



Welcome!

**We will be starting soon...**

Webinar WE7:

**COPRA<sup>®</sup> RF 2011 –**

**Roll Lifecycle Management (RLM)**



**data M**  
Sheet Metal  
Solutions

Sound is provided via Internet only. Please connect speakers or headphones to your computer in order to follow the presentation.

# Topics

- The stock of rolls available in the database
- Benefits from using the COPRA<sup>®</sup> RLM database
- Information stored to the database
- How to find and use existing roll tools
- Bill of material, Ordering and stocktaking
- Additional features
- Demonstration of several functions
- Future prospects

# The Stock of Rolls in the Database

COPRA® RLM Database



Search and use suitable rolls

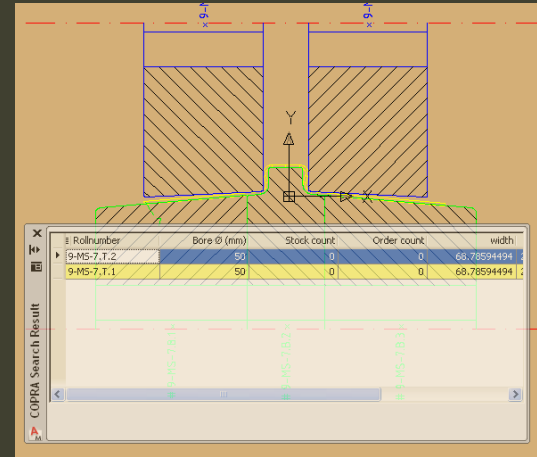
Database represents the stock of rolls



Stock of rolls

Ordering and/or producing rolls

COPRA® RF Design



Detailed Bill of material

## Order Bill of Material



Rollnumber	Bore Ø (mm)	Order count	max diameter	Combirollset
CombiSet_1_3	50.0000	14	156.0164	CombiSet_1
CombiSet_1_2	50.0000	10	208.6142	CombiSet_1
9-MS-1.T.2	50.0000	1	194.3418	
9-MS-2.B.2	50.0000	1	167.2432	
9-MS-2.T.2	50.0000	1	194.2704	
9-MS-3.B.2	50.0000	1	175.6874	
9-MS-3.T.2	50.0000	1	194.3417	

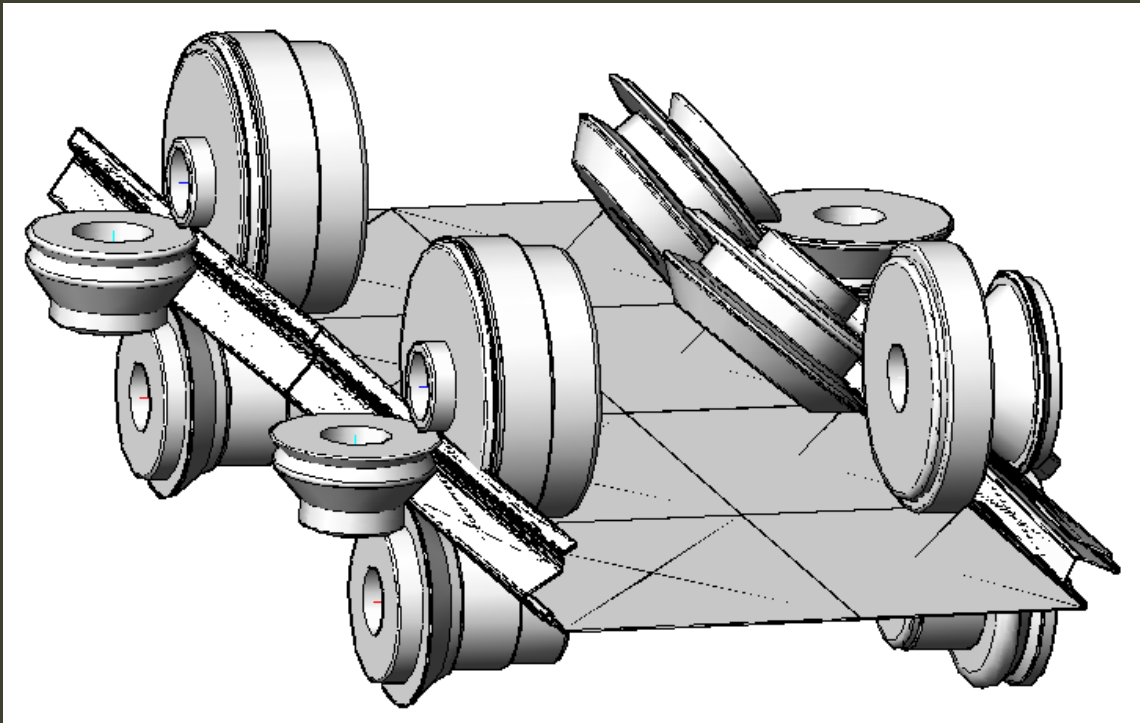
# Benefits for Rollforming Companies

- Saving of cost, time and storage space by flexible re-use of existing Rolls
- Saving of cost by re-using Rolls from finished Projects
- Collection of Data relevant for Production Planning, Quality Management and Stocktaking
- Extensibility for Company-specific Issues



# Information Stored

- Machine setup



- Stations
- Axes / Shafts
- Roll positions
- Fitting positions
- ...

# Information Stored

- Stock and Order Information



Order Bill of Material

Orderer: Steimer      Supplier: Hussmann Drehtechnik

Date of order: Mittwoch, 25. Januar 2012      Date of delivery: Mittwoch, 1. Februar 2012

In order to group the data, drag one column here!

Rollnumber	Order count	Stock count	Bore Ø
Kombiset 1_xx	5	0	63.00
3-O1	2	0	63.00
1-U6	1	0	63.00
1-U5	1	0	63.00
1-U4	1	0	63.00
1-U3	1	0	63.00
1-U2	1	0	63.00
1-U1	1	0	0.00
1-O2	1	0	63.00
1-O1	1	0	63.00
2-R2	1	0	35.00
2-R1	1	0	35.00
2-L2	1	0	0.00
2-L1	1	0	0.00
3-U5	1	0	63.00
3-U4	1	0	63.00
3-U3	1	0	63.00
3-U2	1	0	63.00
3-U1	1	0	0.00
3-O2	1	0	63.00
4-R2	1	0	35.00
4-R1	1	0	35.00
4-L2	1	0	0.00

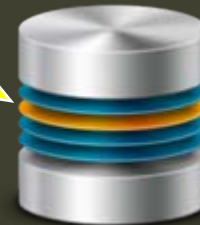
- Stock Count
- Delivery Information
- Count of Rolls to Order
- ...

