



USER GUIDE

Introduction

By double clicking on the symbol of ProkserNET in Desktop Windows or the file C:\ProkserNET\ProkserNET.EXE, program starts on. The password is requested and the correct password is entered to continue. We can chose language option which we want and we can enter the system. There are Russian, English, Turkish languages which we can use. In case incorrect password entered you cannot enter the system. Check the user name and password and log in again. The program is opened, the menu appears. The screen transition is provided by clicking shortcuts in the menu.

Cement Silo Grouping

In this display screen, the amounts of inventory present in the cement silos are showed in kilograms and as level-wise. Furthermore there exists CEMENT GROUPING option at the bottom of the screen in order to be used to make two silos get to work together. The user can make two silos desired operate together, but the user must also choose from the group he has made to operate together, the silo from which the inventory will be reduced.

Cement Silo Selection

If for any reason, the silo used for cement weighing procedure during the production process is to be changed with another silo, the silo that will be employed is chosen using the "MOUSE ARROW" and ticking on the "OPERATE" button.

E - Support

This is used to contact authorized person by Prokser with mail if there is a problem in program. If user has gmail account, can send mail with that. User must write user name and gmail password than write subject and

description. At last press send button. If user has a photo or document which one because of error, can send these with the add button.

General Parameters

FEEDING BAND CARRYING DURATION

This is the time that elapses after the discharge of the weighing band, until the material on the vertical feeding band is completely discharged to the Aggregate Saving/Accumulation Bunker. In other words, following the cease of the operation of the weighing bands, after waiting for this predetermined period, the command "Open the Saving Bunker Lid" is given by the system.

If this period is adjusted to a time of 4 or 5 seconds, the lid of the saving bunker will be opened prior to full discharge of the material on the feeding band, and while the saving bunker is being completely discharged, the feeding band will also be discharged. Thanks to intersecting the two discharging periods, the production time will be reduced, and the system capacity will be provided to have an increase.

For those systems, where there is not a saving/accumulation bunker, if the other units' weighing operations have been completed at the time when the aggregate weighing has been completed, "discharge" command is directed for all of the materials.

THE COLLECTOR BUNKER DISCHARGE DURATION

This is the time required to fully discharge the aggregate within the saving bunker. This period begins with the perceiving of the "Bunker Lid is Open" signal by the system and the lid is shut down at the end of the period.

If the aggregate discharge system operates with a bucket, the discharging period for the material inside the bucket is also defined using this parameter. The period begins with the signal "The Bucket is at the Upper Station" signal, and the bucket begins its descend downward at the end of the period.

PLAYING SIREN DURATION

Along with the closure of the lid of the last mixer taking part in the production, the system announces

the finalization of the production process by ringing a siren.

This value being entered to the system parametrically, determines for how long the end-of-production siren will be blown.

When the discharging procedures pertaining to the last period are finalized, namely the carrying period on the feeding band should elapse for the aggregate to arrive, then the siren will begin to blow for those systems operating without a mixer.

MIXER MIXING DURATION

This is the time required for the materials that had been mixed inside the mixer to be fully discharged. This time period is initialized with the "Mixer Lid is Open" signal and even if the registered period ends, prior to the "Mixer is Empty" signal, the command "Shut the Mixer Lid" is not directed by the system.

It must be kept in mind that, the time that elapses for the mixer lid to gradually open is also included in the discharging period.

This parameter is not being employed in those systems operating without a mixer.

MIXER GATE STEPPED OPENING WAITING AND RUNNING DURATION

The mixer lids can be made to gradually open in order to prevent sudden material flow from the mixer into the transmixer that causes the overflow, bouncing and blockage of the flowing material on the transmixer mouth, during the discharging procedure of mixture within the mixer into the transmixer. The gradual opening takes place as the opening of the mixer lid at a certain range and be kept as waiting in that position for a period, and the complete opening is carried on as that step by step. The process begins by the "Open the Mixer Lid" command given after the completion of the mixing process. The mixer lid is opened for as long as the "Application, namely the discharging, Period". It is kept as waiting during the "Waiting Period" in the adjusted position, and then again goes into process during the "Application Period". This process is carried on repeatedly until the lid is thoroughly opened, in other words the signal "The Mixer Lid is Open" is given by the system.

These parameters are not being employed in those systems which operate without a mixer, and in those facilities that operate with a pneumatic lid system(single exhaust systems).

