

# Foy's EPICS Events

Extrusion Production Information and Control Systems

January 2007 \* Volume 11, Issue 1

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## 2007 EPICS Conference to be Held in Charleston

As mentioned in the last newsletter, the ninth annual EPICS User Conference will be held in historic Charleston, South Carolina. Condé Nast Traveler magazine rated Charleston as the country's #5 travel destination for 2006, and for good reason. Charleston is packed with fascinating things to see and do, and the EPICS conference will be held right in the middle of the activities.

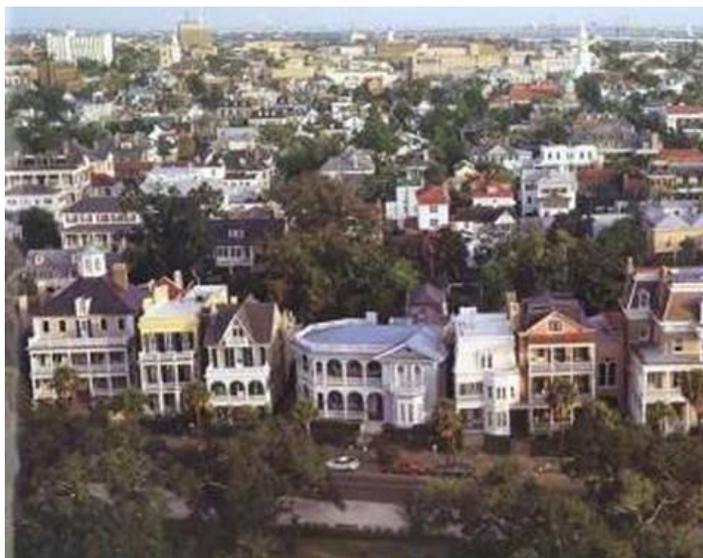
The conference hotel is the [Doubletree Guest Suites Charleston](#), located in the center of the famous [Charleston historic district](#). You should call the Doubletree at 1-843-577-2644 and specify the FOY EPICS CONFERENCE in order to receive the special rate of \$174.



The conference will be held on April 22-25, 2007, with the registration reception from 4:00PM until 8:00PM on Sunday evening. The conference sessions on Monday and Tuesday will follow the same hours as last year, starting at 8:00AM and running until 2:00PM.

A group activity is being planned for Monday evening, involving a tour of some of the historic features of Charleston and ending up at one of Charleston's great restaurants.

An optional day of training will be held on Wednesday, again running from 8:00-2:00. This session will cover the new EPICS features in much more detail than the regular session.



While the conference schedule is still being developed, some topics are already set.

- ✓ The numerous enhanced features of the EPICS Stock Inventory will be reviewed.
- ✓ New billet purchase order capabilities will be explained in detail.
- ✓ The new ability to post billet saw production will be described, which will be of interest to those of you who buy logs and saw them to length
- ✓ Utilizing a stock depot will be explained.
- ✓ Foy's experience with the Microsoft Vista operating system, as well as Office 2007, will be described
- ✓ New offerings from Business Objects (the makers of Crystal Reports) will be covered
- ✓ The EPICS ChemComp program, which more and more billet suppliers are signing up for, will be reviewed.
- ✓ The recently introduced procedures for changing Customer, Part, and Die numbers will be demonstrated



We expect to have additional topics when the official conference flyer is sent out later this month. But mark your calendars now for another great EPICS Conference.

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### **EPICS V8.5 update ready for release**

The EPICS 8.5 update will be released early this week. Your System Administrator will receive email when the new version is ready to be downloaded.

The V8.5 update contains numerous enhancements, including several of the most-requested items on the 2006 Wishlist. The major enhancements are described below. Other changes can be found in the Help file that will be distributed with the update.

A video of the new features will also be posted on the Foy Inc website shortly after the release.

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### **Old Production Posting Screens Replaced**

As we have communicated to you several times over the last year, the old "Post Press Production" and "Post Other Production" screens are going away. The "Advanced Production Posting" screen that was introduced in May of 2005 replaces these screens, and adds numerous features not available with the old screens. The new screen allows you to start using the powerful 'master work order' and 'rack tracking' features, and includes such tools as on-screen workorders and press schedule.

