



ORION USER MANUAL

July 2025

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1. Introduction

This document is a user manual for a software system designed to operate the robotic veneer sheet processing line. It describes the software's features, interface, and usage procedures.

2. Software Purpose

The software is designed to perform the following functions:

- 2.1. Interface with the production line to eliminate veneer sheet defects
- 2.2. Integrate with a machine vision system
- 2.3. Communicate with a programmable logic controller (PLC)
- 2.4. Detect defects in veneer sheets using neural network models based on machine learning
- 2.5. Display defect recognition results:
 - 2.5.1. Types and quantities of defects
 - 2.5.2. Veneer grades before and after repair
 - 2.5.3. Build repair paths based on the patching machine ejector's position
- 2.6. Configure controller parameters through service settings
- 2.7. Display reference materials for the current software version
- 2.8. Create and edit products
- 2.9. Create and edit recipes
- 2.10. Display the user interface based on role: Administrator, Technologist, Operator

3. Authorization

To log in to the software suite:

3.1. Enter your personal six-digit code using the numeric keypad.

3.2. If a mistake is made, delete the last character by pressing the "<" (delete) key.



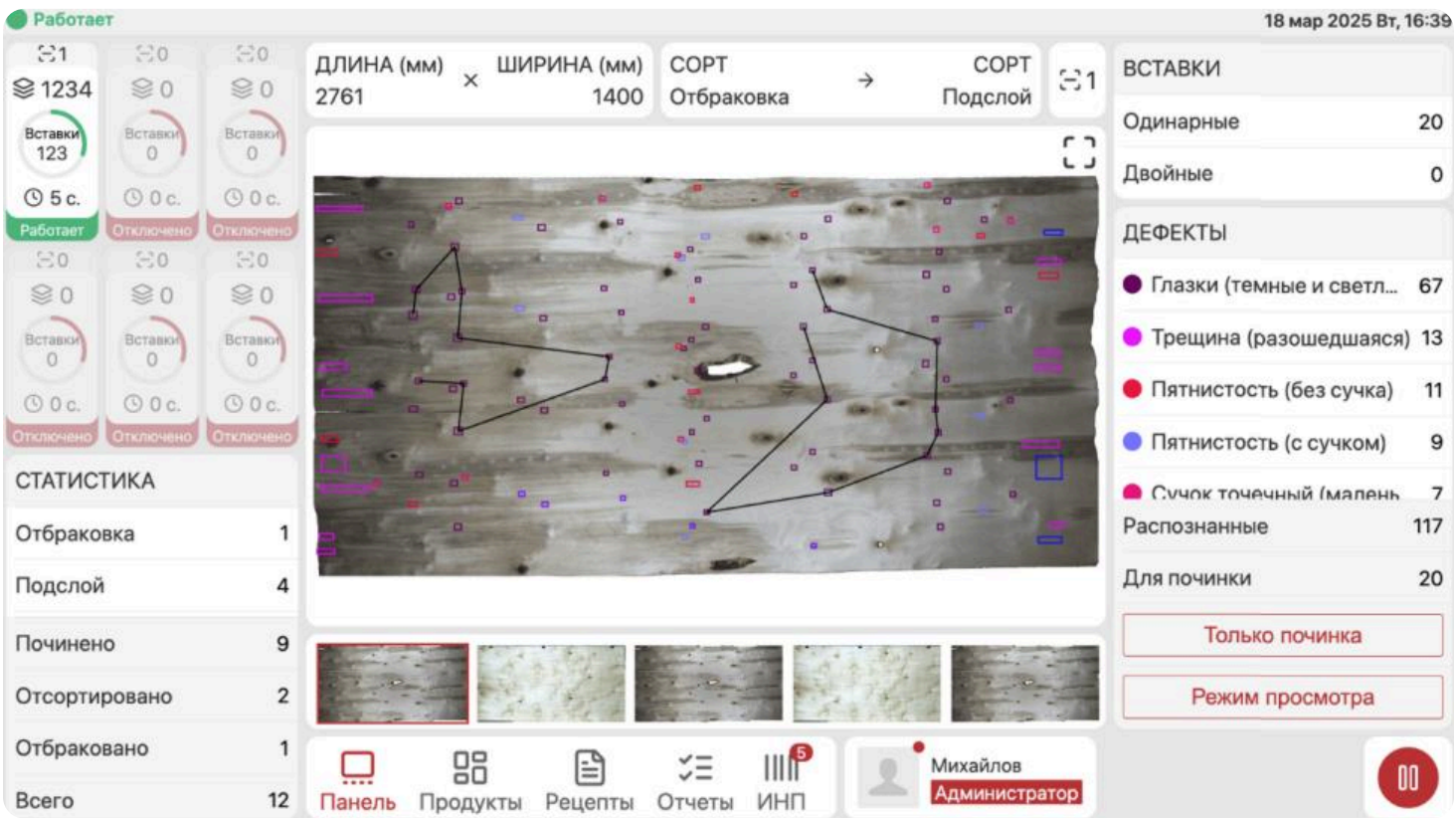
The image shows a login interface for a software suite. At the top, the word "orion" is displayed in blue. Below it, there are six white rectangular input fields for a six-digit code. Underneath the input fields, the text "Введите ваш код" (Enter your code) is written in a small, dark font. Below the text is a numeric keypad with buttons for digits 1 through 9, 0, and a left arrow key (<).

4. Main Screen

4.1. Main Screen Content

The main screen displays the following information:

- 4.1.1. Processed veneer sheet
- 4.1.2. Length and width of the sheet (in mm)
- 4.1.3. Current and target veneer grades
- 4.1.4. Number of single and double inserts performed by the RTC system
- 4.1.5. Number and types of recognized defects
- 4.1.6. Total number of detected defects and those sent to RTC for repair



4.2. Main Screen Functional Features

4.2.1. Veneer Image Manipulation:

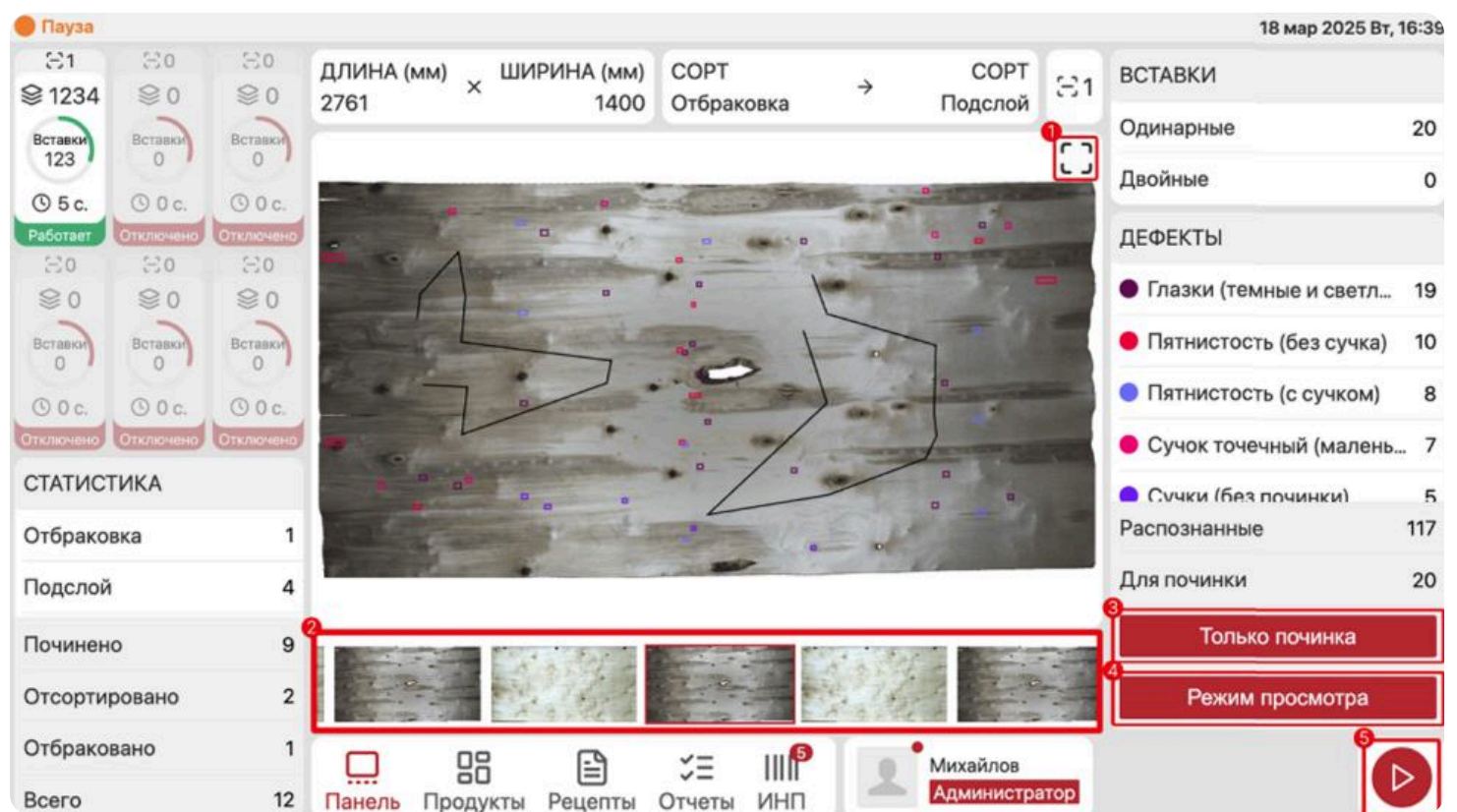
4.2.1.1. Zoom in for detailed viewing or switch to full-screen mode (label “1”). To exit full screen, press the button in the top-right corner.

4.2.1.2. View previously scanned sheets (label “2”). Selecting a sheet activates View Mode.

4.2.2. View Mode: Image display remains static, not updated in real-time (label “4”).

4.2.3. Repair Only Mode: Displays only repairable defects on the list and on the image (label “3”).

4.2.4. Pause / Resume: Controls the processing workflow (label “5”).



4.3. Left Block of the Screen

4.3.1. RTC Cell Information:

4.3.1.1. Cell ID number (label “1”)

4.3.1.2. Current status (Active / Off / Error / Manual) (label “2”)

4.3.1.3. Number of sheets repaired by the cell (label “3”)

4.3.1.4. Average repair time per sheet (label “4”)

4.3.1.5. Number of remaining inserts required to complete the current sheet (label “5”)

4.3.2. General statistics for the current production run:

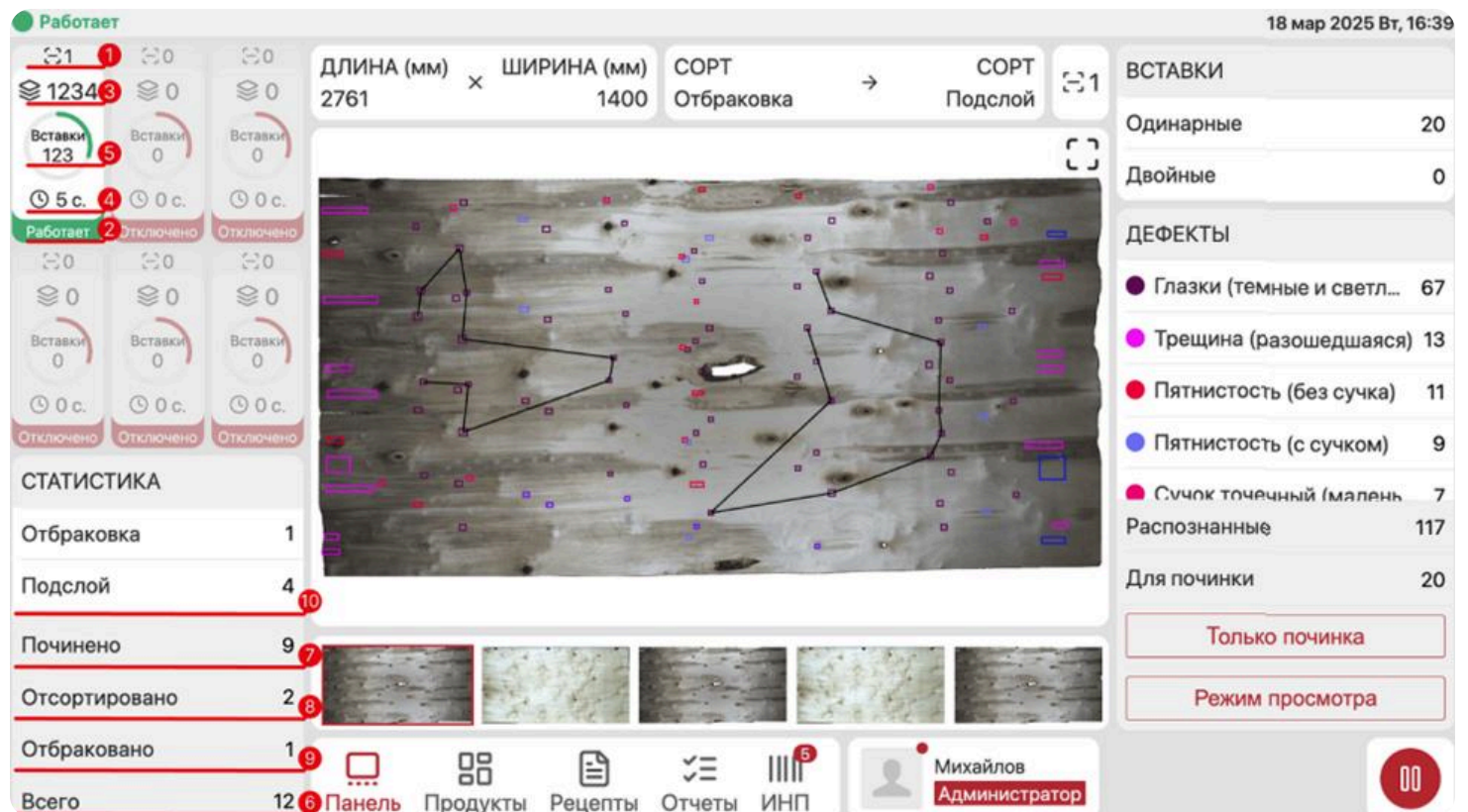
4.3.2.1. Number of processed sheets (label “6”)

