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18341

DP/ID/SER.A/1329
23 March 1990
ORIGINAL: ENGLISH

ASSISTANCE IN ESTABLISHING COMPUTERIZED
PRODUCTION/PRODUCTIVITY CONTROL IN WEAVING

SI/HUN/89/801

THE HUNGARIAN PEOPLE'S REPUBLIC

Technical report: Findings and recommendations*

Prepared for the Government of the Hungarian People's Republic
by the United Nations Industrial Development Organization,
acting as executing agency for the United Nations Development Programme

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* This document has not been edited.

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PREFACE

This report is designed as a guide and operating manual for a computerised productivity and quality control system for operation in the weaving plant of DUNASILK in Sopron, Hungary.

The project arose from a UNIDO request for assistance in designing and programming a micro-computer based system for controlling production in a modern weaving plant. The scope of the tasks were outlined in a series of discussions between Mr. H. Boesch of GHERZI and Mr J. P. Moll of UNIDO, and were finalised during discussions held between Mr D. MacDonald of GHERZI, Mr J. P. Moll and the management of Soproni Szovogyar.

From these discussions it was decided to design a customised system, based on the dBase IV programming language, which could address the main problem areas facing the company, namely monitoring quality performance, measuring productivity and controlling loom spare part consumption. A full range of programmes have now been completed and installed to perform these tasks and are described in detail in this report.

During the second visit the company expressed a desire to also have a programme for controlling wages which could run directly from the quality data they would collect under the new system. As this task was outside the original brief and programming time had not been allocated for this task further work will have to be carried out in the future to fulfil the needs of the company in this area. It should be noted that the file structure of the system has been designed with an open architecture to allow for the easy addition of modules of this type and it is to be hoped that the company's own programmers will also undertake further development work on this and other related tasks to ensure that the system keeps pace with the companys needs.

WEAVING PRODUCTIVITY AND QUALITY CONTROL SYSTEM

1. Introduction

This system has been designed to run on an IBM micro computer and has been created using dBase IV. The system can be run as a "stand alone" application on a single PC or can be run on a PC network environment.

This document provides a full description of the system design and operation, and contains samples of the full range of output reports that can be generated from the system. Samples of these reports are included in the appendices of this report. It should be noted however that the data contained in these reports is fictional and is included simply to display the structure of the various reports.

The applications programmes are provided along with the dBase IV development version operating environment which will give users scope for future system expansion or development if required. All data files have been provided with easy access not only from the MENU system but also through the dBase IV Control Centre. This means that the user not only enjoys access to the full range of system reports but can also create new unique queries and reports through the Structured Query Language (SQL) which is included in the dBase package. A full description of all these features and their capabilities is given in the Ashton Tate manuals which accompany the dBase IV programmes. A listing of all the main types of application files created and the function of each group of files is given in the attached Appendices 11.1 to 11.5.

2. dBase IV PROGRAMME FEATURES

dBase IV is the very latest generation in the dBase family of products. It is a High-Level language with its own command structure which can be used to create a diverse range of data management systems. No knowledge of dBase IV is required to operate this system as all applications programming has been completed by the Gherzi Organisation to provide an easy to use system that is entirely menu driven. However if the operating organisation wishes to undertake any future system development work on the system then an understanding of the dBase IV components and command language is essential.

Full documentation on all the components of the dBase system is provided by Ashton-Tate and is included with the dBase IV software. In addition to the command language it should be noted that dBase IV Developers Edition includes all the following features which are shown schematically in the attached Appendix 12.

- 1) Control Centre user interface.
- 2) Structured Query Language (SQL).
- 3) Query-By-Example facility.
- 4) RunTime capability.
- 5) Template Language.
- 6) Networking capability.
- 7) Applications Generator.

The system also provides a data import/export facility through the control centre medium to give the user an easy means of data transfer between dBase IV and other programmes.

3. Hardware & Software Configuration

Maximum benefit can be derived from this system when it is run on a networked environment where data collection and report access is made available to multiple users and can be readily expanded to cope with future growth in the use of the system. The hardware and software ordered for installation in Sopron has been selected to fulfil this goal and can be summarised as follows:

- a. SYSTEM FILE SERVER
 - FUTURE TECHNOLOGY PC-AT 386, Turbo System (at-386/302 Cache)
 - High Resolution VGA Colour Graphic Card (800 * 600)
 - 14 inch FUTURE VGA Colour Monitor (800 * 600)
 - Archive 60/E 60 MB External Streamer

- b. TERMINAL 1
 - FUTURE TECHNOLOGY PC-AT 286
 - Hercules/Colour Graphic Card with Printer Port
 - 14 inch Flat Screen Monochrome monitor
 - Etherboard (FD 0490)

- c. TERMINAL 2
 - FUTURE TECHNOLOGY LT-3240 PORTABLE

- d. PRINTER
 - FUTURE VP-1821 A3 Printer
 - Printer Buffer PB-256-2

- e. ANCILLARY ITEMS
 - 100 m RG 58 Coaxial Cable
 - 1 bnc Connector
 - 2 Male BNC Kit RG 58
 - Printer Cable
 - 10 DS/DD 3.5 inch Diskettes
 - 10 DS/HD 5.25 inch Diskettes
 - 20 DL 600 Streamer Tapes
 - 10 Printer Ribbons for VP-1821 Printer

- f. SOFTWARE ITEMS
 - Novell Advance Netware 2.15 Networking Software
 - MS DOS 3.3
 - dBase IV Multi-User Development Version.

4. APPLICATION SOFTWARE FOR CONTROL OF WEAVING

4.1 SYSTEM OVERVIEW

This system has been designed to provide a wide range of management information required to successfully manage a modern weaving factory and will provide data on productivity, quality, spare part consumption and yarn management. The system also contains a module to allow operator wages to be calculated by the computer using the data collected on the volume and quality of cloth produced. The system allows for the creation of detailed reports which analyse production quality and productivity from a range of different view points e.g Article, Weaver, Loom, Mechanic, Shift and Inspector.

The reports are structured to clearly highlight the main problem areas thus giving management the opportunity to tackle the most pressing problems first and improve the overall efficiency of the business. The system requires a degree of discipline in collecting and entering the required quality and productivity data each day but will prove very useful as a management tool in terms of the quality of information it can provide about the weaving operation.

The system has been designed to be entirely menu driven and it is not therefore required that the user has a knowledge of dBase IV programming language in order to operate the system. Any system must however be dynamic in order to keep pace with new demands from users. It is important therefore that at least one person in the organisation is fully familiar with the system design concept. When the system and file structure is understood it is a comparatively simple matter to generate new reports and applications from the dBase IV software that will meet future demands from users. The main inputs which require to be fed into the computer on an on-going basis can be summarised as follows :

1. Cloth quality data from Grey Cloth Inspection
2. Productivity data from Loom Downtime Sheets
3. Loomspare parts issues from Spare-Parts stores issue sheets.

With each of these areas it is important to establish a discipline of data entry to ensure that ALL available relevant data is entered onto the computer system as soon as the data becomes available. This will ensure that the data supplied in the output reports from the system are current, giving management the opportunity to spot variances and adverse trends at an early stage. The input and frequency of entry required for each of the above areas of data collection will be covered in detail in section 4.5 of this report.

Any database system of this nature requires a number of MASTER-FILES which are called into regular use during data entry and in formulation of output documents. This system contains MASTER-FILES covering a range of data topics from the names of weavers, article wage rates etc. Cross checks are available wherever possible to ensure that the required data is in the Master Files, but it is important that good manual support systems are established to ensure that these files are updated when changes occur, for instance when a new weaver joins the company or when an article wage rate is modified etc. Details of all the Master Files held by the system and a description of the data they contain is given in section 4.3 of this report.

It should be noted that the system also contains a file structure for controlling the weaving yarn store which can be activated at a future date if required. This yarn monitoring system is not envisaged for use at the present time in Sopron due to the unsatisfactory nature of the present yarn coding system in use in the company. A full description on the use of the yarn stock system and its associated output reports is given in section 4.6 of this report. When a new yarn coding system is introduced at Sopron, consideration should then be given to using the yarn stock reports available.

In designing the structure of the system database, file sizes have been kept as small as possible to speed data processing and to make the system as flexible as possible so that it can be easily modified or expanded to meet additional requirements from the company.

4.2 MAIN MENU

On entering the database system the main menu appears offering the user the following menu options.

- 1 SYSTEM MASTER FILE CONTROL
- 2 SYSTEM DATABASE CONTROL
- 3 INPUT DATABASE RECORDS
- 4 OUTPUT REPORT MENU
- 5 RE-INDEX ALL SYSTEM FILES
- 6 ACCESS DATABASE PROMPT
- 7 LEAVE DATABASE SYSTEM

Each of these options in turn leads to a range of sub-menus, the function and operation of which will now be explained in detail.

4.3 SYSTEM MASTER FILE CONTROL - (Main Menu Item 1)

The central feature of any database system are the data files which hold all the information required for the system to fulfil its function. In dBase IV related information which belong together logically are grouped into data base files and assigned the file extension .dbf by the system. Each file consists of a number of fields which hold specific types of information which has been determined during the file structure design stage. This option allows the user direct access to all the database files which have been classified as MASTER FILES, and it is important that these files are always kept up to date. A full listing of these Master Files and a description of the type of information they contain is given in Appendix 3.

If this option is selected the system will display a sub-menu offering the following options :

1. VIEW DATABASES
2. EDIT DATABASES
3. ADD NEW RECORDS TO DATABASES
4. OBTAIN DATABASE PRINTOUTS

Each of these menu items in turn lead to further sub-menus which allow the user to VIEW files, EDIT files, APPEND data to files or to take PRINTOUTS of entire files. Each menu item provides access to the following MASTER FILES :

- 1 List of Looms
- 2 List of Spare Parts
- 3 List of Mechanics
- 4 List of Cloth Faults
- 5 List of Loom Stop Reasons
- 6 List of Weavers
- 7 List of Sub-Contractors
- 8 Yarn Master Files
- 9 List of Articles
- 10 List of Cloth Inspectors

The VIEW and EDIT options are designed to offer an easy method of Viewing or Editing the data held in the above system database files. It is recommended that unless specific changes to the data in the files is envisaged the user should select the VIEW option to avoid accidental changes to data when scanning the files. When the system is in the VIEW mode it is impossible for the user to alter the stored data.

The ADD NEW RECORDS option is designed to give a customised entry screen for adding new records to each of the above Master Files. It should be noted that if any errors are made during the process of ADDING new records these can be quickly modified in the EDIT mode. The OBTAIN DATABASE PRINTOUTS option is designed to allow the user to call for hardcopy printouts of all the records in each of the Master Files which is printed in customised report formats. Samples of these reports are shown in appendices 1.1 - 1.9.

Appendix 1.1 shows the Loom List Report. This file holds the details of all the looms in the factory that are available for production and the code number for each loom.

Appendix 1.2 shows the Loom Spare Part List. This file holds the details of all the spare parts that can be used by the looms and the code number allocated to each of these parts.

Appendix 1.3 shows the Loom Mechanics List. This file holds the details of all loom mechanics employed by the factory and the code number allocated to each mechanic.

Appendix 1.4 shows the Cloth Faults List. This file holds the details of all possible cloth faults that can occur and the code number allocated to each of these fault groups.

Appendix 1.5 shows the Loom Stoppage Reasons List. This file holds details of all possible reasons for a loom being stopped and the code number associated with each stoppage reason.

Appendix 1.6 shows the Weavers List. This file holds details of all the weavers employed by the factory and the code number allocated to each weaver.

Appendix 1.7 shows the Sub-Contractors List. This file holds the details of all companies for whom sub-contract work is likely to be carried out and the code number allocated to each of these companies.

Appendix 1.8 shows the Articles List. This file holds the technical details of all products likely to be woven at the factory and the article code number allocated to each of these products.

Appendix 1.9 shows the Cloth Inspectors List. This file holds details of all cloth inspectors employed by the factory and the code number allocated to each of the inspectors.

On selecting item 8 on the previous menu "YARN MASTER FILES" the user is presented with a menu offering the following selections :

- 1 YARN DESCRIPTIONS FILE
- 2 YARN COUNT FILE
- 3 YARN FILAMENTS FILE
- 4 YARN TWIST FILE
- 5 YARN TWIST DIRECTION FILE
- 6 YARN PACKAGES FILE
- 7 YARN SUPPLIERS FILE
- 8 YARN SHADE FILE
- 9 YARN BUYERS FILE

Each of these options offers the user the chance to obtain printouts of all the Master Files which are used to define various yarn parameters.

Sample printouts of each of these files are shown in the attached Appendices 2.1 - 2.9.

Appendix 2.1 shows the coding and description given to the various types of yarns that can be used in the company. This 3-digit code number forms the first 3 digits in the 12 figure code used for yarn coding at Sopron.

Appendix 2.2 shows the coding used for the various yarn count groupings in the company. This 3-digit code number forms the second 3 digits in the 12 figure code used for yarn coding at Sopron.

Appendix 2.3 shows the coding used for the number of filaments contained in each yarn. This 2-digit code number forms the 7th and 8th digits in the 12 figure code used for yarn coding at Sopron.

Appendix 2.4 shows the coding used for the yarn twist (tpm) contained in each yarn. This 2-digit code number forms the 9th and 10th digits in the 12 figure code used for yarn coding at Sopron.

Appendix 2.5 shows the coding used for the yarn twist direction in each yarn. This 1-digit code number forms the 11th digit in the 12 figure code used for yarn coding at Sopron.

Appendix 2.6 shows the coding used for the various yarn packages in use. This 1-digit code number forms the 12th digit in the 12 figure code used for yarn coding at Sopron.

Appendix 2.7 shows the coding used for the various yarn suppliers in use.

Appendix 2.8 shows the coding used for the various yarn shades in use.

Appendix 2.9 shows the coding used for the various yarn waste purchasers used by the company.

4.4 SYSTEM DATABASE CONTROL (Main Menu Item 2)

This menu option permits access to the system data files which the user is allowed to VIEW or EDIT. These files are again classified as database files and contain the dBase IV file extension .dbf. They differ from the Master Files only in the type of information they hold. These system databases are being constantly updated with new data that is collected each day, whereas the Master Files hold data that is changed infrequently and is called by the system when required to compose various reports.

On selecting this menu option the user is offered a choice of VIEWING or EDITING System Databases. Again it is recommended that unless specific changes are envisaged to the data held on file the user should select the VIEW option to avoid accidental changes to data when scanning the files. When the system is in the VIEW mode it is impossible for the user to alter the stored data. Both the VIEW and EDIT options give access to a menu offering the following selections :

- 1 QUALITY RECORDS BY DATE
- 2 QUALITY RECORDS BY LOOM
- 3 QUALITY RECORDS BY WEAVER
- 4 SPARE PART ISSUES BY DATE
- 5 SPARE PART CURRENT STOCK
- 6 PRODUCTIVITY RECORDS BY DATE

This menu offers direct access to the most important system files, QUALITY.dbf which holds details of cloth quality, PARTISSU.dbf which holds details of loom spare part issues, PARTSTOC.dbf which contains details of spare-part stock and PRODO.dbf which holds all loom efficiency records. As these files are of central importance to the system a full description is given in the attached Appendices 10.1 to 10.3. Each of these files is made available through the menu in an indexed or ordered format which makes it easier for the user to locate specific records of interest.

4.5 INPUT DATABASE RECORDS (Main Menu Item 3)

The function of this menu item is to give access to an entry format for adding new information to the main system database files. On selecting this option from the main menu a sub-menu appears offering the user the following options :

1. INPUT PRODUCTIVITY INFORMATION
2. INPUT QUALITY INFORMATION
3. INPUT SPARE-PART INFORMATION
4. INPUT YARN INFORMATION.

Each of these options gives the user a method of appending new data into the appropriate files and has a series of security checks to verify that the data being entered is valid. The operation of each of these entry programmes will now be described in more detail.

INPUT PRODUCTIVITY INFORMATION

The function of this item is to allow the user to enter data relating to loom productivity. The system operates by retaining data on the articles running on each loom including the pick reading at the end of each shift. This is expressed as a % against the theoretical maximum number of picks a loom could produce in a shift, bearing in mind loom speed and shift duration. On selecting this option the user is immediately presented with a sub-menu offering the following choices :

1. ENTER SHIFT PRODUCTION DATA
2. UPDATE PRODUCTION MASTER FILE
3. UPDATE PICK READING FILE

The first option ENTER SHIFT PRODUCTION DATA allows the user to enter daily productivity data from the loom sheets into the file PRODO.dbf. The user is first prompted for the required loom number and if a valid code number is given a customised entry screen is presented. The DATE, shift DURATION, LOOM code and ARTICLE fields are filled in automatically by the computer from MASTER FILE data but can be overwritten by the operator if required. When an entry has been completed by the user the following checks are carried out by the computer before the entry is added to the file :

- a) Loom code number is checked to ensure the loom exists in the Master File LOOM.dbf.
- b) Article code number is checked to ensure that it exists in the Master File ARTICLE1.dbf.
- c) Weavercode number is checked to ensure that it exists in the Master File WEAVER.dbf.
- d) The Loom code number is checked to ensure that it exists in the pick counter reading file LASTREAD.dbf.
- e) The calculated picks inserted in the shift are compared to the theoretical maximum possible picks. If calculated picks exceed the maximum a warning is given offering the user the chance to accept or reject the last entry.

If all the criteria listed in points a) to e) are accepted then the entry is added to the file and the user is given the option of adding further entries for the same loom, adding an entry for a new loom or terminating the productivity data entry procedure.

The second menu option UPDATE PRODUCTION MASTER FILE allows the user to update a file called LOOMAST.dbf. This file holds data about the article currently being woven on each of the company's looms and should be updated each time a new warp is loaded onto a loom. A full description of the file LOOMAST and the type of data it holds is given in the attached Appendix 10.4. This file is important as it is used to update the data entry screen for daily productivity entries, so speeding up this process. The file is also at the heart of another programme which predicts when each loom will require a warp change. On entering the option UPDATE PRODUCTION MASTER FILE the user is prompted to answer the following questions about the required loom :

- a) The code number of the article to be woven.
- b) The expected cloth length to be woven.
- c) The pick counter reading at the start of weaving.
- d) The loom speed in picks per minute.
- e) The code number of the warp to be woven.

If valid entries are made for each of the above questions the programme calculates the total picks required and pick reading expected at the end of the weaving and stores all this data under the correct loom number in the file LOOMAST.dbf.

The third menu option UPDATE PICK READING allows the user to update a file called LASTREAD.dbf. This file contains the last recorded pick reading for each loom in the company and is updated automatically every time the user makes a valid daily productivity entry. This menu option gives the user a facility to update this reading manually if required. The user is prompted for a loom code number and when a valid code is given the new pick reading is requested and this value then overwrites the existing value in the file.

INPUT QUALITY INFORMATION

The function of this item is to allow the user to enter the data relating to cloth quality which is extracted from the sheets completed by the grey cloth inspection department. All data entered from this menu option is stored in the system file QUALITY.dbf. On selecting this option from the menu the user is prompted to enter the code number of the loom for which a data entry is intended. When a valid code number is given the user is given a customised entry screen. When the entry of all the data shown on the screen has been completed the following checks are carried out by the computer before the entry is added to the QUALITY.dbf file :

- a) Loom code number is checked to ensure that the loom exists in the Master File LOOM.dbf.
- b) Article code number is checked to ensure that the article exists in the Master File ARTICLE1.dbf.
- c) Weaver code number is checked to ensure that it exists in the Master File WEAVER.dbf.
- d) A cross check is made to ensure that the total quantity inspected balances with the total designated as 1st quality, 2nd quality, 3rd quality and rags.
- e) A check is made to ensure that a wage rate exists in the file WAGERATE.dbf for the combination of article and machine limitation code submitted.

If all the criteria listed above are met then the entry is added to the file and the user is given the option of adding further data for the same loom, adding data for a different loom or terminating the entry sequence for quality data.

INPUT SPARE PART INFORMATION

The function of this item is to allow the user to enter data related to the issue and receipt of loom spare parts. On selecting this menu item the user is presented with a sub-menu offering the following choices :

1. ENTER SPARE PART ISSUES
2. ENTER SPARE PART RECEIPTS
3. SPARE PART STOCK ADJUSTMENT

The first option ENTER SPARE PART ISSUES gives a customised entry screen which asks the user for the code number and loom to which any spare part issued from stores has been allocated. The system checks that both the part code number and the loom code actually exist in their respective master files, and if they do the programme moves the entry and the issue date into a file called ISSUES.dbf and automatically reduces the stock position of that spare part by the issued volume.

The second option ENTER SPARE PART RECEIPTS is designed to handle data entry for delivery of loom spare parts into stock. This option also produces a customised data entry screen which asks for the code number of the part received and the date of delivery of the part. If the part number given is held on the SPARES.dbf master file then the entry will be accepted and the stock position for that part number increased by the quantity delivered.

The third menu option SPARE PART STOCK ADJUSTMENT is designed to give an easy method of manually adjusting the stock quantity for any spare part code number. On selecting this option the file PARTSTOC.dbf is opened in edit mode on the screen to allow the user direct access to the contents of the file. This option should prove useful if any stock adjustments have to be made following stock-taking etc.

4.6 OUTPUT REPORTS MENU (Main Menu Item 4)

This option gives the user access to a series of menus for calling the output reports that the system generates. The reports have been designed to allow the user to specify the time period that the report should cover, and to give a detailed view of the company's performance from a range of different viewpoints. The system at present contains a wide range of reports which will be described in detail in the following pages. It should be noted also that the dBase IV file structure and programming tools provided mean that it is also a relatively simple task for users to create further unique reports from the existing files and data that is collected. On selecting the OUTPUT REPORTS MENU the user is immediately presented with a screen offering the following options :

1. QUALITY REPORTS MENU
2. PRODUCTIVITY REPORTS MENU
3. STOCK REPORTS MENU
4. WAGES REPORTS
5. MULTIPLE REPORTS

Each of these items gives access to further sub-menus which offer the user access to a series of reports on the above topics which can be summarised as follows :

QUALITY REPORTS MENU

This item offers the user access to the full range of quality related reports generated by the system. On selecting this option the user is presented with a menu offering the following selections :

- 1 WEAVER QUALITY REPORTS
- 2 WEAVER FAULT ANALYSIS
- 3 LOOM QUALITY REPORTS
- 4 LOOM FAULT ANALYSIS
- 5 MECHANIC QUALITY REPORTS
- 6 ARTICLE QUALITY REPORTS
- 7 QC-INSPECTOR REPORTS
- 8 SHIFT QUALITY REPORT
- 9 WARP QUALITY REPORTS

Option 1 WEAVER QUALITY REPORTS gives two possible reports which analyse the quality of production being given by individual weavers. Both reports can be based on any time period that the user cares to define. The first report, which summarises the volume of 1st, 2nd, 3rd and 4th quality being

produced by each of the company's weavers is illustrated in the attached Appendix 5.01. The report is indexed to show in descending order the weavers credited with the highest volume of "Non-1st Quality" cloth. The second available report on weaver quality which is illustrated in the attached Appendix 5.02 gives a listing of the Quality History for any individual weaver over any time period that the user cares to define. This report should be useful for spotting quality trends with individual weavers.