Most of you made the move to the new production posting screen last year. **If you are still using the old screens, you need to switch to the new one before you upgrade to the EPICS V8.5 update, since that update does not contain the old screens.**

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## New Stock Inventory Features

The 8<sup>th</sup> ranked item on the 2006 EPICS Wishlist was a "Stock Inventory Module." Rather than create a new EPICS module (for additional cost,) we have greatly expanded the stock inventory system in EPICS and included these new features in release 8.5.

In version 8.5, you will use the Maintain Parts screen to indicate which Customer parts you intend to keep in inventory by checking the "Stock Part" checkbox. We will refer to parts that have the "Stock Part" box checked as "inventoried parts."

Part Number 1.5 X .25 BAR LINEAL for Worldwide Extrusions

Part: 1.5 X .25 BAR LINEAL    CustNum: WORLD

Properties | User Fields | Prices | Stock | Drawing Files | Links | Changes | Dept Specs

DieNum: 17914    Alloy: 6063    AlloyType: P    Temper: T5    Length: 24'0"    CutTot: +    ExtLen: 0"    PcExtLen:    FinCode: 000    Routing: MILL STOCK

Stock Part     Inactive

CustGroup: STD SHAPES    Descr: 1.5 x .25 Bar Lineal    ProdCode:    PackCode:    CertCode:    SpecCode1:    SpecCode2:    SpecCode3:    DiscountSchedule:

Source Part (can fill this part from stock)    Part:    CustNum:    Original Quote Info    Source QuoteNum:    Line:    Alternate Pricing Info    Added Length: +    in    AltPrintWt:    AltPerim:

Die Information (view only)    Die Type: S    PrintWt/ActWt: 0.441    0.406    Full/Finish Perim: 3.5    3.5

Mode:  Inquire     Change     Add     Delete     View    1 of 7    Show All    Done    Notes

For each of these inventoried parts, a "Stock" tab will appear that allows you to specify the desired inventory levels. This tab also displays a list of all current inventory tickets for that part. The yellow highlighted "Reorder Point (Pcs)" field indicates that the current inventory level is below our desired reorder point:

Part Number 1.5 X .25 BAR LINEAL for Worldwide Extrusions

Part: 1.5 X .25 BAR LINEAL    CustNum: WORLD

Properties | User Fields | Prices | Stock | Drawing Files | Links | Changes | Dept Specs

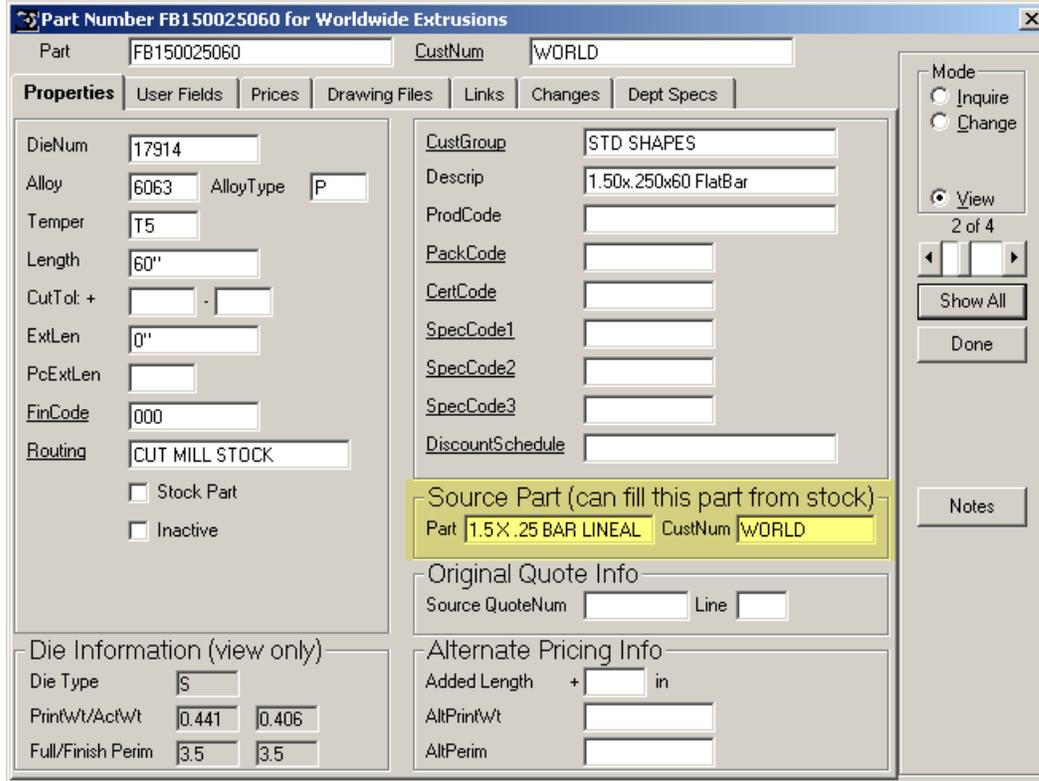
Inventory Control    Reorder Point (Pcs): 300    Minimum Pcs:    Reorder Qty (Pcs): 750    Maximum Pcs:    Stock Location: South Bldg. Rack 27C