PAIL CARRYING TIME

In those systems which operate with a bucket aggregate system, there are certain security periods which are defined to protect the motorized equipment of the system against the problems that may arise due to the deceleration, or halting caused by the coercions throughout the upward and downward movement of the bucket between the upper and the lower stations.

If the bucket does not reach the from one of the stations to the other during the period, the bucket engine is stopped and the user is warned as an alarm. The production may be carried on from the place it had been ceased, following the repair. For a fine-operating control mechanism to be adjusted, these periods can be defined for 1 or 2 seconds more tolerable than the normal moving time of the bucket between the stations.

General Backup - General Restore

This is used to backup or restore Formula, customer, chantier, transmixer, driver, service, orders, parameters, users, plant information to database. If don't want to lose all records you should check "Select all" item and press the backup button.

Graphics

These are a type of transmixer, customer, Formula, chantier, yearly. Which in time zone which transmixer how much work, will show as graphic and numeric in transmixer graphic. Customer graphic shows which customer how much work in certain time range. Formula graphic shows which Formula use in which time range and show the differences of preferences. Also chantier report shows chantiers report as a graphic which one how much work. The yearly report show reports which month how much production was made.

Graphical Display

It indicates customer records for 10 years. Also it shows report as a numeric and graphic which customer in which month in which year how much work

GSM Settings

It is only entered authorized person by Prokser. It is the place of gsm settings.

GSM Rights

This is optional structure. This is used to be informed by gsm about daily production, spent materials, shipping, inventory reports, etc... this is used only authorized person(s). The authorized person can want all report an hour 7/24 until the computer is opened and gsm module active. SIM card is required to use this module. If you have Gsm Module, would be authorized to enter in to the screen. Pricing of this module same as with your telephone network's sms fees. You should know some shortcuts for use this module. User should send "menu" word with sms to see Information screen. You will receive a message. This message give number and description where do you want to reach. You should send number which do you want and you will receive their information. Menu screen is facilitates the use of the user. There are shortcuts like this:

<u>Sent</u>	<u>Return</u>
"menu"	"1-PRODUCTION 2-SPENT 3-PRODUCTION 4-STOCK"
"1"	"11-DAILY PRODUCTION 12-WEEKLY PRODUCTION 13-MONTHLY PRODUCTION 14-YEARLY PRODUCTION"
"11"	"Daily Production: * m3"
"12"	"Weekly Production: * m3"
"13"	"Monthly Production: * m3"
"14"	"Yearly Production: * m3"
"2"	"21-DAILY SPENT 22-MONTHLY SPENT 23-YEARLY SPENT"
"21"	"Daily Spent Materials"
"22"	"Monthly Spent Materials "
"23"	"Yearly Spent Materials "
"3"	"31-CUSTOMER 32-FORMULA 33-CHANTIER 34-TRANSMIXER 35-DRIVER 36-SERVICES"

"31"	"Customer Reports:"
"32"	"Formula Reports:"
"33"	"Chantier Reports:"
"34"	"Transmixer Reports:"
"35"	"Driver Reports:"
"36"	"Services Reports:"
"4"	"Amount of stock"

NEW USER: This is used to define a new user.

NEW NUMBER: This is used to define a new number.

EDIT: This is used to change name and number.

DELETE: This is used to delete selected item.

TELEPHONE NUMBER: This is used to enter telephone number after click new user button. Telephone number should start the country telephone code. For example for turkey it should be start "+90".

NAME: This is used to enter name and surname after click new user button.

Spent Material Reports

This is a report type which shows the amount of each of the materials used during the production process separately, and also the overall material expenditure at the end of the report. Also user may take the desire date range of reports.

Sensitive Weighting Parameters

In order for the measurements to be conducted accurately, some of the weighing units of the system are calibrated with the accurate/sensitive scale measurement limits. In order for the system to operate under these conditions, each aggregate bunker should at least have two lids.

The operating principle here can briefly be stated as, initializing of the material flow for the weighing process with high flow rate and continue the flow with that rate until when material, as predefined by amount with some parameters is left. From that amount of material left, on, the flow rate will descend to the lowest possible value in order to supply the desired amount of material without error.

If the accurate weighing values are equal to or higher than the desired weighing value, the whole weighing procedure will be carried on through using the second lid. In this case, the accuracy of the measurement will of course be very high, but the period of production will increase, and this increase will diminish the system capacity.

