



Anheuser - Busch
TRAINING & DEVELOPMENT GROUP

Put Processing System

Palletizer Operator Training

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Overview

Once beer is packaged, it must be loaded directly on trucks or railcars for delivery to wholesalers, or loaded temporarily in storage warehouse bins until it can be placed on trucks or railcars for delivery.

The warehouse consists of loading docks and a large floor space divided into sections. Each section has a number of bins where product is stored. The sections and bins are numbered and cataloged in a computer system.

The Put Process

The Put process is the portion of Beer Product Tracing (BPT) in which beer is put away into the bins, directly loaded onto trailers or rail cars, or direct staged to rail spots. Each palletizer operator is assigned to a palletizer as primary user, having the responsibility of entering for the beer the correct

- Product
- Container
- Stock (PCS) code
- Date
- Production unit

Once this is done, the system assigns a bin to receive the beer. The palletizer operator then puts the beer away to the selected bin or overrides to another bin of their choice. The operator scans the barcode on the pallets, which assigns all pertinent information to the barcode so that each pallet can be tracked individually.

Put Process From Palletizer

As product comes off the palletizer, it must be loaded directly to waiting trucks or railcars or put away in bins. The Put process is the process of taking the product from the palletizer and placing it in the appropriate bin.

Every pallet and bin is identified by a barcode that can be read by warehouse personnel using the scanner mounted to the fork truck.


Put Processing Fork Truck Screen Review

A radio frequency (RF) terminal is mounted on each fork truck. The RF terminal communicates directly with the Beer Product Tracing (BPT) system. Operators use the RF terminal to perform all required system interactions.

To begin the *Put* program, on the RF terminal, enter the appropriate menu option number and press <Enter>. The Put Processing screen displays:



Figure 1: Put Processing screen

 Note: The display on the RF terminal refers to the <Enter> key as <CR>. Typing information using the keyboard or scanning a tag produces the same results. However, scanning the tags is always faster and more accurate.

Put Process Commands

The valid commands to use on the Put Processing screen are:

Command	Description
A (Autoselect)	Select a bin. If performing a direct load, autoselect replaces the direct load door with an autoselect bin. The Autoselect command will not replace an existing autoselect bin. Its purpose is to autoselect a bin after a direct load. This command is only used when putting away package beer.
B (Bin Inquiry)	View the contents of a bin. Select the option and scan the bin(s) to view the contents. Type E and press <Enter> to exit and return to the <i>Put</i> screen. You can switch between the bin inquiry program and tag inquiry program by scanning the appropriate tag.
BA (Bin Adjustment)	Adjust the contents of a bin. You can add or delete a PCS from a bin, change quantities, dates, or mix flag. To add, type A

