

The logo for mySCADA, featuring a white square icon with a grid pattern to the left of the text "mySCADA" in a white, sans-serif font.

**mySCADA**



# Sheet metal processing/Metallurgy

REFERENCE  
2021

## INTRODUCTION

METAL TRADE COMAX, a.s., (MTC) is engaged in continuous painting (as the only company in Europe), it is also a producer of foundry alloys, aluminium and copper pre-alloys and as the only one in the Czech Republic, it also provides supplies of liquid aluminium. It has 4 production plants and employs 670 people. They were looking for a complement to their existing SCADA system for their plants that would better meet the requirements of modern production, help to optimize processes and thus reduce costs.



## ABOUT THE PROJECT

Currently, mySCADA is running in Kolín and Velvary and monitors operations on the painting, cutting and packaging lines. The system connects about 20 machines and allows to collect, store and evaluate production data. Individual screens relevant to each part of production can be displayed using a clear menu.

*Ex. The foreman can see and work with the entire system, quality control primarily uses real output data and compares it with planned figures. Employees have been trained and can therefore use the system to its full potential, e.g. they can export important data themselves or add notes for others.*

As production information grew, the developers had to look for a new system that better matched their requirements.

The flexibility and openness of the development environment became the most important criteria for selecting a new system. The ability to **continuously adapt the project** and modify it according to the needs that arose at the time proved to be the most important requirement for the new system. **Interconnectivity** with the existing system was also absolutely crucial. Another plus point that contributed significantly to the choice of mySCADA was the ability to connect an **unlimited number of users**. This solved MTC's licensing problem.

An important selection criterion was the local technical support both by phone and email, which contributed to the rapid development of the project and its easy integration into the existing system.

mySCADA allows the connection of a large number of static and mobile devices, which was not possible in the original SCADA version. Moreover, connecting more devices does not mean more costs in the case of mySCADA, which is, on the contrary, a classic "trick" of most SCADA manufacturers.

*Ex. Previously, operational problems occurred mainly in the execution of orders: parameters were written in the form of long text directly on the purchase contract, inaccuracies occurred, non-compliance with the yardage, late arrival of colours or wrong choice of colours, non-compliance with the packaging code, all this led to errors and huge costs (high scrap rate).*

It was because of these shortcomings that the company had to implement mySCADA software in addition to the existing Genesis 32 (Iconics) system, which eliminated the errors of the past and added many features that MTC uses extensively.

## PROJECT - VISUALIZATION

For this project, myPRO software was chosen as the ideal solution for such a large installation. Data is read from various automated machines primarily from Simatic (Siemens), SQL databases, etc.

Currently the system reads data from about 20 machines and devices. In the case of an unexpected event, an alarm appears on the screen and the line operator can start dealing with the event immediately (without delays). At the same time, the system can also alert via SMS or email.

*Ex. When changing the order (from old to new), it is necessary to change the roll. Before the implementation of mySCADA it was not possible to control how long the exchange takes, and why it started later. With the new control system, the delay can be easily quantified, the specific costs associated with it can be documented for a given case and therefore processes can be easily optimized.*

Picture 1 - Order Overview

Picture 2 - Order Detail

Číslo zakázky: **VZ-LL-21010872 / 10000**    Kód příčiny: **LL21-8219**    Kupní smlouva: **KS-ZK-2115289**

Popis: **FeZn 0,47x1154mm / PVC 9010 FOODSAFE J**  
**SALBOND ADHEZIV PVC 710 9230**  
**SALBOND ADHEZIV PVC 710 9230**

Poslední reklamované vady

Obchodník: \_\_\_\_\_    Zákazník: \_\_\_\_\_

Celkem	Požadováno obchodníkem	Vyrobeno	Zbývá vyrobit	Nejméně	Nejvíce
20937	17500	0	20937	17500	21000
4917	4110		4917	4110	4932

ODVŮJENÝ SVITEK    VYRÁBĚNÝ SVITEK    LL21-8219

Číslo: **5946571**  
 Kód příčiny: **LL21-8219**  
 Hmotnost: **10300 kg**  
 Odvinutá délka: **1610 m**  
 Zbývající hmotnost: **3444**  
 Zbývající délka: **808**