Error Correction Values

The weighing of all the materials is done via their flow to the steelyard from a certain height. For this reason, even if when the lids (the whorls or the valves) are shut closed for the steelyard indicators demonstrate that the target weighs have been reached, this last piece of material suspending in the air as a column will also fall onto the steelyard and will cause the system to take more than the desired material amount and therefore will cause error. For this reason, under the ideal operation conditions, considering that there exists a fixed flow error that will be likely to occur in each period, by taking less amount of material than the prior weighing, the system may be able to compensate for this error in the overall procedure. But factors such as the changes caused by the humidity, compression or settlement in the material structure; pressure differences on the pneumatic lids and valve systems effects the material flow output and the cement amount suspended in the air as a column varies from time to time. Therefore the system automatically changes the "ERROR CORRECTION VALUES" by calculating the material flow characteristics according to the algorithms it produces on the result of

the errors made during the prior periods. And as a consequence, the user need not have to interfere with the related entries.

In order to prevent this change to uncontrollably increase by virtue of the errors caused by the mechanical system such as the pneumatic lid malfunction, prevention of the lid closure by the interference of unknown material, etc.,... an upper limit to the extent of a certain multiple of the weighing amounts can be provided for the "ERROR CORRECTION VALUES". The lower limit for the error correction values is zero. Namely, the errors conducted can never be counted as below zero, namely as negative.

Error Correction Control Values

THE LIMIT VALUES OF ERROR CORRECTION FOR AGGREGATE, CEMENT, WATER AND CHEMICAL

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AGGREGATE, CEMENT, WATER AND CHEMICAL ERROR DIVIDE-MULTIPLICATION PARAMETERS

These are the parameters used for calculation of the error correction values. Using these parameters, errors caused by continuously weighing overweight or underweight can be corrected. When the "MULTIPLICATION/DIVIDEND" ratio increases the overweight values, and when this ratio decreases the underweight values causing error will be reduced. In accordance with the error characteristics of the weight units, these values can be adjusted to ratios such as 2/3, 1/5, etc...

UPPER LIMITS FOR AGGREGATE, CEMENT, WATER AND CHEMICAL

These are the parameters that are used to make overflow controls of the steelyard. In other words, when any value read on the steelyard passes the parametric value entered here, the pertaining weighing procedure is halted and the user is being given an alert.

These parameters need not necessarily reflect the calibration values of the steelyard indicators. For instance, for an aggregate steelyard calibrated to 3000 kilograms, provided that all the Formulas and the maximum mixer capacity is taken into account, when the maximum weight of the material to be balanced does not exceed 2600 kilograms. Hence, the parameter values can be registered as 2600-2700 kilograms.

Service

It is the display screen where the service information is entered and changes, or adjustments on the service information can be done.

NAME: Is the service given to the client defined (i.e. with pump, with mixer, etc...)

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the service.

Delivery Note Settings

PRINT FROM THE RECORD: Necessary to suppress the report file's position. It must be selected file which one extension. FR3 in C:\ProkserNET\delivery_note\EN. It is used only when we print waybill in tracking screen.

END OF THE PRODUCTION: Necessary to suppress the report file's position. It must be selected file which one extension. FR3 in C:\ProkserNET\delivery_note\EN. It is used only when we print waybill in product screen.

DESCRIPTION 1: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 2: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 3: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 4: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 5: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 6: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 7: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 8: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 9: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

DESCRIPTION 10: This space is spared for extra information that may be provided during the arrangement of the format of the transport document.

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

EDIT: This is the instruction to make any amendment on chosen record.

History

Using this screen, the information of the previous production can be viewed, the transport document of the selected production can be rewritten and the selected productions can be deleted from the system.

The screen consists of three sections: The information defining the production process is on the top, quantity, Formula, customer, chantier, transmixer ,driver, service information belong to production are on the left bottom side and the numerical values of the weighing procedures are on the right bottom side.

The buttons at the bottom left are used for passing between the registered entries and for making search. The searching procedure is respectively done from the first record, its former record, its latter record, the last record and from the list.

The desired record can more rapidly be tracked from the "SEARCH FROM THE LIST" screen. (If when the user is authorized to delete) the deleting process also, is done from this screen.

PRINT DELIVERY NOTE: The command is used for taking the transport document of the production values on the screen from the printer.

Transmixer

It is the display screen where the transmixer information can be input, and procedures of deleting, correction, etc., can be done on the transmixer information.

PLATE: is the license plate number of the motor vehicle.

