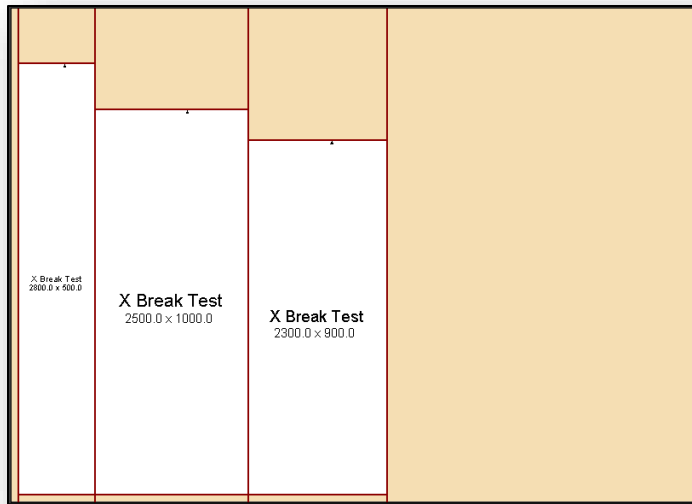
The screenshot shows the 'General' section of the 'Settings' screen. It contains the following fields and controls:

- Break Mode:
- Max Subplate Width: in
- Min Subplate Width: in
- Allow Max Subplate Width Override:
- Always Score Left Trim:
- Filler Mode:
- Supported Cuts:
- Search Depth:
- Sequence Above: lites
- Rack positions:
- Buffer:
- Store and Restock section:
 - Consume Store:
 - Target Yield: %
 - Generate:

General Section

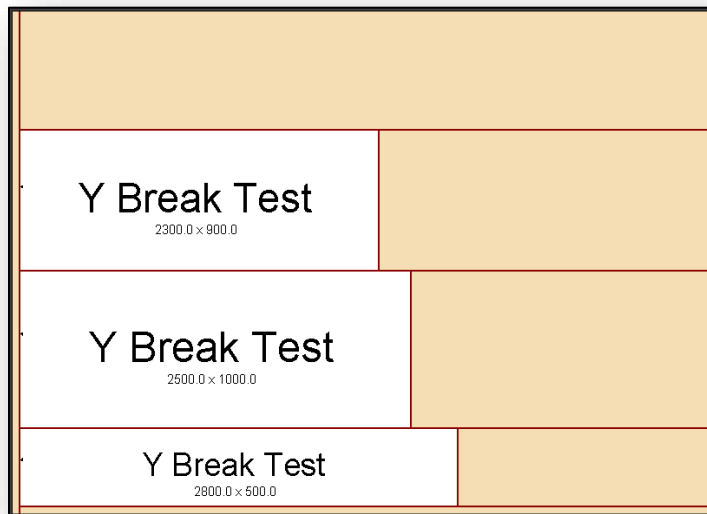
The following fields exist in the 'General' section of the 'Settings' screen:

- **Break Mode**
 - **X** – X Cuts create the subplates.



- **Y – Y** cuts create the subplates.

Note: This is ideal for optimizations with several long narrow lites.



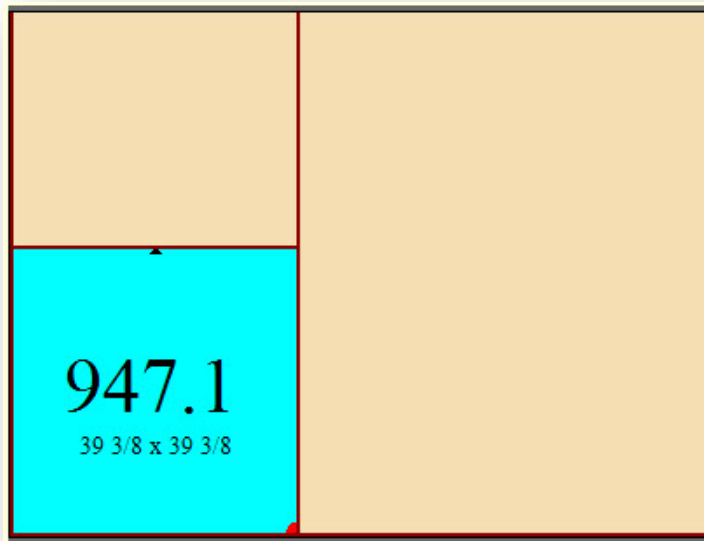
- **XY** – Both X break and Y break optimizations occur “behind the scenes”. The algorithm selects the better of the two optimizations to use.

Note: XY Break Mode will take longer to optimize than other modes.

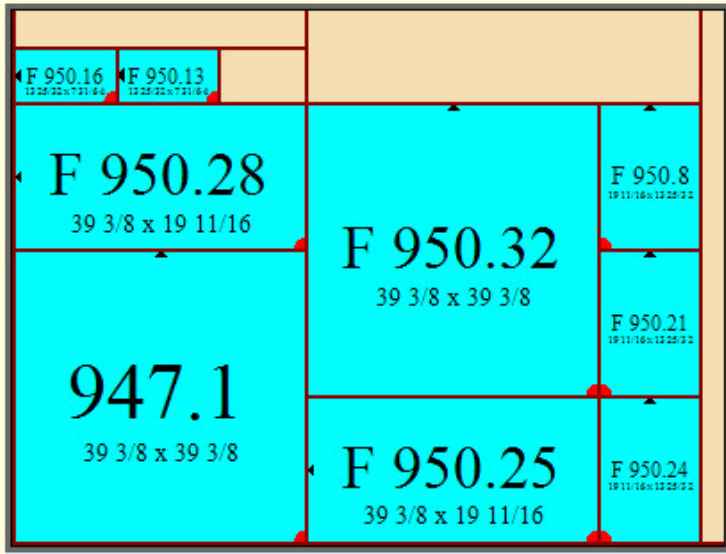
- **Lami** – Optimizes with only X, Y, and Z cuts, but attempts to minimize the number of Z cuts that occur. This can potentially hurt yields.

Note: X cuts in 'Y Break Mode' can still create the subplates if the stock sheet's width is greater than the 'Max Subplate Width'.

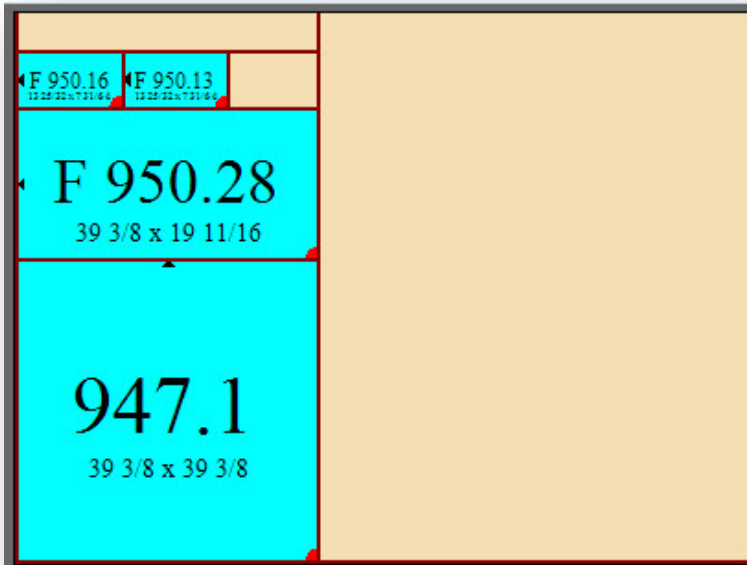
- **Max Subplate Width** – Maximum width between any two X-cuts. The algorithm will never try to put two X cuts (vertical cuts from bottom to top) farther than the maximum subplate width. If a lite is larger than this value or one side is larger, and it cannot be rotated, it is excluded from the optimization unless the 'Allow Max. Subplate Width Override' is enabled.
- **Min Subplate Width** – Minimum distance between any two X-cuts. The algorithm will never try to put two X cuts (vertical cuts from bottom to top) closer than the minimum subplate width. If a lite is smaller than this value or one side is smaller, and it cannot be rotated, it will be excluded from the optimization. There is no option to allow overrides for minimum subplate width.
- **Allow Max Subplate Width Override** – Allows production pieces that cannot be optimized without violating the 'Max. Subplate Width' parameter to be optimized. The 'Max. Subplate Width' is ignored for only those pieces that would not fit if the constraint existed.
- **Always Score Left / Right Trim** – When the last X cut is close to the end of the pattern, the algorithm can choose to remove it and extend all of the Y scores to the edge of the stock sheet. Checking 'Always Score 'Right / Left Trim' assures that the algorithm adds the trim near the edge of the pattern and ends the Y scores at that trim, rather than extending the Y scores to the edge.
- **Filler Mode** – This mode will be used when filling out empty space on patterns with filler lites.
 - **Disabled** – No filler lites will be placed on the patterns. See below for an example of a pattern with filler mode disabled.