# Information Stored

- Quality Management and Production Planning



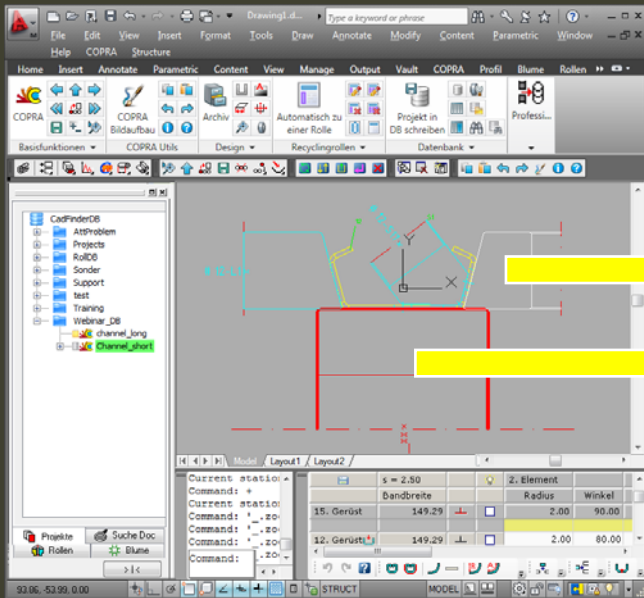
COPRA® RLM Database



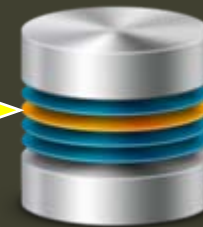
- Contours of Scanned Rolls
- Tracking of Rolls
- ...

# How to Find and Use Existing Rolls

- Prerequisites:
  - Rolls have to be stored to the RLM database
  - Rolls are on stock



COPRA® RLM Database



# How to Find and Use Existing Rolls

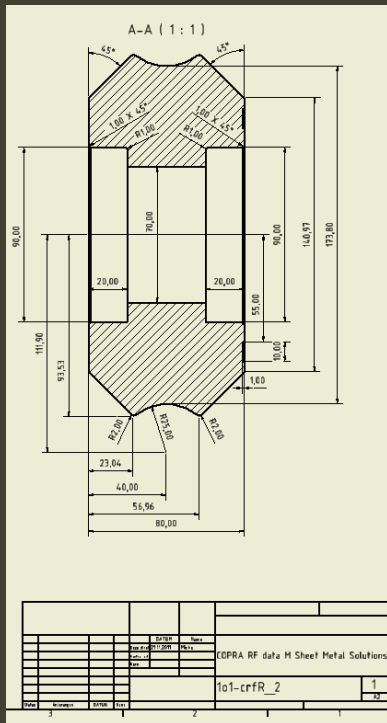
- Combirollsets

Rollnumber	width	max...	Combirollset	Stock...
<b>▼ Kombiset 1     4</b>				
Kombiset 1_2	55.00	130.58	Kombiset 1	0
Project   Pass   Axis				
chan_short   5   Right Axis				
Kombiset 1_1	45.00	114.13	Kombiset 1	0
Kombiset 1_4	41.62	101.11	Kombiset 1	0
Kombiset...	100....	140.00	Kombiset 1	0

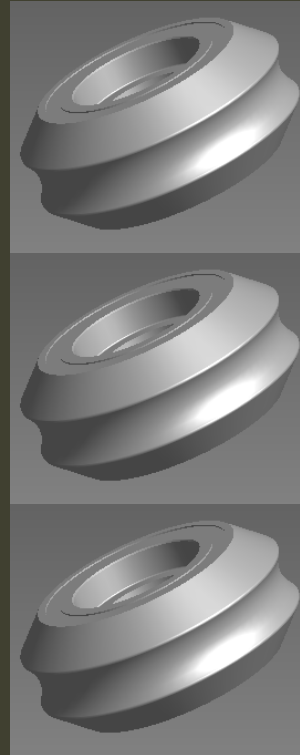
- To group Rolls, e. g. by Bore, Machine, Storage etc.
- To group Standard Rolls
- To limit the search results
- Not mandatory to use the roll search!

