

JaNets JT Simple

Instruction Manual



Congratulations on your purchase of a JUKI product.

To ensure safe use of the JaNets JT Simple, it is necessary to read this Instruction Manual carefully and fully understand its contents before putting the JaNets JT Simple into use. Keep this Instruction Manual at a prescribed position to make it available whenever necessary.

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Introduction

This Instruction Manual describes the operation of terminals that is carried out by sewing machine operators and the operation of the report center that is carried out by the line managers for grasping the production status.

This Instruction Manual describes the operation that is carried out after you have completed the line setting so as to allow data to be collected from sewing machines within the sewing line. If you have not yet completed the line setting, carry out setting of the line referring to the **"Instruction Manual for the setup and change of the line"**. Then, read this Instruction Manual.

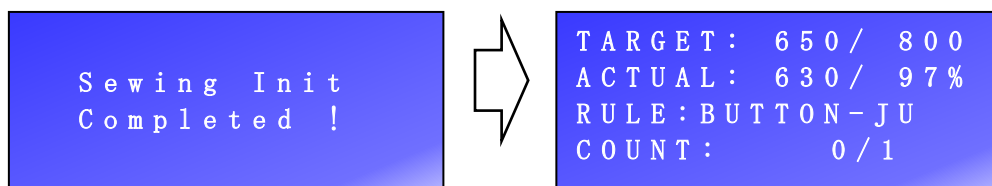
I. Operation of the terminal (for operators)

This section describes how to view the terminal display and how to operate the terminal when the sewing machine operator uses the terminal during sewing work.

1. Terminal display

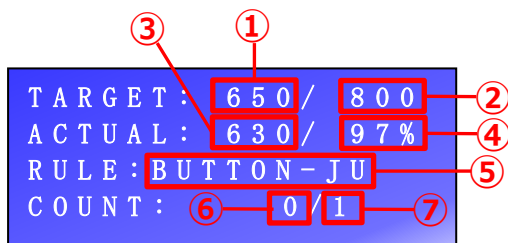
1-1. Display of power-ON of the sewing machine

When you turn ON the power to the sewing machine, the initialization screen, as shown below, is displayed. When the initialization process is completed, today's quantity of output is displayed.



1-2. How to view the terminal display

While the power to the sewing machine is turned ON, the screen, as shown below, is displayed.



- **Target quantity of output**
It displays the Current-time target quantity of output ...① / Daily target quantity of output ...②.
- **Actual quantity of output**
It displays the Actual quantity of output ...③ / Current-time progress ...④.
- * Current-time progress ...④ = (Actual quantity of output ...③ / Current-time target quantity of output ...①) x 100
 - * The aforementioned values allow you to get a grasp of delay or advance of your sewing work.
 - Actual quantity of output ...③ exceeds the current-time target quantity of output ...①
 - Current-time progress ...④ exceeds 100 %
You should carry out the sewing work, while checking the pace of work so as to achieve the following:
- **Count condition ...⑤**
Predetermined condition for counting of the quantity of output is displayed.
 BUTTON-JU: When the JUKI sewing machine button is pressed
 Thread Trimmer: When the thread is trimmed
 Pattern End: When the sewing-pattern sewing operation is completed
 Cycle End : When the cycle-pattern sewing operation is completed
 BUTTON-NJ: When the button is pressed during the process carried out by any machine other than the JUKI sewing machine
- **Count of thread trimming**
Current number of times of thread trimming ...⑥/ Number of times of thread trimming for the process ...⑦
 - * Every time the thread trimming is performed, the current number of times of thread trimming ...⑥ is increased by one. When the number of times of thread trimming for the process ...⑦ is reached, the quantity of output is increased by one.

2. Correction of the quantity of output

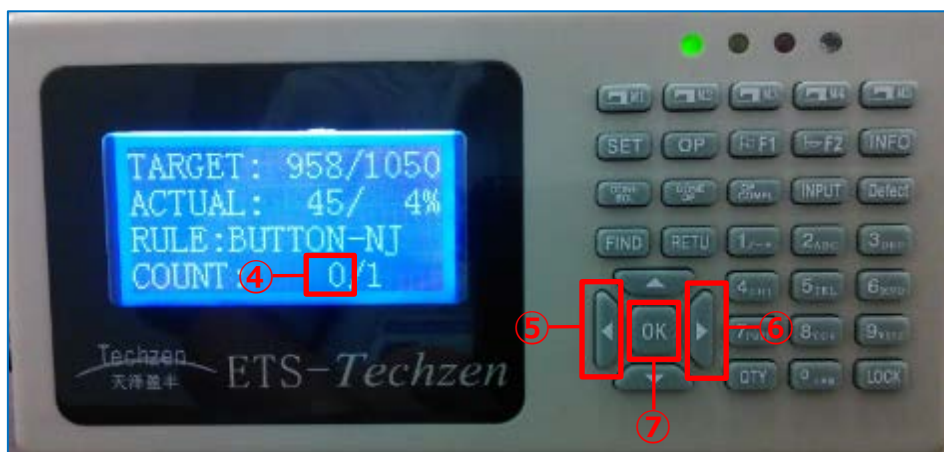
2-1. How to correct the quantity of output

If you want to correct the Actual quantity of output ...① after a sewing failure or a trial stitching, correct it with ▲ key ...② and ▼ key ...③.



2-2. How to correct the current number of times of thread trimming

If the Current number of times of thread trimming ...④ differs from the correct number after the occurrence of thread breakage or re-sewing, correct it with ◀ key ...⑤ and ▶ key ...⑥ to adjust the timing of counting of the quantity of output. In addition, the number of times of thread trimming can be reset to "0 (zero)" by pressing OK key ...⑦.

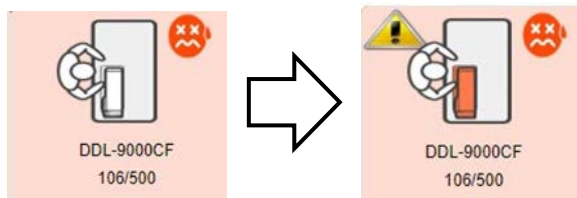


3. Maintenance call

If any trouble occurs during sewing, the operator performs maintenance call operation from the terminal to inform the line manager.

When the operator carries out the maintenance call, the sewing machine displayed on the progress management monitor of the report system changes as shown in the figure below.

Maintenance call state



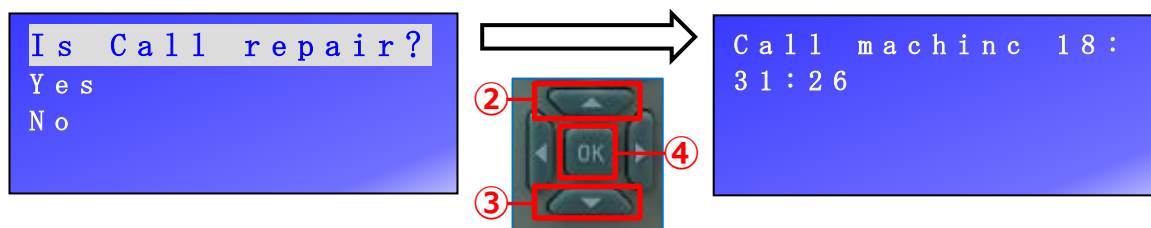
3-1. Issuing a maintenance call

When you press M3 key ...①, the maintenance call confirmation screen is displayed.



Operate ▲ key ...② and ▼ key ...③ to align the cursor on "Yes" and press OK key ...④ to initiate the maintenance call.

* Since the sewing counter continues counting even during the maintenance call, sewing work can be carried out continuously.

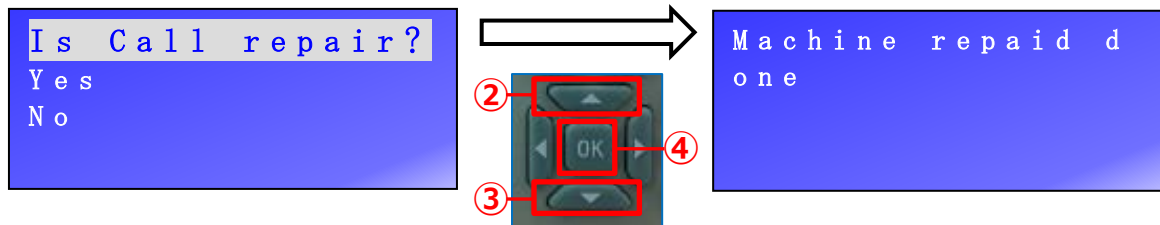


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Releasing the maintenance call

After the completion of maintenance work, press M3 key ...① again.

The maintenance call ending confirmation screen is displayed. Operate ▲ key ...② and ▼ key ...③ to align the cursor on "Yes" and press OK key ...④ to finish the maintenance call.



4. Confirmation and change of machine settings

It is possible to confirm and change the sewing machine settings by operating the terminal. This procedure is not needed during the normal sewing work. If it is necessary to carry out this procedure, follow your line manager's instructions.

4-1. Confirming the machine settings

The sewing machine settings as listed in the table below can be confirmed by operating the terminal.

Item	Sample entry	Remarks
Factory name	SSC smart factory	
Floor name	6F	
Line number	16	
Terminal ID	53368	
Machine number	16012	
Software version	01030361	
Time to turn ON the power to the sewing machine	14:01	

When you press RETU

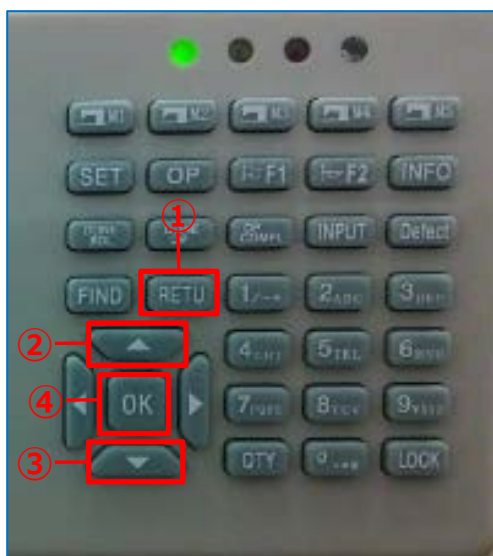
key ...①, the sewing machine setting information specified on the terminal is displayed. Check the sewing machine setting information by turning the pages with ▲ key ...② and ▼ key ...③. This checking procedure is terminated with OK key ...④.

* The screen display shown below indicates the display in the case of the aforementioned

```
SSC smart factory
y--6F--16ID:5336
8-0-S      Machin
```

```
e#16012      Machin
e SerialNo:53368
  Machine Version
:01030361 Machin
```

```
E Connect Time:1
4:01
```



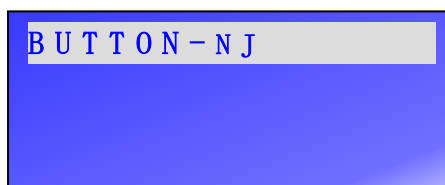
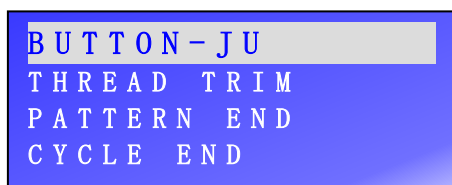
4-2. Changing the count condition

Press M4 key ...①



The screen for selecting the condition for counting the quantity of output is displayed. Select the count condition with ▲ key ...② and ▼ key ...③.

*Refer to **I.1.2 How to view the terminal display** for the kinds of count conditions.

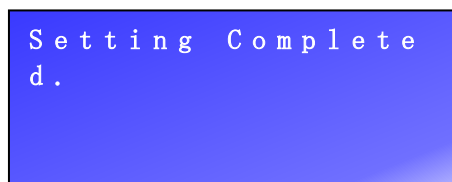


After you have selected the count condition, press OK key ...④. Then, the selected data is confirmed and the message "Ple. InputCount Value" is displayed.



Then, enter the number of times of thread trimming for the process using numeric keypad ...⑤ and press OK key ...④.

If the message "Setting Completed." is displayed, the count condition and the number of times of thread trimming for the process have been successfully entered.



4-3. Changing the final process

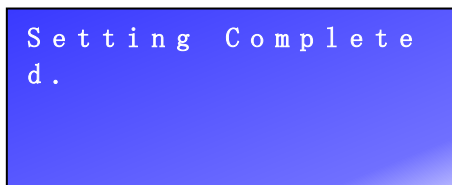
Press M5 key ...①.



The screen for setting whether or not the process at which the terminal is installed is the final process is displayed. Select the "Finish Point" when it is the final process or "Not Finish Point" when it is not with ▲ key ...② and ▼ key ...③.

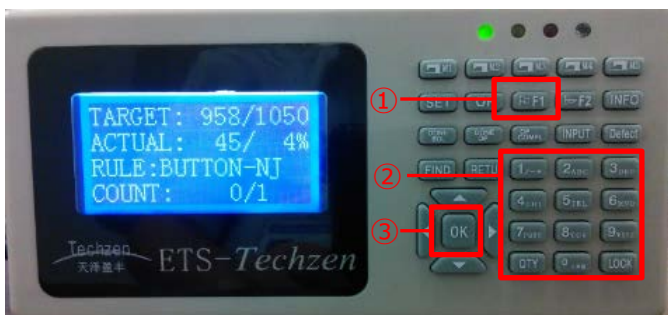


After you have made the selection, press OK key ...④. Then, the data you have selected is confirmed and the message "Setting Completed." is displayed.

