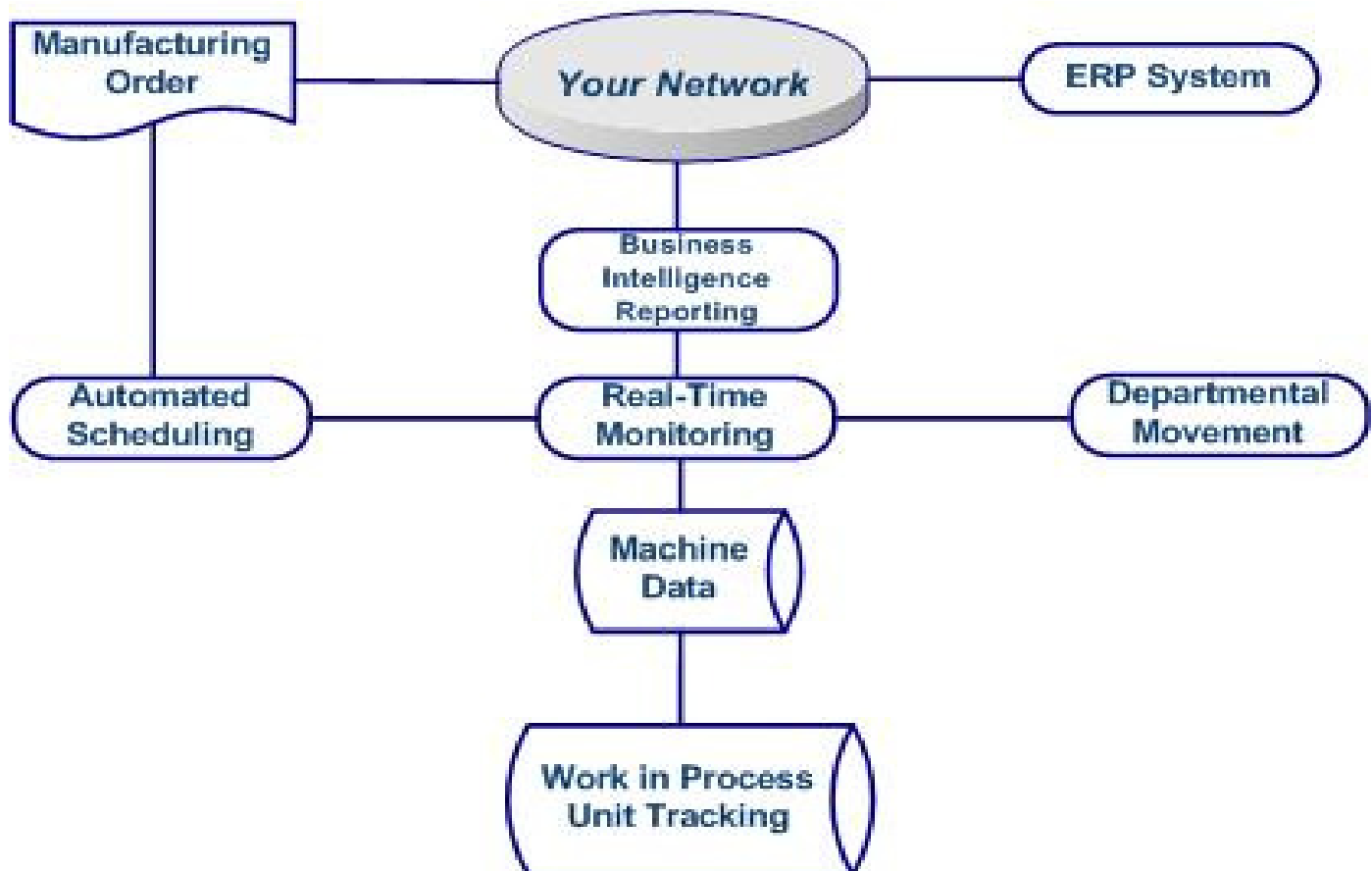


PrintTrac

Real-Time Printing Automated Production Scheduling & Plant Floor Monitoring and Control System