Current Stock (200 pieces)

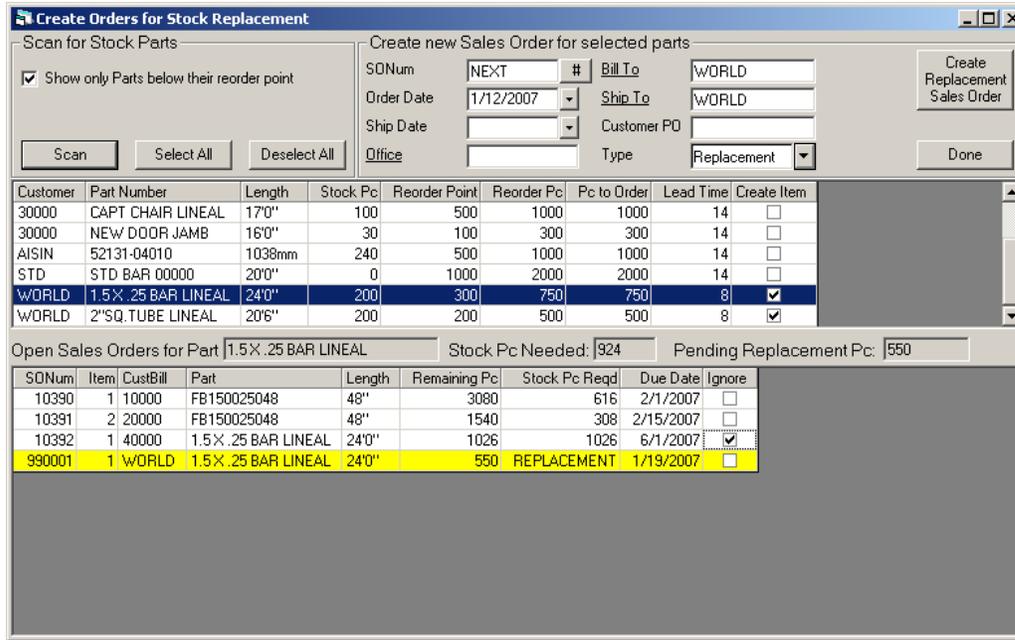
TicketNum	Stock Number	Length	Finish	Pieces
10338	10338	24'0"	000	50
10339	10339	24'0"	000	50
10340	10340	24'0"	000	50
10341	10341	24'0"	000	50

For each of your customer parts, it is also possible in EPICS v8.5 to define a source part. A source part is a different part number of an inventoried part that can be used to fill the part number on screen. For example, you might carry a 24 foot part (the source part) in inventory, and use it to produce 6 foot, 8 foot, and 12 foot pieces.

