



Predator DNC™ v4.0 – What's New

Latest features and benefits in v4.0

Before Installing v4.0

Microsoft Internet Explorer v5.x or later is required to be installed before installing Predator DNC v4.0. To simplify this requirement, we have included IE v5.5 as part of the installation processes.

NOTE: Existing customers who have both DNC v3.2 and MDC v1.3 are not required to upgrade to a new version of MDC before upgrading to DNC v4.0.

Backup everything; especially your PXP or PSF file. Running v4.0 will upgrade the files from v3.2 to v4.0 and it will no longer be compatible with v3.2. Predator DNC will always be forwards compatible.

Why v4.0?

By design, this release was intended to showcase the release of our all-new v6.0 Predator CNC Editor. Along the way we ended up adding several new features and improvements to Predator DNC focused on new hardware support. Details of the major new features are explained throughout this document.

Installing v4.0

One of the biggest changes is a new installation process based on Microsoft's Install Services. This technology was introduced in Windows 2000. If you are running Windows 98 or NT v4.0, and Microsoft's Install Services has never been installed, v4.0 will do this automatically at the very beginning. This will require a re-boot prior to completing the installation of Predator DNC.

By default installation occurs in the \program files\predator software\dnc 4.0\ directory. If you were running v3.2 or earlier, please un-install it prior to installing v4.0.

NOTE: We have dropped supporting floppy drive or diskette based installs. All installations must be performed from a hard drive, CD, CDR, CDRW or DVD drive.

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New! Allen Bradley SLC 50x Ethernet Object

V4.0 has added all new direct support for Ethernet connection to Allen Bradley SLC 500 series PLCs. The 505 series has Ethernet built in while the other models can add Ethernet modules as necessary. Predator DNC supports data transfer of register specific values and appropriate ladder logic must be running on the PLC to process the specific register details. Predator DNC supports multiple devices running from a single PLC with the appropriate ladder logic. Each connected device counts as a port within the Predator license. For example, a customer has 4 stations in an assembly line running from a single PLC; a Predator DNC/4 would be required. In addition a hybrid of CNC and PLCs can be running from a single license of Predator DNC. For example, a customer has 4 CNCs and 4 assembly stations running from a single PLC, a Predator DNC/8 would be required. Support for up to 256 PLCs per PC is now available within Predator DNC. Since the Allen Bradley SLC Ethernet object is a terminator, any of the other objects such as Send/Receive Translate, Search and Replace, CR/LF, VB etc can be combined to interface to wide range of shop floor applications. This object can be used with Predator MDC for high-speed data collection. A recently completed benchmark with Predator MDC/16 successfully processed two-second cycle times from 10 PLCs simultaneously with minimal PC processor load. Direct support for Allen Bradley PLCs opens up a whole new world of opportunities. Contact your local Predator reseller or Predator Software to discuss your application.

NOTE: Allen Bradley PLC support is an extra cost option; please contact an authorized Predator reseller for pricing details.

NOTE: Predator's support for the Allen Bradley PLC does not require a RSLINK software license or an OPC server.

New! Slow Start/Cancel Option

An option for slow start/cancel has been added in the Options menu. This option should only be enabled if a DNC/64 or greater is licensed and the device drivers cannot handle large numbers of simultaneous start and cancel commands. This is a documented problem with Windows 2000 and Flex/N hubs. Customers upgrading their servers from Windows NT to 2000 or XP should be aware that enabling this option might be required. When enabled the Start All and Cancel All commands will take much longer to finish based on the number of machines. To always enable this option select Save Layout from the File menu.

New! Dual Processor Support

V4.0 of Predator DNC supports dual processor style PCs and has been tested with systems from Dell, Compaq, HP and IBM.

New! Directory Selection

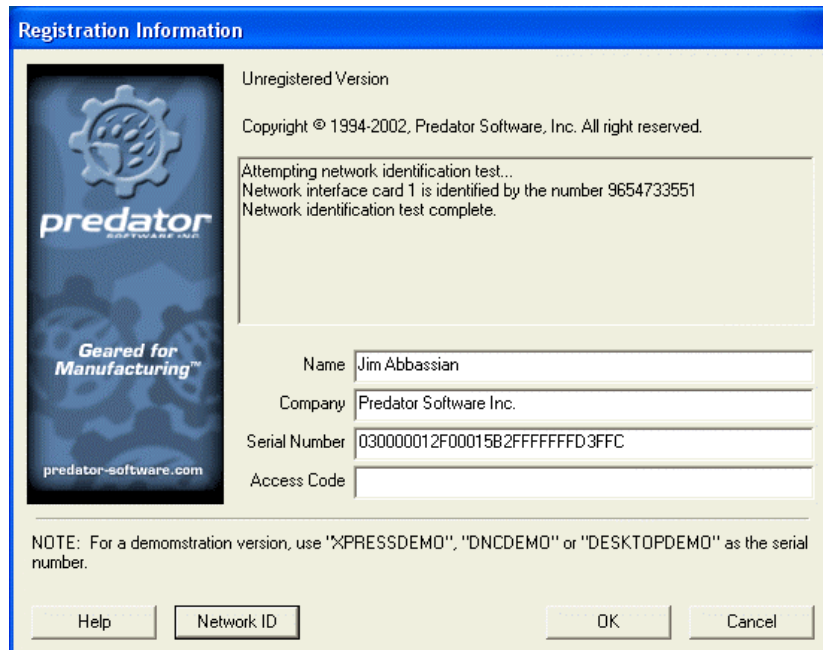
A new directory selection dialog has been added with improved support for network shares and UNC folders.