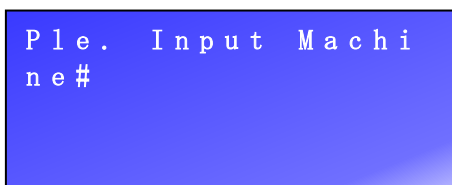


4-4. Changing the machine number

Press F1 key ...①



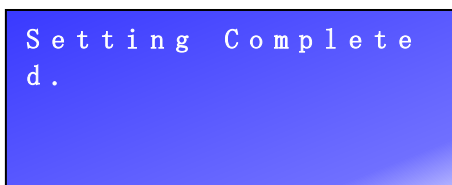
The "Ple. Input Machine#" screen is displayed.



Enter the "Machine number" you want to change (20-digit figure at the maximum) with numeric keypad ...②.



After you have entered the machine number, press OK key ...③. Then, the machine number you have entered is confirmed and the message "Setting Completed" is displayed.



II. How to use the report system (for line managers)

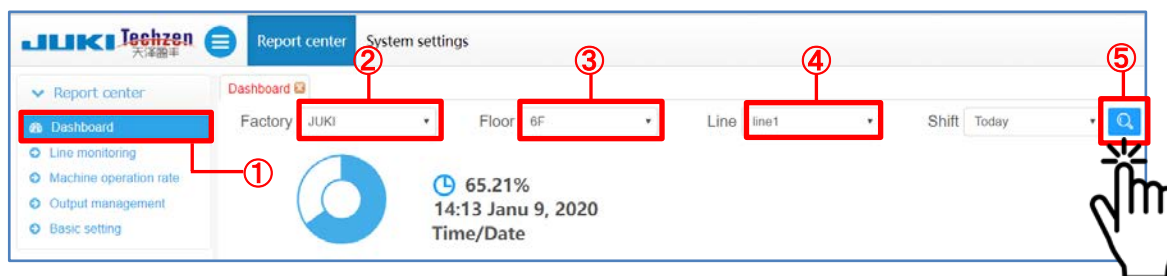
This section describes how the line managers should view the charts and information of the report system.

1. Dashboard

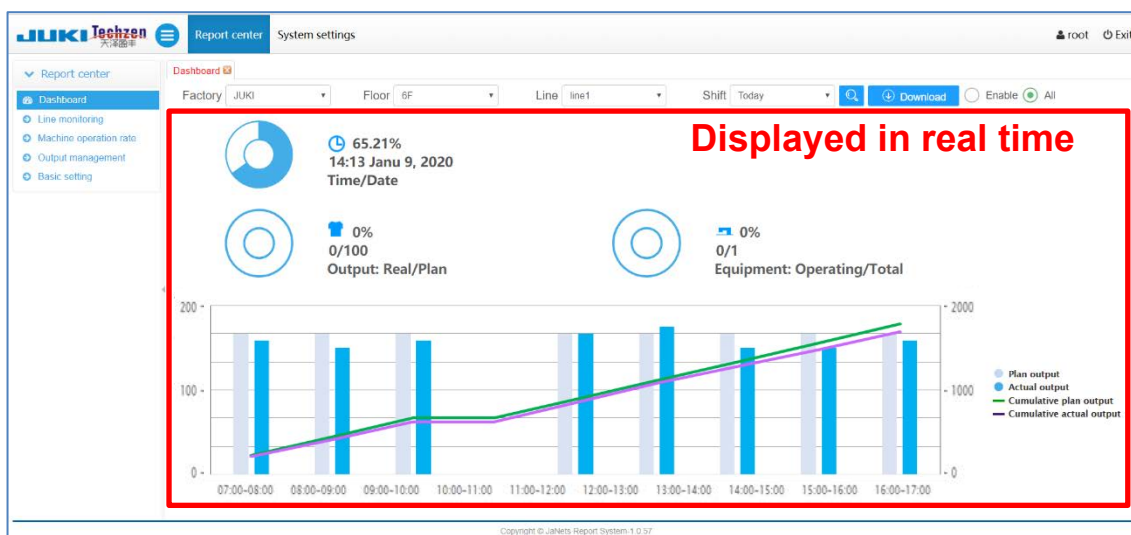
The dashboard allows you to get a real-time grasp of the production status of each line.

1-1. Selecting a line

Select Dashboard ...① of the report center. Then, select Factory ...②, Floor ...③ and Line ...④ in sequence. Then, press Search button ...⑤.

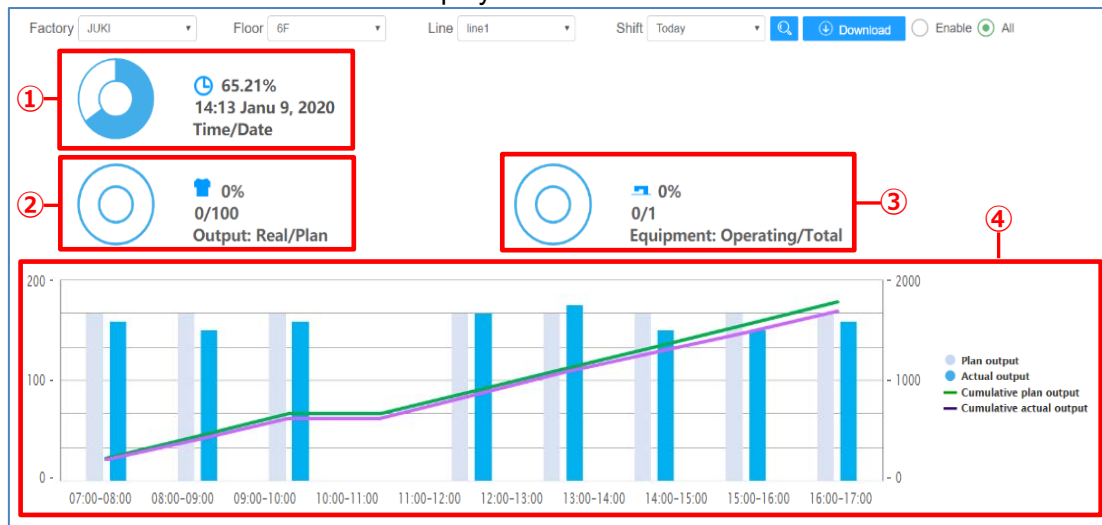


The status of the line you have selected is displayed in real time.



1-2. Real-time display items

This clause describes the items displayed on the dashboard.



● **Elapsed time ...①**

The percentage of working hours elapsed with respect to the specified working hours of the shift is displayed in a pie chart.

● **Progress of the quantity of output ...②**

The percentage of the current quantity of output with respect to the specified target quantity of output of the shift is displayed in a pie chart.

* It is possible to check whether the current production status is behind or in advance of the schedule by comparing the progress of the quantity of output with Elapsed time ...①.

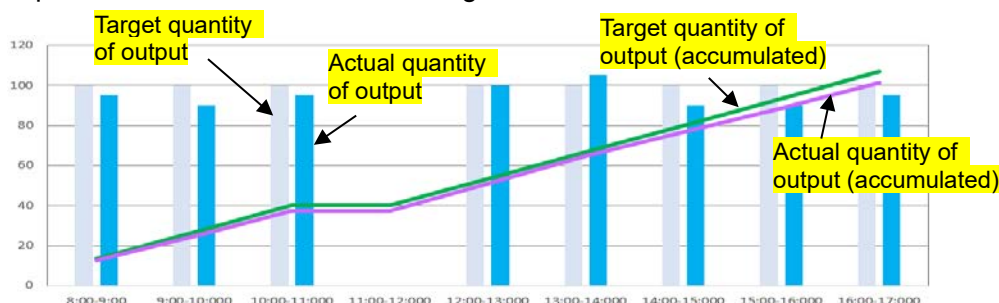
● **Power activation status of the sewing machine ...③**

The ratio of the number of sewing machines to which are turned ON with respect to all sewing machines in the line that are connected to the system is displayed in a pie chart.

● **Time series chart of the quantity of output ...④**

The target quantity of output and the actual quantity of output are displayed in time series in a bar chart. In addition, the accumulated target quantity of output and the accumulated actual quantity of output are displayed in a line chart.

* This time series chart allows you to understand the production status from the start of production to the current time at a glance.

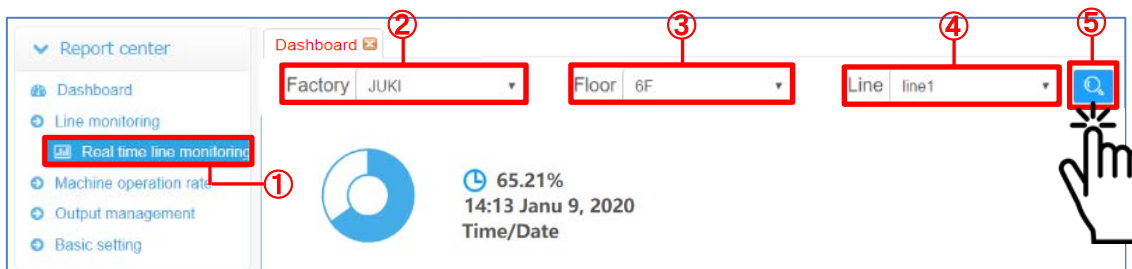


2. Progress management monitor

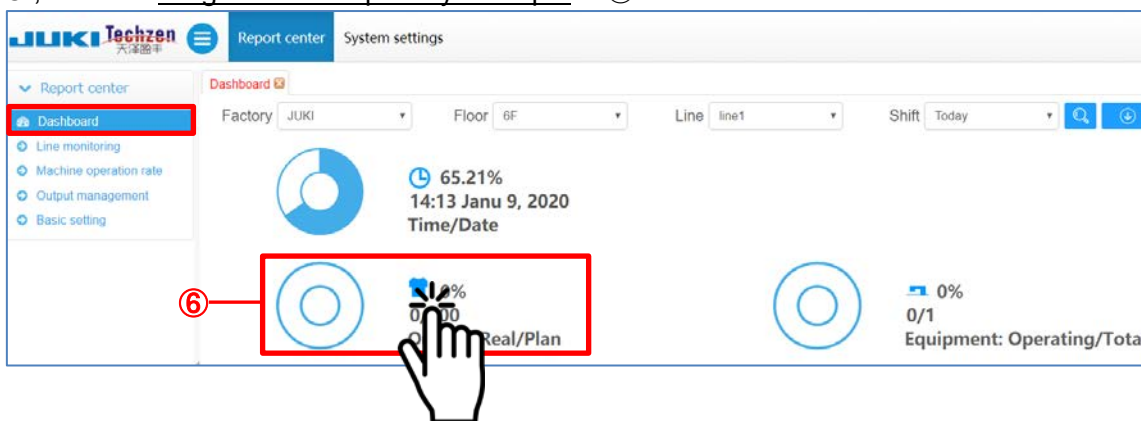
It is possible to understand the production status of each sewing machine in the line in real time.

2-1. Selecting a line

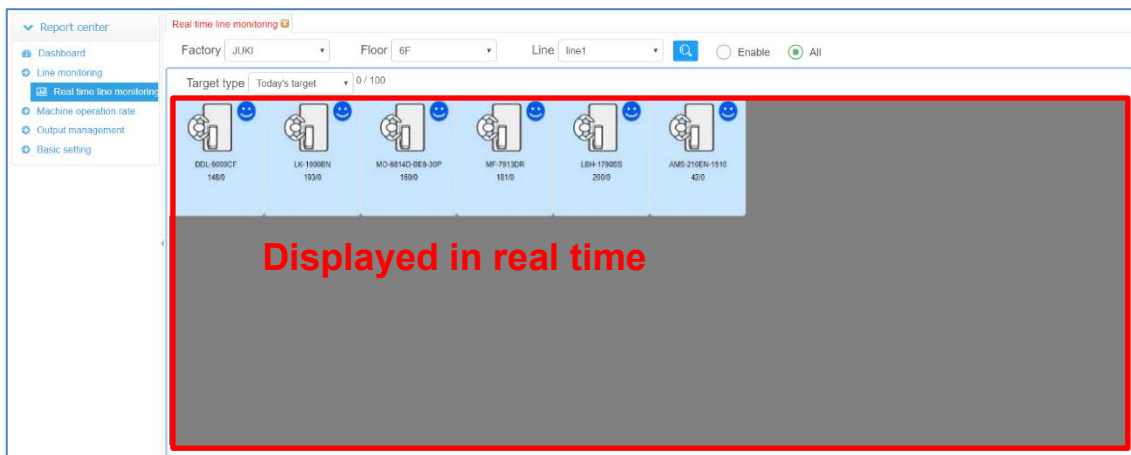
Select the Line monitoring > Real-time line monitoring ...① of the report center. Then, select the Factory ...②, Floor ...③ and Line ...④ in sequence. Then, press Search button ...⑤.



