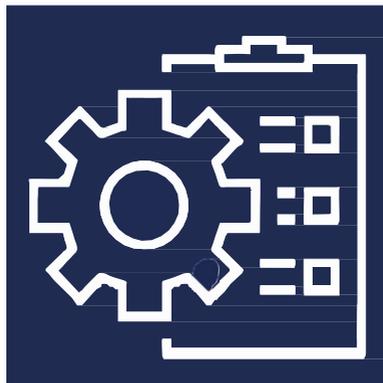
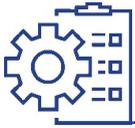


# NAVEKSA

## ShopFloor

- Effective production planning and overview
- Paperless production on a tablet or equal with full traceability
- Single screen cockpit with realtime information
- Digital production order on the operator cockpit includes drawings, comments, work instruction, material withdrawal with full traceability (lot- and serial number tracking)
- Digital QC reporting and management integrated in operator terminal (enhancement module)
- Ability to change order priority
- Automatic collection of data for calculations
- Time and attendance registration (enhanced module)



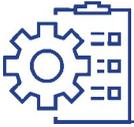


## Shopfloor - Index

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## Shopfloor – Installation and First time setup

1. Order a license key to be able to run app for production purposes by writing to .... Naveksa at [support@naveksa.com](mailto:support@naveksa.com)
2. If for a BC Cloud download the app from Microsoft AppSource.
3. <https://appsource.microsoft.com/da/marketplace/apps?search=naveksa&page=1>  
You can get it here clicking the Free trial button:
4. If for an On-premise go to our Help center and download the app.
  - a. <https://www.dropbox.com/home/NAVEKSA%20TEAM/Teknik/Software/Releases/2023/Shopfloor>
  - b. Installation is done by the common PowerShell commands exactly like any other BC App.

Nb. Please notice you must create yourself as a user, or sign into our Help Center ..... before you can download.

5. Insert the license key in the Shopfloor setup display.
6. Run the Setup wizard or go straight to the First-time setup display.
  - a. Run Setup Web Service
  - b. Run Setup Default Headings
  - c. Run Default messages.
  - d. Make sure the following job q entries are up and running.

Status	User ID	Object Type to Run	Object ID to Run	Object Caption to Run	Description
→ Ready	JKCBC	Report	1511	Delegate Approval Requests	Oprettet
Ready	JKCBC	Codeunit	6700	O365 Sync. Management	Oprettet
Ready	BEKBC	Codeunit	1350	Telemetry Management	
Ready	BEKBC	Codeunit	6170493	NAVEKSA SFS - Automatic Post	NAVEKSA
Ready	BEKBC	Codeunit	6170516	NAVEKSA SFS - DLS Clean Up	NAVEKSA
Ready	BEKBC	Codeunit	6170520	NAVEKSA SFS PORL Update	NAVEKSA

You are ready to go Use the detailed manual to find out how it works.



## Shopfloor – Introduction

The solution consists of 2 parts:

- A planning used by the production planner which deals with material shortages, sequence of orders, re-scheduling resources and capacity load and queue control.
- An execution part used by the shop floor operator which deals with time and attendance, starting and completing jobs, qc reporting etc.

Naveksa Shopfloor has two roles available in Business Central

Display Name
NAVEKSA MakeToOrder
NAVEKSA ItemPlanning Adm
NAVEKSA ItemPlanning User
Company Hub
NAVEKSA CadConnect Adm
NAVEKSA CadConnect User
→ <b>NAVEKSA ShopFloor Adm</b>
NAVEKSA ShopFloor User

- ShopFloor Adm has permission to make setup and various changes
- ShopFloor User is intended for the daily user, production planner and production employee

Each role contains a various number of menus to help the user.

CRONUS Danmark A/S | Production Orders ▾ BC Journals ▾ ShopFloor Journals ▾ | ☰

ShopFloor - Planning Released Production Orders

CRONUS Danmark A/S | Production Orders ▾ BC Journals ▾ ShopFloor Journals ▾ Product Design ▾ Capacities ▾ Setup ▾ | ☰

ShopFloor - Planning ShopFloor - Prod. Res.



## Shopfloor – General information

The Shopfloor system is based on simple principles- a prioritized sequence of the production orders process steps presented in 3 different logical sections:

ORDERS RUNNING, ORDERS QUEING and FUTURE ORDERS. The 3 sections can be shown per resource, work center or even factory total.