In this example, a fabricated part has been set to pull stock (if available) from a standard lineal. The routing for this part has been set to include the cutback department after the fill from stock operation:



Another great new feature of the EPICS Stock Inventory is the ability to quickly create stock replacement orders for inventoried parts:



This screen is designed to be an inventory management worksheet and is divided into four sections. The “Scan for Stock Parts” section of the screen (top-left) scans your customer parts to find all inventoried parts and displays them in the middle section of the screen. By default, it will return only those parts whose inventory is below their designated reorder point, but you can instead view all inventoried parts by un-checking the checkbox before clicking the “Scan” button. The “Select All” button will check the “Create Item” box for all displayed parts.

For each part that is displayed in the middle section of the screen, you will see the current inventory level (“Stock Pc”); the reorder point and reorder pieces that are set for that part; and the lead time that is required to produce each part using its standard routing. The “Pc to Order” column will be set by default to the “Reorder Pc” for each part, but can be changed to a different value if desired before you create the replacement order.

You can click on any part in the middle section of the screen to select it. The bottom section of the screen will then display all open sales orders that can be filled from the selected part. Please note that in the above example, the displayed sales order items include not only items that call for the selected part, but also items that call for different parts that can use the selected part as a “Source Part.”

You should use the “Open Sales Orders” information to determine the number of pieces that should be run to both replenish stock and fill existing orders. You can then modify the “Pc to Order” field for that part accordingly. If any stock replacement orders are already in process for the selected part, these orders will appear highlighted in yellow. You can use the “Ignore” checkbox to selectively subtract items from the displayed totals. In the example above, we have chosen to ignore one item because it is not needed for several months.

The top-right section of the screen allows you to specify the heading information that will be used to create the replacement sales order. The “Create Replacement Sales Order” button will use this heading information to create a single sales order with one sales order item for each displayed part that you have checked the “Create Item” checkbox. You will use the EPICS Order Entry screen to edit and post this new sales order.

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## Billet Purchase Orders Enhancement

The #5 item on the 2006 Wishlist was to create a Billet Purchase Order module. The V8.5 update fulfills this wish.

Billet PO records are no longer tied to the identification of a billet (alloy, alloy type, diameter and length), but rather, billet identification is now a property of the PO. It is now possible for the entire contents of a Billet PO to be seen on one screen. A new screen is included in update 8.5 for the creation and maintenance of these POs.

*It is important to note* that when update 8.5 is installed current billet PO records will be copied into two new tables: BilletPOHeader and BilletPOItem. The Supplier field was added to EPICS a few years ago as a replacement of the Vendor field. The Vendor field has now been removed. When the billet PO records are copied to the new tables, if no Supplier exists with the PO record, the Supplier field will display "Unknown Billet Supplier". The vendor number will be placed in the Note field. Future billet purchase orders and receipts will require a billet Supplier record.

Item	Alloy	Type	Diam	Length	Lb Ordered	Lb Received	Lb Remaining	Price/Lb	Closed	Note
1	6063	P	8	20	100000	9228	90772	1.15	<input type="checkbox"/>	Note text
2	6063	P	8	22	120000	0	120000	1.17	<input type="checkbox"/>	Sample note
3	6060	P	8	20	150000	13988	136012	1.25	<input type="checkbox"/>	can appear on PO
4	6060	P	8	24	150000	0	150000	1.25	<input type="checkbox"/>	

When metal is received against one of the POs, a new screen makes posting the receipts much easier. You simply scan for open POs, click the one that is being received, then enter the quantities. Note that you can enter the number of bundles received and the pcs/bundle, and EPICS will do the math.

PO Number	Item	Alloy	Type	Diam	Length	Cast Number	Bundles	Pcs/Bundle	Pc Received	Lb Received	Price/Lb	Note
1002	1	6063	P	8	20	1020304R	21	19	399	21658	1.15	
1002	3	6060	P	8	20		34	19	646	48321	1.25	

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### Billet Saw Production Posting

This new feature will be of interest to extruders who cut logs to produce billets. The new Post Billet Saw Production screen provides a place to record billet saw production in EPICS. Each production record is assigned a Job Number. The production records remain as a detailed record of the work performed.