# How to Find and Use Existing Rolls

- The concept of „Mother Rolls“ and „Stock Rolls“



Mother Roll

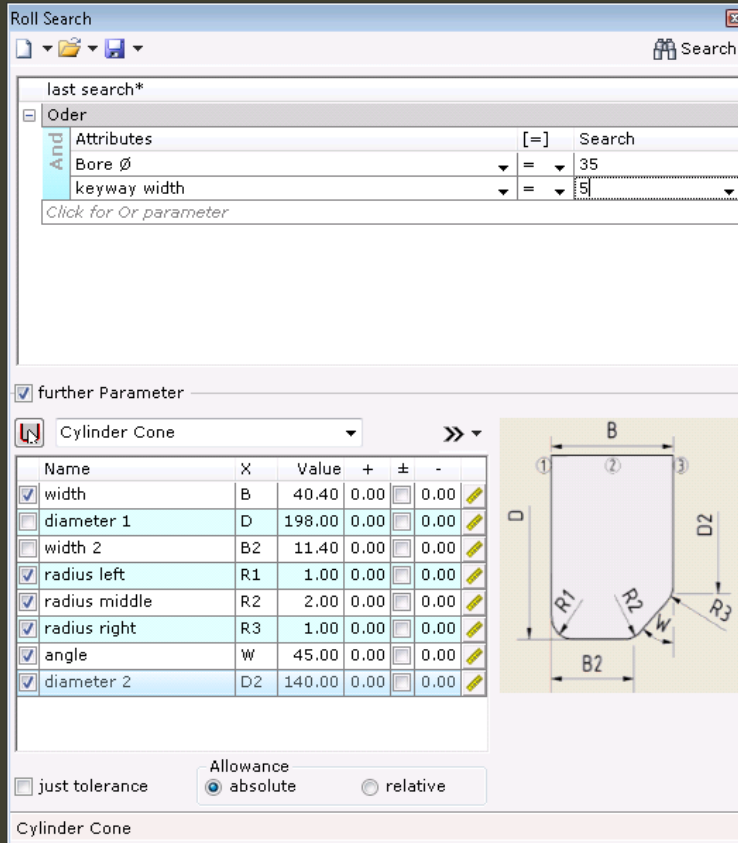


Stock Rolls

- A Mother Roll corresponds to a Roll Design
- A Stock Roll corresponds to a physical existing Roll
- One Mother Roll can incorporate any number of Stock Rolls
- The stock count for a Mother Roll is calculated by the number of its Stock Rolls
- A Unique Identifier can be assigned to Stock Rolls

# How to Find and Use Existing Rolls

- Finding rolls of Standard Geometries



- Search for rolls by simply defining a Set of Parameters
- Clear User Interface for defining the Parameters
- Selection and Deselection of relevant or irrelevant parameters

# How to Find and Use Existing Rolls

- Finding Rolls of any Contour

Roll Search

last search\*

Oder

Attributes	[=]	Search
Bore Ø	=	35
keyway width	=	5

Click for Or parameter

further Parameter

User defined

Name	X	Value
<input checked="" type="checkbox"/> + Allowance	T1	0.10
<input checked="" type="checkbox"/> - Allowance	T2	0.10

just tolerance

Allowance  
 absolute  relative

No roll selected

- Selection of a Roll in COPRA® to define the Contour to search for
- Defining an Allowance to use for the entire Contour
- Defining additional Criteria like Bore Diameter, Keyway Measures, etc.

# How to Find and Use Existing Rolls

- Finding Rolls by relevant Contour Sections

Roll Search

last search\*

Order

Attributes	[=]	Search
Bore Ø	=	35
keyway width	=	5

Click for Or parameter

further Parameter

RKZ roll search

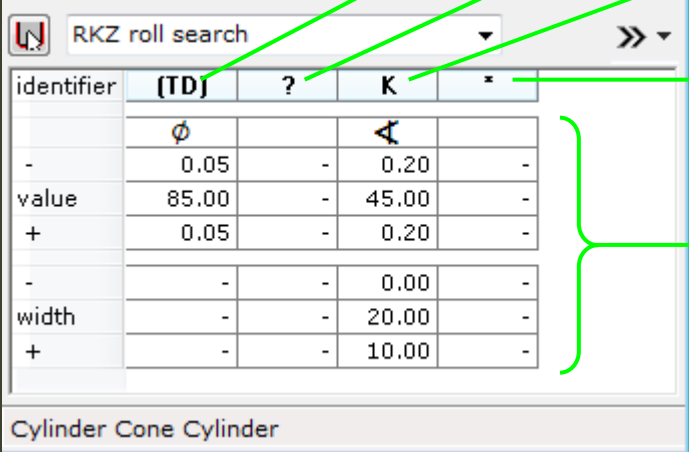
identifier	(TD)	?	K	*
	∅		∠	
-	0.05	-	0.20	-
value	85.00	-	45.00	-
+	0.05	-	0.20	-
-	-	-	0.00	-
width	-	-	20.00	-
+	-	-	10.00	-

Cylinder Cone Cylinder

- Defining Contour Entities (such as Cone, Radius, Cylinder)
- Defining additional Parameters (e. g. Radii, Widths, Angles)
- Defining Allowances for each Parameter
- Again, Defining additional Criteria like Bore Diameter, Keyway Measures, etc.

# How to Find and Use Existing Rolls

- Finding Rolls by relevant Contour Sections



RKZ roll search

identifier	[TD]	?	K	*
	∅		∠	
-	0.05	-	0.20	-
value	85.00	-	45.00	-
+	0.05	-	0.20	-
-	-	-	0.00	-
width	-	-	20.00	-
+	-	-	10.00	-

Cylinder Cone Cylinder

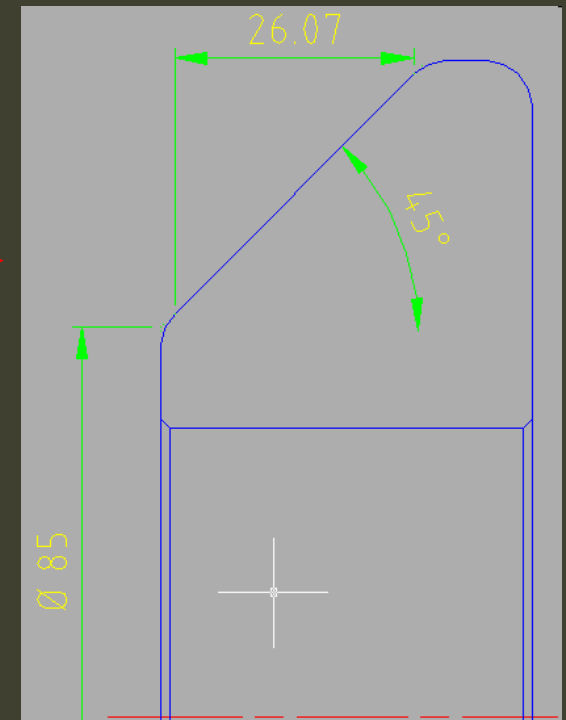
Connecting diameter

Wildcard (1 Element)

Element Type (here: Cone)

