

Lean MAX

User's Manual

Version 2016

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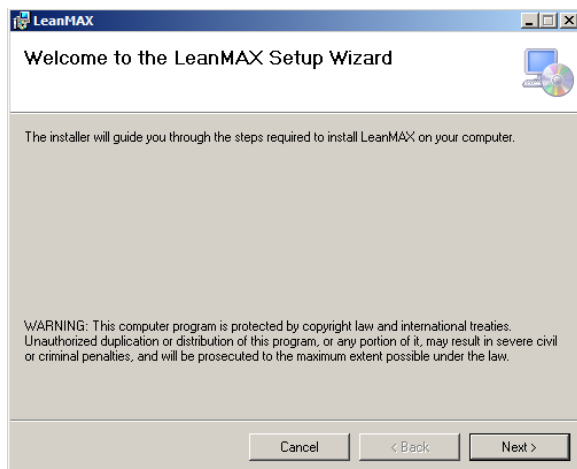
Reports: 17

Purpose: LeanMax provides tools for extending MAX to enhance and combine functions which are available in MAX.

Requirements:

- The SQL server name has to be the same name used to create the license hash.
- We need to have 2 DLL's copied from MAX client folder into the application folder. The application tries to copy them if missing or old but sometimes is prevented and they will need to be manually copied:
 - C:\exact\rmclient\efw\ERMRemCl.dll
 - C:\exact\rmclient\efw\ EXACTRMEnc.dll
- Make sure the MAX client runs on same PC. If MAX has an issue the application will also.
- Sometimes 2 MAX DLL's need to be registered:
 - C:\exact\rmclient\efw\EXACTRMDEV.DLL
 - C:\exact\rmclient\efw\MAXUPDATEXML.DLL
- The user referenced in the Data Settings needs read access to the EXACTMAX database but does not need any further rights to individual company databases.
- DotNet Framework version 4(Full) or newer

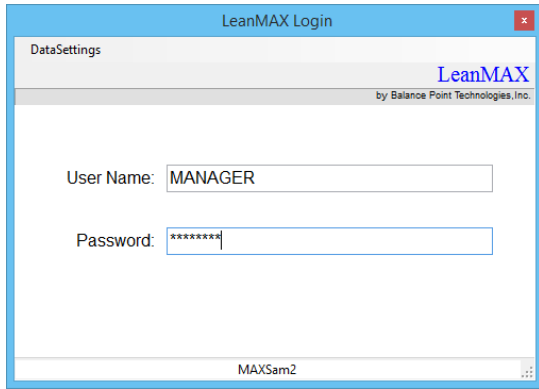
Installation:



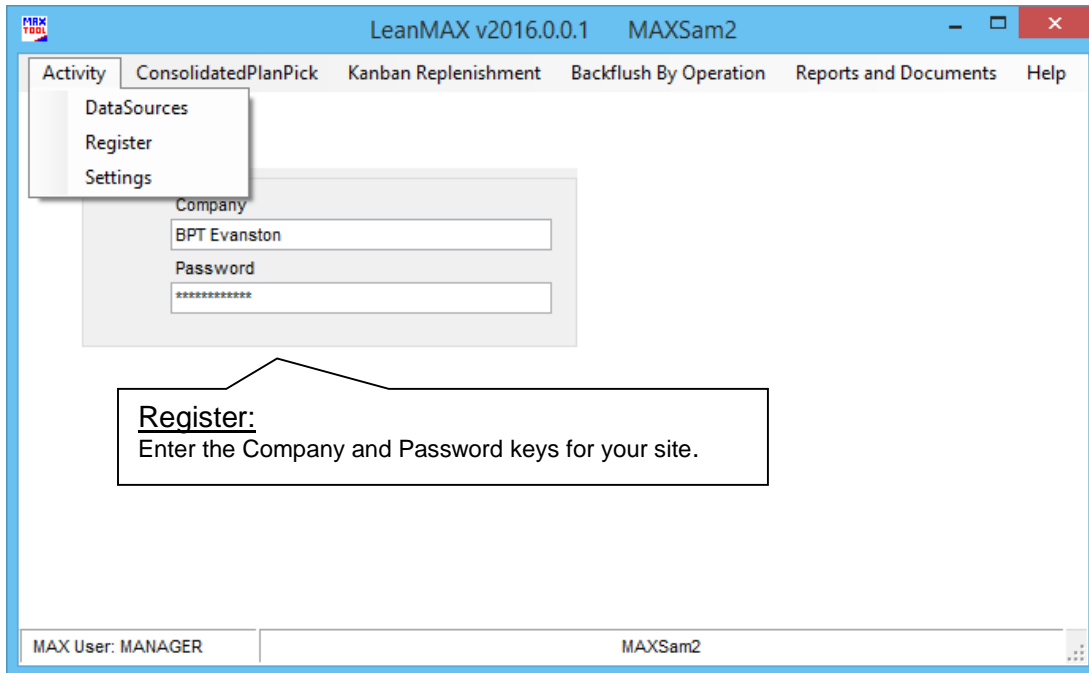
Install by running InstallLeanMAX.EXE and follow the prompts.