Or, click the Progress of the quantity of output ...⑥ on the dashboard.

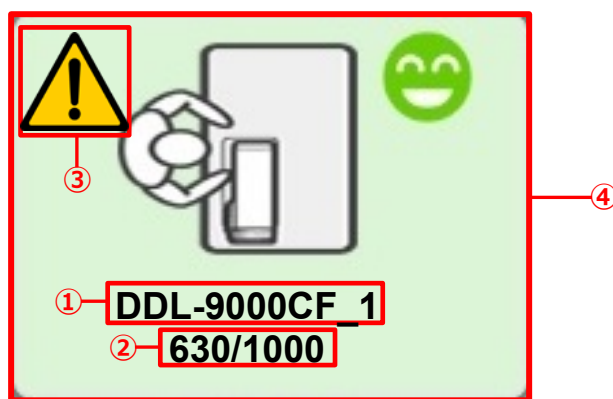
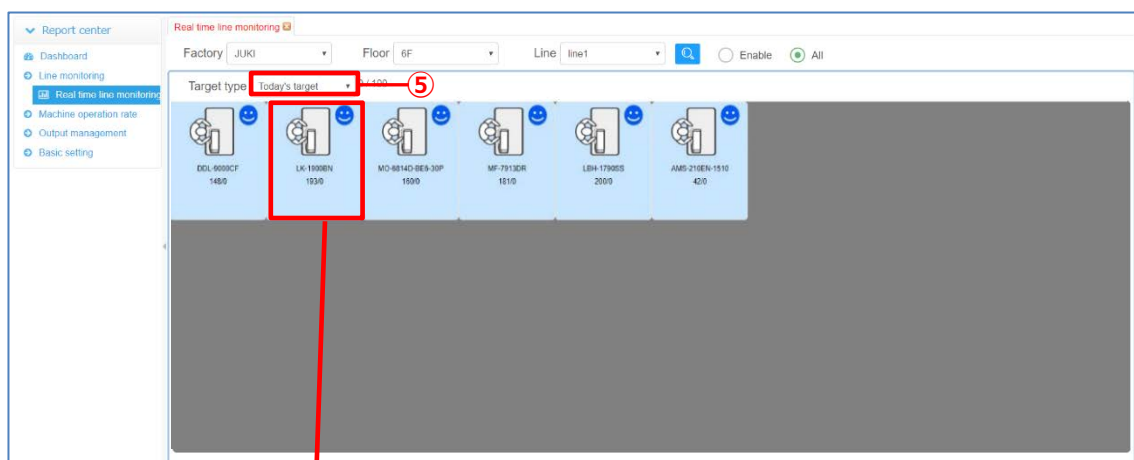


Then, the production status of each machine in the currently-selected line is displayed in real time.



2-2. Real-time display items

This clause describes the items displayed in the real-time line monitor.



● **Sewing machine name ...①**

The name of the sewing machine that is registered is displayed.

● **Output-quantity display ...②**

"Actual quantity of output / target quantity of output" is displayed.

* The target quantity of output can be changed over between the today's target and the real target by setting the Target type ...⑤.

Today's target : The target quantity of output at the end of shift production

Real target : Target quantity of output at the current time (This target value changes with time.)

● **Maintenance call display ...③**

This display appears when the maintenance call operation is carried out on the terminal.

* The maintenance call display is continuously shown on the screen until the maintenance call is released on the terminal.

Refer to **I.3. Maintenance call** for how to operate the terminal.

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●Progress signal display ...④

This signal display indicates whether the production progress is behind / ahead of schedule based on the determination value obtained by the below-stated formula by changing the color so as to allow you to understand at a glance.

Determination value (%) = (Actual quantity of output / target quantity of output at the current time - 1) x 100



Caution: Excessively advanced (+5 % or more)



Normal (+5 % ~ -5 %)



Caution: Excessively delayed (-5 % ~ -10 %)



Warning: Excessively delayed (-10 % or less)



Power OFF or Not yet communicated

* The threshold for changing the color is adjustable according to the management level. Refer to **II.8. Setting the threshold for color of the smileys** in the "Instruction Manual for the setup and change of the line".

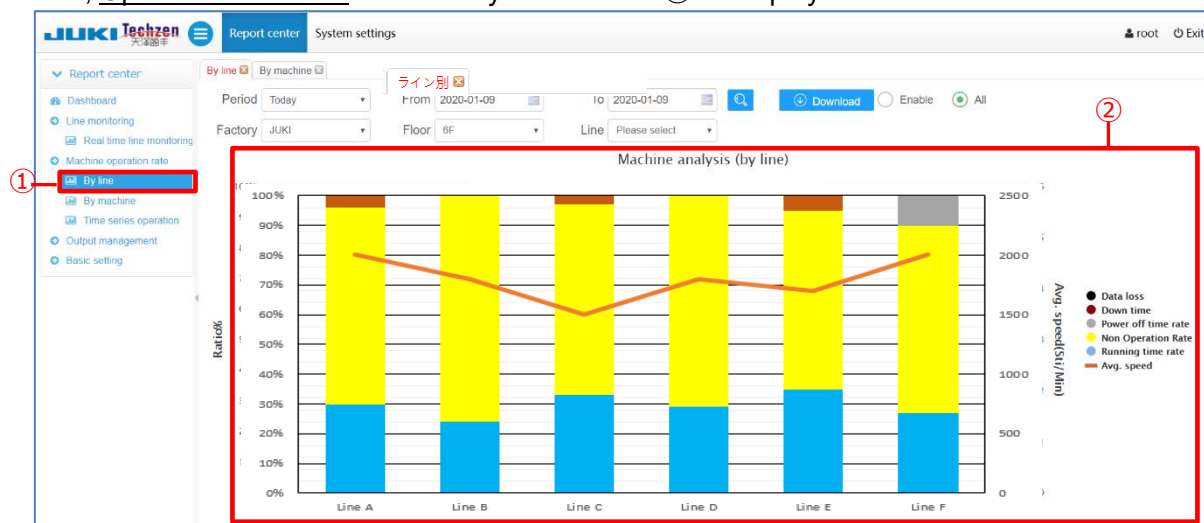
3. Operation rate chart of the sewing machine

With this chart, it is possible to check the operation rate and the average number of revolutions of the sewing machine on a line-by-line basis and on a machine-by-machine basis. In addition, hourly and daily changes in the operation rate of each sewing machine can be checked in time series.

Use the operation rate chart as an indicator for keeping track of the production-line downtime (machine failure, waiting time for goods in process, etc.), evaluating the operators' skill, improving the sewing work, increasing the operation rate of automatic machine, etc.

3-1. Operation rate chart on a line-by-line basis

When you select the Operation rate of sewing machine > Line by line ... ① of the report center, Operation rate chart on a line-by-line basis ... ② is displayed.



● Selection of the period

One of the six periods shown below can be selected.

By line By machine

Period: Today From: 2020-01-09 To: 2020-01-09

Factory: JUKI Floor: 6F Line: Please select

- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day

- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

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● Selection of the line

Narrow down the line you want to display on a chart using the Selection of the factory, floor and line ...③.

By line By machine

Period Today From 2020-01-09 To 2020-01-09

③ Factory JUKI Floor 6F Line Please select

- * To display all of the lines registered with the system
Factory: Not selected yet Floor: Not selected yet Line: Not selected yet
- * To display all of the lines in the selected factory
Factory: Select the factory Floor: Not selected yet Line: Not selected yet
- * To display all of the lines in the selected floor
Factory: Select the factory Floor: Select the floor Line: Not selected yet
- * To specify the line you want to view its operation rate
Factory: Select the factory Floor: Select the floor Line: Select the line

● Retrieval of the data

After you have selected the period and line, press the Search button ...④. Then, the data that meets the specified condition such as the period and line will be retrieved and displayed on a chart.

By line By machine

Period Today From 2020-01-09 To 2020-01-09

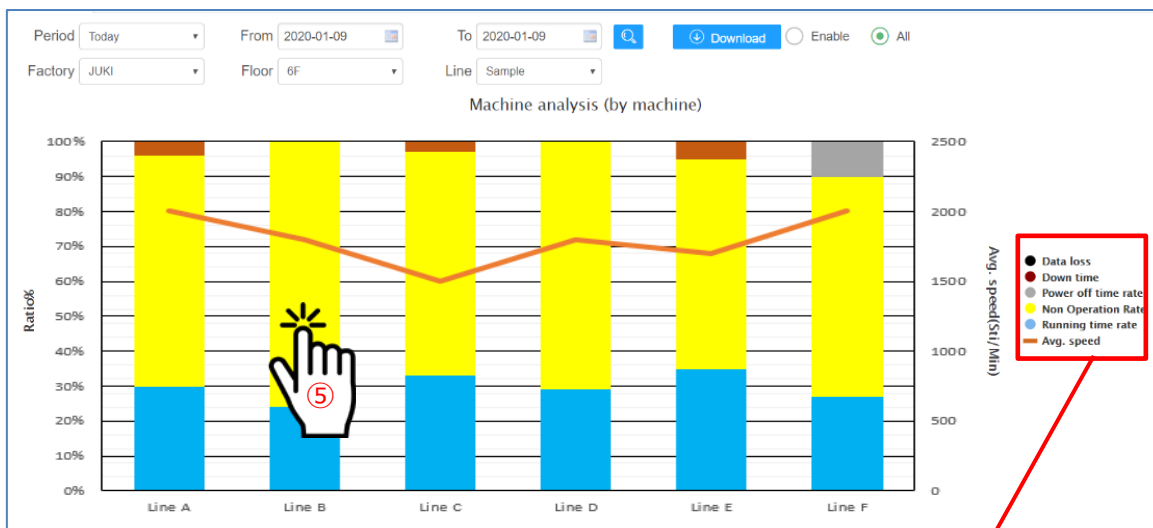
Factory JUKI Floor 6F Line Please select

④

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- Explanation of the items displayed on a chart

The operation rate (%) of the selected line is displayed in a bar chart. The average number of revolutions of the sewing machine is displayed in a line chart. Use this chart to help improve the operation rate without reducing the number of revolutions of the sewing machine for increasing productivity and improving sewing work.

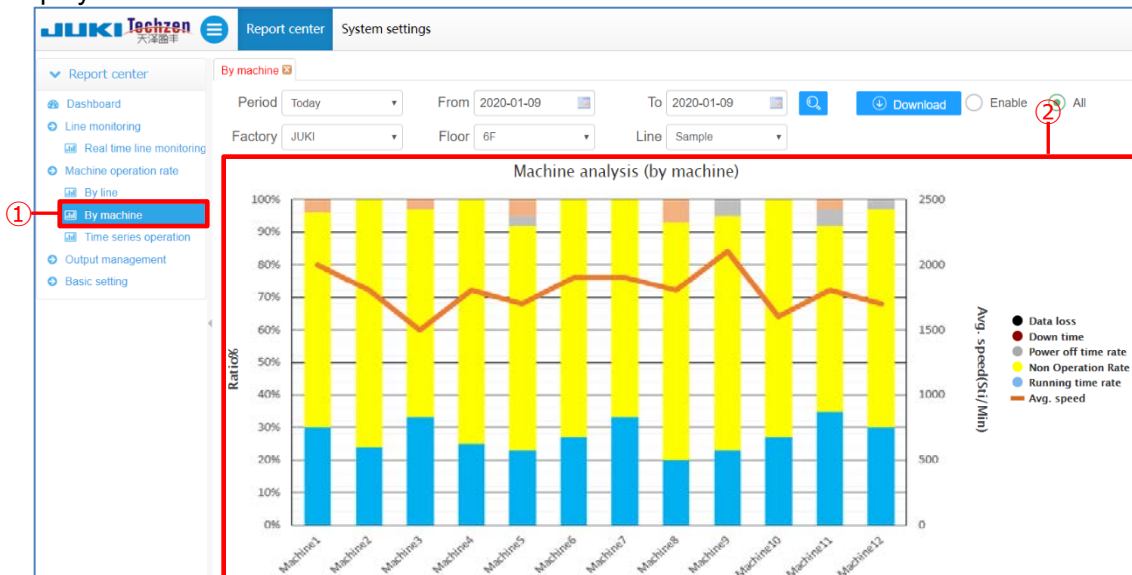


● Data loss	Network fault, terminal power-supply disconnection
● Down time	Maintenance call, temporary stop (automatic machine)
● Power off time rate	Sewing machine power-supply disconnection
● Non Operation Rate	Sewing machine is at rest
● Running time rate	Sewing machine rotates
● Avg. speed	Average sewing speed

* When you click the Line bar chart ...⑤, the operation rate chart for the sewing machine registered in the line you have clicked is displayed.

3-2. Operation rate chart on a machine-by-machine basis

When you select the Operation rate of sewing machine > Machine-by-machine basis ...① of the report center, the Operation rate chart on a machine-by-machine basis ...② is displayed.



- Selection of the period
One of the six periods shown below can be selected.

- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day
- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

- Selection of the line
Select the line using the Selection of the factory, floor and line ...③.