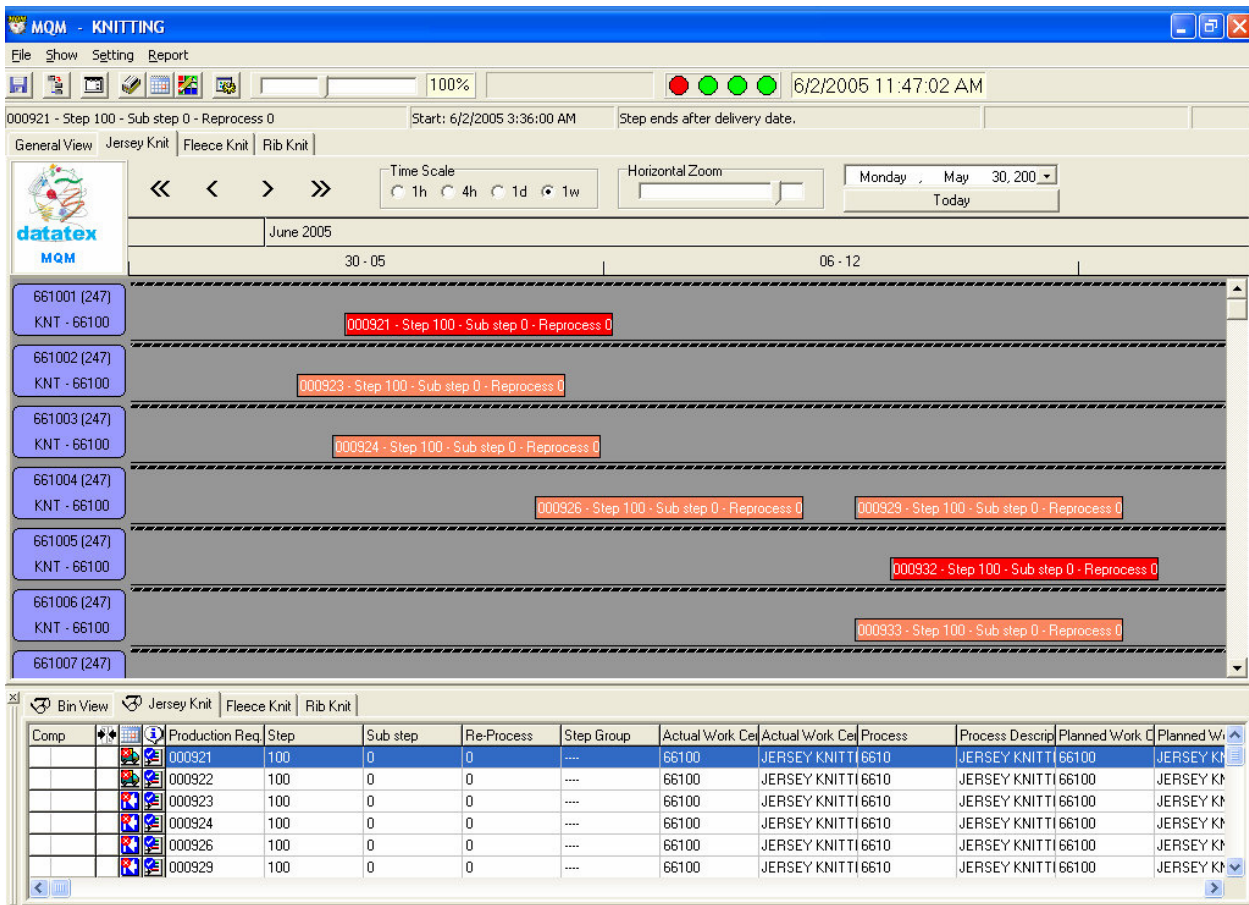


PrintTrac features:

- ❖ **Integrated Automated Production Scheduling**
 - *Linked to ERP - Customer/Production Orders*
- ❖ **Dash Board Information Management**
 - *Graphical Presentation and On-Line Reports*
- ❖ **Real-Time Machine Monitoring**
 - *Set-up, Down-Time, Run-Time, Prints, QC*
- ❖ **Touch Screen Operator Controls**
 - *Encased CPU for Harsh Environments*
- ❖ **Supervisor Control Terminal**
 - *View the Entire Status of Floor on One Screen*
- ❖ **Work-in-Process Unit Tracking and Reporting**
 - *Links to Scheduling System*
- ❖ **Quality Control Reporting**
 - *Reports by Order, Machine, Operator, Type*
- ❖ **Process Time Reporting**
 - *Operator, Machine, Order, Shift, Day, Week etc.*
- ❖ **Labor Costing Analysis**
 - *Operator, Machine, Order, Shift, Day, Week etc.*
- ❖ **Departmental Order Visibility Management**
 - *Printing, Packaging, Shipping*
- ❖ **Bar Code Scanning**
 - *Mfg. Orders, Movement Tickets, Badges etc.*
- ❖ **Internet Transmitted Reporting**
 - *Links Management to Off-shore Facilities*