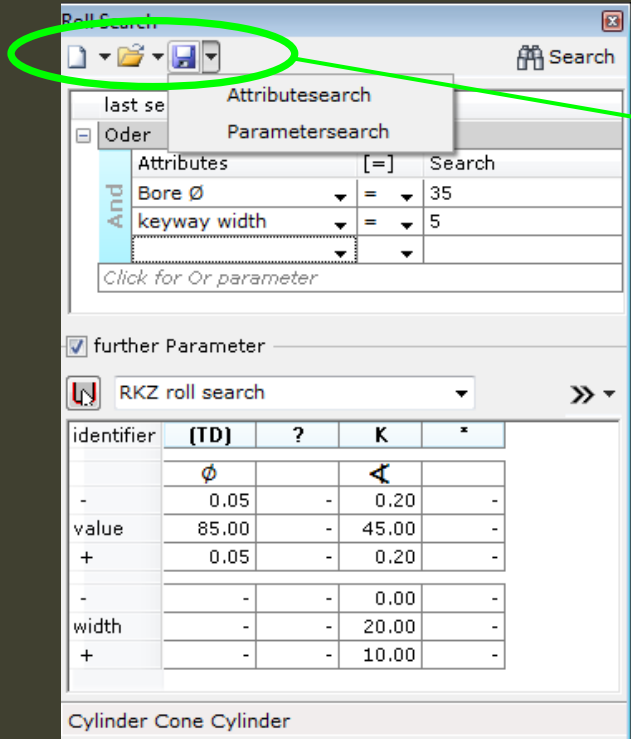
Wildcard (1 or more Elements)

Parameters



# How to Find and Use Existing Rolls

- Save defined Search Parameters to a File



- Easily save or load Sets of Parameters to/from a file
- Save/Load Attributes or Parameters separately or the complete Set

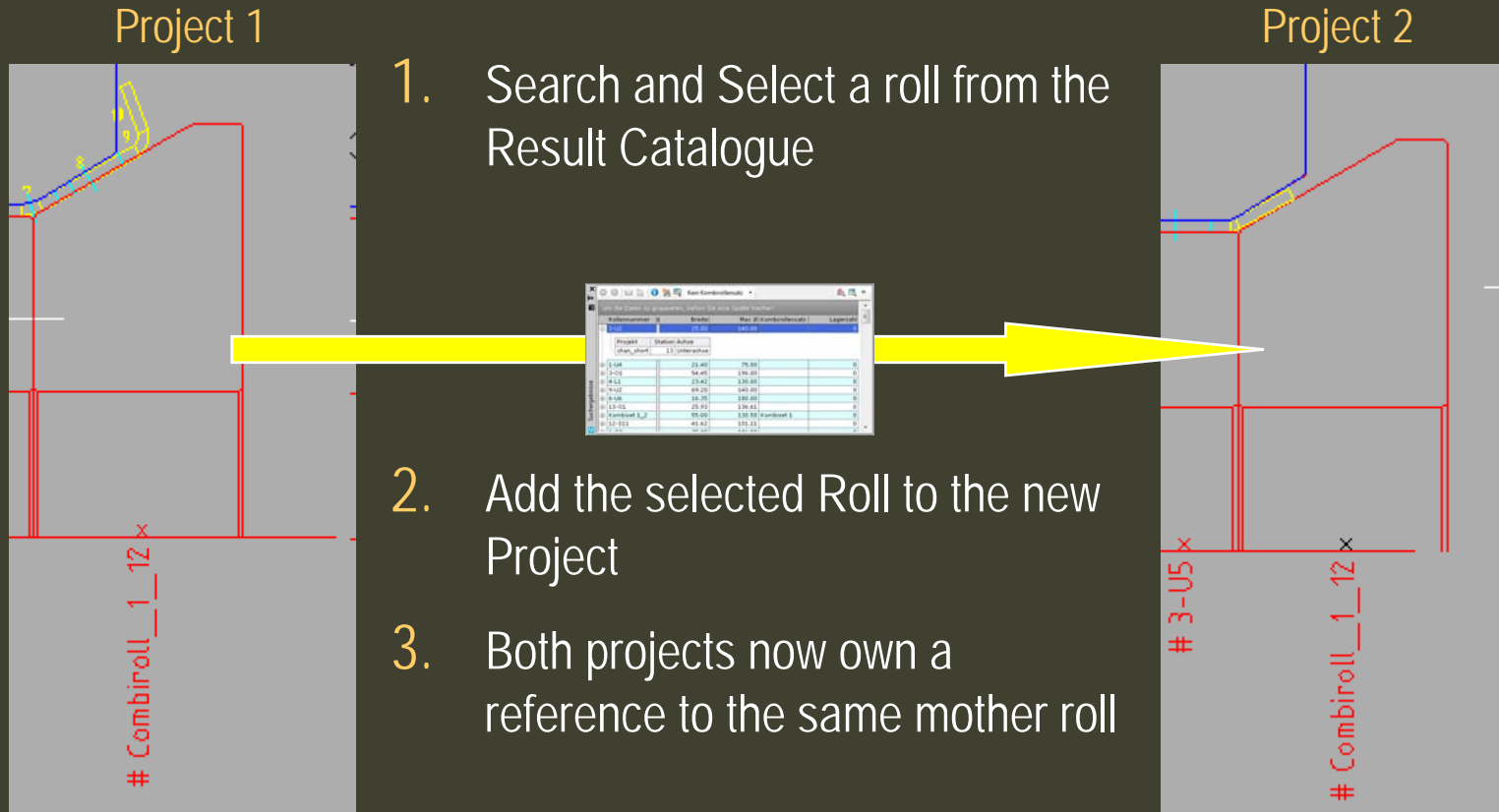
# How to Find and Use Existing Rolls

- Results from a Roll Search
- Search provides a Catalogue of Mother Rolls fitting the Search Criteria
- Preview of the Roll in AutoCAD or Quick Preview in a separate Window
- Filter for Combi Rollsets
- Catalogue highly customizable (visible Columns, groupable by Columns etc.)
- Checking the Stock Count and the Roll Usage by Projects

Rollnumber	width	max diameter	Combirollset	Stock count
3-U2	25.00	140.00		0
Project   Pass   Axis				
chan_short   13   Bottom Axis				
1-U4	21.40	75.00		0
3-O1	54.45	196.00		0
9-U2	69.20	140.00		0
6-U6	16.35	180.00		0
13-O1	25.93	136.61		0
Kombiset 1_2	55.00	130.58	Kombiset 1	0
12-S11	41.62	101.11		0
6-O3	25.00	196.00		0
2-O2	22.22	122.22		0