Using the screen below, the user can post the logs that were cut, and the billets that resulted from this operation.

Log Length	Cast Number	Logs Used	Total Weight Used
205	9986875	6	5584
215	1020304R	5	4881

Billet Length	Cast Number	Billets Produced	Total Weight Produced
20	9986875	24	2179
22	9986875	24	2397
24	1020304R	44	4794

As billet saw production is posted inventory levels are automatically adjusted; decreasing the source log quantity and increasing the newly created billets quantity. A new column has been added to Billet History to show quantity sawed.

**Billet**

Properties | Open PO's | **History** | Changes

Alloy: 6063 AlloyType: P Diameter: 8 Len: Log

Date	Used	Received	Sawed	Price
1/12/2007	0	0	-10.464	0.000
12/21/2006	143	0	0.751	

Log inventory reduced.

**Billet**

Properties | Open PO's | **History** | Changes

Alloy: 6063 AlloyType: P Diameter: 8 Len: 24

Date	Used	Received	Sawed	Price
1/12/2007	0	0	4.794	0.000

Billet inventory increased

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### New Fields Added for Shipping to Depot

In 8.5, four new, optional fields have been added to the “Post Shipments” and “Enhanced Shipping” screens. These fields can be used to input information that might be needed for containerized shipments that are being sent to a freight depot for later shipment. They could also be used for material that is shipped to a customer, but not invoiced until the customer reports using the material. These new fields are stored in the Manifest and Picklist tables and can be printed on documents or reports.

**Post Shipment: Sales Order 10033 for WestTex Dust Screens**

Post Shipment | Pending Shipments

Sales Order: 10033 Bill of Lading: 398101  Next Manifest  
 Date: 1/12/2007 ShipViaCode: OT  Manifest:   
 Supplier: NEVERLATE

	Order	Item	Ticket	Die	Length	Finish	Pieces	Net Wt	St	Master	Ship To
SHIP	10033	4	10337	11022	10'0"	202	10	25	A	0	20000

Pick Selected Tickets for Truck: Tickets Selected: 1 Total Net Wt: 25

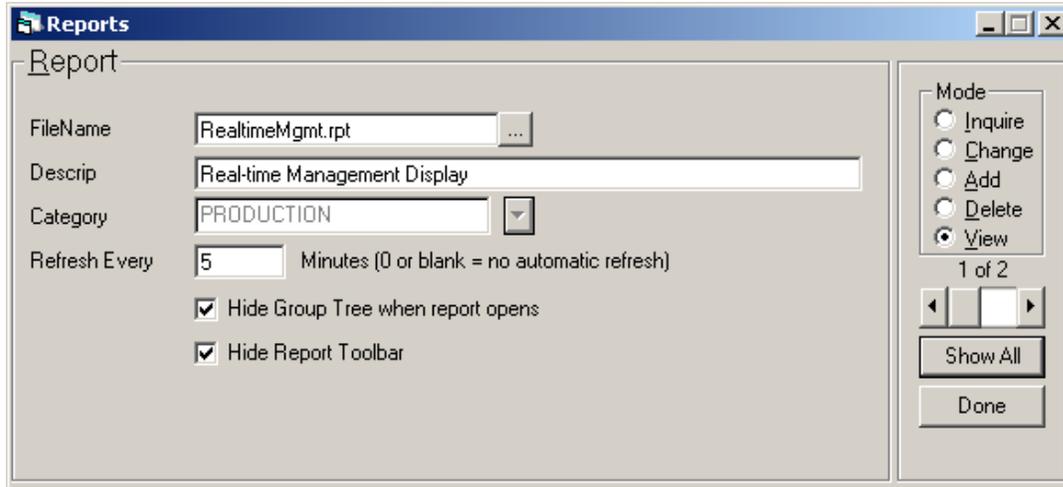
**Optional Information**

Note 1: Container 52712 ETA Depot: 1/19/2007  
 Note 2: Vessel NCC-1701-D ETA Destination: 1/31/2007

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**Improvements to the RealTime Management Report**

Many of you have reported problems with the EPICS "Realtime Management Report" screen. Recent security updates made by Microsoft to the database features of Excel have made it more difficult to display spreadsheets that refresh themselves automatically. Consequently, we have added new fields to the EPICS Reports table that allow you to use any Crystal report as your real-time management display. Below is a screenshot of the "Files/Other Tables/Maintain Reports" screen from EPICS 8.5.



