

# Instruction Manual

## MillMaster® TOP



---

Loepfe Brothers Ltd.  
Kastellstrasse 10  
8623 Wetzikon/Switzerland

Phone        +41 43 488 11 11  
Fax            +41 43 488 11 00  
E-mail        service@loepfe.com  
Internet      www.loepfe.com

Document title: MillMaster TOP Instruction Manual

Language version: English

This Manual is protected by copyright.

Complete or partial reproduction and dissemination of this Manual to third parties – even in form of extracts – as well as the use and / or disclosure of the contents are not allowed without the written approval of Loepfe Brothers Ltd., except for internal purposes.

MillMaster is a registered trademark of Loepfe Brothers Ltd. in Switzerland and / or in other countries.

© 2019 Loepfe Brothers Ltd., Switzerland



# Contents

<b>1</b>	<b>General Information</b>	<b>7</b>
1.1	About this document	7
1.2	Scope of application	7
1.3	Target audience	7
1.4	Notes	7
<b>2</b>	<b>Safety</b>	<b>8</b>
2.1	Intended use	8
2.2	Safety Information and Warnings	8
2.3	Explanation of symbols	8
2.4	Specialist personnel	9
<b>3</b>	<b>Product and Function</b>	<b>10</b>
3.1	Product description	10
3.2	Scope of delivery	10
3.3	Options	10

<b>4</b>	<b>Operation</b>	<b>45</b>
4.1	Operational design	45
4.1.1	User interfaces	45
4.1.2	Data filters and edit window	52
4.2	System startup	56
4.2.1	Start and configure software	56
4.2.2	Configure MillMaster (TOP server)	56
4.2.3	Activate licenses and options	57
4.2.4	Add user	57
4.2.5	Configure basic group settings	59
4.2.6	Custom reports	60
4.2.7	Add and edit shift calendar	62
4.2.8	Connect and add machines	62
4.3	Operate the software	65
4.3.1	Data	66
4.3.2	Analysis	71
4.3.3	Trends	74
4.3.4	Management	79
4.3.5	System	94
<b>5</b>	<b>Service</b>	<b>100</b>
5.1	Support	100

# 1 General Information

## 1.1 About this document

This Instruction Manual helps users to work safely and efficiently with MillMaster TOP.



Clarify anything unclear or uncertainties concerning operation with the supplier!

Read this Instruction Manual in its entirety before starting up MillMaster TOP.

This manual is part of MillMaster TOP and must be kept accessible to trained operators at all times in the immediate vicinity of the device.

## 1.2 Scope of application

This document applies to:

The MillMaster TOP software tool.

## 1.3 Target audience

This document is intended for use by specialist personnel only. The descriptions given here assume that the reader is a qualified professional trained by the manufacturer. These descriptions do not replace training on product use.

## 1.4 Notes

### Information symbol



This symbol indicates additional information for the user.

### Images in the document



The images of the user interface (screenshots) included in this manual are examples, and do not necessarily contain relevant data.







## 2 Safety

### 2.1 Intended use

This software is intended exclusively for use as a data analysis and administration tool for yarn clearers that are linked to the central units of the spinning machines. Any other use, or any use that goes beyond the intended purpose, is considered improper. Loepfe Brothers Ltd. shall not be liable for any damages that result from improper use.

### 2.2 Safety Information and Warnings

Safety information and warnings draw attention to hazards and are marked with symbols and signal words to express the danger level.

	 <b>DANGER</b> Indicates an immediate hazardous situation which will result in death or serious injury.
	 <b>WARNING</b> Indicates a potentially hazardous situation which could result in death or serious injury.
	 <b>CAUTION</b> Indicates a potentially hazardous situation which may result in minor oder moderate injury.
	<b>NOTE</b> Indicates a potentially hazardous situation which may result in damage to property.

### 2.3 Explanation of symbols

#### Warning symbol



General warning symbol



Electrical voltage warning



## 2.4 Specialist personnel

The device and software manufacturer defines specialist personnel as follows:

- **«Foreman»**
  - The foreman is able to instruct operators in how to use the system, and may edit device and software settings and configurations.
- **«Electrician»**
  - Electricians are responsible for installing devices and connecting them to a network. Electricians are professionally trained and qualified to work with electrical equipment, and are familiar with the rules and safety regulations for working with electrical equipment.
- **«Service technician»**
  - Service technicians are responsible for repairing and maintaining the devices and software. They are trained and qualified Loepfe employees, or are expressly authorized by Loepfe to perform service operations.
- **«Network administrator»**
  - Network administrators are responsible for connecting the devices and software to a computer network. They are professionally trained and qualified to work with IT networks, and have administrator rights for the installed network.

## 3 Product and Function

### 3.1 Product description

The software is a data analysis and administration tool that is linked to and periodically synchronized with the machine's LZE central unit. After the data import, all data collected from the LZE central unit can be displayed, analyzed, compared and archived.

### 3.2 Scope of delivery

The following components are included in the scope of delivery: 1 MillMaster TOP

### 3.3 Options

These components can be upgraded with the following options:

Option	Brief description	Reference
Data capture	Number of connected machines	—
Lab Trends	Enhanced trend analysis over a longer period of time	Lab trends (optional feature) [↑ 77]
Planning board	Production planning and direct production control	Planning board (optional feature) [↑ 93]
Additional clients, max. 5	Expand to 8 workstations	—
Database interface	Extract production and quality data from the PostgreSQL database	—

Table 1: MillMaster TOP options

### Option code

An option code is needed to activate a license or code.

To request an option code, send an email to [service@loepfe.com](mailto:service@loepfe.com). The following information is required.

- For machines with the LZE-II or LZE-III central units, provide the MAC addresses of all connected machines.
- For machines that use Informator units, provide the serial numbers of all machines.
- For machines with LZE-V / 6 central units, no option code is required. Machines can be added with the software (see Connect and add machines [▶ 62]).



## 4 Operation

### 4.1 Operational design

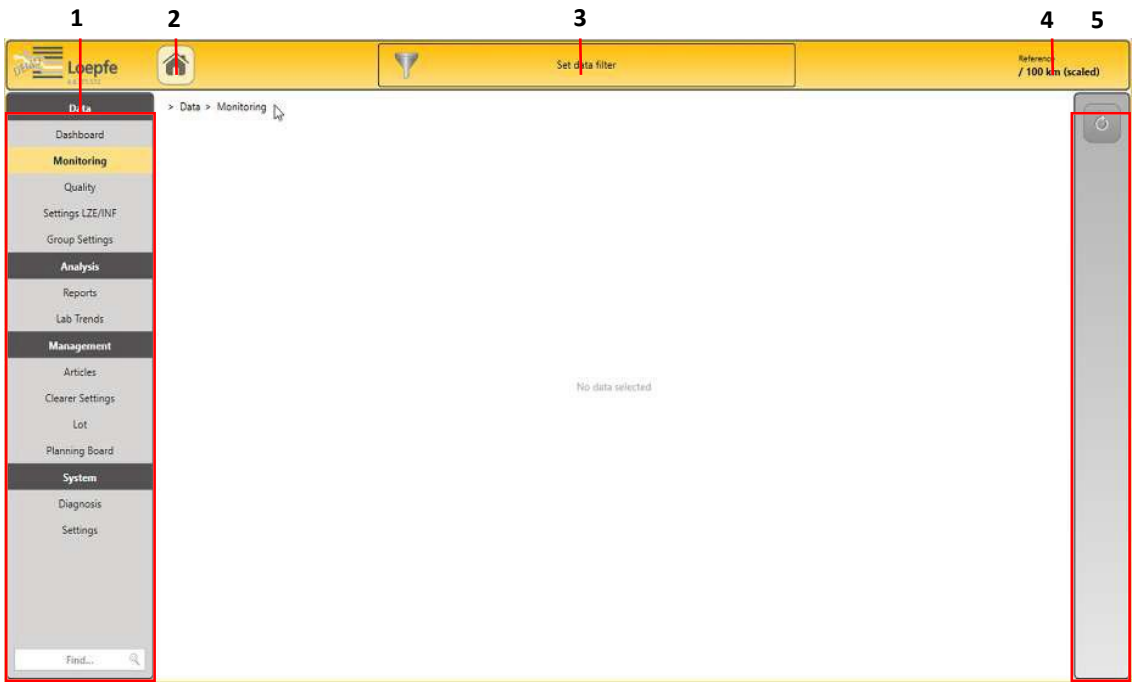
#### 4.1.1 User interfaces

The software consists of two user interfaces, the Room view and the Main view. In the Room view, production data is displayed directly from the LZE central units, providing a quick overview of ongoing production. The Main view displays production data with detailed views, information and analyses; this is also where data administration and system settings are managed.

Control element	Description
Mouse/Keyboard	The software can be controlled with a mouse and keyboard. The keyboard commands are the standard Windows keyboard commands. There are no restrictions on the use of the mouse.
Main menu	Users can use the mouse and keyboard to interact with the main menu, as well as the title bar, main menu bar, function bar and data display area.
Tooltips	Tooltips (mouseover text) show a description of a user-interface element. They appear when the user lets the mouse pointer hover briefly over the element without moving it.
Scrolling	Scrolling by swiping with one finger is only available on mobile devices.
Combo box	The combo box allows users to choose from multiple options, or to enter their own data.
Context menu	The context menu contains context-specific functions that are important for the current content. Right-click to open.
Function buttons	The function button area contains context-specific buttons which are hidden or marked as inactive (grayed out) if they are not needed for the current content.
Room view	The Room view, with title bar, register and the connected machines, can be operated with the mouse.
Checkbox	A checkbox is used to enter and display yes/no decisions. They can be combined into checklists with multiple options.
Selection menu	A selection menu is a dropdown list in which one or more values/options can be selected.
Radio button	Radio buttons are used to enter and display a single selection from among several options.
Video symbol	Certain menus have an accompanying video that provides UI help for a particular topic.

Table 7: User interface control elements

Main view and Room view



Main view

- |   |                     |   |                                       |
|---|---------------------|---|---------------------------------------|
| 1 | Main menu           | 4 | Reference display, for 100 or 1000 km |
| 2 | Switch to Room view | 5 | Function buttons                      |
| 3 | Data filter         |   |                                       |

Main menu

Data

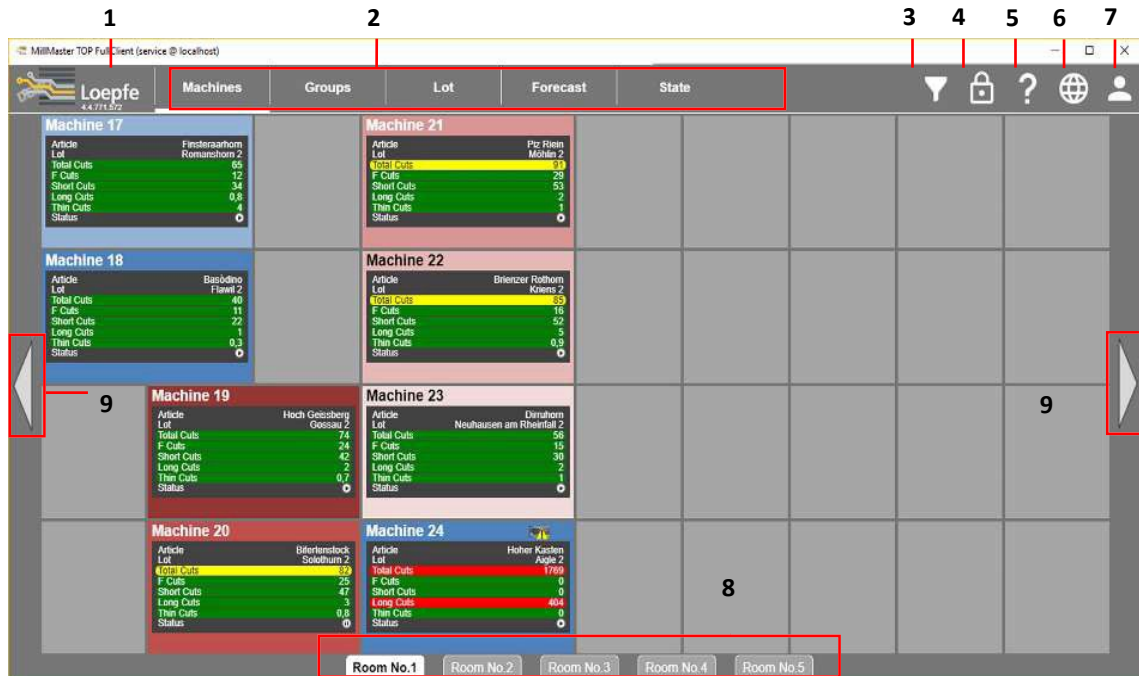
Dashboard	Quick overview of the most important data in graphic and numeric form
Monitoring	Overview of all events in numeric form
Quality	Overview of classification and yarn quality in graphic form
Settings LZE	Overview of settings for LZE central units and clearers, and synchronization of settings
Group settings	Overview of settings for the group

<b>Analysis</b>	
Reports	Configure and generate report
Trend	Production data for a given time period presented as a line chart
Lab Trends (optional feature)	Compare production units (machines) over a period of time
<b>Management</b>	
Articles	Add and edit articles
Clearer settings	Add and edit clearers
Lot	Add and edit lots
Planning board	Manage current production
<b>System</b>	
Diagnosis	Overview of the (active) system
Settings	Local system settings

Table 8: Explanation of the Main view



The software always opens with the overview of the Room view.



Room view

- |   |                     |   |                       |
|---|---------------------|---|-----------------------|
| 1 | Switch to Main view | 6 | Select language       |
| 2 | Room view tabs      | 7 | Login/Logout          |
| 3 | Filter for rooms    | 8 | Other rooms           |
| 4 | Edit Room view      | 9 | Switch to other rooms |
| 5 | Online help         |   |                       |

## Room view

Machines	Overview of connected machines (production units)
Groups	Overview of groups
Lot	Overview of assignments
Forecast	Overview of current production runs
Status	Overview of spindle status (diagram)
Rooms	Production units (machines) in other rooms



Machine 1	
Article	Aubrig
Lot	Kontz
Total Cuts	737
Short Cuts	409
Long Cuts	95
Thin Cuts	53
SF/D Cuts +	6
Status	○

Non-link machine, consists of one or more groups

Machine 5	
Arti...	Signalkuppe
Lot	Lichtensteig
Produced A...	56
Total Cuts	287
D Cuts	272
Thin Cuts	12
F Cuts	15
Status	⏸





Link machine, consists of only one group

Ma. 4	
Article	Alvier
Lot	Bienne
Total Cuts	1227
Short Cuts	546
Long Cuts	173
Thin Cuts	102
SF/D Cuts +	93
Status	▶

Information from a machine

Display and presentation are set in Settings > Machines, e.g.

- Machine number
- Background color, e.g. gray
- Symbols indicate the machine's state:

-  Group settings changed
-  Clearer settings changed
-  Note
-  No connection to machine

Ma. 4	
Article	Alvier
Lot	Bienne
Total Cuts	1227
Short Cuts	546
Long Cuts	173
Thin Cuts	102
SF/D Cuts +	93
Status	▶

Information for a group

The basic data and presentation are set in the Lot menu, e.g.

- Article name
- Lot name
- Background color, e.g. blue
- Monitoring of data points
- The "Status" field shows the production status:




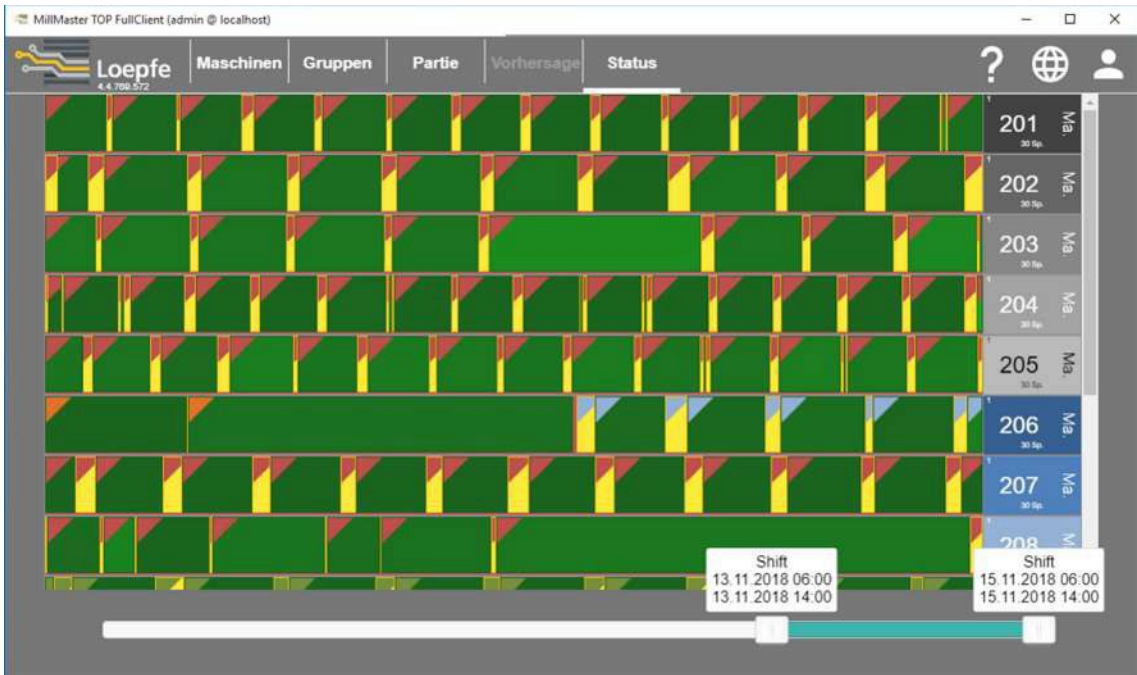
-  Production is ongoing
-  Production is paused
-  Production is stopped

Table 9: Explanation of Room view

Room view > Status



Example of Room view > Status

The **Status** tab in the Room view shows all spindles for all machines. All shifts for the current day are shown. The slider at the bottom of the screen can be used to change the time period being viewed. Up to 7 days back, or 42 shifts. The production area of each spindle/machine is represented by a colored bar that indicates different production statuses. See Table 10. For the **Production** status, more winding in production is represented by increasingly darker shades of green. For the **Production not planned** status, a color gradient is used. Spindles that belong to the same group are shown together in a block. Current production data can be displayed in the tooltip.




