- **Full** – Filler lites will be used where they fit anywhere there is scrap on a pattern. See below for an example of a pattern with filler mode set to 'Full'. The lites marked with an 'F' are filler lites.



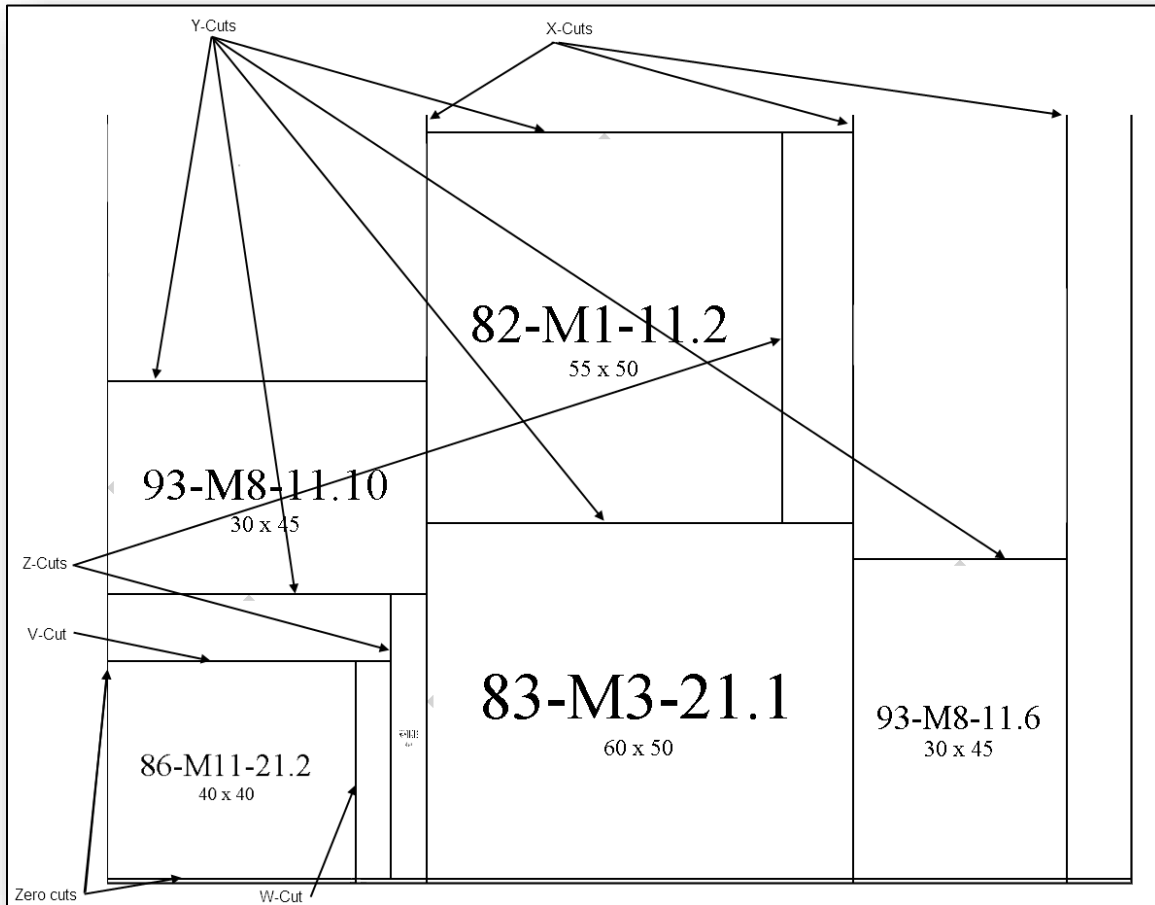
- **Subplate** – Filler lites will only be used to fill the scrap within the subplates on a pattern. They will not be used to fill-in any scrap outside the final X cut on a pattern. See below for an example of a pattern with filler mode set to 'Subplate'. The lites marked with an 'F' are filler lites.



Note: 'Filler' lites are lites that do not need to be cut yet; however, if there is room on the stock sheet that will go to waste then these are pulled into the patterns. 'Filler' lites will take priority over 'Stored' or 'Restocked'.

- **Supported Cuts** – Setting to indicate which cuts are supported for the machine.

- **XYZ, XYZV, XYZVW, or Any** – Indicates types of cuts the machine will support. Below represents an image of an XYZVW cut structure. The image below represents an XYZW cut structure.



- **X-CUT** – Vertical score made along a point on the X-axis. X-CUTs travel between the top and bottom of the sheet.
 - **Y-CUT** – Horizontal score made along a point on the Y-axis. Y-CUTs travel between any two X-CUTs or the sides of the pattern.
 - **Z-CUT** – Vertical score with at least one endpoint on a Y-CUT and no endpoint on a V-CUT.
 - **V-CUT** – Horizontal score with at least one endpoint on a Z-CUT.
 - **W-CUT** – Vertical score with at least one endpoint on a V-CUT.
- **Any** – Includes any cuts supported by FeneVision. Currently, 'Any' and 'XYZVW' are the same.
- **Search Depth** – This setting controls the amount of effort the algorithm exerts to improve yields. This will be a numeric value between 1 and 10. The higher the number, the harder the algorithm will work, which can result in better yields. However, it will also increase the amount of time it takes to optimize. Users are encouraged to experiment with search depths to find what works best. Additionally, this can be changed per release when optimizing.

- **Sequence Above** – This setting only applies to lites from Stacked Racks (A-Frame Racks or L Racks) and does not apply to lites from Harp Racks. If the number of lites included in the release from a particular Stacked Rack exceeds this value, then the optimization algorithm will force the breakout sequence to conform to the desired rack-position-slot-sequence determined by the work route sequencing. If the number of lites in the optimization is less than or equal to this value, sequencing is ignored. Entering a value of 0 into this setting will keep the lites from being sequenced regardless of the number of lites.

Note: Sequencing the optimization will often have a negative impact on material yield. This occurs because there exists a specific order in which lites must be broken out; thus, the algorithm is restricted in what it can do. However, this value can be modified to adjust the balance between production flow and material yield.

- **Rack positions** – This determines how many racks can be included at any time around a cutting table. In 'Batch' mode, this determines the maximum number of racks in a batch.
- **Buffer** – This setting determines how many 'Buffer Racks' there will be. A 'Buffer Rack' is a rack that is used to fill the empty space on the last pattern of a batch. If 'Buffer' is set to '0', and the last pattern of a batch has a poor yield, the next batch will begin on the next pattern instead of using the scrap for the end of the previous batch.

Note: When a buffer rack is used, the lites for the next pattern will be a different color. See 'Lite Colors' for detailed information on the distinct colors used.

Store and Restock Section

The following fields exist in the 'Store and Restock' section of the 'Settings' screen:

- **Consume Store** – When checked, the user will be able to select 'Available' store sheets to use during optimization. This setting only controls consumption of 'Offline Store'. If 'Available' 'Online Store' pieces exist for the machine, then they will always be available to consume. Consumption of 'Online Store' cannot be disabled.
- **Target Yield** – Yield threshold for consumption of store pieces. The yield of any pattern optimized on store must be greater than or equal to the 'Target Yield' otherwise the store will not be consumed.