- * Be sure to select a line without exceptions. If you have not selected any line, the message "Select a line" will be displayed.

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- Retrieval of the data

After you have selected the period and line, press the Search button ...④. Then, the data that meets the specified condition such as the period and line will be retrieved and displayed on a chart.

By machine

Period: Today | From: 2020-01-09 | To: 2020-01-09

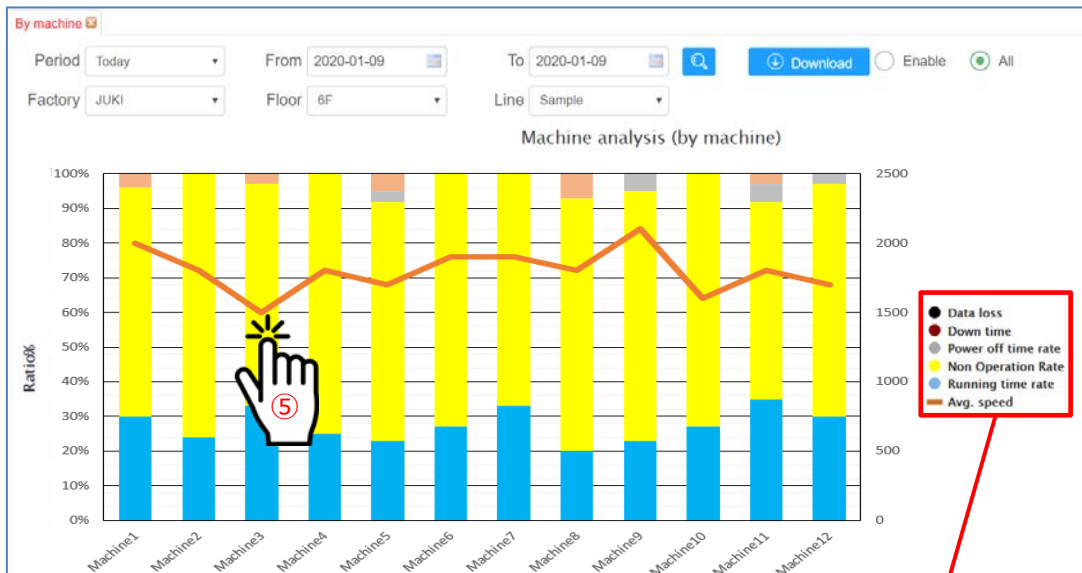
Factory: JUKI | Floor: 6F | Line: Sample

④

- Explanation of the items displayed on a chart

The operation rate (%) of the sewing machine in the selected line is displayed in a bar chart. The average number of revolutions of the sewing machine is displayed in a line chart.

Use this chart to help improve the operation rate without reducing the number of revolutions of the sewing machine for increasing productivity and improving sewing work.

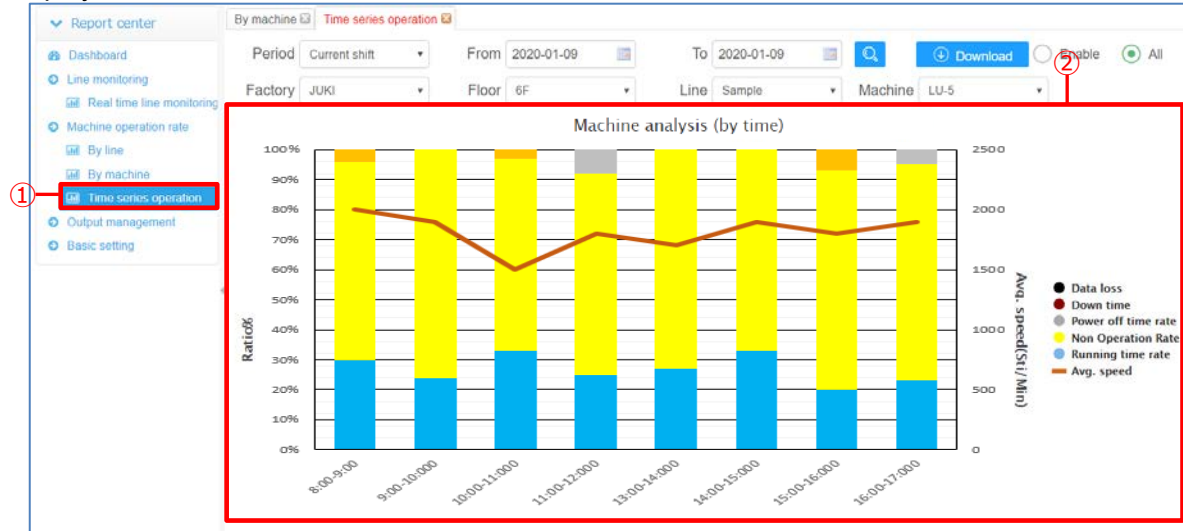


● Data loss	: Network fault, terminal power-supply disconnection
● Down Time	: Maintenance call, temporary stop (automatic machine)
● Power off	: Sewing machine power-supply disconnection
● Stop Time	: Sewing machine is at rest
● Running Time	: Sewing machine rotates
● Avg. Speed	: Average sewing speed

* When you click the Sewing machine bar chart ...⑤, the time-series operation rate chart for the sewing machine you have clicked is displayed.

3-3. Time-series operation rate chart of the sewing machine

When you select the Operation rate of sewing machine > Time-series operation rate ...① of the report center, the Time-series operation rate chart of the sewing machine ...② is displayed.



- Selection of the period
One of the six periods shown below can be selected.

- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day
- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

- Selection of the sewing machine
Select the sewing machine using the Selection of the factory, floor, line and equipment ...

- * Be sure to select a sewing machine without exceptions. If you have not selected any equipment, the message "The sewing machine field cannot be left blank" will be displayed.

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- Retrieval of the data

After you have selected the period and line, press the Search button ...④. Then, the data that meets the specified condition such as the period and line will be retrieved and displayed on a chart.

By machine Time series operation

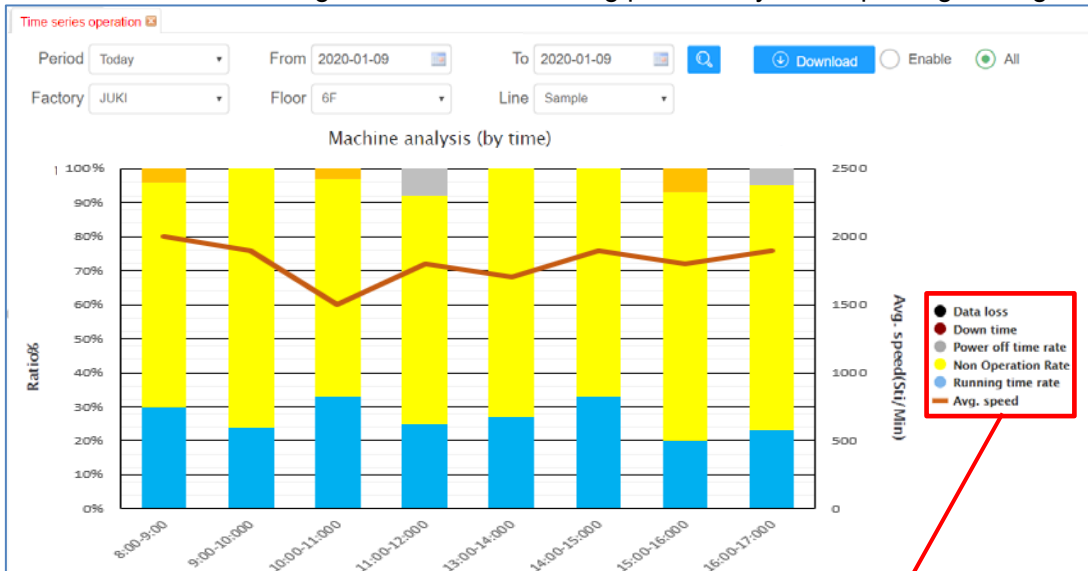
Period: Current shift | From: 2020-01-09 | To: 2020-01-09 | **Search** ④

Factory: JUKI | Floor: 6F | Line: Sample | Machi

- Explanation of the items displayed on a chart

The time-series operation rate (%) of the selected sewing machine is displayed in a bar chart. The average number of revolutions of the sewing machine is displayed in a line chart.

Use this chart to help improve the operation rate without reducing the number of revolutions of the sewing machine for increasing productivity and improving sewing work.



	Data loss	: Network fault, terminal power-supply disconnection
	Down Time	: Maintenance call, temporary stop (automatic machine)
	Power off	: Sewing machine power-supply disconnection
	Stop Time	: Sewing machine is at rest
	Running Time	: Sewing machine rotates
	Avg. Speed	: Average sewing speed

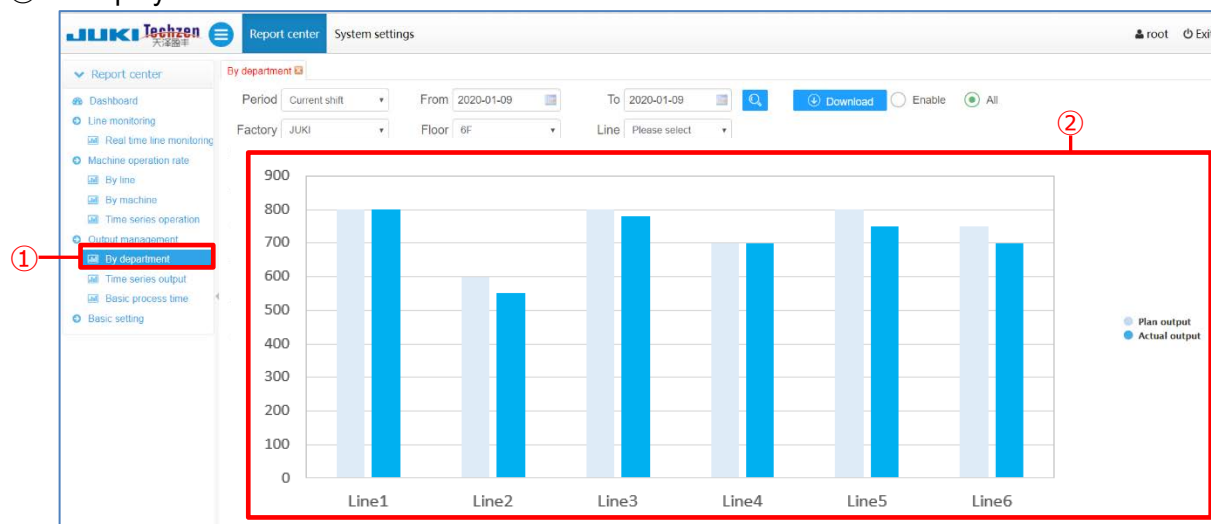
4. Output-quantity chart

It is possible to check the production progress in the past using the target output-quantity chart and the actual output-quantity chart.

4-1. Output-quantity chart on a section-by-section basis

When you select the Management of output-quantity > Department-by-department basis ...

- ① of the report center, the Output-quantity chart on a department-by-department basis ...
- ② is displayed.



● Selection of the period

One of the six periods shown below can be selected.

By department

Period: Current shift | From: 2020-01-09 | To: 2020-01-09

Factory: JUKI | Floor: 6F | Line: Please select

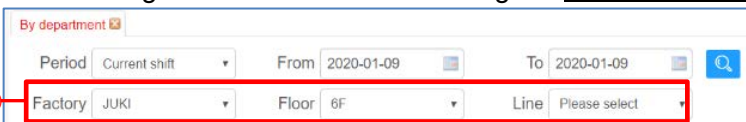
- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day
- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

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● Selection of the department

The following items can be selected using the Selection of the factory, floor and line ...③.



The screenshot shows a web form titled "By department" with a search icon. It contains several input fields: "Period" (Current shift), "From" (2020-01-09), "To" (2020-01-09), "Factory" (JUKI), "Floor" (6F), and "Line" (Please select). A red box highlights the "Factory", "Floor", and "Line" dropdown menus, with a circled number 3 pointing to it.

·Output-quantity chart on a floor-by-floor basis

Factory: Select the factory you want to display

Floor: Not selected yet Line: Not selected yet

* The quantity of output of all of the floors in the factory you have selected is displayed on the horizontal axis side by side.

·Output-quantity chart on a line-by-line basis

Factory: Select the factory you want to display

Floor: Select the floor you want to display Line: Not selected yet

* The quantity of output of all of the lines on the floor you have selected is displayed on the horizontal axis side by side.

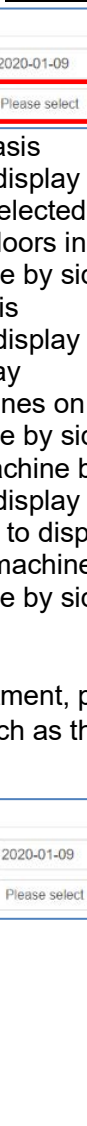
·Output-quantity chart on a machine-by-machine basis

Factory: Select the factory you want to display Floor: Select the floor you want to display
Line: Select the line you want to display

* The quantity of output of all of the machines in the line you have selected is displayed on the horizontal axis side by side.