The above report is set to auto-refresh every 5 minutes. It is also set to hide the group tree that normally appears on the left side of the report as well as the toolbar that appears at the top of the report viewer window. These settings will be used each time the report is opened.

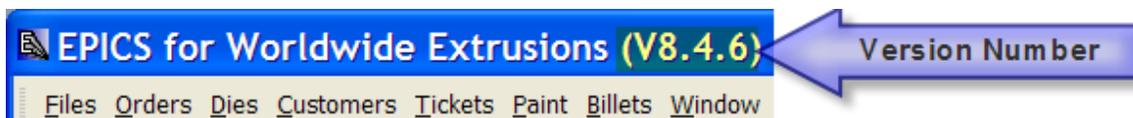
The "RealtimeMgmt.rpt" file referenced above is available for download on our website. It duplicates the functionality of our standard "Realtime Management" Excel spreadsheet. Bundled with the .RPT file is a .SQL script to create the views that are required by the report. As with any of our standard reports, you can use Crystal Reports to modify this management display as you see fit.

Please note that the auto-refresh feature should only be used for reports that do not have any parameters defined. Otherwise, the Crystal Reports viewer will prompt you for new parameter values each time the auto-refresh occurs.

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**Enhancements in EPICS V8.4.0 thru 8.4.6**

Since the release of version 8.4.0 last September, six minor releases have been issued as well. These minor releases, indicated by the last digit of the version number (8.4.6), either add new functionality to EPICS or correct a problem. Your currently installed version number is shown in the EPICS title bar.



Below is a listing of the changes made in the minor releases with a brief explanation. All revisions can always be seen in EPICS by selecting "Revision History" from the Help menu.

Data input issues with the **Advanced Data Collection** screen have been addressed. In some cases detail lines were allowed to be duplicated. Safeguards have been put in place to prevent this. There had been a problem the date, shift and start-time. This has been corrected. Also corrected is the piece calculation when pulling pieces from a Cutback department.

New enhancements to Advanced Data Collection include the following:

- So that scrap and rework may be easily distinguished, rework entries are now highlighted in cyan and scrap entries are highlighted in yellow.
- Scrap, rework and downtime code descriptions are no accessible via right-click while in View mode.
- On-screen data now refreshes when Change mode is selected

A *top-rated wishlist item* has been added to the **Press Scheduling** screen. When a line on the schedule is selected, the entire line is now highlighted. The entire line is now easily tracked by the scheduler when scrolling about the screen. Also, when items are added to the schedule they appear in the same order that they were at the bottom of the screen.

A change was made to eliminate an error that occurred when dies with no active copies where scheduled. A warning is now displayed: "Warning! There are no Die Copies available for Die \_\_\_\_\_. Do you want to schedule this die anyway?"

The **Quotation Module** now allows the viewing of drawings for Quote Dies.

Two changes were made to how the module handles prices. All prices are now copied to the part when a new part is created. There had been some cases in which DieType and Cavity price adders were not being included in the price lookup. This has been corrected.

Another *top-rated wishlist item* has been added to the **Backlog** screen. Jobs that are on hold are now highlighted. The type of hold is also displayed. The entire screen has been re-designed to allow the viewing of more data.