Note: This setting only applies to 'Store', not 'Restock'.

- **Generate** – When checked, the machine will store scrap pieces of glass if they meet the requirements configured in the 'Inventory' settings in FeneVision Opti-Glass.

Confirm Lots Screen

The 'Confirm Lots' screen allows the user to indicate a lot number for each of the parts listed.

Confirm Lots									
Part	Patterns	Bin	Lot Number	Expiration Date	Qty	Received Date	Vendor		
GL100 CL - 2440x3660 - 10 mm Clear 2440x3660	1	Default	MLT1	7/12/2024	999	7/12/2023	FWTSTvend		

Pattern	Yield	Size	Description	Lot Number	File	Store/Restock	Remnant	Source	Status	Pos	Rack	Work Route	Total	Supplied	Accepted	Rejected
1	24.4	3660 x 2440	GL100 CL-...				2602			1	96-	TM-IG	8	0	0	0

The following fields exist in the 'Confirm Lots' screen:

- **Part (required column)** – Alpha-numeric identifier of the part.
- **Patterns** - The number of sheet-drops per release. Only visible in 'Batch' mode, this is an estimate of how many sheet drops will occur based upon an 80% yield.
- **Bin** – Identifier of the bin for parts that have been assigned a bin number.
- **Lot Number (required column)** – The user can select the lot number based upon receipt date or can assign a new lot number.
- **Expiration Date** – Expiration Date for the sheets in that lot.
- **Qty** – Number of units available in the selected lot.
- **Received Date** – Date the sheets from this lot were received.
- **Vendor** – Name of the vendor from whom the sheets were purchased.

Note: The 'Confirm Lots' screen is read only unless the user wishes to change lot numbers.

To assign a lot number, select the 'Lot Number' field. The 'Lot Assignment' screen will appear. At this point, the user can select a different lot number.

Lot Number GL100.CL.--.2440x3660 - 10 mm Clear 2440x3660

Bin
 {All} ▾

Lot Number	Expiration Date	Bin	Qty	Received Date	Vendor
MLT1		Factory Floor	-1	7/12/2023	FWTSTvend
MLT1	7/12/2024	Default	999	7/12/2023	FWTSTvend
▶ MLT713	7/13/2024	Default	2	7/13/2023 8:52 AM	FWTSTvend

The following fields exist in the 'Lot Assignment' screen:

- **Lot Number** – Text field used for selecting the lot number. If the desired lot number exists in the system, the user can start typing it in this field and the grid below will update to only show lot numbers that contain what is typed. Then the user can select the lot number in the grid to select it. If the lot number does not exist in the system, the user can type it here then select 'OK'. This will select the typed lot number and add it into the system.
- **Part (read only)** – Label in the top right corner of this screen to indicate for which part the lot is being selected.
- **Bin** – Drop-down to filter the grid to only display existing lot numbers from the indicated bin.

If the desired lot number does exist for this part, the user will select it by clicking on it in the grid. The following columns exist in the 'Confirm Lots' grid:




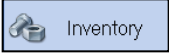

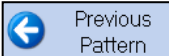
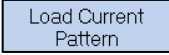
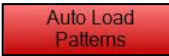
- **Lot Number** – Displays existing lot numbers.
- **Expiration Date** – Expiration Date for the sheets in that lot.
- **Bin** – Displays the bin to which the lot number belongs.
- **Qty** – Displays the quantity of stock sheets from this lot in this bin.
- **Received Date** – Date the lot was received into the plant.
- **Vendor** – Vendor from which the glass / interlayer was purchased.
- – Select to save the lot information.
- – Select to cancel the lot information.

If 'Lot Tracking' is not enabled for that machine, Opti-Break will take the user to the 'Patterns' screen for optimization.


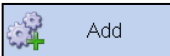

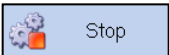
Once the user has started the run and can see the pattern, a 'Lots' button will be visible along the right side of the screen. This will allow the user to go back to the 'Confirm Lots' and change the lot number mid-run if the need arises.

Patterns Screen Actions

Below is an explanation of the various buttons that appear along the right side of the 'Patterns' screen.

- 
 Select this first before rejecting a lite. The reject button will turn red to indicate that it is in 'Rejecting' mode and it will remain red until a lite is rejected or the button is selected again. If a lite is rejected, it will reset the timer and remain in rejecting mode for three seconds. This makes it so that the user can reject multiple lites at once but does not have to turn rejecting off when done.
- 
 Selecting this button allows the user to print all the labels for the current pattern. When the button is green, labels will print automatically when the pattern is loaded. To disable printing, select the button again. It will turn red, indicating that no label printing will occur (*Button only appears if 'Enable Label Printing' and 'Print All for Pattern' are selected in the 'Settings' screen*).
- 
 Will display the 'Lot Assignment Screen'. These numbers can be edited in this screen (*'Lot Tracking' must be enabled on the machine in FeneVision Opti-Glass for this button to appear*).
- 
 Takes the user to the 'Inventory' screen, which allows the user to relieve stock sheets in case something happens to the sheet (e.g., a loader breaking a sheet). Inventory is associated with FeneVision Core.
- 
 Advances to the next pattern.
- 
 Returns the user to the previous pattern (*in 'Batch' mode the user can return to any previous pattern; in 'Dynamic' mode, the user can only return to the previous two patterns*).
- 
 Generates the interface file for the current pattern and sends it to the machine (*'Online Mode' only*).
- 
 When this is green, the interface files for all 'Machine Working Patterns' will be generated when the patterns load. Every time the user selects the 'Next Pattern' button, any 'Machine Working Pattern' that has not yet had the file loaded will be loaded. This functions like the 'Load Current Pattern' button except that the action is automatic and does it for all 'Machine Working Patterns'. When the 'Auto Load Pattern' is red, the automatic loading of patterns is not occurring; thus, the user will need to use the 'Load Current Pattern' button or select this button which will enable it turning it green (*'Online Mode' only*).

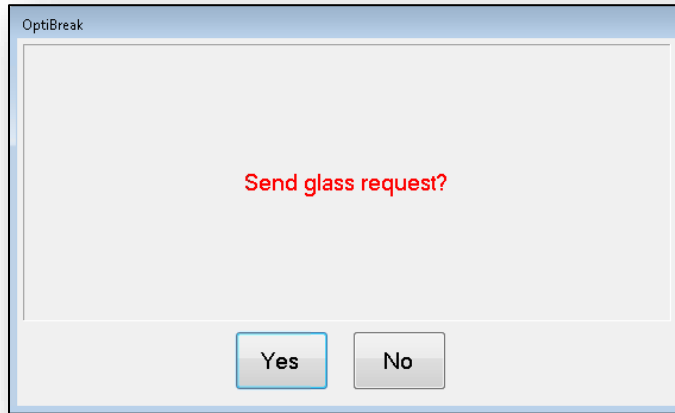
Note: When using Load Current Pattern or Auto Load Patterns in Dynamic Mode, a lock is added to the pattern. This will give the user the ability to recall the dynamic pattern if the run is unexpectedly stopped and / or Opti-Break unexpectedly closes. See Recalling Patterns above for more information.

- 
 Allows the user to add more releases or part types to the current run.
 - 
 Selecting 'Add' takes whatever the user is adding and appends it to the end of the run, so more patterns can be generated after the working patterns from the user's first selections.
 - 
 Allows the user to cancel the process of adding work.
- 
 Stops the process and returns the user to the 'Run Screen'.

Loading Patterns with Opti-Load

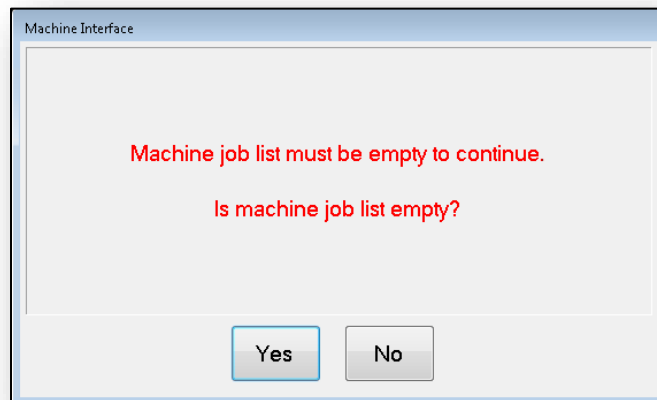
Loading patterns works with or without FeneVision Opti-Load. When using it with Opti-Load, there are a few additional prompts the user will see.