Color	Production status	Meaning
	Production	Machine is running
	Production not planned	Lot not planned
	Pause	Machine temporarily stopped
	Stop	Not in production.
	Unknown	Data not available for spindle range

Table 10: Status in Room view

## Function buttons

	Online help		Send settings to machine
	Search		Restore lot
	Save / Confirm		Synchronize lot data
	Cancel / Discard		Export status report
	Edit settings		Generate lab report
	Add setting		Automatic repair
	Delete setting		Add pause
	Update data		Synchronize time
	Zoom in (month/week/day/shift)		Add user
	Zoom out		Delete user
	Show scan result		Change password
	Duplicate settings		Remote connection
	Open Clearer Setting Assistant		Print report
	Complete lot		Export report to Excel
	Cancel alarm		Start video

## 4.1.2 Data filters and edit window

### Create data filters

There are two ways to create a data filter:

- using data and analysis in the main menu, or
- directly with the «Set data filter» button.



**Create data filters, report filters and trend filters in Main menu > Data**

Prerequisites

- ✓ The software has been started up and connected with the machine's LZE.
- ✓ The Main view is open.

1. In the main menu, open **Data > Dashboard, Monitoring or Quality**.  
→ The «Production data filter» window opens.



2. Search for a machine, in the list or using the search field.
3. Select time period (month, week).
4. Press  to open selection for the week.
5. Select time period (week, day).
6. Press  to open shift selection.
7. Select time period (day, time).
8. Press your selection to open the shift.



⇒ The desired shift is displayed, e.g. with quality data.

9. Select a data window, e.g. D-Class, to open more detailed views.

⇒ The data window is shown in graphic form and with values.



10. In the main menu, open **Data > Settings LZE** to switch to a different menu.

⇒ The data filter is created.

## Create data filters, report filters and trend filters with “Set data filter”

### Prerequisites



- ✓ The software has been started up and connected with the machine's LZE.
- ✓ The Main view is open.

1. Press «Set data filter».

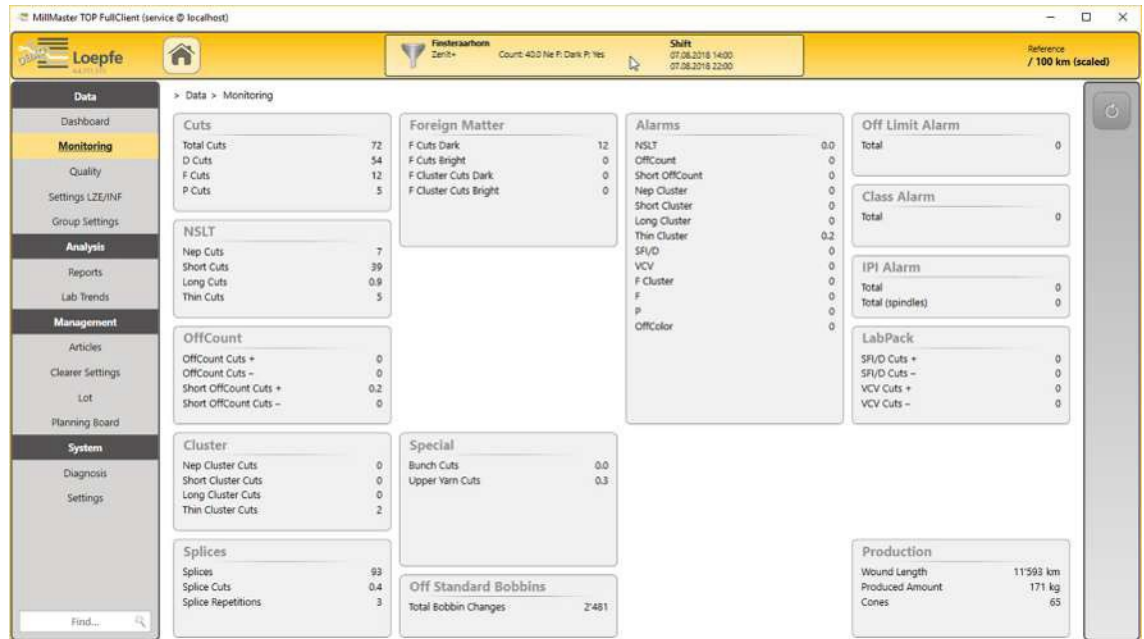


⇒ The «Production data filter» window opens.



2. Search for a machine, in the list or using the search field.
3. Select time period (month, week).
4. Press  to open selection for the week.
5. Select time period (week, day).
6. Press  to open shift selection.
7. Select time period (day, time).
8. Press your selection to open the shift.
  - ⇒ The desired shift is shown, e.g. with monitoring data.





9. Select a data window to open more detailed views.






⇒ The data window is shown in graphic form and with values.

In the main menu, open **Data > Quality** to switch to a different menu.

⇒ The data filter is created.

## Edit window in the Main view

Various windows have a fixed editing time of 10 minutes in edit mode, to prevent multiple people from making changes to the same menu at the same time. The editing time starts when the window is opened, and continues for 9 minutes until the user is asked whether they want to continue working.

Symbol	Description
Lot marked in green	Current production runs with all production data
Lot marked in gray	Completed production runs
	Select year, month, week, day and shift (time of day) to restrict the time period for production data.
	Shift selected
	Clearer settings have changed
	The production data could not be precisely assigned to this shift. The data will be shown in the next shift.
	The Room view, with title bar, register and the connected machines, can be operated with the mouse.

## 4.2 System startup

### 4.2.1 Start and configure software

This menu is used to log in, register, set the user interface language, and start the software.

1. Start the software.
  - ⇒ The Room view opens.
  - ⇒ The login window opens.

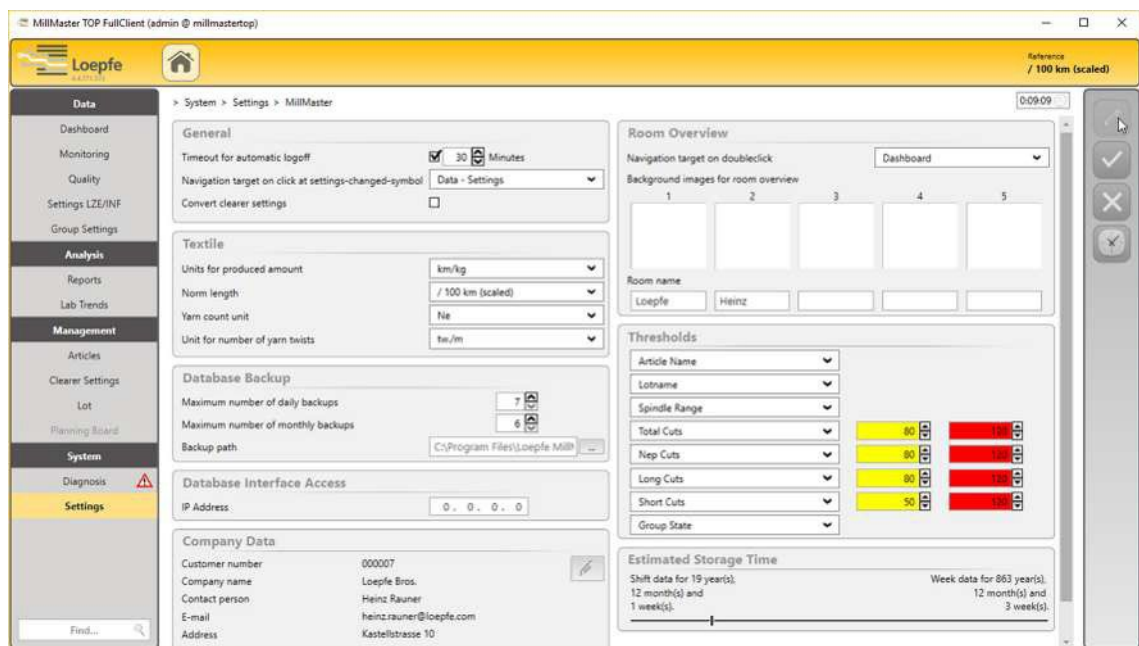


2. Enter the username (admin) and password (Admin1).
    - ⇒ The «Registration» window (for support services) opens.
  3. Enter the requested information in the text boxes, using the (six-digit) Customer Number given in the delivery documents.
  4. Press .
    - ⇒ The «Language» window opens.
  5. Select your language.
  6. Confirm with «OK».
    - ⇒ The language changes.
- ⇒ The Loepfe MillMaster TOP software is started.


### 4.2.2 Configure MillMaster (TOP server)

This menu is used to modify the settings for the system and the server.

1. In the main menu, open **System > Settings > MillMaster**.
  - ⇒ The menu opens.
2. Press .
  - ⇒ The menu is activated and can be edited.
3. Change data if necessary.





4. Press  .
  - ⇒ The data is saved.
  - ⇒ The changes are activated and recorded.

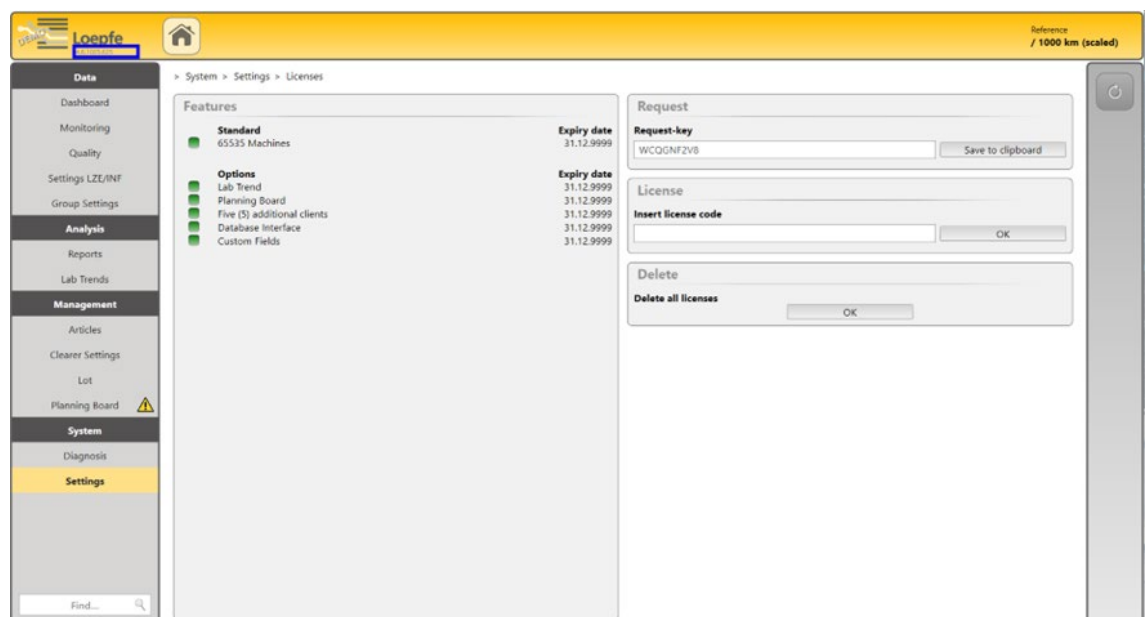
### 4.2.3 Activate licenses and options

This menu can be used to enhance the software with options.

Prerequisites

- ✓ The Loepfe.BDE.LicenseGenerator program has been installed.
- ✓ The request key is available.

1. In the main menu, open **System > Settings > Licenses**.
  - ⇒ All active and inactive options are listed under Functions.




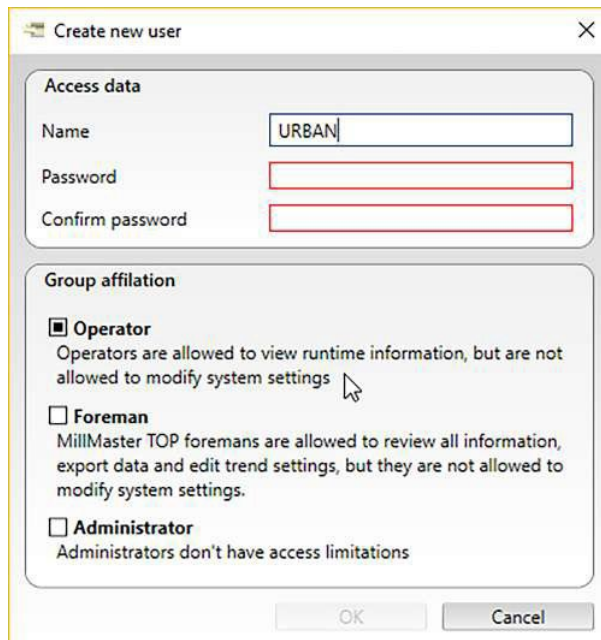
2. Copy the request key shown under "Request" to the clipboard.
  3. Open the Loepfe.BDE.LicenseGenerator program.
  4. Paste in the request key.
  5. Select the desired option(s).
    - ⇒ The license key is created.
  6. Enter the license key in the text box and confirm with «OK».
- ⇒ The desired option is activated.

### 4.2.4 Add user

Depending on their responsibilities, users can be assigned to one of three specified user levels. The following table lists these user levels, which are active with the associated usernames after initial startup.

User level Group affiliation Group/Role	Username	Password	Permissions
Operator	operator	Operator1	View data Create reports View Trends View Management View System > Diagnosis View System > Settings
Foreman	foreman	Foreman1	View all data and information. Export data Create reports Edit Trends Edit and add to Management Edit System > Settings > Machines Edit System > Settings > MillMaster Edit System > Settings > Shift calendar View System > Diagnosis View System > Settings
Administrator	admin	Admin1	No restrictions

1. In the main menu, press **System > Settings > User management**.  
⇒ The User Management menu opens.
2. Press .  
⇒ The «Create new user» window opens.



The dialog box titled "Create new user" contains two main sections. The "Access data" section has three input fields: "Name" (containing "URBAN"), "Password", and "Confirm password". The "Group affiliation" section has three radio button options: "Operator" (selected), "Foreman", and "Administrator". Each option has a descriptive text block below it. The "Operator" text says "Operators are allowed to view runtime information, but are not allowed to modify system settings". The "Foreman" text says "MillMaster TOP foremans are allowed to review all information, export data and edit trend settings, but they are not allowed to modify system settings". The "Administrator" text says "Administrators don't have access limitations". At the bottom are "OK" and "Cancel" buttons.

1. Enter login credentials in the text boxes.
  2. Set the group affiliation/user level.
  3. Confirm with «OK».
- ⇒ The data is saved.
- ⇒ The user is added.

## 4.2.5 Configure basic group settings

The group settings are divided into different yarn clearer types.

- PRISMA
- Zenit+
- Zenit

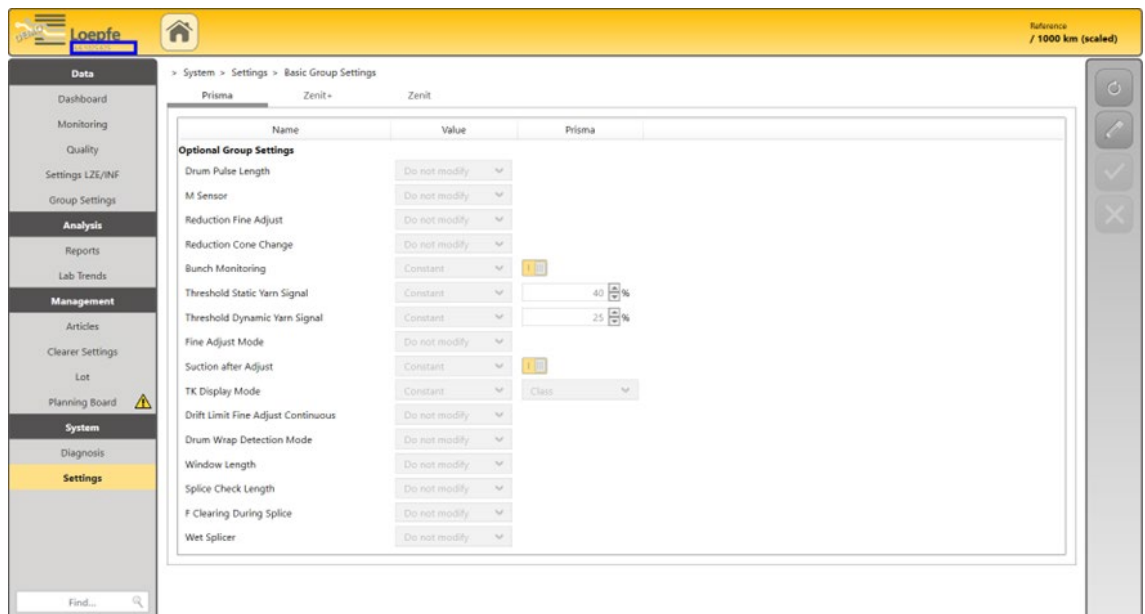


The group settings that are changed at the central unit are displayed in the software. However, these values are not automatically imported by the software.