Week	Pounds	Pieces	SO	Item	Customer	Die	Credit Hold	Plant Hold
<b>Grand Total</b>		<b>8,388,430</b>						
Total 9/17/2005	5,571							
9/17/2005	1,112	25	10021	2 Williamson Windows		11010	ACK	
9/17/2005	1,404	150	10022	2 WestTex Dust Screens		11020		4444
9/17/2005	403	13	10023	2 Acme Products		11030		
9/17/2005	2,652	86	10023	1 Acme Products		11030	SHIP	

**New Backlog Screen Design**

In **Rack Tracking**, if a department is categorized as "NON-PRODUCTION", that department will not be used in determining the Next or the Previous department in the rack's routing. This allows a department to be included in the routing of a sales order but excludes that department in routing the racks.

Another change is in how EPICS handles the STOCK department in routing racks. The STOCK department is ignored, for the purposes of rack tracking, except in the case where it is the last department in the routing. This allows overruns to be posted at any point without affecting rack tracking.

A new **Department Category** has been added. The new "STOCK CUTBACK" category allows the creation of a special Cutback department. Normally, for job that includes CUTBACK in the routing, the workorder is calculated to produce the best extrusion length for the cutback job. However, if metal is pulled from

stock and sent to a cutback department, it is not necessary to optimize the extrusion length for cutback. Use STOCK CUTBACK for jobs that will be cutback using metal pulled from stock. Sales orders routed through a STOCK CUTBACK department will not affect the workorder calculation.

Other corrections include the following:

- Fix right-click lookup of SupplierNum on **Supplier Maintenance** screen.
- Eliminate error when an invalid start or stop time is entered at **Packing**.
- Eliminate error when opening **Post Shipments** screen while another screen is maximized.
- Fix **Password** validation problem.

Other enhancements include the following:

- Allow multiple instances of **Billet**, **BilletPO** and **BilletHist** screens to be open at the same time.
- Display local and network EPICS folder names on the About EPICS screen.

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## New Foy Building Under Construction

Foy Inc is in the process of building a new office building. The new facility is only a block from the current headquarters, and is located on the newly-constructed Farmersville Parkway.

The foundation is now complete, and framing is underway. The General Contractor for the project is Jimmy Foley Construction – many of you have met Jimmy (Stacy's husband) at EPICS User Conferences.

The Foy Building will include a new Training/Conference Room, with space for twelve or more trainees.

The 5000 square foot building should be finished in March, so we hope to have pictures of the completed structure in our next newsletter.

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## EPICS On-Line Knowledgebase Continues to Grow

The EPICS Knowledgebase that was announced in the September newsletter continues to expand. Chris has been adding more and more questions and answers to this important

database. If you cannot find the answer to your question in the extensive EPICS Help file, your next step should be to check the Knowledgebase.

You will find the Knowledgebase at [www.foyinc.com](http://www.foyinc.com).

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## EPICS Training Scheduled

The new EPICS user training schedule has been set, and is available on the web at [www.foyinc.com](http://www.foyinc.com). The training classes run from Monday thru Thursday, and cover a complete walkthrough of the EPICS system, as well as key system administration and report design topics. If you have new employees who will be using EPICS, one of these training sessions would be ideal for them.

More details and the complete schedule can be found in the Training section of the [Foy Inc website](#).

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## EPICS Customer List

**On any given day  
EPICS is helping over 11,000 people  
at over 80 extrusion plants around the world.**



Aluminio de Baja California (ABC) – Tijuana, Mexico  
 Aluminio de Centro America (ALDECA) – San Salvador, El Salvador  
 Aluminio Del Caribe– San Juan, Puerto Rico  
 Aluminum Extrusions Inc – Senatobia, Miss.  
 APEL Extrusions Ltd. – Calgary, Alberta  
 Arch Aluminum – Miami, Florida  
 Astro Shapes – Struthers, Ohio  
 Atlantic Aluminum – Lumber Bridge, N. Carolina  
 Benada Aluminum – Medley, Florida  
 Bristol Aluminum – Levittown, Pennsylvania  
 Briteline Extrusions – Summerville, S. Carolina  
 BRT Extrusions – Niles, Ohio  
 CanArt – Brampton, Ontario  
 CanArt – Tecumseh, Ontario  
 Central Aluminum – Columbus, Ohio  
 Crane Aluminium Extrusions – Angaston, Australia  
 Crane Aluminium Extrusions (Capral) – Penrith, Australia  
 Crown Extrusions, Chaska, Minnesota  
 Crystal Extrusion Systems – Union, Missouri  
 D.W. Aluminum – Cassopolis, Michigan  
 Empire Resources – Baltimore, Maryland  
 Extrudex – Weston, Ontario  
 Extrudex – Bernières, Quebec