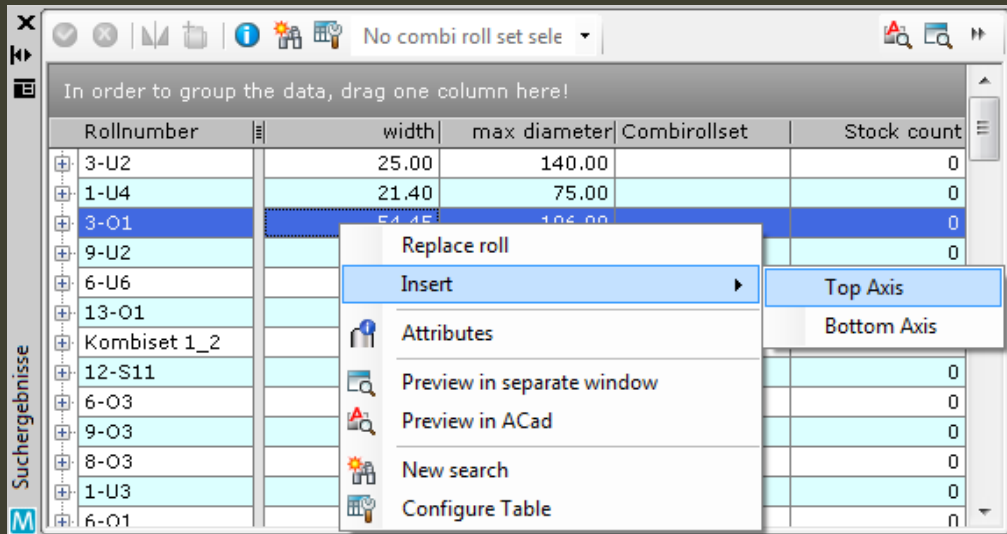
# How to Find and Use Existing Rolls

## ■ Interproject Search and Usage of Rolls



# How to Find and Use Existing Rolls

- Using Rolls from Result Catalogues



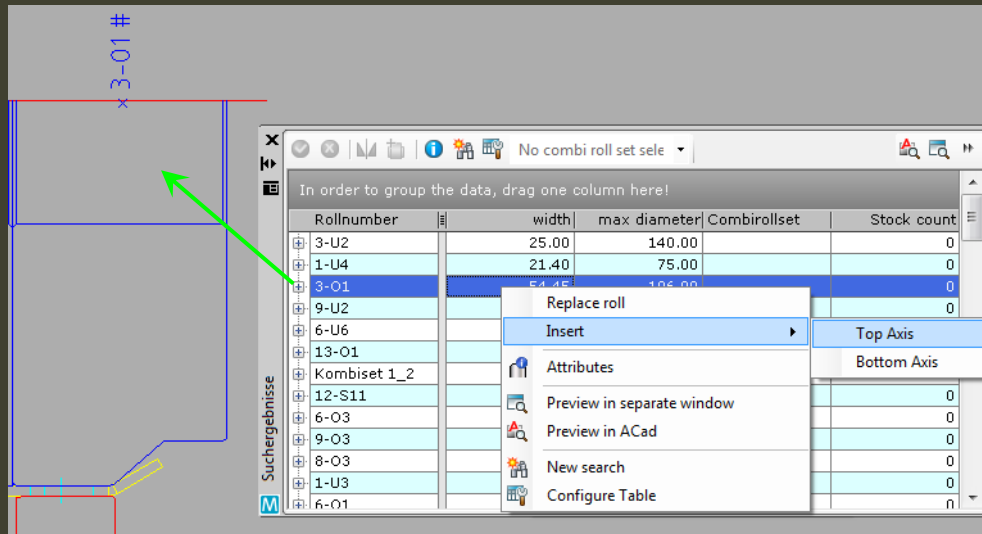
The screenshot shows a software window titled "No combi roll set sele" with a table of roll data. The table has columns for Rollnumber, width, max diameter, Combirollset, and Stock count. Row 3-01 is selected, and a context menu is open over it. The menu options are: Replace roll, Insert (with a submenu for Top Axis and Bottom Axis), Attributes, Preview in separate window, Preview in ACad, New search, and Configure Table. The left sidebar shows a tree view with "Suchergebnisse" and a list of roll numbers.

Rollnumber	width	max diameter	Combirollset	Stock count
3-U2	25.00	140.00		0
1-U4	21.40	75.00		0
3-01	54.45	106.00		0
9-U2				0
6-U6				0
13-01				0
Kombiset 1_2				0
12-S11				0
6-03				0
9-03				0
8-03				0
1-U3				0
6-01				0

- Insertion of the selected Roll at a defined Position on one of the available Shafts
- Replacement of a formerly selected COPRA<sup>®</sup>-Roll by the selected Roll from the Catalogue

# How to Find and Use Existing Rolls

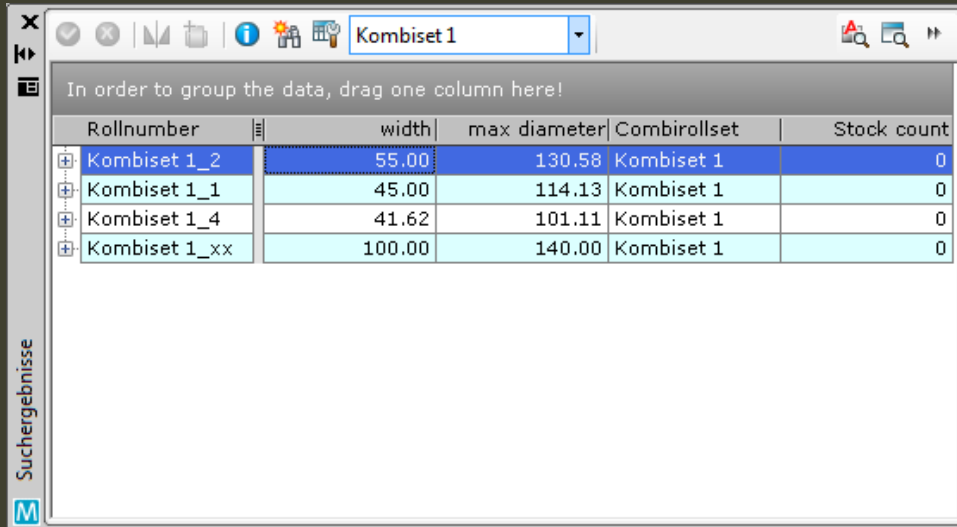
- Using Rolls from Result Catalogues



- Insertion of selected Roll
- Adjust Position of the Inserted Roll (Mirror / Move)
- Adjusting of the Roll also possible directly in AutoCAD
- Save the positioned Roll to COPRA®

# How to Find and Use Existing Rolls

- Combi Rollset Catalogue



In order to group the data, drag one column here!