Option 2 WEAVER FAULT ANALYSIS gives a detailed analysis of the distribution of cloth faults to display the type of faults most frequently occurring and the weavers which produce the greatest number of faults. A sample to illustrate the structure of this report is shown in the attached Appendix 5.03. It should be noted that this report is again indexed to show in descending order the weavers who generate the highest number of cloth faults. The report also summarises the factory's average number of faults recorded/100 LM which should allow the company to monitor the situation over a period of time and gauge the effectiveness of any actions taken to improve cloth quality.

Option 3 LOOM QUALITY REPORTS gives two possible reports which analyse the quality of production being given by the individual looms. Both reports can be based on any time period that the user cares to define. The first report, which summarises the volume of 1st, 2nd, 3rd and 4th quality being produced by each of the company's looms is illustrated in the attached Appendix 5.04. The report is indexed to show in ascending order the looms credited with the highest volume of "Non-1st Quality" cloth. The second available report on loom quality which is illustrated in the attached Appendix 5.05 gives a listing of the Quality History for any individual loom over any time period that the user cares to define. This report should be useful for spotting quality trends with individual looms.

Option 4 LOOM FAULT ANALYSIS gives a detailed analysis of the distribution of cloth faults to display the type of faults most frequently occurring and the looms which produce the greatest number of faults. A sample to illustrate the structure of this report is shown in the attached Appendix 5.06. It should be noted that this report is again indexed to show in descending order the looms which generate the highest number of cloth faults. The report also summarises the factory's average number of faults recorded/100 LM which should allow the company to monitor the situation over a period of time and gauge the effectiveness of any actions taken to improve cloth quality.

Option 5 MECHANIC QUALITY REPORTS

gives three possible reports which analyse the quality of production being given by individual mechanics. Both reports can be based on any time period that the user cares to define. The first report, which summarises the volume of 1st, 2nd, 3rd and 4th quality being produced by each of the company's mechanics is shown in the attached Appendix 5.07. The report is indexed to show in descending order mechanics credited with the highest volume of "Non-1st Quality" cloth.

The second available report on mechanic quality which is illustrated in the attached Appendix 5.08 gives a listing of the Quality History for any individual mechanic over any time period that the user cares to define. This report should be useful for spotting quality trends with individual weavers.

The third available report is the MECHANIC FAULT ANALYSIS which gives a detailed analysis of the distribution of cloth faults to display the type of faults most frequently occurring and the mechanics who produce the greatest number of faults. A sample to illustrate the structure of this report is shown in the attached Appendix 5.09. It should be noted that this report is again indexed to show in descending order mechanics who generate the highest number of cloth faults. The report also summarises the factory's average number of faults recorded/100 LM which should allow the company to monitor the situation over a period of time and measure the effectiveness of any actions taken to improve cloth quality.

Option 6 ARTICLE QUALITY REPORTS

gives two possible reports which analyse the quality of production being given on each of the company's articles. Both reports can be based on any time period that the user cares to define. The first report, which summarises the volume of 1st, 2nd, 3rd and 4th quality being produced on each of the company's articles is illustrated in the attached Appendix 5.10. The report is indexed to show in descending order the articles which generate the highest volume of "Non-1st Quality" cloth. The second available report on article quality which is illustrated in the attached Appendix 5.11 gives a listing of the Quality History for any individual article over any time period that the user cares to define. This report should be useful for spotting quality trends with individual articles.

Option 7 QC-INSPECTOR REPORTS gives two possible reports which analyse the quality of production being passed by the QC Inspectors. Both reports can be based on any time period that the user cares to define. The first report, which summarises the volume of 1st, 2nd, 3rd and 4th quality being passed by each of the company's inspectors is

illustrated in the attached Appendix 5.12. The report is indexed to show in descending order the inspectors credited with detecting highest volume of "Non-1st Quality" cloth. The second available report on inspector quality which is illustrated in the attached Appendix 5.13 gives a listing of the Quality History for any individual inspector over any time period that the user cares to define. This report should be useful for spotting quality trends with individual QC Inspectors.

Option 8 SHIFT QUALITY REPORT produces a report which analyses the quality of production coming from individual shifts within the factory. The report which summarises the volume of 1st, 2nd, 3rd and 4th quality cloth produced on each shift is illustrated in the attached Appendix 5.14. The report indexes in ascending order the shifts producing the highest volume of "Non-1st Quality" cloth.

Option 9 WARP QUALITY REPORTS gives two possible reports which analyse production quality from the standpoint of individual warps. The first report summarises the volume of 1st, 2nd, 3rd and 4th quality cloth, and the number of faults detected by individual warp is illustrated in the attached Appendix 5.15. This report can be based on any user defined time period. The second available warp report is shown in the attached Appendix 5.16 and is intended as a daily summary report to show the quality of production on any user defined date.

PRODUCTIVITY REPORTS MENU

This item offers the user access to the full range of productivity related reports generated by the system. On selecting this option the user is presented with a menu offering the following selections :

- 1 LOOM DOWNTIME REPORT
- 2 LOOM EFFICIENCY REPORT
- 3 WEAVER DOWNTIME REPORT
- 4 WEAVER EFFICIENCY REPORT
- 5 MECHANIC DOWNTIME REPORT
- 6 MECHANIC EFFICIENCY REPORT
- 7 ARTICLE EFFICIENCY REPORT
- 8 WARP COMPLETION FORECAST
- 9 LOOM EFFICIENCY BY LOOM WIDTH

Option 1 LOOM DOWNTIME REPORT produces a report which analyses loom downtime distribution over the predetermined loom stoppage codes to highlight the most frequently occurring sources of lost time and to show which looms have the highest number of lost hours. Appendix 6.1 shows a

sample output which illustrates the structure of this report. It should be noted that this report is indexed to show in descending order the looms which have the highest percentage of lost time. This report can again be called for any user defined time period and shows an average lost time % for the company as a whole so that the effectiveness of any actions taken can be gauged over a period of time.

Option 2 LOOM EFFICIENCY REPORT

produces a report which analyses loom efficiency for all looms over any user defined time period. Efficiency for this purpose is measured as actual picks inserted expressed as a % of the theoretical maximum number of picks that could have been inserted during the defined time period. Appendix 6.2 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed on the Lost Time field to show in descending order the looms with highest number of lost time hours.

Option 3 WEAVER DOWNTIME REPORT

produces a report which analyses weaver downtime distribution over the predetermined loom stoppage codes to highlight the most frequently occurring sources of lost time and to show which weavers have the highest number of lost hours. Appendix 6.3 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed to show in descending order the weavers who have the highest percentage of lost time. This report can again be called for any user defined time period and shows an average lost time % for the company as a whole so that the effectiveness of any actions taken can be measured over a period of time.

Option 4 WEAVER EFFICIENCY REPORT

produces a report which analyses weaver efficiency over any user defined time period. Efficiency for this purpose is measured as actual picks inserted expressed as a % of the theoretical maximum number of picks that could have been inserted during the defined time period. Appendix 6.4 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed on the Lost Time field to show in descending order the weavers with the highest number of lost time hours.

Option 5 MECHANIC DOWNTIME REPORT

produces a report which analyses mechanic downtime distribution over the predetermined loom stoppage codes to highlight the most frequently occurring sources of lost time and to show which mechanics have the highest number of lost hours. Appendix 6.5 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed to show in descending order the mechanics who have the highest percentage of lost time. This report can again be called for any user defined time period and shows an average lost time % for the company as a whole so that the effectiveness of any actions taken can be gauged over a period of time.

Option 6 MECHANIC EFFICIENCY REPORT produces a report which analyses mechanic efficiency over any user defined time period. Efficiency for this purpose is measured as actual picks inserted expressed as a % of the theoretical maximum number of picks that could have been inserted during the defined time period. Appendix 6.6 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed on the Lost Time field to show in descending order the mechanics with the highest number of lost time hours.

Option 7 ARTICLE EFFICIENCY REPORT produces a report which analyses article efficiency over any user defined time period. Efficiency for this purpose is measured as actual picks inserted expressed as a % of the theoretical maximum number of picks that could have been inserted during the defined time period. Appendix 6.7 shows a sample output which illustrates the structure of this report. It should be noted that this report is indexed on the Lost Time field to show in descending order the articles with highest number of lost time hours.

Option 8 WARP COMPLETION FORECAST produces a report which predicts when a warp is due to be finished weaving. The report works on the principle of calculating the total picks required in each warp and comparing this to the known number of picks which have already been inserted at the time this report is called. Using the known loom speed and previous efficiency % achieved for the article it is possible to convert outstanding picks to be inserted into hours of weaving time. Appendix 6.8 shows a sample output which illustrates the structure of this report. It should be noted that the report is indexed on the PICKS REQD field to show in ascending order the looms with the least number of picks still required to complete the warp.

Option 9 LOOM EFFICIENCY BY LOOM WIDTH produces a report which analyses loom efficiency by loom width groupings over any user defined time period. Appendix 6.9 shows a sample output which illustrates the structure of this report. Efficiency for this purpose is measured as actual picks inserted expressed as a percentage of the theoretical maximum number of picks that could have been inserted during the defined time period. It should be noted that this report is presented in natural order.

STOCK REPORTS MENU

This item offers the user access to the full range of productivity related reports generated by the system. On selecting this option the user is presented with a menu offering the following selections :

1. LOOM SPARE PART CONSUMPTION
2. LOOM SPARE PART STOCK
3. YARN STOCK REPORTS

The LOOM SPARE PART CONSUMPTION option makes available a total of four separate reports which are offered on a sub-menu as follows :

- SPECIFIC LOOM REPORT
- LOOM SUMMARY REPORT
- PART ISSUES BY PART-CODE
- PART ISSUES BY QUANTITY

The SPECIFIC LOOM REPORT gives details of the spare part consumption of any individual loom within the factory. The user simply supplies the loom number and the time period that the report is to be based on. A sample output illustrating the structure of this report is shown in the attached appendix 7.1. The report is indexed on the date of spare part issue and should prove to be a useful report for spotting looms which are using high quantities of particular parts due to some other underlying problem with the machine.

The LOOM SUMMARY REPORT gives details of the volume and value of parts consumed by all the looms in the company for any particular user defined time period. A sample output illustrating the structure of this report is shown in the attached Appendix 7.2. This report is indexed by Value of Parts Issued in ascending order to highlight looms with a high consumption rate. From the details supplied in this report the user may want to run the SPECIFIC LOOM REPORT for the worst offending looms in terms of spares expenditure to get exact details of which parts were being used by the machine.

The PART ISSUE BY PART-CODE report gives details of the spare part consumption for all spare parts for any user defined time period. A sample output illustrating the structure of this report is shown in the attached Appendix 7.3. The report is indexed by spare-part code number and lists the quantity, cost and total value of issues made for each part held in the Spares Master File.

The PART ISSUES BY QUANTITY report is identical in structure to the PART ISSUES BY PART-CODE report outlined above except that this report is indexed by Issue Quantity instead of the spare part code number. A sample output illustrating the structure of this report is shown in the attached Appendix 7.4.

The LOOM SPARE PART STOCK option makes available a total of three separate reports which are offered on a sub-menu as follows :

- CURRENT STOCK BY PART CODE
- CURRENT STOCK BY QUANTITY
- SPARE PART STOCK FORECAST

The CURRENT STOCK BY PART CODE report gives details of the spare part stock in terms of quantity and values and is a real-time report reflecting the situation at the time of calling the report. A sample illustrating the structure of this report is shown in the attached Appendix 7.5. The report is indexed by ascending spare part code number.

The CURRENT STOCK BY QUANTITY is identical to the CURRENT STOCK BY PART CODE report outlined previously except that the index used in presenting the report is based on the quantity held in stock and not on part-code as in the previous report. The report is produced in ascending order of stock quantity to highlight items which are out of stock. A sample output illustrating the structure of this report is shown in the attached Appendix 7.6.

The SPARE PART STOCK FORECAST report shows the issues, current stock, annualised consumption rate and estimated run-out time for the present stock based on the calculated consumption rate. A sample output illustrating the structure of this report is shown in the attached Appendix 7.7. The report is indexed by spare part code number.

The YARN STOCK REPORTS option gives access to a range of programmes designed to control the issue and receipt of yarns for weaving. This section of the system is not envisaged for immediate use at Sopron due to the present outdated system of yarn coding. Yarns are currently coded at the head office with a 12 digit code number, and it is understood that the present system is under review and may be replaced in the near future. The system structure has been designed to fit the present coding system, but this can be easily modified and redesigned to fit with the existing file structure when a new, more logical coding system is implemented within the company.

A brief description of the Yarn Stock options available from the system is given for information purposes. On selecting the YARN STOCK REPORTS option the user is presented with a menu offering the following selections :

- SUMMARY OF YARN ISSUES
- SUMMARY OF YARN RECEIPTS
- CURRENT YARN STOCK REPORT
- SUMMARY OF OLD YARN STOCKS
- YARN QUALITY SUMMARY
- YARN REJECT SUMMARY
- SURPLUS YARN SALES
- SURPLUS YARN WRITE-OFFS

The SUMMARY OF YARN ISSUES report gives the user details of all yarns issued between any user defined dates. A sample output illustrating the structure of this report is shown in the attached Appendix 8.1.

The SUMMARY OF YARN RECEIPTS report gives the user details of all yarns received by the company between any user defined dates. A sample output illustrating the structure of this report is shown in the attached Appendix 8.2.

The CURRENT YARN STOCK REPORT gives the user details of all yarns held in stock at the time the report is called. A sample output illustrating the structure of this report is shown in the attached Appendix 8.3.

The SUMMARY OF OLD YARN STOCKS report gives the user details of all old yarns held in stock. The date prior to which a yarn is classified as old stock is defined by the user from a system prompt. A sample output illustrating the structure of this report is shown in the attached Appendix 8.4.

The YARN QUALITY SUMMARY report provides details of all past yarn quality problems registered for specific suppliers and batches and details the supplier response to the particular problem. A sample output illustrating the structure of this report is shown in the attached Appendix 8.5.

The YARN REJECT SUMMARY report gives details of all yarns which have been classified as rejects, listed by supplier and batch number and detailing the reason for rejection. A sample output illustrating the structure of this report is shown in the attached Appendix 8.6.

The SURPLUS YARN SALES report gives details of all surplus yarns not used by the company, which have been resold to other companies. A sample output illustrating the structure of this report is shown in the attached Appendix 8.7.

The SURPLUS YARN WRITE-OFFS report gives details of all surplus yarns not used by the company which have been written off. A sample output illustrating the structure of this report is shown in the attached Appendix 8.8.

WAGES REPORTS

The system also offers the user the opportunity to incorporate a wages system for weavers and mechanics directly from the data acquired on the volume and quality of the cloths produced. The system works from a Master File called WAGERATE.dbf which hold details of the wage rates the the company will pay per meter for 1st, 2nd and 3rd quality grades of cloth for every article and loom code combination. This data is then linked with the details of cloth production and volume accredited to each weaver and mechanic which is stored in the file QUALITY.dbf. As with all Master Files it is important that WAGERATE.dbf is always kept up to date as the system will not permit the entry of quality inspection data if no wage rate can be found on file for the article and loom combination being entered.

On entering the WAGES REPORTS option the user is presented with a menu offering the following selections :

1. WEAVERS WAGES
2. WEAVERS WAGES SUMMARY
3. MECHANICS WAGES

Option 1 WEAVERS WAGES offers a report for any user defined time period which details weaver by weaver the volume of cloth produced by grade/article and the corresponding wages due for this production including any bonuses to which the weaver is entitled. A sample output illustrating the structure of this report is shown on the attached Appendix 9.1.

Option 2 WEAVERS WAGES SUMMARY produces a summary report of the Quality of production and total wages paid to each weaver during any user defined time period. A sample output illustrating the structure of this report is shown on the attached Appendix 9.2.

Option 3 MECHANICS WAGES offers a report for any user defined time period which details for each mechanic the volume of cloth produced by grade/article and the corresponding wages due for this production including any bonuses to which the mechanic is entitled. A sample output illustrating the structure of this report is shown on the attached Appendix 9.3.

It should be noted that this wages system is outside the brief of this particular project and further programme development work requires to be carried out before this module can become operational. These programmes can be installed at a future date when programming is completed and will integrate fully with the system as it stands at the present time.

MULTIPLE REPORTS

The MULTIPLE REPORTS option is a feature that is included to speed up the production of QUALITY and PRODUCTIVITY reports. As each of these two sub-sections of the system contain a wide range of reports which will probably be required at the same time (i.e end of the month) this feature allows the user to produce all of these reports in sequence by defining the reporting period only once and leaving the system to create and print the full range of available reports without any further user inputs. On selecting this option the user is presented with a menu offering the following choices :

1. PRINT QUALITY REPORTS
2. PRINT PRODUCTIVITY REPORTS

On selecting one or other of these options the user is prompted for the starting and finishing date of the reporting period and the system then produces the full range of Quality or Productivity output reports.

4.7

RE-INDEX ALL SYSTEM FILES (Main Menu Item 5)

In order for the system to operate as speedily as possible and to maintain data integrity the system runs a number of indexes in conjunction with the data files. A special programme is required to keep these indexes up to date and also to maintain the data files in good working order and this programme is accessed through Option 5, RE-INDEX ALL SYSTEM FILES. The programme will remove all redundant records and also move any file updates into the correct indexes. It is strongly recommended that this programme be run whenever data in the files has been EDITED, DELETED, APPENDED or in any way modified to ensure data accuracy. In fact it is often a good routine to establish that this programme is run at the start or finish of every working session with the computer. When this programme is run the system displays a wait message for the user and gives an estimate of the time required for the re-indexing process to be completed. When this programme is being run, access to the system and its files is not permitted.

4.8 ACCESS DATABASE PROMPT (Main Menu Item 6)

This option allows the user direct access to the dBase IV dot prompt. This is important only if the user wishes to look directly at the structure of the application programmes or to carry out some additional programming or file access work. The dBase IV manual supplied with the system gives a full description of the commands contained in the language and a guide to working with dBase from the dot prompt. When the user has finished working from the dBase prompt the main menu for the system can be restored by giving the command DO SOPRON at the dot from the dot prompt.

4.9 LEAVE DATABASE SYSTEM (Main Menu Item 7)

This option allows the user to end a working session with dBase IV and returns control of the system to the DOS environment. It is important to give this command and return to DOS before the system is switched off as the programme ensures that all open files are closed and that data integrity is maintained.

SOPRON WEAVING : LOOM LISTING

<u>LOOM CODE</u>	<u>MECHANIC GROUP</u>	<u>M/C TYPE</u> : <u>WIDTH</u>	<u>WEFT ENDS</u>
1201	2	SZTB - 175 Cms	2
1202	2	SZTB - 175 Cms	2
1203	2	SZTB - 175 Cms	2
1204	2	SZTB - 175 Cms	2
1205	2	SZTB - 175 Cms	2
1206	2	SZTB - 175 Cms	2
1207	2	SZTB - 175 Cms	2
1208	2	SZTB - 175 Cms	2
1209	2	SZTB - 175 Cms	2
1210	2	SZTB - 175 Cms	2
1211	2	SZTB - 175 Cms	2
1212	2	SZTB - 175 Cms	2
1301	2	SZTB - 175 Cms	2
1302	2	SZTB - 175 Cms	2
1303	2	SZTB - 175 Cms	2
1304	2	SZTB - 175 Cms	2
1305	2	SZTB - 175 Cms	2
1306	2	SZTB - 175 Cms	2
1307	2	SZTB - 175 Cms	2
1308	2	SZTB - 175 Cms	2
1309	2	SZTB - 175 Cms	2
1313	2	SZTB - 175 Cms	2
1311	2	SZTB - 175 Cms	2
1312	2	SZTB - 175 Cms	2
1401	2	SZTB - 175 Cms	2
1402	2	SZTB - 175 Cms	2
1403	2	SZTB - 175 Cms	2
1404	2	SZTB - 175 Cms	2
1405	2	SZTB - 175 Cms	2
1406	2	SZTB - 175 Cms	2
1407	2	SZTB - 175 Cms	2
1408	2	SZTB - 175 Cms	2
1409	2	SZTB - 175 Cms	2
1410	2	SZTB - 175 Cms	2
1411	2	SZTB - 175 Cms	2
1412	2	SZTB - 175 Cms	2
1501	2	SZTB - 175 Cms	2
1502	2	SZTB - 175 Cms	2
1601	4	SZTB - 175 Cms	2
1602	4	SZTB - 175 Cms	2
1603	4	SZTB - 175 Cms	2
1604	4	SZTB - 175 Cms	2
1605	5	SZTB - 175 Cms	2
1606	5	SZTB - 175 Cms	2
1607	5	SZTB - 175 Cms	2
1608	5	SZTB - 175 Cms	2
1609	5	SZTB - 175 Cms	2
1611	6	SZTB - 175 Cms	2
1612	6	SZTB - 175 Cms	2
1613	7	SZTB - 175 Cms	2
1614	7	SZTB - 175 Cms	2
1615	7	SZTB - 175 Cms	2
1616	7	SZTB - 175 Cms	2
1701	4	SZTB - 175 Cms	2
1702	4	SZTB - 175 Cms	2
1703	4	SZTB - 175 Cms	2
1704	4	SZTB - 175 Cms	2
1705	5	SZTB - 175 Cms	2