CAPACITY: is the maximum amount of load that can be carried by the vehicle. If the production is going to be done for a specific transmixer, than the capacity of the transmixer should be greater than or equal to the amount of product that will be produced. Otherwise, the alert message: "The maximum truck load capacity is less than the amount you will produce." will be displayed.

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the transmixer.

Scales Capacities

In this display screen, the weighbridge capacities for the Aggregates, Cement, Water, and Alloy are entered. These values are submitted to the system by the Prokser personnel during the installation process. An approval from Prokser should be taken for further adjustments.

Delete Records

This is used to erase record of the date range which is unused. There are three type of it as daily, monthly, yearly delete. If want, erase all records in specific date range.

User Types

This screen which can be used by the authorized personnel of the facility only, had been arranged to limit the user rights by this authorized person(s). The authorized person can close the processes he wishes to the users. For instance, if the approval tick for "Formula Correction Right" of the operator user is canceled, the operator user can enter the "Formula" screen but cannot make any adjustments on the Formulas. The authorized person should also disapprove the user Operator1's right to enter the "Definition of the User Rights Screen" so that the user Operator1 will not be allowed to make changes on his present situation.

User Rights

TOTAL PRODUCTION: It shows total production since the beginning of the day. For example the production starts 7 am and you send message 11 am. It is back total production between 7 am and 11 am. So all amount of production come with sms since start production.

STOCK REPORTS: It will send current available stock status which one active stock control of materials.

SPENT REPORTS: It will send spent material's report since start production.

PRODUCTION REPORTS: It will send Production report since start production.

FAILURE NOTIFICATIONS: It will send all failure notifications

MIXER RUNNIG DURATION: It will send operating time of mixer

CUSTOMER REPORTS: It will send reports which customer how much work.

FORMULA REPORTS: It will send reports which Formula how much work.

CHANTIER REPORTS: It will send reports which chantier how much work.

TRANSMIXER REPORTS: It will send reports which transmixer how much work.

DRIVER REPORTS: It will send reports which driver how much work.

SERVICE REPORTS: It will send reports which service how much work.

AUTOMATIC DAILY PRODUCTION INFORMATION: It will send daily production automatic if it is checked.

Users

Using this display screen, the users defines to the program can be traced, new users can be defined, and the user passwords can be changed

NEW USER: This is used to define a new user. Enter user type and password to the boxes after click to button.

EDIT: This is used to change user password, type or name.

DELETE: This is used to delete selected item.

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

THE PASSWORD: is the password information belonging to a defined user. The password is displayed on the screen as "****" for security.

USER TYPE: This is used to determine the type of user. Each type has different authorization.

Lists

Using this screen, see all list of customer, chantier, Formula.

Material and Stock Settings

This screen, which is of material which has silos and bunkers, how much stock is available each entry in the stock . Actions carried out like this.

Come over animation model which one you enter stock. If animation model's color is become green, screen view becomes selection mode. New window open after click selected model. In this screen , write name of model which one enter stock. Actions carried out two ways. Write in to the box at the top if enter new name. List of materials is here when we had defined materials list.

EDIT: This is used edit to material name

DELETE: This is used delete to material name

FORWARD: This is used pass to the next step after definition of material name

AVAILABLE STOCK: It shows how much available stock in selected material.

RESET: It reset amount of available stock in selected material.

DESCRIPTION: Write description to selected material during enter stock.

STOCK CONTROL: It does stock control if this is checked. If it is not checked, it doesn't do stocked control.

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

SELECT BACKGROUND: This is used change background image on animation.

Customer

This is the display screen where the information input about a client is made, is traced, and processes such as deletion or correction of the records is being done.

CUSTOMER CODE: Is the number input that must separately be given to every individual client. The code can be made up of number characters or letters.

NAME: The name of the client is entered the system.

TELEPHONE: The telephone contact information regarding a client is entered.

FACSIMILE: The facsimile number of the client is entered.

ADDRESS: The address of the client is entered the system.

TAX OFFICE: The tax collector office the client is registered to is entered.

TAX NO: It is the tax ID number pertaining to the client.

CITY: The name of city of the address provided by the client is entered.

PROVINCE: The name of the province of the address provided by the client is entered.

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the client

Humidity Parameters

It is the display screen where the manual humidity values(maximum 20%) for the aggregates can be entered in percents and the values coming from the automatic humidity sensor can be viewed.