PrintTrac

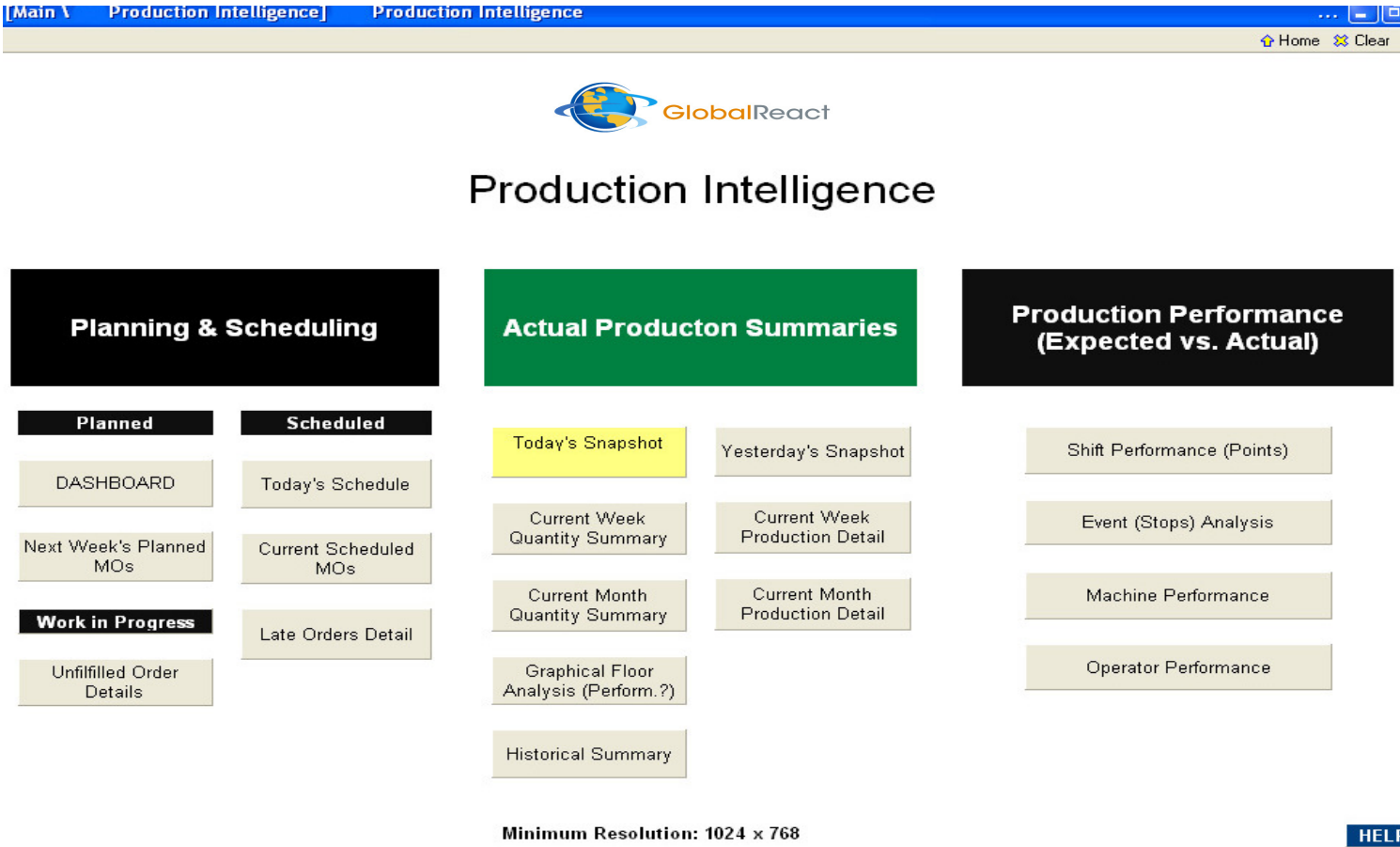
❖ Integrated Automated Production Scheduling



Gantt based schedule control and optimization with drag and drop order to machine processing. The system is fast and easy to use and control and is the production scheduling is directly connected to the plant floor monitoring and work-in-process tracking applications and updated automatically.

PrintTrac

❖ Dash Board Information Management



The screenshot shows a web browser window titled "Production Intelligence". The page features the GlobalReact logo and the title "Production Intelligence". The dashboard is organized into three main columns:

- Planning & Scheduling:**
 - Planned:** DASHBOARD, Next Week's Planned MOs
 - Scheduled:** Today's Schedule, Current Scheduled MOs, Late Orders Detail
 - Work in Progress:** Unfilled Order Details
- Actual Producton Summaries:**
 - Today's Snapshot, Yesterday's Snapshot
 - Current Week Quantity Summary, Current Week Production Detail
 - Current Month Quantity Summary, Current Month Production Detail
 - Graphical Floor Analysis (Perform.?)
 - Historical Summary
- Production Performance (Expected vs. Actual):**
 - Shift Performance (Points)
 - Event (Stops) Analysis
 - Machine Performance
 - Operator Performance

At the bottom, it specifies "Minimum Resolution: 1024 x 768" and includes a "HELP" button.

