



Predator MDC™ v1.3 – What's New

Latest features and benefits in v1.3

Before Installing v1.3

Existing Predator MDC administrators must read the MDC Upgrade to 1.3 from v1.2 document before installing v1.3. There are few changes and your local Predator reseller should be consulted prior to upgrading.

Microsoft Internet Explorer v5.5 or later is required to be installed before installing Predator MDC v1.3. If Predator DNC or Desktop will be used with MDC v1.3 then v3.2x of Predator DNC or Desktop is required.

Backup everything; especially your Oracle space or Access MDB file. Running v1.3 will upgrade the data from v1.2 to v1.3 automatically and it will no longer be compatible with v1.2. Predator MDC will always upgrade the data forward but not backwards.

NOTE: v1.3 does not support Windows 95, existing users must upgrade to Windows 98, 2000, NT or XP.

Why v1.3?

By design, this release was intended to be a maintenance release to v1.2. Along the way we ended up adding a lot of features. Details of the new features are explained throughout this document and within the online help.

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Installing v1.3

By default, installation occurs in the \program files\predator software\mdc 1.3\ directory. If you were running v1.2 simply proceed with the installation normally. If you were running a beta version of 1.3, please un-install it prior to installing v1.3. MDC Administrator v1.3 will upgrade your data from v1.2 or any 1.3 beta to the final release automatically. If upgrading fails, confirm that read only flag is not set on the MDB file.

NOTE: Windows NT v4.0 service pack 4 or greater is required to be installed prior to installing Predator MDC v1.3

NOTE: Should installation fail, manual installation of the major components can be performed by reviewing the setupmdc.ini file and launching each component.

Network Installations of v1.3

By committing to store the product installation on a server, users will enjoy automatic healing of all critical files upon running Predator MDC. For example, a user accidentally deletes pmdc.exe. Under normal circumstances he would be down and the software would fail to run. With v1.3, when the user double clicks the desktop shortcut, all critical files are checked and if necessary restored from the network server and the software begins to run automatically.

To perform a network installation is to step through the following:

1. Copy the contents of the entire CD to a \predator cd\ or similar directory.
2. Run the setupmdc.exe from the \predator cd\ directory.

NOTE: Should any automatic healing be necessary, Predator MDC will be able to automatically extract the necessary files from the appropriate cab files stored in the \predator cd\ directory. If you install from an actual CD, Predator MDC will be forced to prompt for the CD.

What's New in v1.3?

New! Microsoft SQL Server Support

Support for Microsoft SQL Server has been added throughout Predator MDC. In addition, demo mode can also support SQL Server. Finally, SQL Server data collection objects have also been added for Predator DNC and Desktop.

Improved! HTML based Online Help

Updated HTML based, context sensitive, online help details the new features and changes made in v1.3 of Predator MDC. Refer to the What's New section for v1.3 specifics.

New! Automatic Summarization

V1.3 of Predator MDC automatically summarizes and processes collected data on the fly and eliminates the need to manually Summarize Information prior to running historical charts and reports. This requires that the latest v1.3 style MDC objects be used for data collection within Predator DNC or Desktop.

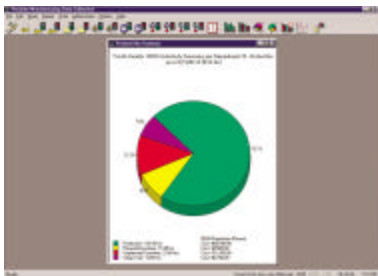
NOTE: Automatic summarization fixes the problems with manual summarization and eliminates the need for repetitive prompting. It also eliminates the need for Predator MDC to create data on the fly to maintain machine and user states.

New! Fix Collected Data

A new fix collected data command has been added to fix missing or incomplete data that has been collected from the shop floor. Data can be fixed, deleted or skipped. Skipping the data allows the user to double check with appropriate personnel or whatever and then come back and fix the missing or incomplete data later.