The Humidity Control operates as follows: The aggregate amount is increased as much as the percentage value that had been defined during the production, and the same amount of water is reduced, therefore the overall total concrete weight is protected and the desired concrete consistency is obtained.

Parameter Settings

It is only entered authorized person by Prokser. It is the place of plc connection settings.

Formula

This screen is used to make definitions of concrete recipes to be applied in the productions, trace the entered records and make the modifications, if necessary.

CODE: A different recipe code is given to each separate recipe. This code can be composed of letters and numbers.

NAME: The name describes the recipe entered.

AGGREGATES VALUES: Amount of the aggregate must be entered

CEMENT VALUES: Amount of the cement must be entered

WATER VALUES: Amount of the water must be entered

CHEMICAL VALUES: Amount of contribute must be entered

MIXING TIME: Those mixing periods describe how long concrete is to be mixed inside the mixer based on seconds once the weighted materials had been started to pouring into the mixer.

DISCHARGING TIME: Once the lid of mixer was opened up completely, it defines the period in seconds that is passed to discharge the concrete from mixer

STEPPED OPENING WAITING PERIOD: The cover must be opened in stages, the desired standby time.

STEPPED OPENING RUNNING TIME: The cover must be opened in stages, the desired opening time.

SLUMP: Slump value of concrete.

GRANULITES: Defines the value of the biggest grain in mm inside the concrete.

STRENGTH: Defines the strength value of the concrete in standards.

DESCRIPTION 1: The user can enter the descriptive information regarding to the recipe.

DESCRIPTION 2: The user can enter the descriptive information regarding to the recipe.

DESCRIPTION 3: The user can enter the descriptive information regarding to the recipe.

DESCRIPTION 4: The user can enter the descriptive information regarding to the recipe.

WATER/CEMENT RATIO: It describes the water and cement ratio entered in the recipe.

TOTAL WEIGHT: It describes the total material included in the recipe.

FIXED MIXER CAPACITY: Mixer capacity is adjusted according to Formula.

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the Formula

Production Reports

This screen is used to see and print production report as different formats. User can select records with grouping options According to election records contain the reports can be specified. User can take reports the desire date range.

Shortcuts

- F1:** Record Entry
- F2:** Plant Settings
- F3:** Parameters
- F4:** Production
- F5:** History
- F6:** Report
- F7:** Maintenance
- F8:** Order
- "1":** Select Quantity on the production screen
- "2":** Select Formula on the production screen
- "3":** Select Customer on the production screen
- "4":** Select Chantier on the production screen
- "5":** Select Transmixer on the production screen
- "6":** Select Ddriver on the production screen
- "7":** Select Service 1 on the production screen
- "8":** Select Service 2 on the production screen

- "9":** Select Extra water on the production screen
- "0":** Select Ready quantity on the production screen
- "B":** Start the production on the production screen
- "D":** Stop the production on the production screen
- "U":** Finish the production on the production screen
- "M":** Enter manual record .on the production screen
- "S":** Reset the production on the production screen
- "P":** Open the order windows on the production screen

CTRL + "J": It calculates system how many second remove up bucket. It test that condition itself. If user change the bucket remove up time on parameters, should be done it.

Order

This section intended for operator. Operator can enter orders by customer has given and then you can choose this order from production section. At first press new order button to add new order. Formulas, quantity, customer, chantier, are written by user and press ok button. Such as add more order and you can delete or edit orders too. User can select these orders in production screen after selection order will delete which one was made.

Password screen appears when you click ProkserNET icon. User write user name and password and enter program if password is correct. If you want to exit program but don't want to close program you have some special work on desktop. You may come on desktop and then right click notify icon, you may enter all section where do you want. There are menu connections in there. If you don't enter password, you couldn't enter this section and it will be inactive.

User can use this program as Turkish, English, Russian. User can select language options on login screen.

Stock Reports

Using this screen, the inventory that has remained can be viewed on the screen, and the amounts can be transferred to the printer.

Driver

It is the display screen from where the driver information is input, is viewed; and processes of deleting or changing the saved inputs are being done.

NAME: The name(s) of the driver(s) using any certain vehicle(s) is entered.

ADDRESS: is the address information of the driver.

TELEPHONE: is the telephone number of the driver.

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the driver.

Chantier

This is the display screen where one or more construction sites belonging to a specific client can be defined, and changes, adjustments and corrections on the recorded entries can be done.

NAME: is the name information of the construction site.