Values	Properties
Unchangeable	<ul style="list-style-type: none"> <li>■ Settings from the central unit are automatically imported by the software</li> <li>■ Not displayed when creating a new lot</li> <li>■ Central unit settings are not displayed when downloading</li> </ul>
Constant	<ul style="list-style-type: none"> <li>■ Settings can be entered under group settings, but are not displayed when creating a new lot</li> <li>■ Central unit settings are copied over when downloading a lot</li> </ul>
Configurable	<ul style="list-style-type: none"> <li>■ Settings can be entered under group settings</li> <li>■ They are displayed when creating a new lot and can be modified/changed for this lot</li> <li>■ Central unit settings are copied over when downloading a lot</li> </ul>

1. In the main menu, press **System > Settings > Basic settings**.

⇒ The menu opens.



2. Select the tab for the desired «yarn clearer type»

3. Press .

⇒ The menu is activated and can be edited.

1. If necessary, enter values in the “Value” column.

2. If necessary, modify or remove settings under the yarn clearer type.

3. Press .

⇒ The data is saved.

⇒ The menu closes.

⇒ The changes are recorded.

## 4.2.6 Custom reports

There are two ways to prepare reports: automatically-generated reports by default, or configuring custom reports (optional feature).

### Automatic generated reports

The automatic generated reports are a selection of pre-defined reports. The individual customer's logo can be entered in the settings for each report, as well as the minimum production volumes for list reports and OffLimit reports. The user also selects the report language, the directory path, the wait time and the desired reports. Rooms can also be separated into various folders and saved. The reports can then be generated from the main menu under Analysis > Reports and printed out.

1. In the main menu, open **System > Settings > Auto Report Generation**.

⇒ The menu opens.

2. Press .

⇒ The menus are activated and can be edited.

3. Under “General report settings”, enter the customer logo and production volumes, for example.

4. Under “Automatically generated reports”, select the language, directory path, wait time and desired reports, for example.

5. Select type of report if you want a PDF, Excel, None of it = OFF

6. Press .

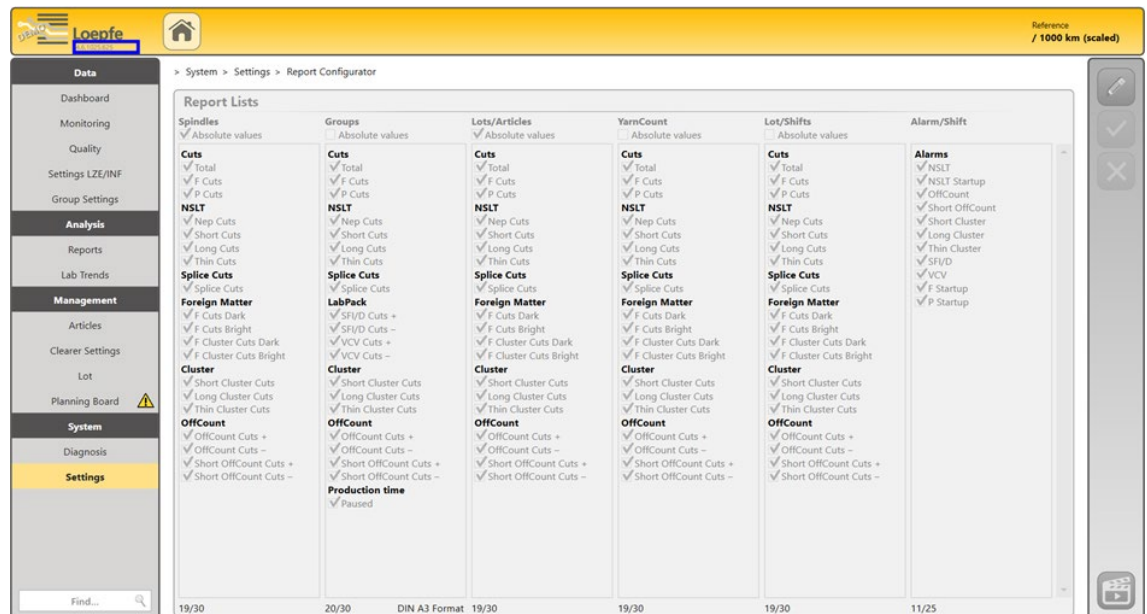
⇒ The data is saved.



⇒ The changes are recorded.

## Custom reports (optional feature)

The report configuration tool is used to create user-defined reports, with the report properties (list reports) set individually in the report settings. The reports can then be generated from the main menu under Analysis > Reports and printed out.

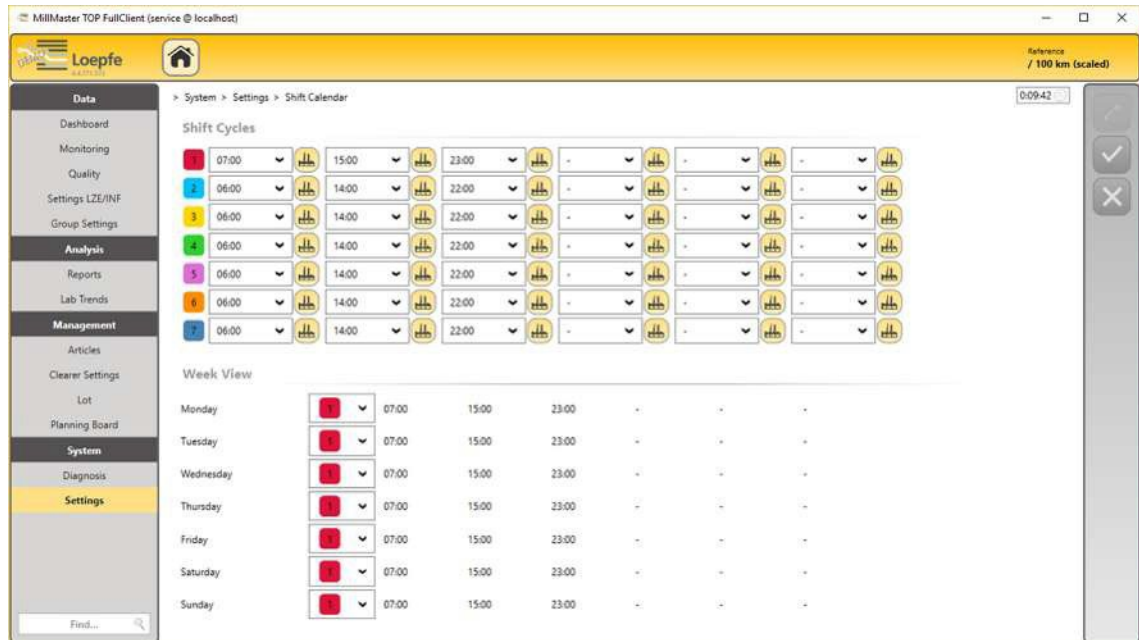
1. In the main menu, open **System > Settings > Custom reports**.  
⇒ The menu opens.



2. Press .  
⇒ The menu is activated and can be edited.
  3. Under “List reports”, modify selections e.g. under Spindles, Groups, Article/Lot, etc.
  4. Press .  
⇒ The data is saved.
- ⇒ The changes are recorded.

## 4.2.7 Add and edit shift calendar

1. In the main menu, press **System > Settings > Shift calendar**.  
⇒ The Shift calendar overview opens.



1. Press .

⇒ The menu is activated and can be edited for the specified editing time.

### Shift calendar

### Properties

#### Shift cycles

- set a maximum of 7 different shift cycles
- set a maximum of 3 user-defined shifts per day
- a shift may last up to 12 hours max
- time can be set in 15-minute increments

#### Week view

Choose the desired distribution:

- distribute shift cycles over an entire week or
- one shift cycle can be assigned multiple times

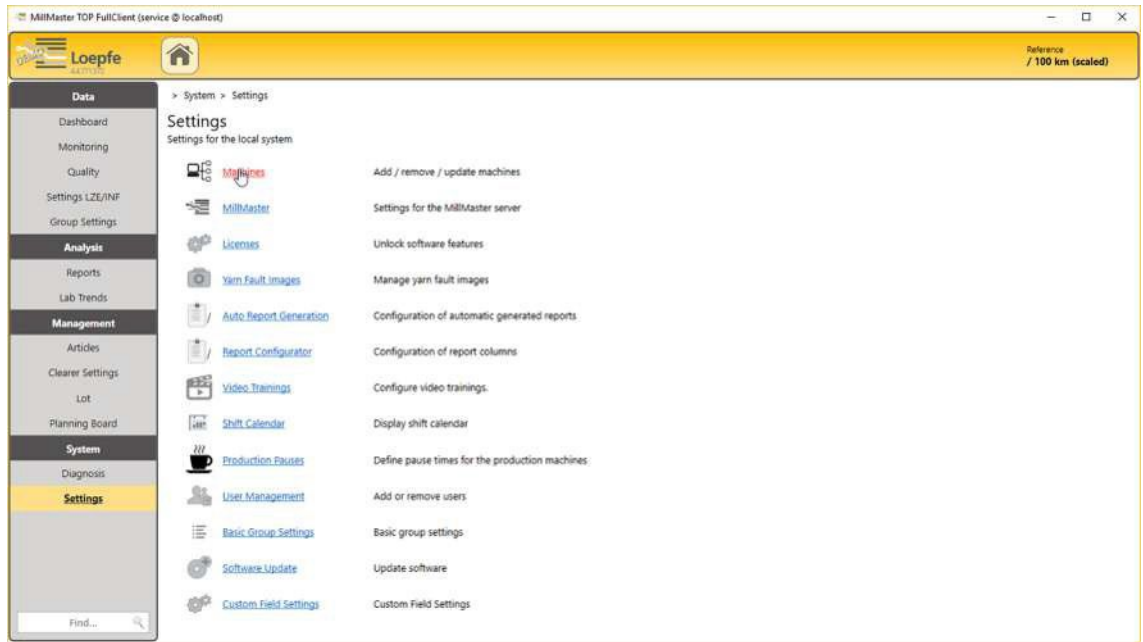
## 4.2.8 Connect and add machines

This menu is used to connect machines to the software and add them.

1. Press the Loepfe company logo.

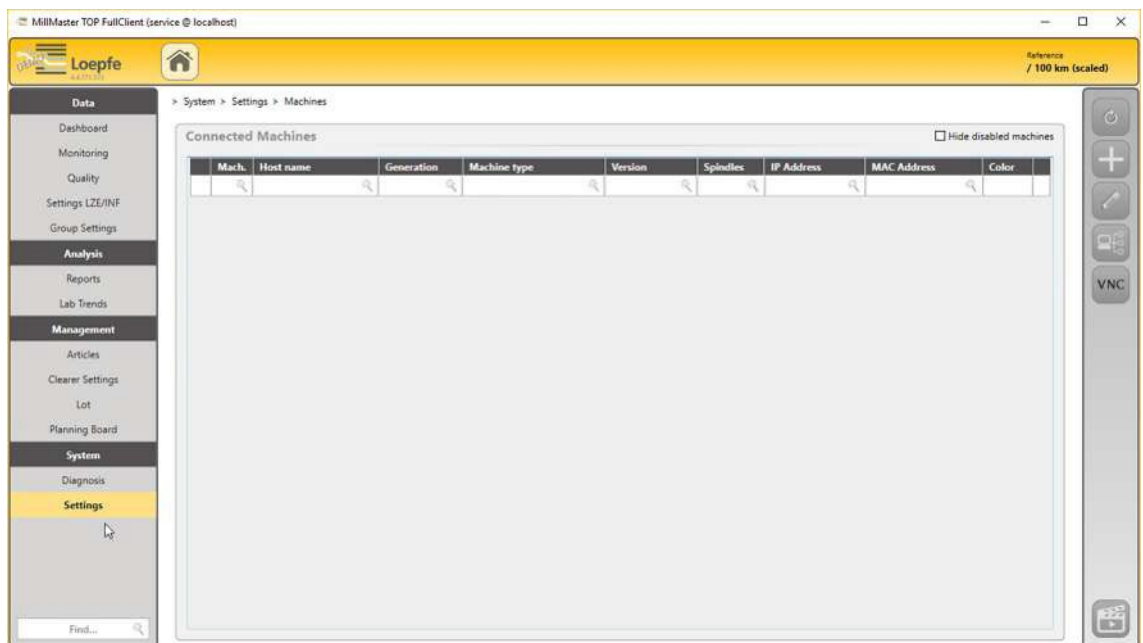


- ⇒ The Main view opens.
  - ⇒ No data are displayed because no data have been added yet.
2. In the main menu, open **System > Settings > Machines**.



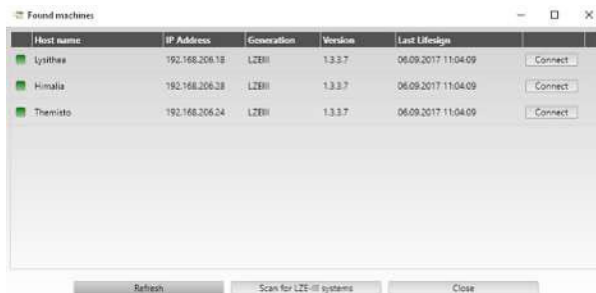
⇒ The **Settings > Connected machines** menu opens.

⇒ No data are displayed because no data have been added yet.

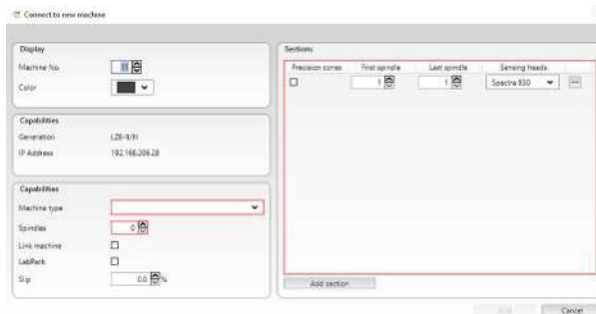


3. Press .

⇒ The «Found machines» window opens.



- ⇒ All winding machines with LZE-V / 6 and Informators and that are connected to the data system are displayed.
- ⇒ Note: Use the «Search for LZE-III» button to search for winding machines with LZE-III units.
- ⇒ If no machines are shown, add them manually or check the connection data.
- 4. Select the desired machine and press «Connect».
- ⇒ The «Connect to new machine» window opens.



- 5. Enter values in the input fields, making sure to fill in the machine parameters and sections.
- 6. Press «Add section».
- ⇒ The machine is connected to the software.
- 7. Check that the desired machine is listed in the menu.
- ⇒ The desired machine has been added.




Symbol	Machine statuses	Meaning
	Reachable	Unrestricted communication with the data system
	Reachable	Cannot communicate with machine because data transfer has not yet occurred or because multiple different configurations are present.
	Not reachable	Communication with data system interrupted

Table 11: Machine statuses




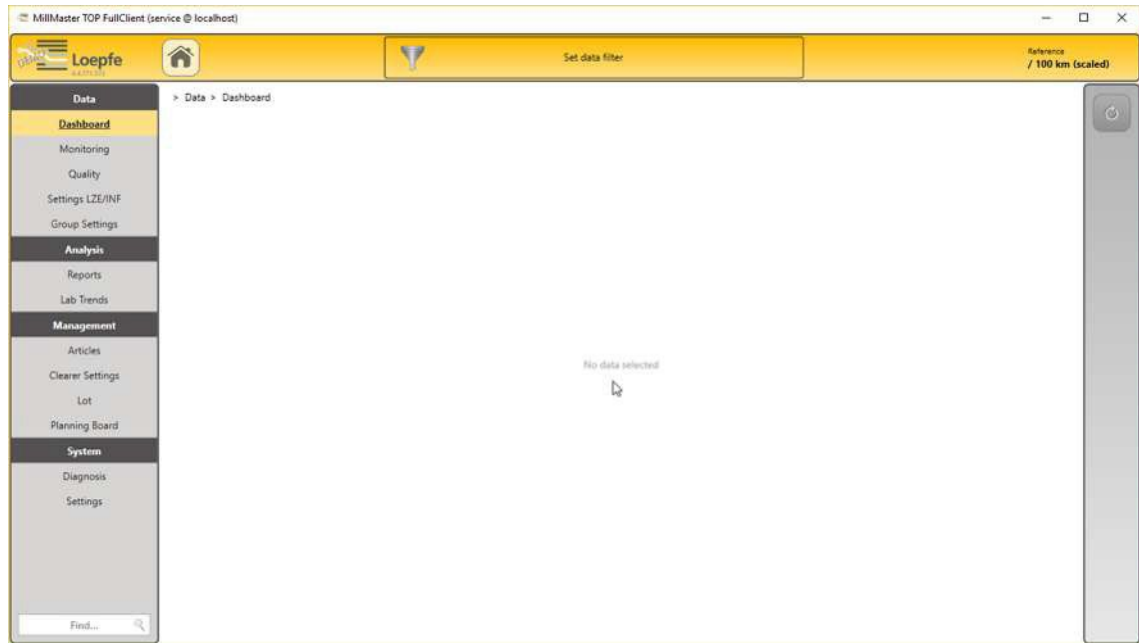
## 4.3 Operate the software

### Open the Main view

#### Prerequisites

- ✓ The software has been connected with the machine's LZE.
- 1. Start the software.
  - ⇒ The login window opens.
- 2. Enter username and password in the text boxes.
- 3. Press «OK».
  - ⇒ The Room view opens.