Production Intelligence reporting is an on-line dash board reporting system with the ability to drill down into the details on any given report and export the information to other applications like Excel. The Intelligence module can also incorporate information from other systems and spreadsheets into the dash board information system.

PrintTrac

❖ Dash Board Information Management

[Main \ Production Intelligence] PS_Next Week MOs

Sep.05 | Week 36-2005
Home Clear

HOME
Next Week's Planned Manufacturing Orders

HELP

Available Drills: **Machine / Step / Code**

	Manufacturing Orders Planned	Planned Qty (End Date)	Planned Setup Time (End Date)	Planned Execution Time (End)	Planned Start Date	Planned End Date
1	392272	13,615	27	1,238	9/8/2005	9/8/2005
2	391618	9,691	82	1,057	9/9/2005	9/9/2005
3	391206	7,882	76	860	9/9/2005	9/9/2005
4	389596	1,886	60	189	9/6/2005	9/6/2005
5	389597	1,872	60	187	9/6/2005	9/6/2005
6	389347	1,836	60	184	9/6/2005	9/6/2005
7	389349	1,836	55	184	9/6/2005	9/6/2005
8	389351	1,836	65	184	9/6/2005	9/6/2005
9	389350	1,836	71	200	9/6/2005	9/6/2005
10	389348	1,836	60	184	9/6/2005	9/6/2005
11	389346	1,836	55	184	9/6/2005	9/6/2005
12	390254	1,155	65	116	9/9/2005	9/9/2005
13	385949	864	109	102	9/8/2005	9/8/2005
14	390255	647	49	65	9/9/2005	9/9/2005
15	390256	565	60	57	9/9/2005	9/9/2005
16	392018	12	65	2	9/6/2005	9/6/2005
17	392323	6	16	1	9/7/2005	9/7/2005
18	392330	5	180	2	9/9/2005	9/9/2005
19	392167	5			9/9/2005	9/9/2005
20	392194	4			9/9/2005	9/9/2005
21	391508	3	65	0	9/6/2005	9/6/2005
22	392111	3			9/9/2005	9/9/2005
23	392153	3			9/8/2005	9/8/2005
TOTAL			1,282	4,992		

This page is to assist in the planning process by displaying MOs that are planned to end next week.

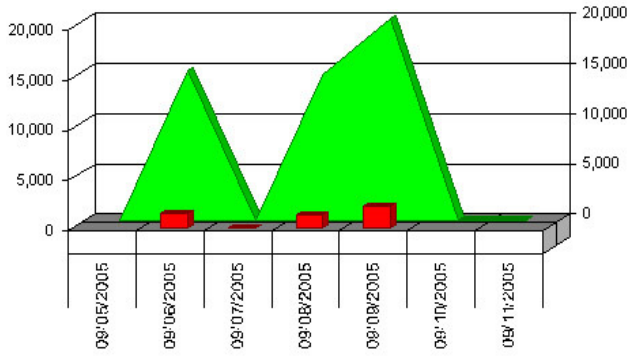
1. Next Week is selected by default
2. Users can drill down from MO to the planned machine, step, and code in order to display further detail of the pending orders

■

Planned Execution Time (min)