4.3.2.2. Number of repaired sheets (label “7”)

4.3.2.3. Number of sorted sheets not requiring repair (label “8”)

4.3.2.4. Number of rejected sheets per recipe criteria (label “9”)

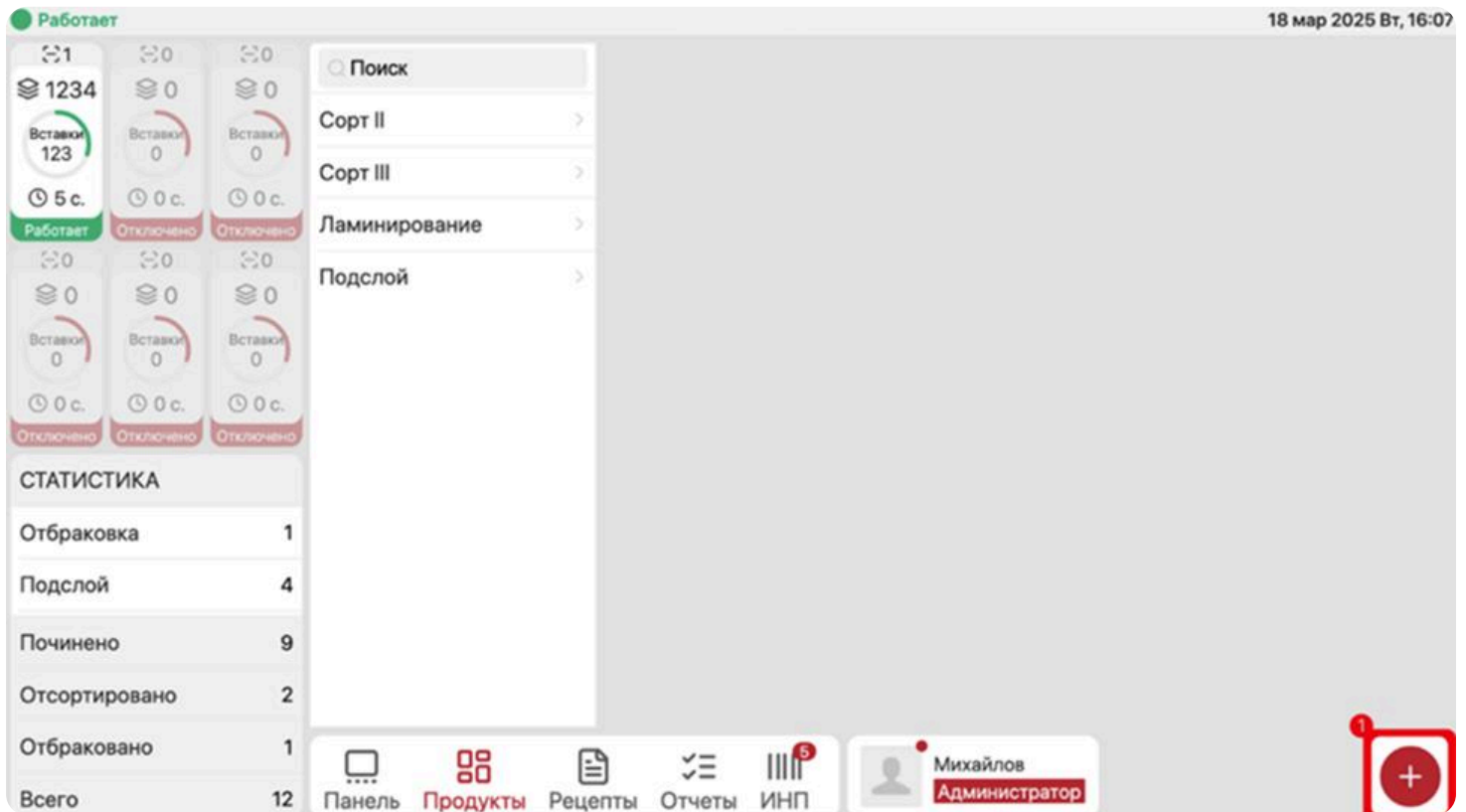
4.3.2.5. Veneer yield statistics by grade (label “10”)



5. Products

5.1. Creating a Product

5.1.1. Press the red “+” button in the bottom right corner of the screen (label “1”).



5.1.2. Fill in the product details:

5.1.2.1. Enter the product name (letters, numbers, and special characters allowed) (label “1”)

5.1.2.2. Specify length in millimeters (label “2”)

5.1.2.3. Specify width in millimeters (label “3”)

5.1.2.4. Proceed to the next step (red arrow button pointing right) (label “4”)

5.1.2.5. To cancel, press the cross icon (label “5”)

The screenshot displays the Synetra application interface. At the top, a status bar shows 'Работает' (Working) and the date '18 мар 2025 Вт, 16:05'. Below this is a navigation bar with tabs: 'Описание' (Description), 'Дефекты' (Defects), 'Параметры' (Parameters), 'Приоритеты' (Priorities), 'Допуски' (Tolerances), and 'Результат' (Result). The 'Описание' tab is active. The main form contains three input fields: 'Название продукта' (Product Name) with a red '1' label, 'Длина (мм)' (Length in mm) with a red '2' label, and 'Ширина (мм)' (Width in mm) with a red '3' label. A red '4' label points to a red arrow button on the right side of the keyboard. A red '5' label points to a red 'X' icon in the top left corner of the form. On the left side of the interface, there is a sidebar with a 'СТАТИСТИКА' (Statistics) section showing counts for 'Отбраковка' (1), 'Подслой' (4), 'Починено' (9), 'Отсортировано' (2), 'Отбраковано' (1), and 'Всего' (12). The bottom of the interface features a virtual keyboard with Cyrillic and Latin characters.

5.1.3. Select defects:

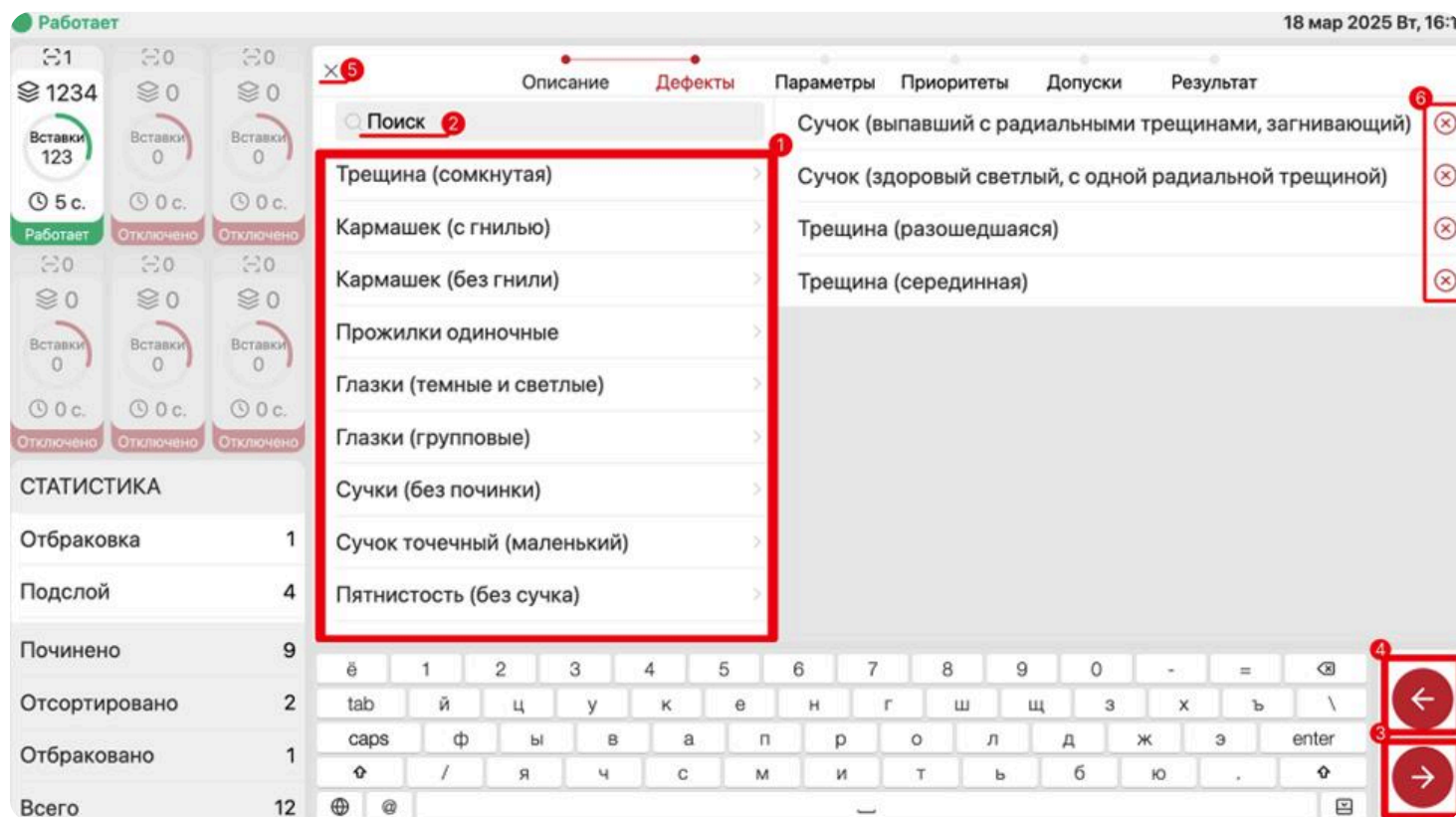
5.1.3.1. Choose defects from the list that should be considered during production and processing (label “1”) (Use the search field if necessary — label “2”)