CUSTOMER: is the name of the client to whom the construction site belongs to. Dialog box by pressing the side of the customer is customer choice.

TELEPHONE: is the telephone number of the construction site.

FAX: is the facsimile number of the construction site.

ADDRESS: The address information of the construction site is entered.

CHIEF: is the information of the person contacted by the client.

DISTANCE: The distance between the facility and the construction site can be entered the system in kilometers.

CITY: The city where the construction site is, is entered.

CITY: The city where the construction site is, is entered.

NEW RECORD: This is the instruction to open a new page enabling to create a new record.

EDIT: This is the instruction to make any amendment on chosen record.

DELETE RECORD: This is used to delete the current record

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

CLEAR: Clear the box which to find the chantier

Weighting Start and Discharging End Duration

AGGREGATE, CEMENT, WATER AND CHEMICAL WEIGHING START LIMIT WEIGHTS

Tare control is made prior to the first weighing operation of the production process. This control is necessary to prevent the problems that are caused by materials which had previously been weighed manually or have been canceled because of an error pertaining to the past production processes and have remained in the steelyard.

When the material in the steelyard is heavier than the weight capacity limit of the steelyard, the user is given an alert , and that material in the steelyard is not weighed.

In order to solve the problem, if the material in the steelyard is in acceptable weight limits, the steelyard indicator is initialized and the present weight is introduced as the tare to the system. A second method is, the adjustment of the parameter value to a value above the amount of material on the steelyard. But if the exceeding amount is likely to deteriorate the product quality, the material should manually be discharged without canceling the production process and the production operation should be continued on its usual course after the discharge.

AGGREGATE, CEMENT, WATER AND CHEMICAL DISCHARGING END LIMIT WEIGHTS

The steelyard discharge procedure is not terminated after the passing of a certain time period but following the steelyard weight control procedure. Immediately after the steelyard weights fall below the "TERMINATION LIMIT WEIGHTS", the weighing band stops, the bunker lids are shut.

As long as the steelyard weight does fall below the related parameter, the band does not cease to operate or the lids are not closed. Taking the possible material adhering, if the clean-up procedure of the related unit is going to be delayed, the steelyard indicator can simply be initialized, or the parametric value of the unit can be set to above the steelyard weighing value.

Weighting and Discharging Delay Duration

AGGREGATE, CEMENT, WATER, CHEMICAL BEFORE AND AFTER WEIGHTING WAITING TIME

The weighing procedure of the next period is being done immediately after the discharging process of the material that had been balanced previously, and meanwhile the material that will be weighed flows to the steelyard from a certain predefined location. For these reasons, there appear oscillations during the discharging and also during the weighing procedures. The system begins the measurement after waiting for a time gap whose period has been parametrically entered by the system for dissipation of the oscillations that had been produced prior to and afterwards the weighing procedures.

In other words, the aim of using these waiting gaps, is to minimize the mechanical oscillations formed on the steelyards by the machinery equipment as far as possible.

AGGREGATE, CEMENT, WATER, CHEMICAL BEFORE AND AFTER DISCHARGING WAITING TIME

The discharge procedure is terminated, immediately after when the Steelyard weights fall below the "Discharge Termination Limit". In the banded aggregate systems, an additional waiting time gap can be added prior to the shutting of the discharging lids, for the balancing weight may seem to fall below the termination limit value instantaneously, by virtue of the oscillations produced during the discharge process, and it is possible that there might still exist some material inside the steelyard.

When the system does not have a saving bunker, a time gap for the delays should also be adjusted to the system in order to enable the Cement, the Water and the Alloy discharges to reach from the weighing band of the aggregate into the mixer. Thanks to this time gap provided, the Aggregate, the Cement, Water and the Alloy can enter the mixer simultaneously.

Plant Settings

It is the display screen where the facility information is entered and changes, or adjustments on the plant settings can be done.

CODE: If the firm owns more than one facility, this is the number ID given to each one of them. This information is used in the facilities which are connected to each other by a network system which is being controlled from a single center.

NAME: is the name information of the facility.

DELIVERY NOTE SERIAL NUMBER: is the serial number of delivery note.

DELIVERY NOTE NO: is the number of delivery note.

AGGREGATE TOLERANCE: This is used to input of aggregate tolerance.

CEMENT TOLERANCE: This is used to input of aggregate tolerance.

WATER TOLERANCE: This is used to input of water tolerance.