NOTE: Fix Collected Data has replaced the Summarize Information command.

Predator MDC



New! Delete Collected Data

A new option to delete collected data per machine has been added. Options allow only real-time, only summarized or both types of data to be deleted within a date range.

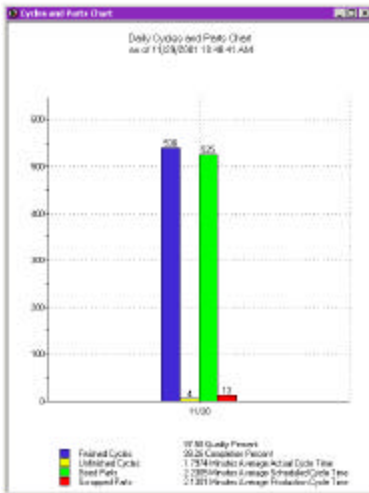
New! View Machine Status

A new view machine status has been added within Predator MDC to show the real-time status of any machine. Additional real-time details such as the current part number, number of good parts, scrapped parts, and downtime reasons can be updated every 5 seconds or any other user configurable interval. Drilling down to specific departments, locations or groups is also supported. An unlimited number of MDC clients can view machine status at the same time from anywhere on the corporate network.

Machine Status for All Machines						
Status	Machine	User	Part	Job	Downtime Code	
Cycling	10 - Fadal 4020B	jima - Jim Abbassian	Zd-11-02 - Z Series Driver	-	-	
Idle	11 - Haas VF-650	-	-	-	-	
Idle	12 - Mori Seiki SVD-503	-	Zd-13-05 - Bullet Driver Series	10-1235 - 50 Widgets for HP	-	
In Setup	14 - Bridgeport VMC 1500	-	-	-	-	
In Setup	15 - Okuma Crown-E	-	-	-	-	
Down	16 - Citizen CINCOCM L32	-	-	-	115 - Fixture Problem	
Idle	17 - Hardinge T42	-	-	-	-	
Idle	18 - SuperMax TC-26	richardr - Richard Runnells	-	-	-	
Down	33 - Mori Seiki SL50	-	-	-	120 - Preventive M	

New! Finished vs. Unfinished Cycles Chart

A new finished cycles vs. unfinished cycle chart has been added. This bar chart graphs the number of cycles and compares them. This chart supports drilling down to a specific department, location, group, or machine with date and time options. Filters for part types, part numbers, jobs and shifts are also supported.



New! Cycles and Parts Chart

A new cycles and parts chart has been added. This bar chart graphs the number of finished cycles, unfinished cycles, good parts, scrapped parts and compares them. This chart can drill down to a specific department, location, group, or machine with date and time options. Filters for part types, part numbers, jobs and shifts are also supported.

New! Event Time Analysis Chart

A new real-time event time analysis chart has been added to track cycle time, setup time, machine downtime, user downtime, job time, part time, and logon time per machine per day. This bar chart graphs the total time per event with a drill down showing each event in order of occurrence while charting the duration of each event. This chart supports drilling down to a specific shift.

New! MDC Objects

MDC Objects used within Predator DNC or Desktop have been completely re-designed to automatically summarize information on the fly as the data is collected. This new design dramatically improves the real-time capabilities of Predator MDC while simplifying the reporting and charting process. The new MDC objects have been improved with better production rules to automatically process data and minimize prompting. Only missing or

incomplete collected data is flagged and requires prompting by a user. Three new dripfeed objects have been added to support mold making and other DNC heavy data collection applications.

NOTE: These new MDC objects will not require changes to bar code labels, CNC programs or other data collection methods if the latest version of Predator MDC v1.2 is used. Early v1.2 customers of Predator MDC or those upgrading from v1.0 or v1.1 may require several changes to bar code labels, CNC programs or other data collection methods. Please consult your local Predator VAR before utilizing these new MDC objects and upgrading to v1.3.