5.1.3.2. You can remove mistakenly selected defects using delete button (label “7”)

5.1.3.3. Proceed to the next step (red arrow button pointing right — label “3”)

5.1.3.4. Go back to the previous step (red arrow button pointing left — label “4”)

5.1.3.5. To cancel, press the cross icon (label “5”)



5.1.4. Specify defect parameters (for each selected defect in order, the defect name is shown in field “1”):

5.1.4.1. Set allowable quantity for this defect type (label “2”)

5.1.4.2. Specify whether the defect is repairable (toggle switch — label “3”)

5.1.4.3. Define defect size limits (min/max length/width — labels “4–7”)

5.1.4.4. Enable rejection if size limits are exceeded (toggle switches — labels “8–11”)

5.1.4.5. Proceed to the next step (red arrow button pointing right — label “12”)

5.1.4.6. Go back to the previous step (red arrow button pointing left — label “13”)

5.1.4.7. To cancel, press the cross icon (label “14”)

Работает 19 мар 2025 Ср, 11:06

Описание Дефекты **Параметры** Приоритеты Допуски Результат 1 / 2

Сучок (выпавший с радиальными трещинами, загнивающий) 1

Починка Дефекта 3

* Количество дефектов 0 2

Ширина Длина

Минимум Минимум

0 мм. 4 0 мм. 6

Отбраковка Отбраковка

Если меньше мин. знач. 8 Если меньше мин. знач. 10

Максимум Максимум

0 мм. 5 0 мм. 7

Отбраковка Отбраковка

Если больше макс. знач. 9 Если больше макс. знач. 11

СТАТИСТИКА

Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

Панель Продукты Рецепты Отчеты ИНП 5

Михайлов Администратор

13 12

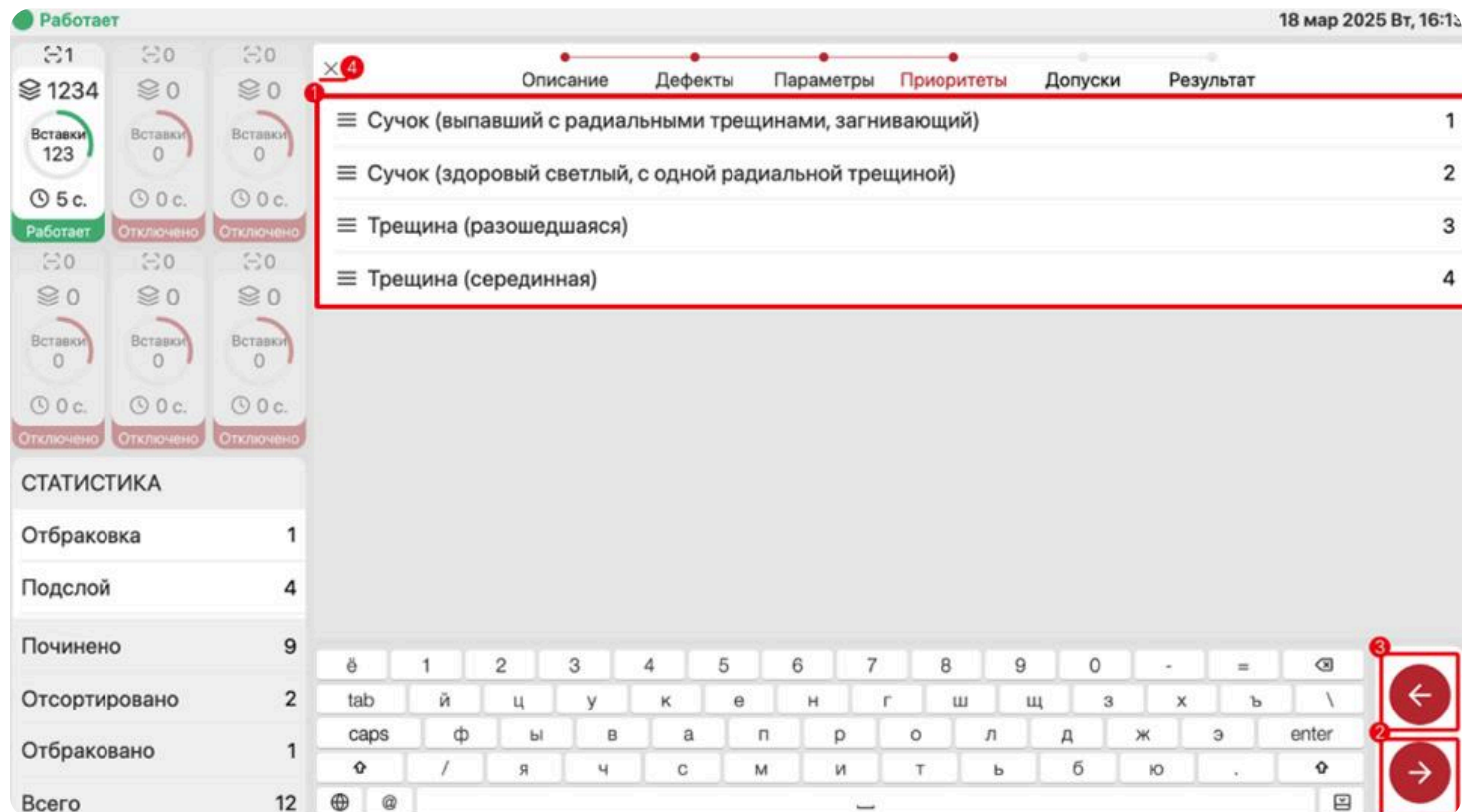
5.1.5. Set repair priorities:

5.1.5.1. Set defect repair priorities by dragging rows (label “1”)

5.1.5.2. Proceed to the next step (red arrow button pointing right — label “2”)

5.1.5.3. Return to the previous step (red arrow button pointing left — label “3”)

5.1.5.4. To cancel, press the cross icon (label “4”)



5.1.6. Set tolerances:

5.1.6.1. Max allowable number of unrepairable defects (label “1”)

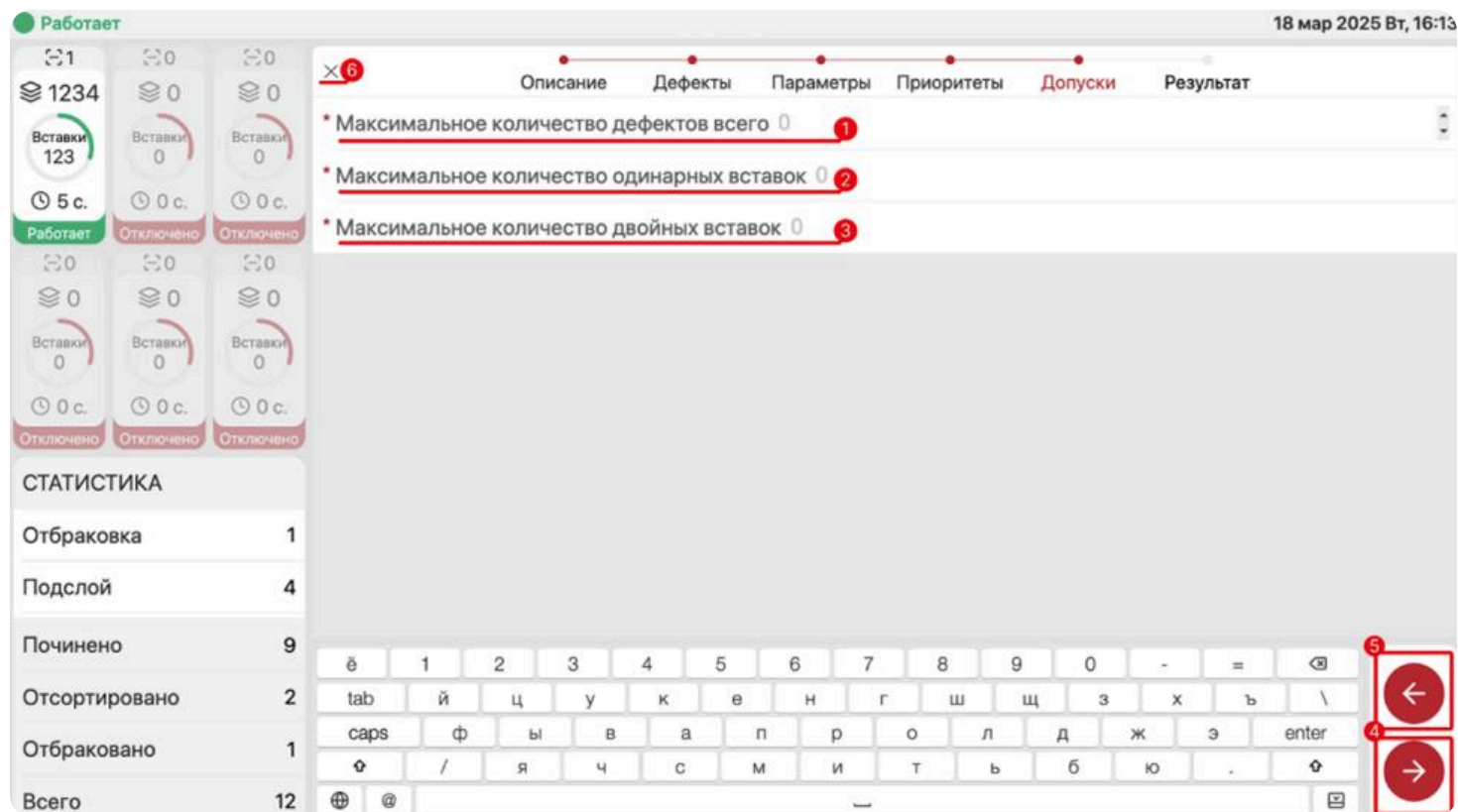
5.1.6.2. Max allowable number of single inserts (label “2”)

5.1.6.3. Max allowable number of double inserts (label “3”)

5.1.6.4. Proceed to the next step (red arrow button pointing right — label “4”)

5.1.6.5. Return to the previous step (red arrow button pointing left — label “5”)

5.1.6.6. To cancel, press the cross icon (label “6”)



5.1.7. Result

5.1.7.1. Verify that all fields are correctly filled

5.1.7.2. Save the new product by clicking the Save button (red diskette icon – label “1”)

5.1.7.3. If corrections are needed, go back (red arrow pointing left – label “2”)

5.1.7.4. To cancel, press the cross icon (label “3”)

Работает 18 мар 2025 Вт, 16:1

1234 Вставки 123 5 с. Работает 0 0 с. Отключено 0 0 с. Отключено 0 0 с. Отключено

СТАТИСТИКА

Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

Описание Дефекты Параметры Приоритеты Допуски Результат

Описание

Название	Сорт
Ширина (мм)	1200
Длина (мм)	2400

Допуски

Максимальное количество дефектов	50
Максимальное количество одинарных вставок	30
Максимальное количество двойных вставок	10

Дефекты

- Сучок (выпавший с радиальными трещинами, загнивающий)

Допустимое количество	10
Починка	✓
Мин. ширина (мм)	10

Панель Продукты Рецепты Отчеты ИНП 5

Михайлов Администратор

2 1

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5.2. Editing a Product

5.2.1. Select a product from the list (label “1”)

5.2.2. Open the menu (“...”) (label “2”)

5.2.3. Click Edit

5.2.4. Continue through the product creation flow with pre-filled data (see 5.1.2)

The screenshot displays the Syntetra software interface. On the left, a sidebar contains a 'СТАТИСТИКА' (Statistics) section with a table showing counts for various stages: Отбраковка (1), Подслой (4), Починено (9), Отсортировано (2), Отбраковано (1), and Всего (12). The main area shows a list of products with columns for 'Поиск' (Search) and 'Сорт' (Sort). A red box labeled '1' highlights the 'Сорт' menu item in the sidebar. Another red box labeled '2' highlights the 'Редактировать' (Edit) button in the top right corner of the product details panel. The product details panel shows fields for 'Описание' (Description), 'Название' (Name), 'Ширина (мм)' (Width (mm)), 'Длина (мм)' (Length (mm)), 'Допуски' (Tolerances), and 'Дефекты' (Defects). The 'Дефекты' section lists 'Сучок (выпавший с радиальными трещинами, загнивающий)' (Knot (fallen with radial cracks, rotting)) and 'Допустимое количество' (Allowable quantity) of 10. The bottom bar shows navigation icons for 'Панель', 'Продукты', 'Рецепты', 'Отчеты', and 'ИНП', along with a user profile for 'Михайлов Администратор' and a red '+' button.

Статус	Вставки	Время	Сорт	Описание	Название	Ширина (мм)	Длина (мм)	Допуски	Дефекты
Работает	123	5 с.	Сорт II	Максимальное количество дефектов		1200	2400	50	Сучок (выпавший с радиальными трещинами, загнивающий)
Отклонено	0	0 с.	Сорт III	Максимальное количество двойных вставок				10	
Отклонено	0	0 с.	Ламинирование	Максимальное количество одинарных вставок				30	
Отклонено	0	0 с.	Подслой	Допустимое количество				10	
Отклонено	0	0 с.	Сорт	Починка				✓	
Отклонено	0	0 с.		Мин. ширина (мм)				10	