SOPRON : LOOM SPARE PARTS LIST

<u>PART CODE NUMBER</u>	<u>PART DESCRIPTION</u>	<u>PART COST</u>
10100220	1311 KONZOL	1379.50
10100420	1313 MENETESRUD	135.00
10170013	TARTOLAP	91.70
10170023	BILINCS	91.70
10170033	BALLONKEPZO DUGO	141.50
10200020	0006 SKALA	240.30
10200060	0009 ALATET	6.20
10200063	0009 ALATET	3.60
10200073	REZ SZEGECS 216-2-7	5.40
10200074	REZ SZEGECS	0.00
10200080	0011 KEZI KEREK	605.20
10200090	0012 SZIJTARCSA	2282.00
10200094	MEGHAJTOSZIJTARCSA	0.00
10200096	SZIJTARCSA	319.50
10200100	KUPLUNG KERESZT	329.30
10200110	ATMENETI CSATLAKOZO	46.10
10200120	0015 MEGH.TENGELY	1063.20
10200123	0015 MEGHAJTOTENGELY	699.50
10200124	MEGHAJTOTENGELY	0.00
10200126	MEGHAJTOTENGELY	113.90
10200140	0017 KUFOS PERSELY	70.60
10200150	0016 TUZOORSO	19.80
10200153	OSSZEKOTCSAVAR	8.90
10200160	0019 SZORITOCsap	34.30
10200163	SZARITOCsap	32.90
10200164	SZORITOCsap	0.00
10200170	0020 ALATET	361.30
10200180	0021 CSUSZKA	129.80
10200190	0022 RUGO	203.30
10200200	1334 TAMCSAFAGY	200.30
10200210	1335 TAMASZTO ALATET	174.40
10200213	1335 TARCsa 100%	52.50
10200220	0023 SZORITOCsap	36.30
10200223	SZORITOCsap 216-2-22	31.20
10200224	SZORITOCsap	0.00
10200233	TARCsa	69.40
10200234	TARCsa	0.00
10200240	0024 TENG.KAFCS.KAR	592.70
10200260	0025 SZAB.TAM.CSAVAR	18.70
10200290	0027 FEKSZALAG	106.80
10200297	FEKSZALAG	91.70
10200300	0028 FEKBETET	95.50
10200380	0031 ALLITOCSAVAR	53.00
10200390	0033 RUGO	31.20
10200400	1341 CSAP	38.40
10200430	0034 RUGO	48.10
10200450	0035 OSSZEKOTOLEC	181.60
10200493	CSAP	28.90
10200500	0037 ZAROCsAPSZEG	27.00
10200520	0038 FOGANTYU	19.60
10200540	0039 HATAROLO	89.00
10200600	0040 INDITOKARUTKOZO	19.60
10200603	0043 INDITOKARUTKOZO	8.90
10200604	INDITOKARUTKOZO	0.00
10200693	SZIJTARCSA 216-2-69	87.20
10200694	MOTORSZIJT.216-2-69	0.00
10200696	MOTORSZIJTARCSA	43.60
10200830	0045 TENGELY	368.50

SOPRON : LIST OF LOOM MECHANICS

<u>MECHANICAL</u> <u>GROUP</u>	<u>MECHANIC</u> <u>CODE</u>	<u>MECHANICS NAME</u>	<u>SHIFT</u>
1	01	GYULA GYORVARY	A
1	02	ANDRAS NEMETH	B
1	03	TIBOR HUSZAR	C
2	04	FERENC MURAI	A
2	05	FERENC PECZA	B
2	06	GYULA MOGYAROSI	C
3	07	ATTILA GRACZOL	A
3	08	ATTILA GORGYAN	B
3	09	BELA TOTH	C
4	10	FRENC TRINKL	A
4	11	HELMUT HEISSENBERGER	B
4	12	ERNO RUZSOVITS	C
5	13	FERENC TOTH	A
5	14	REZSO LEITNER	B
5	15	ZOLTEN NAGY	C
6	16	KAROLY KANITCH	A
6	17	JOZSEF DOMINEK	B
6	18	GEBOR TOBL	C
7	19	LASZLO IVAN	A
7	20	SANDOR HORVATH	B
7	21	JOZSEF CZAKLER	C
8	22	ARPAD FINTA	A
8	23	TAMAS HEGYKO!	B
8	24	GABOR KOVACS	C
9	25	IMRE SZALAY	A
9	26	ELEMER SZABO	B
9	27	JENO TOTH	C
11	28	GEZA KOVACS	A
11	29	PETER PODMANICZKI	B
11	30	IMRE SZUKITS	C

SOPRON : LIST OF GREY CLOTH FAULTS

<u>FAULT CODE</u>	<u>FAULT DESCRIPTION</u>
1	WARP FAULTS
2	SELVEDGE/CLOTH WARP
3	WARP STRIPES (LUSTRE)
4	LACING - INCORRECT WRONG WARP
5	WEFT STRIPING DUE TO LOOM STOPPAGE
6	WEFT FAULTS, TONE
7	MISSING WEFT PICK
8	WEFT STRIPING - WRONG YARN, ETC
9	WEFT FAULTS, KNOTS, LOOPS ETC
10	OILY WARP OR WEFT PICK
11	PATTERN FAULT
12	OIL STAIN OR DIRTY MARK
14	SELVEDGE FAULTS
16	OTHER WEAVING FAULTS
18	RECURRING WARP STRIP
19	SHADE VARIATIONS
20	OTHER YARN FAILURES

SOPRON : LIST OF LOOM STOPPAGE REASONS

<u>STOPPAGE CODE</u>	<u>STOPPAGE DESCRIPTION</u>
1	LOOM REPAIR
2	WARP CHANGE
3	TYING-IN NEW WARP
4	PATTERNING CARD REPAIR/REPLACEMENT
5	REPAIR BROKEN WARP END
6	REPAIR MULTIPLE BROKEN ENDS
10	SERVICE MAINTENANCE
12	BREAKDOWN
13	WARP SHORTAGE
14	WEFT SHORTAGE
15	SPARE PART SHORTAGE
16	WEAVER SHORTAGE
17	MECHANIC SHORTAGE

SOPRON : LIST OF WEAVERS

<u>CODE</u>	<u>NAME</u>	<u>SHIFT</u>	<u>WAGE RATE</u>
1	MARIANN HISS	T	0.00
2	MONIKA MEZO	T	0.00
3	RITA MOLNAR	T	0.00
4	SZILVIA ROZMAN	T	0.00
5	SZILVIA MARKUS	T	0.00
6	SZILVIA KOZAK	T	0.00
8	TUNDE FUZI	T	0.00
9	BARBARA BIHARI	T	0.00
10	KATALIN FINTER	T	0.00
11	ELVIRA DOBOR	T	0.00
13	ZSUZSANNA KALMAR	T	0.00
14	CECILIA NYITRAI	T	0.00
15	GERTRUD CSAPO	T	0.00
16	HEILGA HARGITAI	T	0.00
17	PIROSKA ROZMAN	T	0.00
18	LIVIA NEMETH	T	0.00
19	TIMEA ABRAHAM	T	0.00
20	BARBARA BIHARI	T	0.00
21	ANDREA CZETIN	T	0.00
22	ANNA KALMAR	T	0.00
23	JUDIT ZSUGONITS	T	0.00
24	VALERIA TARCSAI	T	0.00
26	MARTA TAKACS	T	0.00
27	JUDIT KOVACS	T	0.00
28	MELINDA BALOGH	T	0.00
29	MARIA LANYI	T	0.00
30	ELEONORA HIDEGH	T	0.00
51	JANOSNE VARGA	A	0.00
52	ERZSEBET SZAKALY	A	30.30
53	IMRENE FAZEKAS	A	27.60
54	ISTAVANNE LANG	A	29.30
56	GYULANE FEHER	A	0.00
57	MELINDA EDELMAYER	A	27.60
58	LASZLONE SZASZVAROSI	A	30.30
59	PALNE MESZAROS	A	30.30
61	TEREZ ZISS	A	29.30
63	ISTAVANNE MOLNAR	A	30.30
64	ERIKA MUTZHAUSZ	A	0.00
65	JOZSEFNE FEKETE	A	30.30
66	ZOLTANNE FELEK	A	0.00
73	SANDORNE II TAKACS	A	29.30
74	ANASZTAZIA GOSZTOLA	A	29.30
75	KRISTA ROZMAN	B	0.00
76	IMRENE VARGA	A	0.00
80	TIBORNE VARGA	A	27.60
83	JENONE VISSI	A	27.60
85	IDA SOOS	A	29.30
87	BAK EVA	A	27.60
88	GYULANE KRANITZ	A	30.30
89	VILMOSNE FEKETE	B	0.00
92	IMRENE ORI	A	0.00
93	PETERNE DARABOS	A	27.60
95	PALNE FABIANKOVICS	A	27.60
97	VERONIKA POLYAK	A	0.00
98	ERNONE BALASKO	A	0.00
100	MARTA CSETKOVICS	A	29.30
351	JOZSEFNE KOVACS	B	27.60
354	MARIA FERENCZI	B	0.00
355	IREN NAGY	B	29.30

SOPRON : LIST OF SUB-CONTRACTORS

<u>CONTRACTOR CODE</u>	<u>SUB-CONTRACTOR NAME</u>
1	RABATEXT
2	BUDAFLAX BUDAKLARASZ
3	BUDAFLAX GYORILENSZOVO
4	PATEX
5	PNYV

ARTICLE MASTER-FILE REPORT

<u>ARTICLE</u> <u>CODE</u>	<u>ARTICLE NAME</u>	<u>DRAWING</u> <u>IN WIDTH</u>	<u>REED</u> <u>WIDTH</u>	<u>REED</u> <u>DENSITY</u>	<u>SELVEDGE</u> <u>ENDS</u>	<u>SELVEDGE</u> <u>WIDTH</u>	<u>SELVEDGE</u> <u>YARN CODE</u>	<u>WARP</u> <u>CONTRACTION</u>	<u>PICKS</u> <u>/10 CMS</u>	<u>SUR-</u> <u>CONTRACTOR</u>	<u>MACHINE</u> <u>LIMITATION</u>
2308368	DOLLY	163.3	163.3	22.0	156	3.6	232106245622	4.2	0.0	0	12
2305550	DOLORES	163.3	163.3	22.0	156	3.6	232106245622	4.5	0.0	0	12
2307066	ERNA	172.0	172.0	16.0	60	3.6	232106245622	5.5	0.0	0	13
685801	FANTA	173.3	173.3	15.0	157	3.6	231058362724	4.7	0.0	0	12
1202966	FATIME	173.3	173.3	39.0	160	3.6	210068241715	5.1	0.0	0	15
685701	FELICIA	163.3	163.3	13.0	96	3.5	350173870152	6.2	0.0	0	11
686401	FF. FUGGONY	306.0	306.0	11.0	114	3.5	134104222322	6.3	0.0	0	33
686402	FF. FUGGONY	306.0	306.0	11.0	114	3.5	134104222322	5.9	0.0	0	33
2308058	FIGARO	163.3	163.3	15.0	134	3.6	281104323624	4.8	0.0	0	13
685801	FILOMENA	163.3	163.3	15.0	152	3.6	210058390903	5.1	0.0	0	13
686702	ISABELL	171.0	171.0	21.0	154	3.6	100958102123	6.2	0.0	0	13
685501	NILUS	165.0	165.0	20.0	144	3.5	250111201713	4.5	0.0	0	31
686302	NINIVE	165.0	165.0	20.0	144	3.6	250111201713	3.9	0.0	0	11
2308558	PAMINA	162.3	162.3	19.0	108	3.6	250111201719	6.2	0.0	0	13
1407056	PIRAMIS	161.3	161.3	17.0	120	3.6	133104242323	5.6	0.0	0	41
1402658	VERONA	154.6	154.6	17.0	120	3.6	281104323624	5.0	0.0	0	11
	<u>AVERAGE :</u>	<u>162.9</u>	<u>162.9</u>	<u>18.1</u>	<u>131</u>	<u>3.6</u>		<u>5.2</u>	<u>0.0</u>		

SOPRON : LIST OF CLOTH INSPECTORS

<u>INSPECTORS CODE</u>	<u>INSPECTORS NAME</u>
11	DEZSONE POLACSEK
12	FERENCNE CSASZAR
13	FERENCNE KOVACS
14	TIBORNE MIHOCZA
15	MATYASNE NEMETH
16	SANDORNE SZABO
21	GYORGYNE JOOS
22	IMRENE KOCSIS
23	ISTAVANNE KOVACSICS
24	ANTALNE NAGY
25	FERENCNE SZEKENDI
26	MIHALYNE TRACKL

APPENDIX 2 - YARN MASTER FILE REPORTS

MASTER FILE : YARN DESCRIPTIONS

<u>IDENTIFICATION CODE</u>	<u>YARN DESCRIPTION</u>
<u>001</u>	<u>100 % VICOS FENYES</u>
<u>031</u>	<u>PA 6 FELMATT N ZS FEKETE</u>
<u>035</u>	<u>PA6 FM NEMSZUG ENG VELKOL</u>
<u>036</u>	<u>PES FENYES FEKETE SZOVOF</u>
<u>037</u>	<u>PA6 FM NEMSZUG 10% ENG</u>
<u>039</u>	<u>VISKZ FENYES KONTINUE</u>
<u>040</u>	<u>PA6 F CSILLAMLO NEMSZUG</u>
<u>050</u>	<u>VISCOS MATT</u>
<u>058</u>	<u>36% PES 64% PA66 BOUCLE FM</u>
<u>060</u>	<u>PES FENYES NEMSZUG</u>
<u>068</u>	<u>PES FENYES MFEST Z FZSUG</u>
<u>083</u>	<u>PES KREPP M NZS TORLEN</u>
<u>086</u>	<u>PES TORLEN</u>
<u>087</u>	<u>PES FMATT TORLEN</u>
<u>093</u>	<u>VISCOS FENYES ELOHENGER</u>
<u>095</u>	<u>VISCOZ FENYES</u>
<u>100</u>	<u>PA6 MATT NEMZUGORITOTT</u>
<u>101</u>	<u>INOXOR 0,25 MN</u>
<u>127</u>	<u>93% ACRYL 7% VISCOS</u>
<u>133</u>	<u>PES MATT NYERS</u>
<u>134</u>	<u>PES FM NYERS LENGVEL</u>
<u>159</u>	<u>85% PES 15% BOURETTE</u>
<u>169</u>	<u>PES FM T FSZIN DIS 1 SETT</u>
<u>173</u>	<u>PES FM TEXTURALT CANELLAS</u>
<u>177</u>	<u>PA 6 FM NZS NYERS</u>
<u>196</u>	<u>PES NYERS LEGFUV TERJED</u>
<u>198</u>	<u>PES T FM SETT TORLEN SZ</u>
<u>201</u>	<u>ACETAT 100%</u>
<u>202</u>	<u>PES TERJ SET FE FON FEST</u>

MASTER FILE : YARN COUNT CODING

<u>IDENTIFICATION CODE</u>	<u>YARN CODE</u>	
<u>000</u>	<u>10</u>	<u>dtex</u>
<u>001</u>	<u>11</u>	<u>dtex</u>
<u>002</u>	<u>12</u>	<u>dtex</u>
<u>003</u>	<u>12.2</u>	<u>dtex</u>
<u>004</u>	<u>13</u>	<u>dtex</u>
<u>005</u>	<u>13.4</u>	<u>dtex</u>
<u>006</u>	<u>14</u>	<u>dtex</u>
<u>007</u>	<u>14.4</u>	<u>dtex</u>
<u>008</u>	<u>15</u>	<u>dtex</u>
<u>009</u>	<u>15.6</u>	<u>dtex</u>
<u>010</u>	<u>16</u>	<u>dtex</u>
<u>011</u>	<u>16.6</u>	<u>dtex</u>
<u>012</u>	<u>17</u>	<u>dtex</u>
<u>013</u>	<u>17.6</u>	<u>dtex</u>
<u>014</u>	<u>18</u>	<u>dtex</u>
<u>015</u>	<u>18.8</u>	<u>dtex</u>
<u>016</u>	<u>19</u>	<u>dtex</u>
<u>017</u>	<u>20</u>	<u>dtex</u>
<u>018</u>	<u>21</u>	<u>dtex</u>
<u>019</u>	<u>22</u>	<u>dtex</u>
<u>020</u>	<u>22.2</u>	<u>dtex</u>
<u>021</u>	<u>23</u>	<u>dtex</u>
<u>022</u>	<u>23.2</u>	<u>dtex</u>
<u>023</u>	<u>24</u>	<u>dtex</u>
<u>024</u>	<u>24.4</u>	<u>dtex</u>
<u>025</u>	<u>25</u>	<u>dtex</u>
<u>026</u>	<u>25.6</u>	<u>dtex</u>
<u>027</u>	<u>26</u>	<u>dtex</u>
<u>028</u>	<u>26.6</u>	<u>dtex</u>

MASTER FILE : NUMBER OF FILAMENTS

<u>FILAMENT CODE</u>	<u>NUMBER OF FILAMENTS</u>
00	0
01	1
02	2
03	3
04	4
05	5
06	6
07	7
08	8
09	9
10	10
11	11
12	12
13	13
14	14
15	15
16	16
17	17
18	18
19	19
20	20
21	21
22	22
23	23
24	24
25	25
26	26
27	27
28	28

MASTER FILE : YARN TWIST CODING

<u>TWIST CODE</u>	<u>YARN TWIST RANGE (tpm)</u>
01	0-20
02	21-40
03	41-60
04	61-70
05	71-80
06	81-90
07	91-100
08	101-110
09	111-120
10	121-130
11	131-140
12	141-150
13	151-160
14	161-170
15	171-180
16	181-190
17	191-200
18	201-225
19	226-250
20	251-275
21	276-300
22	301-325
23	326-350
24	351-375
25	376-400
26	401-425
27	426-450
28	451-475
29	476-500

MASTER FILE : TWIST DIRECTION CODING

<u>TWIST DIRECTION CODE</u>	<u>DESCRIPTION OF TWIST DIRECTION</u>
<u>0</u>	<u>PARHUZ</u>
<u>1</u>	<u>S SODR</u>
<u>2</u>	<u>Z SODR</u>
<u>3</u>	<u>Z=S CE</u>
<u>4</u>	<u>S=Z CE</u>
<u>5</u>	<u>S+Z = S</u>
<u>6</u>	<u>S+Z = Z</u>
<u>7</u>	<u>S FO</u>
<u>8</u>	<u>Z FO</u>
<u>9</u>	<u>S+Z FO</u>

MASTER FILE : YARN PACKAGE CODING

<u>PACKAGE CODE</u>	<u>DESCRIPTION OF YARN PACKAGE</u>
<u>0</u>	<u>KALACS</u>
<u>1</u>	<u>MOTRIN</u>
<u>2</u>	<u>SIK X</u>
<u>3</u>	<u>KUPOS X</u>
<u>4</u>	<u>S KONUS</u>
<u>5</u>	<u>K KONUS</u>
<u>6</u>	<u>T CSEVE</u>
<u>7</u>	<u>KOPS</u>
<u>8</u>	<u>SAJT X</u>
<u>9</u>	<u>HENGER</u>

MASTER FILE : YARN SUPPLIER LISTING

<u>SUPPLIER CODE</u>	<u>SUPPLIER NAME</u>
01	COURTAULDS
02	LUSTRE FIBRES
03	
04	ICI
05	MARGLAS
06	GLAS FIBRES
07	
08	
09	
10	ROCHRUDE
100	JET SETA
11	RHODIACETA
12	RHONE POULENCE
13	REXOR S.A
14	CHAVANOZ/ISERIA
15	
16	VERRE TEXTILE
17	
18	
19	
20	SNIA/ITAVISCOZA
21	ANIC
22	SCHATILLON
23	ORSI MANGELLI
24	RHODIATOCE
25	MONTEFIBRE
26	BERTRAND
27	MILANO VITROFIL
28	METALREX

MASTER FILE : YARN SHADE CODING

<u>SHADE CODE</u>	<u>YARN SHADE</u>
0000	<u>UNDYED</u>
1115	<u>SARGA</u>
1120	<u>DARANY</u>
1215	<u>MUSTARD</u>
1230	<u>NARANCS</u>
2205	<u>ROSA</u>
2225	<u>PIROS</u>
2230	<u>TERRAKOTTA</u>
2235	<u>BORDO</u>
2245	<u>BORDO</u>
2250	<u>BORDOK</u>
2300	<u>ROZSA</u>
2320	<u>LILA</u>
3005	<u>V. KEK</u>
3007	<u>V. KEK</u>
3015	<u>KEK</u>
3025	<u>AC. KEK</u>
3040	<u>S. KEK</u>
3045	<u>KEK</u>
3055	<u>KEK</u>
3060	<u>S. KEK</u>
4310	<u>ZOLD</u>
4500	<u>ZOLD</u>
4512	<u>ZOLD</u>
4515	<u>S. ZOLD</u>
5505	<u>BEIGE</u>
5510	<u>DRAPP</u>
5520	<u>DRAPP</u>
5530	<u>BRANDY</u>

LIST OF WASTE YARN PURCHASERS

<u>BUYER CODE</u>	<u>BUYERS NAME</u>	<u>BUYERS ADDRESS</u>
1	HUNGARIAN KNITTERS	202 RADGASSE BUDAPEST HUNGARY
2	THE KNITTING CO	24 KOENIG STR. STUTTGART GERMANY
3	FULLY FASHIONED PLC	29 ACKERSTR. SOPRON HUNGARY
4	TEXTILE WASTE LTD	46 AYERS LANE BRADFORD ENGLAND

APPENDIX 3 - LIST OF SYSTEM MASTER FILES

Appendix 3.0

DESCRIPTION OF SYSTEM MASTER FILES

<u>FILE NAME</u>	<u>DESCRIPTION</u>
1. WEAVER.dbf -	Lists the code number and full name of all WEAVERS employed by the company. File also holds details of the wage rate bonus percentage each weaver is entitled to.
2. LOOMS.dbf -	Lists the code number and technical parameters of all weaving machines available for production in the factory. The file also contains details of the mechanical group assigned to the loom.
3. MECHANIC.dbf -	Lists the code number and full name of all loom mechanics employed by the company. The file also holds details of which shift the mechanic works and to which group of looms he is assigned to.
4. CLOTHERR.dbf -	Lists the code number and description of all possible cloth faults which can occur at the company.
5. LOOMSTOP.dbf -	Lists the code number and description of all the possible reasons for a loom stoppage which can occur at the company.
6. SUBCONT.dbf -	Lists the code number and name of all the companies for whom sub contracted weaving may be carried out.
7. INSPECT.dbf -	List the code number and full names of all the cloth inspectors employed by the company.
8. ARTICLE1.dbf -	Lists the code number, name and the technical parameters of all articles produced by the company.
9. SPARES.dbf -	Lists the code number and description of all the possible loom spare parts that the company holds.
10. YARNAME.dbf -	Lists the code number and description of all yarns used by the company.

DESCRIPTION OF SYSTEM MASTER FILES

<u>FILE NAME</u>	<u>DESCRIPTION</u>
11. YARCNT.dbf -	Lists the code number and description of all yarn count groups used by the company.
12. YARNFIL.dbf -	Lists the code number and description of all filament groups (number of filaments) used by the company.
13. YARTWIST.dbf -	Lists the code number and description of all yarn twist groups in use (TPI).
14. YARDIR.dbf -	Lists the code number and description of all twist types used by the company.
15. YARPACK.dbf -	Lists the code number and description of all yarn package types used by the company.
16. YARNSUP.DBF -	Lists the code number and names of all yarn suppliers used by the company.
17. YARNCOL.dbf -	Lists the code number and names of all yarn shades used by the company.
18. YARBUY.dbf -	Lists the code number and names of all purchasers of waste yarn used by the company.