■

Planned Quantity



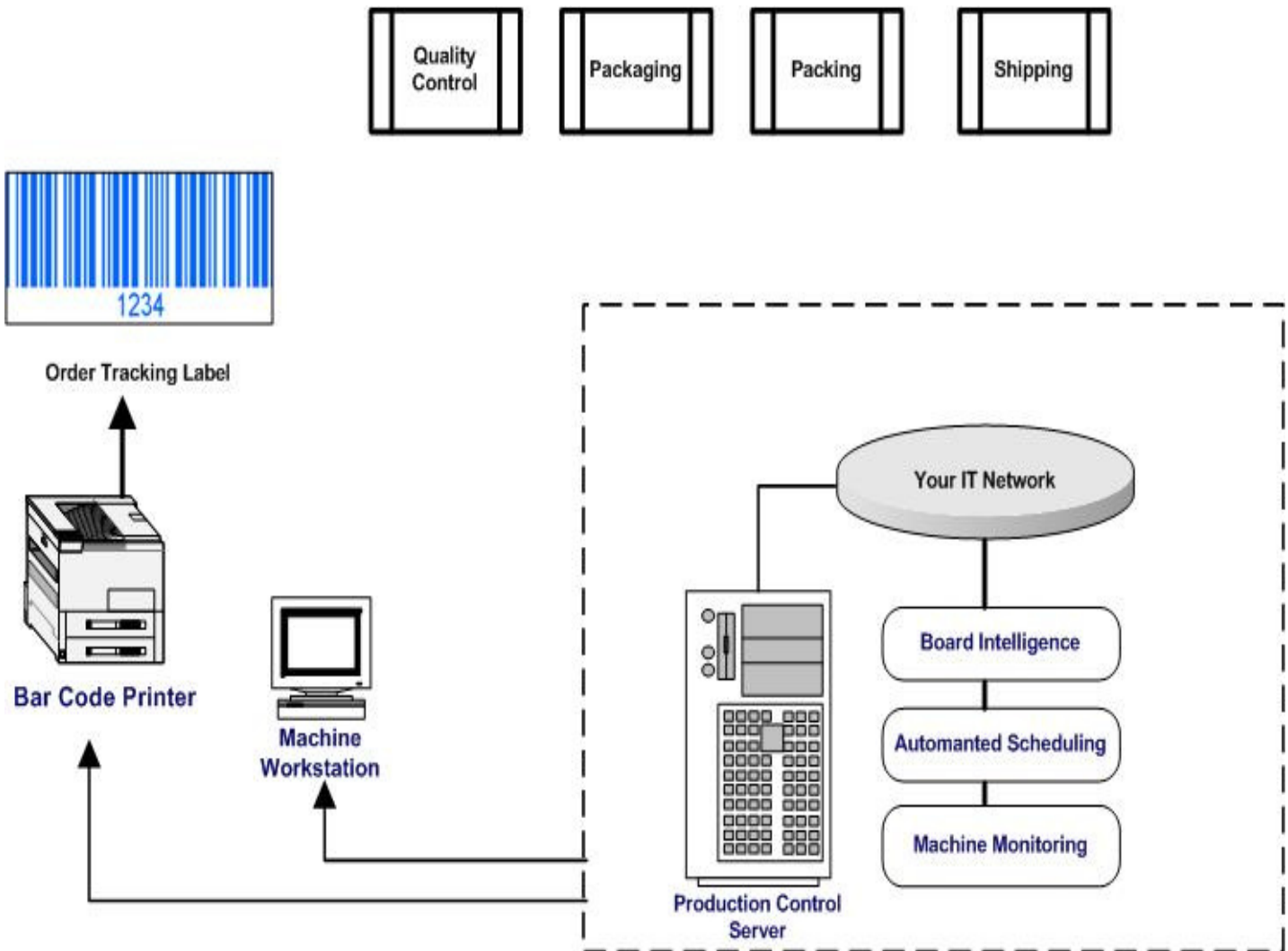
Date	Planned Quantity	Planned Execution Time (min)
08/05/2005	0	0
08/06/2005	~15,000	~2,000
08/07/2005	0	0
08/08/2005	~18,000	~2,000
08/09/2005	~20,000	~2,000
08/10/2005	0	0
08/11/2005	0	0

Menu
Capsule: [Main] \ Production Intelligence (Db: _Prod) Ver. 5.5

Each reporting screen can be user-specific and present on the data required by that user from the PrintTrac system. Graph and Charts can be customized and the data can be updated by the user at any time.