Login:

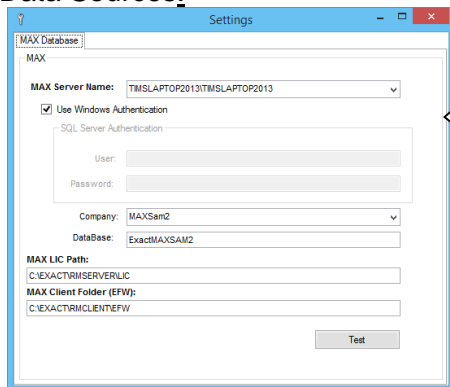
The user and password will be verified with the MAX Security table and requires the user to have a supervisor level in the MRP module.



Main Menu:

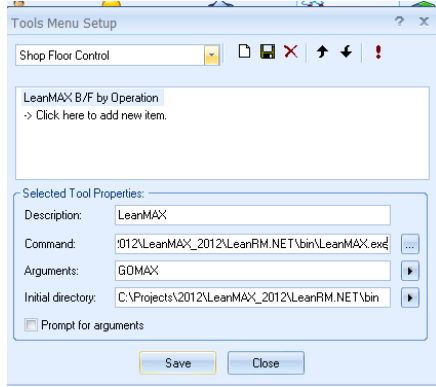


Data Sources:



1. Max Server
2. Windows or SQL Authentication
3. Company Name (will fill in the database name automatically)
4. MAX License path
5. Max Client Path

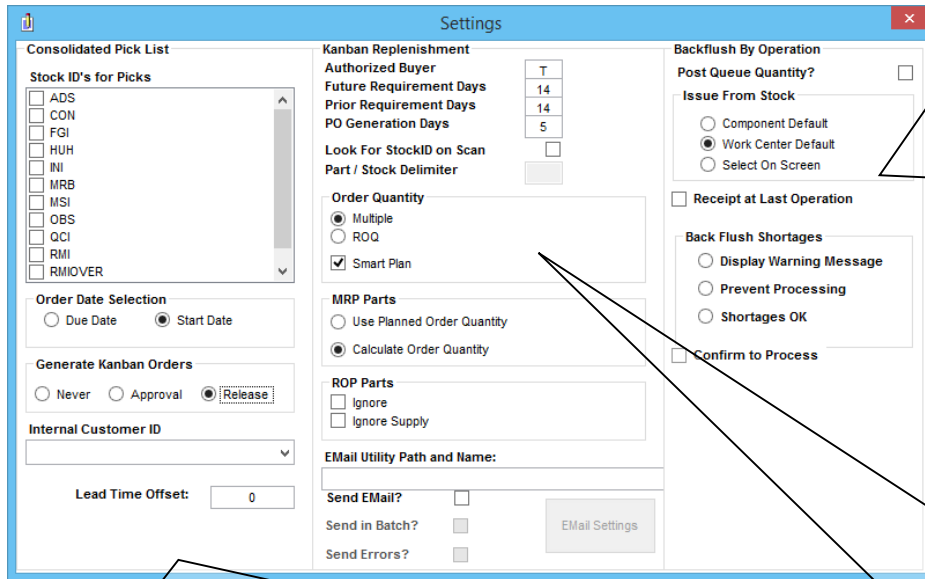
MAX Tools Shortcut:



Enter "GOMAX" as an argument to bypass the Login screen.

Settings:

This form is used to select switches and parameters. These switches are stored in the MAX database.



- Back Flush by Operation:**
1. Update the Job Progress Queue quantity.
 2. Select default issue from location.
 3. Receipt at last Op
 4. Shortage options
 5. Confirm to Process – show a process button

- KanBan:**
1. Authorized Buyer – partial match allowed.
 2. Due Past / Prior – date horizon.
 3. PO Generation Days - if an existing PO is found within this time frame it will be added to.
 4. Look For Stock ID on Scan – scan contains both part and stock ID separated by a delimiter.

Stock ID's for Picks: this Stock ID's selected here determine which orders are selected in the Pick process. Only Orders with requirements having a default Stock ID on this list will display. Selected Stock ID's have UDFKEY_05 set to ".cp".

Order Date Selection: determines the date sequence of the Planning Screens.

Generate Kanban Orders: select whether to generate Kanban type supply orders and at approval or release.

Internal Customer ID: Identify the internal customer ID to be used to cross reference Model with Part ID using the Customer Part Data table which is maintained as part of part sales.