APPENDIX 4 - LIST OF MAIN SYSTEM DATA FILES

Appendix 4.0

DESCRIPTION OF MAIN SYSTEM DATA FILES

FILE NAME -----	DESCRIPTION -----
1. QUALITY.dbf -	This file is used to hold all the quality related data which is entered each day from the Grey Cloth inspection sheets. This file is extremely important to the operation of the system as the data it contains is used in conjunction with various Master Files to create the entire range system Quality Reports shown in Appendices 5.01 to 5.16. This file is also directly involved in supplying the data required to produce the wages reports (Appendices 9.1 - 9.3) produced by the system. A full description of the file structure of QUALITY.DBF is given in Appendix 10.1
2. PRODO.dbf -	This is the databases file used to hold all the productivity related data which is entered each day from the individual loom productivity sheets. This file consequently provides all the data required to create the full range of productivity related reports shown in the attached Appendices 6.1 to 6.9. A full description of the file structure of PRODO.DBF is given in Appendix 10.2.
3. PARTISSU.dbf -	This file holds all data relating to the issue of loom spare-parts from stores to the looms. The data from this file is used to produce the spare-part issues related reports which are shown in Appendices 7.1 to 7.4. A full description of the file structure of PARTISSU.DBF is given in Appendix 10.3.
4. PARTSTOC.dbf -	This file holds details of the current stock position for each loom spare part used by the company. This file is updated automatically each time the system is informed of a loom spare-part issue or receipt. The data from this file is used to produce the spare-part stock related report which are shown in the attached Appendices 7.5 to 7.7. A full description of the file structure of PARTSTOC.DBF is given in the attached Appendix 10.3

APPENDIX 5 - SAMPLE QUALITY OUTPUT REPORTS

QUALITY ANALYSIS SUMMARISED BY WEAVER - FROM 01/01/89 - 31/12/89

<u>WEAVER CODE</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON- 1st QUALITY</u>	<u>VOLUME OF NON 1st QUALITY</u>	<u>WEAVERS NAME</u>
677	2790	1610	785	285	110	<u>42.3 %</u>	1180	<u>TIBORNE NICKL</u>
380	450	200	200	0	50	<u>55.6 %</u>	250	<u>KRISZTINA ROZMAN</u>
351	600	400	120	30	50	<u>33.3 %</u>	200	<u>JOZSEFNE KOVACS</u>
695	287	157	120	0	10	<u>45.3 %</u>	130	<u>TEREZ FARKAS</u>
092	500	400	50	50	0	<u>20.0 %</u>	100	<u>IMRENE ORI</u>
371	500	400	100	0	0	<u>20.0 %</u>	100	<u>EDIT KEREKES</u>
679	390	300	90	0	0	<u>23.1 %</u>	90	<u>ANTALNE HORVATH</u>
097	200	140	30	20	10	<u>30.0 %</u>	60	<u>VERONIKA POLYAK</u>
064	250	190	10	10	40	<u>24.0 %</u>	60	<u>ERIKA MUTZHAUSZ</u>
089	80	20	50	10	0	<u>75.0 %</u>	60	<u>VILMOSNF FEKETE</u>
692	110	80	10	10	10	<u>27.3 %</u>	30	<u>JANOSNE PADANYI</u>
680	90	60	10	20	0	<u>33.3 %</u>	30	<u>ERZSEBET MONOSTARI</u>
660	90	70	0	0	20	<u>22.2 %</u>	20	<u>KATALIN DULICZ</u>
397	100	80	5	5	10	<u>20.0 %</u>	20	<u>SANDORNE KULCSAR</u>
100	95	90	5	0	0	<u>5.3 %</u>	5	<u>MARTA CSETKOVICS</u>
TOTAL	6532	4197	1585	440	310	35.7 %	2335	METERS

WEAVER QUALITY HISTORY FROM -- 01/01/89 TO 31/12/89

WEAVER 677 - TIBORNE NICKL

<u>DATE</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>
06/06/89	200	100	50	50	0	50.0 %
07/06/89	300	200	50	20	30	33.3 %
08/06/89	150	140	10	0	0	6.7 %
08/06/89	100	50	25	25	0	50.0 %
09/06/89	300	100	200	0	0	66.7 %
09/06/89	100	30	40	30	0	70.0 %
10/06/89	50	50	0	0	0	0.0 %
11/06/89	250	200	0	40	10	20.0 %
12/06/89	200	90	100	10	0	55.0 %
13/06/89	20	20	0	0	0	0.0 %
13/06/89	100	30	70	0	0	70.0 %
14/06/89	300	100	100	50	50	66.7 %
15/06/89	120	110	0	0	10	8.3 %
16/06/89	300	120	120	50	10	60.0 %
17/06/89	100	90	10	0	0	10.0 %
18/06/89	100	80	10	10	0	20.0 %
23/06/89	100	100	0	0	0	0.0 %
TOTAL :	<u>2790</u>	<u>1610</u>	<u>785</u>	<u>285</u>	<u>110</u>	<u>42.3 %</u>

GREY CLOTH FAULT ANALYSIS BY WEAVER : REPORT PERIOD 07/09/89 TO 10/09/89

		<u>FAULT CODE NUMBERS</u>																		<u>TOTAL</u>	<u>TOTAL</u>	<u>FAULTS</u>	<u>WEAVERS NAME</u>
<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>	<u>12</u>	<u>13</u>	<u>14</u>	<u>15</u>	<u>16</u>	<u>17</u>	<u>18</u>	<u>19</u>	<u>20</u>	<u>FAULTS</u>	<u>PRODN</u>	<u>/100 LM</u>	
0	0	0	0	0	1	0	0	2	0	0	0	0	0	0	0	0	0	0	0	3	18	16.7	ZSUGONITS JUDIT
0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	17	00.0	BOZMAN PIROSKA

FAULTS SUMMARY

	<u>TOTAL FAULTS</u>	<u>% of FAULTS</u>
CODE 1 - WARP FAULTS :	0	0.0 %
CODE 2 - SELVEDGE/CLOTH WARP :	0	0.0 %
CODE 3 - WARP STRIPES (LUSTRE) :	0	0.0 %
CODE 4 - LACING - INCORRECT WRONG WARP :	0	0.0 %
CODE 5 - WEFT STRIPING DUE TO LOOM STOP :	0	0.0 %
CODE 6 - WEFT FAULTS, TONE :	1	33.3 %
CODE 7 - MISSING WEFT PICK :	0	0.0 %
CODE 8 - WEFT STRIPING - WRONG YARN :	0	0.0 %
CODE 9 - WEFT FAULTS, KNOTS, LOOPS ETC :	2	66.7 %
CODE 10 - OILY WARP OR WEFT PICK :	0	0.0 %
CODE 11 - PATTERN FAULT :	0	0.0 %
CODE 12 - OIL STAIN OR DIRTY MARK :	0	0.0 %
CODE 13 - :	0	0.0 %
CODE 14 - SELVEDGE FAULTS :	0	0.0 %
CODE 15 - :	0	0.0 %
CODE 16 - OTHER WEAVING FAULTS :	0	0.0 %
CODE 17 - :	0	0.0 %
CODE 18 - RECURRING WARP STRIPE :	0	0.0 %
CODE 19 - SHADE VARIATIONS :	0	0.0 %
CODE 20 - OTHER YARN FAILURES :	0	0.0 %
 TOTAL FAULTS RECORDED :	 3	 100 %

TOTAL CLOTH PRODUCTION : 35 LM.

AVERAGE FAULTS RECORDED/100 LM = 8.6

QUALITY ANALYSIS SUMMARISED BY LOOM - FROM 07/09/89 - 11/09/89

<u>LOOM</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>	<u>VOLUME OF NON 1st QUALITY</u>
<u>2402</u> :	289	289	0	0	0	<u>00.0 %</u>	<u>0</u>
<u>2320</u> :	35	26	9	0	0	<u>25.9 %</u>	<u>9</u>
<u>6008</u> :	48	22	0	26	0	<u>54.1 %</u>	<u>26</u>
<u>1203</u> :	50	0	50	0	0	<u>100.0 %</u>	<u>50</u>
<u>1202</u> :	95	29	66	0	0	<u>69.5 %</u>	<u>66</u>
TOTAL :	<u>517</u>	<u>366</u>	<u>125</u>	<u>26</u>	<u>0</u>	<u>29.2 %</u>	<u>151</u>

LOOM QUALITY HISTORY FROM - 01/01/89 TO 07/17/91

LOOM : 1210

<u>DATE</u>	<u>SHIFT</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>
06/06/89	C	200	100	50	50	0	50.0 %
06/08/89	C	150	140	10	0	0	6.7 %
06/08/89	A	100	50	25	25	0	50.0 %
06/09/89	C	300	100	200	0	0	66.7 %
06/09/89	B	100	30	40	30	0	70.0 %
06/10/89	C	50	50	0	0	0	0.0 %
06/11/89	C	250	200	0	40	10	20.0 %
06/12/89	C	200	90	100	10	0	55.0 %
06/12/89	B	500	400	100	0	0	20.0 %
06/13/89	A	100	30	70	0	0	70.0 %
06/14/89	C	300	100	100	50	50	66.7 %
06/15/89	C	120	110	0	0	10	8.3 %
06/16/89	C	300	120	120	50	10	60.0 %
06/17/89	C	100	90	10	0	0	10.0 %
06/29/89	A	12	12	0	0	0	0.0 %
06/30/89	A	120	110	10	0	0	8.3 %
TOTAL :		<u>2902</u>	<u>1732</u>	<u>835</u>	<u>255</u>	<u>80</u>	<u>40.3 %</u>

GREY CLOTH FAULT ANALYSIS BY LOOM : REPORT PERIOD 07/09/89 TO 10/09/89

		<u>FAULT CODE NUMBERS</u>																		<u>TOTAL</u>	<u>TOTAL</u>	<u>FAULTS</u>	<u>LOOM CODE</u>
<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>	<u>12</u>	<u>13</u>	<u>14</u>	<u>15</u>	<u>16</u>	<u>17</u>	<u>18</u>	<u>19</u>	<u>20</u>	<u>FAULTS</u>	<u>PRDGN</u>	<u>/100 LM</u>	
22	0	0	0	6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	28	95	29.5	1202
0	5	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	5	50	10.0	1203
0	0	0	0	0	1	0	0	2	0	0	0	0	0	0	0	0	0	0	0	3	35	8.6	2320

FAULTS SUMMARY

	<u>TOTAL FAULTS</u>	<u>% of FAULTS</u>
CODE 1 - WARP FAULTS :	22	61.1 %
CODE 2 - SELVEDGE/CLOTH WARP :	5	13.9 %
CODE 3 - WARP STRIPES (LUSTRE) :	0	0.0 %
CODE 4 - LACING - INCORRECT WRONG WARP :	0	0.0 %
CODE 5 - WEFT STRIPING DUE TO LOOM STOP :	6	16.7 %
CODE 6 - WEFT FAULTS, TONE :	1	2.8 %
CODE 7 - MISSING WEFT PICK :	0	0.0 %
CODE 8 - WEFT STRIPING - WRONG YARN :	0	0.0 %
CODE 9 - WEFT FAULTS, KNOTS, LOOPS ETC :	2	5.6 %
CODE 10 - OILY WARP OR WEFT PICK :	0	0.0 %
CODE 11 - PATTERN FAULT :	0	0.0 %
CODE 12 - OIL STAIN OR DIRTY MARK :	0	0.0 %
CODE 13 - :	0	0.0 %
CODE 14 - SELVEDGE FAULTS :	0	0.0 %
CODE 15 - :	0	0.0 %
CODE 16 - OTHER WEAVING FAULTS :	0	0.0 %
CODE 17 - :	0	0.0 %
CODE 18 - RECURRING WARP STRIPE :	0	0.0 %
CODE 19 - SHADE VARIATIONS :	0	0.0 %
CODE 20 - OTHER YARN FAILURES :	0	0.0 %
TOTAL FAULTS RECORDED :	36	100 %

TOTAL CLOTH PRODUCTION : 180 LM.

AVERAGE FAULTS RECORDED/100 LM = 20.0

QUALITY ANALYSIS SUMMARISED BY MECHANIC - FROM 01/01/89 - 31/12/89

<u>MECHANIC CODE</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON- 1st QUALITY</u>	<u>VOLUME OF NON 1st QUALITY</u>	<u>MECHANICS NAME</u>
09	2050	1110	650	200	90	<u>45.9 %</u>	940	<u>BELA TOTH</u>
25	450	200	200	0	50	<u>55.6 %</u>	250	<u>IMRE SZALAY</u>
06	605	405	120	40	40	<u>33.1 %</u>	200	<u>GYULA MOGYAROSI</u>
07	677	482	120	35	40	<u>28.8 %</u>	195	<u>ATTILA GRACZOL</u>
08	700	510	145	35	10	<u>27.1 %</u>	190	<u>ATTILA GORGYAN</u>
04	480	320	150	10	0	<u>33.3 %</u>	160	<u>FERENC MURAI</u>
05	300	200	20	30	50	<u>33.3 %</u>	100	<u>FERENC PECZA</u>
14	500	400	50	50	0	<u>20.0 %</u>	100	<u>REZSO LEITNER</u>
21	390	300	90	0	0	<u>23.1 %</u>	90	<u>JOZSEF CZAKLER</u>
13	200	140	30	20	10	<u>30.0 %</u>	60	<u>FERENC TOTH</u>
12	90	60	10	20	0	<u>33.3 %</u>	30	<u>ERNO RUZSOVITS</u>
18	90	70	0	0	20	<u>22.2 %</u>	20	<u>GEBOR TOBL</u>
TOTAL	6532	4197	1585	440	310	35.7 %	2335 METERS	

QUALITY ANALYSIS SUMMARISED BY MECHANICAL GROUP - FROM 01/01/89 - 31/12/89

<u>TOTAL</u> <u>INSPECTED</u>	<u>TOTAL 1st</u> <u>QUALITY</u>	<u>TOTAL 2nd</u> <u>QUALITY</u>	<u>TOTAL 3rd</u> <u>QUALITY</u>	<u>TOTAL</u> <u>RAGS</u>	<u>% OF NON-</u> <u>1st QUALITY</u>	<u>VOLUME OF NON</u> <u>1st QUALITY</u>	<u>MECHANICAL</u> <u>GROUP</u>
3427	2102	915	270	140	<u>38.7</u> %	1325	3
1385	925	290	80	90	<u>33.2</u> %	460	2
450	200	200	0	50	<u>55.6</u> %	250	9
700	540	80	70	10	<u>22.9</u> %	160	5
390	300	90	0	0	<u>23.1</u> %	90	7
90	60	10	20	0	<u>33.3</u> %	30	4
90	70	0	0	20	<u>22.2</u> %	20	6
<u>6532</u>	<u>4197</u>	<u>1585</u>	<u>440</u>	<u>310</u>	<u>35.7</u> %	<u>2335</u>	

GREY CLOTH FAULT ANALYSIS BY MECHANIC : REPORT PERIOD 07/09/89 TO 11/09/89

1	2	FAULT CODE NUMBERS																		TOTAL FAULTS	TOTAL PRDN	FAULTS /100 LM	MECHANICS NAME	
		3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20					
22	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	22	45	48.9	POCZA FERENC
0	5	0	0	6	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	11	100	11.0	MAGYAROSI GYULA
0	0	0	0	2	0	0	0	0	0	0	2	0	6	0	0	0	0	0	0	0	10	82	12.1	TRIMML FERENC
7	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	8	26	30.2	MUEZAR TIBOR
0	0	0	0	1	0	0	0	2	0	0	0	0	2	0	0	0	0	0	0	0	5	78	6.4	HEISSENERGER HELMUT
0	0	0	0	0	0	0	0	2	0	0	0	0	2	0	0	0	0	0	0	0	4	40	10.0	PUTSOVITS ERNO
1	0	0	0	0	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	3	65	4.6	NEMETH ANDRAS
0	0	0	0	0	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	2	45	4.3	GYORHARY GYULA

FAULTS SUMMARY

	TOTAL FAULTS	% of FAULTS
CODE 1 - WARP FAULTS :	30	46.2 %
CODE 2 - SELVEDGE/CLOTH WARP :	5	7.7 %
CODE 3 - WARP STRIPES (LUSTRE) :	0	0.0 %
CODE 4 - LACING - INCORRECT WRONG WARP :	0	0.0 %
CODE 5 - WEFT STRIPING DUE TO LOOM STOP :	9	13.8 %
CODE 6 - WEFT FAULTS, TONE :	0	0.0 %
CODE 7 - MISSING WEFT PICK :	0	0.0 %
CODE 8 - WEFT STRIPING - WRONG YARN :	0	0.0 %
CODE 9 - WEFT FAULTS, KNOTS, LOOPS ETC :	9	13.8 %
CODE 10 - DILY WARP OR WEFT PICK :	0	0.0 %
CODE 11 - PATTERN FAULT :	0	0.0 %
CODE 12 - GIL STAIN OR DIRTY MARK :	2	3.1 %
CODE 13 - :	0	0.0 %
CODE 14 - SELVEDGE FAULTS :	10	15.4 %
CODE 15 - :	0	0.0 %
CODE 16 - OTHER WEAVING FAULTS :	0	0.0 %
CODE 17 - :	0	0.0 %
CODE 18 - RECURRING WARP STRIPE :	0	0.0 %
CODE 19 - SHADE VARIATIONS :	0	0.0 %
CODE 20 - OTHER YARN FAILURES :	0	0.0 %
TOTAL FAULTS RECORDED :	65	100 %

TOTAL CLOTH PRODUCTION : 483 LM.

AVERAGE FAULTS RECORDED/100 LM = 13.5

QUALITY ANALYSIS SUMMARISED BY ARTICLE - FROM 01/01/89 - 31/12/89

<u>ARTICLE CODE</u>	<u>ARTICLE NAME</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>	<u>VOLUME OF NON-1st QUALITY</u>
686402	<u>FF.FUGGONY</u>	2290	1320	640	220	110	42.4 %	<u>970</u>
686702	<u>ISABELL</u>	800	490	245	65	0	38.8 %	<u>310</u>
1202966	<u>FATIME</u>	545	290	205	0	50	46.8 %	<u>255</u>
2308058	<u>FIGARO</u>	572	382	160	20	10	33.2 %	<u>190</u>
1402658	<u>VERONA</u>	590	470	50	50	20	20.3 %	<u>120</u>
685601	<u>FANTA</u>	300	200	20	30	50	33.3 %	<u>100</u>
686401	<u>FF. FUGGONY</u>	500	400	100	0	0	20.0 %	<u>100</u>
2307066	<u>ERNA</u>	200	140	30	20	10	30.0 %	<u>60</u>
1407056	<u>PIRAMIS</u>	80	20	50	10	0	75.0 %	<u>60</u>
686301	<u>NILUS</u>	250	190	10	10	40	24.0 %	<u>60</u>
2306660	<u>DOLORES</u>	75	25	50	0	0	66.7 %	<u>50</u>
2308658	<u>PAMINA</u>	110	80	10	10	10	27.3 %	<u>30</u>
2308368	<u>DOLLY</u>	100	80	5	5	10	20.0 %	<u>20</u>
685801	<u>FILOMENA</u>	120	110	10	0	0	8.3 %	<u>10</u>
TOTAL :		<u>6532</u>	<u>4197</u>	<u>1585</u>	<u>440</u>	<u>310</u>	<u>35.7 %</u>	<u>2335</u> METI

ARTICLE QUALITY HISTORY FROM - 01/01/89 - 31/12/89

ARTICLE 686402 - FF.FUGGONY

<u>DATE</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>
06/06/89	200	100	50	50	0	50.0 %
07/06/89	300	200	50	20	30	33.3 %
08/06/89	150	140	10	0	0	6.7 %
09/06/89	300	100	200	0	0	66.7 %
10/06/89	50	50	0	0	0	0.0 %
11/06/89	250	200	0	40	10	20.0 %
12/06/89	200	90	100	10	0	55.0 %
13/06/89	20	20	0	0	0	0.0 %
14/06/89	300	100	100	50	50	66.7 %
15/06/89	120	110	0	0	10	8.3 %
16/06/89	300	120	120	50	10	60.0 %
17/06/89	100	90	10	0	0	10.0 %
TOTAL :	<u>2290</u>	<u>1320</u>	<u>640</u>	<u>220</u>	<u>110</u>	<u>42.4 %</u>

QUALITY ANALYSIS SUMMARISED BY INSPECTOR - FROM 01/01/89 - 31/12/89

<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>TOTAL FAULTS</u>	<u>AV. FAULTS /100 L.M</u>	<u>% OF NON-1st QUALITY</u>	<u>VOLUME OF NON-1st QUALITY</u>	<u>INSPECTOR NOS & SURNAM</u>
1677	1027	475	95	80	534	31.8	<u>38.8 %</u>	650	<u>11 (POLACSEK)</u>
1560	1010	265	155	130	499	32.0	<u>35.3 %</u>	550	<u>12 (CSASZAR)</u>
750	320	320	50	60	274	36.5	<u>57.3 %</u>	430	<u>22 (KOCSIS)</u>
500	300	150	30	20	367	73.4	<u>40.0 %</u>	200	<u>13 (KOVACS)</u>
705	570	115	10	10	123	17.4	<u>19.1 %</u>	135	<u>23 (KOVACSIK)</u>
500	400	50	50	0	55	11.0	<u>20.0 %</u>	100	<u>16 (SZABO)</u>
200	100	50	50	0	41	20.5	<u>50.0 %</u>	100	<u>25 (SZEKENDI)</u>
390	300	90	0	0	45	11.5	<u>23.1 %</u>	90	<u>21 (JOOS)</u>
80	10	60	0	10	33	41.3	<u>87.5 %</u>	70	<u>14 (MIHOCZA)</u>
170	160	10	0	0	23	13.5	<u>5.9 %</u>	10	<u>24 (NAGY)</u>
<u>6532</u>	<u>4197</u>	<u>1585</u>	<u>440</u>	<u>310</u>	<u>1994</u>	<u>30.5</u>	<u>35.7 %</u>	<u>2335</u>	