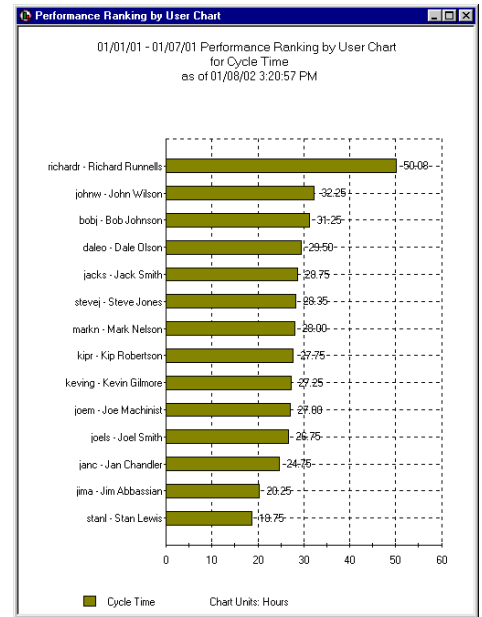
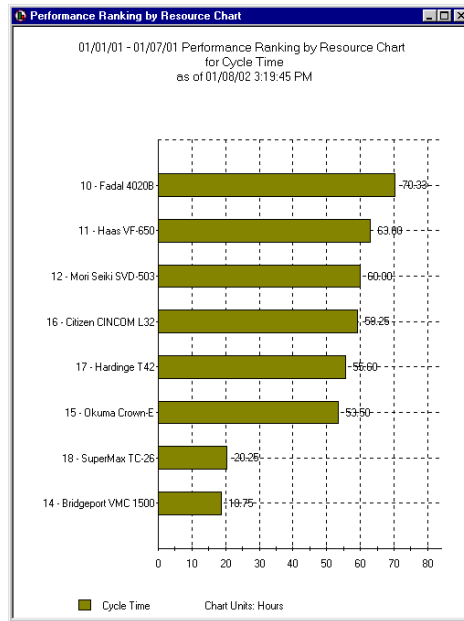
New! Custom Start and Stop Events

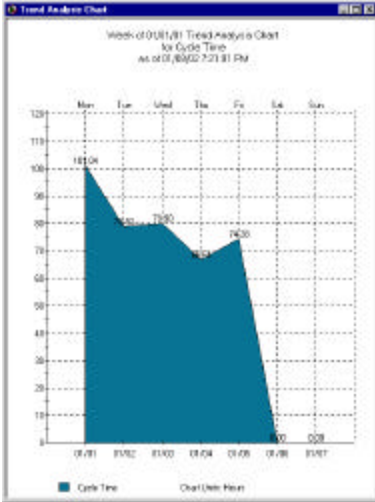
An unlimited number of custom start and stop events can now be added to the data collection process. In addition, three new custom data collection objects have been added for Microsoft Access, SQL Server and Oracle for use within Predator DNC or Desktop.

NOTE: Custom Start and Stop events require custom reports and charts to be developed with Crystal Reports, Microsoft Access, or Oracle Reports. Please contact your local Predator VAR or Predator Software for more information.

New! Performance Ranking Charts

Two new performance ranking charts have been added for machines and users. These bar charts graph the best performer to the worst performer using 35 different criteria. Some of the criteria include parts per hour, quality percent, production percent, scheduled percent, cycle time, cycle percent, idle time, idle percent, setup time, setup percent, good parts, scrapped parts, machine time, downtime, downtime percent and many more. These bar chart graphs and ranks machines or users and compares them. This chart supports drilling down to a specific department, location, group, or machine with date and time options. Filters for part types, part numbers, jobs and shifts are also supported.





New! Trend Analysis Chart

A new trend analysis chart has been added. This plot or area chart graphs one of 35 different production trends over time. Some of the trends include parts per hour, quality percent, production percent, scheduled percent, cycle time, cycle percent, idle time, idle percent, setup time, setup percent, good parts, scrapped parts, machine time, downtime, downtime percent and many more. This chart supports drilling down to a specific department, location, group, or machine with date and time options. Filters for part types, part numbers, jobs and shifts are also supported.