Popis: **S220GD | Z200**  
**FeZn 0,47x1154mm S220GD**  
**PVC 9010 FOODSAFE J**

Min	Hmotnost	Vypočtená	Max
	<b>1000</b>	<b>460</b>	<b>4000</b>

Min	Délka	Měřená	Max
	<b>234</b>	<b>108</b>	<b>939</b>

LAMINO  
**PVC FOODSAFE REINWEISS 9010 1185mm I**  
**150mí F455-1342 H +/-0,5**  
**Brucha**

sklad 50: **6061 m**    sklad 53: **48056 m**

	NDC	DEMI voda	MIXER hladina	MIXER vodivost
horst	<b>0.00</b>	<b>69.41</b>	A <b>398.13</b>	<b>11.11</b>
délka	<b>0.00</b>		B <b>399.56</b>	<b>9.52</b>
		g/m <sup>2</sup>	%	mm

Následující zakázky

Číslo zakázky	Popis	Množství	Specifikace
VZ-LL-NAV2015 PS			
VZ-LL-21012459 LL21-8979	PVC 9010 FOODSAFE J	2757 m	
VZ-LL-NAV2015 PS			
VZ-LL-21013484 LL21-9503	FOLIE MT P02T-2-N50/1250	4721 m	
VZ-LL-21013514 LL21-9508	FOLIE MT P02T-2-N50/1250	1671 m	

Picture 3 - Order Detail 2

AKTUALNÍ ZAKÁZKA    Od: 10:53 — 29.9.2021    Do: 12:26 — 29.9.2021

Číslo zakázky: **VZ-LL-21011270 / 10000**    Kód příčiny: **LL21-8453**    Kupní smlouva: **KS-ZK-2115691**

Popis: **FeZn 0,60x1213,5mm / PVC 9016Smooth FOODSAFE J+SF**  
**PVC FOODSAFE BRIGHT WHITE 9016 Satin 455-1347**  
**SALBOND ADHEZIV PVC 710 9230**

Poslední reklamované vady

Obchodník: \_\_\_\_\_    Zákazník: \_\_\_\_\_

Celkem	Požadováno obchodníkem	Vyrobeno	Zbývá vyrobit	Nejméně	Nejvíce
12267	12 000	0	12267	10800	13200

tolerance sirka: **-0/+5mm**  
**Povrch folie nesmí mít bublinky, tecky, carky způsobených aplikací**  
**pricna delicka**

NÁSLEDUJÍCÍ ZAKÁZKA

Číslo zakázky	Kód příčiny	Kupní smlouva
VZ-LL-NAV2015	PS	

Popis: \_\_\_\_\_    Celkem: \_\_\_\_\_    Požadováno obchodníkem: \_\_\_\_\_

Poznámky: \_\_\_\_\_    Počet: \_\_\_\_\_    Cívka: \_\_\_\_\_

INFORMACE K ZAKÁZCE  
**MINIMÁLNÍ MNOŽSTVÍ NESPLNĚNO**

BALENÍ  
 Typ: **v8-Ki2+ C500**  
 Popis: \_\_\_\_\_  
 Rozměr palety: \_\_\_\_\_  
 Hmotnost MIN / MAX: **min: 1500 max: 4500**  
 Průměr: \_\_\_\_\_  
 Hloubka: \_\_\_\_\_  
 Počet: **3**  
 Cívka: **13 mm**  
 Hmotnost pleťky: \_\_\_\_\_  
 Povrchová barva: \_\_\_\_\_  
 Další výrobní operace: **pricna delicka**

VYROBĚNÉ SVITKY  
 Výrobní barva / Hmotnost / Délka  
 celkem vyrobeno: **0**



Picture 4 – Order Detail 3

## ADDED VALUE

"Time savings, less errors, production data readily available, real-time comparison of machine and production data. Simply having the right data in the right place is the key to savings for us," says Jiří Anděl - MTC programmer.

Other benefits are undoubtedly **the unlimited number of users** and any number of displays. Also, **the variability of the system**, which in practice means that currently the employees themselves say what they need to see on the screens during their shift. Due to the large amount of data at some stations, multiple screens flash on a single monitor at a certain time interval.



Picture 5 - Specific wiring in production

For the development department, the biggest plus is the development environment, which is very open and basically everything can be created or added according to the needs of users. mySCADA can also be easily connected with other ERP systems of the company, with NPM packages (scripting), etc.

## CONCLUSION

The new system saves time and costs. By controlling production in real time and reporting the data obtained, the company is able to correct errors in certain areas much more efficiently than it was under the old system, when the risk of poor production was really high. Now, production is virtually error-free, saving costs in the millions.



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