● Retrieval of the data

After you have selected the period and department, press the Search button ...④. Then, the data that meets the specified condition such as the period and department will be retrieved and displayed on a chart.



The screenshot shows the same web form as above, but with a red box around the search button (a magnifying glass icon) and a circled number 4 pointing to it.

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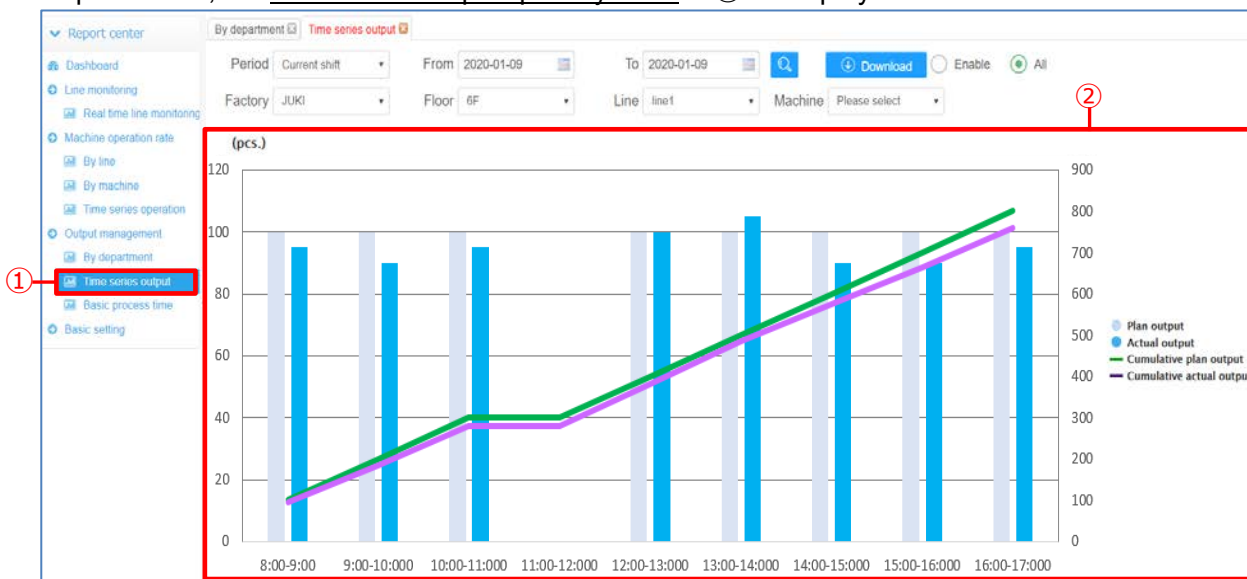
- Explanation of the items displayed on a chart

The quantity of output is displayed on the vertical axis of the bar chart. All members of the department you have selected are displayed on the horizontal axis of the bar chart.



4-2. Time-series output-quantity chart

When you select the Management of output-quantity > time-series output-quantity ...① of the report center, the Time-series output-quantity chart ...② is displayed.



- Selection of the period
One of the six periods shown below can be selected.

By department Time series output

Period: Current shift | From: 2020-01-09 | To: 2020-01-09

Factory: JUKI | Floor: 6F | Line: line1 | Machine: Please select

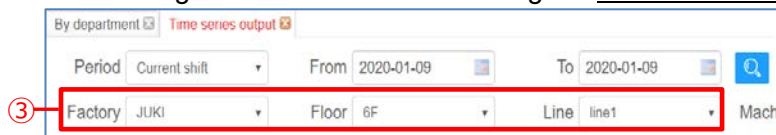
- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day
- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

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● Selection of the department

The following items can be selected using the Selection of the factory, floor and line ...③.



By department Time series output

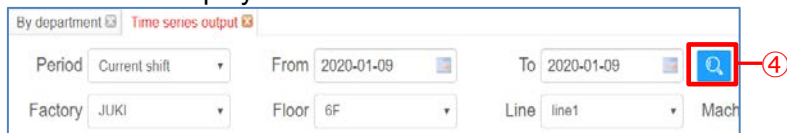
Period: Current shift (dropdown) From: 2020-01-09 (calendar icon) To: 2020-01-09 (calendar icon) [Search icon]

③ Factory: JUKI (dropdown) Floor: 6F (dropdown) Line: line1 (dropdown) Mach

- Time-series output-quantity chart on a factory-by-factory basis
Factory: Select the factory you want to display Floor: Not selected yet
Line: Not selected yet
* The total quantity of output of all of the lines in the factory you have selected is displayed in chronological order.
- Time-series output-quantity chart on a floor-by-floor basis
Factory: Select the factory you want to display Floor: Select the floor you want to display
Line: Not selected yet
* The total quantity of output of all of the lines on the floor you have selected is displayed in chronological order.
- Time-series output-quantity chart on a line-by-line basis
Factory: Select the factory you want to display Floor: Select the floor you want to display
Line: Select the line you want to display
* The quantity of output of the line you have selected is displayed in chronological order.

● Retrieval of the data

After you have selected the period and department, press the Search button ...④. Then, the data that meets the specified condition such as the period and department will be retrieved and displayed on a chart.



By department Time series output

Period: Current shift (dropdown) From: 2020-01-09 (calendar icon) To: 2020-01-09 (calendar icon) [Search icon] ④

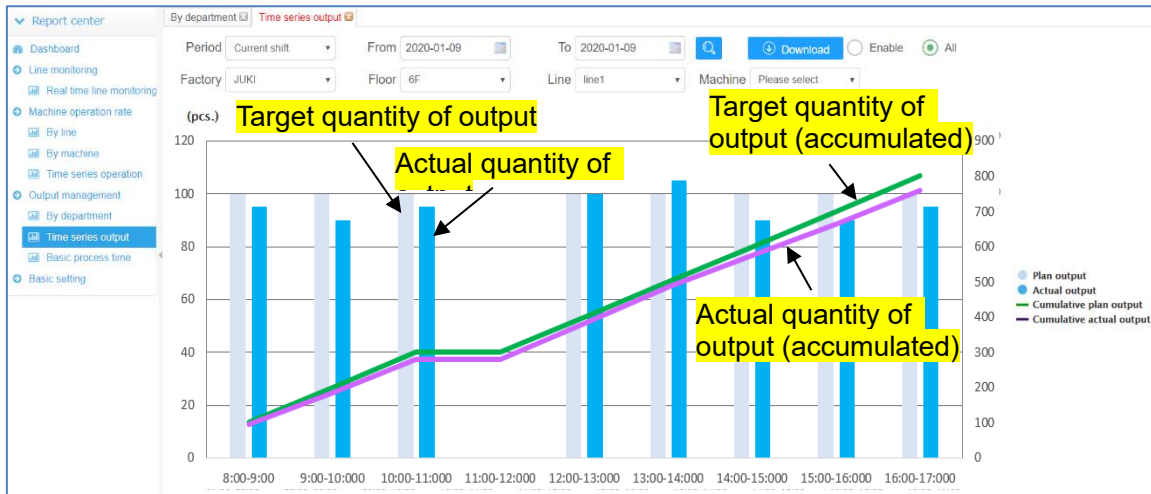
Factory: JUKI (dropdown) Floor: 6F (dropdown) Line: line1 (dropdown) Mach

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- Explanation of the items displayed on a chart

The quantity of output of the department you have selected is displayed on a bar chart, while putting quantity of output on the vertical axis and putting time or date on the horizontal axis.

* If the period you have selected is within 48 hours, time is put on the horizontal axis. If it is 48 hours or more, date is put on the horizontal axis.

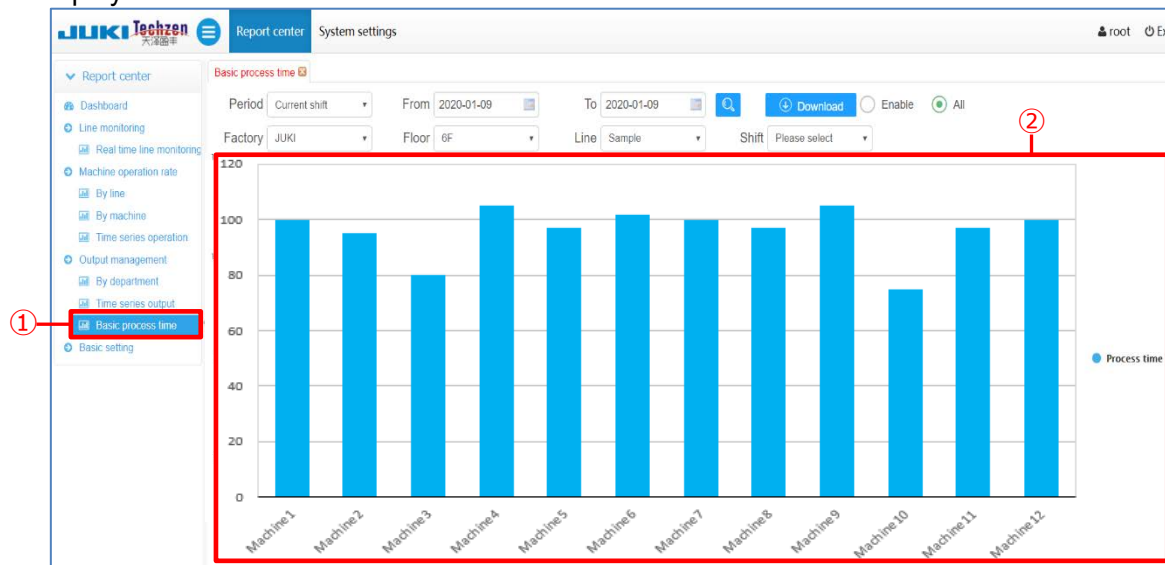


5. Net processing time chart

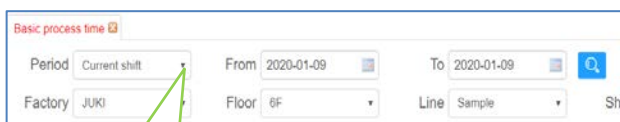
It is possible to check the net processing time by adding up the processing time of each process (each machine), eliminating statistically abnormal values and averaging only normal values.

Use this chart to help find bottleneck process(es) to balance among the sewing lines for increasing productivity of the line.

When you select the Management of output-quantity > Net processing time ...① of the report center, the Net processing time chart ...② for each process (each sewing machine) is displayed.



- Selection of the period
One of the six periods shown below can be selected.



- Current shift
- Today
- Yesterday
- Last 7 days
- Last 31 days
- Any

- * Current shift
- * Current day
- * Previous day
- * For the past 7 days
- * For the past 31 days
- * Arbitrary setting
- * The period is set by setting the starting date and the ending date.

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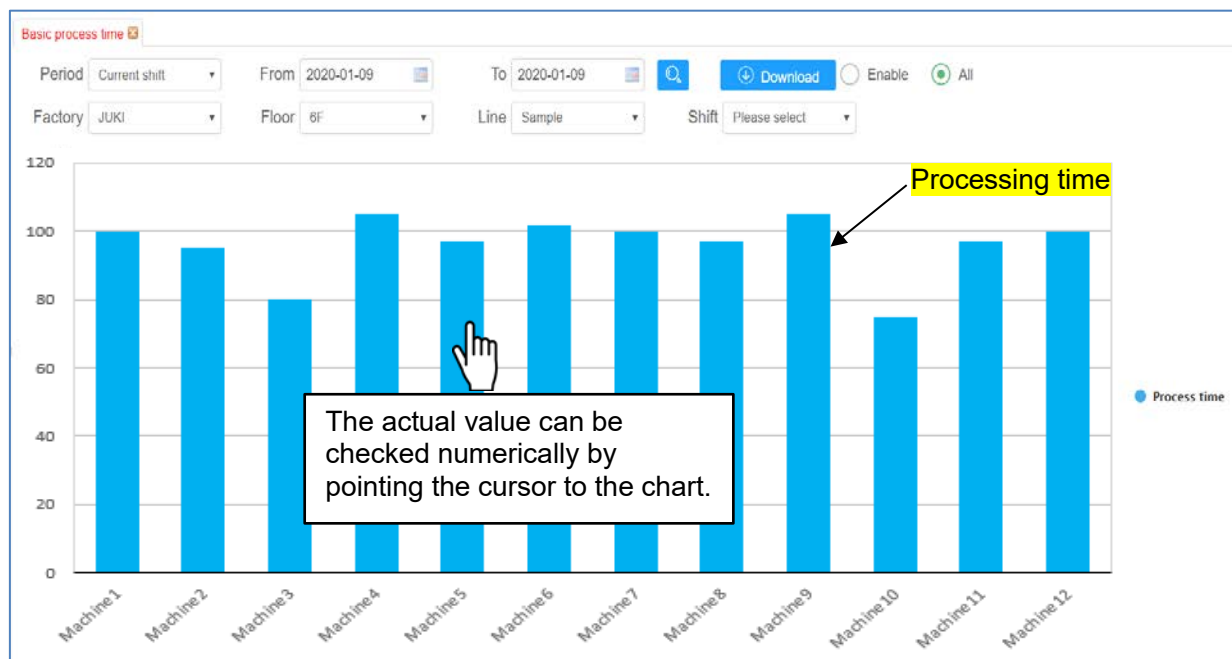
- Selection of the line
Select the line of which the processing time is to be displayed using the Selection of the factory, floor and line ...③.