4. Change the language if necessary.
  5. Press .
    - ⇒ The «Language» window opens.
  6. Select your language.
  7. Press «OK».
    - ⇒ The language changes.
  8. Press the Loepfe company logo.
    - ⇒ No data are displayed because no data have been selected yet.
- ⇒ The Main view is open.




### 4.3.1

#### Data

This menu displays the machines' production data in various different overviews, including the Dashboard, Monitoring, and Quality, as well as the settings for the LZE central units and the group settings.

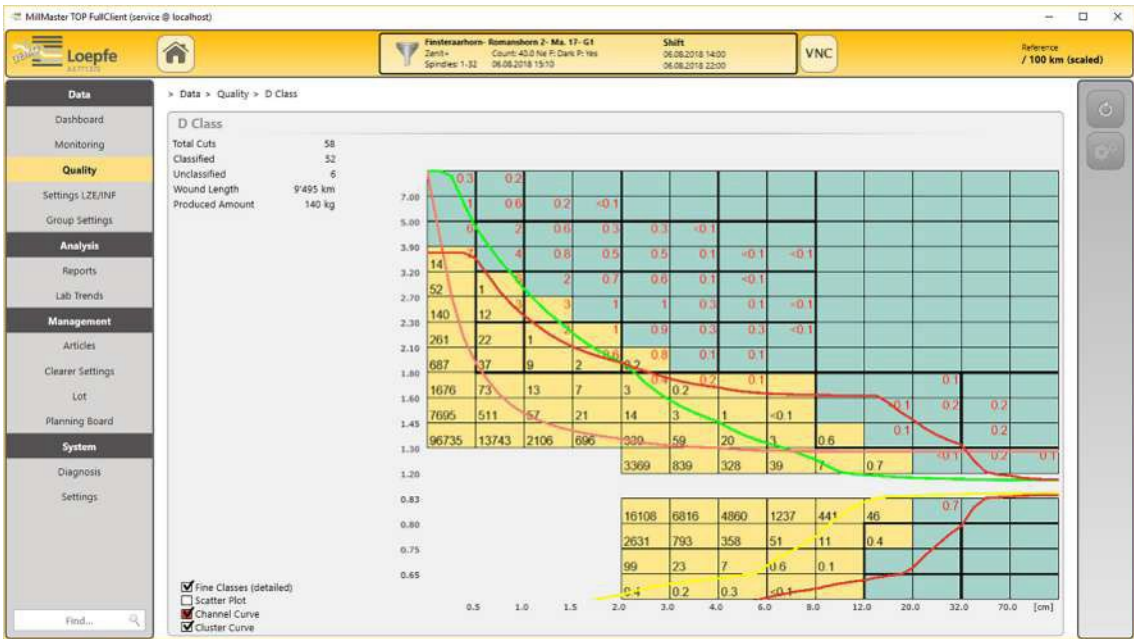
## Display overview in Dashboard, Monitoring or Quality

### Prerequisites

- ✓ The Main view is open.
  - ✓ No data are displayed because no data have been selected yet.
1. In the main menu, open **Data > Dashboard, Monitoring or Quality**.
    - ⇒ The «Production data filter» window opens.
  2. Search for a machine, in the list or using the search field.
  3.  Select a time period to open the data for a particular shift.
    - ⇒ The desired overview is displayed, e.g. Quality.



4. Select a data window to open more detailed views.
  - ⇒ The data window is shown in graphic form and with values.




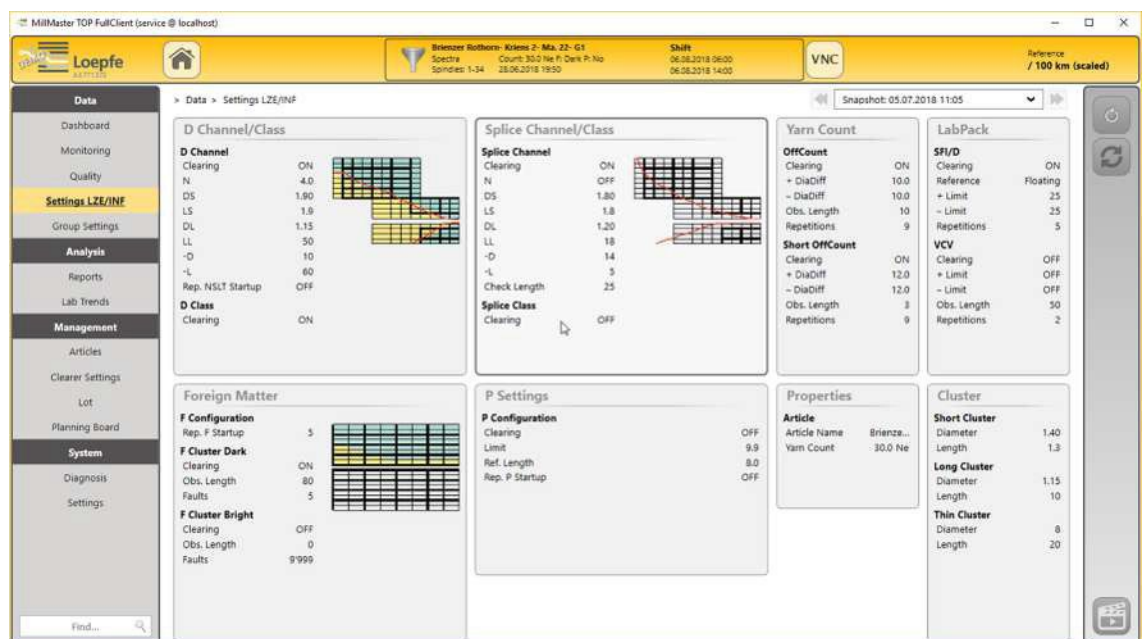
## Display LZE settings overview

### Prerequisites

- ✓ The Main view is open.
  - ✓ No data are displayed because no data have been selected yet.
1. Press «Set data filter» or open **Data > Settings LZE** in the main menu.  
⇒ The «Production data filter» window opens.



2. Search for a machine, in the list or using the search field.
3.  Select a time period to open the data for a particular shift.  
⇒ The LZE settings overview is displayed.




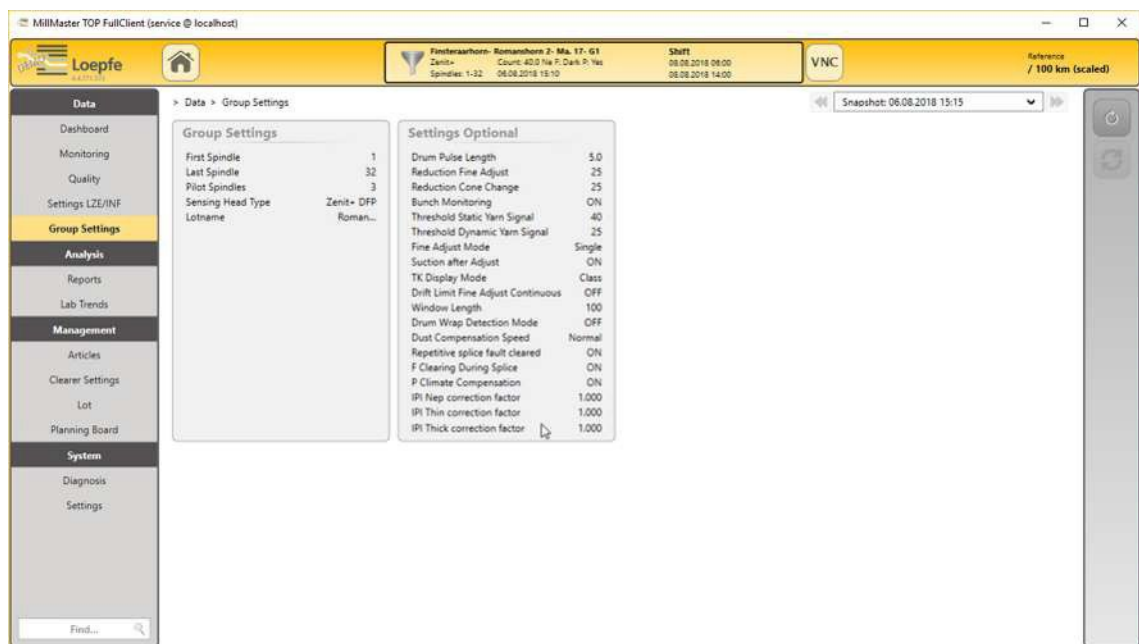
4. Select a data window to open more detailed views.
- ⇒ The data window is shown in graphic form and with values.

## Display group settings overview

### Prerequisites

- ✓ The Main view is open.
- ✓ No data are displayed because no data have been selected yet.

1. In the main menu, open **System > Settings > Group**.  
⇒ The «Production data filter» window opens.
2. Search for a machine, in the list or using the search field.
3.  Select a time period to open the data for a particular shift.  
⇒ The group settings overview is displayed.



### 4.3.2 Analysis

In this menu, production data and clearer settings can be displayed in various pre-defined reports. These reports can be exported or saved as PDF or Excel files, and also printed out. Report features can only be changed with the “Custom reports” option.

#### Overview of pre-defined reports

Reports	Description
Shift report	At the end of a shift, a shift report is automatically saved for each winding machine.
Lot report	This report shows the production data for the selected lots.
Spindle report	This report shows the production data for each individual spindle for the selected shift.
Group report	This report shows the production data for the groups.
Lot/Article report	This report shows the production data for the selected lots or articles.
Yarn count report	This report shows the production and quality data sorted by article yarn count over the selected time period (max. 30 days).
Shift book report	This report shows the shifts with the production data for the last 4 days.
OffLimit report	This report displays spindles that have exceeded the specified threshold values.
Lot/Shift report	This report shows the production and quality data per shift for the selected lot.
Alarms/Shift report	This report shows all alarm messages for each shift.


Table 12: Pre-defined reports

#### Open reports with report filter

The Data filters and edit window [► 52] section of the Operational Design chapter describes how to open reports with the report filter.

#### Shift report

✓ The report filter window is open.

1. At the left, select “Shift report”.
2. At the right, select the desired report options (display options).
3. In the middle, search for an object in the list or using the search field.
4.  Select a time period to open the data for a particular shift.  
⇒ The report is generated and opens.


### Lot report

The report filter window is open.

1. At the left, select "Lot report".
2. At the right, select the required pre-defined filters.
3. In the middle, search for an object in the list or using the search field.
4. Press «OK».  
⇒ The report is generated and opens.

### Spindle report

The report filter window is open.

1. At the left, select "Spindle report".
2. In the middle, search for an object in the list or using the search field.
3.  Select a time period to open the data for a particular shift.  
⇒ The report is generated and opens.

### Group report

The report filter window is open.

1. At the left, select "Group report".
2. At the right, select the required pre-defined filters.
  - Shift filter: select from the last four shifts.
  - Period filter: Set shift period start date and end date.
  - Yesterday filter: All shifts from the previous day.
3. Press «OK».  
⇒ The report is generated and opens.

### Lot/Article report

The report filter window is open.

1. At the left, select "Lot/Article report".
2. Select Articles or Lots filter.
3. Search for an object in the list or using the search field.
4. Press «OK».  
⇒ The report is generated and opens.

### Yarn count report

The report filter window is open.

1. At the left, select "Yarn count report".
2. Set shift period start date and end date.
3. Select the desired yarn count.
4. Press «OK».  
⇒ The report is generated and opens.



## Shift book

The shift book shows changes that have been made at the LZE central unit.

✓ The report filter window is open.

1. At the left, select "Shift book".
2. At the right, select the required pre-defined filters.
3. In the middle, search for a machine (object).  
⇒ The report is generated and opens.



The following pre-defined filters are available:

- Changes to clearer settings of the active group
- Changes to group settings of the active group
- Information about the group (Group information), e.g.
  - Lot name,
  - Article name,
  - Material,
  - Group,
  - Spindle range,
  - Starts and stops,
  - Planned spindle range,
  - Download time and target

## OffLimit report

The OffLimit report shows spindles with faults in production.

✓ The report filter window is open.

1. At the left, select "OffLimit report".  
⇒ The «**OffLimit Configurations and Machines**» window opens.
2. Press  to open existing configurations or
3. press  to add a new configuration.
4. At the right, change the name.
5. Choose from the various setting options and the Data Elements with "Percentage".
6. Choose data source - select machine and time period.
7. Press «OK».  
⇒ The report is generated and opens.

### Lot/Shift report

The report filter window is open.

1. At the left, select "Lot/Shift report".
2. Search for an object in the list or using the search field.
3. Press «OK».  
⇒ The report is generated and opens.

### Alarms/Shift report

The report filter window is open.

1. At the left, select "Alarm/Shift report".
2. Select date or press «Last shifts».  
⇒ The existing shifts are displayed.
3. Select the desired shift.
4. Press «OK».  
⇒ The report is generated and opens.

## 4.3.3 Trends

This menu shows production and quality data for the selected period. These data and values are displayed as a trend. Trend reports are compiled and displayed from existing data elements from the Monitoring and Quality menu. The data elements are shown in three different styles, as a line and bar chart and in a table.

### Generate trend data filter (Trend configuration filter)



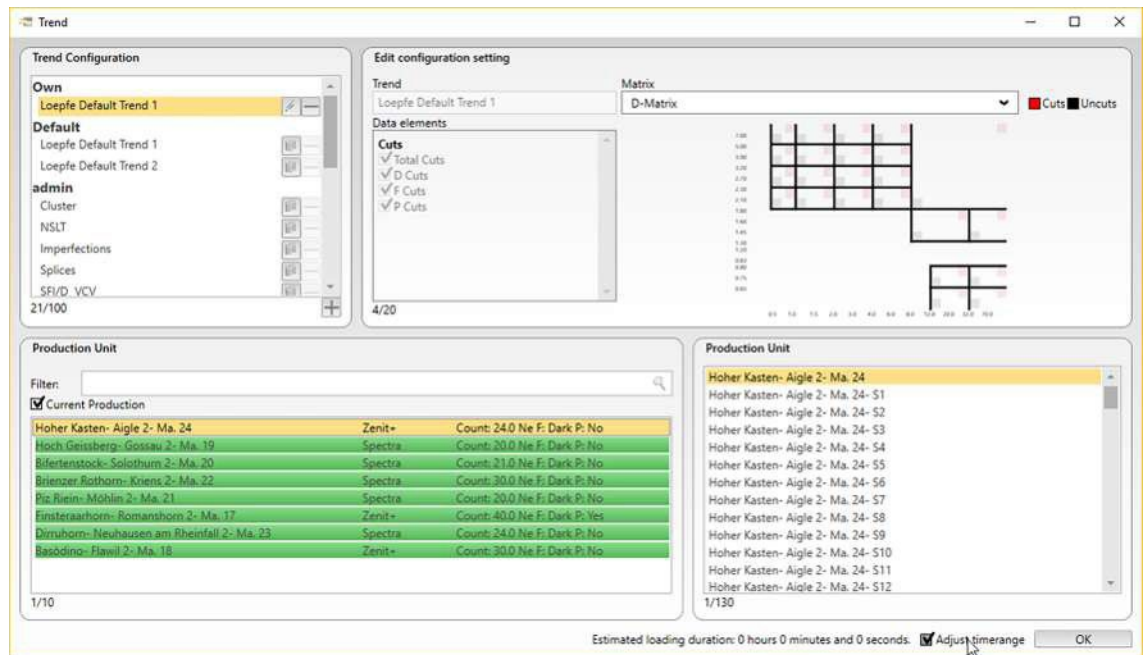
A new or existing trend configuration is always created and edited in the user level currently in use. The data then become visible in any other user level and can be used there.