ARSMsg: Can be downloaded separately from www.maxtoolkit.com is a Utility that is used to send emails

Email Setup:

1. Enter the SMTP server.
2. Enter the From display name and From Email address.
3. Enter the Internal Email address (for exceptions) – these are optional.
4. Enter CC addresses.
5. Enter Subject
6. Mail User and Password
7. Enter the Individual PO Crystal and attachment type.
8. Enter the Summary PO Crystal Name and attachment type.
9. The “Lean Turn Around” will be used to export an Excel file for turnaround as a ship document by the vendor. The default Crystal is: LeanMAXTurnAround.rpt and is installed within the \Reports folder.

ARMsg: Process

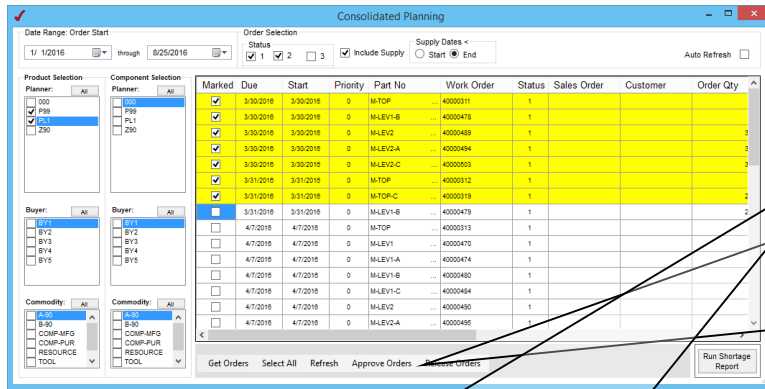
The main form can be used to send a simple email based on the selected Purchase Order. The Vendor's Email address is the default, but can be changed on the form.

The SendDay function is used to send the accumulated emails grouped by vendor.

As a scheduled function use ARSMMSG.EXE SENDDAY in the command line.

Consolidated Plan and Pick:

Planning Function:



A right click on any line will display the requirements detail related to the work order.

Part ID	DefStk	Qty Per	IssQty	DueQty	On Hand
12100	MSI	1	0	100	1196.01
13000	RMI	1	0	100	2309
13100	RMI	1	0	100	1361
13990	MSI	2	0	200	98
HITOPPER		1	0	100	0

A right click on the requirements tab will show all other requirements for the same component.

Priority	Order	Parent	DueDate	ReqQty	SD
0	3000011	11000	7/6/2006	200	
0	5000005	11000	7/6/2006	200	
0	5000011	11000	9/5/2006	200	
0	5000011	11000	8/21/2006	199	
0	5000011	11000	8/11/2006	200	
0	5000011	11000	8/11/2006	200	
0	5000011	11000	7/27/2006	200	
0	5000006	11000	7/19/2006	200	
0	5000006	11000	7/19/2006	200	
0	5000005	11000	7/19/2006	200	
0	5000012	11000	9/7/2006	200	
1	3000000	11000	11/19/2003	75	200000560201
1	3000004	11000	9/9/2004	194	
3	3000000	11000	9/19/2002	97	
3	5000000	11000	12/16/2003	97	
3	5000002	11000	2/16/2004	97	
3	5000002	11000	2/16/2004	97	
3	5000002	11000	2/16/2004	97	
3	5000002	11000	3/4/2004	97	
3	5000002	11000	3/4/2004	97	
3	5000002	11000	3/4/2004	97	
3	5000003	11000	3/4/2004	97	

Date Range: can be set to use either the Order Due Date or the Order Start date which is defined as the due date less the part lead time. The date used is determined in the Settings Tab.

Product Selection: work orders with parts that match the 3 selection boxes are included. If none are selected the selection criteria for the box is empty, meaning there is no selection taking place for this parameter.

Component Selection: similar to Product except that the selection is based on the parts in the order requirement detail table. Only orders with match requirements will be selected.

Order Status: orders are selected based on their status codes (STATUS_10)

Include Supply: if selected the current on hand balances of component requirements are augmented by the total DUEQTY_10 of all supply orders with a STATUS_10 = "3" and CURDUE_10 <= the To Date on the form.

Buttons:

1. **Get Orders:** does the query to retrieve all the work orders which meet the selection criteria.
2. **Select All:** marks all the displayed orders. The first 4 characters of the REQUES_10 filed are set = ".cp." to indicate Marked. The corresponding Requirement details have their UDFKEY_11 set in the same way. Positions 8 -11 contain a Pick Quantity in the format "0000".
3. **Roll BackDue:** only is visible if Due Dates have been changed. This will undue the recent date changes. When the dates are changed ORGDUE_10 is set = CURDUE_10, CURDUE_10 is set to new date and VENID_10 is set = ".dc."
4. **Refresh:** sort and redisplay the current orders.
5. **Approve Orders:** promote marked orders from Status 1 to 2.
6. **Release Orders:** release marked approved orders setting their status codes to 3 and inserting the job progress data for each released order. Generated automatic replenishment orders for those parts which are short and have are under Kanban control.