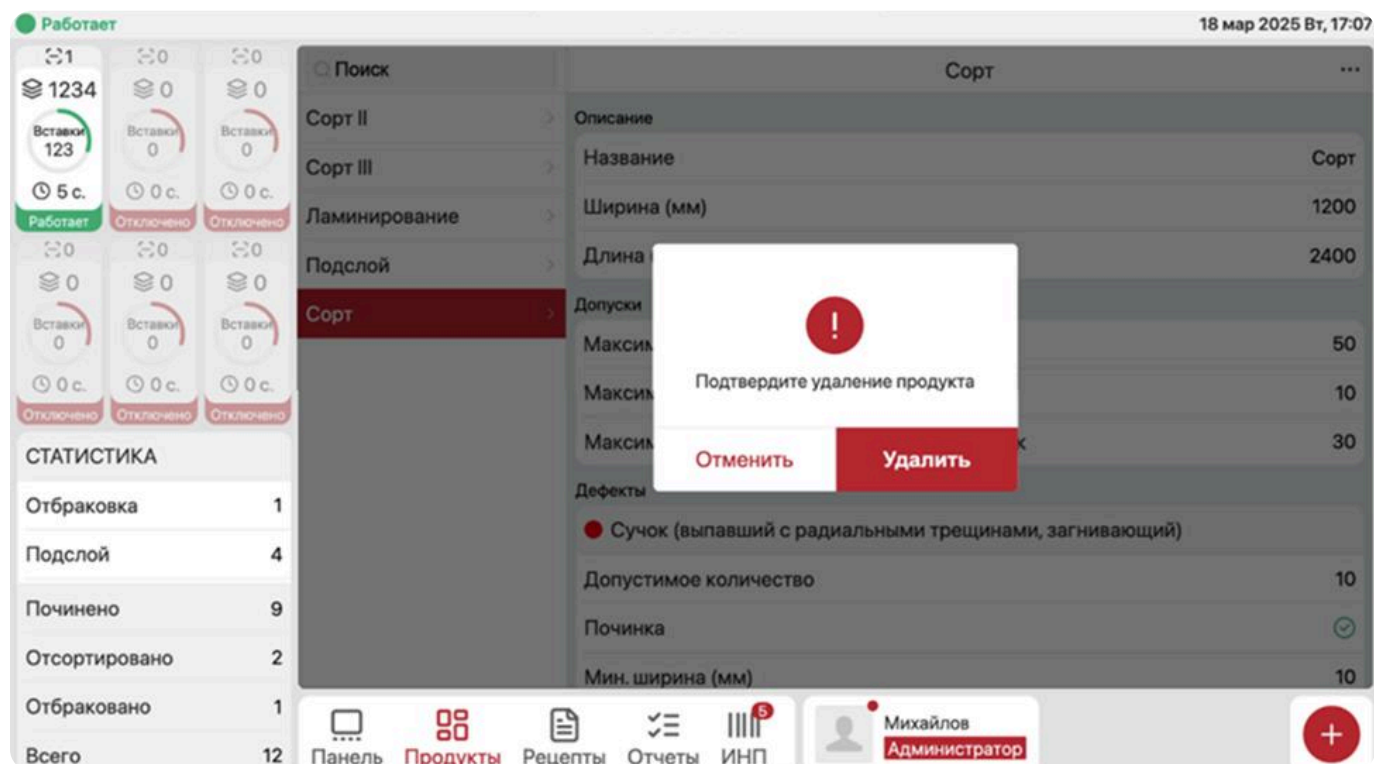
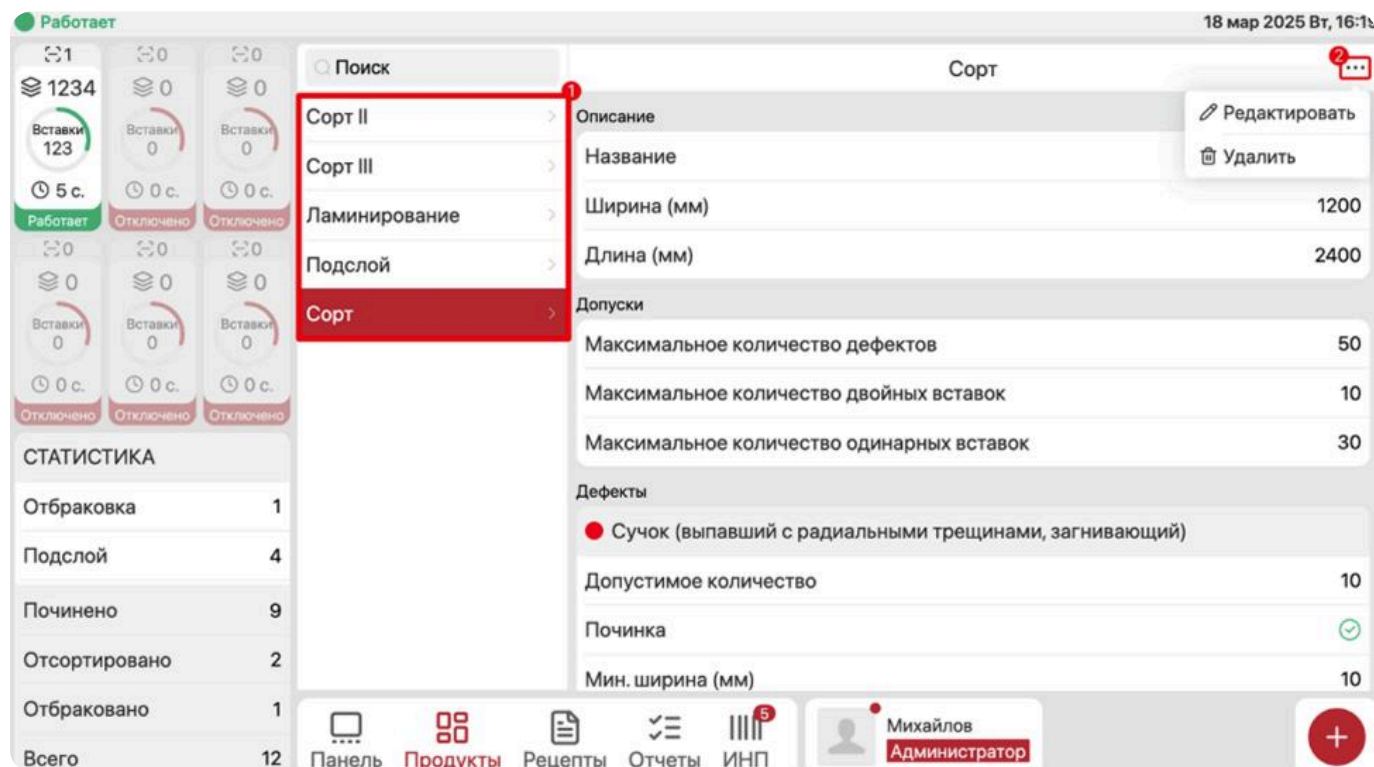
5.3. Deleting a Product

5.3.1. Select a product from the list (label “1”)

5.3.2. Open the menu (“...”) (label “2”)

5.3.3. Click Delete

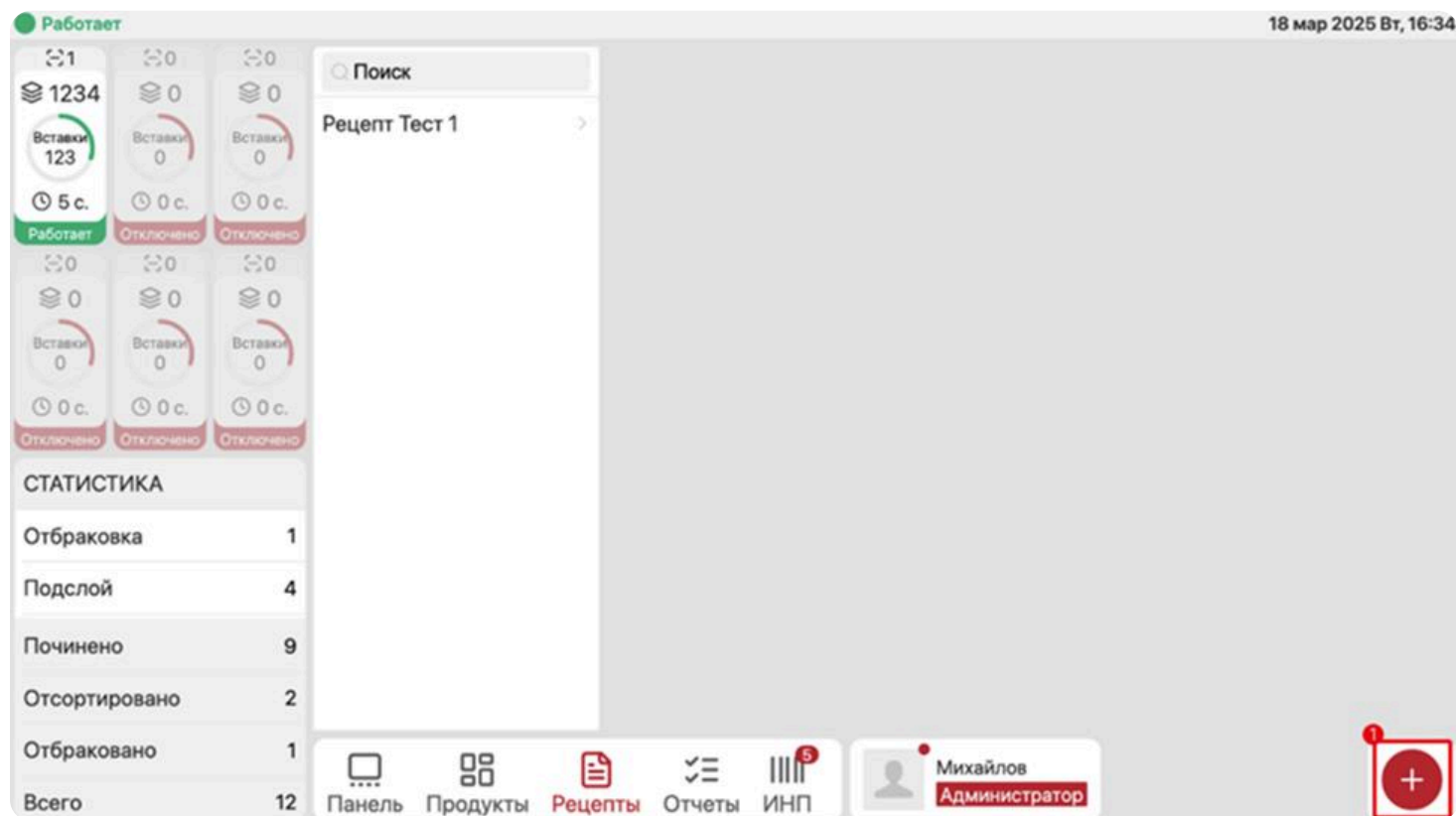
5.3.4. Confirm the action



6. Recipes

6.1. Creating a Recipe

6.1.1. Press the red “+” button in the bottom right corner of the screen (label “1”).



6.1.2. Fill in the recipe description

6.1.2.1. Enter the recipe name (label “1”)

6.1.2.2. Enter a short description for the operator (label “2”)

6.1.2.3. Proceed to the next step (red arrow button pointing right — label “3”)

6.1.2.4. To cancel, press the cross icon (label “4”)

18 мар 2025 Вт, 16:34

Работает

1234

Вставка 123

5 с.

Работает

Вставка 0

0 с.

Отключено

Вставка 0

0 с.

Отключено

Вставка 0

0 с.

Отключено

Вставка 0

0 с.

Отключено

Вставка 0

0 с.

Отключено

СТАТИСТИКА

Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

Описание

Продукты

Приоритеты

Результат

* Название рецепта Введите название 1

* Краткое описание Введите описание 2

ё 1 2 3 4 5 6 7 8 9 0 - = <

tab й ц у к е н г ш щ з х ъ \

caps ф ы в а п р о л д ж э enter

/ я ч с м и т ь б ю .

→ 3

6.1.3. Products

6.1.3.1. Select products to associate with the recipe (label “1”)

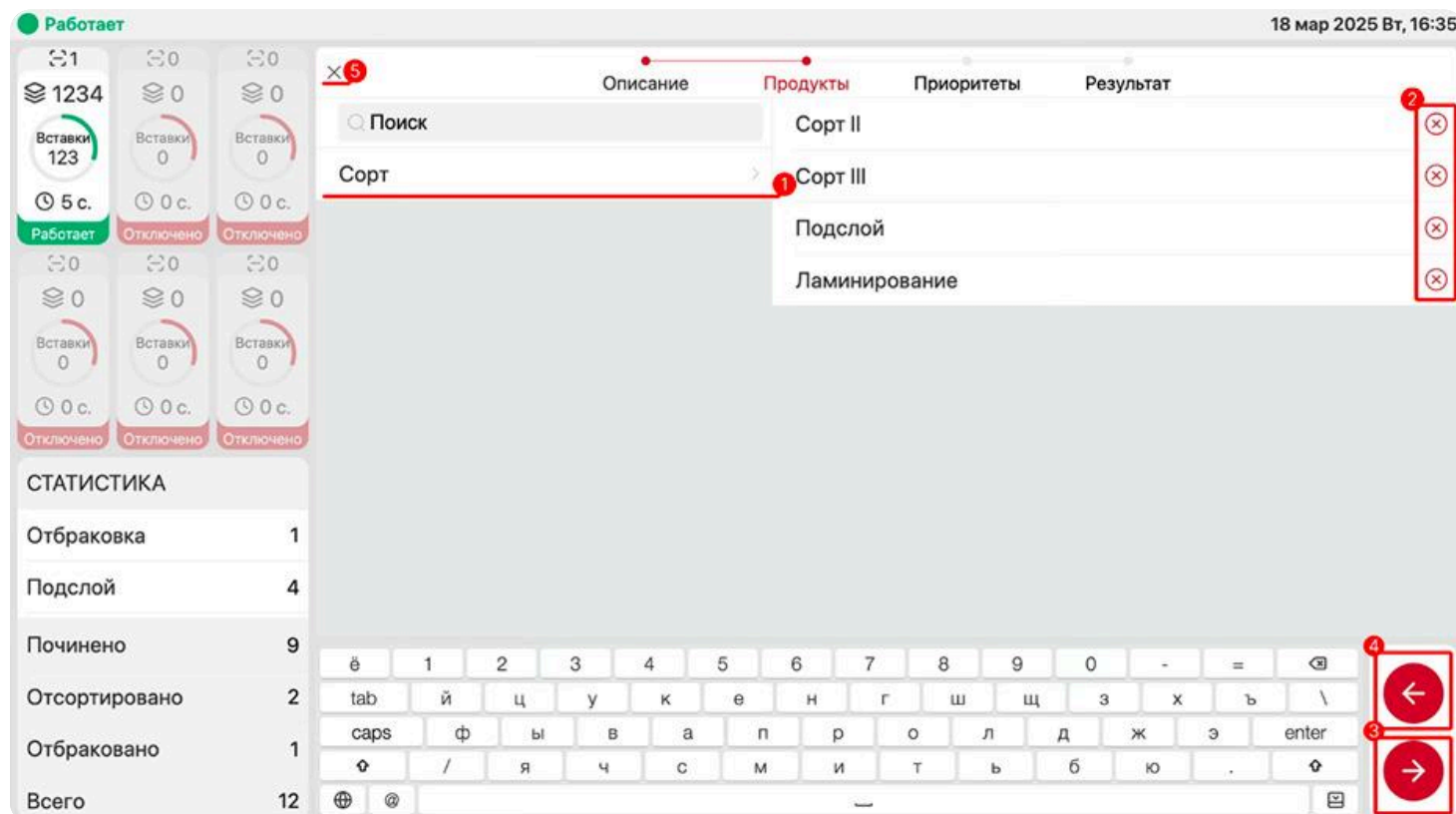
(Note: the system will only verify incoming veneer sheets against the selected products at this stage)