#### Prerequisites

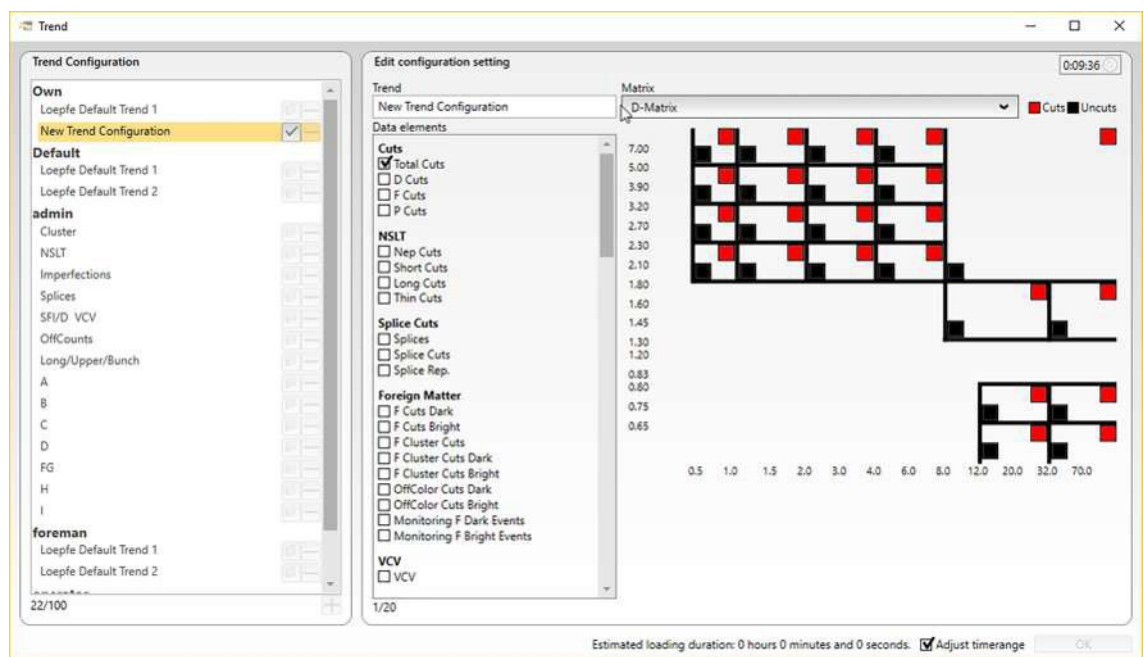
The main menu is open.


No data are displayed because no data have been selected yet.

1. In the main menu, open **Analysis > Trends**.  
⇒ The «Trends» window opens.



2. In «Trend configuration», press  to open edit mode.
3. Add a «New trend configuration» (max 100/user).
4. In «Edit trend configuration», enter the trend name and mark the necessary trend data points(max. 20).




5. Confirm with  in «Trend configuration».
- ⇒ The trend configuration and the trend data points are saved.

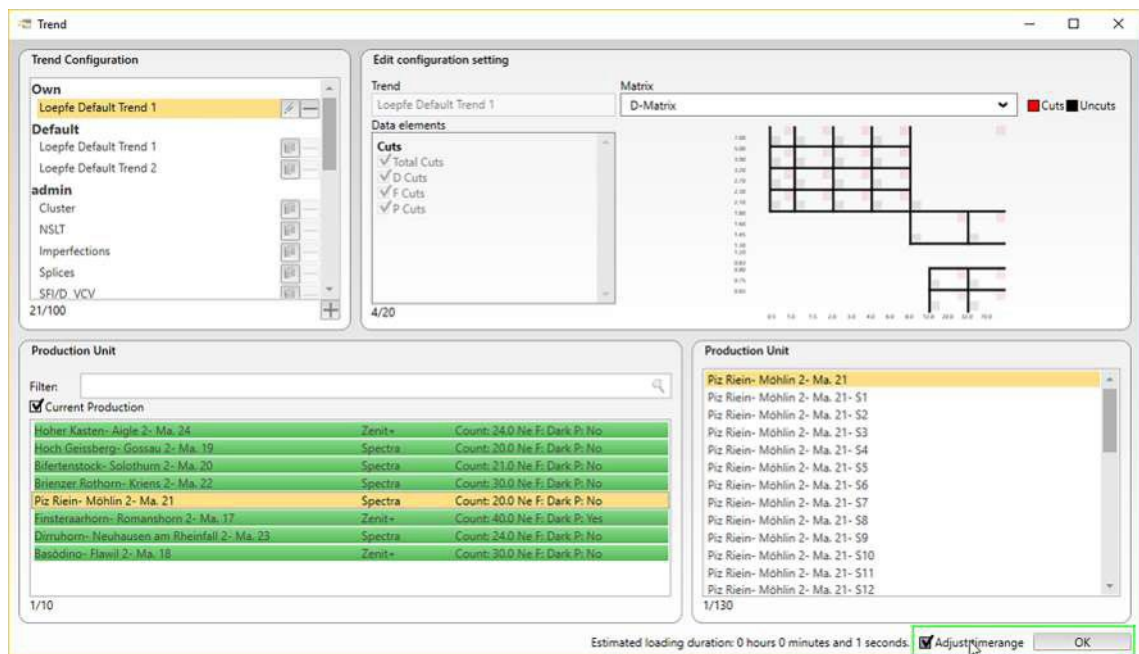
## Set trend configuration and production unit

### Prerequisites

The main menu is open.

No data are displayed because no data have been selected yet.

1. In the main menu, open **Analysis > Trends**.  
⇒ The «Trends» window opens.
2. Select the desired configuration in «Trend configuration».
3. Press  to modify the configuration if needed.
4. Select the desired object/machine under «Production unit».  
⇒ If multiple objects/machines are selected, no spindles can be displayed.  
⇒ If only one object/machine is selected, all spindles for the selected production unit are displayed.
5. Select one or more spindles.
6. Check the «Adjust time range» checkbox if desired.



7. Press «OK».  
⇒ The «Line chart» tab opens.  
⇒ Additional tabs can be opened with other representations.


## Lab trends (optional feature)

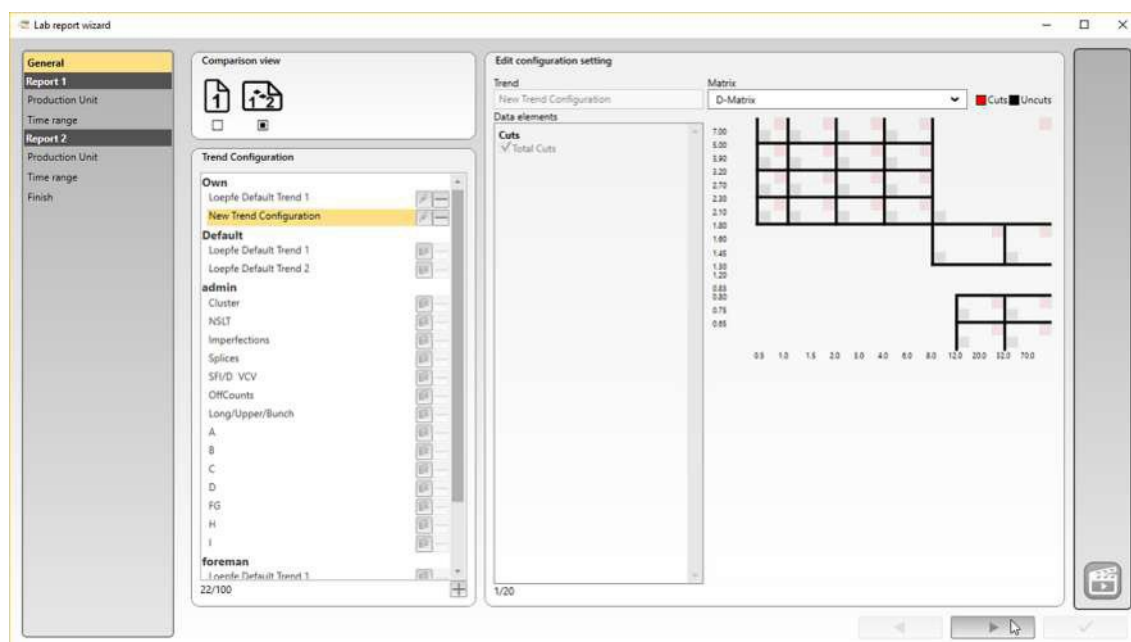
With the “Lab trends” option, reports on individual production units or comparisons of production units can be individually generated and displayed and printed in a combined trend report.

As in the Trends menu, production and quality data for a current time period are also displayed here. Trend reports are compiled and displayed from existing data elements from the Monitoring and Quality menu.

### Prerequisites

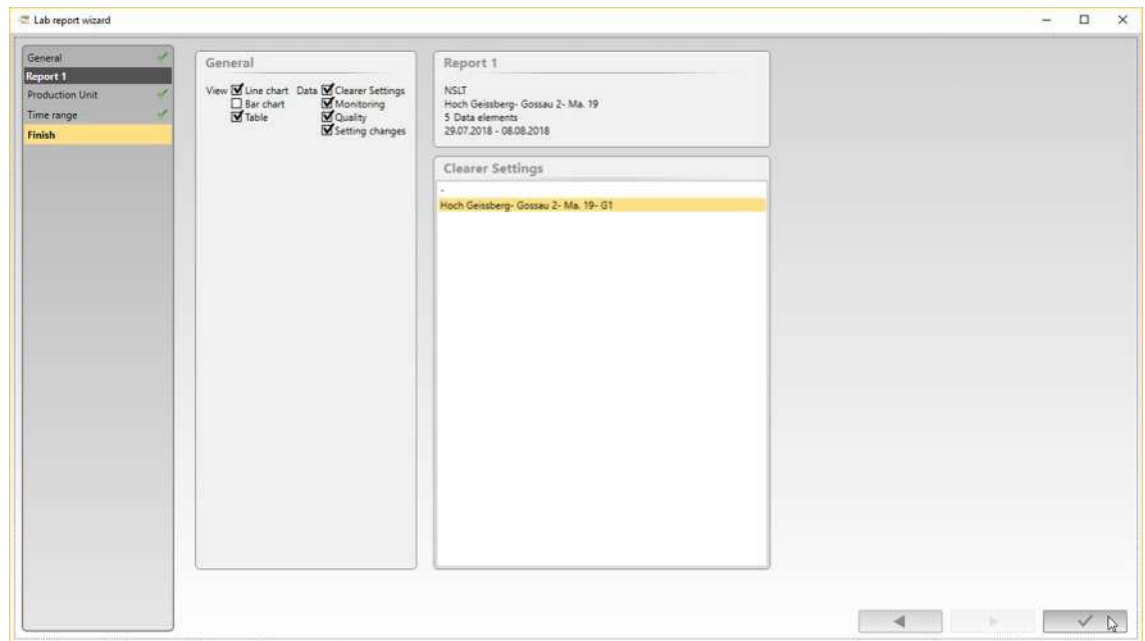
- ✓ The main menu is open.
- ✓ No data are displayed because no data have been selected yet.

1. In the main menu, open **Analysis > Lab trends**.  
⇒ The «Trend» window opens with the «Lab trends» tab.
2. Press  to create a trend report.  
⇒ The wizard opens.
3. Select the Comparison view, 1 or 1 <—> 2.  
⇒ If you select the 1 <—> 2 Comparison view, a second report appears in the menu at the left.
4. Select the desired configuration in «Trend configuration».



5. Press the «arrow».  
⇒ The “Production unit” tab opens.
6. Select the desired object/machine under «Production unit».





11. Press the «checkmark» button.

⇒ The trend report is created and can be printed out.

## 4.3.4 Management

This menu is used to manage the settings for articles, yarn clearers, and lots, and to transfer them to the machine. Synchronization between the software and the machine also takes place here.

### Articles

#### Prerequisites

The Main view is open.

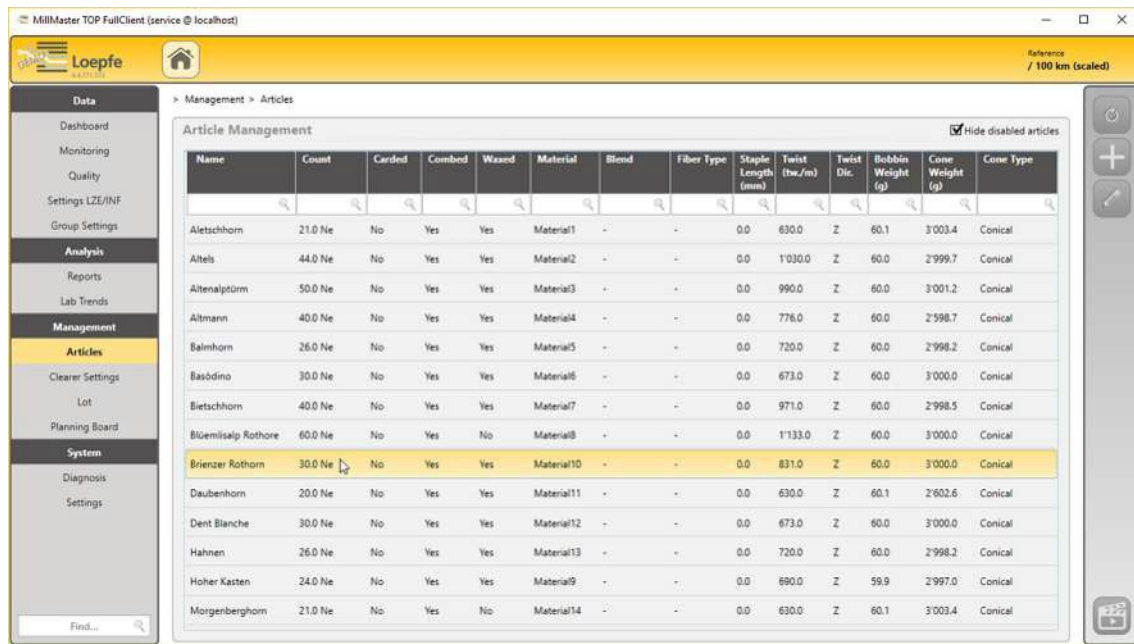
No data are displayed because no data have been selected yet.

1. Proceed to “Add article” or “Edit article” below.

### Add article

In the main menu, open **Management > Articles**.

⇒ The “Article management” menu opens.



2. Press .
  - ⇒ The «Create new article» window opens.

3. Enter settings in the input fields and selection menus, and edit values.



4. Press «OK».
  - ⇒ The new article is saved.
  - ⇒ The article has been added.

## Edit article



The article name can be changed in the Clearer settings [► 82] menu.

1.

- In the main menu, open **Management > Articles**.
  - ⇒ The “Article management” menu opens.
2. Search for a machine, in the list or using search fields.
3. Press .
  - ⇒ The «Edit article» window opens.
4. Enter settings in the input fields and selection menus, and edit values.

The screenshot shows the 'Edit article' window with the following settings:

- General:** Name: Aletschhorn 11, Material info: Material116, Yarn Count: 50.0 Ne, Additional Info: (empty), Activate article: ☒
- Material details:** Material: Pure, Fiber 1: CO-Cotton, Staple Length Fiber 1: 0.0 mm, Fiber 2: None, Staple Length Fiber 2: 0.0 mm, Blend: 100% / 0%, Blend additional Info: -, Conductive Material: No
- IPI Correction:** Neps +200%: Off /km, Thick +50%: Off /km, Thin -50%: Off /km
- Twist:** Twist: 0.0 tw/m, Twist Direction: -
- Style:** Type: Carded, Waxed: ☐
- Usage:** Warp: ☐, Weft: ☐, Knitting: ☐
- Bobbin / Cone:** ConeType: -, Cone Length/Weight: 160020 m / 1890 g, Bobbin Length/Weight: 0 m / 0 g

5. Press «OK».
  - ⇒ The data is saved.
  - ⇒ Article editing is complete.

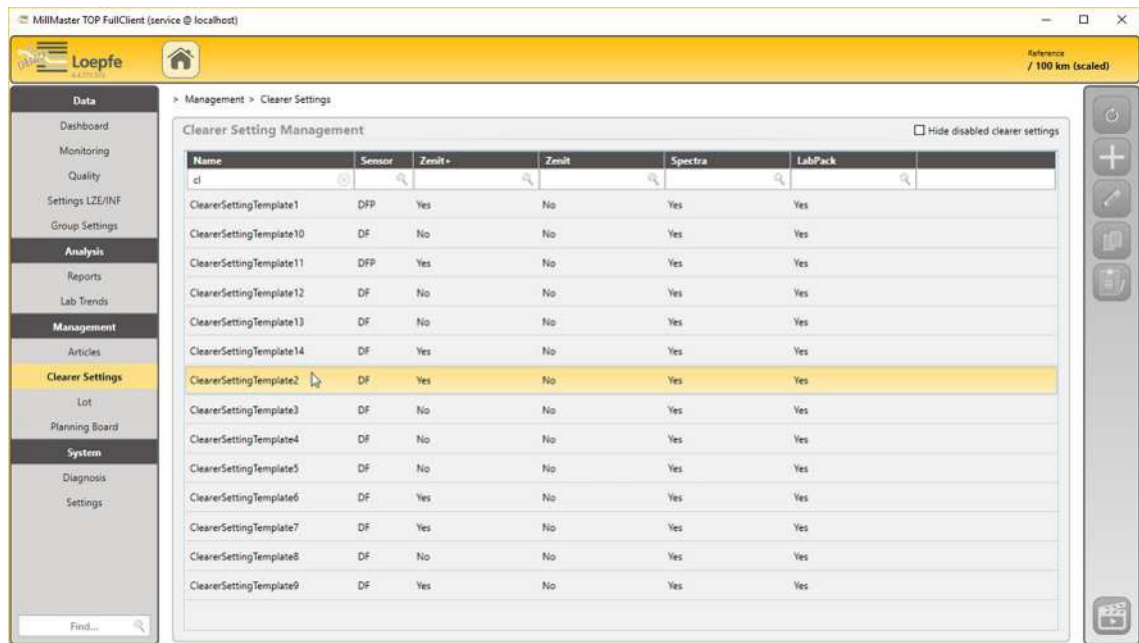
## Clearder settings


### Prerequisites

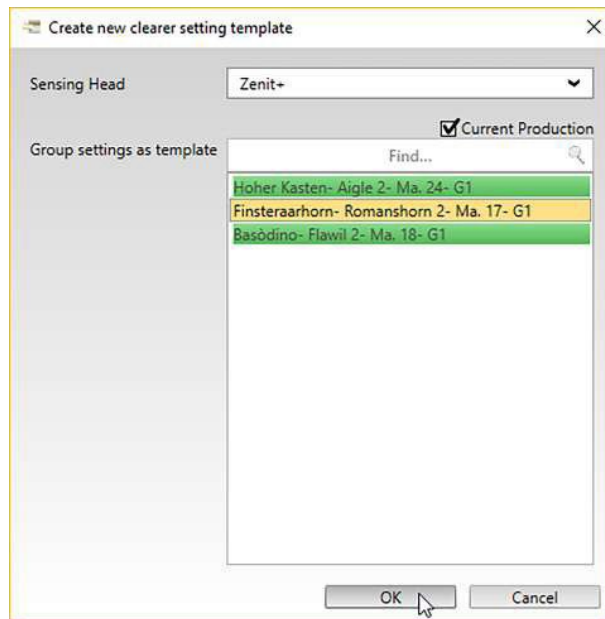
- ✓ The Main view is open.
  - ✓ No data are displayed because no data have been selected yet.
1. Proceed to “Add clearer settings” or “Edit clearer settings” below.