To load a pattern into Opti-Load, the user will select either Load Current Pattern to load just the current pattern, or Auto Load Patterns to load all working patterns, typically 3-5 patterns. When Load Current Pattern is selected with Opti-Load enabled, the user will get the following prompt:



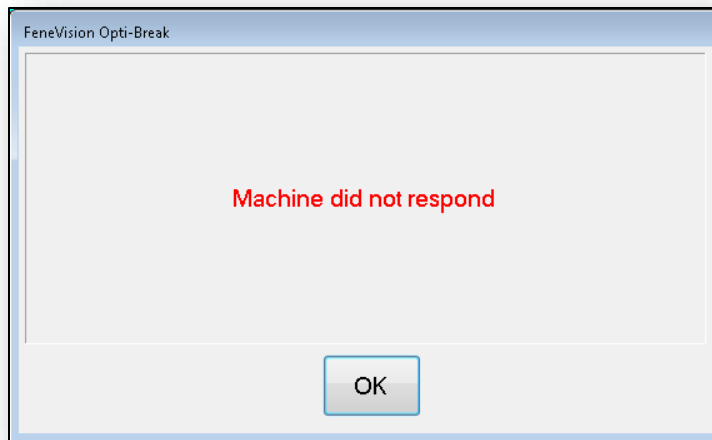
This prompt allows the user to choose if the glass needs to be requested from Opti-Load again. For example: The Opti-Break machine is accidentally shut down, but the files have already been sent to Opti-Load and the crane has already picked up the material. The user may need to generate the load file again but does not need it reordered from Opti-Load. The user would select No to the prompt and Opti-Load would not be triggered to reorder the glass.

When selecting Auto Load Patterns at the beginning of a run, the user will be prompted with the following message:



This prompt allows the user the time to make sure the job list is empty before creating new jobs. Users would clear out old jobs if left in the list through a job being stopped without completing. By selecting Yes to the prompt, users are allowing the new jobs to be added to the list. By selecting No, the new load patterns will not be created, and the user will be taken out of Auto Load Patterns mode.

If Opti-Break is having trouble communicating with the loading machine, the following prompt will appear:



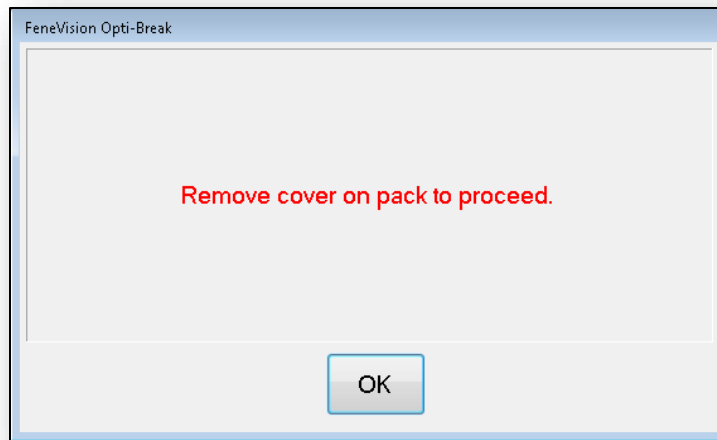
Users will select OK to this prompt, and Opti-Break will be taken out of Auto Load Patterns mode. Once the communication between Opti-Break and the loading machine is restored, the user may select Auto Load Patterns once again to try loading.

If using Opti-Load with Opti-Load Inventory, users may come across the following prompt:



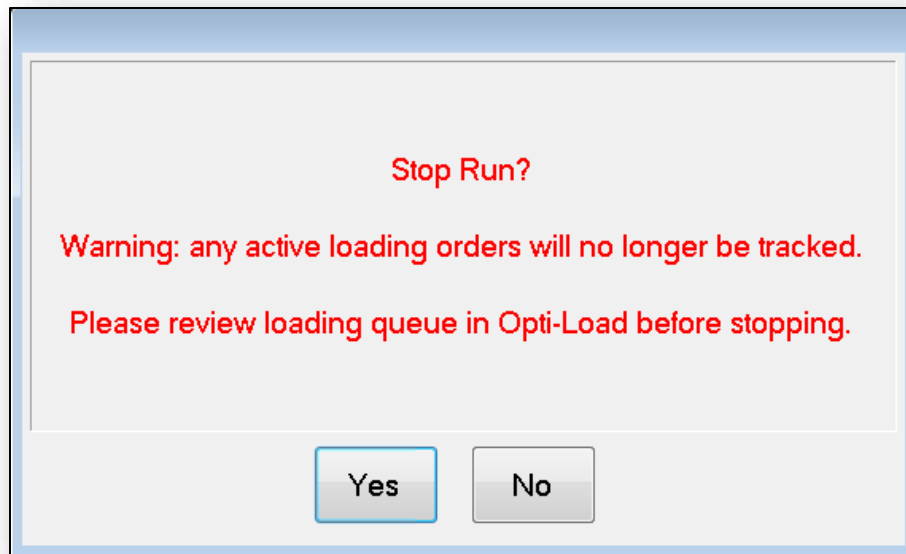
This prompt indicates that Opti-Load could not find a valid rack within Opti-Load Inventory that had the glass pieces needed for Opti-Break's run. The user will select OK to this prompt and be taken out of Auto Load Patterns mode. Upon adding glass to a rack in Opti-Load Inventory, the user will be able to continue with Auto Load Patterns.

If a pack contains a coversheet or a divider, the user will be prompted to remove these. Coversheets will need to be removed before a pack of glass can be used; while a divider will need to be removed after a pack of glass is used, before the next pack can be used.



By selecting OK to either of these prompts, the user will be taken out of Auto Load Pattern mode. Once the coversheet or divider has been removed, the user may select Auto Load Pattern to resume work on the run.

The last prompt a user will receive when using load patterns is when stopping the run.



This prompt allows the user to verify that they want to stop the run. If any patterns are not complete but the pattern has been sent to Opti-Load, they will be cleared from the Opti-Load queue. When beginning the run again, the patterns will need re-loaded to have Opti-Load order the glass.

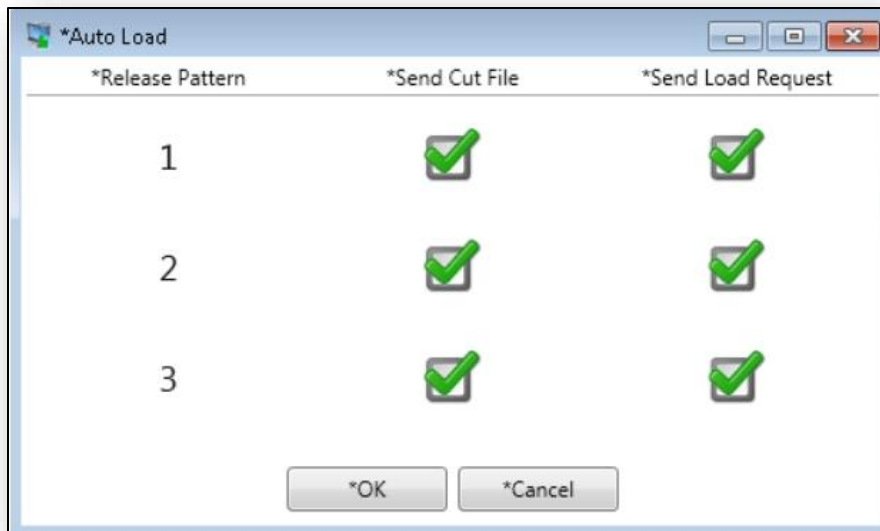
Auto-Load Recovery

Users can utilize the auto-load recovery screen to have more control over what actions are taken when pressing auto load patterns, particularly when recovering from a bad state.