Consolidated Shortage Report:

4/1/2016
2:27:40PM

Consolidated Shortage Report

Page 1 of 2

Supply Selected < 08/25/2016

DueDate	M-TOP	Cust ID	WorkOrder	Bal Due	DueQty
03/30/2016	M-TOP		40000311	7.00	7.00
03/31/2016	M-TOP		40000312	5.00	5.00
03/31/2016	M-TOP-C		40000319	23.00	23.00
03/30/2016	M-LEV2		40000489	39.00	39.00
03/30/2016	M-LEV2-A		40000494	39.00	39.00
03/30/2016	M-LEV2-C		40000503	39.00	39.00

Part Number	Component	Description	Qty OH	Pick Qty	Shortage
M-LEV2 40000489	13400	Microprocessor	0.00	39.00	-62
Anticipated Supply:					
Supply Order	DueDate	VendorID	VendorName	VendorPhone	Due Qty
70000009-01-01	10/24/2006	12:0/200	Hamilton Avnet	810-367-2000	4
40000489	13800	Printed Circuit Board	0.00	39.00	-39
M-LEV2-A 40000494	13400	Microprocessor	0.00	39.00	-101
Anticipated Supply:					
Supply Order	DueDate	VendorID	VendorName	VendorPhone	Due Qty
70000009-01-01	10/24/2006	12:0/200	Hamilton Avnet	810-367-2000	4
40000494	13800	Printed Circuit Board	0.00	39.00	-78

Current Page No.: 1 Total Page No.: 2 Zoom Factor: 100%

Consolidated Pick Function:

Dates Prior: Order Start
8/25/2016

Order Selection
Commodity: None

- A-90
- B-90
- COMP-MFG
- COMP-PUR
- RESOURCE
- TOOL
- VEND-SUPPLY

Stock ID: None

- ADS
- CON
- INI
- MRB
- MSI
- OBS
- QCI
- RMI
- RMI/OVER
- WIP

Marked	Due Date	Priority	Part No	Work Order	Sales Order	Customer	Order Qty	Bal Due	Comp Kits	Pick Qty
<input checked="" type="checkbox"/>	10/27/06	3	11000	30000001			3	2	2	
<input checked="" type="checkbox"/>	11/03/06	3	11000	30000004			20	19	19	
<input checked="" type="checkbox"/>	12/08/06	3	11000	30000005			15	14	14	
<input type="checkbox"/>	12/29/06	3	11000	50000002			2	2	0	
<input type="checkbox"/>	04/25/07	3	12300	50000006			2	2	2	
<input checked="" type="checkbox"/>	03/08/16	3	12100	50000007			100	100	100	
<input checked="" type="checkbox"/>	03/08/16	3	12200	50000008			100	100	100	
<input type="checkbox"/>	03/18/16	3	11000	50000009			1000	997	55	
<input type="checkbox"/>	03/23/16	3	M-TOP-A	50000010			33	33	0	
<input type="checkbox"/>	03/23/16	3	M-TOP-B	50000011			6	6	0	

Get Orders Select All CUTEPDF WRITER Run Consolidated Pick Report Issue Inventory

Orders are selected based on matching the checked models, and the checked Warehouse locations within the date range. Released orders will display.

Right click to see order requirements:

Requirements for 30000001 11000 Computer MAX

PartID	DefStk	Qty Per	IssQty	DueQty	TotReqs	OnHand	RelSupply	PlnSupply
12100	MSI		1					
13000	RMI							
13100	RMI							
13990	RMI		1					

Right click on component to see the other requirements:

Requirements for 30000001 11000 Computer MAX

Demand for: 12100

Priority	Order	Parent	DueDate	ReqQty	SO
0	30000001	11000	10/20/2006	2	
0	30000004	11000	10/27/2006	19	
0	30000005	11000	12/11/2006	14	
0	50000009	11000	3/11/2016	997	

Issue Inventory:

Consolidated Picking

Dates Prior: Order Start
4/23/2016

Order Selection
Commodity: None

- A-90
- B-90
- COMP-MFG
- COMP-PUR
- RESOURCE
- TOOL
- VEND-SUPPLY

Stock ID: None

- ADS
- CON
- NI
- MRB
- MSI
- OBS
- OCI
- RMI
- RMOVER
- WIP

Priority	Part No	Work Order	Sales Order	Customer	Order Qty	Bal Due	Comp Kits	Pick Qty	Planner	Buyer
3	11000	30000001			3	2	2	0	PL1	
3	11000	30000004			20	19	19	0	PL1	
3	11000	30000005			15	14	14	0	PL1	
3	11000	50000002			2	2	0	0	PL1	
3	12300	50000006			2	1	1	0	PL1	
3	12100	50000007			100	99	99	0	PL1	
3	12200	50000008			100	99	99	0	PL1	
3	11000	50000009			1000	997	56	0	PL1	
3	11000	50000017			100	100	0	0	PL1	
3	12100	50000018			100	100	100	0	PL1	
3	L1	50000016			3	3	0	3	Z90	
3	L1	50000019			100	100	100	3	Z90	

Get Orders Select All CutePDF Writer Label Printer Run Consolidated Pick Report Issue Inventory

Labels and or Detailed Work Order BOM:

LeanMAX

Do you want Detailed Work Order BOM report?