- ORDERS RUNNING (Processing) are being worked on at the moment.
- QUEING ORDERS (Waiting) has been completed by the previous job step and is now ready to be processed at the next job step.
- FUTURE ORDERS (Arriving) are orders which are being worked on somewhere in the factory and will show up at this workplace later.





## Shopfloor – How to use for production planner

Start up screen in BC

CRONUS Danmark A/S | Production Orders | BC Accounts | ShopFloor Journals | Product Design | Capabilities | Setup

ShopFloor - Planning | ShopFloor - Prod. Res.

### Want to learn more about NAVEXSA ShopFloor?

Activities

- Production Orders
  - Planned Production Orders: 0
  - First Planned Production Orders: 0
  - Released Production Orders: 87
- Operations
  - Prod. Orders Released: 34
  - Prod. Orders in Progress: 11

Insights

My Job Queue | My Items

You start the ShopFloor Planning by selecting the menu item. You will be presented to a list to choose what workcenter or resource you want to work with.

Code T	Name	Type T	Work Center Group Code	Work Center No.
1	Lagerafdeling	Work Center Group		
2	Produktionsafdeling	Work Center Group		
100	Samleafdeling	Work Center	1	
200	Pakkeafdeling	Work Center	1	
300	Malerafdeling	Work Center	2	
400	Maskinafdeling	Work Center	2	
110	Jesper Raebild	Machine Center		100
120	Daniel Goldschmidt	Machine Center		100
130	Anders Riis	Machine Center		100
210	Pakkebord 1	Machine Center		200
220	Pakkebord 2	Machine Center		200
230	Pakkemaskine	Machine Center		200
310	Malekabine	Machine Center		300
320	Malerobot	Machine Center		300
330	Terrekbine	Machine Center		300
340	Inspektion af maling	Machine Center		300
410	Boremaskine	Machine Center		400
420	CNC-maskine	Machine Center		400
430	Maskinafgraving	Machine Center		400
440	Maskininspektion	Machine Center		400

The entry point is a list of work center groups, work centers and resources according to the setup in standard BC:

A resource /machine center belongs to a work center, and a work center belongs to a work center group.



## Shopfloor – How to use for production planner

### The Planner Cockpit

NAVEKSA SPS PLAN.SHOP.WRK.LIST1 WORK DATE: 27-01-2022

Work Center - 100

General

Code: 100 Prod.order:   
Name: Samleafdeling

Running

ORDERS RUNNING

Total time: Setup 15 / Rum 240

Routing Progress	Started	Prod. Order No. T	Item No.	Description	Operation No. T	Op. Description	Cap. %	Quantity	Quantity Ready	Quantity Completed	Prod. Order Start	Prod. Order Due	Capacity Date
→ +	STARTED	1011003	1000	Cykel	20	Kædesamling	0,2	16	0	0	26-01-2022	29-01-2022	27-01-2022

Waiting

ORDERS READY HERE

Total time: Setup 220 / Rum 312

Routing Progress	Prod. Order No. T	Item No.	Description	Operation No. T	Op. Description	Cap. %	Quantity	Quantity Ready	Quantity Completed	Prod. Order Start	Prod. Order Due	Capacity Date	Operation Start Date Time
+	1011003	1000	Cykel	10	Fælg med diale	---	16	0	0	26-01-2022	29-01-2022	26-01-2022	26-01-2022 14:5
→ +	1011004	1000	Cykel	10	Fælg med diale	0,2	10	0	0	27-01-2022	29-01-2022	27-01-2022	27-01-2022 12:2

Arriving

ORDERS COMING HERE

Total time: Setup 55 / Rum 878

Routing Progress	Prod. Order No. T	Item No.	Description	Operation No. T	Op. Description	Cap. %	Quantity	Quantity Ready	Quantity Completed	Prod. Order Start	Prod. Order Due	Capacity Date	Operation Start Date Time
→ +	1011003	1000	Cykel	30	Indlæg samling	0,4	16	0	0	26-01-2022	29-01-2022	26-01-2022	26-01-2022 09:1
+	1011003	1000	Cykel	40	Kontrol	0,2	16	0	0	26-01-2022	29-01-2022	28-01-2022	28-01-2022 0:1
+	1011004	1000	Cykel	20	Kædesamling	0,3	10	0	0	27-01-2022	29-01-2022	28-01-2022	28-01-2022 0:1
+	1011004	1000	Cykel	30	Endelig samling	0,4	10	0	0	27-01-2022	29-01-2022	28-01-2022	28-01-2022 1:2

For a resource, work center, or work center group, the screen shows the total workload at different status – Running (In process), Queuing (Waiting) or Future (Arriving) orders.