CHEMICAL TOLERANCE: This is used to input of contributions tolerance.

ASH TOLERANCE: This is used to input of ash tolerance.

ICE TOLERANCE: This is used to input of ice tolerance.

PAINT TOLERANCE: This is used to input of paint tolerance.

DELIVERY NOTE PRINT APPROVAL: If consent YES/NO is wanted to print the transport document after the production, this consent is chosen.

SOUND APPROVAL: It control in the status of all voice ProkserNET program. If checked all voice is active in program.

FEEDING BAND STANDBY BETWEEN PERIODS: Feeding band wait until last period will finish and new period will start. If it marked, this situation becomes active.

PULLCORD APPROVAL If there is rope switches in the system it can be active. If rope break off, the system switches itself to standby mode automatic. Approval of it will be on the screen. If it checked this situation becomes active.

BAND SLIDED APPROVAL: If band slide, the system switches itself to standby mode automatic. If it checked this situation becomes active.

BAND BROKEN APPROVAL: if rope break off, the system switches itself to standby mode automatic.

If it checked this situation becomes active.

COLLECTOR BUNKER EMPTY CONTROL APPROVAL: If there is switch in gather bunker, it can be active.

We can understand gathering bunker is full or empty by switch. If it checked this situation becomes active.

FEEDING BAND HALT APPROVAL WHEN STOPED: Feeding band stop while stand by. If it checked this situation becomes active.

SAVE: This is used to keep the information entered currently or any modifications made on a present record.

CANCEL: This is used to cancel the modifications made.

EDIT: This is the instruction to make any amendment on chosen record.

Plant Configuration

It is only entered authorized person by Prokser. Plant settings is done in there.

Production

In this screen there is a general view as 3 dimensional model of facility. Intelligibility of animation is top level. Amount of each material stock and available capacities appear over each animation model and change their values which materials stock control active. Transparent screen of cement and contribute appear and rise their amount of stock when user come over cement and contribute model. A value of rising material is real value and screen if stock control always active and true. Transparent screen of cement and contribute disappear in 10 seconds and ex screen view come back when mouse pull over model. The screen is divided two unit as control and information.

Information screen reflected on animation by values. There are aggregates values in the upper left corner of screen. Wanted, measured and error values are displayed 3 different value in there. All wanted values's colors are green according to Formula before start production. After selection Formula all value automatic update in there. Near aggregate values there are water and contribute values. These values change according to Formula too. Near water and contribute values there are cement values.

REQUIRED: Entered by user for a Formula.

MEASURED: Values measured during production.

DIFFERENCE: Difference between wanted values and measured values.

There are period values of cement, aggregates, contribute, water and mixer in the bottom left of screen. Trans panel appear and show time of mixer working, current period and total period during continued production, how much production would produce as cubic meters, mixer discharge time, mixer mixing time when come over mixer model.

Weighing instant value of aggregates show on weighing band as a numeric. Cement weighing value show on cement bunker and like this also water and contribute instant weighing values show on their bunker. Mixer mixing time appear on mixer model when mixer start to mix. Mixer discharging time appear on mixer cover when cover is opened and it start to discharge. On animation there are two point models on mixer cover. If there is red point model on animation, it means the cover is closed. If there is green point model, it means cover is opened.

There are end of day button, user name, plant name, average hourly production, daily production information at the bottom of the screen.

HOURLY AVERAGE PRODUCTION: The amount of production since per day rate of hour.

DAILY PRODUCTION: Show total amount of production as cubic meter since per day. The user may change selections on control screen. This structure is on the right side of the screen.

ORDERS: This is used to choose Formula, customer and amount of production which is recorded in order screen. All orders show in this panel when click the order button. **Shortcut Key "P"**

PRODUCTION PLAN: This is used to want consecutive production. User queue orders or entered a new production and than can be consecutive production in order. Using new production button the Formula, amount of production, customer, chantier, transmixer, driver and type of service are entered or choose order which is ready to production and transfer to this screen. So the production is ready to be done.