The screenshot shows a form titled "Basic process time" with several input fields. A red box highlights the "Factory", "Floor", and "Line" dropdown menus. The "Factory" dropdown is set to "JUKI", "Floor" to "6F", and "Line" to "Sample". The "Period" dropdown is set to "Current shift", and the "From" and "To" date fields are both set to "2020-01-09". A search button with a magnifying glass icon is visible to the right of the date fields.

- Retrieval of the data
After you have selected the period and line, press the Search button ...④. Then, the data that meets the specified condition such as the period and line will be retrieved and displayed on a chart.

This screenshot is identical to the previous one, but a red box highlights the search button (magnifying glass icon) with a circled number 4 next to it.

- Explanation of the items displayed on a chart
The processing time of the line you have selected is displayed on a bar chart, while putting processing time on the vertical axis and putting process (machine) on the horizontal axis.



6. Output of CSV files

Events that have occurred by operating the sewing machine and that have occurred by operating the terminal are listed and displayed with the relevant time stamps on the screen. This list can be output to a CSV file.

6-1. Operation on the screen

When you select the Basic configuration > Data export ...①, the Event list ...② is displayed.

The screenshot shows the 'Data export' interface. On the left, a sidebar menu has 'Data export' highlighted with a red box and a circled '1'. The main area contains a search form with a date range from '2019-05-23 09:00' to '2019-05-23 17:45' (circled '3'), a search button (circled '5'), and a 'Download' button. Below the date range, there are dropdown menus for 'Factory' (JUKI, circled '4'), 'Floor' (6F), 'Line' (Sample), and 'Machine' (Please select). A table of event data is displayed below these filters, with a circled '2' pointing to the table header. The table has columns: Time stamp, Factory, Floor, Line name, Machine type, Machine name, Machine event, and Event. The data rows show events like 'MachineOnline' and 'ButtonIncreaseOutput'. At the bottom, there is a pagination control with a circled '6' pointing to the navigation arrows, a circled '7' pointing to the 'Page 1' indicator, and a circled '8' pointing to the 'Show row 20' dropdown.

Time stamp	Factory	Floor	Line name	Machine type	Machine name	Machine event	Event
2019-05-23 09:17:31	juki	test	Test Line1	NotJUKI	1001	MachineOnline	
2019-05-23 09:17:39	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	
2019-05-23 09:17:40	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	
2019-05-23 09:17:39	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	
2019-05-23 09:17:40	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	
2019-05-23 09:17:59	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	
2019-05-23 09:18:00	juki	test	Test Line1	NotJUKI	1001	ButtonIncreaseOutput	

- Selection of the period
Enter the event output retrieval period with the Start - End ...③.
- Narrowing-down of the target data for output of events
Narrow down the target data by specifying the Factory, floor, line and machine ...④.
*If they are not selected, all of the data will be subject to the event output without narrowing down.
- Retrieval of the data
After you have selected the period and the target data, press the Search button ...⑤.
Then, the data that meets the specified condition such as the period and target will be retrieved, and the Event list ...② will be displayed.

This is a close-up of the search filters. It shows the 'From' date as '2020-01-09 00:00' and the 'To' date as '2020-01-09 14:41'. The search button (circled '5') is highlighted. Below the date range, there are dropdown menus for 'Factory' (JUKI), 'Floor' (6F), 'Line' (Sample), and 'Machine' (Please select).

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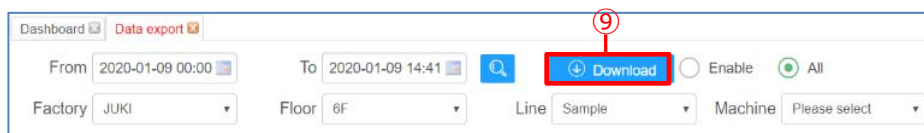
- How to check the event list

If the event list produced after the data retrieval is spread over multiple pages, the page can be changed over with the Page turning button ...⑥. It is also possible to directly jump to the target page by specifying the page number and pressing the Go button ...⑦. In addition, the Number of lines per page ...⑧ can be changed.



- How to output the CSV file

After you have retrieved the data by selecting the period and target data, press the Download button ...⑨. Then, the CSV data is output to the downloads folder.



6-2. Event list items

Event list

In the middle of inquiring with Techzen

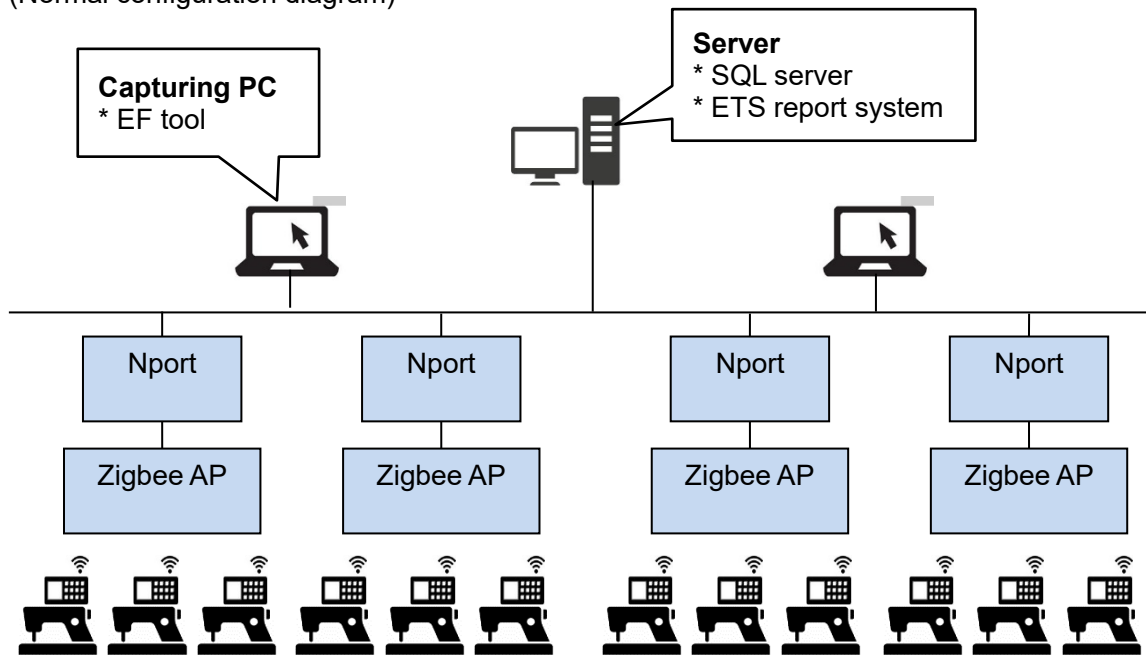
III. Restarting the server and management PC (for managers)

This section describes the steps of procedure for restarting the server and the capturing PC.

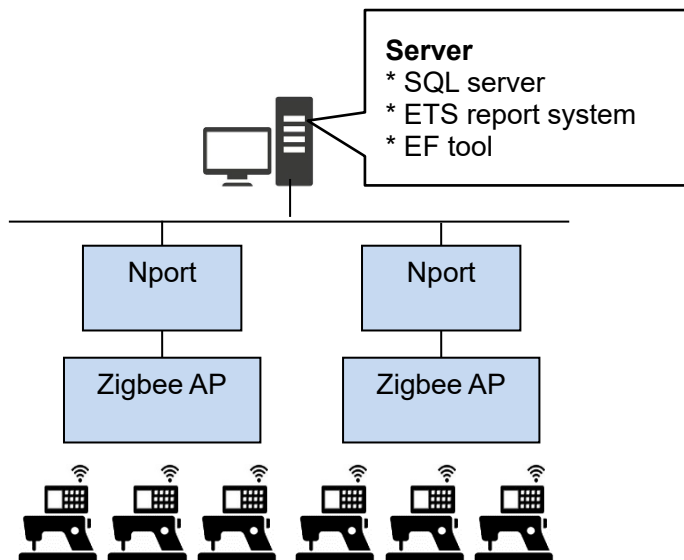
* For the normal use, continuously run the server, capturing PC, LAN network devices, Com ⇔ LAN converter (Nport), Zigbee ⇔ Com converter (Zigbee AP) for 24 hours without turning the power OFF.

1. System configuration

(Normal configuration diagram)



(Simplified configuration diagram)



2. Restarting the capturing PC

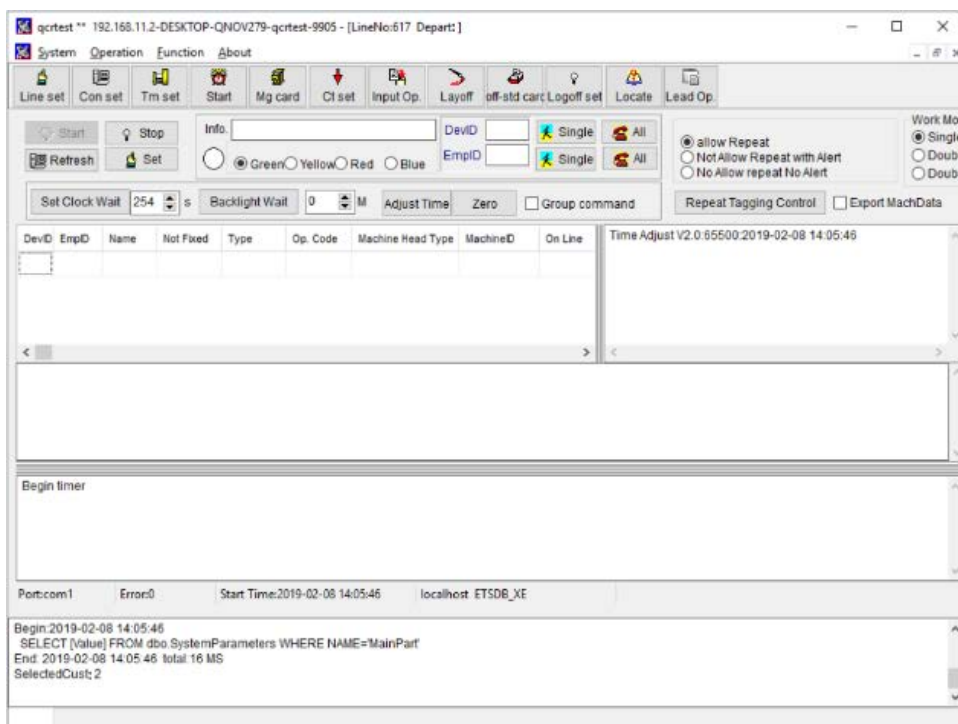
When you turn ON the power to the capturing PC, start the "EF tool" that has been installed on the PC.



* Click the shortcut icon to start the tool.

When the "EF tool " has normally started, the following screen is displayed.

* The "EF tool" must be started for each Zigbee ↔ Com converter (Zigbee access point). Click all of the EF tool shortcut icons on the desktop to start the EF tools.



3. Restarting the server

When you turn ON the power to the server, start the server application for the report system.

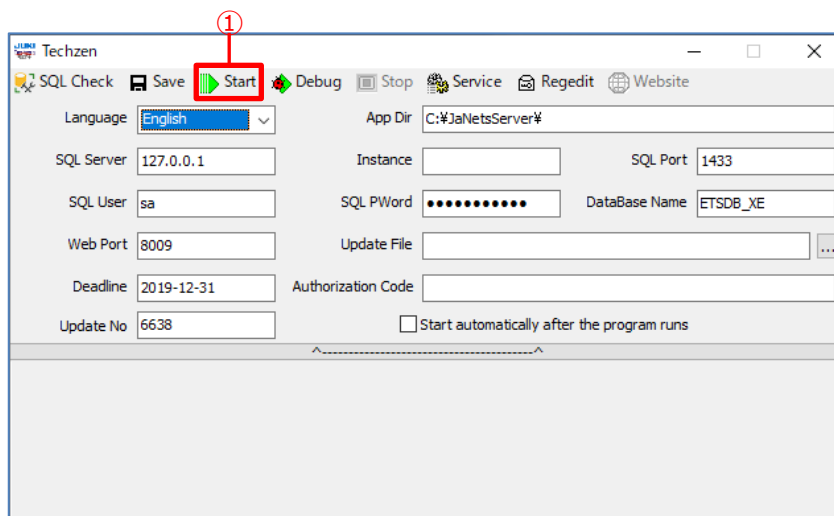
- * Double click the EtsTool.exe shortcut icon on the desktop to start the application.