For Example: There is some reason the user needs to stop auto-load. They may have the glass delivered for patterns 1 and 2, and cut files delivered for 1 and 2. If they were to start auto-load again, the auto-load recovery would allow for the user to decide which cut files need to be generated/regenerated.

When pressing the auto-load button, the user may hold the SHIFT key to bring up the "Auto-Load" window. If the user has chosen to recall dynamic patterns during the start of a run, the first time "Auto-Load" is pressed (even without the shift key), the screen will also show, since Opti-Break is already trying to recover.

On this screen, the user can directly control which actions will occur for each pattern (up to the maximum sent to the machine at once) so that they can correctly indicate how to recover.



Note: The Opti-Load and Opti-Sort specific columns are only shown when their specific settings are enabled.

Lite Colors

Lites will appear in different colors on the 'Patterns' screen. Lite colors can be customized. The default colors are

PRODUCTION AND FILLER LITES	PULLED BACK LITES
STORE AND RESTOCK LITES	LITE FROM NEXT BATCH and USED AS FILLER
REMAKES	STOCK
REJECTED LITE	ACCEPTED
SCRAP	PRIORITY

- **Aqua** – Used to indicate 'Production' and 'Filler' lites.
- **Aquamarine** – Used to indicate lites that are 'Online Store', 'Offline Store', and 'Restock'
- **Light Yellow** – Used to indicate 'Remakes'.
- **Red** – Indicates the lite has been rejected.
- **Wheat** – Used to indicate scrap.
- **Light Gray** – Used to indicate pulled back lites.
- **Goldenrod** – Used to indicate the beginning of the next batch.

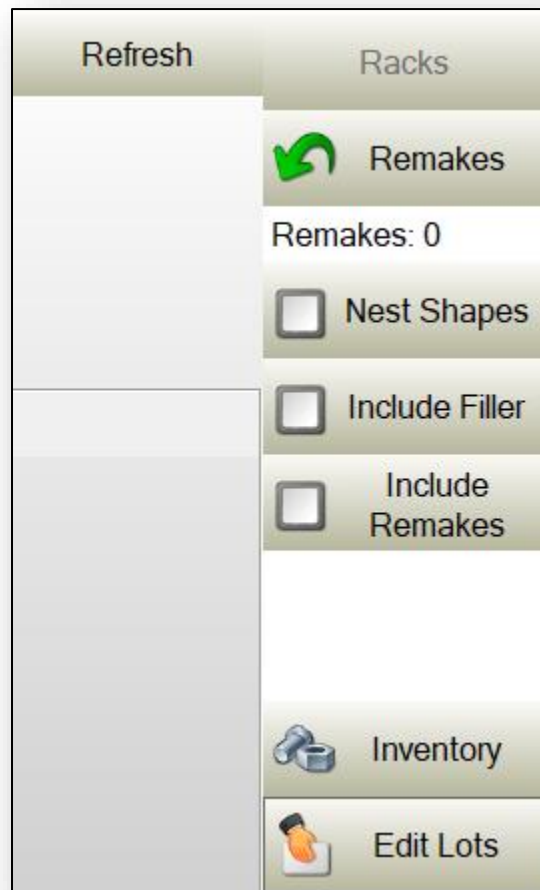
- **Sky Blue** – Used to indicate scrap around shapes.
- **Dark Green** – Indicates the lite has been accepted.
- **Gold** – Priority

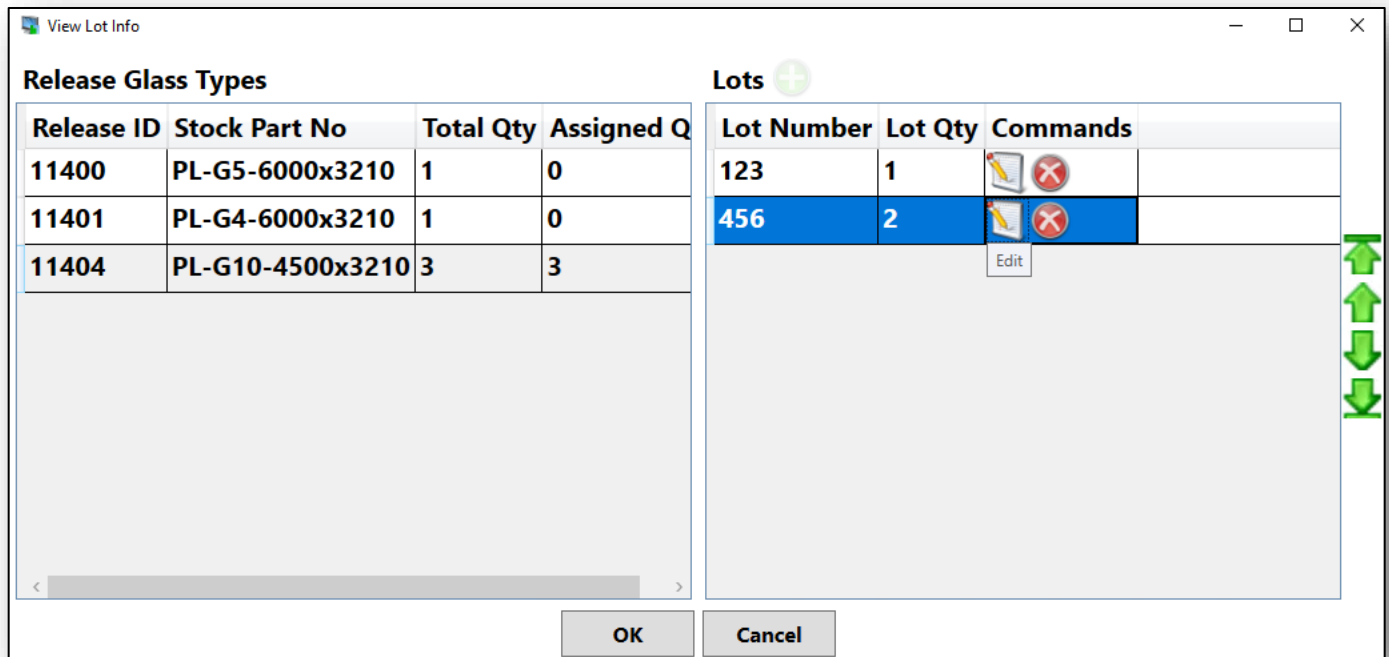
Note: The list above displays the default colors that correspond to the status of the lites on a pattern. These colors can be customized within the database. Contact FeneTech for more information

Edit Lot Info

The 'Edit Lot Info' screen allows users to input lot number while retrieving glass for glass operators to mirror releases. Users check off a release and click on the Edits Lots button to open the View Lot Info screen. The Release Glass Types are on the left and the individual lots are off to the right.

Note: There is scanning support for this screen, so once the screen is opened, users can scan lot barcodes (formatted as #LotNumber) to select the lot.





In the View Lot Info screen, users select a stock size and can add lots for that stock size. If the user adds multiple lots for a stock size, then the sequencing using the arrows on the far right is important for what lot is being assigned. In the example above, the first pattern of PL-G10-4500x3210 will come from lot 123. Since that lot qty is set to 1, Opti-Break automatically knows to use lot 456 for the next 2 patterns. If the total qty does not equal the assigned qty, then the remaining qty will be unassigned.

Exiting

Users can exit the FeneVision Opti-Break application by selecting the 'Close' icon in the upper right-hand corner of the application.

Setup

The user must complete an initial setup of the FeneVision Opti-Break application. This section outlines the setup options and their use.

System Requirements

The Opti-Break application has specific hardware and software requirements. Please reference the FeneVision Hardware and Software Requirements document.

Installation

The Opti-Break application is installed by executing an installation file and following the associated installation wizard. Although the software and hardware installations are not difficult, it should be done by someone with Microsoft® Windows and computer setup experience.

This section will identify the steps required to install the FeneVision Opti-Break application.

Program

To install the Opti-Break application, complete the following steps.