QUANTITY: Production values as a cubic meter which will be do. **Shortcut Key "1"**

FORMULA: This is used to choose formula which will use. **Shortcut Key "2"**

CUSTOMER: This is used to choose customer which production will go. **Shortcut Key "3"**

CHANTIER: This is used to choose chantier which customer has it. Selection process become after choose customer because chantier is associated with customer. So at first user select customer and then select chantier. If the user have previously chosen chantier belongs to customer it memory that. Later if user select same customer, chantier will be select automatic. **Shortcut Key "4"**

TRANSMIXER: This is used to choose transmixer. **Shortcut Key "5"**

DRIVER: This is used to choose driver. **Shortcut Key "6"**

SERVICE 1: This is used to choose service type **Shortcut Key "7"**

SERVICE 2: This is used to choose service type. **Shortcut Key "8"**

EXTRA WATER: This water values fall down from Formula. **Shortcut Key "9"**

PRESENT QUANTITY: That indicates how much production is ready. That value fall down from total production **Shortcut Key "0"**

START: Start production after write all values. **Shortcut Key "B"**

END PRODUCTION: End production after start production. **Shortcut Key "U"**

STOP: Stop to production. **Shortcut Key "D"**

RESET: Reset to production. It cancels to startup process. Production comes back starting position.

Shortcut Key "S"

MANUAL RECORDING: The productions that had been manually made or completed, can be registered to the program as dispatched registry and their inventory chasing and transport document printing transactions can be made.

To the left of this screen, similar to the animation screen's, "The Production Information" can be entered and be changed, and to the right of the screen there exists the amount information that will aid the user for the manual weighing procedures.

The information regarding the data that will be added are entered and the "ADD MANUAL DATA" button is pressed. The transport document printout can also be taken by stating "YES" for transport document print option **Shortcut Key "M"**

PERIOD VALUES: It show total period as a numeric and which period to end. After selection period click end button. The production finishes at selected period. For example we can end up production at 1, 2, 3 or 4.period with control which total production period is 4.

END DAY: Database backup is done in this process. If you have got any gms module , production, shipping, spent, stock, Formula, transmixer, customer, chantier reports are sent to authorized persons.

Database Restore

This is used to restore all data in to database.

Database Backup

It backup record information on database. It is useful to enter description for restore database and it should be done one times a week.

Vibrator and Air Shock Duration

AGGREGATE VIBRATION CONTROL and VIBRATION APPLICATION TIME

The system does "Time-Dependent Flow Control" for the weighing made from the aggregate beams. If the amount of flow is insufficient within the control parameters limit, vibration is automatically applied during the time period determined, in order to increase the flow.

VIBRATION APPLICATION AND WAITING PERIODS FOR THE THE WEIGHING BAND

During the discharge of the weighing band, vibration is applied to ensure the quick flow and discharge and also of the materials that are likely to adhere to the surface. In order to prevent the mechanical deterioration, this vibration does not begin altogether with the flow and simultaneously continue, but begin to the end of the discharge procedure and continue as apply and wait, and cease with the discharging procedure. The vibration at intervals process begins immediately after the steelyard weight falls below the "Weighing Band Vibration Control Weight".

VIBRATION APPLICATION AND WAITING PERIODS FOR THE CEMENT BUNKER

While the cement bunker is being discharged, vibration is applied in order to ensure rapid discharge and also the quick discharge of the materials likely to adhere to the surface. In order to prevent the mechanical deterioration, this vibration does not begin altogether with the flow and simultaneously continue but, begin to the end of the discharge procedure and continue as apply and wait, and cease with the discharging procedure. The vibration at intervals process begins immediately after the steelyard weight falls below the "Cement Bunker Vibration Control Weight".

VIBRATION APPLICATION AND WAITING PERIODS FOR THE COLLECTOR BUNKER

These parameters change in accordance with the type of the system: namely, according to whether the system does or does not employ "The Accumulation Bunker is Empty" signal.

If the system employs the use of the "empty" signal, the vibration is applied and waiting period is employed depending on the application and waiting periods, if when the empty signal still had not been perceived by the system at the end of the "Vibration Control Period" the vibration begins until the signal becomes perceived by the system.

If the system does not employ the use of the "empty" signal, application of the vibration begins following the fulfillment of the "Vibration Control Period" and the vibration continues with the apply-and-wait procedure at vibration intervals until the discharge procedure comes to the end.

These parameters are not being employed in those systems without the saving/accumulation bunker.

THE APPLICATION AND WAITING PERIODS OF THE CEMENT AIR SHOCK

These are the parameters that regulate the air shock given to the conic bottom line of the silos in order to accelerate the material flow during the cement weighing process. This air shock is not applied continuously in order to prevent the cement solidification that is to be produced because of humidification. It is rather given during a certain application period to the silos, and is stopped during the predefined waiting period.