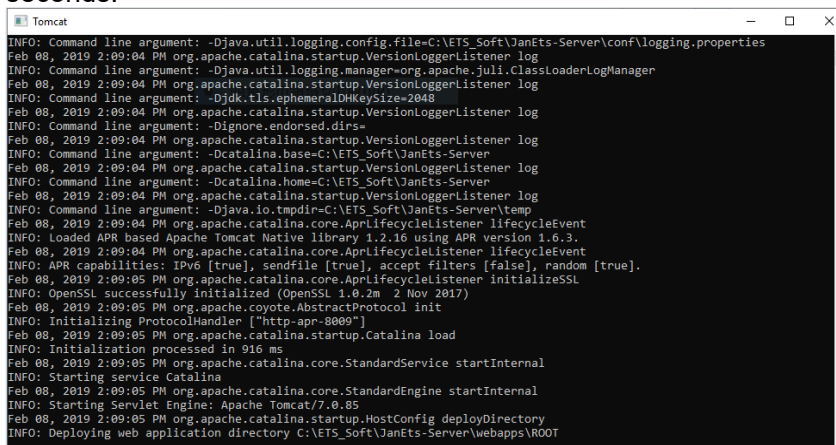
on the desktop to start the application.

The following window opens. Click the Start ... ① on the menu. The JaNets JT Simple system starts its operation.

- * Do not change the settings.



When the system starts its operation, the Dos prompt screen is displayed for a several seconds.



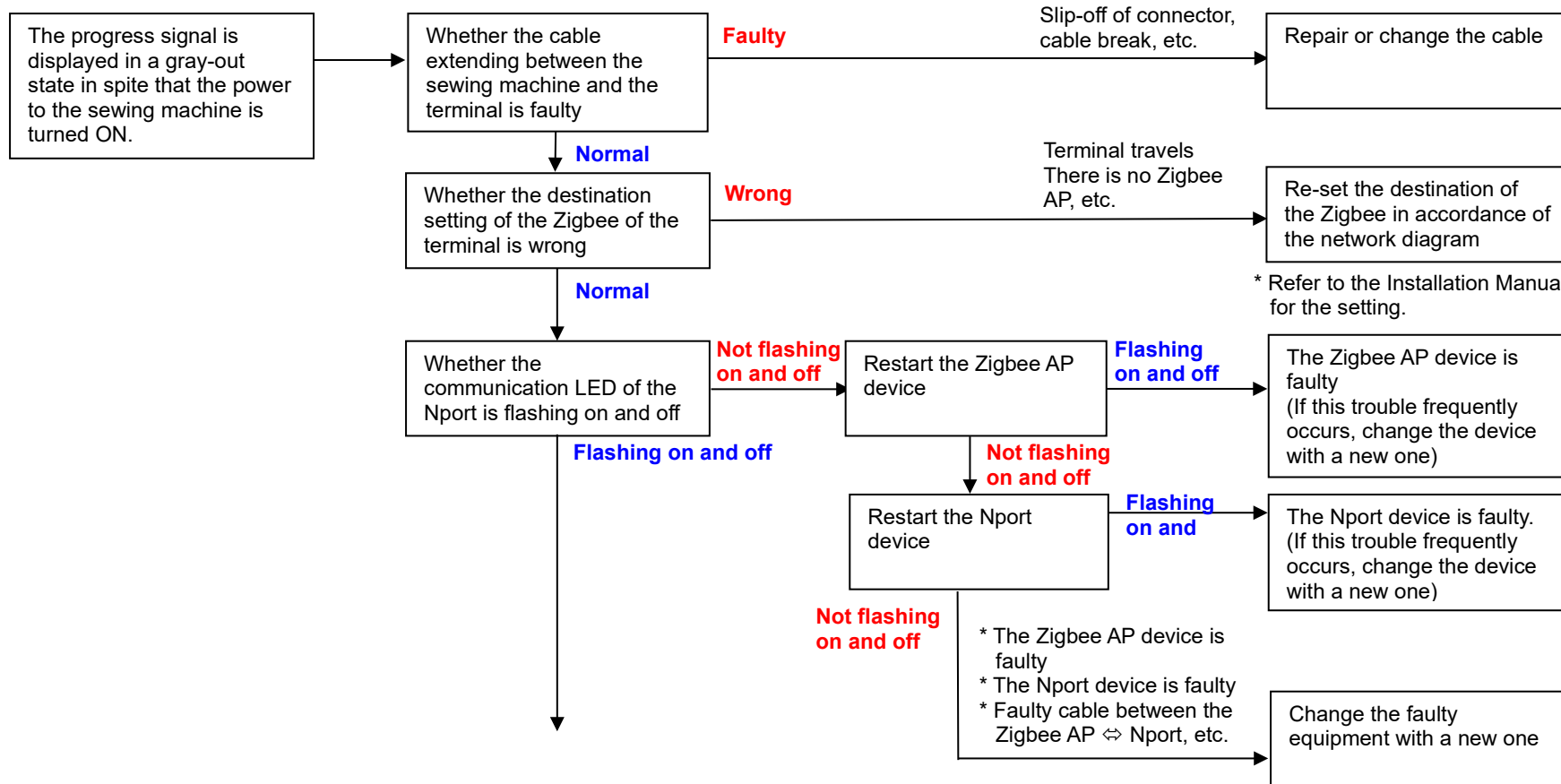
IV. Troubleshooting (for managers)

This section describes troubles that are likely to occur while the JaNets JT Simple system is in use, and how to cope with them.

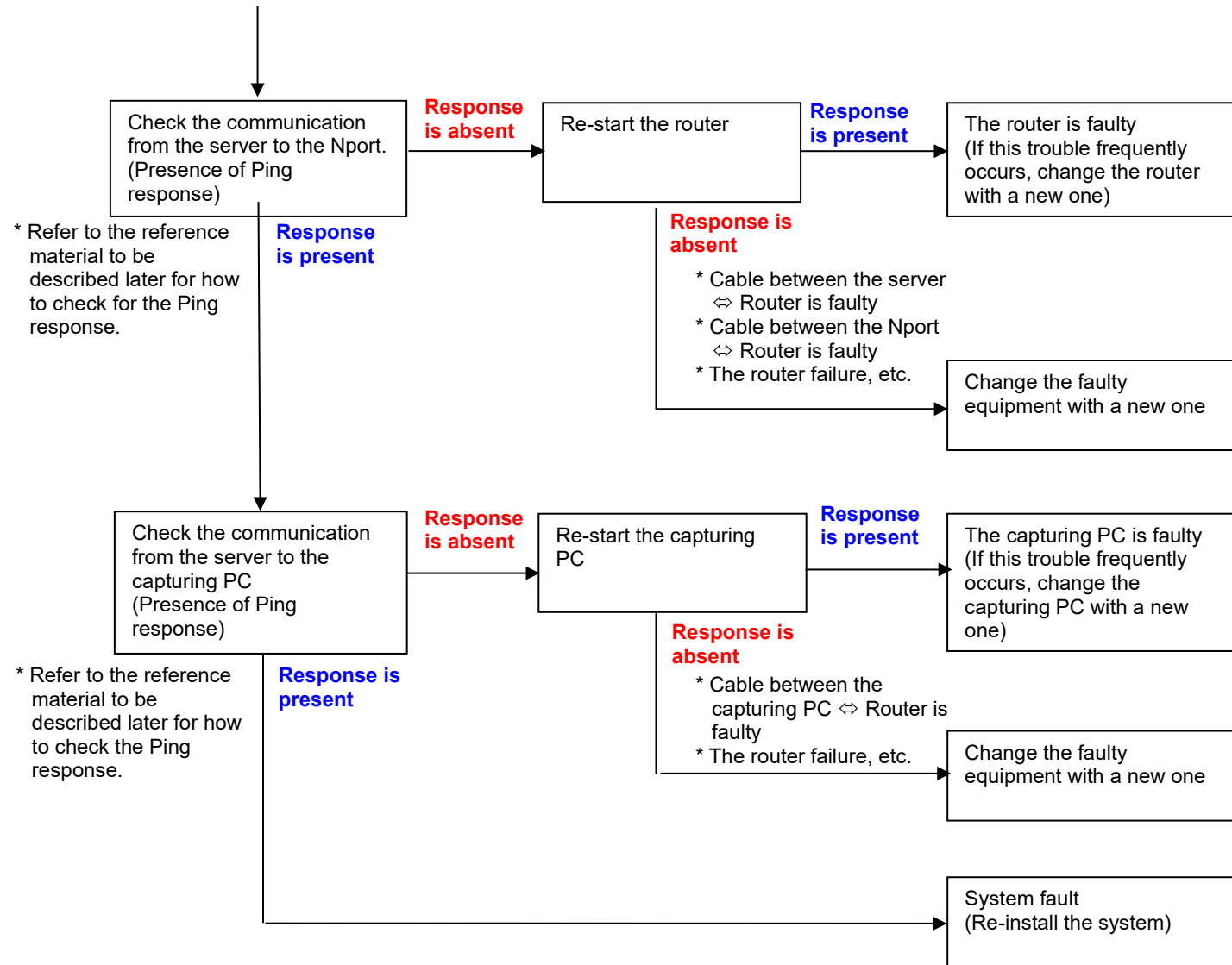
1. Trouble phenomena and causes / measures

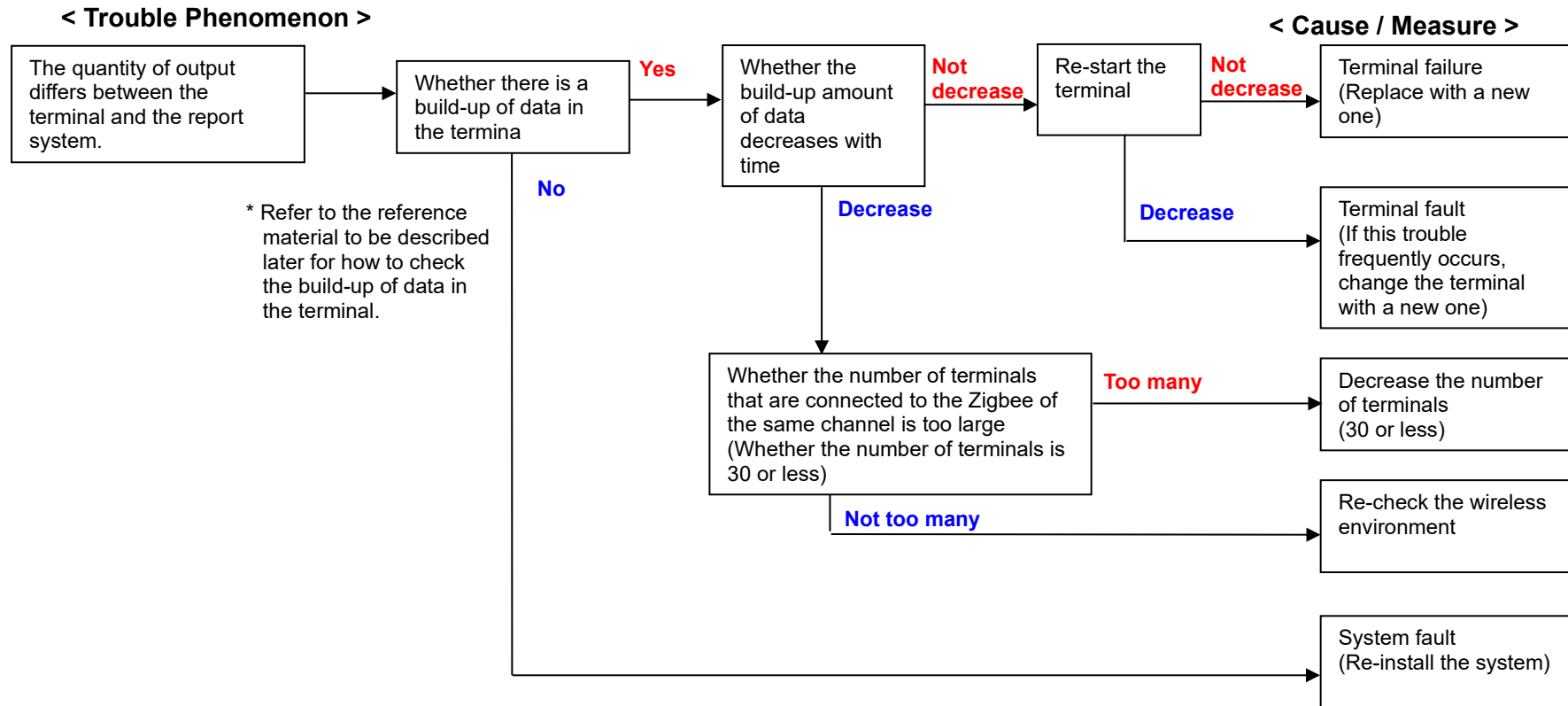
< Trouble phenomenon >

< Cause / measure >



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< Trouble Phenomenon >

The system fails to start up

Whether there is an available space in the hard disk

No

Whether the free-of-charge SQL server is used

Yes

Whether the amount of data has exceeded the capacity (10 MB)

Yes

No

No

< Cause / Measure >

* Install an additional hard disk
* Delete the data
(Ask JUKI for the deletion of data)

* Purchase the charged SQL server
* Delete the data
(Ask JUKI for the deletion of data)

System fault
(Re-install the system)

* Refer to the reference material to be described later for how to check the SQL server.