INSPECTOR QUALITY HISTORY FROM - 01/01/89 TO 31/12/89

INSPECTOR 11 - DEZSONE POLACSEK

<u>DATE</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>TOTAL FAULTS RECORDED</u>	<u>AV. FAULTS /100 L.M</u>	<u>% OF NON-1st QUALITY</u>
13/04/89	100	80	5	5	10	23	23.0	20.0 %
21/05/89	90	60	10	20	0	42	46.7	30.0 %
23/05/89	75	25	50	0	0	55	73.3	50.0 %
24/05/89	250	190	10	10	40	109	43.6	60.0 %
07/06/89	300	200	50	20	30	41	13.7	100.0 %
09/06/89	300	100	200	0	0	56	18.7	200.0 %
09/06/89	100	30	40	30	0	48	48.0	70.0 %
10/06/89	50	50	0	0	0	14	28.0	0.0 %
12/06/89	200	90	100	10	0	117	58.5	110.0 %
17/06/89	100	90	10	0	0	22	22.0	10.0 %
23/06/89	100	100	0	0	0	0	0.0	0.0 %
29/06/89	12	12	0	0	0	7	58.3	0.0 %
TOTAL :	<u>1677</u>	<u>1027</u>	<u>475</u>	<u>95</u>	<u>80</u>	<u>534</u>	<u>31.8</u>	<u>38.8 %</u>

QUALITY ANALYSIS SUMMARISED BY SHIFT - FROM 01/01/89 - 31/12/89

<u>SHIFT</u>	<u>TOTAL INSPECTED</u>	<u>TOTAL 1st QUALITY</u>	<u>TOTAL 2nd QUALITY</u>	<u>TOTAL 3rd QUALITY</u>	<u>TOTAL RAGS</u>	<u>% OF NON-1st QUALITY</u>	<u>VOLUME OF NON 1st QUALITY</u>
B :	1500	1110	215	115	60	<u>26.0 %</u>	<u>390</u>
A :	1807	1142	500	65	100	<u>36.8 %</u>	<u>665</u>
C :	3225	1945	870	260	150	<u>39.7 %</u>	<u>1280</u>
TOTAL :	<u>6532</u>	<u>4197</u>	<u>1585</u>	<u>440</u>	<u>310</u>	<u>35.7 %</u>	<u>2335 METERS</u>

GREY CLOTH FAULT ANALYSIS BY WARP : REPORT PERIOD 17/09/89 TO 17/09/89

<u>WARP</u> <u>ARTICLE</u>	<u>TOTAL</u> <u>PROD</u>	<u>1st</u> <u>QUAL</u>	<u>2nd</u> <u>QUAL</u>	<u>3rd</u> <u>QUAL</u>	<u>4th</u> <u>QUAL</u>	<u>FAULT CODE NUMBERS</u>																						
						<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>	<u>12</u>	<u>13</u>	<u>14</u>	<u>15</u>	<u>16</u>	<u>17</u>	<u>18</u>	<u>19</u>	<u>20</u>			
824 DGRIAN	113	113.4	0.0	0.0	0.0	3	0	0	0	1	1	0	0	3	0	0	0	2	2	0	0	0	0	0	0	0	0	0
825 FELENKA	222	222.0	0.0	0.0	0.0	0	0	0	0	2	0	0	0	3	2	0	0	0	8	0	0	0	0	0	0	0	0	0
826 FELENKA	241	240.6	0.0	0.0	0.0	2	0	0	0	4	0	0	0	9	0	0	0	0	0	0	0	0	0	0	0	0	0	0
827 FELENKA	251	251.0	0.0	0.0	0.0	0	0	0	0	2	0	0	0	4	0	0	0	0	0	0	0	0	0	0	0	0	0	0

FAULTS SUMMARY

	<u>TOTAL FAULTS</u>	<u>% of FAULTS</u>
CODE 1 - LANCFONAL HIBAK :	5	10.4 %
CODE 2 - BOFDACSIK, LIRACSIK :	0	0.0 %
CODE 3 - LANCFENYCSIKOSSAG, PIKKELYESSE :	0	0.0 %
CODE 4 - ELFUZES, ELBORDAZAS :	0	0.0 %
CODE 5 - INDITASI SURU, RITKA CSIK :	9	18.8 %
CODE 6 - VETULEK SZINHISAK :	1	2.1 %
CODE 7 - HIANYOS VETULEK :	0	0.0 %
CODE 8 - VETULEK FENYCSIKOSSAG- ROSSZ F :	0	0.0 %
CODE 9 - VETULEK CSOMOS, MUNKOS :	19	39.6 %
CODE 10 - OLAJOS LANC ES VETULEKFONAL :	2	4.2 %
CODE 11 - MINTAHIBA-KOTESHIBA :	0	0.0 %
CODE 12 - OLAJFOLTON ES ESYEB FOLTOS SIE :	0	0.0 %
CODE 13 - :	2	4.2 %
CODE 14 - SIELEHISAK :	10	20.9 %
CODE 15 - :	0	0.0 %
CODE 16 - EGYEB SZOVESI HIBAK :	0	0.0 %
CODE 17 - :	0	0.0 %
CODE 18 - RAPPORTSZERU LANCCSIKOSSAG :	0	0.0 %
CODE 19 - TARLA, TABLABOL EREDO TORES :	0	0.0 %
CODE 20 - EGYEB FONALHIBAK :	0	0.0 %
TOTAL FAULTS RECORDED :	48	100 %

TOTAL CLOTH PRODUCTION : 227 LM.

AVERAGE FAULTS RECORDED/100 LM = 5.8

GREY CLOTH FAULT ANALYSIS BY NAAP : FOR 17/09/97

<u>LOON</u> <u>NAAP</u>	<u>ARTICLE</u>	<u>TOTAL</u> <u>FREQN</u>	<u>1st</u> <u>QUAL</u>	<u>2nd</u> <u>QUAL</u>	<u>3rd</u> <u>QUAL</u>	<u>4th</u> <u>QUAL</u>	<u>FAULT CODE NUMBERS</u>																				<u>TOTAL</u> <u>FAULTS</u>	<u>FAULTS</u> <u>/100 LB</u>							
							<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>	<u>12</u>	<u>13</u>	<u>14</u>	<u>15</u>	<u>16</u>	<u>17</u>	<u>18</u>	<u>19</u>	<u>20</u>									
1604	1814/10 BORGAN	51.0	51.0	0.0	0.0	0.0	0	0	0	0	1	0	0	0	2	0	0	0	2	2	0	0	0	0	0	0	0	0	0	0	0	7	13.7		
1594	1814/10 BORGAN	34.4	34.4	0.0	0.0	0.0	1	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	2	5.8		
1504	1814/10 BORGAN	28.0	28.0	0.0	0.0	0.0	2	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	3	10.7		
2418	1845/13 PELENKA	7.0	7.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	14.3		
2418	1845/13 PELENKA	45.0	45.0	0.0	0.0	0.0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	5	10.9		
2418	1845/13 PELENKA	45.0	45.0	0.0	0.0	0.0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	2.2		
2418	1845/13 PELENKA	45.0	45.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	6	13.3		
2418	1845/13 PELENKA	58.0	58.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0	
2418	1845/13 PELENKA	7.0	7.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	2	3.4		
2418	1845/13 PELENKA	58.0	58.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	3	5.2	
2312	2013/ 5 PELENKA	51.0	51.0	0.0	0.0	0.0	0	0	0	0	1	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	3	5.5	
2312	2013/ 5 PELENKA	52.0	52.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	5.7		
2312	2013/ 5 PELENKA	17.4	17.4	0.0	0.0	0.0	0	0	0	0	1	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	5.7		
2312	2013/ 5 PELENKA	51.0	51.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	5	9.6	
2312	2013/ 5 PELENKA	17.4	17.4	0.0	0.0	0.0	0	0	0	0	0	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0	
2312	2013/ 5 PELENKA	52.0	52.0	0.0	0.0	0.0	2	0	0	0	1	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0	
2516	2017/ 5 PELENKA	10.0	10.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	3	2.6	
2516	2017/ 5 PELENKA	115.5	115.5	0.0	0.0	0.0	0	0	0	0	1	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0	
2516	2017/ 5 PELENKA	10.0	10.0	0.0	0.0	0.0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0	
2516	2017/ 5 PELENKA	115.5	115.5	0.0	0.0	0.0	0	0	0	0	1	0	0	0	2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0.0

LOOM DOWNTIME ANALYSIS - REPAIRS TO WEARERS

STOPPAGE			REASON			CODE			NUMBERS			TIME AVAIL	TOTAL LOST	LOST TIME	LOOM	
1	2	3	4	5	6	7	8	9	10	11	12	13	(HOURS)	TIME (HRS)	(%)	CODE
0	0	0	1	1	2	0	0	4	5	0	1	0	32.0	14.7	45.9	2305
1	0	2	2	0	2	0	1	0	3	1	1	0	32.0	17.5	54.4	2304
4	0	1	1	0	0	4	1	0	1	0	1	0	48.0	12.5	26.0	1704
0	0	0	1	0	0	0	8	0	0	0	1	0	24.0	10.3	43.1	2302
1	0	0	4	0	0	0	0	1	0	0	3	0	24.0	9.4	39.2	2301
1	0	0	1	2	0	0	2	1	0	0	1	0	24.0	6.7	27.9	2303
2	0	0	0	1	2	0	0	0	0	0	0	0	32.0	4.7	14.6	1205
2	0	0	1	0	0	0	0	0	0	0	0	0	16.0	3.8	23.4	1202
2	0	0	0	0	0	0	0	1	0	0	0	0	8.0	2.7	33.3	1407
1	0	1	0	0	1	0	0	0	0	0	0	0	24.0	2.6	10.8	2513
1	0	0	1	0	0	1	0	0	0	0	0	0	8.0	2.4	30.2	1203
1	0	0	0	0	0	0	1	0	0	0	0	0	8.0	2.0	25.0	1201
1	0	0	0	0	0	0	0	0	0	0	0	0	8.0	1.3	16.7	1305
0	0	0	1	0	0	0	0	0	0	0	0	0	8.0	1.3	15.6	2511
1	0	0	0	0	0	0	0	0	0	0	0	0	8.0	0.9	11.3	1507
0	0	0	0	0	0	0	0	0	0	0	0	0	8.0	0.4	5.2	1705
0	0	0	0	0	0	0	0	0	0	0	0	0	8.0	0.4	5.2	1301
0	0	0	0	0	0	0	0	0	0	0	0	0	8.0	0.4	5.2	1606

LOOM LOST TIME SUMMARY	TOTAL	
	LOST TIME	% LOST TIME
CODE 1 - <u>LOOM REPAIR</u>	: 16.2	26.2 %
CODE 2 - <u>WARP CHANGE</u>	: 0.0	00.0 %
CODE 3 - <u>TYING-IN NEW WARP</u>	: 2.7	3.0 %
CODE 4 - <u>PATTERNING CARD REPAIR/REPLACE</u>	: 14.4	16.0 %
CODE 5 - <u>REPAIR BROKEN WARP END</u>	: 3.4	3.8 %
CODE 6 - <u>REPAIR MULTIPLE BROKEN ENDS</u>	: 5.3	7.5 %
CODE 7 - <u>SERVICE MAINTENANCE</u>	: 5.5	6.1 %
CODE 8 - <u>BEKENDOWN</u>	: 14.0	15.5 %
CODE 9 - <u>WARP SHORTAGE</u>	: 7.9	8.8 %
CODE 10 - <u>WEFT SHORTAGE</u>	: 8.2	9.1 %
CODE 11 - <u>SPACE PART SHORTAGE</u>	: 0.6	0.6 %
CODE 12 - <u>WEAVER SHORTAGE</u>	: 7.4	8.2 %
CODE 13 - <u>MECHANIC SHORTAGE</u>	: 1.0	1.1 %

TOTAL LOOM LOST TIME (HRS) : 90.0 100.0 %

AVERAGE LOST TIME PER LOOM : 27.4 %

LOGON EFFICIENCY ANALYSIS : 01/01/75 TO 01/31/75

<u>LOGON NUMBER</u>	<u>LOST TIME (HOURS)</u>	<u>POSSIBLE PICKS</u>	<u>ACTUAL PICKS</u>	<u>GROSS EFFICIENCY</u>
<u>2365</u>	14.7	3163	1051	34.1 %
<u>2394</u>	13.6	3340	950	28.7 %
<u>1294</u>	12.5	520300	247500	59.8 %
<u>2392</u>	10.3	2374	452	29.7 %
<u>2391</u>	9.4	2996	570	19.8 %
<u>2393</u>	6.7	2160	600	27.8 %
<u>1295</u>	4.7	384000	238000	62.0 %
<u>1292</u>	3.8	137200	165200	86.6 %
<u>1495</u>	2.7	93600	35000	37.4 %
<u>2513</u>	2.6	2736	620	22.7 %
<u>1293</u>	2.4	95000	52000	54.2 %
<u>1291</u>	2.0	100600	44000	43.7 %
<u>1295</u>	1.3	96000	55000	57.3 %
<u>2511</u>	1.3	1006	400	39.7 %
<u>1609</u>	0.7	100600	55000	54.6 %
<u>1795</u>	0.4	85400	79500	92.0 %
<u>1791</u>	0.4	91200	86500	94.8 %
<u>1605</u>	0.4	96000	59750	62.2 %
<u>TOTAL :</u>	<u>90.0</u>	<u>1930438</u>	<u>1222762</u>	<u>63.3 %</u>

WEAVER LOOM STOPPAGE ANALYSIS - 01/01/79 TO 01/31/79

1	STOPPAGE REASON CODE NUMBERS											12	13	TIME WARP (HOURS)	TOTAL LOOM TIME (HRS)	LOOM TIME (%)	WEAVER
	2	3	4	5	6	7	8	9	10	11							
0	0	2	1	1	3	0	0	3	1	0	0	0	0	20.0	10.2	31.5	JENŐNE VISSI
4	0	0	0	0	2	1	1	0	1	0	0	0	0	44.0	6.5	13.5	IREN NAGY
0	0	0	0	0	0	0	0	0	5	0	0	0	0	3.0	4.5	57.5	JULIA TARCSAI
1	0	0	0	0	0	0	0	4	0	0	0	0	0	15.0	4.5	28.1	ERIKA KUTZHAUSE
3	0	1	0	0	0	0	0	1	0	0	0	0	0	15.0	4.5	28.1	MARTA CSETHOVICS
0	0	0	1	0	0	0	0	1	0	0	1	0	0	3.0	4.0	50.0	TEREZ ZISS
0	0	0	1	0	0	0	0	0	0	0	0	0	0	3.0	4.0	50.0	VERONIKA POLYAK
0	0	0	0	0	0	3	0	0	0	0	1	0	0	2.0	3.8	47.9	PALNE ACS
0	0	0	3	0	0	0	0	0	0	0	0	0	0	3.0	3.8	46.9	KIRALYNE FUZI
0	0	0	0	0	0	0	4	0	0	0	0	0	0	2.0	3.7	45.8	VIKTORNE HORVATH
0	0	0	2	0	0	0	2	0	0	0	0	1	0	3.0	3.5	45.6	GYULANE KRANETI
0	0	0	1	0	0	0	1	0	0	0	1	0	0	3.0	3.3	43.7	JENŐNE MESTAKOS
1	0	0	0	0	0	0	1	0	0	1	0	0	0	3.0	2.9	37.5	TEREZ FARKAS
0	0	0	1	0	0	0	0	0	2	0	0	0	0	2.0	2.9	36.5	FERENCNE RASZTOVICS
2	0	0	1	0	0	0	0	0	0	0	0	0	0	2.0	2.8	36.5	SANDORNE II TAKACS
2	0	0	0	0	0	0	0	1	0	0	0	0	0	3.0	2.7	35.4	JOZSEFNE KOVACS
0	0	0	0	0	2	0	0	0	0	0	0	0	0	2.0	2.6	32.3	ISTVANNÉ II HORVATH
1	0	0	1	0	0	1	0	0	0	0	0	0	0	3.0	2.4	30.2	LASZLONE SZASTVARGOSI
1	0	0	0	0	0	0	0	1	0	0	0	0	0	2.0	2.2	27.1	ISTVANNÉ HORVATH
1	0	0	0	0	0	0	0	1	0	0	0	0	0	3.0	1.7	20.5	KRISZTINA HRUSTYAK
1	0	0	1	0	0	0	0	0	0	0	0	0	0	3.0	1.7	20.8	IMRENE VARGA
1	0	0	0	0	0	0	0	0	0	0	0	0	0	3.0	1.7	16.7	JOZSEFNE CIUPPON
0	0	0	0	1	0	0	0	0	0	0	0	0	0	3.0	1.2	14.6	ANASTAZIA GOSZTOLA
1	0	0	0	0	0	0	0	0	0	0	0	0	0	3.0	1.0	12.5	GYORGYNE SEBESTYEN
1	0	0	0	0	0	0	0	0	0	0	0	0	0	2.0	0.9	11.5	IREN BALOGH
0	0	0	0	0	0	0	0	0	0	0	0	0	0	2.0	0.8	11.5	VILMOSNE FEVETE
0	0	0	0	0	0	0	0	0	0	0	0	0	0	2.0	0.8	9.4	PALNE FARIANOVICS
0	0	0	0	0	0	0	0	0	0	0	0	0	0	2.0	0.8	9.4	ANDRASNE BOKOR

LOOM LOST TIME SUMMARY	TOTAL LOST TIME	% LOST TIME
CODE 1 - <u>LOOM REPAIR</u> :	18.2	20.2 %
CODE 2 - <u>WARP CHANGE</u> :	0.0	00.0 %
CODE 3 - <u>TYING-IN NEW WARP</u> :	2.7	3.0 %
CODE 4 - <u>PATTERNING CARD REPAIR/REPLACE</u> :	14.4	16.0 %
CODE 5 - <u>REPAIR BROKEN WARP END</u> :	3.4	3.8 %
CODE 6 - <u>REPAIR MULTIPLE BROKEN ENDS</u> :	6.8	7.5 %
CODE 7 - <u>SERVICE MAINTENANCE</u> :	5.5	6.1 %
CODE 8 - <u>BREAKDOWN</u> :	14.0	15.6 %
CODE 9 - <u>WARP SHORTAGE</u> :	7.7	8.3 %
CODE 10 - <u>WEFT SHORTAGE</u> :	8.2	9.1 %
CODE 11 - <u>SPARE PART SHORTAGE</u> :	0.6	0.6 %
CODE 12 - <u>WEAVER SHORTAGE</u> :	7.4	8.2 %
CODE 13 - <u>MECHANIC SHORTAGE</u> :	1.0	1.1 %
TOTAL LOOM LOST TIME (HRS) :	90.0	100.0 %
AVERAGE LOST TIME PER WEAVER :	27.4 %	

WEAVER EFFICIENCY ANALYSIS : 01/01/89 TO 31/12/89

<u>WEAVER NAME</u>	<u>LOST TIME (HOURS)</u>	<u>POSSIBLE PICKS</u>	<u>ACTUAL PICKS</u>	<u>GROSS EFFICIENCY</u>
<u>JENŐNE VIGDÉ</u>	10.2	3552	1380	38.9 %
<u>IRÉN NAGY</u>	8.5	744000	582250	75.6 %
<u>JULIA TASCZAI</u>	4.6	792	150	18.9 %
<u>ERIKA MUTZHAUSZ</u>	4.5	1704	212	12.4 %
<u>MARTA CSENYOVICS</u>	4.5	201600	92500	45.9 %
<u>TEREZ ZISS</u>	4.0	792	320	40.4 %
<u>VERONIKA POLYAK</u>	4.0	960	190	19.8 %
<u>PALNE ACS</u>	3.8	100800	39000	38.7 %
<u>MIMALYNE FUZI</u>	3.8	960	190	19.8 %
<u>VIKTORNE HORVATH</u>	3.7	792	170	21.5 %
<u>GYULANE KRANITZ</u>	3.5	720	330	45.8 %
<u>JENŐNE MESZAROS</u>	3.3	840	250	29.8 %
<u>TEREZ FARKAS</u>	3.0	792	210	26.5 %
<u>FERENCNE RASZTOVICS</u>	2.9	840	100	11.9 %
<u>SANDORNE II TAKACS</u>	2.9	840	350	41.7 %
<u>JOZSEFNE KOVACS</u>	2.9	93600	50600	54.2 %
<u>ISTAVANNE II HORVATH</u>	2.7	93600	35000	37.4 %
<u>SANDORNE I TAKACS</u>	2.6	792	280	35.4 %
<u>LASZLONE SZASZVAROSI</u>	2.4	96000	52000	54.2 %
<u>ISTAVANNE HORVATH</u>	2.2	720	70	9.7 %
<u>KRISZTINA KRUSTYAK</u>	1.7	960	190	19.8 %
<u>IRÉNE VARGA</u>	1.7	100800	61500	61.0 %
<u>JOZSEFNE CZUPPON</u>	1.3	96000	55000	57.3 %
<u>ANASZTAZIA GOSZTOLA</u>	1.2	96000	45500	47.4 %
<u>GYORGYNE SERESTYEN</u>	1.0	720	200	27.8 %
<u>IRÉN BALOGH</u>	0.9	93600	75800	81.0 %
<u>VILNOSNE FEKETE</u>	0.9	100800	55000	54.6 %
<u>PALNE FABIANKOVICS</u>	0.8	912	120	13.2 %
<u>ANDRASNE ROKOR</u>	0.8	96000	54500	56.8 %

MECHANIC DOWNTIME ANALYSIS : 01/01/79 TO 31/12/79

<u>STOPPAGE REASON CODE NUMBERS</u>													<u>TIME AVAIL</u> <u>(HOURS)</u>	<u>TOTAL LOST</u> <u>TIME (HRS)</u>	<u>LOST TIME</u> <u>(%)</u>	<u>MECHANIC</u>	
<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>6</u>	<u>7</u>	<u>8</u>	<u>9</u>	<u>10</u>	<u>11</u>	<u>12</u>	<u>13</u>					
0	0	2	2	2	2	0	5	0	3	0	3	0	0	40.0	19.5	46.5	FERENC TRINKL
5	0	0	2	0	2	1	3	0	0	0	0	0	0	56.0	12.5	21.9	FERENC PECZA
0	0	0	6	0	0	0	4	0	0	0	1	0	0	32.0	11.3	36.7	HELMUT HEISSENRE
5	0	0	1	0	0	0	2	2	0	1	1	0	0	32.0	9.8	30.5	ERNO RUIZSOVITS
2	0	0	0	0	0	3	0	0	1	0	1	0	0	40.0	7.7	19.2	GYULA HOSYAROSI
0	0	0	1	1	0	0	0	4	0	0	1	0	0	16.0	7.5	46.9	FERENC TOTI
4	0	1	1	1	0	1	0	0	0	0	0	0	0	32.0	7.2	22.4	FERENC KUKAI
1	0	0	0	0	0	0	0	0	5	0	0	0	0	24.0	5.4	22.6	ZOLTEN NAGY
2	0	0	0	0	0	0	0	0	1	0	0	0	0	8.0	2.7	33.3	ATTILA GORGTAN
0	0	0	0	0	2	0	0	0	0	0	0	0	0	8.0	2.6	32.3	REZSO LEITNER
1	0	1	0	0	1	0	0	0	0	0	0	0	0	24.0	2.6	19.8	LASZLO IVAN
0	0	0	1	0	0	0	0	0	0	0	0	0	0	8.0	1.5	15.6	KAROLY KANTICH
1	0	0	0	0	0	0	0	0	0	0	0	0	0	8.0	0.9	11.5	JOZSEF GOMINEK