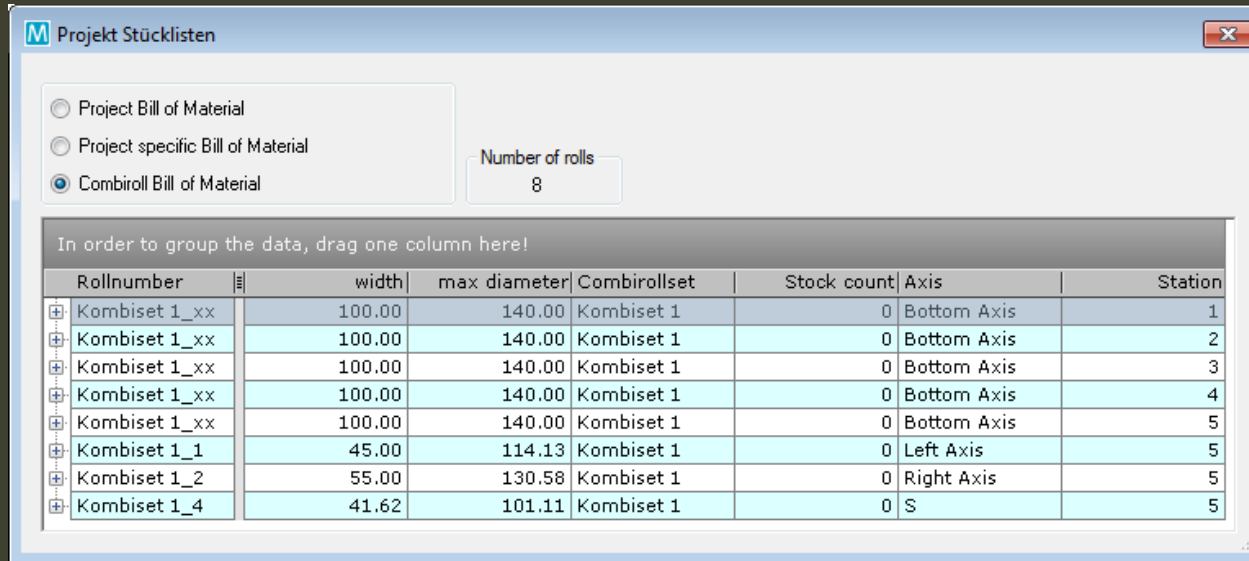
Rollnumber	width	max diameter	Combirollset	Stock count
Kombiset 1_2	55.00	130.58	Kombiset 1	0
Kombiset 1_1	45.00	114.13	Kombiset 1	0
Kombiset 1_4	41.62	101.11	Kombiset 1	0
Kombiset 1_xx	100.00	140.00	Kombiset 1	0

Suchergebnisse

- Shows all of the rolls associated with one particular Combi Rollset
- Provides Quick selection of Standard Rolls

# Bill of Material and Ordering

- Project Bill of Material



The screenshot shows a software window titled 'Projekt Stücklisten'. It has three radio buttons: 'Project Bill of Material', 'Project specific Bill of Material', and 'Combiroll Bill of Material'. The 'Combiroll Bill of Material' option is selected. To the right of these buttons is a text input field labeled 'Number of rolls' containing the value '8'. Below this is a table with the following data:

Rollnumber	width	max diameter	Combirollset	Stock count	Axis	Station
Kombiset 1_xx	100.00	140.00	Kombiset 1	0	Bottom Axis	1
Kombiset 1_xx	100.00	140.00	Kombiset 1	0	Bottom Axis	2
Kombiset 1_xx	100.00	140.00	Kombiset 1	0	Bottom Axis	3
Kombiset 1_xx	100.00	140.00	Kombiset 1	0	Bottom Axis	4
Kombiset 1_xx	100.00	140.00	Kombiset 1	0	Bottom Axis	5
Kombiset 1_1	45.00	114.13	Kombiset 1	0	Left Axis	5
Kombiset 1_2	55.00	130.58	Kombiset 1	0	Right Axis	5
Kombiset 1_4	41.62	101.11	Kombiset 1	0	S	5

- Bill of Material of all Rolls used in the current Project
- Bill of Material for Combi Rolls used in the current Project
- Bill of Material for Rolls specific for the current Project