### Add clearer settings

1. In the main menu, open **Management > Clearer settings**.
  - ⇒ The “Clearer setting management” menu opens.




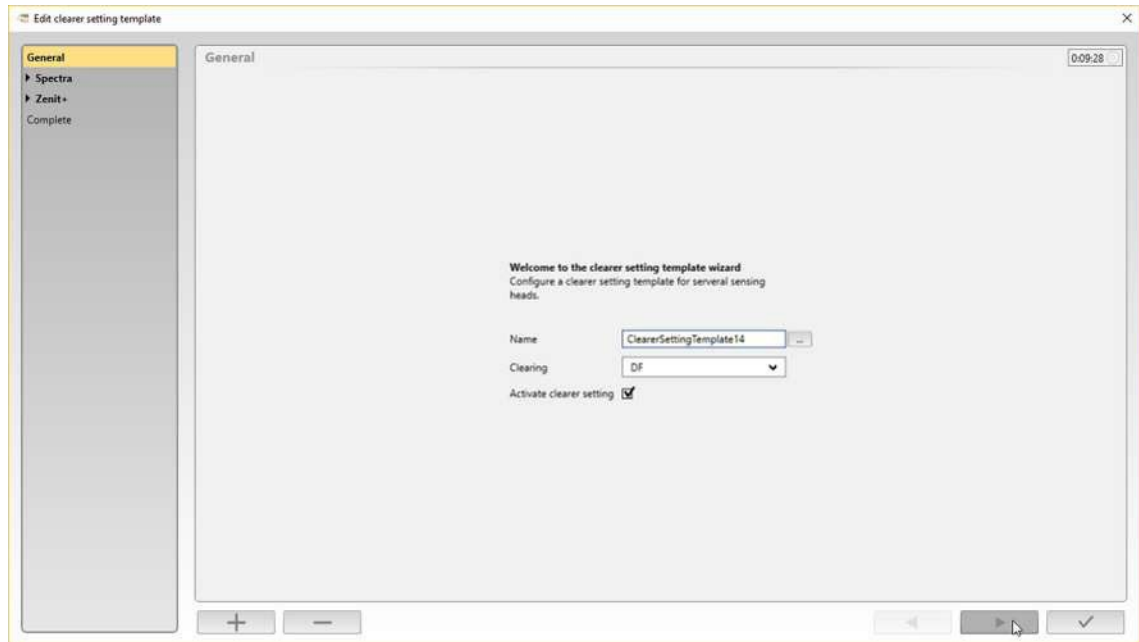
2. Press  .
  - ⇒ The «Add new clearer setting to template» window opens.
3. Select the sensing head and group settings.



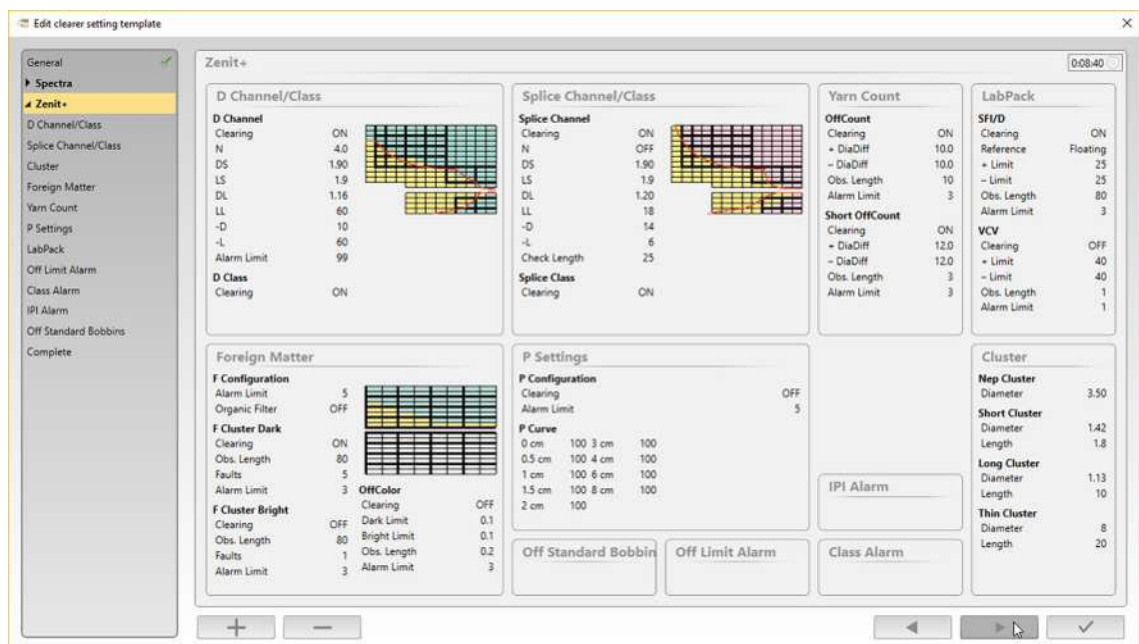
4. Press «OK».
  - ⇒ The wizard opens.
5. Enter a name for the clearer and select the desired clearing type.
6. Press the «arrow» to move on to the next setting.
  - ⇒ Continue to follow the wizard's instructions.
7. Confirm with the «checkmark» button.
  - ⇒ The changes are saved.
  - ⇒ The Synchronization menu opens.
8. Perform synchronization or close the menu.
  - ⇒ The clearer has been added.

### Edit clearer settings

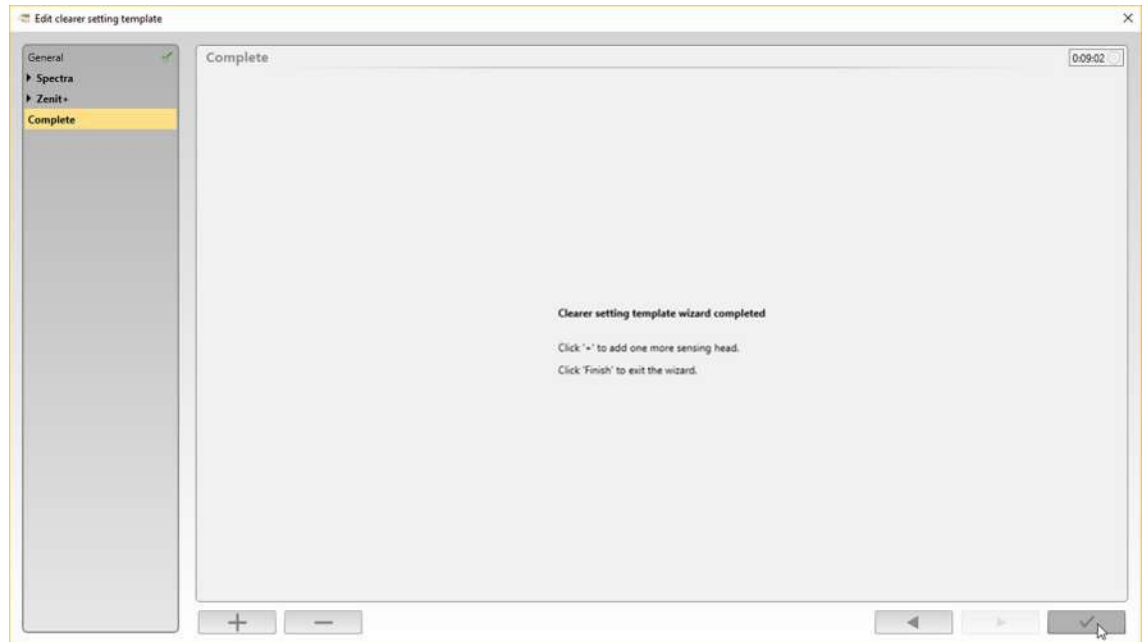
1. In the main menu, open Management > Clearer settings.
  - ⇒ The "Clearer setting management" menu opens.
2. Search for a clearer, in the list or using search fields.
3. Press  to edit a clearer.
  - ⇒ The "Edit clearer setting template" window opens.



4. If necessary, make changes to the name of the clearer and the desired clearing type.
5. If necessary, tick the "Clearer setting" checkbox.
6. Choose the clearer type in the menu at the left.  
⇒ The clearer settings overview opens.
7. Open and edit the desired settings.



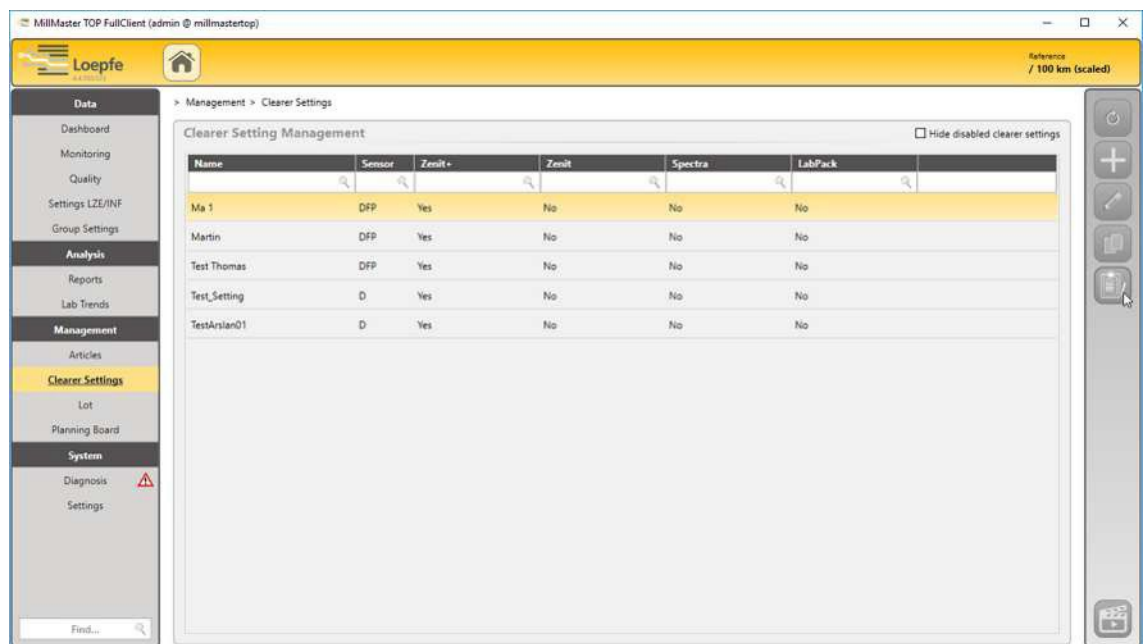
8. Press the «arrow» to move on to the next setting.
9. Confirm with the «checkmark» button.

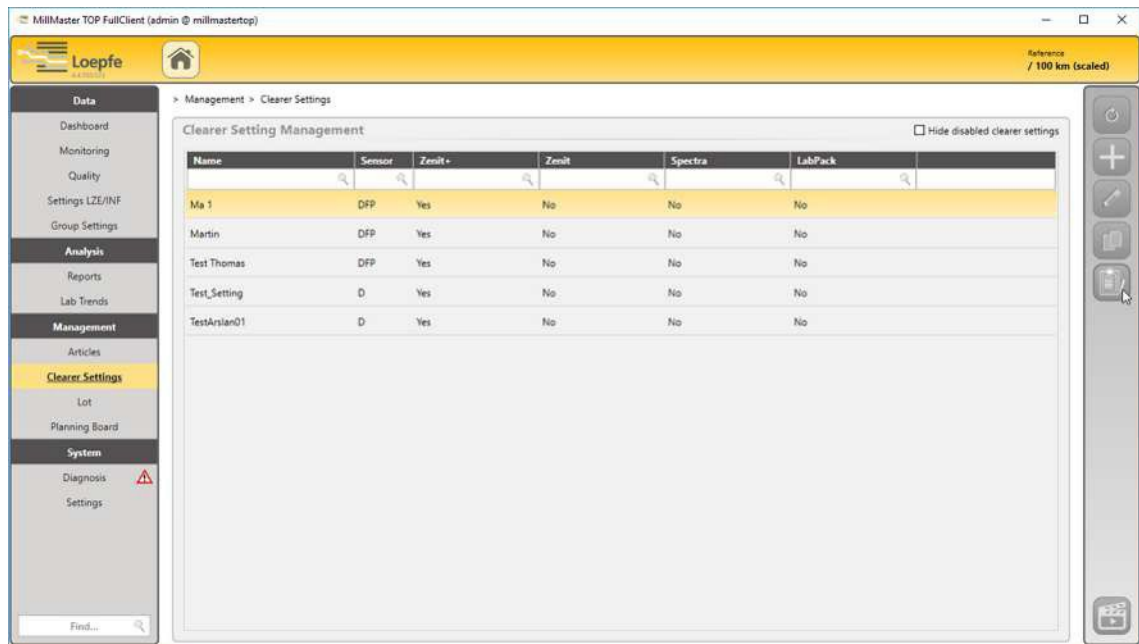




- ⇒ The data is saved.
- ⇒ The Synchronization menu opens.
- 10. Perform synchronization or close the menu.
- ⇒ The clearer settings are recorded.

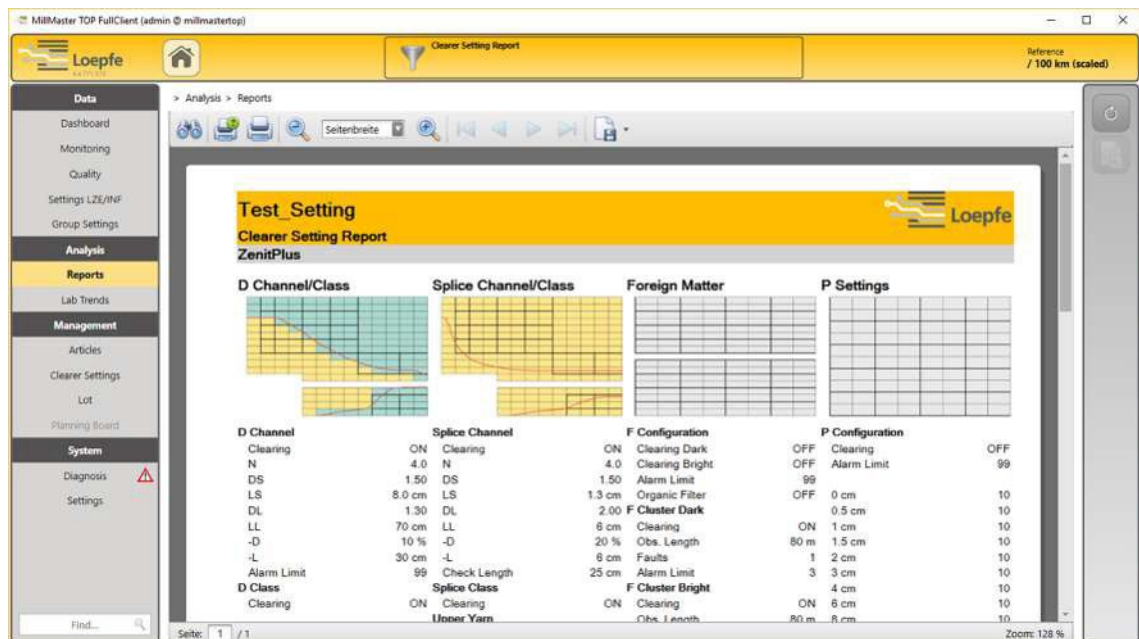
## Print clearer settings report

1. In the main menu, open Management > Clearer settings.
  - ⇒ The “Clearer setting management” menu opens.
2. Search for a clearer, in the list or using search fields.