<u>LOOM LOST TIME SUMMARY</u>	<u>TOTAL</u> <u>LOST TIME</u>	<u>% LOST TIME</u>
CODE 1 - <u>LOOM REPAIR</u>	: 18.2	20.2 %
CODE 2 - <u>WARP CHANGE</u>	: 0.0	00.0 %
CODE 3 - <u>TYING-IN NEW WARP</u>	: 2.7	3.0 %
CODE 4 - <u>PATTERNING CARD REPAIR/REPLACE</u>	: 14.4	16.0 %
CODE 5 - <u>REPAIR BROKEN WARP END</u>	: 3.4	3.8 %
CODE 6 - <u>REPAIR MULTIPLE BROKEN ENDS</u>	: 6.8	7.5 %
CODE 7 - <u>SERVICE MAINTENANCE</u>	: 5.5	6.1 %
CODE 8 - <u>BREXDOWN</u>	: 14.0	15.6 %
CODE 9 - <u>WARP SHORTAGE</u>	: 7.9	8.8 %
CODE 10 - <u>WEFT SHORTAGE</u>	: 3.2	3.6 %
CODE 11 - <u>SPARE PART SHORTAGE</u>	: 0.6	0.6 %
CODE 12 - <u>WEAVER SHORTAGE</u>	: 7.4	8.2 %
CODE 13 - <u>MECHANIC SHORTAGE</u>	: 1.0	1.1 %
<u>TOTAL LOOM LOST TIME (HRS)</u>	: 90.0	100.0 %
<u>AVERAGE LOST TIME PER MECHANIC</u>	: 27.4 %	

MECHANIC EFFICIENCY ANALYSIS : 01/01/67 TO 31/12/67

<u>MECHANIC</u>	<u>LOST TIME (HOURS)</u>	<u>POSSIBLE PICKS</u>	<u>ACTUAL PICKS</u>	<u>GROSS EFFICIENCY</u>	<u>MECHANIC NAME</u>
10	18.5	4152	1232	29.7 %	<u>FERENC TRANK</u>
05	12.3	669600	420000	71.7 %	<u>FERENC PECLA</u>
11	11.8	3312	810	24.5 %	<u>HELMUT HEISSENBECKER</u>
12	9.2	3312	570	17.2 %	<u>ERNO RUTSGVITS</u>
06	7.7	477600	274500	57.4 %	<u>GYULA HOSYAROSI</u>
13	7.5	1534	650	41.9 %	<u>FERENC TOTI</u>
04	7.2	333800	234500	69.3 %	<u>FERENC MERAI</u>
15	5.4	183192	139400	76.1 %	<u>IGLICH NASTY</u>
02	2.7	93600	35000	37.4 %	<u>ATTILA GOROVAN</u>
14	2.6	792	260	35.4 %	<u>REISO LEITNER</u>
19	2.6	2736	620	22.7 %	<u>LESLLO IVAN</u>
16	1.3	1608	400	39.7 %	<u>KAROLY KANITCH</u>
17	0.9	100800	55000	54.6 %	<u>JOSEEF DOMINEK</u>
TOTAL:	99.0	1930488	1222762	63.3 %	

ARTICLE EFFICIENCY ANALYSIS : 01/01/69 TO 31/12/69

<u>ARTICLE</u>	<u>ARTICLE NAME</u>	<u>LOST TIME (HOURS)</u>	<u>POSSIBLE PIQS</u>	<u>ACTUAL PIQS</u>	<u>GROSS EFFICIENCY</u>
685701	FELICIA	14.7	3162	1020	32.1 %
2306058	FIGARO	13.6	3260	950	29.1 %
2307056	EENA	13.3	9494	5752	60.6 %
685402	FF.FUGGORY	10.4	37600	20600	54.8 %
1407056	PIERRE	9.4	2320	570	24.6 %
685301	NILUS	8.6	47792	27220	57.0 %
2308058	FANTINA	6.7	2160	600	27.8 %
685401	FF. FUGGORY	4.7	167200	115000	68.8 %
685601	FANTA	3.6	187200	165000	88.1 %
685302	NINIVE	2.8	374400	264750	70.9 %
685702	ISAACELL	1.3	96000	55000	57.3 %
2308059	BELLY	0.9	100000	55000	55.0 %
<u>TOTAL :</u>		<u>90.0</u>	<u>1970482</u>	<u>1222760</u>	<u>62.0 %</u>

WARP COMPLETION FORECAST : ASSUMED EFFICIENCY 75 %

<u>LOOM</u>	<u>ARTICLE</u>	<u>NAME</u>	<u>PICKS REQD</u> <u>(*100)</u>	<u>SPEED</u> <u>(PPM)</u>	<u>WEAVING TIME</u> <u>(HOURS)</u>
2513	686301	<u>NILUS</u>	1180	190	13.8
2517	2306660	<u>DOLORES</u>	1700	190	19.9
2520	686301	<u>NILUS</u>	1800	200	20.0
2516	1202966	<u>FATIME</u>	2000	190	23.4
2514	686302	<u>NINIVE</u>	2300	190	26.9
2301	1407056	<u>PIRAMIS</u>	2520	200	28.0
2511	2307066	<u>ERNA</u>	2800	210	29.6
2512	686702	<u>ISABELL</u>	2900	200	32.2
2515	2308658	<u>PAMINA</u>	2900	190	33.9
2304	2308058	<u>FIGARO</u>	3050	175	38.7
2305	685701	<u>FELICIA</u>	3210	165	43.2
2303	2308658	<u>PAMINA</u>	4170	150	61.8
2519	686401	<u>FF. FUGGONY</u>	4350	200	48.3
2518	686402	<u>FF. FUGGONY</u>	4650	190	54.4
2302	2307066	<u>ERNA</u>	6198	165	83.5

WIDTH EFFICIENCY ANALYSIS : 19/09/89 TO 20/09/89

<u>LOOM WIDTH</u>	<u>LOST TIME</u> <u>(HOURS)</u>	<u>POSSIBLE</u> <u>PICKS</u> <u>(* 100)</u>	<u>ACTUAL</u> <u>PICKS</u> <u>(* 100)</u>	<u>PICKS</u> <u>/HOUR</u>	<u>GROSS</u> <u>EFFICIENCY</u>
175	38.8	90564	78081	10609	86.2 %
180	11.0	44870	40984	11137	91.3 %
330	69.2	25656	9126	3803	35.6 %
<u>TOTAL :</u>	<u>119.0</u>	<u>161090</u>	<u>128191</u>		<u>79.6 %</u>

APPENDIX 7 - SAMPLE LOOM SPAREPART REPORTS

LOOM SPARE-PART CONSUMPTION - FROM 01/01/89 TO 31/12/89

LOOM NUMBER : 1201

<u>DATE</u>	<u>SPARE PART NAME</u>	<u>SPARE PART CODE NUMBER</u>	<u>QUANTITY ISSUED</u>	<u>PART COST</u>	<u>TOTAL VALUE OF PARTS</u>
18/06/89	0011 KEZI KEREK	10200080	1	605.20	605.2
07/07/89	SZORITOC SAP 216-2-22	10200223	2	31.20	62.4
07/07/89	0028 FEKBETET	10200300	2	95.50	191.0
07/07/89	0031 ALLITOC SAVAR	10200380	2	53.00	106.0
07/07/89	0033 RUGO	10200390	1	31.20	31.2
07/07/89	0034 RUGO	10200430	2	48.10	96.2
07/07/89	CSAP	10200493	1	28.90	28.9
07/07/89	0037 ZAROC SAPSZEG	10200500	2	27.00	54.0
09/07/89	FÉKSZALAG	10200297	1	91.70	91.7
			<u>14</u>		<u>1266.6</u>

SPARE-PART ISSUES SUMMARISED BY LOOM - FROM 01/01/89 TO 31/12/89

<u>LOOM</u>	<u>LOOM TYPE / WIDTH</u>	<u>QUANTITY OF PARTS ISSUED</u>	<u>TOTAL VALUE OF PARTS ISSUED</u>
1312	: SZTB / 175 Cms	1	0.0
1212	: SZTB / 175 Cms	1	34.3
1611	: SZTB / 175 Cms	1	38.4
1605	: SZTB / 175 Cms	2	39.6
1702	: SZTB / 175 Cms	1	52.5
1407	: SZTB / 175 Cms	1	53.0
1206	: SZTB / 175 Cms	2	54.0
1409	: SZTB / 175 Cms	2	54.0
1401	: SZTB / 175 Cms	2	57.8
1404	: SZTB / 175 Cms	2	57.8
1501	: SZTB / 175 Cms	2	68.6
1704	: SZTB / 175 Cms	8	84.8
1412	: SZTB / 175 Cms	2	96.2
1202	: SZTB / 175 Cms	3	221.2
1705	: SZTB / 175 Cms	9	257.0
1406	: SZTB / 175 Cms	2	283.0
1211	: SZTB / 175 Cms	6	342.6
1311	: SZTB / 175 Cms	1	368.5
1201	: SZTB / 175 Cms	14	1266.6
1502	: SZTB / 175 Cms	2	1448.9
1204	: SZTB / 175 Cms	5	2861.9
1606	: SZTB / 175 Cms	3	4138.5
	<u>TOTAL</u> :	<u>72</u>	<u>11879.2</u>

SPARE-PART ISSUES RANKED BY PART CODE - FROM 01/01/89 TO 31/12/89

<u>SPARE-PART CODE</u>	<u>SPARE PART NAME</u>	<u>QUANTITY OF PARTS ISSUED</u>	<u>PART COST</u>	<u>TOTAL VALUE OF PARTS ISSUED</u>
10100220	1311 KONZOL	6	1379.50	8277.0
10170033	BALLONKEPZO DUGO	2	141.50	283.0
10200080	0011 KEZI KEREK	1	605.20	605.2
10200150	0016 TUZOORSO	4	19.80	79.2
10200160	0019 SZORITOC SAP	6	34.30	205.8
10200164	SZORITOC SAP	1	0.00	0.0
10200213	1335 TARCSA 100%	1	52.50	52.5
10200220	0023 SZORITOC SAP	1	36.30	36.3
10200223	SZORITOC SAP 216-2-22	2	31.20	62.4
10200224	SZORITOC SAP	2	0.00	0.0
10200233	TARCSA	3	69.40	208.2
10200234	TARCSA	3	0.00	0.0
10200297	FEKSZALAG	1	91.70	91.7
10200300	0028 FEKBETET	2	95.50	191.0
10200380	0031 ALLITOC SAVAR	4	53.00	212.0
10200390	0033 RUGO	1	31.20	31.2
10200400	1341 CSAP	1	38.40	38.4
10200430	0034 RUGO	4	48.10	192.4
10200450	0035 OSSZEKOTOLEC	1	181.60	181.6
10200493	CSAP	8	28.90	231.2
10200500	0037 ZAROC SAPSZEG	10	27.00	270.0
10200604	INDITOKARUTKOZO	4	0.00	0.0
10200693	SZIJTARCSA 216-2-69	3	87.20	261.6
10200830	0045 TENGELY	1	368.50	368.5
<u>TOTAL</u>		<u>72</u>		<u>11879.2</u>

SPARE-PART ISSUES RANKED BY STOCK QUANTITY - FROM 01/01/89 TO 31/12/89

<u>SPARE-PART CODE</u>	<u>SPARE PART NAME</u>	<u>QUANTITY OF PARTS ISSUED</u>	<u>PART COST</u>	<u>TOTAL VALUE OF PARTS ISSUED</u>
10200213	1335 TARC ... 100%	1	52.50	52.5
10200220	0023 SZOF ... CSAP	1	36.30	36.3
10200297	FÉKSZALAG	1	91.70	91.7
10200450	0035 OSSZEKOTOLEC	1	181.60	181.6
10200400	1341 CSAP	1	38.40	38.4
10200164	SZORITOC SAP	1	0.00	0.0
10200830	0045 TENGELY	1	368.50	368.5
10200080	0011 KEZI KERÉK	1	605.20	605.2
10200390	0033 RUGO	1	31.20	31.2
10200223	SZORITOC SAP 216-2-22	2	31.20	62.4
10200224	SZORITOC SAP	2	0.00	0.0
10170033	BALLONKEPZO DUGO	2	141.50	283.0
10200300	0028 FEKBETET	2	95.50	191.0
10200233	TARCSA	3	69.40	208.2
10200234	TARCSA	3	0.00	0.0
10200693	SZIJTARCSA 216-2-69	3	87.20	261.6
10200380	0031 ALLITOC SA VAR	4	53.00	212.0
10200430	0034 RUGO	4	48.10	192.4
10200604	INDITOKARUTKOZO	4	0.00	0.0
10200150	0016 TUZDORSO	4	19.80	79.2
10100220	1311 KONZOL	6	1379.50	8277.0
10200160	0019 SZORITOC SAP	6	34.30	205.8
10200493	CSAP	8	28.90	231.2
10200500	0037 ZAROC SAP SZEG	10	27.00	270.0
<u>TOTAL</u>		<u>72</u>		<u>11879.2</u>

LOOM SPAPE PART STOCK : LISTED BY PART-CODE

<u>CODE NUMBER</u>	<u>PART DE: IPTION</u>	<u>UNIT COST</u>	<u>STOCK</u>	<u>STOCK VALUE</u>
10100220	<u>1311 KONZOL</u>	1379.50	29	40005.5
10100420	<u>1313 MENETESRUD</u>	135.00	10	1350.0
10170013	<u>TARTOLAP</u>	91.70	4	366.8
10170023	<u>BILINCS</u>	91.70	5	458.5
10170033	<u>BALLONKEPZO DUGO</u>	141.50	9	1273.5
10200020	<u>0006 SKALA</u>	240.30	0	0.0
10200060	<u>0009 ALATET</u>	6.20	2	12.4
10200063	<u>0009 ALATET</u>	3.60	3	10.8
10200073	<u>REZ SZEGECS 216-2-7</u>	5.40	40	216.0
10200074	<u>REZ SZEGECS</u>	0.00	9	0.0
10200080	<u>0011 KEZI KEREK</u>	605.20	18	10893.6
10200090	<u>0012 SZIJTARCSA</u>	2282.00	34	77588.0
10200094	<u>MEGHAJTOSZIJTARCSA</u>	0.00	23	0.0
10200096	<u>SZIJTARCSA</u>	319.50	25	7987.5
10200100	<u>KUPLUNG KERESZT</u>	329.30	20	6586.0
10200110	<u>ATMENETI CSATLAKOZO</u>	48.10	40	1924.0
10200120	<u>0015 MEGH.TENGEI.Y</u>	1063.20	1	1063.2
10200123	<u>0015 MEGHAJTOTENGELY</u>	699.50	2	1399.0
10200124	<u>MEGHAJTOTENGELY</u>	0.00	7	0.0
10200126	<u>MEGHAJTOTENGELY</u>	113.90	5	569.5
10200140	<u>0017 KUPOS PERSELY</u>	70.60	0	0.0
10200150	<u>0016 TUZOORSO</u>	19.80	4	79.2
10200153	<u>OSSZEKOTCSAVAR</u>	8.90	0	0.0
10200160	<u>0019 SZORITOC SAP</u>	34.30	2	68.6
10200163	<u>SZARITOC SAP</u>	32.90	5	164.5
10200164	<u>SZORITOC SAP</u>	0.00	4	0.0
10200170	<u>0020 ALATET</u>	361.30	3	1083.9
10200180	<u>0021 CSUSZKA</u>	129.80	6	778.8
10200190	<u>0022 RUGO</u>	208.30	8	1666.4
10200200	<u>1334 TAMCSAPAGY</u>	200.30	19	3805.7
10200210	<u>1335 TAMASZTO ALATET</u>	174.40	39	6801.6
10200213	<u>1335 TARCSA 100%</u>	52.50	0	0.0
10200220	<u>0023 SZORITOC SAP</u>	36.30	2	72.6
10200223	<u>SZORITOC SAP 216-2-22</u>	31.20	1	31.2
10200224	<u>SZORITOC SAP</u>	0.00	5	0.0
10200233	<u>TARCSA</u>	69.40	3	208.2
10200234	<u>TARCSA</u>	0.00	7	0.0
10200240	<u>0024 TENG.KAPCS.KAR</u>	592.70	3	1778.1
10200260	<u>0025 SZAB.TAM.CSAVAR</u>	18.70	8	149.6
10200290	<u>0027 FEKSZALAG</u>	106.80	5	534.0
10200297	<u>FEKSZALAG</u>	91.70	8	733.6
10200300	<u>0028 FEKBETET</u>	95.50	6	573.0
10200380	<u>0031 ALLITOC SA VAR</u>	53.00	12	636.0
10200390	<u>0033 RUGO</u>	31.20	15	468.0
10200400	<u>1341 CSAP</u>	38.40	8	307.2
10200430	<u>0034 RUGO</u>	48.10	16	769.6
10200450	<u>0035 OSSZEKOTOLEC</u>	181.60	18	3268.8
10200493	<u>CSAP</u>	28.90	17	491.3
10200500	<u>0037 ZAROC SAPS ZEG</u>	27.00	18	486.0
10200520	<u>0038 FOGANTYU</u>	19.60	3	58.8
10200540	<u>0039 HATAROLO</u>	89.00	9	801.0
10200600	<u>0040 INDITOKARUTKOZO</u>	19.60	0	0.0
10200603	<u>0043 INDITOKARUTKOZO</u>	8.90	0	17.8
10200604	<u>INDITOKARUTKOZO</u>	0.00	0	0.0
10200693	<u>SZIJTARCSA 216-2-69</u>	87.20	0	0.0
10200694	<u>MOTORSZIJT.216-2-69</u>	0.00	4	0.0
10200696	<u>MOTORSZIJTARCSA</u>	43.60	5	218.0
10200830	<u>0045 TENGEI.Y</u>	368.50	9	3316.5

LOOM SPARE PART STOCK : LISTED BY STOCK QUANTITY

<u>CODE NUMBER</u>	<u>PART DESCRIPTION</u>	<u>UNIT COST</u>	<u>STOCK</u>	<u>STOCK VALUE</u>
10200020	<u>0006 SKALA</u>	240.30	0	0.0
10200213	<u>1335 TARCSEA 100%</u>	52.50	0	0.0
10200693	<u>SZIJTARCSA 216-2-69</u>	87.20	0	0.0
10270014	<u>TAVTARTOgyURU</u>	0.00	0	0.0
10300100	<u>2392 GYURU</u>	11.60	0	0.0
10250036	<u>FEKSZALAG</u>	405.40	0	0.0
10200600	<u>0040 INDITOKARUTKOZO</u>	19.60	0	0.0
10300010	<u>1366 KAR</u>	213.60	0	0.0
10200153	<u>OSSZEKOTCSAVAR</u>	8.90	0	0.0
10200140	<u>0017 KUPOS PERSELY</u>	70.60	0	0.0
10300250	<u>0071 KOZBETET</u>	96.50	0	0.0
10300260	<u>0072 KOZ.BET.HUVELY</u>	33.20	1	33.2
10200223	<u>SZORITOCsAP 216-2-22</u>	31.20	1	31.2
10200604	<u>INDITOKARUTKOZO</u>	0.00	1	0.0
10300236	<u>TENG.FOGASKEREKkel</u>	206.50	1	206.5
10200120	<u>0015 MEGH.TENGELY</u>	1063.20	1	1063.2
10250044	<u>MEGHAJTOKERESZT</u>	0.00	1	0.0
10200950	<u>2374 TENGELY</u>	237.60	2	475.2
10200123	<u>0015 MEGHAJTOTENGELY</u>	699.50	2	1399.0
10200060	<u>0009 ALATET</u>	6.20	2	12.4
10200220	<u>0023 SZORITOCsAP</u>	36.30	2	72.6
10300020	<u>0053 GORGO</u>	99.70	2	199.4
10200603	<u>0043 INDITOKARUTKOZO</u>	8.90	2	17.8
10200160	<u>0019 SZORITOCsAP</u>	34.30	2	68.6
10300246	<u>0070 PERSELY JAV.</u>	1295.00	3	3885.0
10250030	<u>0052 FEKSZALAG 3-1</u>	1104.50	3	3313.5
10200170	<u>0020 ALATET</u>	361.30	3	1083.9
10300110	<u>0060 GORGO</u>	29.10	3	87.3
10200233	<u>TARCSEA</u>	69.40	3	208.2
10300090	<u>0059 BUTYKOSTARCSEA</u>	184.80	3	554.4
10200063	<u>0009 ALATET</u>	3.60	3	10.8
10200240	<u>0024 TENG.KAPCS.KAR</u>	592.70	3	1778.1
10200520	<u>0038 FOGANTYU</u>	19.60	3	58.8
10200694	<u>MOTORSZIJT.216-2-69</u>	0.00	4	0.0
10200150	<u>0016 TUZDOORSO</u>	19.80	4	79.2
10250050	<u>2379 FEKDOB</u>	2749.20	4	10996.8
10170013	<u>TARTOLAP</u>	91.70	4	366.8
10200164	<u>SZORITOCsAP</u>	0.00	4	0.0
10300130	<u>0062 KIEGY.ALATET</u>	6.20	4	24.8
10300040	<u>0055 GYURU</u>	184.90	4	739.6
10200163	<u>SZORITOCsAP</u>	32.90	5	164.5
10200126	<u>MEGHAJTOTENGELY</u>	113.90	5	569.5
10300270	<u>0073 TARCSEA</u>	61.40	5	307.0
10200224	<u>SZORITOCsAP</u>	0.00	5	0.0
10200290	<u>0027 FEKSZALAG</u>	106.80	5	534.0
10250020	<u>0051 KRSZT.KOMPL.1-2</u>	2694.30	5	13471.5
10300070	<u>0057 HAZ</u>	1054.40	5	5272.0
10300160	<u>KULONLEGES ALATET</u>	12.50	5	62.5
10200696	<u>MOTORSZIJTARCSEA</u>	43.60	5	218.0
10170023	<u>BILINCS</u>	91.70	5	458.5
10200300	<u>0028 FEKBETET</u>	95.50	6	573.0
10200180	<u>0021 CSUSZKA</u>	129.80	6	778.8
10300230	<u>0069 TENG.FOG.KEREK</u>	4484.70	6	26908.2
10201013	<u>UTKOZO</u>	16.90	6	101.4
10300050	<u>0056 CSAPSZEG</u>	69.50	6	417.0
10250046	<u>0000 KRSZT.KOMPL.JAV</u>	673.70	6	4042.2
10300200	<u>0067 GYURU</u>	543.80	7	3806.6
10200234	<u>TARCSEA</u>	0.00	7	0.0