6.1.3.2. You can remove mistakenly selected products using the red cross (label “2”)

6.1.3.3. Proceed to the next step (red arrow button pointing right — label “3”)

6.1.3.4. Return to the previous step (red arrow button pointing left — label “4”)

6.1.3.5. To cancel, press the cross icon (label “5”)



6.1.4. Priorities

6.1.4.1. Select from the list the products the system will attempt to match the sheet to during repair (label “1”)

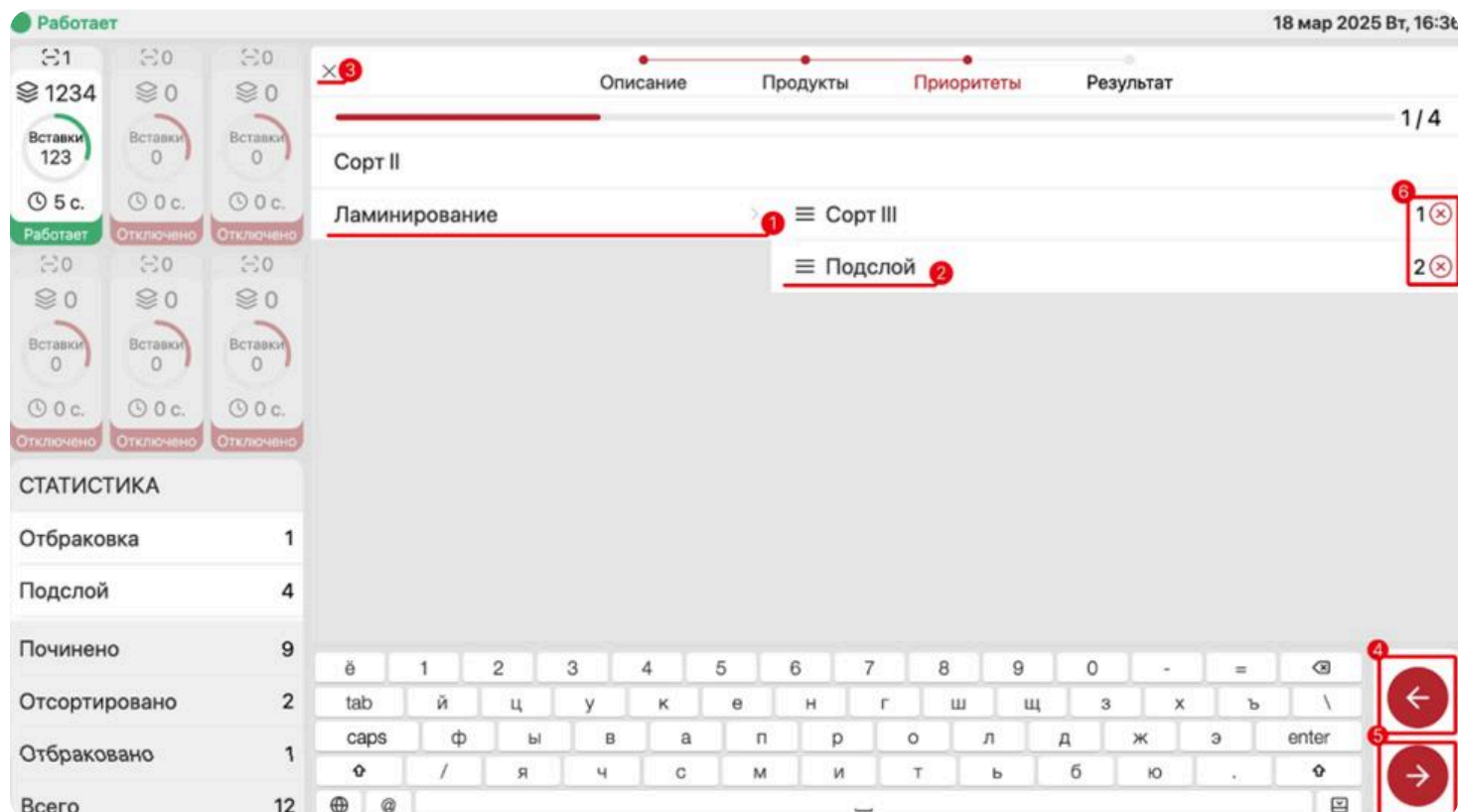
6.1.4.2. Drag and drop to set priority for the target product list (label “2”)

6.1.4.3. You can remove mistakenly selected products using the red cross (label “6”)

6.1.4.4. Proceed to the next step (red arrow button pointing right — label “5”)

6.1.4.5. Return to the previous step (red arrow button pointing left — label “4”)

6.1.4.6. To cancel, press the cross icon (label “3”)



6.1.5. Result

6.1.5.1. Verify that all fields are filled correctly

6.1.5.2. Save the new recipe by clicking the Save button (red diskette icon – label “1”)

6.1.5.3. If corrections are needed, go back (red arrow pointing left – label “2”)

6.1.5.4. To cancel, press the cross icon (label “3”)

Работает 18 мар 2025 Вт, 16:36

Описание Продукты Приоритеты Результат

Описание

Название

Описание

Сорт II

Сорт III 1

Подслой 2

Сорт III

Подслой

Ламинирование 1

Ламинирование

СТАТИСТИКА

Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

1 2 3

← 1

2

1

6.2. Editing a Recipe

6.2.1. Select a recipe from the list (label “1”)

6.2.2. Open the menu (“...”) (label “2”)

6.2.3. Click Edit

6.2.4. You’ll be redirected to the recipe creation flow with pre-filled data (see 6.1.2)

The screenshot displays the Syntetra software interface. At the top, a status bar shows 'Работает' (Working) and the date '19 мар 2025 Ср, 12:08'. The left sidebar contains a dashboard with three status indicators: 'Вставки 123' (Working, 5s), 'Вставки 0' (Disconnected, 0s), and 'Вставки 0' (Disconnected, 0s). Below this is a 'СТАТИСТИКА' (Statistics) table:

Category	Count
Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

The main content area features a search bar labeled 'Поиск' and a list of recipe components for 'Рецепт Тест 1'. The components are:

- Описание
- Название
- Описание рецепта
- Сорт II
- Сорт III (1)
- Ламинирование (2)
- Подслой (3)
- Сорт III
- Сорт II (1)
- Ламинирование (2)
- Ламинирование
- Подслой (1)

On the right side of the recipe list, there are two buttons: 'Редактировать' (Edit) and 'Удалить' (Delete). The bottom navigation bar includes icons for 'Панель', 'Продукты', 'Рецепты' (highlighted), 'Отчеты', and 'ИНП'. A user profile card for 'Михайлов Администратор' is also visible.

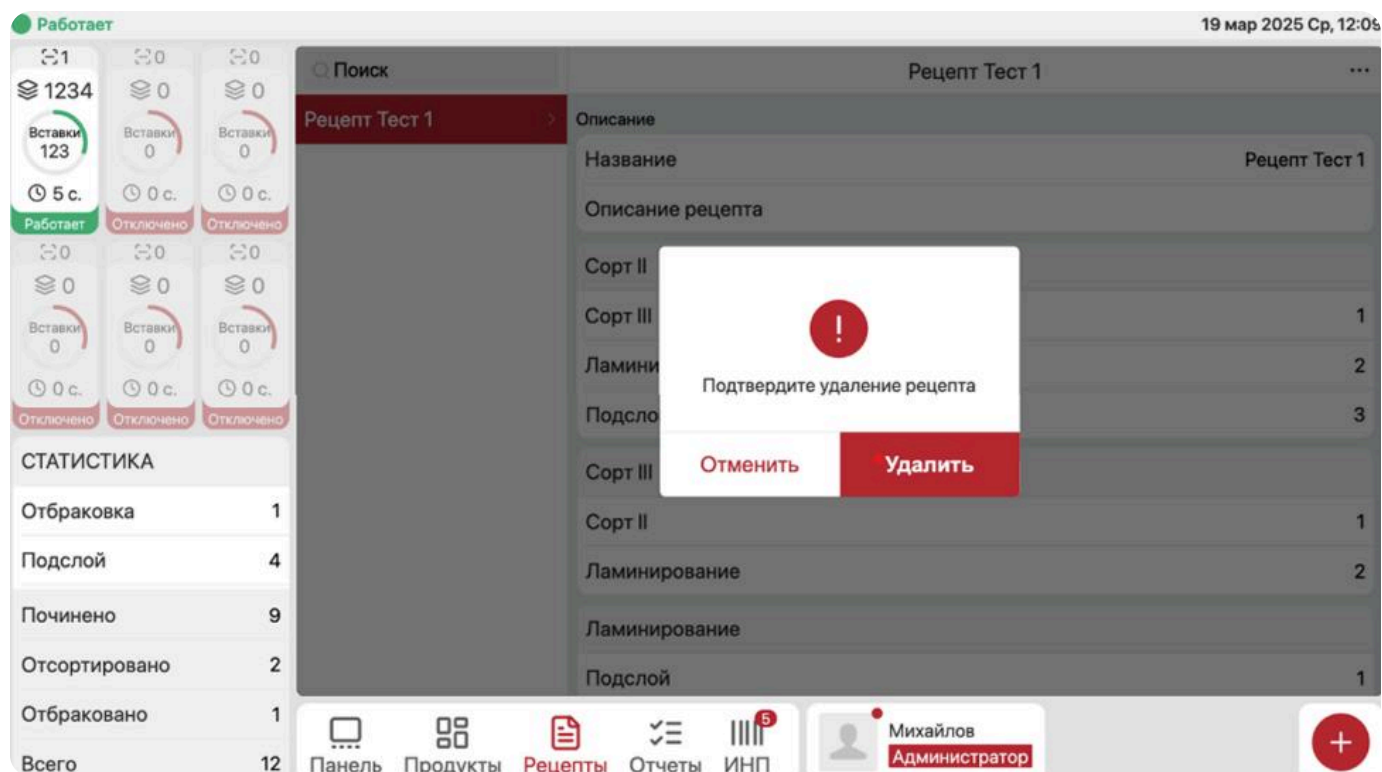
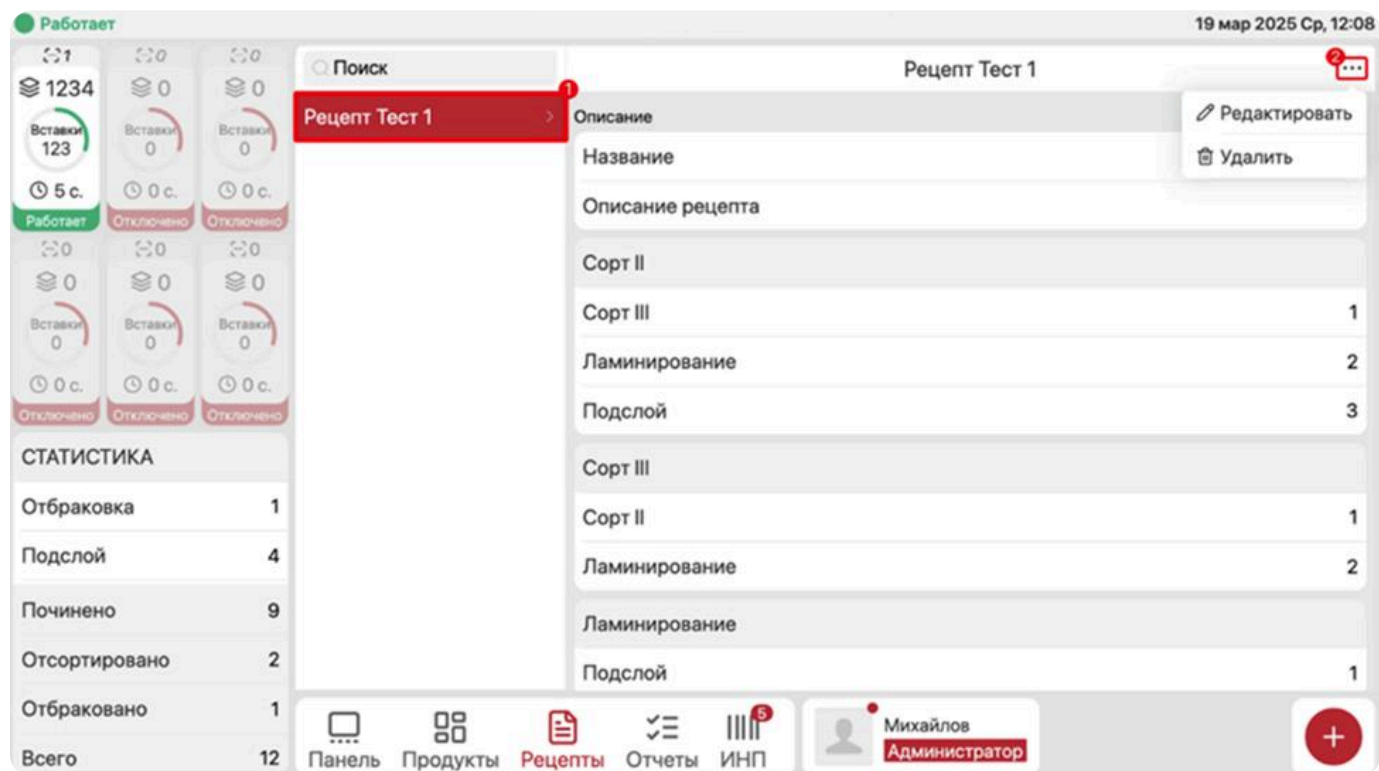
6.3. Deleting a Recipe