# Bill of Material and Ordering

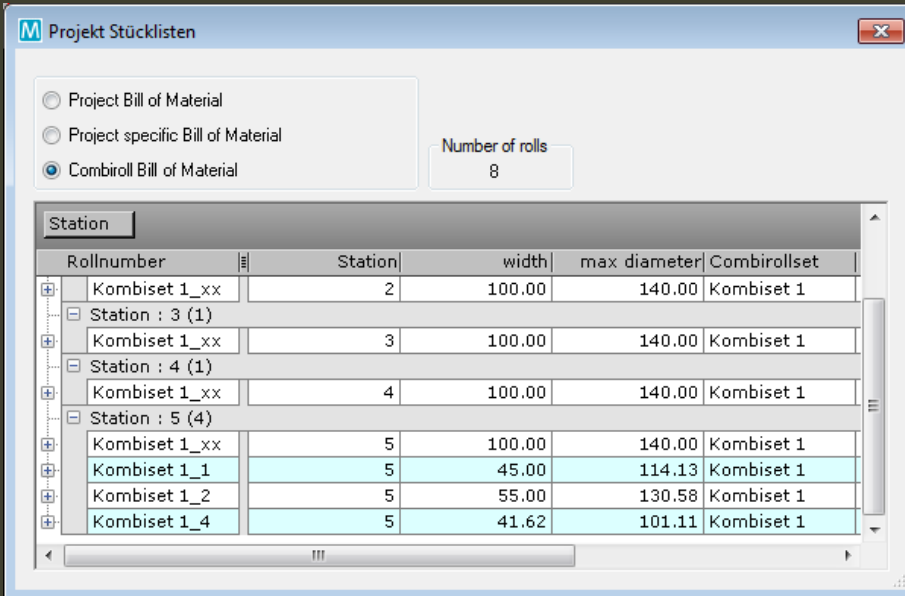
- Order Bill of Material

Rollnumber	Order count	Stock count	Bore ø	max diameter	width	Combirollset
15-O1	1	0	63.00	135.00	29.50	
15-O2	1	0	63.00	196.00	41.00	
15-O3	1	0	63.00	135.00	29.50	
Kombiset 1_xx	5	0	63.00	140.00	100.00	Kombiset 1
15-L1	1	0	35.00	100.00	45.00	
15-R1	1	0	35.00	100.00	45.00	
14-O1	1	0	63.00	135.89	29.02	
14-O2	1	0	63.00	196.00	41.95	
14-O3	1	0	63.00	135.89	29.02	
14-L1	1	0	0.00	100.00	45.00	
14-R1	1	0	35.00	100.00	45.00	
13-O1	1	0	63.00	136.61	25.93	

- List of Rolls to order for the current Project
- Calculation of the Number of Items to order with regard to the Count of Rolls on Stock
- Create the Order Bill specifying the Orderer, the Supplier and the planned Delivery Date

# Bill of Material and Ordering

- Customizing the Lists



Projekt Stücklisten

Project Bill of Material  
 Project specific Bill of Material  
 Combiroll Bill of Material

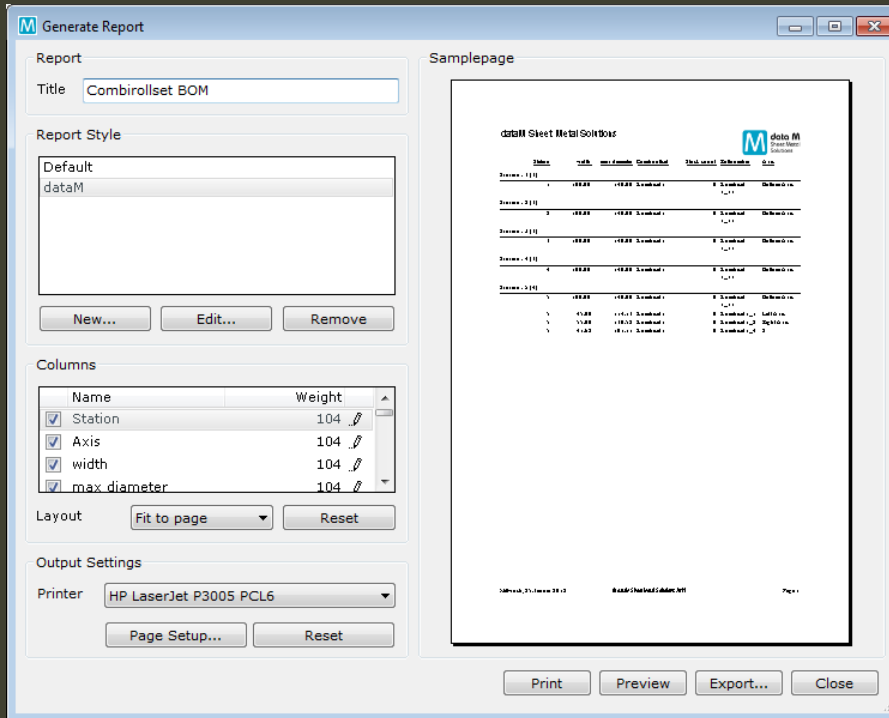
Number of rolls: 8

Rollnumber	Station	width	max diameter	Combirollset
Kombiset 1_xx	2	100.00	140.00	Kombiset 1
Station : 3 (1)				
Kombiset 1_xx	3	100.00	140.00	Kombiset 1
Station : 4 (1)				
Kombiset 1_xx	4	100.00	140.00	Kombiset 1
Station : 5 (4)				
Kombiset 1_xx	5	100.00	140.00	Kombiset 1
Kombiset 1_1	5	45.00	114.13	Kombiset 1
Kombiset 1_2	5	55.00	130.58	Kombiset 1
Kombiset 1_4	5	41.62	101.11	Kombiset 1

- Groupable by any Column (e. g. Station)
- Sortable by any Column, even by more than one Column at the same time
- Activation / Deactivation of relevant / irrelevant Columns

# Bill of Material and Ordering

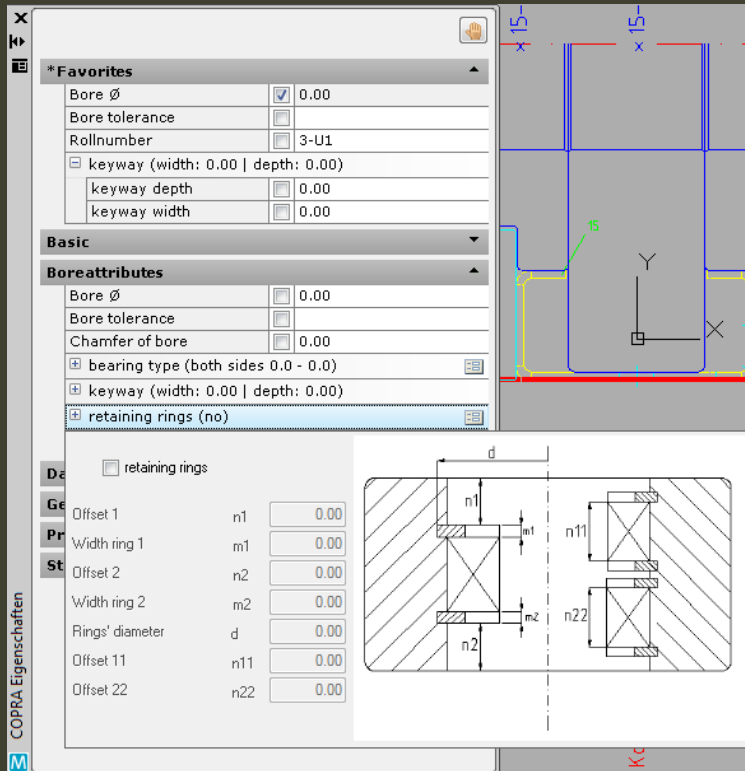
- Customizable Printing



- Easy Creation of Company specific Bill Templates including Company Logos etc.
- Selection of Columns to Print
- Document Export (e. g. Export to PDF-Document)
- Print Preview