New! Temporary Licensing

An all-new option for temporary licensing via a network card is now available. Support for multiple network cards within a single PC and multiple products via a network card license is also standard. Finally, support for a network card license and a SIM license on

the same PC is also available. Temporary licensing can be used for product evaluations, demos, pilots and SIM failures. Permanent licensing still requires a Predator SIM. To request a temporary license, select the Network ID button in the Upgrade dialog. Predator will display a 10-digit number for every network card installed on the PC. The 10-digit number can be emailed to sales@predator-software.com for processing. A reply with the appropriate serial number and access numbers will be sent.

NOTE: Token ring network cards are not supported.



Improved! Directory Shortcuts

Support for directory shortcuts with the file search option has been added. Although support for this feature was added in an earlier version of Predator DNC it was dropped in v3.2 to support wildcards. V4.0 of Predator DNC includes support for both directory shortcuts and wildcards with the file search option.

Improved! Multiple Commands

When multiple commands are enabled within a machine icon multiple commands can startup automatically. Previously only the first command started per machine.

Improved! Regex Command Object

Added support for the ENTER key within the regex command object.

Improved! Heidenhain DNC Object

An updated Heidenhain DNC object provides support for extended Heidenhain style filenames with newer Heidenhain CNC controls.

Improved! Okuma B Object

The Okuma B object has been improved with support for remote canceling. This object includes integrated support for remote request and is designed to run stand-alone.

Improved! File Management Object

The File Management object has been improved to support network shares. In addition a new browse dialog has been added to improved UNC, directory and network share selection. The File Management object has also been improved to support a configurable event type for selected files. Finally, a bug has been fixed when the File Management object is used when wait for CNC is enabled in the COM Port terminators.

Improved! Search and Replace Object

The Search and Replace object has been improved with support for variables. The following new variables are now available as replace options:

/Date	The current date
/FileDate	The file's modified date
/FileFull	The file's path and filename
/FileName	The file's filename
/FilePath	The file's directory or location
/FileSize	The file's size in bytes
/FileTime	The file's modified time
/Time	The current time
/User	The current user

Utilizing one or more of the above variables allows a wide range of version control and CNC program manipulation during the DNC process. In addition, the search and replace object has been improved to support "Other" style commands.

NOTE: When using the Search and Replace object within an "Other" style command it is important to position it as high as possible. For example, when using the Search and Replace object within a Remote Start command position it above the Remote Request object.

Improved! Multiple Commands

The multiple commands per machine feature has improved canceling all active Remote commands. The first remote command received will cancel all active remote commands while processing the appropriate Send to Machine command and then automatically return to remote. For example, enable multiple commands for a Mori Seiki machine. The first Remote command is serial based. The second Remote command is Ethernet based. A third Send to Machine command is serial based and utilizes the same COM port as the first Remote command. With v4.0 of Predator DNC and the above example, remote requests can be done from either serial or Ethernet. The only limit to the number of remote inputs is the number of port licenses purchased.

Improved! File and Sub Program Object

Sub program support has been enhanced to support faster communications, and high speed machining. New options for prefixes and suffixes allow greater compatibility with filename conventions and G code from a variety of CNC vendors. Finally an option to ignore 8000 or 9000 sub programs has also been added.

Improved! Live Folders

V4.0 of Predator DNC will now refresh sub directories in addition to filenames when the

F5 key is pressed or initially selected with the mouse.

Improved! Hand Held Terminal Object

A new checkbox option has been added to support using the VB script object with the Hand Held Terminal object.

Improved! Online Help

Updated online help reflects the improvements made in Predator DNC 4.0. In addition, several DNC objects have updated online help.

Bug Fix! Delete

Fixed a bug when deleting shortcut files or scheduled files. Disabled the Delete key within a live folder.

Bug Fix! Blinking Icons

Fixed a bug with blinking icons with multiple machines using the VB Script and Client/Server objects.

Bug Fix! Save Layout

Fixed a bug when opening a saved layout after changing the layout number.

Bug Fix! Right Mouse Menu

Fixed a rare right mouse menu bug.

For more information

For the latest information on Predator DNC, check our web site at
<http://www.shopfloorautomations.com>

(877) 611-5825 Toll Free

Shop Floor Automations, Inc.



Predator Desktop™ v4.0 – What's New

Latest features and benefits in v4.0

What's New in v4.0?

Predator Desktop includes all of the new DNC features outlined above including the all new Predator CNC Editor v6.0 along with the following Desktop features:

New! Run Schedule Command

V4.0 of Predator Desktop includes a new Run Schedule command. This command will sequentially process every scheduled file in order. Support for command specific operation is still available by selecting the command. The Run Schedule command can only be performed at the PC. Scheduled files with a status of On Hold or Completed will be skipped when processing a Run Schedule.

Improved! Predator Virtual CNC Viewer

The Predator Virtual CNC Viewer has been upgraded from v4.1 to v5.0 for details on what is new refer to the What's New in Predator Virtual CNC v5.0 document.

Bug Fixes! Scheduling

Canceling a scheduled file while it is processing will not increment the number of copies. Drag and dropping while the schedule is active has been disabled.