6.3.1. Select a recipe from the list (label “1”)

6.3.2. Open the menu (“...”) (label “2”)

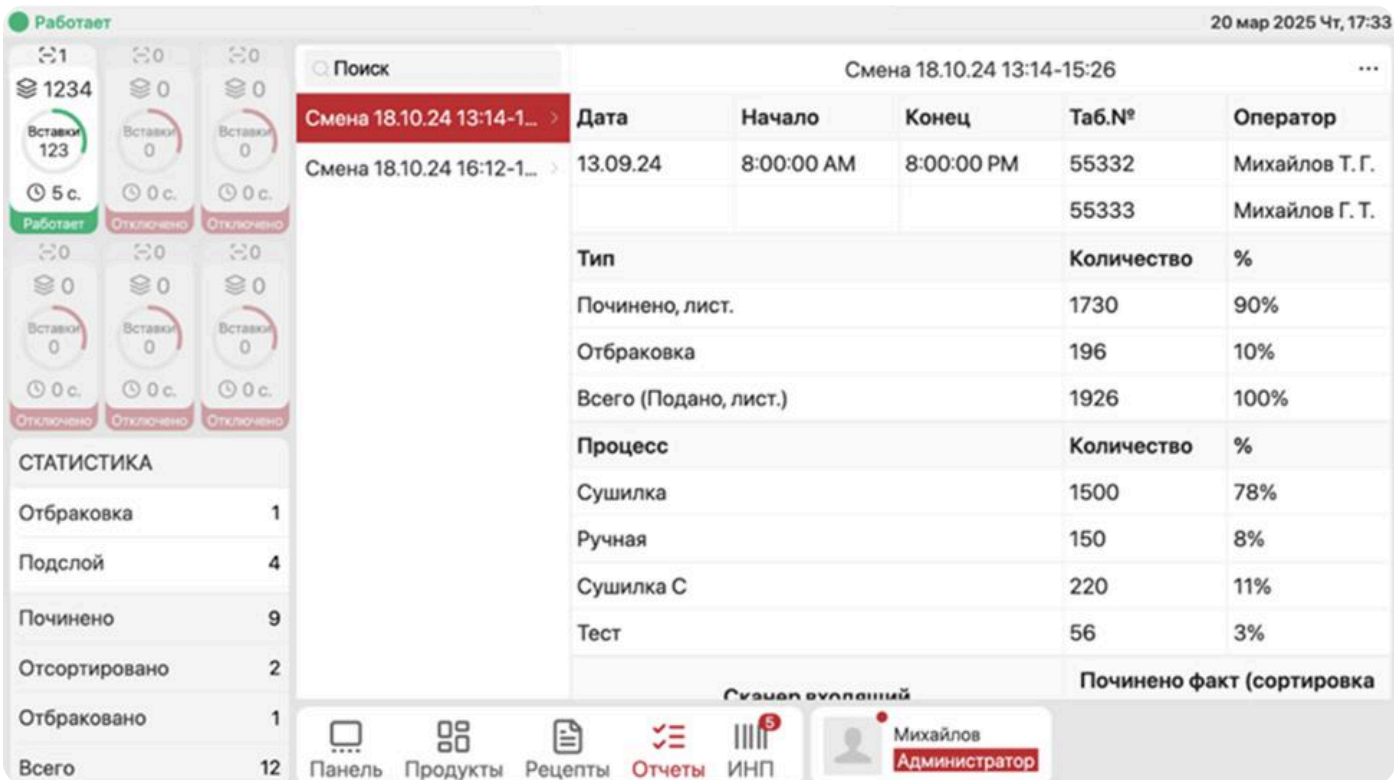
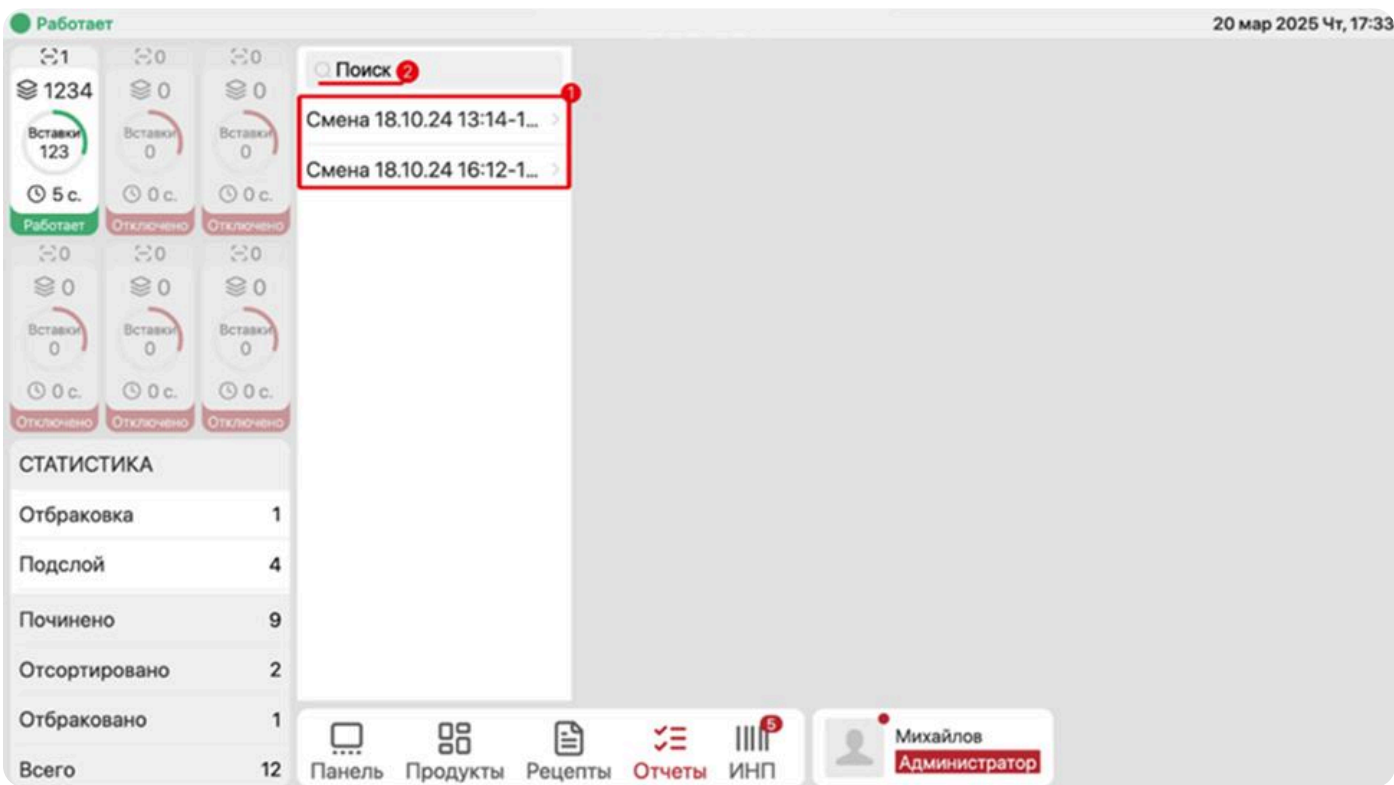
6.3.3. Click Delete

6.3.4. Confirm the action



7. Reports

- 7.1. Select a shift from the list on the left side of the screen to view the corresponding report (label “1”)
- 7.2. For quick search, use the Search field (label “2”)



8. INP

8.1. Adding a New INP

8.1.2. Fill in the following fields: “Sheets”, “Day”, “Hour”, “Minute” (labels “1-4”)

8.1.3. Select the following “Process”, “Certificate”, “Additional Attribute” (labels “5-7”)

8.1.4. Click the Add INP button (label “8”)

Работает

1234

Вставки 123

5 с.

Работает

0

Вставки 0

0 с.

Отключено

0

Вставки 0

0 с.

Отключено

0

Вставки 0

0 с.

Отключено

0

Вставки 0

0 с.

Отключено

0

Вставки 0

0 с.

Отключено

СТАТИСТИКА

Отбраковка1

Подслой4

Починено9

Отсортировано2

Отбраковано1

Всего12

Список ИНП

555.25.24.54.111.0.1	1
556.25.25.54.111.0.1	2
557.25.26.54.111.0.1	3
558.25.27.54.111.0.1	4
559.25.28.54.111.0.1	5