Yes No

Lot/Serial selection:

Consolidated Issue Lot/Serial Components

Work Order: 50000019

Component: L2 LOT TESTER

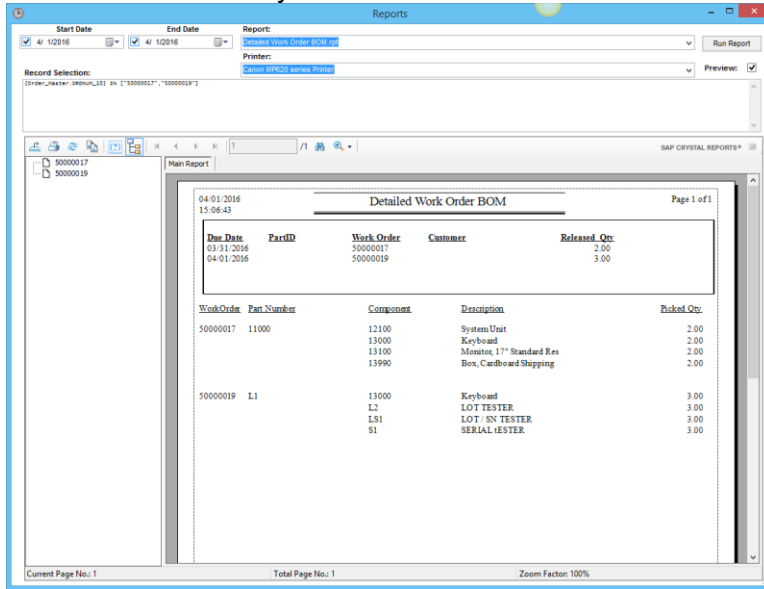
Stock ID: MSI

Required: 3 Picked: 3

Issue

Lot	Quantity	IssueQty	ExpDate
L60	174.00	3.00	
L50	224.00	0.00	
L10	499.00	0.00	
L20	600.00	0.00	
L30	700.00	0.00	
L40	800.00	0.00	

Work Order Summary:



Consolidated PickList:

04/01/2016 15:40:40 **CONSOLIDATED PICK LIST REPORT** Page 1 of 1

Work Order	PartID	Customer	Est Due	Pick Qty	Due Date
50000004	11000		2.00	0.00	11/9/2006 12/1
50000005	11000		12.00	0.00	12/9/2006 12/1
50000002	11000		2.00	0.00	12/20/2006 12
50000006	12300		2.00	0.00	4/25/2007 12/1
50000007	12100		100.00	0.00	3/9/2016 12/0
50000008	12300		100.00	0.00	3/9/2016 12/0
50000009	11000		996.00	0.00	3/18/2016 12/1
50000016	L1		3.00	3.00	3/25/2016 12/1
50000017	11000		100.00	0.00	3/21/2016 12/1
50000019	L1		100.00	0.00	4/1/2016 12/0

Picked By: _____
Received By: _____

Stock Loc.	Component	Description	Qty. On H	Pick Qty	Picked
MS1	12100	System Unit	4,954.00	0.00	
	12200	Cabinet	1,012.00	0.00	
	12300	Monitor Board	3,458.00	0.00	
	13000	Keyboard	2,003.00	0.00	
	L2	LOT TESTER	2,994.00	0.00	
	LS1	LOT IN TESTER	99.00	0.00	
	S1	SERIAL TESTER	99.00	0.00	
MS1	13100	Monitor, 17" Standard Res	89.00	0.00	
	13210	Hard Drive, 4 GB	5,685.00	0.00	
	13400	Microprocessor	15.00	0.00	
	13500	Mouse, 1000, 125"	376.00	0.00	
	13700	Memory 32 MB SDRAM	7.00	0.00	
	13800	Printed Circuit Board	5.00	0.00	
	13900	Resistor, 100 Ohm	173.00	0.00	
	13990	Box, Cardboard Shipping	3,447.00	0.00	

Component Labels: printed after issues are processed.

Seagate Crystal Reports - ConPickLabels.rpt

ConPickLabels.rpt

Part No.	Part No.	Part No.
26-0517-001	29-001727-00	50-0126-001
LBL:IX300.ITRONIXLARGE	IX300.HARNES.S,WLAN	IX300.PWR SUP.20V.60W
Qty.: 11	Qty.: 11	Qty.: 11
3/26/04	3/26/04	3/26/04

Records: 46

Kanban Replenishment:

Part Information						
13100						
Part Description						
Monitor, 17" Standard Res						
Part Notes						
Vendor						
V200 Hamilton Avnet						
Lead Time	10	On Hand	89	EA	Buyer	T45
Manufacturer						
Supply Information						
Net Available	-1041	Next Scheduled Receipt				
Pur UOM	EA	V200	700000160101	04/15/16	1041	
Conversion	1					
On Hand Locations		Status				
RMI	89	70000016-01-01 was entered with V200.				