1. Locate the Opti-Break installation program.
2. Double-click the installation file to begin installation.
3. An installation wizard will launch that will install the Opti-Break application.
4. A dialog box will appear that contains the license terms. These must be accepted in order to proceed with the installation.
5. Choose the typical install.
6. An application icon is automatically placed on the user desktop. This icon can be used to start the application.
7. It may be necessary to activate the FeneVision Opti-Glass database server to enable the use of this application. Contact FeneTech to receive the activation codes.

Note: Certain functionality, such as dynamic optimization, must be enabled via activation codes. Contact FeneTech to receive the activation codes.

Initial Setup

A setup screen opens the first time the software is run. All information in the screen must be supplied in order to communicate with the FeneVision database server. Consult a system or network administrator for the required information.

Note: This dialog can be opened at any time by holding the shift key while the software is starting.

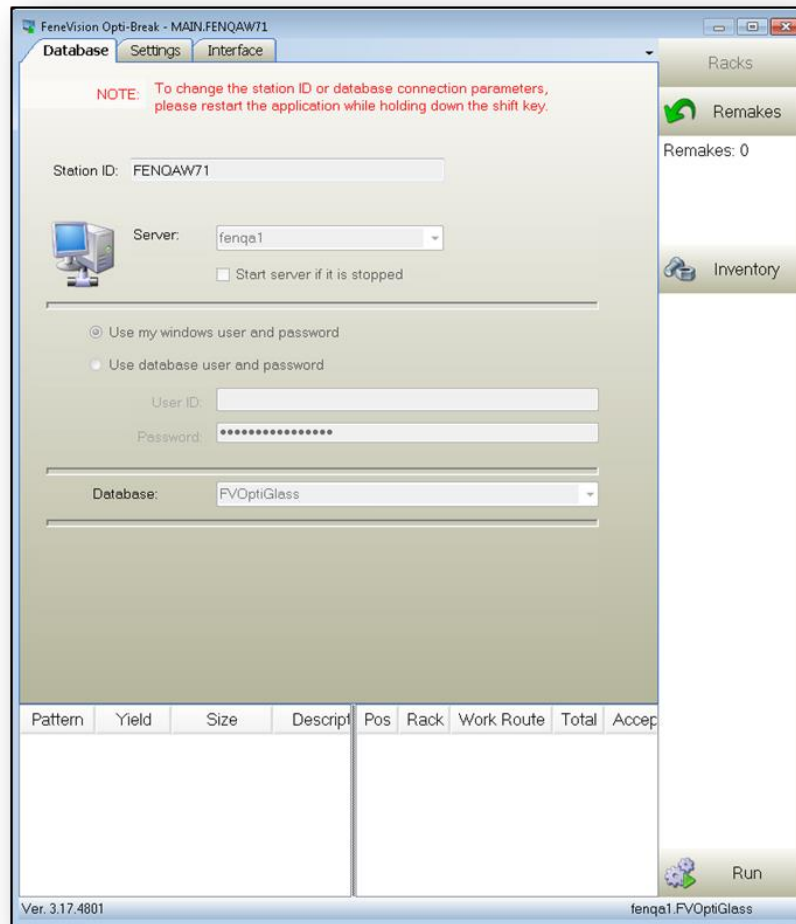
The screenshot shows a 'Connect to Database' dialog box. It features a title bar with the text 'Connect to Database' and a small computer icon on the left side. The dialog contains several input fields: 'Station ID' with the value 'OptiBreak', 'Server' with the value 'fenqa5', 'User ID' (empty), 'Password' (masked with dots), and a 'Database' dropdown menu set to 'FVOptiGlass'. There are two radio buttons: 'Use my windows user and password' (selected) and 'Use database user and password'. At the bottom of the dialog are two buttons: a green checkmark and a red X.

Each physical station using Opti-Break must maintain a unique 'Station ID'. Attempting to use the same 'Station ID' for multiple stations can cause conflicts with parameters. Stations will automatically be added to the stations list in FeneVision Core after accessing the settings screen for any new station.

Note: If the location is changed for a station, this will be updated in the stations list of Core as well, as StationIDs must be unique across all locations.

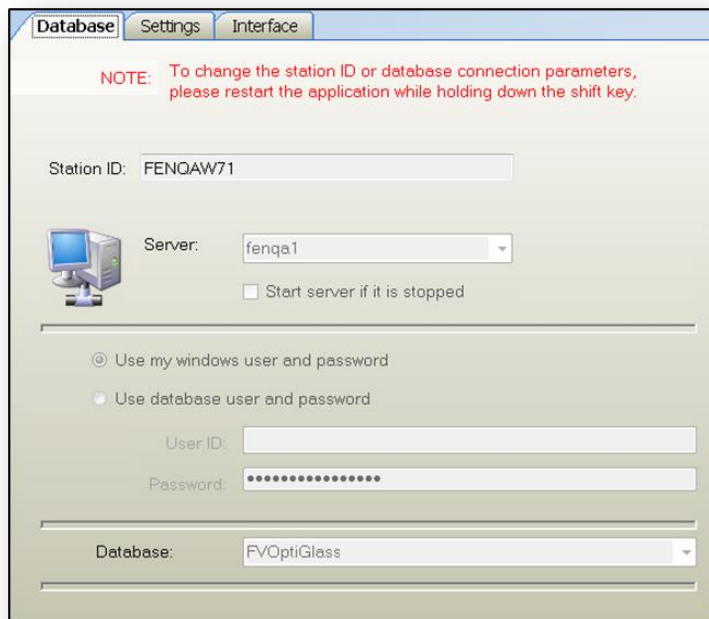
Settings

Upon opening FeneVision Opti-Break, configure the settings for the Station. To edit the settings, simultaneously press ALT+S on the keyboard. A login screen will appear, and the proper permissions are required to access the 'Settings' screen. These permissions can be granted through Opti-Glass. The 'Settings' screen will appear as seen in the image below.



Database Tab

The 'Database' tab displays the connection information for the database the application will use. These are configured during the first execution of the application. The settings cannot be changed here. If it is necessary to change these settings, exit the application and then start it again while holding down the **SHIFT** key.



Settings Tab

The 'Settings' tab allows the user to configure the station's settings, such as pattern display settings and label printing settings. The following image shows the 'Settings' tab divided into five sections.

General

Logon Required
 Stock Sizes Selected by Default
 Default Last Lot Number
 Enable Edit Lot Info

Enable Opti-Load
 Opti-Load Controls Store Status

Enable Laser

Pattern Display

Metric
 Show Base/Lower Right

Dual Display
 Show Side Numbers

Clone Pattern
 Show Short Side

Show Shape 90° Corners
 Show Edgework

Show Rack Side

Lite Tag Format:
 Online Store Capacity Alert Threshold (%):

Popup Tag Format:

Label Printing

Enable Label Printing
 Print Label on Accept
 Print All for Pattern

Patterns to Print in Advance:

Glass Label:

Store Label:

Glass Label Printer: ...

Store Label Printer: ...