Aacoa Extrusions – Niles, Michigan  
 American Aluminum Extrusions of Ohio – Canton, Ohio  
 American Aluminum Extrusions of Wisconsin – Beloit, Wisconsin  
 Aerolite Extrusion – Youngstown, Ohio  
 Almag Aluminum Inc. – Brampton, Ontario  
 Altec (Alumnitec). – Jeffersonville, Indiana



Extrudex – North Jackson, Ohio  
 FISA – Guayaquil, Ecuador  
 Frontier Aluminum – Corona, California  
 Hulett–Hydro Alum. – Pietermaritzburg, South Africa  
 Hulett–Hydro Alum. – Capetown, South Africa  
 Hulett–Hydro Alum. – Olifantsfontein, South Africa  
 Indalex West Inc– Watsonville, California  
 Independent Extrusions (INEX) – Hamilton, New Zealand  
 International Extrusion – Alhambra, California  
 International Extrusion – Waxahachie, Texas  
 International Extrusions – Garden City, Michigan  
 Jalex – Kingston, Jamaica  
 Keymark Corporation – Fonda, New York  
 Keymark Corporation – Lakeland, Florida  
 MI Metals, Inc - Smyrna, Tennessee  
 MI Metals, Inc – Millersburg, Pennsylvania  
 MI Metals, Inc – Oldsmar, Florida  
 MI Metals, Inc – Millen, Georgia  
 MI Metals, Inc – Prescott Valley, Arizona  
 Mid–America Extrusions – Indianapolis, Indiana  
 Midwest Aluminum – Withee, Wisconsin  
 Non-Ferrous Extrusion – Houston, Texas  
 Patrick Metals – Mishawaka, Indiana  
 Pennex – Wellsville, Pennsylvania  
 Perfiles de Aluminio.– San Juan, Puerto Rico  
 Pries Enterprises – Independence, Iowa  
 PT Alumindo Perkasa – Jakarta, Indonesia

PT Indal – Surabaya, Indonesia  
 Profab Industries – Canfield, Ohio  
 Profile Extrusions – Rome, Georgia



Profile (RJS Precision Ext.) – Phoenix, Arizona  
 Selaco Aluminium – Johar, Malaysia  
 Service Center Metals – Prince George, Virginia  
 Sierra Aluminum – Fontana, California  
 Sierra Aluminum – Riverside, California  
 Specialty Extrusion – Fullerton, California  
 Spectra Aluminum – Woodbridge, Ontario  
 Star Extruded Shapes, Canfield, Ohio  
 Superior Extrusion – Gwinn, Michigan  
 Sun Valley Extrusions – Los Angeles, California  
 Taber Extrusions – Gulfport, Mississippi  
 Taber Extrusions – Russellville, Arkansas  
 TAI-AO Aluminium – Taishan, Guang Dong, China  
 Tri–City Extrusion – Bristol, Tennessee  
 Temroc Metals – Hamel, Minnesota  
 Tubelite – Reed City, Michigan  
 Vista Wall Arch. Products – Midway, Tennessee  
 Vista Wall Arch. Products – Terrell, Texas  
 Vitex – Franklin, New Hampshire  
 Wakefield Engineering – Pelham, New Hampshire  
 Western Extrusion – Carrolton, Texas  
 Zarbana Industries – Columbiana, Ohio

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Help	<a href="mailto:help@foyinc.com">help@foyinc.com</a>

To stop receiving EPICS-related email, send a blank email to [unsubscribe@foyinc.com](mailto:unsubscribe@foyinc.com)