The only user input is the part and an optional deliver to stock ID.

If the part is an authorized Kanban part and matches the criteria to be order and new line item will be added to an existing Kanban purchase order if one exists or if none exists a new purchase order will be created.

An email can be sent immediately to vendor or a comprehensive email can be sent showing everything ordered for the day or since last sent.

PO Created Email to Vendor:

From: BPT Overflow
Date: Thursday, December 04, 2003 11:26 AM
To: 2@bptechnologies.com
Subject: ARS Purchase Release from Citronics 12/4/2003
Attach: 7000090901-112246.TXT (31 bytes)

SAMPLE COMPANY Purchase Order 12/4/2003 11:22:46
SHIPPING ADDRESS

PO	PART	QUANTITY	DUEDATE
7000090901	13000 Keyboard	500	12/14/2003

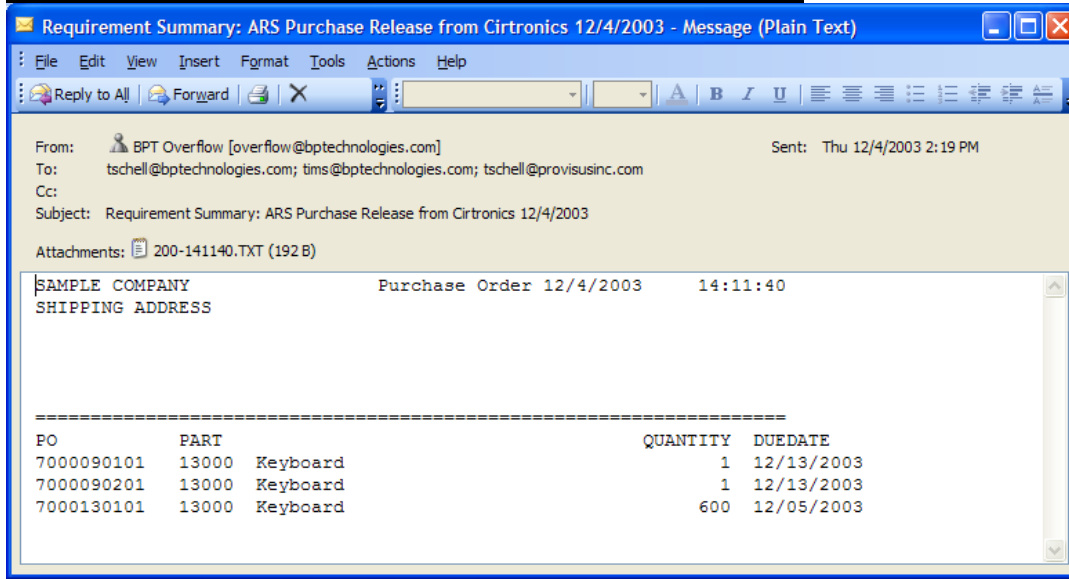
Attachment:

7000090901,13000,Keyboard,500,12/14/2003

Kanban scanned in Error Internal Email:



Vendor Summary Emailed to Vendor and to Internal Address:



Summary Attachment:

7000090101,13000,Keyboard,1,12/13/2003
7000090201,13000,Keyboard,1,12/13/2003
7000130101,13000, Keyboard,600,12/05/2003

Back Flush By Operation

PickPro: Used to maintain BOM and Routing relationship for issuing components by operation.

Part ID 11000 **BOM Effective Date** 4/1/2016 **Include Part Types** BOM A B C D M O X Y **See Structure** 4

Routing

Op Seq	WorkCenter	Operation	OpType
0010	EASSY	Assemble Per Pri...	U
0020	BURN	24 Hour Burn-In ...	B
0030	FINQA	Final Inspection ...	U
0040	PACK	Pack and Ship ...	U

BOM

Component	Description	Qty Per	Pick Qty
12100	System Unit ...	1	1
13000	Keyboard ...	1	1
13100	Monitor, 17" Stan...	1	1
13990	Box, Cardboard ...	1	1

Pick List

Op Seq	Component	QtyPer
0011	12100 ...	1
0012	13000 ...	1

BPT\TimSchell MAX: (Exact MAX Sample Company)

Assign Stock Issue From to Work Centers:

Work Center Issue From

W/C	Stock ID	Description
AULTIN	WIP	WIP Floor Locations
BTTEST		N/A
BURN		N/A
EASSY	RMI	Raw Material Inventory
ETEST	RMI	Raw Material Inventory
FINQA	RMI	Raw Material Inventory
HEAT	QCI	Quality Control Inventory
IPQA	MSI	Main Stores Inventory
MANNI		N/A
MASSY		N/A
MILL		N/A
PACK		N/A
PAINT		N/A
PLATE		N/A
PRESS		N/A
PROTC		N/A
REVWRI		N/A
RWDR		N/A
SAW		N/A
WASH	RMI	Raw Material Inventory

When a Part is selected the related single level exploded BOM (accounting for phantoms and pseudos) and Routing will display. When a particular Routing step is highlighted the Pick instructions which follow the selected operation will be displayed below.