Dynamic

Disable Rack Prompts
 Remake Rack Slots:

Filter Vendor Part ID
 Nest Shapes:

Filter Lot Number
 Include Filler:

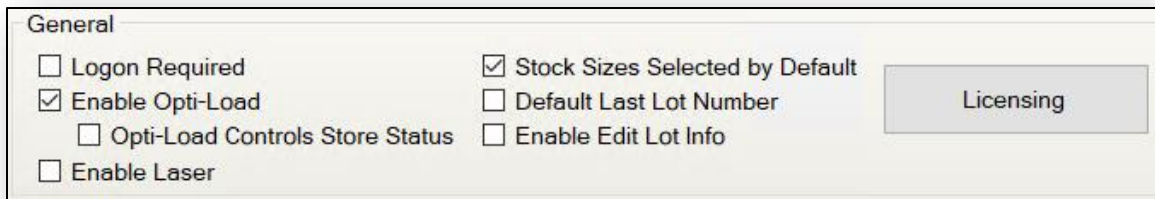
Include Remakes:

Batch

Always Accept on Pattern Advance

Licensing

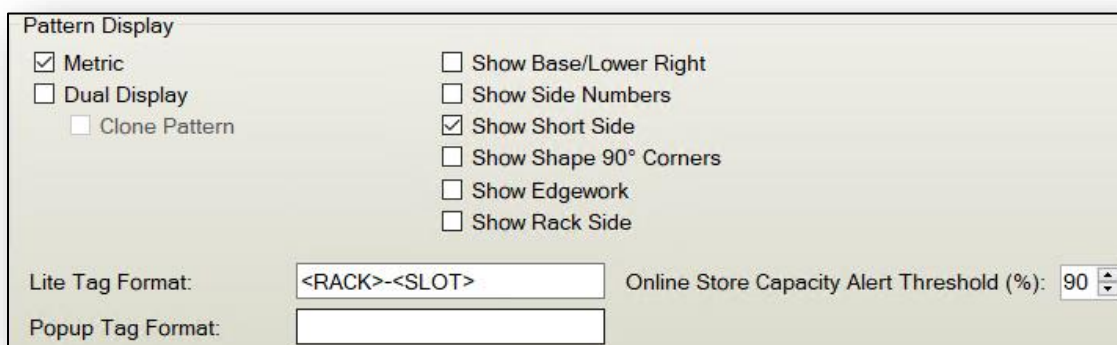
- **General** – Contains general information regarding the application.




- **Logon Required** – Requires that the user log in when starting a run in FeneVision Opti-Break.

Note: If Logon Required is enabled, an additional Log Off button will appear on the run screen.

- **Enable Opti-Load** – Enables the current station to feed FeneVision Opti-Load. Opti-Load is an add-on interface to control and automated glass loading system.
 - **Opti-Load Controls Store Status** – When checked, this allows the Opti-Load interface to manage store status.
 - **Enable Laser** – Check to enable the release of laser files used to integrate with laser marking machinery. *Contact FeneTech for more detailed information regarding this setting.*
 - **Stock Sizes Selected by Default** – Defaults the Enabled column checkboxes in the Stock Size Selection, Add Work, and Pattern Editor Re-Opt screens to all checked or unchecked.
 - **Default Last Lot Number** – When checked the last lot number used will be the default when beginning a new release, and when unchecked the lot number will be blank when beginning a new release.
 - **Enable Edit Lot Info** – When checked, the user can access the ‘Edit Lot Info’ screen. This screen allows glass operators to mirror releases by indicating what lots will be used as the glass is brought to the table instead of when the operator starts cutting the glass.
 - **Licensing** – Certain features such as ‘Dynamic’ optimization mode and ‘Store’ functionality are optional features within Opti-Break and are controlled via license activation codes. Contact FeneTech to receive the activation codes when setting up a new Opti-Break station.
- **Pattern Display** – Settings to control the display of on-screen optimized patterns. These settings are unique to each individual station.



- **Metric** – Measurements are displayed in metric units. Otherwise, measurements are displayed in Imperial units.
- **Dual Display** – When checked, the user will see the patterns on the secondary monitor (if a second break out monitor is attached to the computer).

- **Clone Pattern (checked)** – When checked, the second monitor will display the exact same pattern as the primary monitor.
- **Clone Pattern (unchecked)** – When unchecked, the user can be viewing a different pattern on the two screens simultaneously. The following hotkeys allow the user to navigate between patterns on the two screens:
 - **F9** key will move to the ‘Previous Pattern on the second monitor.
 - **F10** key will move to the ‘Next Pattern’ on the second monitor.
 - **F11** key will move to the ‘Previous Pattern’ on the primary monitor.
 - **F12** key will move to the ‘Next Pattern’ on the primary monitor.
- **Show Base / Lower right** – Marked by a pentagon shape that is placed near the lower right corner of the unit. Point of the shape is on the base of the unit.
- **Show Side Numbers** – Side numbers displayed on lites next to each edge. The side numbers will appear on DXFs as well.
- **Show short side** – Marked by a black triangle. Shows shorter width or height of lite as ordered.
- **Show 90° corners** – Indicates if a corner of a shape is 90 degrees. Only displayed on shapes (since rectangles have all 90° corners). Marked by a black rectangle  in the corner.
- **Show Edgework** – When checked, will allow the user to set a color at the ‘Edgework Code’ level. If the color is set, lines in that color will be drawn on the pattern displays to indicate which sides contain edgework.
- **Lite Tag Format** – Indicate what information will display on each lite of glass, or piece of interlayer, in the pattern. Each tag will be replaced by the information that tag represents when displayed on screen.
 - **<RACK>** – Rack identifier.
 - **<SLOT>** – Rack slot or position.
 - **Harp Racks** – Slot number.
 - **‘A’ and ‘L’ Frame Racks** – The position in the format of ‘xx’ / ‘nn’ where ‘xx’ is the stack position and ‘nn’ is the position within the stack. For example, 21.01 is the first stack on the second side of an ‘A’ frame rack, and it is the first piece within that stack.
 - **<ASLOT>** – Similar to <SLOT>, except that the format for ‘A’ and ‘L’ frame racks changes to 1A, 1B, and 1C to identify the stack position on the first side, and 2A, 2B, and 2C to identify stacks on the second side of a rack.
 - **<STACK>** – Rack side and stack.
 - **‘A’ and ‘L’ Frame Racks** – The position in the format of ‘xx’ where ‘xx’ is the stack position. For example, 21 is the first stack on the second side of an ‘A’ frame rack. The position within the stack is not shown.
 - **<ASTACK>** – Similar to <STACK>, except that the format for ‘A’ and ‘L’ frame racks changes to 1A, 1B, and 1C to identify the stack position on the first side, and 2A, 2B, and 2C to identify stacks on the second side of a rack. The position within the stack is not shown.
 - **<KSTACK>** – Similar to <STACK>, except that the format for ‘A’ and ‘L’ frame racks changes to A, B, and C to identify the stack position on the first side, and K, L, and M to identify stacks on the second side of a rack.

For example, assume that:

Rack ID = 12

Side = 2

Stack = 1

- <RACK>-<STACK> = 12-21
- <RACK>-<ASTACK> = 12-2A
- <RACK><KSTACK> = 12K

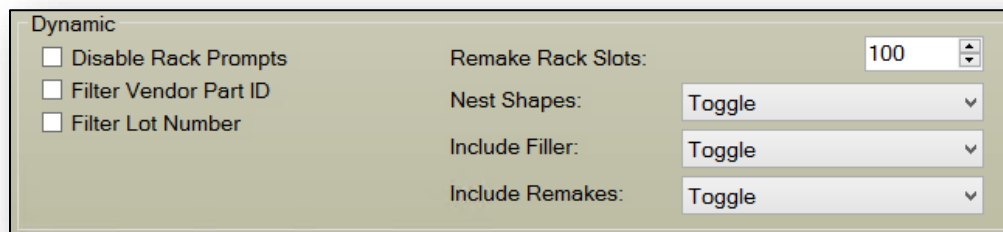
- <ORDER> – Order number.
- <ITEM> – Order line item number.
- <PART> – Part number.
- <POS> – Cutting table rack position. This is a numeric value from 1 to the number of rack positions configured for the machine.
- <BATCH> – Batch number if running in batch mode.
- <TAG> – Lite TAG attribute value.
- <RID> – Release identifier.
- <MSLOT> – Manual slot.
- <RACKID> – Database rack identifier.
- <L2RACK> – The level 2 rack. If no level 2 rack exists, the level 1 rack will be displayed.
- <L2SLOT> – The level 2 slot. If no level 2 rack exists, the level 1 rack and slot will be displayed.
- <SCHEDID> – Schedule number.
- <UNITID> – Unit number.
- <MASTERKEY> – Identifier of the part. Used in barcodes.
- <PARENTKEY> – Identifier of the part’s parent in the BOM. Used in barcodes.
- <RACKSEQ> - Identifier of the rack sequence number.
- <USERDEF1> - Displays the information specified in the UserDef1 field in the RackDetail table.
- <CUSTOMERID> - Customer’s alphanumeric identification, assigned through FeneVision Core.
- <SITEID> - Alphanumeric identifier for the customer’s individual site/locations
- <CUSTOMER> - Customer name.