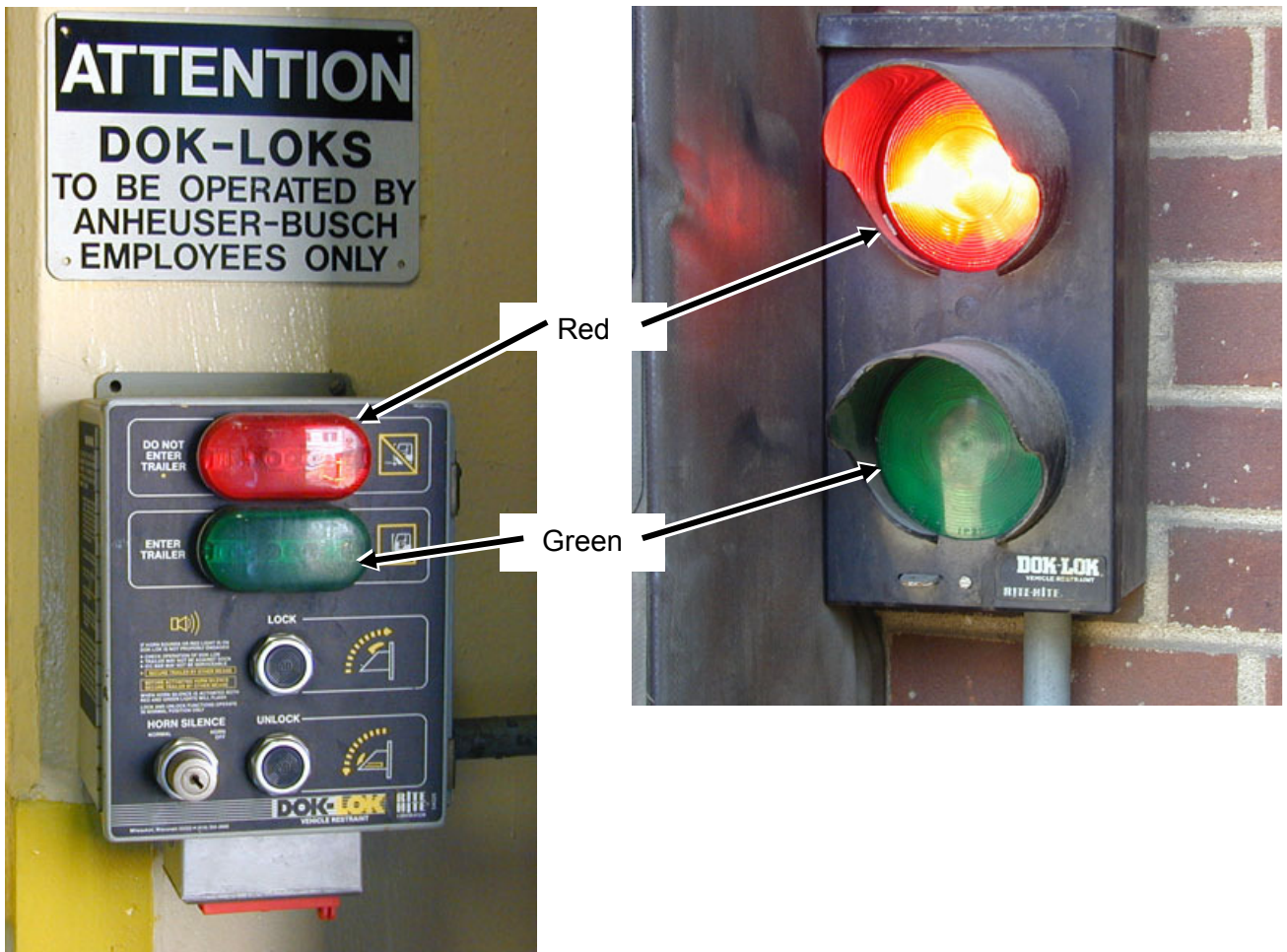


Figure 3: Dok-Lok Control Panel and Driver Light

Dock Leveler


The Dock Leveler is a hydraulically operated ramp that is positioned in the trailer so the fork truck can enter the trailer. The operator must make sure the ramp is in position for loading.

Cleanliness


Cleanliness standards ensure the product is always at peak quality for freshness and package appeal. The consumer expects this level of quality and will repeat the purchase of our products as long as our quality meets or exceeds the customers' expectations.

The structural integrity of trailers and railcars must meet A-BI standards. Sound, roadworthy transportation is the only link to getting product from the brewery to the consumer, so quality standards must be followed to ensure that the product reaches the consumer in a safe and timely fashion.

2. After exiting the *Instructions* screen, the *Put* screen displays.

 Note: The word “Auto” is replaced with “Direct” for a direct load or “Stage” for a staged load. Next to this prompt is the dock door or rail spot where the direct load or stage is to take place. Directly beneath this bin is the total number needed along with the number that is currently there.

3. Continue to take beer to the truck dock or rail spot until the direct load or stage is complete.

 Note: When a direct load is accepted, the autoselect bin is removed, but the override bin is not. You can continue to take beer to the override bin or you can take it to the autoselect bin by entering it as an override bin. Therefore, you can put beer in the bin and perform a direct load at the same time.

Instruction Screen Review

This screen is accessed immediately after accepting a direct load for a truck, or by using the **I** command at the prompt. The *Instructions* screen displays any special instructions for the loader as well as identifies the spotting service (if applicable), the destination, the trailer or rail car number, the load point, the total pallet spots, and the load pattern for truck orders. It also allows you to enter seal numbers for rail orders.

To modify the instructions on the Instructions screen:

1. Type **C** and press **<Enter>**. The cursor moves through the fields that you are allowed to change.
2. Press **<Enter>** to skip a field and go to the next field. Make necessary changes as you move through the fields.
3. Type **F** and press **<Enter>** to return to the *Put* screen once you have finished viewing and/or entering the data.

Verifying the Trailer Number

Before placing any product on a trailer, the operator must verify the order information shown on the fork truck’s RF terminal, including the:

- Order number
- Trailer number
- Trailer size and type
- Dock door number
- Order destination
- Special instructions for the load