# Additional Features

- Improved Roll Attributes



- New Interface for Defining and Editing Roll Attributes
- Customizable „Favorites“-List for commonly used Attributes
- New COPRA®-Panel: Project can be processed in AutoCAD while leaving the Attributes Interface open
- Defining single Attributes to be set to „Default“

# Additional Features

- Optimizing Rolls with identical contours inside the project

Rollennummer	Station	Stationsname	Achse	Position
<b>Match   2 Rollen   Breite 29.500</b>				
15-01	Station 1		Oberachse	Position...
15-03	Station 1		Oberachse	Position 50.000
<b>Match   5 Rollen   Breite 100.000</b>				
<b>Mutterrolle   Rollennummer    Kombiset 1_3</b>				
Kombiset 1_3	Station 1		Unterachse	Position 50.000
Kombiset 1_3	Station 2		Unterachse	Position 50.000
Kombiset 1_3	Station 3		Unterachse	Position 50.000
Kombiset 1_3	Station 4		Unterachse	Position 50.000
Kombiset 1_3	Station 5		Unterachse	Position 50.000
<b>Match   2 Rollen   Breite 45.000</b>				
15-L1	Station 1		Linke Achse	Position 6.250
15-R1	Station 1		Rechte Achse	Position 3.750
<b>Match   2 Rollen   Breite 29.024</b>				
14-01	Station 2		Oberachse	Position...
14-03	Station 2		Oberachse	Position 50.000

- List of Rolls grouped by identical contour
- Small preview of the Roll Contour in the Header of each group
- Identical Rolls can be concentrated to reference the same Mother Roll by simple Drag&Drop Operations
- Only one entry in the BOM for concentrated rolls with the number to order

# Future Prospects

- Inventory Management
- Production Planning
  - Find Collisions when using Rolls in multiple Projects automatically („Is it possible to produce several Projects at the same time using the Rolls currently on stock?“)
- Identification of single Stock Rolls using a Bar Code Scanner or a similar device
- Stocktaking Functions (e. g. „What was the cost of this particular Stock Roll that broke when producing the XYZ-Profile in November and who was the Supplier?“)

# Discussion and Questions



# Webinars 2012

## Our next webinars

26 January 2012

Category: Webinar German



### WE7: COPRA® RF 2011 Roll Data Base

Organizer: data M Sheet Metal Solutions GmbH

Time suitable for Middle East / Asia / Australia:

10:00 AM

(UTC+01 Amsterdam, Berlin, Rome, Vienna)



Time suitable for North / South America:

5:00 PM

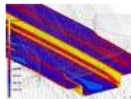
(UTC+01 Amsterdam, Berlin, Rome, Vienna)



[Click here](#) for additional information on this webinar!

23 February 2012

Category: Webinar German



### WE8: COPRA® FEA RF 2011: Design Optimisation

Organizer: data M Sheet Metal Solutions GmbH

Time suitable for Middle East / Asia / Australia:

10:00 AM

(UTC+01 Amsterdam, Berlin, Rome, Vienna)



Time suitable for North / South America:


5:00 PM

(UTC+01 Amsterdam, Berlin, Rome, Vienna)




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## Archive of Webinars



Rollforming the Future®


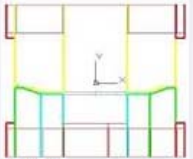
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- FAQs

### WE5 & WE6- COPRA® RF 2011 - Roll Construction 1 & 2

Name	Content	Video files	Presentation files
<p><b>WE5:</b> Roll Construction 1: Free Design and Classic</p>  <p>24.11.11</p>	<ul style="list-style-type: none"> <li>Designing rolls using COPRA® classic construction (using COPRA® and AutoCAD)</li> <li>Modifying classically designed rolls using COPRA® roll design modification tools</li> <li>Designing rolls using COPRA® free design functions (using AutoCAD)</li> <li>Modifying free designed rolls using COPRA® roll design modification tools and AutoCAD</li> </ul>	<p><a href="#">WE5-RollConstruction1.mp4</a> (67 MB)</p> <p><a href="#">WE5-RollConstruction1.wmv</a> (63 MB)</p>	<p><a href="#">WE5-RollConstruction1.pdf</a> (1,3 MB)</p>
<p><b>WE6:</b> Roll Construction 2: Cloned Rolls</p>  <p>15.12.11</p>	<ul style="list-style-type: none"> <li>Clone Rolls - Terms and Definitions</li> <li>Automatic and manual clone functions</li> <li>Material lists / roll drawings</li> <li>Benefits of cloning rolls</li> <li>View of the roll database</li> </ul>	<p><a href="#">WE6-RollConstruction2.mp4</a> (33 MB)</p> <p><a href="#">WE6-RollConstruction2.wmv</a> (34 MB)</p>	<p><a href="#">WE6-RollConstruction2.pdf</a> (428 KB)</p>

# www.datam.de Videos



Rollforming the Future®

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- FAQs

**NEW** **COPRA® RF 2011 Workflow Videos**

→ [Click here](#) to get a free copy of the complete COPRA® Roll Forming Videos in full length. We are looking forward to receiving your request!

**See a Preview here:**



**Content:**

### COPRA® Roll Forming Software Part 1

CADFinder and Creating a Profile

- Create Project
- Import Profile from AutoCAD
- Modify Profile in Spreadsheet
- Redo / Undo Functions

# Online-Trainings



- Save Time
- Save Expenses

Thank you very much for your  
attention!

Goodbye...

Webinar WE7:  
**COPRA® RF 2011 – Roll  
Lifecycle Management**



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