SPARE-PART USAGE & STOCK FORECAST - FROM 01/01/89 TO 31/12/89

<u>PART CODE</u>	<u>SPARE PART NAME</u>	<u>QUANTITY ISSUED</u>	<u>CURRENT STOCK</u>	<u>ANNUAL CONSUMPTION</u>	<u>SPARE PART STOCK (WEEKS)</u>
10100220	1311 KONZOL	6	20	6	173
10170033	BALLONKEPZO DUGO	2	9	2	233
10200080	0011 KEZI KEREK	1	18	1	933
10200150	0016 TUZOORSO	4	4	4	52
10200160	0019 SZORITOC SAP	6	2	6	17
10200164	SZORITOC SAP	1	4	1	207
10200213	1335 TARCSA 100%	1	0	1	0
10200220	0023 SZORITOC SAP	1	2	1	104
10200223	SZORITOC SAP 216-2-22	2	1	2	26
10200224	SZORITOC SAP	2	5	2	130
10200233	TARCSA	3	3	3	52
10200234	TARCSA	3	7	3	121
10200297	FÉK SZALAG	1	8	1	415
10200300	0028 FEKBETET	2	6	2	156
10200380	0031 ALLITOC SA VAR	4	12	4	156
10200390	0033 RUGO	1	15	1	778
10200400	1341 CSAP	1	8	1	415
10200430	0034 RUGO	4	16	4	207
10200450	0035 OSSZEKOTOLEC	1	18	1	933
10200493	CSAP	8	17	8	110
10200500	0037 ZAROC SAPS ZEG	10	18	10	93
10200604	INDITOKARUTKOZO	4	1	4	13
10200693	SZIJTARCSA 216-2-69	3	0	3	0
10200830	0045 TENGELY	1	9	1	467

TOTAL 72 203

AVERAGE SPARE-PART STOCK POSITION = 241,3

APPENDIX 8 - SAMPLE YARN STOCK REPORTS

SOPRON REPORT ON YARN ISSUES

<u>BATCH</u>	<u>CODE NUMBER</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>DATE</u>	<u>QTY ISSUED</u>	<u>COST</u>
7278	095194400514	VISCOZ FENYES	333	42	71-80	S SDR	STURKE	09/10/89	300 290.55
1723	001043122044	100 % VICOS FENYES	35.6	12	251-275	S=Z CE	UNDYED	14/08/89	590 293.55
4942	060161404818	PES FENYES NENSZUG	167	42	1351-1400	S SDR	MOGYORO	08/08/89	800 321.91
7278	095194400514	VISCOZ FENYES	333	42	71-80	S SDR	STURKE	31/07/89	400 290.55
2384	379227682714	86% AC 14% NYLON ROUCLE	769	200	426-450	S SDR	BRANDY	30/07/89	500 359.95
8115	281068240302	PES FENYES	50	24	41-60	PARKUZ	DRAPP	29/07/89	450 367.20
1723	001043122044	100 % VICOS FENYES	35.6	12	251-275	S=Z CE	UNDYED	08/07/89	600 293.55
2384	379227682714	86% AC 14% NYLON ROUCLE	769	200	426-450	S SDR	BRANDY	30/06/89	350 359.95
4942	060161404818	PES FENYES NENSZUG	167	42	1351-1400	S SDR	MOGYORO	30/05/89	300 321.81
4942	060161404818	PES FENYES NENSZUG	167	42	1351-1400	S SDR	MOGYORO	04/04/89	500 321.81

SOPRON REPORT ON YARN RECEIPTS

<u>BATCH</u>	<u>CODE NUMBER</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>YARN SUPPLIER</u>	<u>DATE</u>	<u>STOCK</u>	<u>COST</u>
8115	281068240302	PES FENYES	50	24	41-80	PARRUZ DRAPP	MARURENI	01/09/89	7000	367.20
7278	095194400514	VISCOZ FENYES	333	42	71-80	S SODR SZURKE	VERRE TEXTILE	03/07/89	1355	290.55
4942	060161404818	PES FENYES HEMSZUG	167	42	1351-1400	S SODR MUGYORO	REXOR S.A	02/03/89	5000	321.21
1723	001043122044	100 % VICOS FENYES	35.6	12	251-275	S=Z CE UNDYED	LEITZTEIT	02/02/89	800	293.55
2384	379227682714	86% AC 14% NYLON BOUCLE	769	200	426-450	S SODR BRANGY	MEXIKO FILOFIBRA	05/01/89	4000	359.93

SOPRON CURRENT YARN STOCK POSITION

<u>DATE</u>	<u>BATCH</u>	<u>CODE NUMBER</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>STOCK</u>	<u>COST</u>	<u>STOCK VALUE</u>
02/02/89	1723 2	001043122044	100 X VICOS FENYES	35.6	12	251-275	S=Z CE UNDYED	800	293.55	234840
05/01/89	2384 1	379227682714	86% AC 14% NYLON BOUCLE	769	200	426-450	S SDR BRANDY	4000	359.95	1439800
02/03/89	4942 1	060161404818	PES FENYES NENSIUG	167	42	1351-1400	S SDR MOGYORD	5000	321.81	1609050
03/03/89	7278 1	095194400514	VISCOZ FENYES	333	42	71-80	S SDR SZURKE	1355	290.55	393695
01/09/89	8115 1	281058240302	PES FENYES	50	24	41-60	PARHUI GRAPP	7000	367.20	2570400
TOTAL :								<u>18155</u>		<u>6247785</u>

S O P R O N R E D U N D A N T Y A R N S T O C K P O S I T I O N (YARN RECEIVED PRIOR TO - 30/04/89)

<u>DATE</u>	<u>BATCH</u>	<u>CODE NUMBER</u>	<u>YARN DESCRIPTION</u>	<u>DIEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>LUSTRE</u>	<u>TEXTURE</u>	<u>STOCK</u>	<u>COST</u>	<u>STOCK VALUE</u>
06/01/89	2384 1	379227682714	86Z AC 14Z NYLON BOUCLE	769	200	426-450	S SODR BRANDY	FM	SET	4000	359.95	1439800
02/02/89	1723 2	001043122044	100 Z VICOS FENYES	35.6	12	251-275	S=Z CE UNDYED	FM	SET	800	293.55	234840
02/03/89	4942 1	060161404818	PES FENYES KEMZUG	167	42	1351-1400	S SODR NOGYORO	MA	POY	5000	321.81	1609050
03/03/89	7278 1	095194400514	VISCOZ FENYES	333	42	71-80	S SODR SEURKE	MA	POY	1355	290.55	393695
<u>TOTAL :</u>										<u>11155</u>		<u>3677385</u>

SOPRON REPORT ON YARN QUALITY PROBLEMS

<u>BATCH</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>SUP-CODE</u>	<u>YARN SUPPLIER</u>	<u>DATE</u>	<u>STOCK</u>	<u>COMPLAINT</u>
3280	VISCOS FENYES ELOWENGER RESPONSE TO COMPLAINT : 10 % DISCOUNT RECEIVED	84.7	24	71-80	Z SDR	SARGA	04 ICI	01/01/89	200	UNEVENNESS
1271	100 % VICOS FENYES RESPONSE TO COMPLAINT : 10 % DISCOUNT OFFERED	167	0	551-600	Z SDR	UNDYED	04 ICI	06/03/89	800	WEAK YARN
8115	PES FENYES RESPONSE TO COMPLAINT : NO COMPENSATION	50	24	41-60	FARHUZ	DRAPP	04 ICI	01/09/89	1000	EXCESSIVE KNOTS
7278	VISCOZ FENYES RESPONSE TO COMPLAINT : 20 % DISCOUNT RECEIVED	333	42	71-80	S SDR	SZURKE	16 VERRE TEXTILE	03/03/89	100	UNLEVEL DYEING
1723	100 % VICOS FENYES RESPONSE TO COMPLAINT : NO COMPENSATION RECEIVED	35.6	12	251-275	S-Z CE	UNDYED	36 LEITZETIT	02/02/89	400	THICKNESS VARIATION
2384	86% AC 14% NYLON BOUCLE RESPONSE TO COMPLAINT : 15 % DISCOUNT	769	200	426-450	S SDR	BRANDY	56 MEXIKO FILDIFIBRA	06/01/89	290	DYE VARIATION
1276	PE SET N25 TREV POY SZ RESPONSE TO COMPLAINT : NO COMPENSATION	75.7	32	141-150	S SDR	UNDYED	72 NEFF CO	02/11/89	120	UNLEVEL YARN.
1105	PE FR N25 CREP TORL NYUJT RESPONSE TO COMPLAINT : NO COMPENSATION	109.8	24	0-20	Z SDR	UNDYED	75 NORDFASEV	04/05/89	900	UNLEVEL YARN

SOPRON REPORT ON YARN RETURNED TO SUPPLIERS

<u>BATCH</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>SUP-CODE</u>	<u>YARN SUPPLIER</u>	<u>DATE</u>	<u>QTY RETURNED</u>	<u>COMPLAINT</u>
7278	VISCOZ FENYES RESPONSE TO COMPLAINT :	333	42	71-60	S SDR	STURKE	16 VERRE TEXTILE	08/07/89	300	THICK & THIN PLACES
1723	100 Z VICOS FENYES RESPONSE TO COMPLAINT :	35.6	12	251-275	S=2 CE	UNDYED	36 LEIZETEIT	12/11/89	200	OIL STAINS IN YARN

S O P R C N R E P O R T O N S U R P L U S Y A R N S A L E S

<u>BATCH</u>	<u>Y A R N</u>	<u>D E S C R I P T I O N</u>	<u>D T E X</u>	<u>F I L A M E N T</u>	<u>T W I S T</u>	<u>S H A D E</u>	<u>S A L E D A T E</u>	<u>C O S T</u>	<u>S A L E P R I C E</u>	<u>Q T Y S O L D</u>	<u>S A L E S V A L U E</u>	<u>Y A R N B U Y E R</u>
1276	FE SET	N2S TREV POY SZ	75.7	32	141-150	S SDR UNDYED	06/06/89	291.74	10.00	200	2000	HUNGARIAN KNITTERS
1271	100 I	VICOS FENYES	167	0	551-600	I SDR UNDYED	06/08/89	275.77	5.00	100	500	THE KNITTING CO
7278	VISCOZ	FENYES	333	42	71-80	S SDR SZURKE	03/03/89	290.55	7.50	150	1125	FULLY FASHIONED PLC
TOTAL :										450	3625	

SOPRON REPORT ON SURPLUS YARN WRITTEN-OFF

<u>BATCH</u>	<u>YARN DESCRIPTION</u>	<u>DTEX</u>	<u>FILAMENT</u>	<u>TWIST</u>	<u>SHADE</u>	<u>SALE DATE</u>	<u>COST</u>	<u>QTY WRITTEN-OFF</u>	<u>BOOK VALUE</u>	
1271	100 X VICOS FENYES	167	0	551-600	Z SDDR	UNDYED	08/09/89	275.77	900	248193
1276	PE SET NZS TREV POY SZ	75.7	32	141-150	S SDDR	UNDYED	07/08/89	291.74	700	204213
1105	PE FM NZS CREP TORL NYUJT	109.8	24	0-20	Z SDDR	UNDYED	06/08/89	134.15	1000	134150
7273	VISCOZ FENYES	333	42	71-80	S SDDR	SZURKE	03/03/89	290.55	350	101693
								TOTAL :	2950	638254

APPENDIX 9 - SAMPLE WAGE REPORTS

MECHANICS WAGE REPORT : FROM 01/09/89 TO 30/09/89

MECHANIC : 01 - GYORVARY GYULA

<u>LOOM</u>	<u>ARTICLE</u>	<u>INSPECTED</u>	<u>1st QUALITY</u>		<u>2nd QUALITY</u>		<u>3rd QUALITY</u>		<u>TOTAL</u>	<u>TOTAL</u>	
			<u>METERS</u>	<u>FL/MT</u>	<u>PAY</u>	<u>METERS</u>	<u>FL/MT</u>	<u>PAY</u>			<u>METERS</u>
6002	CSABA	45.0	45.0	2.00	92.0	0.0	1.00	0.0	0.00	0.0	92.0
6003	CSABA	33.5	33.5	2.00	67.0	0.0	1.00	0.0	0.00	0.0	67.0
6006	CSABA	41.0	41.0	2.00	82.0	0.0	1.00	0.0	0.00	0.0	82.0
6007	CSABA	20.3	20.3	2.00	40.6	0.0	1.00	0.0	0.00	0.0	40.6
6010	CSABA	42.0	42.0	2.00	84.0	0.0	1.00	0.0	0.00	0.0	84.0
6011	CSABA	36.5	36.5	2.00	73.0	0.0	1.00	0.0	0.00	0.0	73.0
6012	CSABA	45.0	45.0	2.00	90.0	0.0	1.00	0.0	0.00	0.0	90.0

TOTAL : 264.3 264.3 528.6 0.0 0.0 0.0 0.0 0.0 528.6

TOTAL WEAVER WAGES = 528.6 Ft

MECHANIC WAGES = 317.2 Ft

QUALITY DISTRIBUTION OF WEAVING OUTPUT FROM 01/09/69 TO 01/10/69

WEAVER	NAME	INSPECTED	1st QUALITY	2nd QUALITY	3rd QUALITY	TOTAL	TOTAL
			METERS	METERS	METERS	RAGS	PAY
001	KISS MARIANN	277.9	203.6	33.7	35.4	0.0	0.00
002	MEZO MONIKA	229.1	173.0	39.1	17.0	0.0	0.00
003	MOLNAR RITA	513.0	473.0	0.0	40.0	0.0	0.00
004	ROZMAN SZILVIA	61.0	36.0	25.0	0.0	0.0	0.00
005	MARKUS SZILVIA	709.2	629.2	31.0	49.0	0.0	0.00
006	KOZAK SZILVIA	633.7	633.7	0.0	0.0	0.0	0.00
008	FUZI TUNDE	62.0	46.0	16.0	0.0	0.0	0.00
014	NYITKAI CECILIA	36.0	36.0	0.0	3.0	3.0	0.00
015	HARGITAI HELEA	40.0	40.0	0.0	0.0	0.0	0.00
052	SIKALY ERZSEBET	29.0	0.0	0.0	29.0	0.0	0.00
053	FAZEKAS IMRENE	36.0	36.0	0.0	0.0	0.0	0.00
054	LANG ISTAVANNE	349.5	322.5	27.0	0.0	0.0	0.00
061	KISS TEREZ	256.7	197.9	0.0	58.9	0.0	0.00
062	BIHARI BARBARA	782.7	615.9	107.3	22.0	37.5	0.00
065	FENEKE JOZSEFNE	318.4	290.0	23.4	0.0	5.0	0.00
072	CZETIN ANDREA	445.7	445.7	0.0	0.0	0.0	0.00
080	VARGA TIBORNE	558.2	510.5	47.7	0.0	0.0	0.00
083	VISSI JENONE	449.1	374.1	75.0	0.0	0.0	0.00
085	SOS ISDA	422.1	422.1	0.0	0.0	0.0	0.00
088	KRANITZ GYULANE	671.5	671.5	0.0	0.0	0.0	0.00
093	DARABOS PETERNE	309.6	219.8	53.0	36.8	0.0	0.00
095	FARJANKOVICS PALNE	459.9	459.9	0.0	0.0	0.0	0.00
097	TARCSAI JULIA	599.0	545.1	12.9	0.0	31.0	0.00
098	BALASKO ERNONE	246.0	210.0	36.0	0.0	6.0	0.00
100	CSEIKOVICS MARTA	611.6	589.6	31.0	0.0	0.0	0.00
351	KOVACS JOZSEFNE	959.5	863.4	66.1	0.0	0.0	0.00
355	NAGY IREN	427.5	380.4	47.1	0.0	0.0	0.00
357	ZERGI ATTILANE	484.9	427.9	57.0	0.0	0.0	0.00
359	KASZA JANDOSNE	637.7	637.7	0.0	0.0	0.0	0.00
360	ABRAHAM TIMEA	381.3	313.3	32.0	33.0	3.0	0.00
362	STALAI IMRENE	346.3	300.3	0.0	0.0	0.0	0.00
366	NEMETH MIKLOSNE	1094.9	1045.9	49.0	0.0	0.0	0.00
367	VISSI IMRENE	716.0	716.0	0.0	0.0	0.0	0.00
369	KOLOSSVARI ENDRENE	17.0	0.0	0.0	17.0	0.0	0.00
373	FUZI MIHALYNE	544.9	436.5	80.6	27.8	0.0	0.00
375	KETI IMRENE	679.7	648.3	31.4	0.0	0.0	0.00
378	TOTH PALNE	34.8	34.8	0.0	0.0	0.0	0.00
382	TAKACS SANDORNE I	554.2	479.3	74.9	0.0	0.0	0.00
386	BALAZS FERENCNE	31.0	0.0	0.0	31.0	0.0	0.00
391	MESZAROS F. JENONE	521.0	436.0	44.0	41.0	0.0	0.00
396	HORVATH VIKTORNE	228.1	228.1	0.0	0.0	0.0	0.00
397	KULCSAR SANDORNE	924.7	821.1	72.6	0.0	31.0	0.00
652	SZIGETI MARIA	519.3	439.9	79.4	0.0	0.0	0.00
657	KISS GYULANE	344.4	299.4	45.0	0.0	0.0	0.00
660	BULICZ KATALIN	270.1	209.1	46.0	0.0	15.0	0.00
662	RASITOVICS FERENCNE	43.0	0.0	0.0	26.0	17.0	0.00
665	TRINYL FERENCNE	778.2	740.4	37.8	0.0	0.0	0.00
666	BALOGH IREN	481.7	481.7	0.0	0.0	0.0	0.00
673	POISSAI SANDORNE	509.5	488.0	0.0	0.0	21.5	0.00
675	GOSITOLA GYULANE	712.8	698.7	0.0	0.0	14.1	0.00
677	NICOL TIBORNE	615.7	615.7	0.0	0.0	0.0	0.00
679	HORVATH ISTVANNE II	603.1	603.1	0.0	0.0	0.0	0.00
679	HORVATH ANTALNE	79.0	0.0	0.0	38.0	0.0	0.00
680	MCHOSTOR ERZSEBET	567.7	441.7	23.0	38.0	0.0	0.00
684	NAGY ISOLYA	60.0	60.0	0.0	0.0	0.0	0.00
692	PADANYI JANDOSNE	723.9	583.6	99.3	0.0	41.0	0.00
693	BOKOR ANDRASNE	270.8	243.8	0.0	27.0	0.0	0.00
695	FARKAS TEREZ	367.4	312.4	49.0	0.0	0.0	0.00

WEAVERS WAGE REPORT : FROM 11/09/89 TO 19/09/89

WEAVER : 001 - MISS MARIANN

LOGN	ARTICLE	INSPECTED	1st QUALITY		2nd QUALITY	PAY-RATE		2nd QUALITY	3rd QUALITY	PAY-RATE		3rd QUALITY	TOTAL	TOTAL
			METERS	PAY		PAY	METERS			PAY	METERS		PAY	PAGS
1604	DOLORES	51.0	51.0	1.50	76.5	0.0	0.75	0.0	0.0	0.00	0.0	0.0	0.0	76.5
1617	PANINA	5.2	5.2	3.00	15.6	0.0	1.50	0.0	0.0	0.00	0.0	0.0	0.0	15.6
1703	NINIVE	35.4	0.0	2.00	0.0	0.0	1.00	0.0	35.4	0.00	0.0	0.0	0.0	0.0
2503	PIRAMIS	25.3	25.3	2.00	50.6	0.0	1.00	0.0	0.0	0.00	0.0	0.0	0.0	50.6
2504	PIRAMIS	27.1	27.1	2.00	54.2	0.0	1.00	0.0	0.0	0.00	0.0	0.0	0.0	54.2
2510	PIRAMIS	33.7	0.0	2.00	0.0	33.7	1.00	33.7	0.0	0.00	0.0	0.0	0.0	33.7
2512	PIRAMIS	40.0	40.0	2.00	80.0	0.0	1.00	0.0	0.0	0.00	0.0	0.0	0.0	80.0
2513	PIRAMIS	23.0	23.0	2.00	46.0	0.0	1.00	0.0	0.0	0.00	0.0	0.0	0.0	46.0
5003	NILUS	32.0	32.0	2.00	64.0	0.0	1.00	0.0	0.0	0.50	0.0	0.0	0.0	64.0
5004	NILUS	5.2	5.2	2.00	10.4	0.0	1.00	0.0	0.0	0.50	0.0	0.0	0.0	10.4
TOTAL :		277.9	209.8		397.3	33.7		33.7	35.4		0.0	0.0	0.0	431.0