PrintTrac

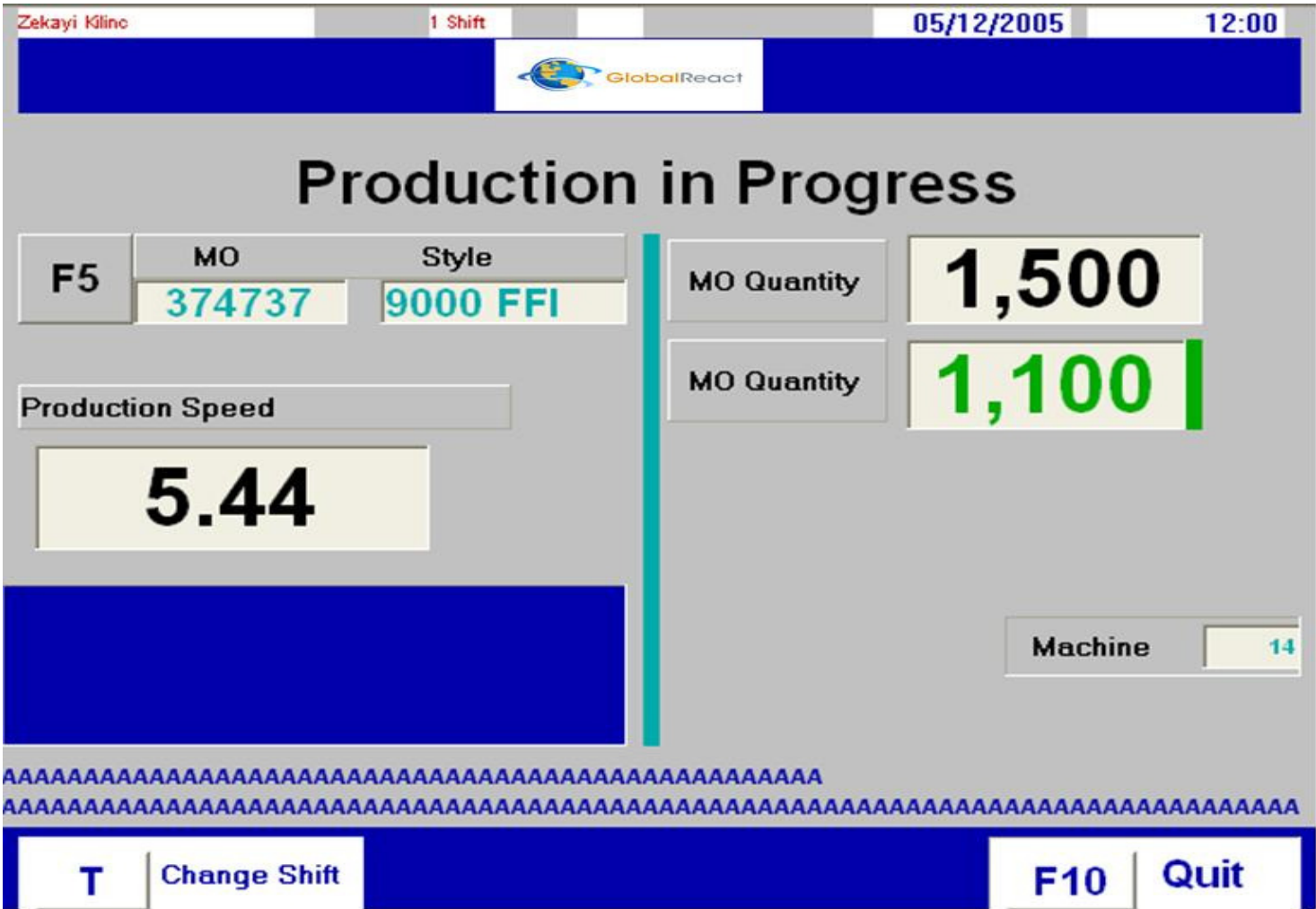
❖ Real-Time Machine Monitoring



Production Monitoring of print machine can be by linking serially to the PLC's on the machines wherever possible, otherwise, the process can be managed by operator control easily and efficiently.

PrintTrac

❖ Touch Screen Operator Controls



The screenshot displays the 'Production in Progress' screen. At the top, it shows 'Zekayi Kilino', '1 Shift', '05/12/2005', and '12:00'. The GlobalReact logo is centered. The main title is 'Production in Progress'. Below this, there are several data fields: 'F5' (a function key), 'MO' (Manufacturing Order) with value '374737', and 'Style' with value '9000 FFI'. To the right, 'MO Quantity' is shown as '1,500' and another 'MO Quantity' as '1,100'. Below the 'MO' field, 'Production Speed' is '5.44'. At the bottom right, 'Machine' is '14'. The bottom of the screen has a blue bar with 'T Change Shift' and 'F10 Quit' buttons. There are also two rows of 'A' characters above the bottom bar.

Touch Screen capability allows the operator to quickly initiate production processes and record manufacturing order information. The screens can be in different languages and with help features that guide the operator. The monitoring system updates the production time for set up and run times and keeps the operator apprised of the current order status.