Orders processing are orders where start activity has been reported.

Waiting (Queuing) orders are orders waiting to be processed at this resource. Queuing orders means that all previous operation steps have been finished.

Arriving (Future) orders are orders that may currently be in process elsewhere in the factory, but at a time they will arrive at this resource.

For information of family/bundled orders please visit the manual at [www.naveksa.com](http://www.naveksa.com)



## Shopfloor – How to use for production planner

### Tooltips

When you click on a line the tooltip menu will vary depending upon various attached information to the order/operation line you click at.

The screenshot displays the 'Dynamics 365 Business Central' interface. The main window shows a 'Work Center - 100' with a 'Running' status. A table titled 'ORDERS RUNNING' is visible, showing production orders with columns for Prod. Order No. 1, Status, Item No., Description, Operation No. 1, Op. Description, Cap. %, Quantity, Quantity Ready, and Quantity Completed. A tooltip menu is open on the left, listing options: Attributes, Show prod.order, BOM, Routing, Drawings, Priority, New Note, Reprint Barcode labels, ItemPlanning - Item, ItemPlanning - BOM, and ItemPlanning - Prod.order.

Prod. Order No. 1	Status	Item No.	Description	Operation No. 1	Op. Description	Cap. %	Quantity	Quantity Ready	Quantity Completed
100047	Released	i-TECH-16	NAV demo item	0010	Assembly	3,259	90	0	0
STARTED 100153	Released	SP107	Play ruck elevation	01000	Made complete	3,259	3	2	0
STARTED 100176	Released	MT-iCSW	Coated Steel Wire	10	Unspooling	3,259	600	0	0
STARTED 100260	Released	FK-71 LGT	LOT controlled item	03000	Pre-assembly	3,259	0	3	0
STARTED 100263	Released	FK-72	Lot produced item	10	Assembly	3,259	0	2	0
STARTED 100269	Released	FK-72	Lot produced item	10	Assembly	3,259	2	0	0

The are tooltips for the following information. Attributes = Clicking on this will give the option to view or edit the operations attributes

- Show prod.order = Clicking this will show Production order for selected line
- BOM = Clicking on this opens up the standard BC / NAV Production BOM editable bill of material display
- Routing = Clicking on this opens up the standard BC / NAV Routing editable display
- Drawings = Clicking on this will show the first drawing (only) attached to this production order
- Priority = Opens up the display for changing execution sequence for the product on order
- New Note = Opens the main card for the Prod.order and you can write new comments
- Reprint Barcode labels = Print labels for the Prod.order
- ItemPlanning = Clicking on this opens 3 possibilities looking at the inventory profile for the item, Production order or the bill of material.

**For more information about the columns and content please visit the manual at [navexsa.com](http://navexsa.com)**



## Shopfloor - How to use for production employees

Orders released in BC will be displayed in the Naveksa Shopfloor cockpit

The screenshot shows the 'SHOP WORK LIST' for the 'Assembly department'. It features a search bar with filters for 'Status', 'Start Multiple Lines', 'Prod. Order No.', 'Item No.', 'Description', 'Customer Order', 'Machine Ch.', 'Operation No.', 'Op. Description', 'Quantity', 'Quantity ready', 'Quantity completed', 'Due Date', 'Capacity Date', 'Previous Operation No.', 'Next Operation No.', 'Priority', and 'Setup Time'. The table lists several work orders, with the first one (100) highlighted in blue. On the right side, there are buttons for 'START JOB', 'STOPJOB', 'START', 'STOP', 'DRAWINGS', 'PRINT BOM', 'PRINT ROUTE', 'PRINT JOB', 'CHECK BOM', 'CHECK ROUTE', 'CHECK JOB', 'CLOCK IN', 'CLOCK OUT', and 'OK'.

Choose the resource (machine) you want to use in the field SHOP WORK LIST ie 100. A list of resources with 100 will appear and you must choose the actual.

- If no other information given, click on the first line in the field Waiting.