TOTAL PIECE RATE WAGES = 431.0 Ft
WEAVER WAGE SUPPLEMENT 0.0% = 0.0 Ft
GRAND TOTAL OF WAGES DUE = 431.0 Ft

APPENDIX 10 - STRUCTURE OF MAIN DATA FILES

Appendix 10.1

Structure of file QUALITY.DBF

FIELD	TYPE	WIDTH	DESCRIPTION
ARTICLE	C	10	ARTICLE CODE
WEAVER	C	3	WEAVER CODE
LOOM	C	4	LOOM CODE
MECHCODE	C	2	LOOM MECHANIC CODE
MECH_GRP	C	2	MECHANICAL GROUP OF LOOM
DATE	D	8	DATE OF QUALITY ENTRY
CHECKER	C	3	CODE OF GREY CLOTH INSPECTOR
TOTAL_M	N	8,1	TOTAL METERS EXAMINED
TOT_1ST	N	8,1	TOTAL METERS GRADED AS 1st QUALITY
TOT_2ND	N	8,1	TOTAL METERS GRADED AS 2nd QUALITY
TOT_3RD	N	8,1	TOTAL METERS GRADED AS 3rd QUALITY
TOT_RAGS	N	8,1	TOTAL METERS GRADED AS WASTE
NON_1ST	N	8,1	TOTAL VOLUME NON-1ST QUALITY CLOTH
SHIFT	C	1	SHIFT ON WHICH CLOTH WAS PRODUCED
FAULT_1	N	5	TOTAL FAULTS FOUND FOR CODE Nos 1.
FAULT_2	N	5	TOTAL FAULTS FOUND FOR CODE Nos 2.
FAULT_3	N	5	TOTAL FAULTS FOUND FOR CODE Nos 3.
FAULT_4	N	5	TOTAL FAULTS FOUND FOR CODE Nos 4.
FAULT_5	N	5	TOTAL FAULTS FOUND FOR CODE Nos 5.
FAULT_6	N	5	TOTAL FAULTS FOUND FOR CODE Nos 6.
FAULT_7	N	5	TOTAL FAULTS FOUND FOR CODE Nos 7.
FAULT_8	N	5	TOTAL FAULTS FOUND FOR CODE Nos 8.
FAULT_9	N	5	TOTAL FAULTS FOUND FOR CODE Nos 9.
FAULT_10	N	5	TOTAL FAULTS FOUND FOR CODE Nos 10.
FAULT_11	N	5	TOTAL FAULTS FOUND FOR CODE Nos 11.
FAULT_12	N	5	TOTAL FAULTS FOUND FOR CODE Nos 12.
FAULT_13	N	5	TOTAL FAULTS FOUND FOR CODE Nos 13.
FAULT_14	N	5	TOTAL FAULTS FOUND FOR CODE Nos 14.
FAULT_15	N	5	TOTAL FAULTS FOUND FOR CODE Nos 15.
FAULT_16	N	5	TOTAL FAULTS FOUND FOR CODE Nos 16.
FAULT_17	N	5	TOTAL FAULTS FOUND FOR CODE Nos 17.
FAULT_18	N	5	TOTAL FAULTS FOUND FOR CODE Nos 18.
FAULT_19	N	5	TOTAL FAULTS FOUND FOR CODE Nos 19.
FAULT_20	N	5	TOTAL FAULTS FOUND FOR CODE Nos 20.
TOTFAULT	N	7	SUM TOTAL OF ALL FAULTS RECORDED
WARP	C	4	WARP CODING
PIECE	N	2	WARP PIECE NUMBER
CHAR	C	1	PIECE DESCRIPTION CODE
RATE_1	N	6,2	PAY RATE FOR THE 1st QUALITY CLOTH
RATE_2	N	6,2	PAY RATE FOR THE 2nd QUALITY CLOTH
RATE_3	N	6,2	PAY RATE FOR THE 3rd QUALITY CLOTH
TOTPAY	N	6,2	TOTAL PAY EARNED BY THE WEAVER

Appendix 10.2

Structure of the file PRODO.DBF

LOOM	C	4	LOOM CODE
WEAVER	C	3	WEAVER CODE
MECH_GRP	C	2	MECHANICAL GROUP OF LOOM
MECHCODE	C	2	LOOM MECHANIC CODE
ARTICLE	C	10	ARTICLE CODE
SHIFT	C	1	SHIFT ON WHICH CLOTH WAS PRODUCED
DATE	D	8	DATE OF PRODUCTIVITY ENTRY
PICKS	N	6	ACTUAL NUMBER OF PICKS INSERTED
POSSPICK	N	6	MAXIMUM NUMBER OF PICKS POSSIBLE
SPEED	N	4	LOOM SPEED IN RPM
TIME	N	6	DURATION OF SHIFT IN MINUTES
DT1	N	3	LOST TIME DUE TO DOWNTIME CODE 1.
DT2	N	3	LOST TIME DUE TO DOWNTIME CODE 2.
DT3	N	3	LOST TIME DUE TO DOWNTIME CODE 3.
DT4	N	3	LOST TIME DUE TO DOWNTIME CODE 4.
DT5	N	3	LOST TIME DUE TO DOWNTIME CODE 5.
DT6	N	3	LOST TIME DUE TO DOWNTIME CODE 6.
DT7	N	3	LOST TIME DUE TO DOWNTIME CODE 7.
DT8	N	3	LOST TIME DUE TO DOWNTIME CODE 8.
DT9	N	3	LOST TIME DUE TO DOWNTIME CODE 9.
DT10	N	3	LOST TIME DUE TO DOWNTIME CODE 10.
DT11	N	3	LOST TIME DUE TO DOWNTIME CODE 11.
DT12	N	3	LOST TIME DUE TO DOWNTIME CODE 12.
DT13	N	3	LOST TIME DUE TO DOWNTIME CODE 13.
DT14	N	3	LOST TIME DUE TO DOWNTIME CODE 14.
DT15	N	3	LOST TIME DUE TO DOWNTIME CODE 15.
DT16	N	3	LOST TIME DUE TO DOWNTIME CODE 16.
DT17	N	3	LOST TIME DUE TO DOWNTIME CODE 17.

Appendix 10.3

Structure of the file PARTISSU.DBF

PARTCODE	C	8	LOOM SPARE-PART CODE
QTY	N	2	LOOM SPARE-PART ISSUE QUANTITY
DATE	D	8	LOOM SPARE-PART ISSUE DATE
LOOM	C	4	CODE OF LOOM RECEIVING SPARE-PART

Structure of file PARTSTOC.DBF

PARTCODE	C	8	LOOM SPARE-PART CODE
STOCK	N	5	LOOM SPARE-PART STOCK QUANTITY

Appendix 10.4

Structure of the file LOOMAST.DBF

FIELD	TYPE	WIDTH	DESCRIPTION
-----	-----	-----	-----
LOOM	C	4	LOOM CODE
ARTICLE	C	10	ARTICLE CODE
SPEED	N	4	LOOM SPEED RPM
PICKNOW	N	5	PRESENT LOOM PICK COUNTER READING
PICKEND	N	5	FINAL EXPECTED PICK COUNTER READING
PICKNEED	N	5	TOTAL PICKS REQUIRED
PICKIN	N	5	PICKS INSERTED ON CURRENT WARP
PICKTOGO	N	5	PICKS STILL TO BE INSERTED
CLOTHLEN	N	4	EXPECTED CLOTH LENGTH (Meters)
WARP	C	4	WARP CODE

APPENDIX 11 - SUMMARY OF APPLICATION FILES

DATABASE FILES (.dbf EXTENSION)

SUBCONT.DBF	CLOTHERR.DBF	LOOMSTOP.DBF	ARTICLE2.DBF
TEMP4.DBF	YARTWIST.DBF	TEMPIN.DBF	PARTOUT.DBF
BAD.DBF	BAD2.DBF	BAD3.DBF	TEMP7.DBF
MECH1.DBF	MECH2.DBF	TEMP8.DBF	YARCQL.DBF
PRODD.DBF	BAD1.DBF	YARCNT.DBF	BAD4.DBF
BAD5.DBF	BAD6.DBF	BAD7.DBF	TEMPOUT.DBF
WEAVER.DBF	BAD8.DBF	INSPECT.DBF	YARPACK.DBF
BAD9.DBF	BAD10.DBF	YARBACK.DBF	BAD11.DBF
BAD12.DBF	BAD13.DBF	YARINP.DBF	YAROUT.DBF
DON3.DBF	TEMP3.DBF	FCST1.DBF	FCST2.DBF
SPARES.DBF	YARNAME.DBF	LOOMPROD.DBF	YARFIL.DBF
YARDIR.DBF	YARNSUP.DBF	YARNREJ.DBF	WEAV1.DBF
PRCD1.DBF	WEAV2.DBF	LOOM2.DBF	ART1.DBF
MECHANIC.DBF	DON4.DBF	LOOMS.DBF	PARTSTOC.DBF
PARTISSU.DBF	YARN.DBF	YARSALE.DBF	YARBUY.DBF
YARWRITE.DBF	PICKREAD.DBF	BAD30.DBF	92027260.DBF
61864214.DBF	LASZLO.DBF	LASZLO2.DBF	WAGE1.DBF
LOOMAST.DBF	WAGERATE.DBF	ARTICLE.DBF	WAGE2.DBF
QUALITY.DBF	WAGES2.DBF	WAGES3.DBF	WAGE6.DBF

These are the system data files used to hold all the data that the system requires to produce output reports. These files are always given the extension .dbf by dBase IV.

PROGRAMME/COMMAND FILES (.prg EXTENSION)

NSOPRON.PRG	FIBINP.PRG	SOPOUT.PRG	SOPRON.PRG
SOPDBASE.PRG	SOPADD.PRG	PARTSTOC.PRG	SOPVIEW.PRG
SOPEDIT.PRG	SOPREPO.PRG	ART1ADD.PRG	ARTEDIT.PRG
ART1.PRG	SOPQUAL.PRG	ARTQUAL.PRG	BLANK4.PRG
SOPDATA.PRG	BLANK5.PRG	WEAVQUAL.PRG	LOOMQUAL.PRG
MECHQUAL.PRG	FLTQUAL.PRG	MECHADD.PRG	QUAL_7.PRG
SPARADD.PRG	INSPQUAL.PRG	BLANK3.PRG	SOPSTOCK.PRG
SUBADD.PRG	PARTUSE.PRG	PARTSIN.PRG	P2_MULTI.PRG
LOOMADD.PRG	REP2.PRG	WEAVADD.PRG	STOPADD.PRG
FAULTADD.PRG	INSPQL2.PRG	SOPINDEX.PRG	YARNVIEW.PRG
QUAL_8.PRG	QUAL_2.PRG	WEAVREPO.PRG	MESSAGE.PRG
LOOMREPO.PRG	MECHREPO.PRG	YARET.PRG	PICKAWAY.PRG
DATAVIEW.PRG	WIPEOUT.PRG	DATAEDIT.PRG	SOPINP.PRG
QUALADD.PRG	MTLADD.PRG	PARTOUT.PRG	YARADD.PRG
PARTIN.PRG	QUAL_9.PRG	PARTSORT.PRG	INSPADD.PRG
ARTADD.PRG	ART2ADD.PRG	BLANK2.PRG	FLTQUAL2.PRG
ARTVIEW.PRG	YARBACK.PRG	QUALDAY.PRG	LOOMQL2.PRG
ARTQUAL2.PRG	QUAL_3.PRG	QUAL_4.PRG	WEAVQL2.PRG
QUAL_6.PRG	YARNADD.PRG	REP3.PRG	YARNEDIT.PRG
PLURAL.PRG	REP4.PRG	REP5.PRG	REP6.PRG
REP7.PRG	S_MULTI.PRG	YARNREPO.PRG	LOOMSPAR.PRG
PARTOT.PRG	SINGLOOM.PRG	PARTRANK.PRG	QUAL_5.PRG
PARTFCST.PRG	YARSTK_1.PRG	WAGES.PRG	CNTADD.PRG
P3_MULTI.PRG	YARSTK_2.PRG	P4_MULTI.PRG	PRODADD.PRG
PTSTK_1.PRG	YARN_1.PRG	YARN_2.PRG	YARN_3.PRG
YARN_4.PRG	YARN_5.PRG	YARN_6.PRG	YARN_7.PRG
YARN_8.PRG	P5_MULTI.PRG	YARNSTK.PRG	YARN_9.PRG
P6_MULTI.PRG	YARSTK_4.PRG	PRODINP.PRG	YARINP.PRG
YARSALE.PRG	YAROUT.PRG	YARSTK_3.PRG	YARSTK_5.PRG
LOOMAST.PRG	GYAKORLO.PRG	YARNREJ.PRG	P7_MULTI.PRG
WARNING1.PRG	WARNING2.PRG	PROD1.PRG	WARPROD.PRG
LOOMDATA.PRG	WEAV1.PRG	P1_MULTI.PRG	WEAV2.PRG
MECHQL2.PRG	REASON.PRG	PROD2.PRG	MECH2.PRG
MECH1.PRG	P_MULTI.PRG	FILADD.PRG	TWSTADD.PRG
Q_MULTI.PRG	TWDESC.PRG	REASON2.PRG	PACKADD.PRG
Q1_MULTI.PRG	Q2_MULTI.PRG	Q3_MULTI.PRG	Q4_MULTI.PRG
Q5_MULTI.PRG	Q6_MULTI.PRG	Q7_MULTI.PRG	Q8_MULTI.PRG
Q9_MULTI.PRG	Q10_MULT.PRG	SUPADD.PRG	SHADADD.PRG
QUAL_0.PRG	FLTWARP.PRG	DAYWARP.PRG	NSOPDB.PRG
GEPSZ.PRG	BUYADD.PRG	DESCADD.PRG	HASTUPJ.PRG
YARSTK_7.PRG	YARADJ.PRG	YARWRITE.PRG	YARMOVE.PRG
YARSTK_8.PRG	YARSTK_6.PRG	SOPPROD.PRG	WEAVWAGE.PRG
WEAVSUM.PRG	REDUCER.PRG	RATEINFO.PRG	MECHWAGE.PRG

These are the command files which contain the programming code to tell the system which tasks it must perform. Each of these files with the extension .prg is designated as a source file in ASCII format and when the programme is implemented an object file written in machine code is compiled by the system and given the same file name but with an extension of .dbo instead of .prg.

REPORT FORMS (.frm EXTENSION)

ARTY.FRM	WEAVY.FRM	LOOMY.FRM	MECHY2.FRM
PARTSTOC.FRM	WEAVER.FRM	INSP.FRM	LOOMS.FRM
SPARES.FRM	MECHANIC.FRM	CLOTHERR.FRM	LOOMSTOP.FRM
SUBCONT.FRM	WEAVFLT.FRM	LOOMFLT.FRM	PARTISSU.FRM
INSPECT.FRM	ARTICLE.FRM	ARTDAY.FRM	INSPECT2.FRM
LOOMDAY.FRM	WEAVDAY.FRM	ARTY2.FRM	WEAVY2.FRM
SHIFTY.FRM	LOOMY2.FRM	LCOMSPAR.FRM	SINGLOOM.FRM
PARTOT.FRM	PARTRANK.FRM	MECHY.FRM	FORECAST.FRM
YARNAME.FRM	YARCNT.FRM	YARFIL.FRM	YARTWIST.FRM
YARDIR.FRM	YARPACK.FRM	YARCOL.FRM	YARNSUP.FRM
YARN4.FRM	YARN3.FRM	YARN2.FRM	YARN1.FRM
WARPOUT.FRM	PRODQL.FRM	WEAVQL.FRM	WEAVEFF.FRM
LOOMEFF.FRM	ARTEFF.FRM	MECHFLT.FRM	MECHEFF.FRM
MECHQL.FRM	PTSTK_1.FRM	WARPFLT.FRM	DAYFLT.FRM
GYAKORLO.FRM	YARN5.FRM	LASZLO.FRM	YARBUY.FRM
YARN7.FRM	YARN8.FRM	YARN6.FRM	WAGEY.FRM
WAGEY2.FRM	WAGEY3.FRM		

These are the files created from the system report designer which customise the format of output reports produced from the system. When this file is created dBase IV automatically creates a second file with the same name but having the extension *.frg which contains the programming code required to make the report. When an output report is finally printed the .frg file is compiled and the object code written to a file with the extension .fro.

SCREEN FORMS (.scr EXTENSION)

LOOMS.SCR	MECHANIC.SCR	SUBCONT.SCR	SPARES.SCR
QUALITY.SCR	WEAVER.SCR	LOOMSTOP.SCR	CLOTHERR.SCR
ARTICLE.SCR	PARTOUT.SCR	PARTIN.SCR	PRODD.SCR
ARTICLE2.SCR	INSP.SCR	LOOMADD.SCR	YARINP.SCR
YARNREJ.SCR	YAROUT.SCR	LOOMAST.SCR	YARBACK.SCR
YARCNT.SCR	YARFIL.SCR	YARTWIST.SCR	YARDIR.SCR
YARPACK.SCR	YARNSUP.SCR	DESCRIP6.SCR	DESCADD.SCR
YARCOL.SCR	YARBUY.SCR	YARSALE.SCR	YARWRITE.SCR

These are the files used by the system to customise screen formats. When this file is saved the system automatically creates a second file with the same name but having the extension .fmt, which contains the programming code necessary to reproduce the customised screen.

INDEX FILES (.ndx & .mdx EXTENSION)

LOOMREAD.NDX
WEAVCODE.NDX
LOOMCODE.NDX
LOOMWIDE.NDX
STOPCODE.NDX
TEMP7.NDX
TEMP4.NDX
TEMP6.NDX
PARTDATE.NDX
YARTWIST.NDX
QUALWEAV.NDX
YARCOL.NDX
YARDIR.NDX
ARTICLE.NDX
YARDAT.NDX
WRITDATE.NDX
WAG.NDX

QUALDATE.NDX
WEAVSHIF.NDX
LOOMWEFT.NDX
MECHGROU.NDX
CLOTHERR.NDX
QUALOOM.NDX
TEMP2.NDX
CODEPART.NDX
TEMP9.NDX
MECHCODE.NDX
SUPER.NDX
YARNAME.NDX
YARPACK.NDX
ART.NDX
YARBUY.NDX
REJDATE.NDX

ARTRATE.NDX
WEAVWAGE.NDX
LOOMECH.NDX
MECHSHIF.NDX
SUBCODE.NDX
STOCODE.NDX
TEMP5.NDX
CODELOOM.NDX
DON3.NDX
BAD12.NDX
DON4.NDX
YARCNT.NDX
YARNSUP.NDX
YARDATE.NDX
PRODATE.NDX
LOOMPICK.NDX

ARTNAME.NDX
WEAVSURN.NDX
ISSUDATE.NDX
MECHNAME.NDX
PARTCODE.NDX
TEMP15.NDX
TEMP3.NDX
INSP.NDX
DDD.NDX
BAD14.NDX
FCST1.NDX
YARFIL.NDX
LOOMAST.NDX
YARBATCH.NDX
SALDATE.NDX
WGE1.NDX

. dir *.mdx
LOOMS.MDX
INSPECT.MDX
YARCNT.MDX
YARCOL.MDX
YARBUY.MDX

ARTICLE.MDX
YARNSUP.MDX
YARFIL.MDX
YAROUT.MDX
WAGERATE.MDX

SPARES.MDX
PARTSTOC.MDX
YARTWIST.MDX
MECHANIC.MDX

WEAVER.MDX
YARNAME.MDX
YARDIR.MDX
HASZNALO.MDX

These files hold data from the databases files in an indexed format. Files which are indexed on a single databases field are given the extension .ndx and those with multiple indexes are designated as .mdx files. The purpose of these files is to speed up data searching in the database files.

GUIDE TO THE

dBASE IV ENVIRONMENT

This illustration shows you how the dBASE components are related and which books to check for more information. It also points you, where appropriate, to the on-line Help system.

Entering the dBASE IV Environment
 See *Getting Started with dBASE IV Developer's Edition*.

Enhancements to dBASE III PLUS
 See *dBASE IV Change Summary*.

Control Center

Use the Control Center to learn and work in dBASE IV. New and experienced users can easily manipulate files and accomplish database management tasks, such as creating and using database

files, catalogs, views, forms, reports, and labels. See *Using the Menu System* and on-line Help.

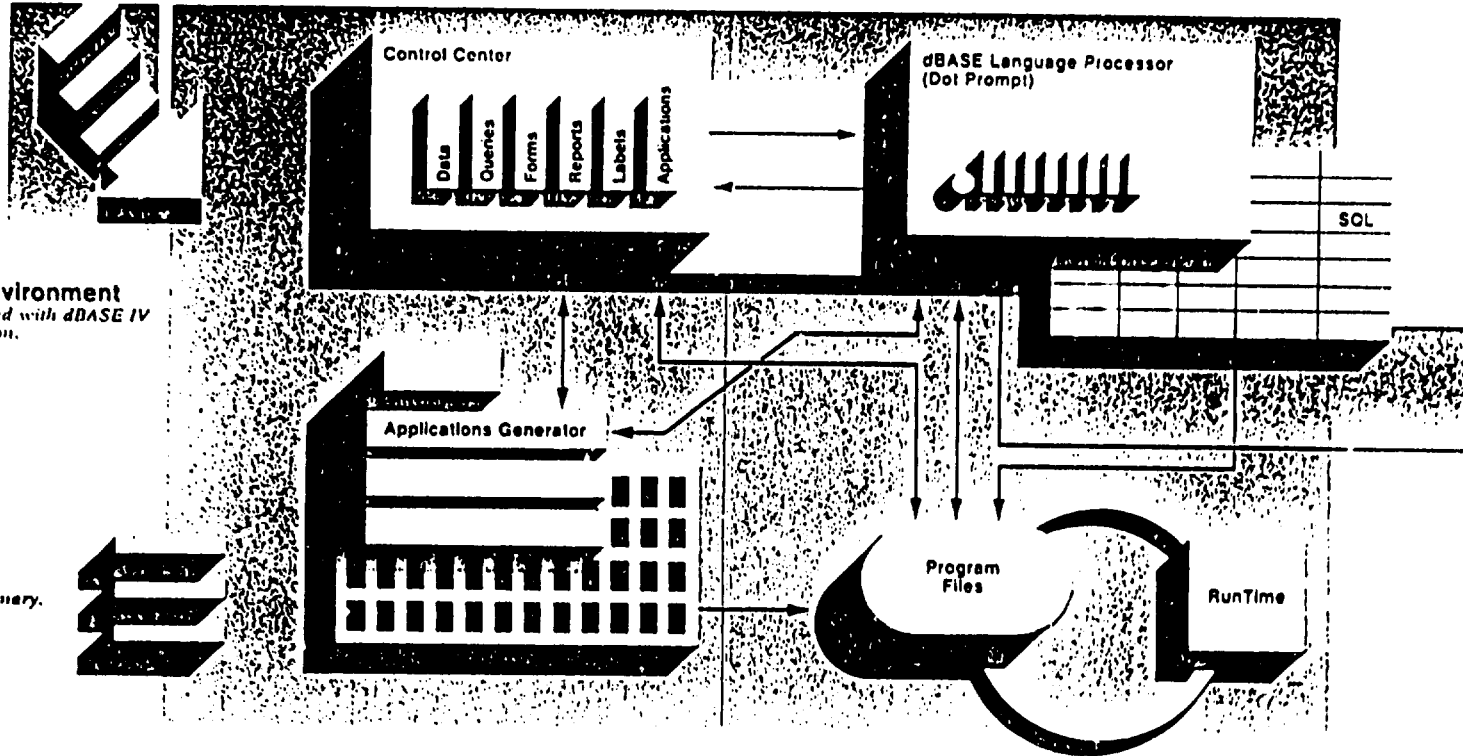
dBASE Language Processor

Use the commands and functions from the dot prompt or in programs to directly access data and to build dBASE applications. You can also modify programs created with the

Applications Generator. See *Language Reference, Programming with dBASE IV, Sample Programming Code, Quick Reference*, and on-line Help.

SQL

Use SQL to combine the language standard of mainframe computers with the power and flexibility of the dBASE language. SQL commands and func-



Applications Generator

Use the Applications Generator to create applications without programming. New application developers benefit by learning the basics of application design.

Experienced devel-

and effort, without forfeiting access to the dBASE language. See *Using the dBASE IV Applications Generator, Template Language*, and on-line Help.

RunTime

Use RunTime to prepare applications for distribution to others. Professional developers can distribute applications with RunTime to their clients. See *Programming with dBASE IV*.