Новый ИНП

Листы3001

День312

Час153

Минута594

Процесс

процесс 1

процесс 2

процесс 3

5

Сертификат

0

1

6

Доп. признак

признак 1

признак 2

признак 3

7

листы.день.час.минута.процесс.сертификат.признак

Добавить ИНП8

ё1234567890-==<>

tabйцукенгшщзхъ\

capsфываппролджэenter

ф/ячсмитьбю.ф

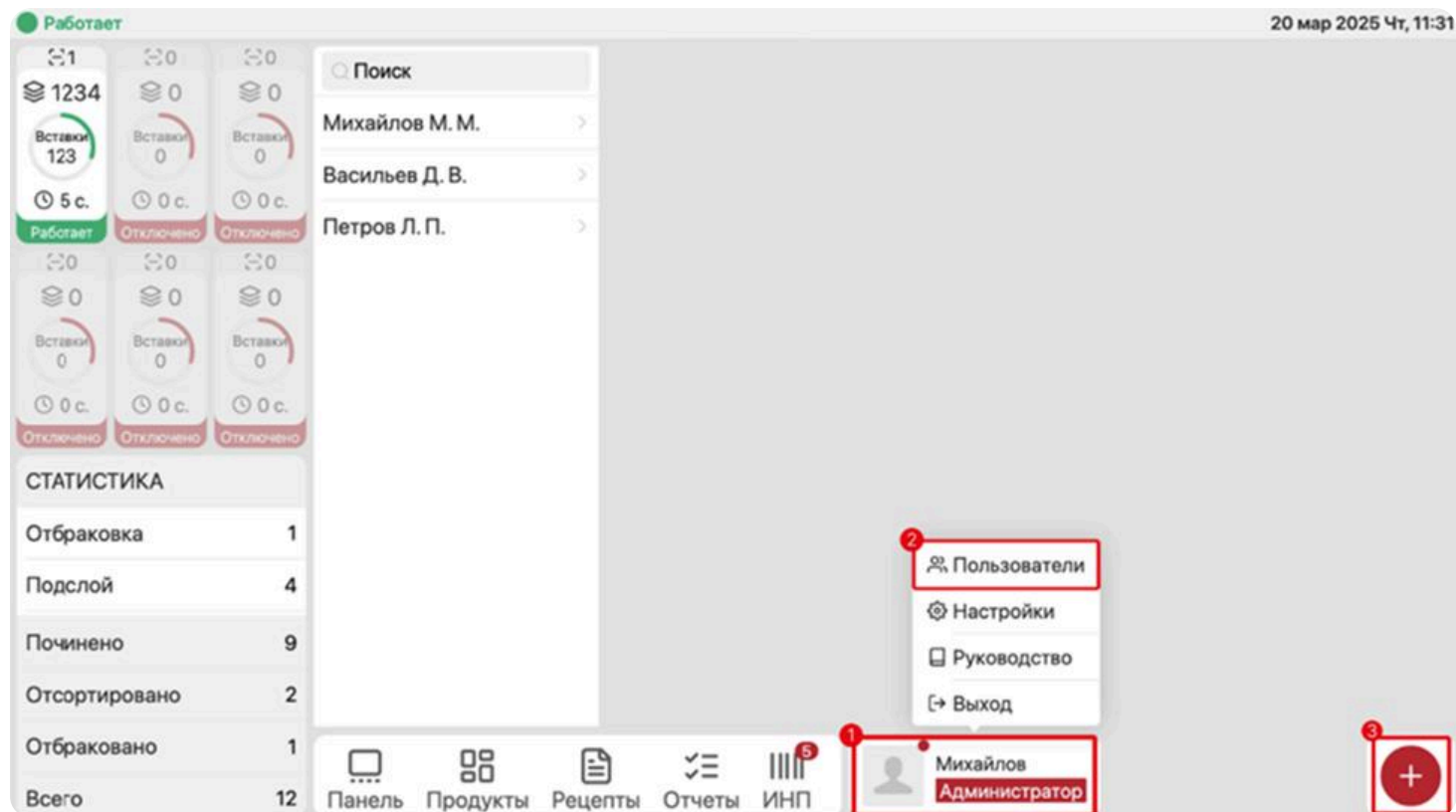
9. Users

9.1. Creating a User

9.1.1. Click on the block showing the user's surname and role (label “1”)

9.1.2. Select Users from the menu (label “2”)

9.1.3. Press the red “+” button (label “3”)



9.1.4. Fill in user information

9.1.4.1. Enter the following fields “First Name”, “Last Name”, “Middle Name”, “Employee ID” (labels “4-7”)

9.1.4.2. Set a unique 6-digit password (label “8”)

9.1.4.3. Select the user’s role (label “9”)

9.1.4.4. Proceed to the next step (red arrow pointing right – label “10”)

9.1.4.5. To cancel, press the cross icon (label “11”)

Работает 18 мар 2025 Вт, 16:37

Пользователь Результат

* Имя Введите имя 4

* Фамилия Введите фамилию 5

* Отчество Введите отчество 6

* Табельный номер Введите табельный номер 7

* Пароль (код) Введите код 8

* Роль ☐ Администратор 9
☐ Технолог
☒ Оператор

СТАТИСТИКА

Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

10

11

9.1.5. Result

9.1.5.1. Verify that all fields are filled correctly

9.1.5.2. Save the new user by clicking Save (red diskette icon — label “1”)

9.1.5.3. To edit something, return to the previous step (red arrow pointing left — label “2”)

9.1.5.4. To cancel, press the cross icon (label “3”)

The screenshot displays the Synetra software interface. At the top, a status bar shows 'Работает' (Working) with a green dot and the date '18 мар 2025 Вт, 16:36'. Below this is a progress bar with two steps: 'Пользователь' (User) and 'Результат' (Result). The main area is divided into a left sidebar and a central form.

Left Sidebar:

- Top Section:** A grid of 9 circular indicators. The first is green and labeled 'Вставки 123' (Inserts 123) with a '5 с.' (5 sec) timer and 'Работает' (Working) status. The other eight are red and labeled 'Вставки 0' (Inserts 0) with '0 с.' (0 sec) timers and 'Отключено' (Disabled) status.
- STATISTIKA (Statistics) Table:**

Статистика	Значение
Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

Central Form:

Пользователь (User) Form:

Поле	Значение
ФИО	Фамилия Имя Отчество
Табельный номер	123
Роль	Оператор
Пароль (код)	123123

Bottom Section:

A virtual keyboard is visible. To its right are two red circular icons: a left-pointing arrow (labeled '2') and a diskette icon (labeled '1'). A red 'X' icon with a '3' is located at the top left of the main form area.

9.2. Editing a User

9.2.1. Select a user from the list (label “1”)

9.2.2. Open the menu (“...”) (label “2”)

9.2.3. Click Edit

9.2.4. You’ll be redirected to the user creation form with pre-filled data (see 9.1.4)

The screenshot displays a software interface with a sidebar on the left and a main content area on the right. The sidebar contains a status bar at the top with a green indicator and the word "Работает". Below it are three circular gauges labeled "Вставки" with values 123, 0, and 0, and a timer showing 5 seconds. Further down is a "СТАТИСТИКА" section with a table:

Статистика	Значение
Отбраковка	1
Подслой	4
Починено	9
Отсортировано	2
Отбраковано	1
Всего	12

The main content area features a search bar labeled "Поиск" and a list of users. A red box labeled "1" highlights the user "Михайлов М. М." in the list. To the right of the list, a user details form for "Михайлов М. М." is visible, showing fields for "ФИО", "Табельный номер" (3333), "Роль" (Администратор), and "Пароль (код)" (000000). A red box labeled "2" highlights the menu icon (three dots) next to the user name. At the bottom of the interface is a navigation bar with icons for "Панель", "Продукты", "Рецепты", "Отчеты", and "ИНП", along with a user profile card for "Михайлов Администратор" and a red plus button.

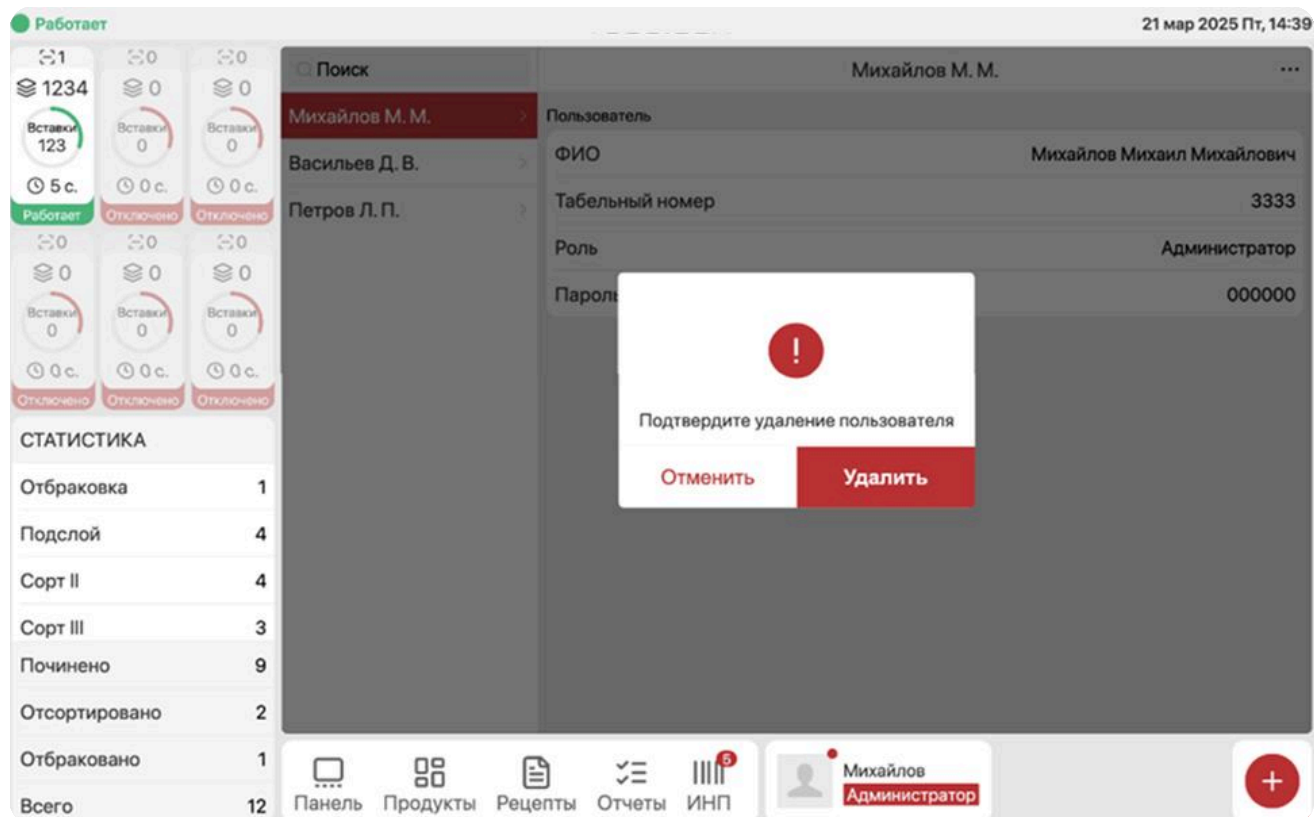
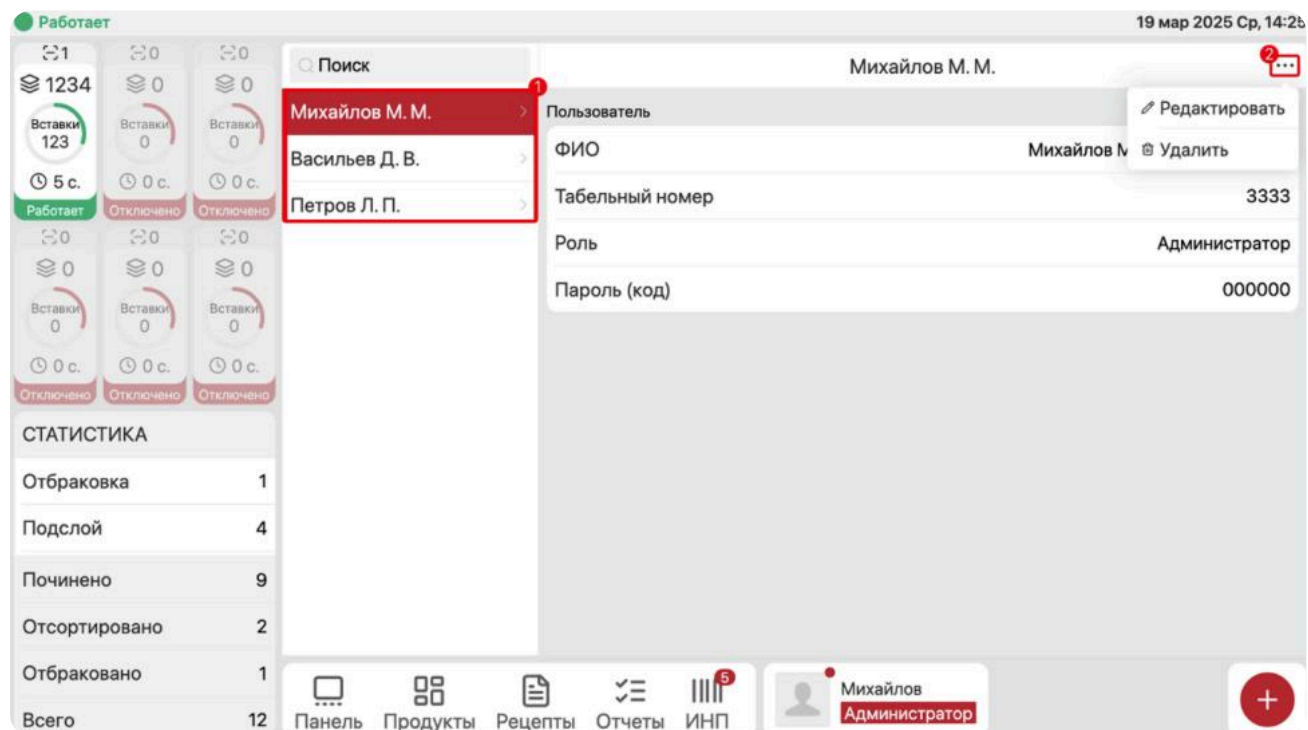
9.3. Deleting a User