PrintTrac

❖ Touch Screen Operator Controls



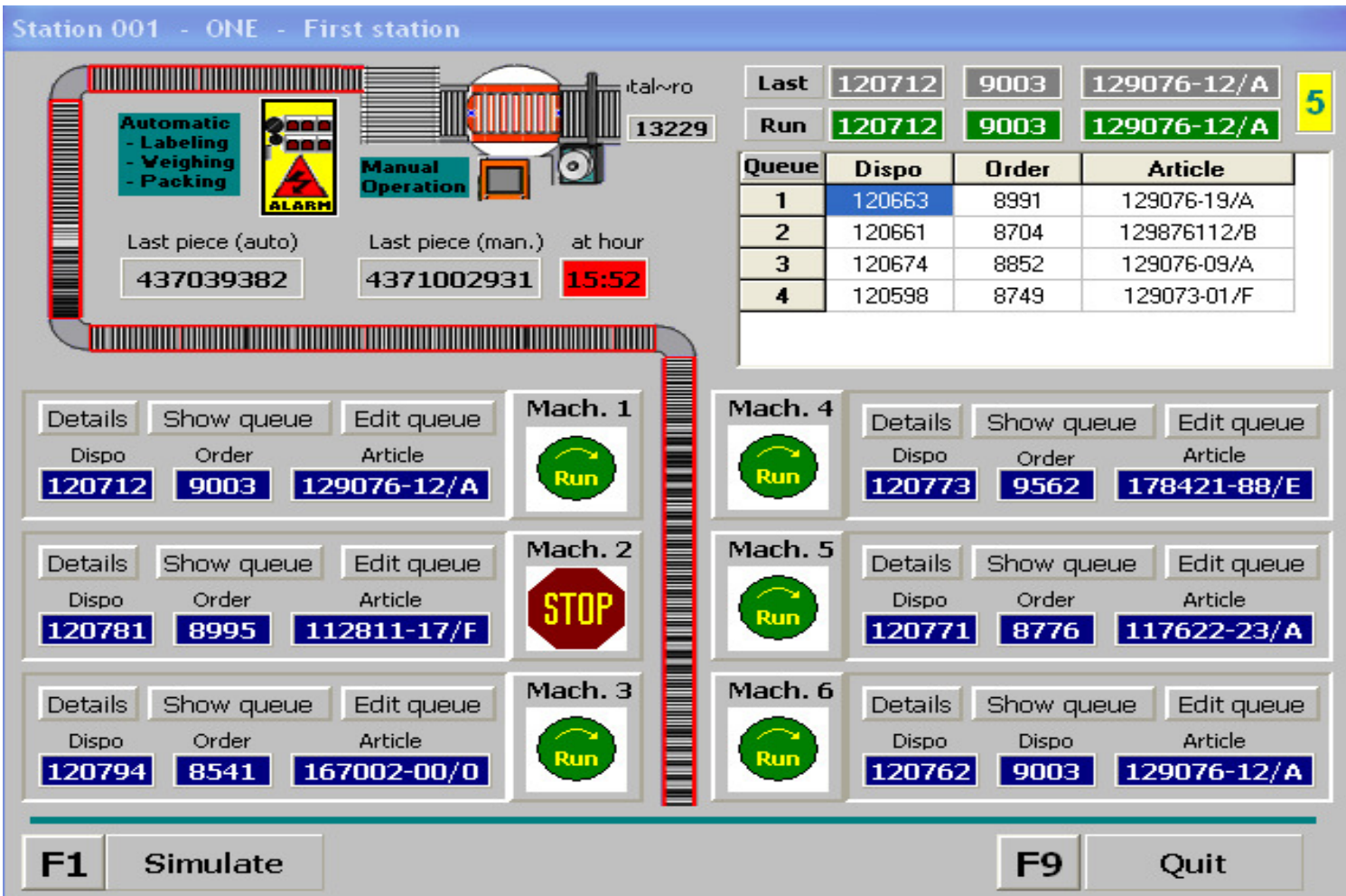
The screenshot shows a touch screen interface for machine stop controls. At the top, a blue banner displays "MACHINE STOP" in white. Below this, a grey box contains the text "Start At:" followed by two input fields: "10.05.2005" and "00:27". A larger grey box below contains the text "Enter Stop Reason". To the left of this box is a button labeled "F1". To the right is a large yellow display showing the number "99". Below the "Enter Stop Reason" box is a black bar with the word "Breakdown" in red. At the bottom of the interface are two buttons: "F3" and "Ok". A navigation bar at the very bottom contains buttons labeled "Check", "Change", "Event", "Finish", and "C".

The operator can enter stop reason code information or other key events during the printing or embroidery process into the touch screen when they occur. The system will calculate and report the information to the monitoring system and then update the production scheduling system which will recalculate the projected run-time of the manufacturing order. The production intelligence system will gather this data and the effect on the dash board.

PrintTrac

❖ Supervisor Control Station

Station 001 - ONE - First station



Automatic - Labeling - Weighing - Packing

Manual Operation

Last piece (auto) 437039382

Last piece (man.) 4371002931

at hour 15:52

Queue	Dispo	Order	Article
1	120663	8991	129076-19/A
2	120661	8704	129876112/B
3	120674	8852	129076-09/A
4	120598	8749	129073-01/F