Pick entries are added by right-clicking on the component in the BOM frame and dragging over to the Pick List frame. Double clicking on the component will also move the component to the Pick

List.To delete, reverse this move or change the quantity per to zero. Pick quantities can be changed to any quantity up to the total required quantity for that component.

Please note: this application allows you to enter the same part more than once within a routing and allows the quantity to be different than the required quantity on a given pick entry.

Synchronize Pick Work Centers: will audit the Pick operations to make sure the referenced Work center equals the linked to operation's work center.

Clear: will delete all of the Pick entries for a given operation.

Re Sequence: will renumber the Pick Entries.

Audit: will provide a quick quantity audit for a given part by comparing the BOM to the Pick entries. This can be sent directly to the printer (default) or viewed on-line.

□

The screenshot shows a Notepad window with the following content:

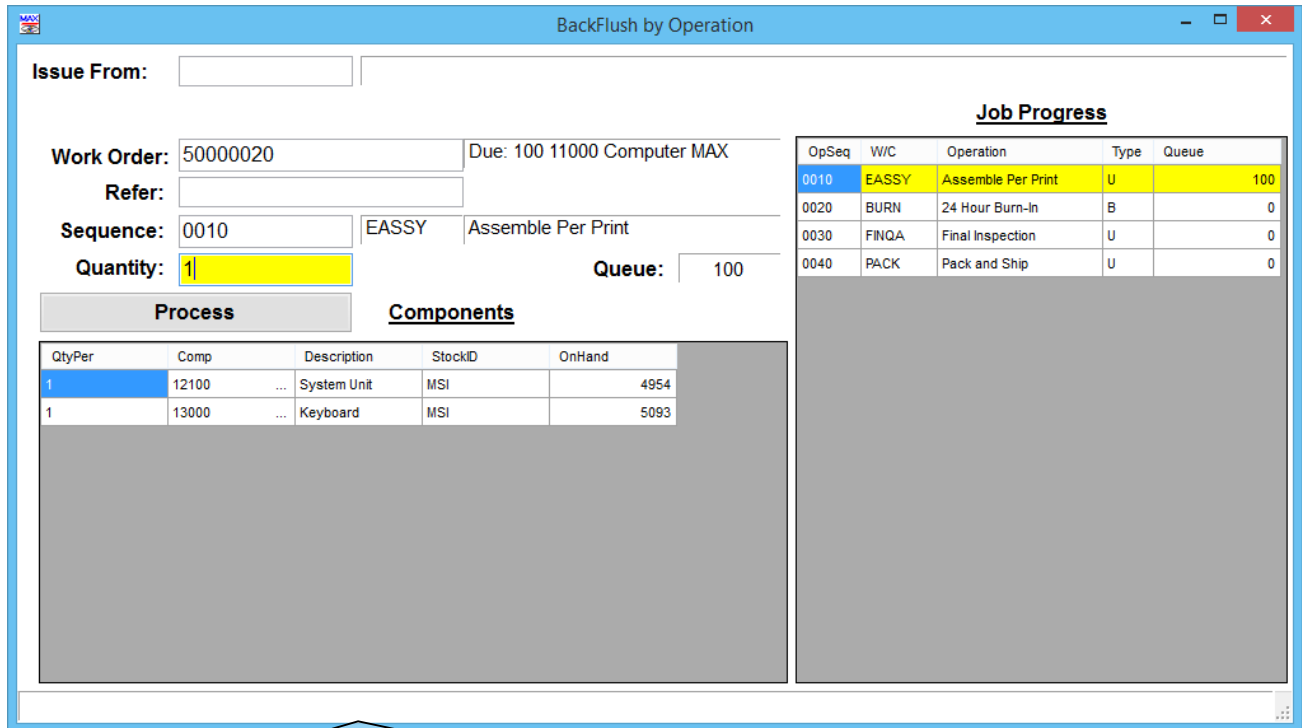
5/2/01 PickPro Audit: 11000 COMPUTER Page 1

OpSeq	Description	Part	Qty
0010	GET THE THING STARTED		
0018	Pick:	13990	Box, Cardboard Shipping .50
0019	Pick:	12200	Cabinet 2.00
0020	24 Hour Burn-In		
0022	Pick:	13100	Monitor, 17" Standard Res 1.00
0023	Pick:	13000	Keyboard 1.00
0030	FIX TO STUB		
0032	Pick:	HUH	TEST OH .50
0033	Pick:	13100	Monitor, 17" Standard Res 1.00
0034	Pick:	12300	Mother Board 2.00
0050			
0054	Pick:	12200	Cabinet 1.00
0056	Pick:	13000	Keyboard 2.00
0057	Pick:	13210	Hard Drive, 4 GB 1.00
0058	Pick:	12300	Mother Board 2.00