9.3.1. Select a user from the list (label “1”)

9.3.2. Open the menu (“...”) (label “2”)

9.3.3. Click Delete

9.3.4. Confirm the action



9.4. User Roles and Permissions

9.4.1. Operator

9.4.1.1. Select recipes

9.4.1.2. Start/stop the system

9.4.1.3. View statistics, help, reports, recipes, and products

9.4.2. Technologist

9.4.2.1 All Operator permissions

9.4.2.2. Create, edit, and delete recipes and products

9.4.2.3. Change system settings

9.4.3. Administrator

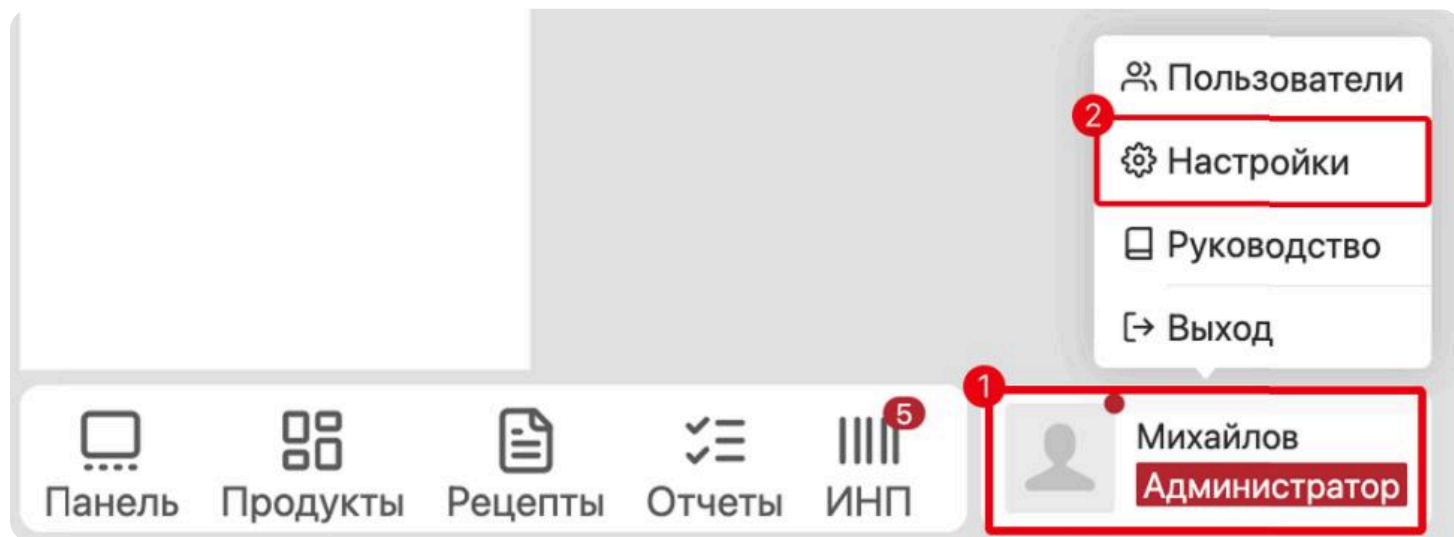
9.4.3.1. All Technologist permissions

9.4.3.2. Manage user accounts

10. Settings

10.1. Click on the block displaying the user's surname and role (label “1”)

10.2. Select Settings from the menu (label “2”)



10.3. General Settings

10.3.1. Change the email address used to send shift reports

The screenshot shows the 'Общие' (General) settings page. On the left, there is a sidebar with a 'Работает' (Working) status indicator and a 'Поиск' (Search) bar. Below the search bar, there are several settings categories: 'Общие' (General), 'Настройки листа' (Sheet settings), 'Ручная калибровка' (Manual calibration), 'Оборудование' (Equipment), and 'Настройки ИНП' (INP settings). The 'Общие' category is selected. The main content area shows the 'Почта для отправки отчета' (Email for report sending) field, which is currently set to 'test@gmail.com'. Below this field is a red 'Сохранить' (Save) button. At the bottom of the interface, there is a status bar showing the user's name 'Михайлов' and role 'Администратор' (Administrator).

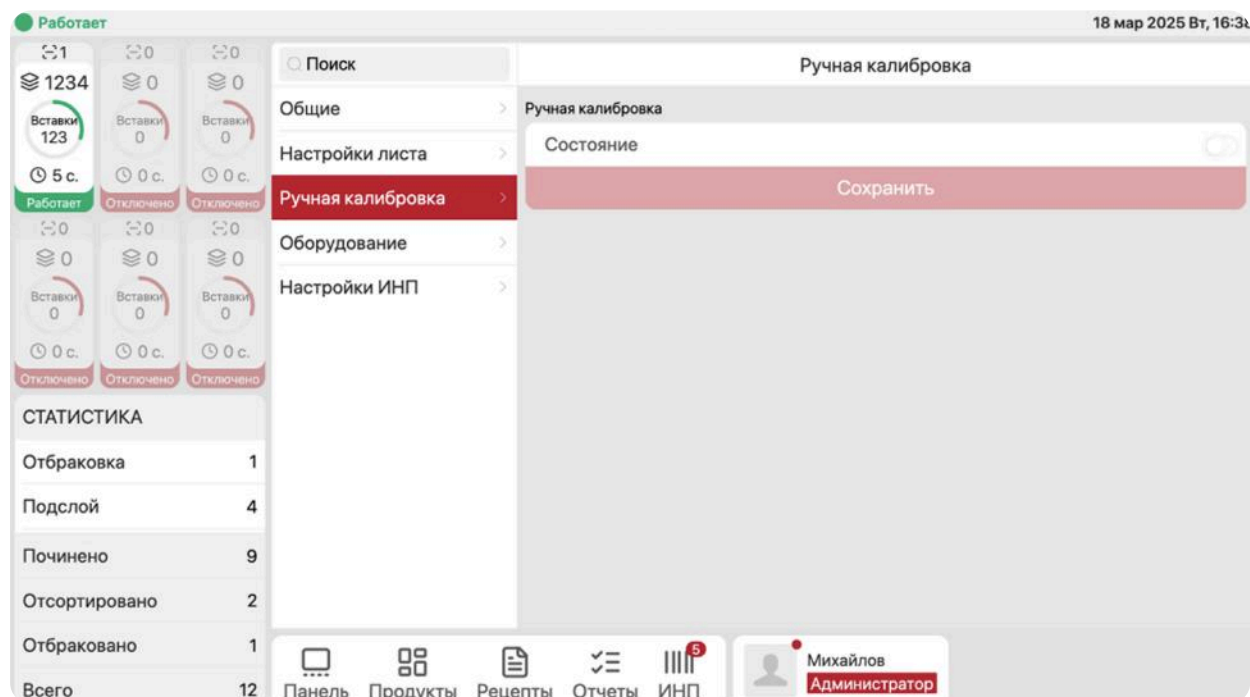
10.4. Sheet Settings

10.4.1. Set the critical angle (in degrees), sheet dimensions (length/width in mm), and zone partitioning

The screenshot shows the 'Настройки листа' (Sheet settings) page. On the left, there is a sidebar with a 'Работает' (Working) status indicator and a 'Поиск' (Search) bar. Below the search bar, there are several settings categories: 'Общие' (General), 'Настройки листа' (Sheet settings), 'Ручная калибровка' (Manual calibration), 'Оборудование' (Equipment), and 'Настройки ИНП' (INP settings). The 'Настройки листа' category is selected. The main content area shows the 'Критический угол листа' (Critical angle of the sheet) field, which is currently set to '10'. Below this field, there are two more fields: 'Критический размер листа' (Critical size of the sheet) and 'Разделение листа на две зоны' (Dividing the sheet into two zones). The 'Критический размер листа' field has two sub-fields: 'Длина' (Length) set to '2700' and 'Ширина' (Width) set to '1300'. The 'Разделение листа на две зоны' field has a sub-field 'Координата' (Coordinate) set to '50'. Below these fields is a red 'Сохранить' (Save) button. At the bottom of the interface, there is a status bar showing the user's name 'Михайлов' and role 'Администратор' (Administrator).

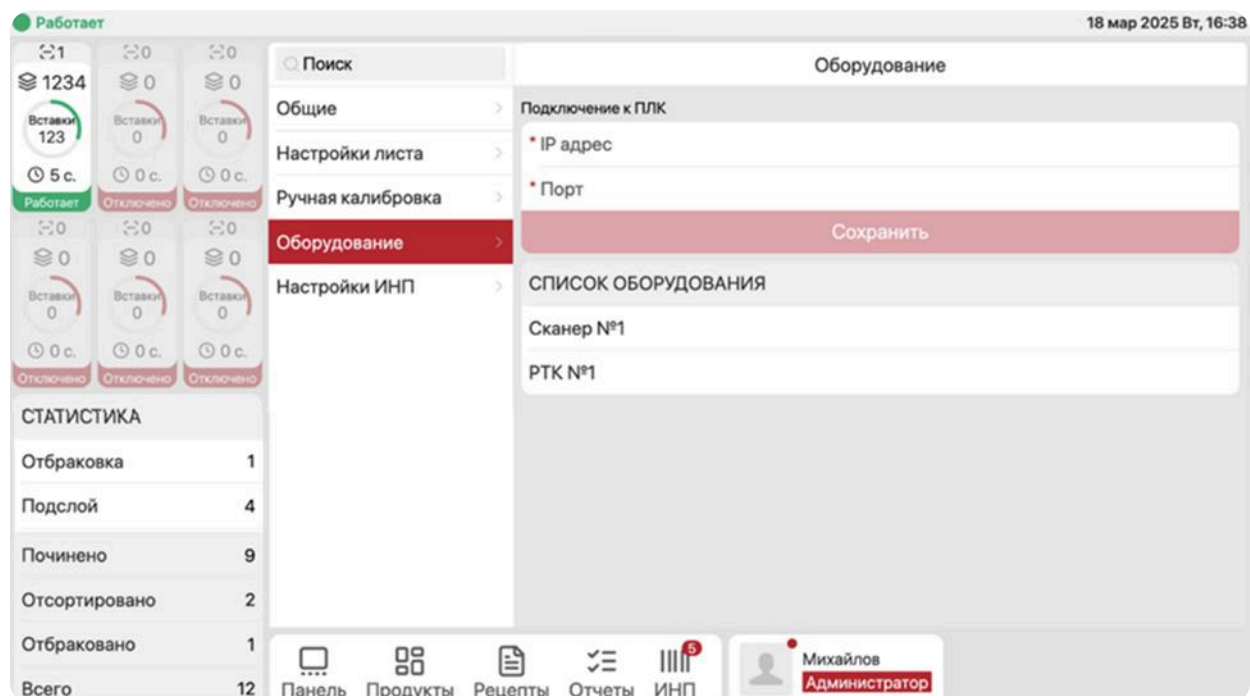
10.5. Manual Calibration

10.5.1. Perform equipment calibration manually



10.6. Equipment

10.6.1. Change the PLC's IP address and port, configure the equipment list

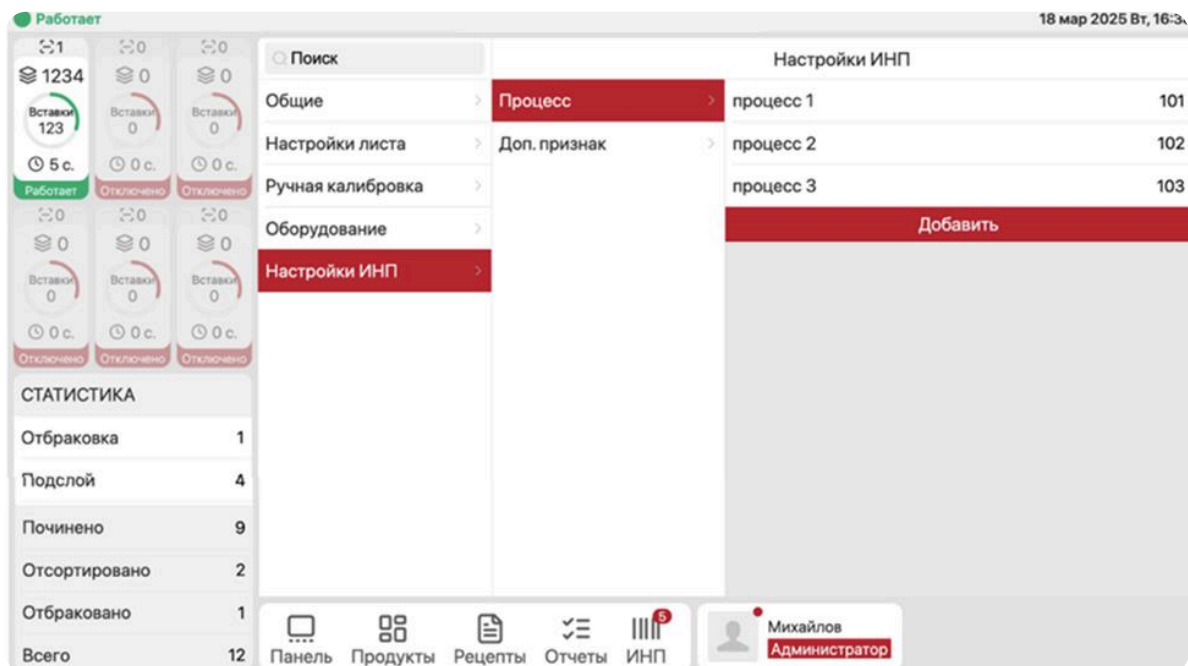


10.7. INP Settings

10.7.1. Adding a New Process

10.7.1.1. Press the Add button

10.7.1.2. Fill in the “Name” and “Value” fields and press Save



10.7.2. Adding an Additional Attribute

10.7.2.1. Press the Add button

10.7.2.2. Fill in the “Name” and “Value” fields and press Save