Mach. 1: Run

Mach. 2: STOP

Mach. 3: Run

Mach. 4: Run

Mach. 5: Run

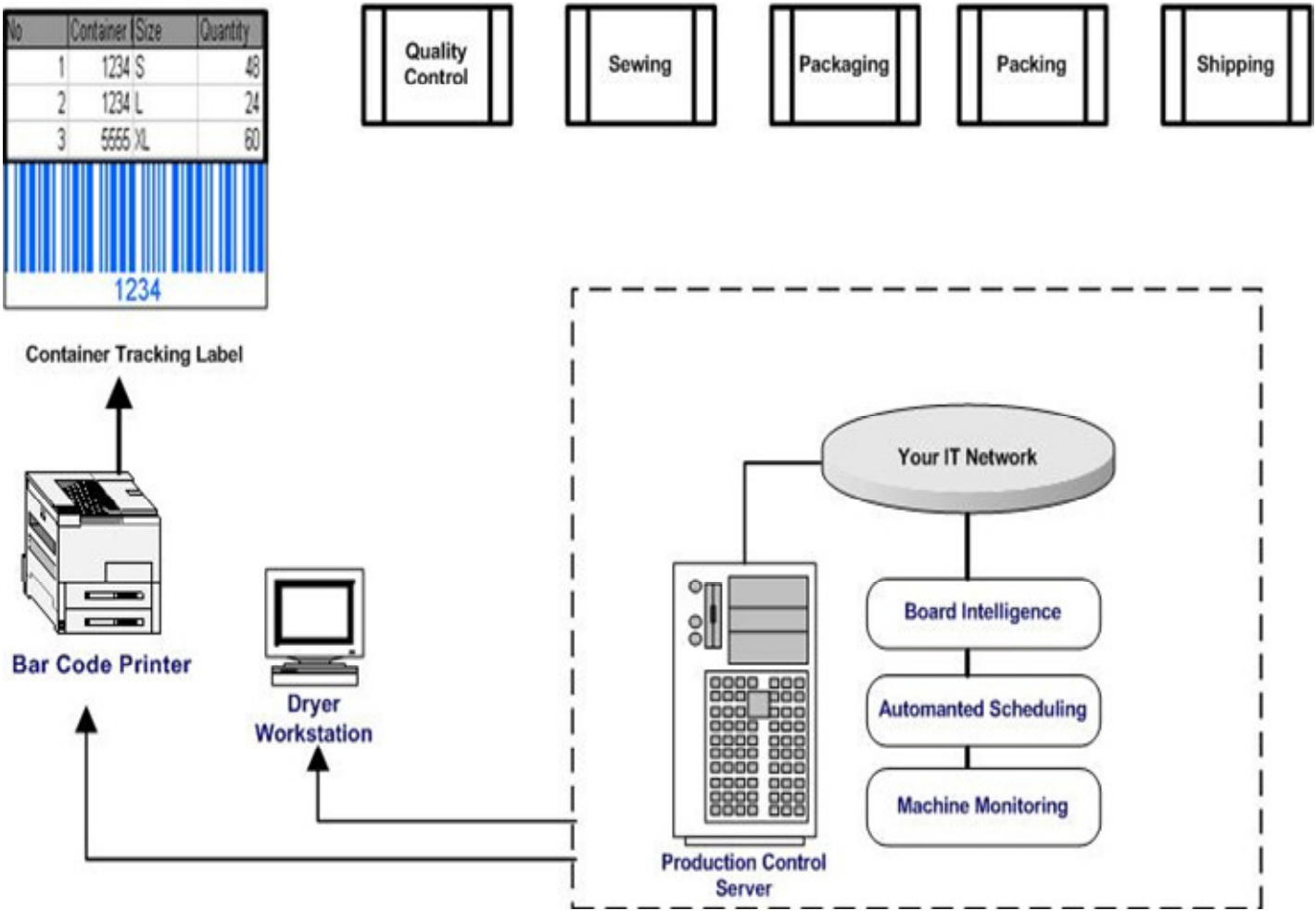
Mach. 6: Run

F1 Simulate F9 Quit

Production Supervisors and Management can view the status of the shop floor and drill into production information about each order, machine, operator, efficiency, queue, down-time from anywhere at anytime through the access to the server thru the Internet.

PrintTrac

❖ Work-in-Process Unit Tracking



PrintTrac utilizes bar coded documents and can scan track movement of orders through various departments and updates the scheduling system of where an order or parts of an order reside of work-in-process in the plant. Production is updated and daily reports reflect to the departments what their work requirements levels will be and the scheduling system can present the work load.

PrintTrac

❖ **Internet and Excel Integrated Reporting**

- **Quality Control Reporting**
 - *Reports by Order, Machine, Operator, Type*
- **Process Time Analysis**
 - *Operator, Machine, Order, Shift, Day, Week*
- **Labor Costing Analysis**
 - *Operator, Machine, Order, Shift, Day, Week*
- **Departmental Order Visibility Reporting**
 - *Printing, Sewing, Trim, Packaging, Shipping*
- **Work in Process Reporting**
 - *Reports by Customer, Order, Mfg. Order, Machine, Operator, Type*

PrintTrac reports can be presented on the operations dash board or presented in Excel format and transmitted to other offices and plants via the internet. New reports from the system are easily created and dash board presented based on each individual users requirements.



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