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## Adjustable Pick Conveyance Pause Control

### Why have picker directed conveyance "pause" control?

The intent for matching the correct advancing speed of a carton (see variable speed setting control for conveyance within pick area) to a picker is to closely meet the average carton pick time needed for ALL zones to fulfillment current wave flow volume BIN pick requirements. Variable speed motor control settings regulate cartons advancing on pick area conveyance through the Control Panel. At times an abnormal pick will enter a zone. The operator would then push the "pause" button causing the conveyance to stop for a prescribed user (supervisor) defined period before automatically restarting. This pause of conveyance allows the picker to complete the requirements for the odd carton. Should the picker be completed before the automatic restart, the button can be pushed to activate the conveyance to restart.

The goal is to increase the speed of the conveyance to the maximum point to cause minimal "justifiable" pauses of conveyance. The theory is that cartons that travel at highest fulfillment by zone capacity speed unencumbered by extraordinary pauses, will yield highest per hour carton throughput for system. The supervisory "juggle" of conveyance speed and acceptable pauses provide authoritative control inducements to regulate carton presentment at zone/BIN for picks.

### Adjustments

The BOSS Pick System conveyance has an integrated picker directed conveyance "pause" button located within each station. When there are too many pauses spread across many zones, the speed of the conveyance is perceived to be in excess of pick capability and must be tempered. If the line is not being paused, the speed should be assumed to be too slow. If a single zone has an abnormal frequency of pauses, the title(s) velocity or other indicators could be the root cause as well as a potentially inferior picker and therefore require supervisory scrutiny. The duration of the pause should be just long enough for pick completions when in excess of average.

### Control Panel HMI (Human Machine Interface)

Located on the front face of the Control panel door is a HMI with button control for display and adjustments of the pause 30 stations. The HMI performs other Control Panel interface along with the Station Pause Control configuration setup using the buttons located at the HMI. Follow the on-screen instruction to set the pause duration to desired length of time before restart. Monitor (periodic review multiple time during daily pick sessions) the display function for Pause Station Control at production to see the last five Pause occurrences. These will be displayed most recent at top to last of five at bottom. The date, time, and station are listed. For more information, review the control panel HMI detailed instructions left with The Source by Gary Jabben – PE (J & M Consulting – look inside control panel for manuals etc.).

### Data Capture / Report / Analysis Potential

The current control panel program setup could integrate with DPS BOSS VIP Pick System to capture, store, report and analyze the 30 station pause control mechanisms with station number, date and time. Request estimate from Data Processing Services, Inc.