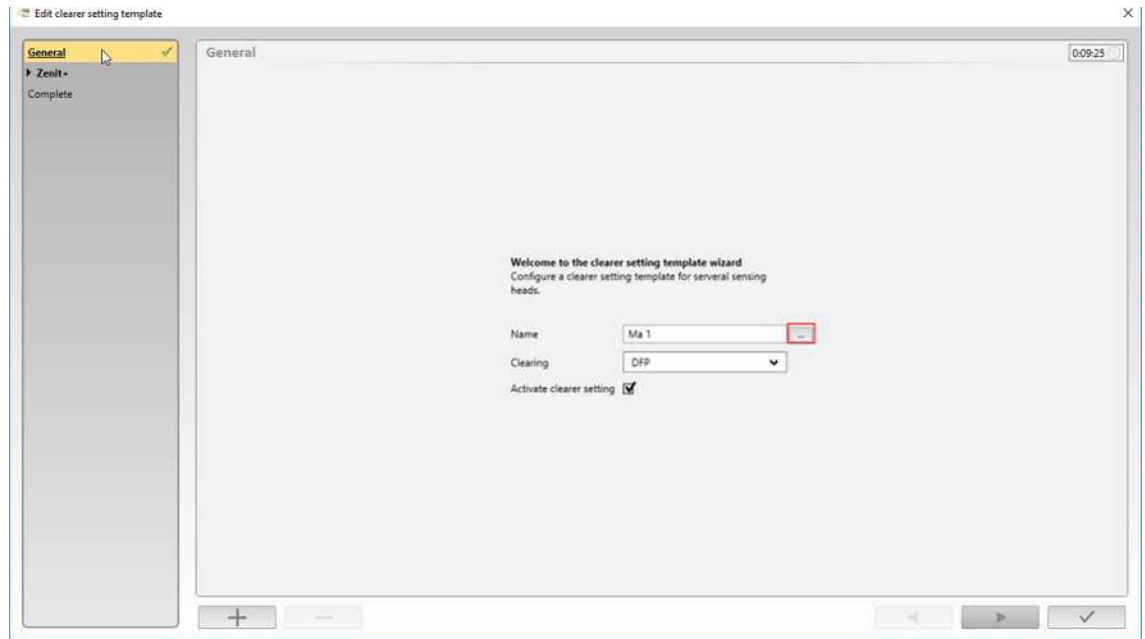


3. Press 
  - ⇒ The report is generated and opens.
4. Press  to print the report.
  - ⇒ The report is printed.



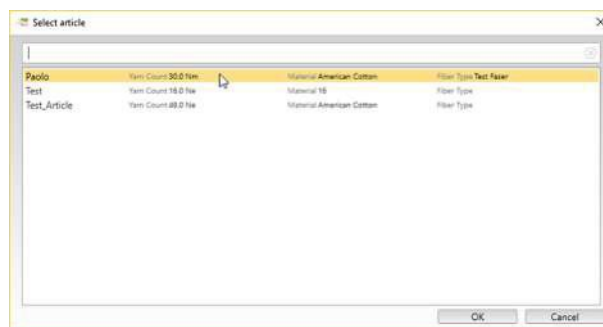
## Change article name

1. In the main menu, open Management > Clearer settings.
  - ⇒ The "Clearer setting management" menu opens.
  - ✓ Search for a clearer, in the list or using search fields.
2. Press  to edit a clearer.
  - ⇒ The "Edit clearer setting template" window opens.
3. Press the button next to the name of the clearer.



⇒ The “Select article” window opens.

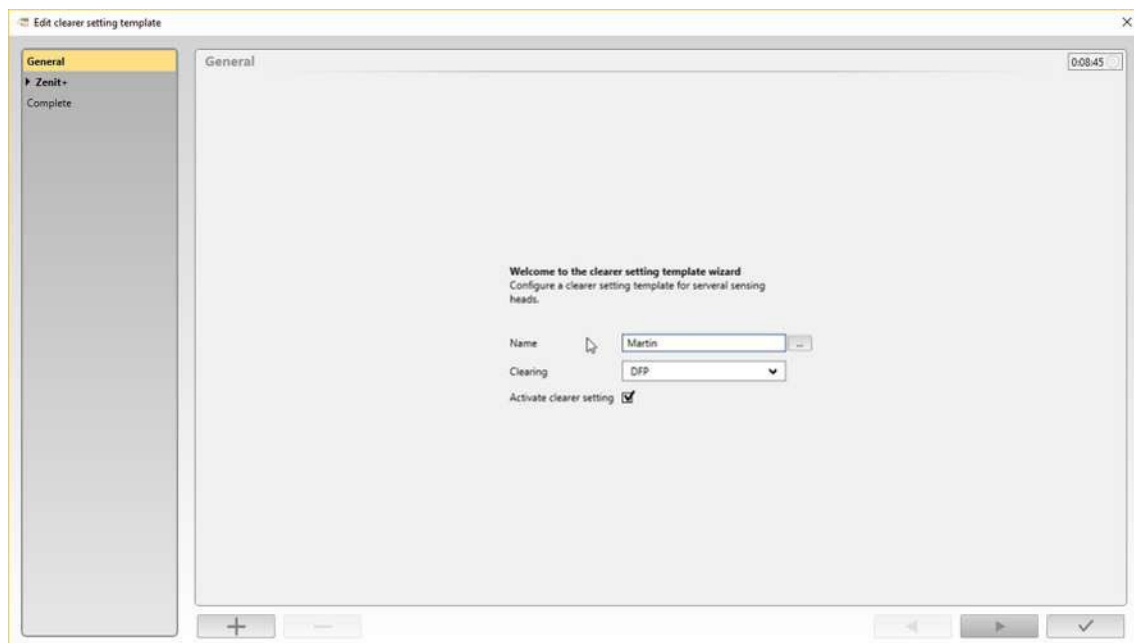
4. Select an article.



⇒ The window closes.

⇒ The article name is shown in the Name field.

5. Change the name.



6. Confirm with the «**checkmark**» button.  
⇒ The article name has been changed.



## Lot

### Prerequisites

- ✓ The Main view is open.
- ✓ No data are displayed because no data have been selected yet.

1. Proceed to “Add lot” or “Edit lot” below.




Double-click on the lot to show details. Double-clicking on another lot will hide these details again.

## Add lot


1. In the main menu, open **Management > Lot**.  
⇒ The “Lot management” menu opens.

Article	Lot Name	Yarn Count	Customer	Prod. Amount / Expected Production (kg)	Machine	Spindles	Ring spinning machine	Status	Prod. Amount (kg)
Hoher Kasten	Aigle 2	24.0 Ne	Customer1	3 / 20				Running	2.6
Aletschhorn	Allschwil	21.0 Ne	Customer1	0 / 1928	17	1 - 32		Planned	
					19	1 - 34		Downloaded	Article 2
					20	1 - 34		Downloaded	Article 5
					21	1 - 34		Downloaded	Article 3
					22	1 - 34		Downloaded	
Morgenberghorn	Luzern 2	21.0 Ne	Customer1	0 / 355	22	1 - 34		Downloaded	Article 20
Dent Blanche	Muttenz	30.0 Ne	Customer1	0 / 272	18	1 - 32		Planned	
Basodino	Pratteln	30.0 Ne	Customer1	0 / 330	17	1 - 32		Planned	
Balmhorn	Pully	26.0 Ne	Customer1	0 / 930				Downloaded	Article 5
Altels	Regensdorf	44.0 Ne	Customer1	0 / 410				Downloaded	Article 1
Daubenhorn	Thalwil	20.0 Ne	Customer1	0 / 1002				Downloaded	

2. Press .  
⇒ The «Add Lot» window opens, with the General menu.

3. Edit the fields marked in red under “Basic data”.
4. You may also enter other information, e.g. the color of the cops bobbin or cone bobbin.
5. Under «**Machines**», press  to add a clearer.
6. Choose “Machine with clearer”.
7. Enter other information, e.g. the numbers of one or more ring spinning machines 1, 3-5.  
⇒ A clearer, e.g. Zenit, is added in “Clearer settings” in the menu at the left.
8. In «**Group settings**», add the machine's basic settings.
9. In «**Thresholds and data points**», enter and select the necessary values.
10. If necessary, enter values under Optional.
11. Confirm with the «**checkmark**» button.  
⇒ The data is saved.  
⇒ The clearer/lot has been added.

## Edit lot

1. In the main menu, open **Management > Lot**.  
⇒ The “Lot management” menu opens.
2. Search for an article/lot, in the list or using search fields.
3. Press .  
⇒ The «**Edit lot**» window opens, with the General menu.

**General**

**Base Data**

Lot Name: Aigle 2

Article name: Hoher Kasten

Yarn Count: 24.0 Ne

Clearer setting template: ClearerSettingTemplate9

Clearing: DF

LabPack: ☒

Customer: Customer1

Amount: 813 km 20.0 kg

Color:

Slip: 0.0 %

**Machine**

Machine	Spindles	Pilot	Ring m.	Amount (Km/Kg)	m/min
21 (Section 1-34 DF Spectra)	1 34	3	0	170.6	4.2
24 (Section 1-128 DFP Zenit+)	1 128	13		642.2	15.8

**Thresholds**

Article Name:

Lotname:

Total Cuts:  80  100

F Cuts:  80  100

Short Cuts:  80  100

Long Cuts:  80  100

Thin Cuts:  80  100

Group State:

**Optional**

☐ Earliest lot start: 12.12.2018 13:18:00

☐ Latest delivery date: 12.12.2018 13:19:00

Expected performance:  80 %

4. If necessary, enter values under General.
5. Choose the clearer type under «Clearer settings» at the left.  
⇒ The clearer settings overview opens.

**Zenit+**

**D Channel/Class**

Parameter	Value
Clearing	ON
N	4.0
D5	1.90
LS	1.9
DL	1.16
LL	60
-D	10
-L	60
Alarm Limit	99
Clearing	ON

**Splice Channel/Class**

Parameter	Value
Clearing	ON
N	OFF
D5	1.90
LS	1.9
DL	1.20
LL	18
-D	14
-L	6
Check Length	25
Clearing	ON

**Yarn Count**

Parameter	Value
Clearing	ON
+ DiaDiff	11.0
- DiaDiff	11.0
Obs. Length	10
Alarm Limit	3
Short OffCount	ON
Clearing	ON
+ DiaDiff	12.0
- DiaDiff	12.0
Obs. Length	3
Alarm Limit	3

**LabPack**

Parameter	Value
Clearing	ON
Reference	Floating
+ Limit	25
- Limit	25
Obs. Length	80
Alarm Limit	3
VCV	ON
Clearing	ON
+ Limit	73
- Limit	21
Obs. Length	18
Alarm Limit	3

**Foreign Matter**

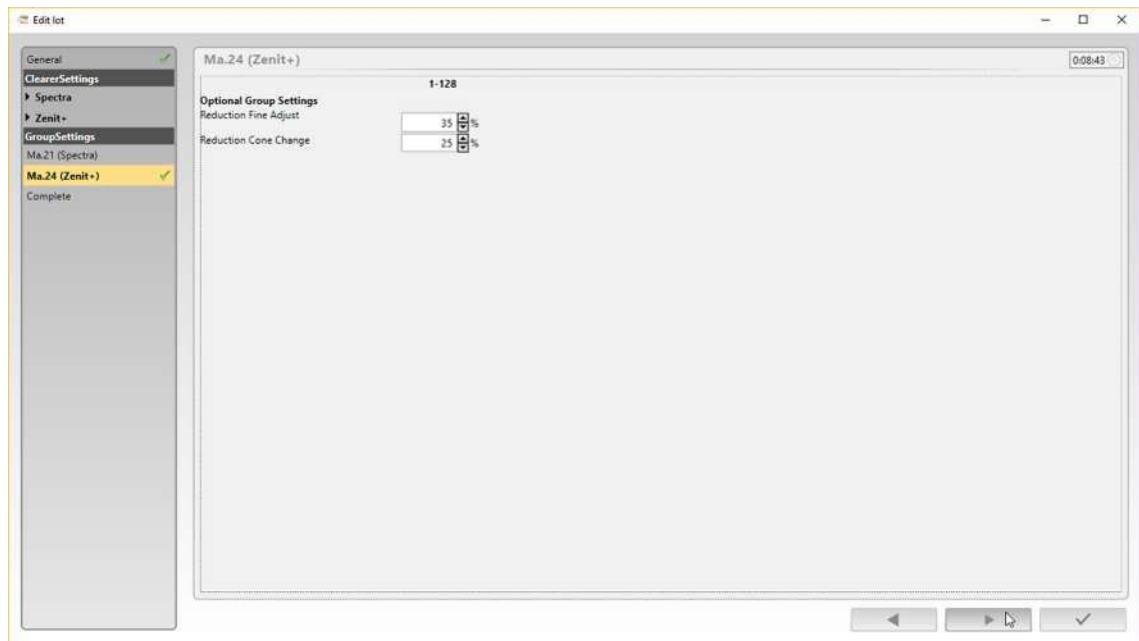
Parameter	Value
Alarm Limit	99
Organic Filter	OFF
Clearing	ON
Obs. Length	80
Faults	5
Alarm Limit	3
OffColor	OFF
Clearing	OFF
Dark Limit	0.1
Bright Limit	0.1
Obs. Length	1
Obs. Length	0.2
Alarm Limit	3

**Cluster**

Parameter	Value
Nep Cluster	1.50
Diameter	1.42
Length	1.8
Long Cluster	1.13
Diameter	10
Length	10
Thin Cluster	8
Diameter	20
Length	20

☐ Off Standard Bobbin ☐ Off Limit Alarm ☐ Class Alarm

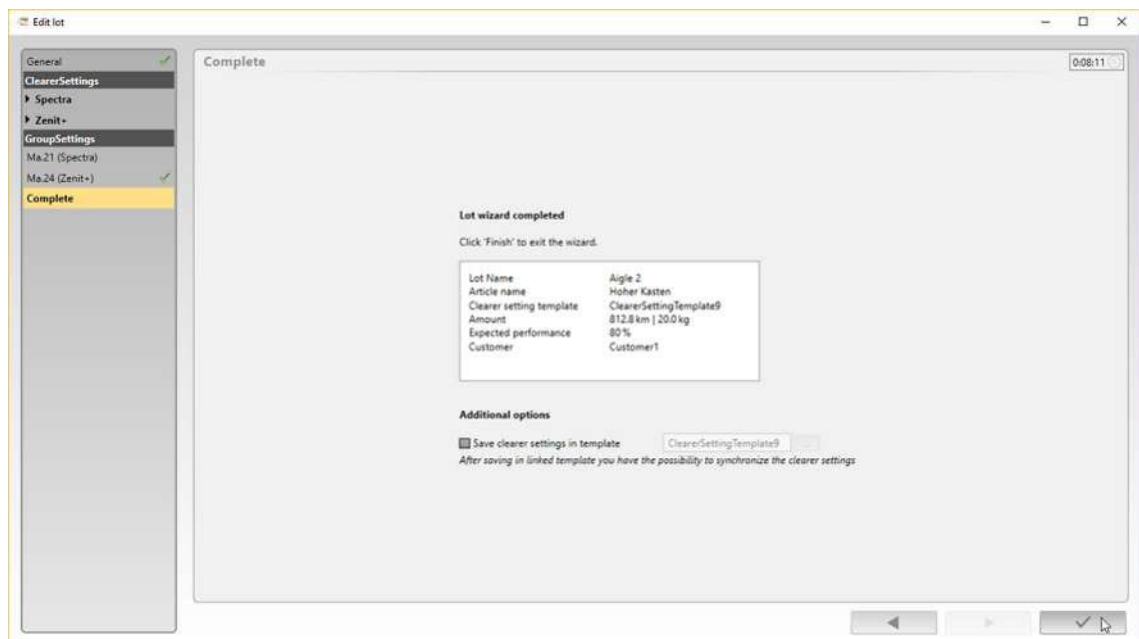
6. Press the «arrow» to open the necessary settings.
7. Edit the settings.
8. Press the «arrow» to move on to the next setting.
9. If necessary, edit the machine's basic settings under «Group settings».



10. Press the «**arrow**» to move on to the next basic setting.

11. Confirm with the «**checkmark**» button.

⇒ The «**Finish**» window opens.



12. Review the settings.

13. Tick the «**Additional options**» checkbox to save the clearer settings as a template.

14. Confirm with the «**checkmark**» button.

⇒ The data is saved.

⇒ The menu closes.

⇒ The Lot settings are recorded.



## Planning board (optional feature)

This menu provides an overview of the production status of all machines and their lots that were previously created in the Lot menu. Current production data can be displayed in tooltips, and productions can be stopped, changed and moved, and pauses can be added.

## Add and edit planning board

### Prerequisites



- ✓ The Main view is open.
- ✓ Data have already been entered in the Lot menu.

1. In the main menu, open **Management > Planning board**.  
⇒ The "Planning board" menu opens.
2. Press .
3. Press .  
⇒ The «Add lot» window opens, with the General menu.
4. Follow the additional instructions as described in the Lot [▶ 89] management chapter under «Add lot» and «Edit lot».
5. Confirm with the «checkmark» button.  
⇒ The data is saved.