Note: If the customer’s site name differs from the customer name, the <CUSTOMER> tag will show as Name[SiteName].

- **Popup Tag Format** – Allows the user to click and hold the mouse over a lite to show basic information about the lite. Uses the same tags listed under Lite Tag Format above.
- **Label Printing** – Printing labels for the glass / interlayer being cut.

- **Enable Label Printing** – Enables label printing. This setting must be checked in order for all the other settings under ‘Label Printing’ to be enabled. Additionally, one of the following two settings must be checked when enable is checked.

- **Print Label on Accept** – Every time a lite is marked ‘Accepted’ the label for that individual lite is printed.
 - **Print All for Pattern** – Prints all labels for the pattern when the pattern first appears at breakout.
 - Patterns to Print in Advance – Field to indicate the number of patterns to print in advance.
 - **Glass Label** – Drop-down to select which SSRS report to use for the glass label. Custom labels can be generated for specified customers. Contact FeneTech for more information about customer specific labels.
 - **Store Label** – Drop-down to select which SSRS report to use store labels. *Note:* Labels are only printed for ‘Offline Store’. Labels do not print for ‘Online Store’ or ‘Restock’.
 - **Glass Label Printer** – Specifies the Glass label printer. Users must select the button to access available printers.
 - **Store Label Printer** – Specifies the Store label printer. Users must select the button to access available printers.
- **Dynamic** – Enabled when running Opti-Break in ‘Dynamic’ mode.



- **Remake Rack Slots** – Numerical field to indicate how many slots to allot in the ‘Remake Rack’.
 - **Disable Rack Prompts** – When checked, user will not receive prompts indicating that racks are being moved during to a run.
 - **Filter Vendor Part ID** – When checked, remakes are only included if the ‘Vendor Part ID’ on the material matches the ‘Vendor Part ID’ of the material originally used to cut the remake.
 - **Filter Lot Number** – When checked, remakes are only included if the ‘Lot Number’ on the material matches the ‘Lot Number’ of the material originally used to cut the remake.
 - **Nest Shapes** – Allows nesting shapes to be enabled, disabled, or available for the user to toggle between using nested shapes during optimization.
 - **Include Filler** – Allows filler to be included, not included, or available for the user to toggle between including during optimization.
 - **Include Remakes** – Allows remakes to be included, not included, or available for the user to toggle between including during optimization.
- **Batch** – Enabled when running Opti-Break in ‘Batch’ mode.



- **Always Accept on Pattern Advance** – If checked, upon selecting ‘Next Pattern’, if any lite on the pattern has been accepted, FeneVision Opti-Break will accept every lite that does not have a status on the pattern being left. If no

rejects are present, this feature alleviates the need to return to the monitor and select each lite in order to accept each lite; the entire pattern is accepted at once.

Note: The 'Always Accept on Pattern Advance' feature applies to 'Batch' mode only; in 'Dynamic' mode, lites without a status on a pattern are always accepted on pattern advance, regardless of setting.

Interface

The 'Interface' tab allows the user to set parameters and values for each of Opti-Break's accompanying machine interfaces.

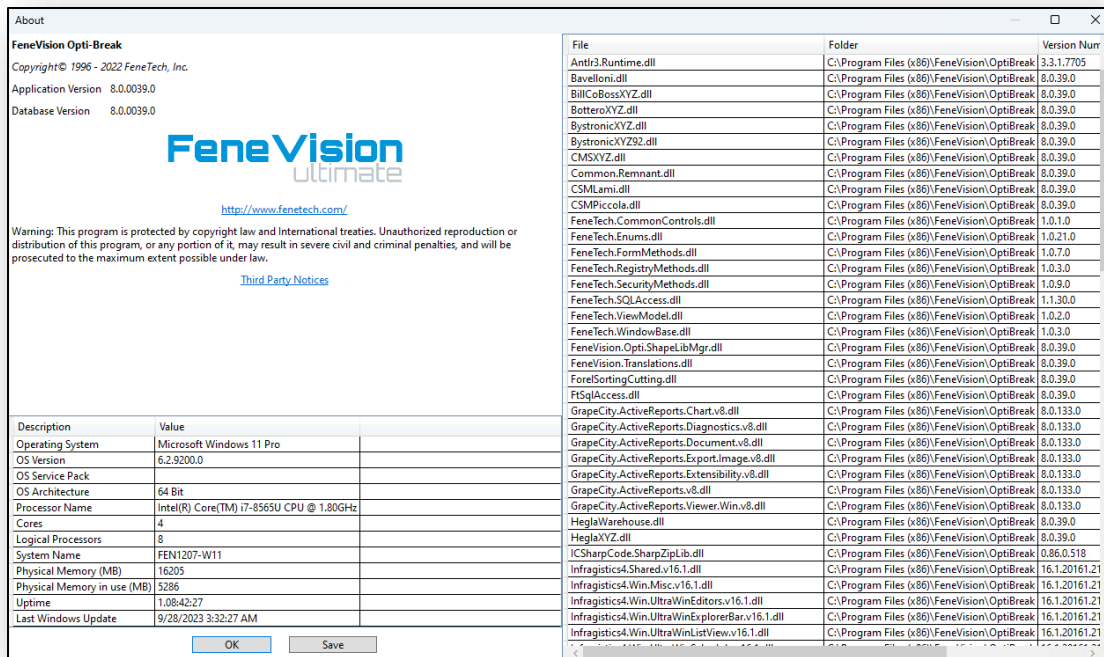
Note: The machines must first be configured in FeneVision Opti-Glass. For more information regarding individual interface settings, contact FeneTech for the individual interface user manual.

The screenshot shows the 'Interface' tab in a software application. At the top, there are three tabs: 'Database', 'Settings', and 'Interface'. Below the tabs, there is a dropdown menu for 'Machine' set to 'LISEC FLOAT'. Underneath, there are three sub-tabs: 'LISEC', 'Edge Delete', and 'Online Store'. The main area contains a table with two columns: 'Parameter' and 'Value'. The 'Edge Delete Mode' row is highlighted in blue and has a value of '1'. Other rows include 'Do not output restock item' (checked checkbox), 'Post process', 'Create Machine Files in Subdirectory' (unchecked checkbox), 'Enable Online Mode:' (unchecked checkbox), 'NC Files Dir:' (with a browse button), 'Timeout' (value 10), 'Enable Transfer File:' (unchecked checkbox), 'Transfer File Dir:' (with a browse button), 'Transfer File Max Height:' (value 0.00), 'Transfer File Max Width:' (value 0.00), 'Transfer File Min Height:' (value 0.00), 'Transfer File Min Width:' (value 0.00), 'Transfer File Output 1 Work Routes:', 'Transfer File Output 2 Work Routes:', 'Transfer File Output 3 Work Routes:', 'Enable Laser File:' (unchecked checkbox), 'Laser X Offset:' (value 0.00), and 'Laser Y Offset:' (value 0.00).

Parameter	Value
Edge Delete Mode	1
Do not output restock item	<input checked="" type="checkbox"/>
Post process	
Create Machine Files in Subdirectory	<input type="checkbox"/>
Enable Online Mode:	<input type="checkbox"/>
NC Files Dir:	...
Timeout	10
Enable Transfer File:	<input type="checkbox"/>
Transfer File Dir:	...
Transfer File Max Height:	0.00
Transfer File Max Width:	0.00
Transfer File Min Height:	0.00
Transfer File Min Width:	0.00
Transfer File Output 1 Work Routes:	
Transfer File Output 2 Work Routes:	
Transfer File Output 3 Work Routes:	
Enable Laser File:	<input type="checkbox"/>
Laser X Offset:	0.00
Laser Y Offset:	0.00

About

Users may access the 'About' screen by selecting F1. The application version number and the database version number are shown within this screen. The application version number should match the database version number.



Help

Users can access the most up-to-date user manuals from the FeneVision Opti-Glass application. See the FeneVision Opti-Glass user manual for additional steps to access the full user manual directory.