5/2/01 PickPro Audit: 11000 COMPUTER Page 2

Component	Description	Qty_Required	Qty_Picked
12200	Cabinet	2.00	3.00 +
12300	Mother Board	2.00	4.00 +
13210	Hard Drive, 4 GB	2.00	1.00 -
13000	Keyboard	10.00	3.00 -
13100	Monitor, 17" Standard Res	1.00	2.00 +
13990	Box, Cardboard Shipping	1.00	.50 -
HUH	TEST OH	1.00	.50 -
		.00	.00
		.00	.00

Post Operation with Component Issues:



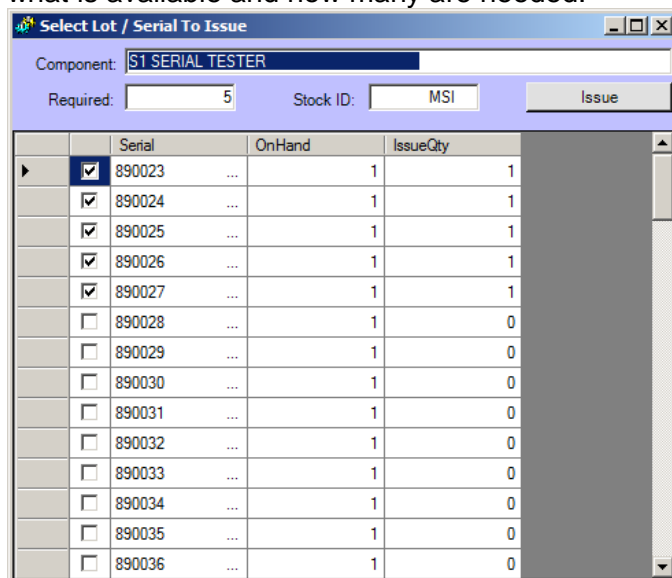
Issue From: will default based on the LeanMAX settings to be either the individual component default Stock ID, the Stock ID associated with the Work center (see below) or an entered Stock ID which overrides the defaults.

Work Order: open work order

Sequence: open operation

Quantity: quantity to back flush and/or post operation completion.

Lot or Serial control components will display for selection with a default selection made based on what is available and how many are needed.



Reports:

can be run as needed from the Crystal reports saved in the \Reports folder.

The screenshot shows the 'Reports' window in Crystal Reports. At the top, there are fields for 'Start Date' and 'End Date', both set to '4/ 1/2016'. A 'Report:' dropdown menu is open, showing a list of reports including 'ConPickOrderReqDetails.rpt', 'ARSPOP.rpt', 'ConPickLabels.rpt', 'ConPickList.rpt', 'ConPickPlanAllocationDetails.rpt', 'ConPickReqDetails.rpt', 'ConPickShortages.rpt', 'ConPickShortagesBKUP.rpt', 'ConPickShortages_1.rpt', 'ConPickShortages_2.rpt', 'Detailed Work Order BOM.rpt', 'KanbanLabels.rpt', 'KanbanLabelsByPartStock.rpt', 'LeanMAXTurnAround.rpt', and 'Requirement Allocation Lister.rpt'. The 'ConPickOrderReqDetails.rpt' report is selected. To the right of the dropdown is a 'Run Report' button and a 'Preview:' checkbox which is checked. Below the dropdown is a 'Record Selection' field containing a filter: '{CUSTOM_BPT_LEANRM_MSSUM.SELECTED} = 1 AND {CUSTOM_BPT...'. On the left side, there is a file explorer showing a list of folders: 40000313, 40000470, 40000474, 40000479, 40000480, and 40000494. The main preview area shows the report content for '4/1/2016' at '5:01:22PM'. The report title is 'Selected Consolidated Pick Work Orders Requirement D'. The report contains a table with the following data:

<u>WORKORDER</u>	<u>PRNUM</u>	<u>STOCKID</u>	<u>PRIORITY</u>	<u>DUEDATE</u>	<u>QTYPER</u>	<u>ALLOCA</u>
40000313	M-LEV1	MSI	0	04/07/2016	1.00	
40000313	M-LEV1-A	MSI	0	04/07/2016	1.00	
40000313	M-LEV1-B	MSI	0	04/07/2016	1.00	
40000313	M-LEV1-C	MSI	0	04/07/2016	1.00	
<hr/>						
40000470	13000	MSI	0	04/07/2016	1.00	
40000470	13500	RMI	0	04/07/2016	1.00	
40000470	M-LEV2	MSI	0	04/07/2016	1.00	
<hr/>						
40000474	M-LEV2-A	MSI	0	04/07/2016	1.00	

At the bottom of the window, it shows 'Current Page No.: 1', 'Total Page No.: 1', and 'Zoom Factor: 100%'.