## Add pause

### Prerequisites

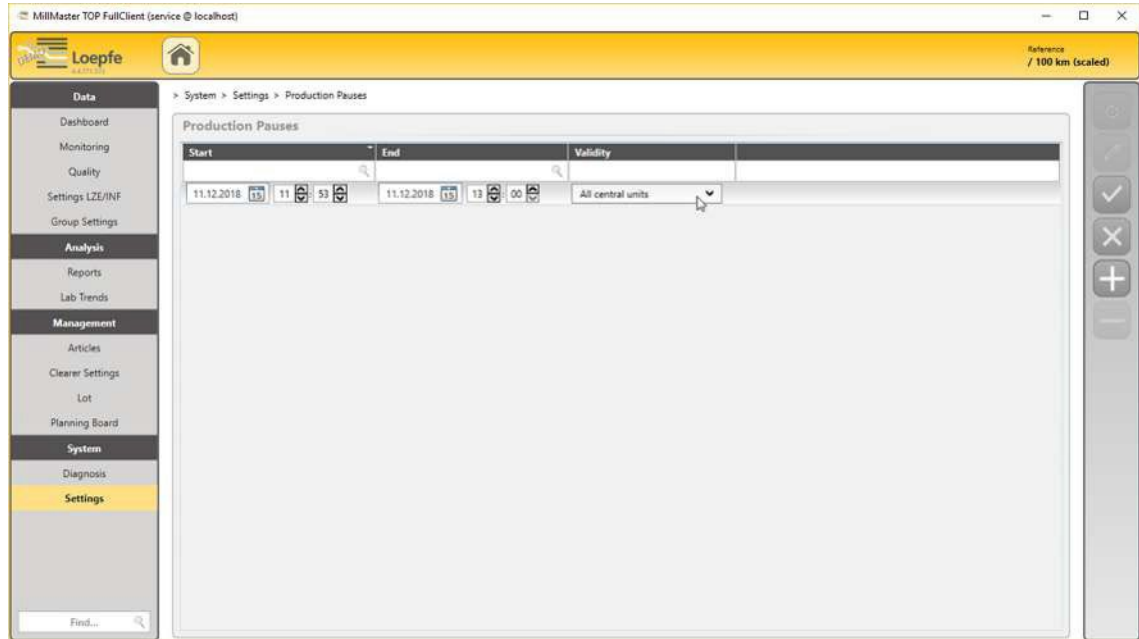
- ✓ The Main view is open.
- ✓ Data have already been entered in the Lot menu.

1. In the main menu, open **Management > Planning board**.  
⇒ The "Planning board" menu opens.
2. Press .
3. Press .  
⇒ The «Add pause» window opens.
4. Machine: Select a machine.
5. Duration: Select the length of the pause.
6. Press «OK».  
⇒ The pause is shown on the planning board.
7. Confirm with the «checkmark» button.  
⇒ The data is saved.

## Add production pauses

1. In the main menu, open **System > Settings > Production Pauses**.  
⇒ The menu opens.
2. Click .  
⇒ The menu is activated and can be edited.
3. Click .  
⇒ The **Start**, **Until**, and **Valid For** fields open.
4. In the **Start** column, open the calendar.

5. Select a date and time.
6. In the **Until** column, open the calendar.
7. Select a date and time.
8. In the **Valid For** column, select **Machine** from the selection menu.



9. Confirm with ☒ .
  - ⇒ The data is saved.
  - ⇒ The changes are activated and recorded.

## 4.3.5 System

In this menu, users can review the status of the system and configure the system settings. Licenses and options are also managed in this menu.

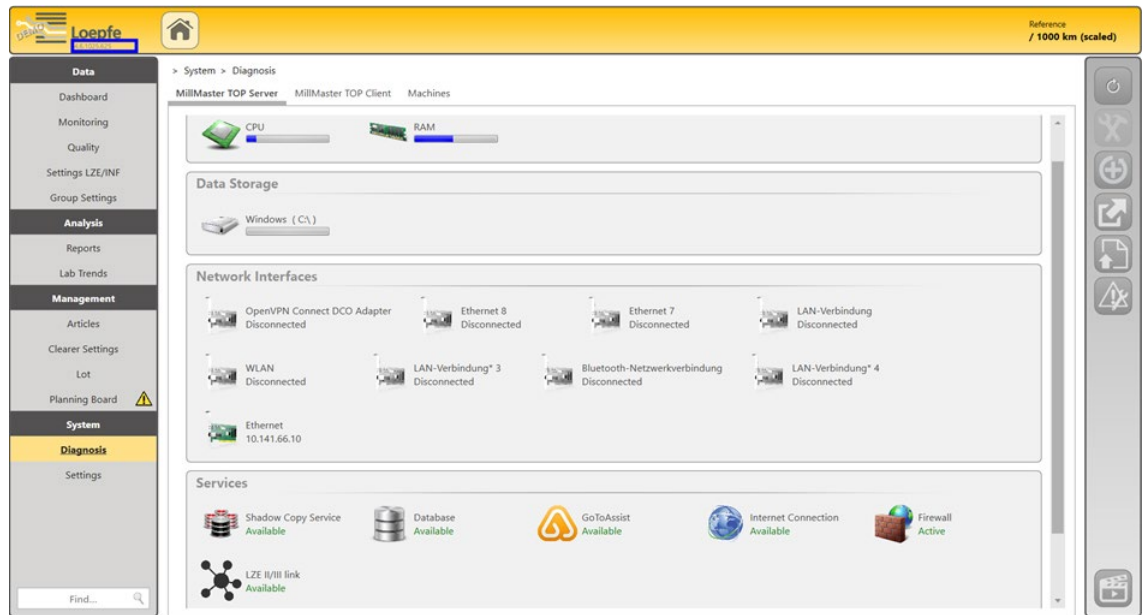
The following system settings were described earlier in the “System Startup” chapter.


- Configure MillMaster (TOP server) [► 56]
- Activate licenses and options [► 57]
- Custom reports [► 60]
- Add and edit shift calendar [► 62]
- Configure basic group settings [► 59]
- Update software [► 65]

## Diagnosis

In the Diagnosis section, a current overview is displayed as a diagnostic report and as a logfile dump, both of which can be exported.


1. In the main menu, press **System > Diagnosis**.
  - ⇒ The Diagnosis menu opens.

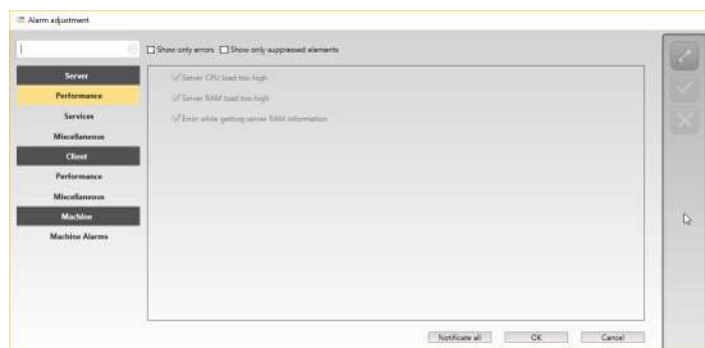



2. Select the desired tab: «Server, Client or Machine».
3. Press  (Diagnostic report).  
⇒ A «Windows File Explorer» window opens.
4. Locate the directory in which you want to save the diagnostic report file.
5. Press «Save».  
⇒ The file is saved.  
⇒ The file is saved and can then be emailed to the Loepfe Customer Support and Services team at [service@loepfe.com](mailto:service@loepfe.com).


## Alarm settings

This menu can be used to change the alarm settings.

1. In the main menu, press **System > Diagnosis**.  
⇒ The Diagnosis menu opens.
2. Select the desired tab: «Server, Client or Machine».
3. Press .  
⇒ The «Alarm settings» window opens.



4. Press .
5. Configure alarm settings for the server, client and machines.

6. Press .

⇒ The data is saved.

⇒ The changes are activated and recorded.

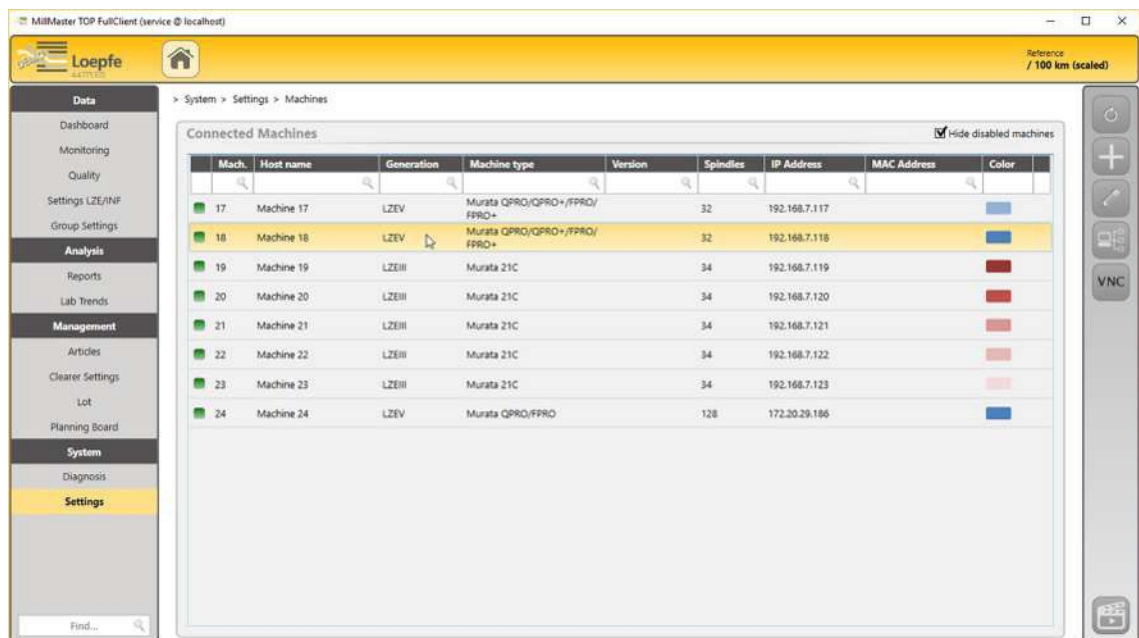
## Settings

### Edit machines

red Machine is unreachable. The connection between MillMaster TOP and the machine is broken.  
 yellow Machine is reachable. However, the software cannot communicate with the machine because data transfer has not yet occurred or because multiple different configurations are present.  
 green Machine is reachable. The connection between MillMaster TOP and the machine is OK.

In the main menu, open **System > Settings > Machines**.

⇒ The **Settings > Connected machines** menu opens.



2. Search for a machine, in the list or using search fields.

⇒ If no machines are shown, add them manually or check the connection data.

3. Press .

⇒ The «Edit machine» window appears.







4. Edit values in the input fields under «**Connection**», «**Machine Parameters**», and «**Sections**».
5. If spindles have been added, press «**Add section**» to add spindles.
6. Press «**Save**».
  - ⇒ The data is saved.
- ⇒ The changes to the machine are complete.




## Fault images

### Prerequisites

- ✓ New material is being produced.
- ✓ The images for new material are available.

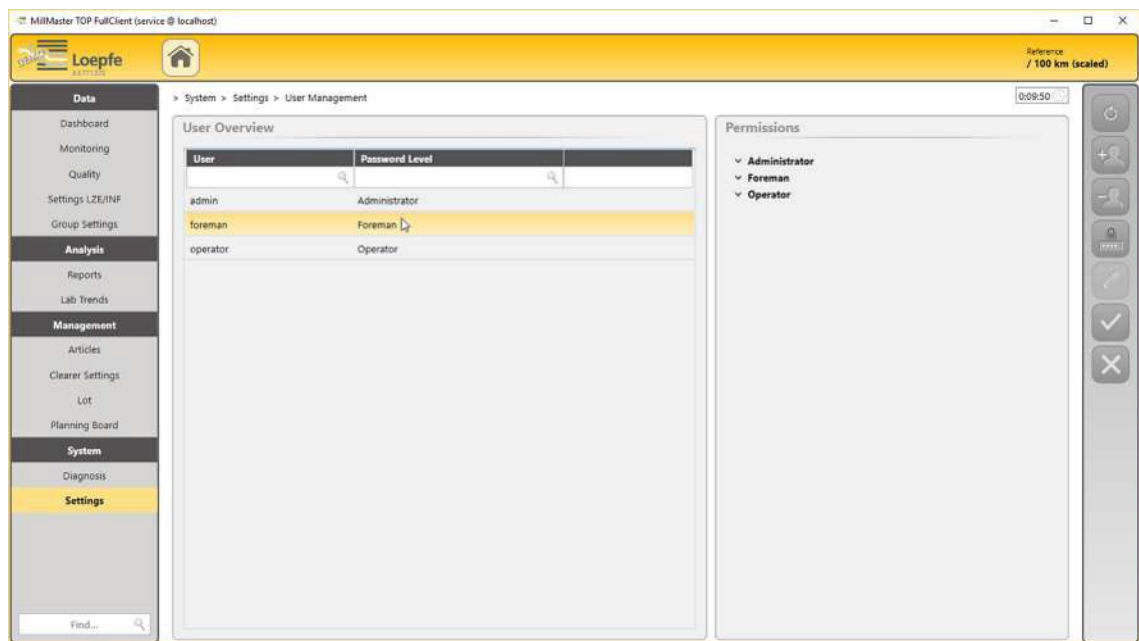
1. Open Windows Explorer.
2. Select and copy the directory at `C:\Program Files\Loepfe MillMaster TOP\4.x.xxx.xxx\Loepfe.BDE.Client\0.0.0.0\YarnFaultDefaultImages`.
3. Paste the «**YarnFaultDefaultImages**» folder into another folder.
4. Rename the «**YarnFaultDefaultImages**» folder, e.g. with the name of the new material.
5. In the new folder, overwrite the existing images individually, but do not change the filename or format.
6. Switch to the «**MillMaster TOP**» software.
7. In the main menu, open **System > Settings > Yarn fault images**.
  - ⇒ The **Settings > Yarn fault images** menu opens.
8. Press .
  - ⇒ The menu is activated and can be edited.
9. Press  in the «**footer**».
  - ⇒ The «**Add Yarn Fault Set**» window opens.
10. In the “Material selection” menu: Select a material.
11. In the “Yarn count” text box: Enter the yarn count.
12. In the “Path selection” menu: Find the directory path of the new folder.
13. Press «**OK**».
  - ⇒ The new material is added and the images are imported from the folder.
14. Under “Yarn faults”, left-click on the image names to check images.


## Edit production pauses (optional)

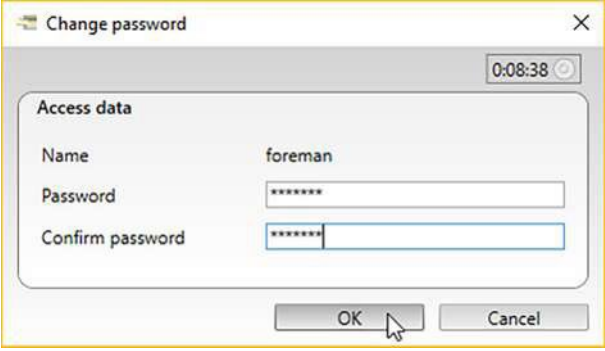
1. In the main menu, open **System > Settings > Production pauses**.  
⇒ The «Production pauses» menu opens.
  2. Press .  
⇒ The menu is activated and can be edited.
  3. Press .
  4. Search for a machine, in the list or using search fields.  
⇒ The **Start**, **Until**, and **Valid for** fields open.
  5. Edit the values if necessary.
  6. Press .  
⇒ The data is saved.
- 🕒 The changes are activated and recorded.

## Change user password

1. In the main menu, press **System > Settings > User management**.  
⇒ The «User management» menu opens.



2. Search for a user in the list or using the search field.
3. Press .
4. Double click on a user to edit their profile.  
⇒ The «Change password» window opens.



Change password

0:08:38

Access data

Name foreman

Password \*\*\*\*\*

Confirm password \*\*\*\*\*

OK Cancel

5. Enter the new password.
6. Press «OK».
  - ⇒ The data is saved.
- ⇒ The password has been changed.

## 5 Service

### 5.1 Support

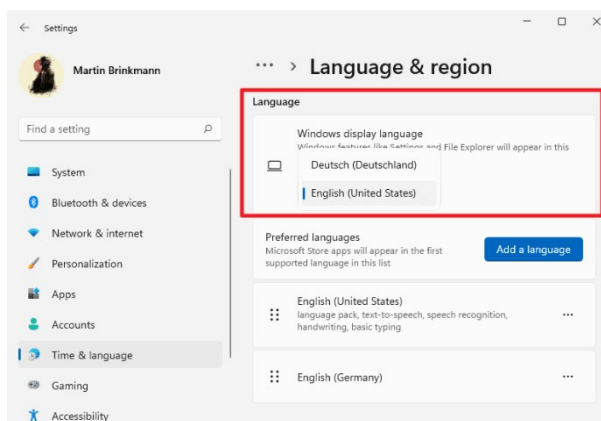
In order for the support team to be able to use the Windows operating system's user interface in English when support is needed, the operating system should be installed in English, or the English language package should be installed.

- ✓ The Windows 11 operating system is installed.

1. Restart the computer to open the BIOS.
  - ⇒ A message appears at the bottom of the screen: «Please press DEL or F2 to Enter UEFI BIOS settings».
2. Press the «DEL» or «F2» key during the reboot process.
  - ⇒ The «UEFI BIOS» menu opens.
3. Select the Language symbol to open language settings. ("Select your preferred language.")

Or?

1. Open **Settings > Time & Language > Region & Language**.



2. Press «Add a language» and select English.
  - ⇒ The English language package becomes available and is shown.
3. Press «English language package available».
4. Press «Options».
  - ⇒ The language options window opens.
5. Press «Download» to download the language package.
  - ⇒ The language package is downloaded.



Loepfe Brothers Ltd.  
8623 Wetzikon/Switzerland  
Phone +41 43 488 11 11  
Fax +41 43 488 11 00  
[service@loepfe.com](mailto:service@loepfe.com)  
[www.loepfe.com](http://www.loepfe.com)