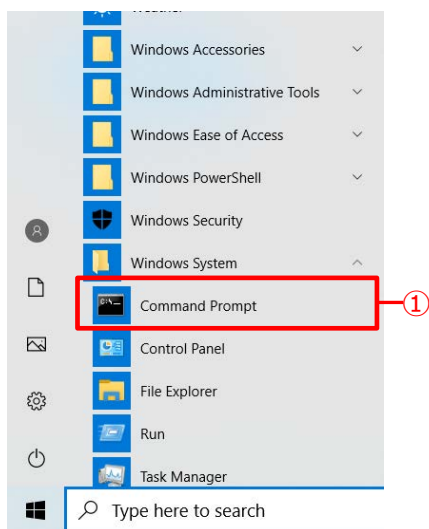
2. Reference materials

Reference 1: How to check the Ping response

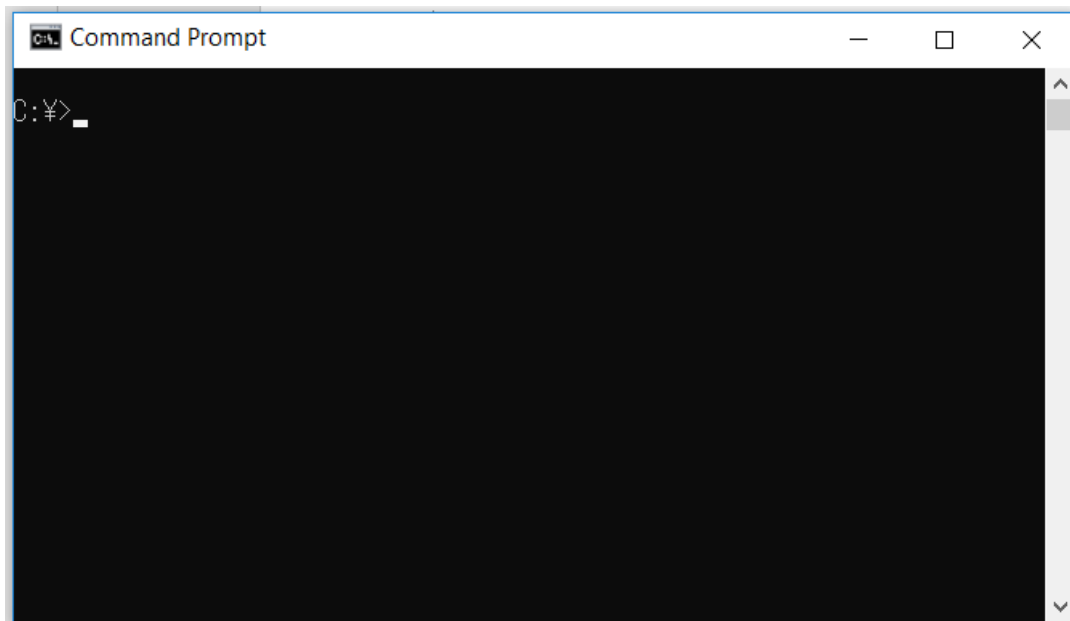
The networking devices of the server, capturing PC, router and Nport are respectively assigned with a unique IP address.

Arrange the networking devices to allow input of their IP addresses after they are networked.

Then, click the Windows system tool > Command prompt ...① to open the command prompt window.



Command prompt window



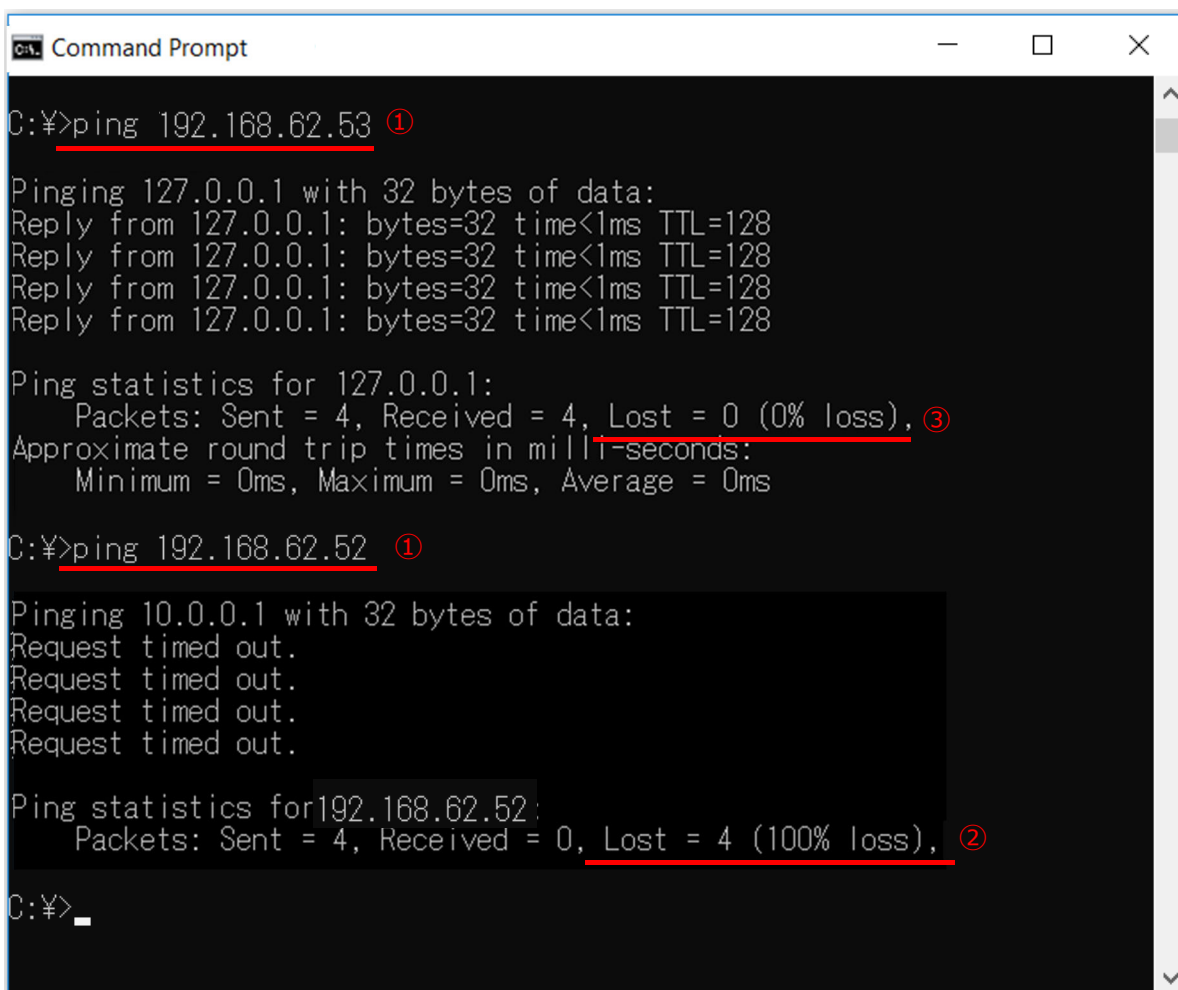
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Then, enter Ping xxx.xxx.xxx.xxx ...① and press the Enter key.
IP address

Then, Ping is sent to / received from the device IP address of which is entered as described above, and the result of communication is displayed.

In the case of successful communication: Loss = 0 (0-percent loss) ...② is displayed.

In the case of failed communication: Loss = 4 (100-percent loss) ...③ is displayed.



```
Command Prompt
C:\>ping 192.168.62.53 ①
Pinging 127.0.0.1 with 32 bytes of data:
Reply from 127.0.0.1: bytes=32 time<1ms TTL=128
Reply from 127.0.0.1: bytes=32 time<1ms TTL=128
Reply from 127.0.0.1: bytes=32 time<1ms TTL=128
Reply from 127.0.0.1: bytes=32 time<1ms TTL=128

Ping statistics for 127.0.0.1:
    Packets: Sent = 4, Received = 4, Lost = 0 (0% loss), ③
    Approximate round trip times in milli-seconds:
        Minimum = 0ms, Maximum = 0ms, Average = 0ms

C:\>ping 192.168.62.52 ①
Pinging 10.0.0.1 with 32 bytes of data:
Request timed out.
Request timed out.
Request timed out.
Request timed out.

Ping statistics for 192.168.62.52:
    Packets: Sent = 4, Received = 0, Lost = 4 (100% loss), ②

C:\>
```

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Reference 2: How to check the build-up of data in the terminal

The data build-up can be checked by pressing the "LOCK" key ...①.



The transmission status of the below-stated two kinds of data can be checked.

Tml data ... Operation data of the terminal, which is left unspent to the EF

Sew data ... Data acquired from the sewing machine, which is left unspent to the EF

```
1 Debug Mode
2 MCU RESET
Tml data : 00031
Sew data : 00053
```

Wait approximately 10 seconds before the screen returns to the normal screen.

* Check whether the data decreases with the passage of time by repeating the aforementioned procedure.

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Reference 3: How to check the SQL server

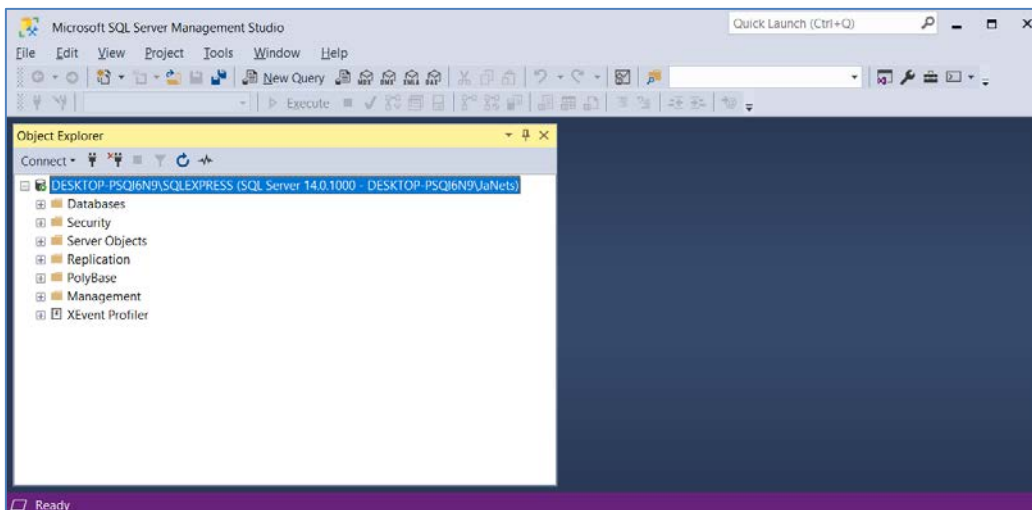
Various versions of SQL server are available. To check whether your SQL server is charged version or free-of-charge version, check the edition of your SQL server.

SQL server 2017 Standard or Express
Edition

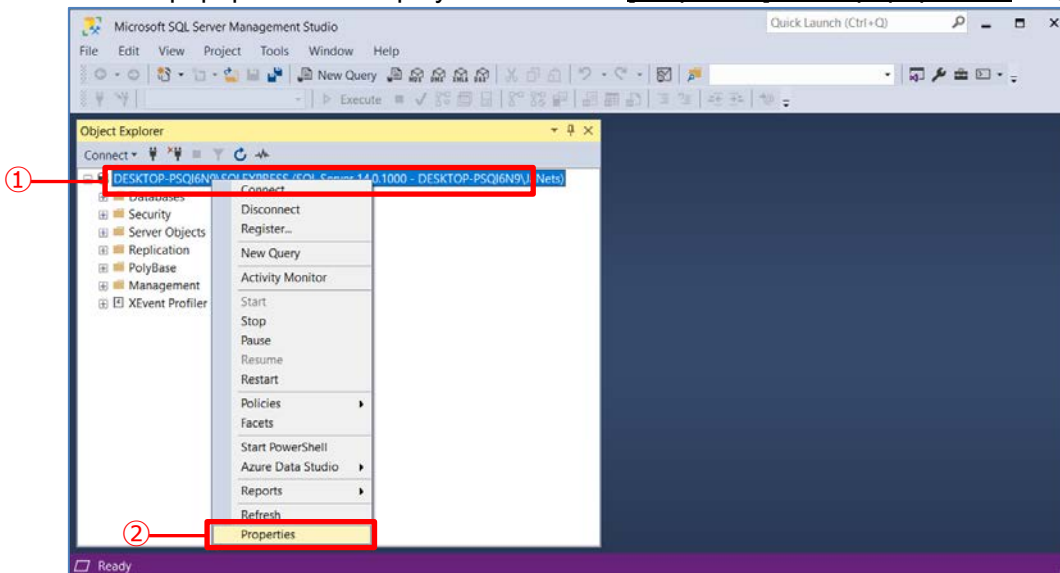
- * Standard: Charged version
- * Express: Free-of-charge version

(Checking procedure)

Start up the SQL Server Management Studio.



Select the Top of the "Object Explorer" ...① and click the right mouse button. Then, the popup menu is displayed. Select the [Properties] of the popup menu ...②.



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Then, the Server Properties dialog is displayed. Select the [General] from the [Page selection] area displayed at the left on the screen. The edition of SQL Server installed on your computer is displayed in the column of [Product] at the right display area on the screen.