The line turns blue and some of the function buttons in the right side turns blue. By pressing the BOM/ Route-button the BOM/Route will be shown. If Drawings attached to the product the button will turn blue and the drawing can be inspected.

Depending on the setup you can either issue the materials automatically or manually. For companies using lot number for raw materials, manual withdrawal is recommended until you are full up running.

To start the job, press the function button START JOB and you will be directed to the screen below

The dialog box 'You have started the job' contains the following fields and options:

- Production Order No.: 101037
- Prod. res.: [input field] Choose prod. res.
- Operation No.: 30
- Starting Date: 10-11-2015
- Starting Time: 12:37:06
- Print Job Tag:  Yes  No
- Buttons: OK, Cancel

Press Choose prod resource, select your employee no and press OK



The production order will move to the Orders Processing window and get a green status number

Status	Start	Multiple Lines	Prod. Order No.	Item No.	Prod. Res.	Description	Customer Order	Prod. Res. Type	Machine Ct.	Operation No.	Ct.	Description	Quantity	Finished	Quantity ready	Quantity completed	Send-Ahead Quantity	Due Date	Capacity Date	Previous Op
<span style="color: green;">■</span>		<input type="checkbox"/>	101037	1000	130	Cycl		Job.Center	100	30		Endstop sampling	3	0%	3	0	0	04-02-2016	03-02-2016	20

Once the job has been completed, it has to be reported as completed. (Dependent of the set up, you might be asked to issue material, before the job can be completed – if no material has been issued, the key “Issue material” is highlighted dark blue).

## Outputting a single job

Mark the concerned line and select “Output” on the main screen. Subsequently the following window will pop up:

Stop job

Item No.	Starting Date	Starting Time	Prod. Res.
M-32	11-07-2016	1305:49	130

Production Order No.	Item No.	Item description	Output Quantity	Scrap Quantity	Status	End time
101028	M-32	Finished Item j-1 product	0	0		15:30:23

7	8	9	Prod. Res.	130
4	5	6	Output Quantity	0
1	2	3	Single operation	All operations
0	.	Delete	<input type="radio"/> Setup	Setup
			<input type="radio"/> Part quantity	Part quantity
			<input type="radio"/> Pause	Pause all
			<input type="radio"/> End operation	End all operations

Choose Location/Bin   Print pallet label   Scrp   OK   Cancel

There is now an opportunity to carry out individual reporting as completed on the single lines, or, during all operations to mark, that the following reportings have to be made:

- Set up- for setup of equipment.
- Partial output- only a part of the production order is finished
- Pause- i.e. a lunch break
- End operation- the production order is finished; no more items will be produced on this order. Fill in the numbers of good items and scrapped items and press OK and the data is transferred to BC.

There is a number of extra features that can be used, please visit the manual on Naveksa.com for more information of:

Lot and serial numbers, Location/BIN, Quality Assurance & Control, Time and Attendance, please visit the manual at [www.naveksa.com](http://www.naveksa.com)



## Shopfloor – Extra benefits and Functions

**Lot and serial numbers**

**QR/Barcodes for resources (men and machine), raw materials Priority of released production orders**

**Capacity load**

**Quality control module**

**Bundled production.**

**Multi operator/ multi tasks**

**Job assignment to operators**

**Time and attendance module**

**For more information, please visit the manual at [www.naveksa.com](http://www.naveksa.com)**



## Shopfloor - License renewal.

1. Order a license key to be able to run app for production purposes by writing to .... Naveksa at [support@naveksa.com](mailto:support@naveksa.com)
2. Go to BC and open the ShopFloor Setup.
3. Insert the new license key in the Shopfloor setup.
4. You are ready to go.

## Shopfloor – Version update.

1. If for a BC Cloud the update follows the normal Rules for BC Cloud installation. If you need to download the app from Microsoft AppSource, you can get it here clicking the Free trial button:

<https://appsource.microsoft.com/da/marketplace/apps?search=naveksa&page=1>

2. If for an On-premises go to our Help center and download the app.
  - a. <https://www.dropbox.com/home/NAVEKSA%20TEAM/Teknik/Software/Releases/2023/Shopfloor>
  - b. Installation and update is done by the common PowerShell commands exactly like any other BC App.

Nb. Please notice you must create yourself as a user, or sign into our Help desk before you can download.

3. Go to the ShopFloor setup and check for new set up parameters if any mentioned in the release notes.
4. You are ready to go.