Improved! Filter Charts by Job

All historical charts have been improved to support filtering by job number.

Improved! Cycle Time Analysis Chart

The real-time cycle time analysis chart has been improved to support cycle start to cycle start times as well as cycle start to cycle end times.

Improved! Part Change/Idle Time Analysis Chart

The real-time part change/idle time analysis chart has been improved its accuracy.

New! Job Barcode Report

A new job bar code report has been added. This report can be used with the release job to shop floor command to create a simple bar code enabled tracking sheet. This report includes bar codes for the job number and each part number within the job. Quantities per part number are also shown along with schedule start and end dates for the job.

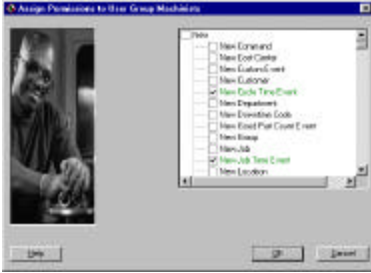
Job Barcode Report Per Job 10-1236 - Aerospace Part 12 for Boeing

Job: 10-1236 - Aerospace Part 12 for Boeing
 Customer: [Redacted]
 Projected Start Date: 05/21/01
 Projected End Date: 05/31/01

Part	Part Number	Target Qty
Z0-13-05 - Bullet Driver Series	[Barcode]	50
10002 - Prototype Type 20 Putter	[Barcode]	53
Z0-09-02 - Zinger Zebra	[Barcode]	59

Improved! Machine Status Report

The machine status report has been updated to show the current part number, number of good parts, scrapped parts, and downtime reasons.



Improved! Assign Permissions Dialog

Green and Red color coding has been added to the assign permissions dialog. Green indicates that the user/group has permission for a particular item and Red indicates that permission has been disabled.

Improved! Permissions Report

Green and Red color coding has been added to the permissions report. Green indicates that the user/group has permission for a particular item and Red indicates that permission has been disabled. In addition, A bug has been fixed so the permissions report can now be printed.

Improved! Time and Attendance Report

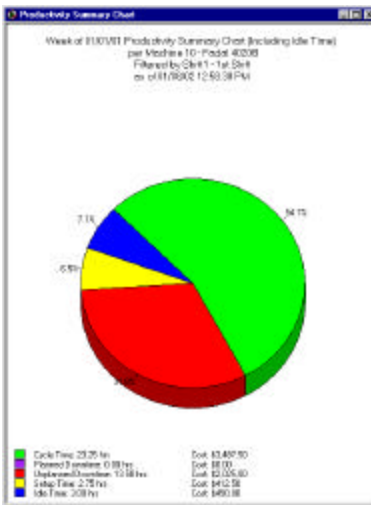
The time and attendance report has been improved with the addition of user time. User time is the time from the first machine login to the last machine logoff per day.

Improved! Production Details Reports

All four production details reports have been improved to support filtering by job. In addition, scheduled production percent has been added.

Improved! Machine Time Reports

Both machine time reports have been improved to support filtering by job.



Improved! Productivity Chart

The productivity chart has been improved with an option to display idle time. Idle time can be toggled on or off as an option within the right mouse menu.

Improved! Good Parts Summary Chart

The good parts summary chart has been improved to support configuration of the "None" shift.

NOTE: The "None" shift is anytime activities occur outside any defined shifts.

Improved! Toolbar Buttons

Predator MDC v1.3 includes a few new toolbar buttons.

Improved! Shift Support

Predator MDC v1.3 includes completely updated production rules for multiple shifts. Support for overlapping shifts and coincident shifts has been improved. In addition, we have improved the use of a users default shift as well.

Improved! Upgrading process

The upgrading process has been improved by displaying the database version numbers within the confirmation upgrade dialog box prior to actually upgrading the database.

Improved! Job and Part Number Formatting

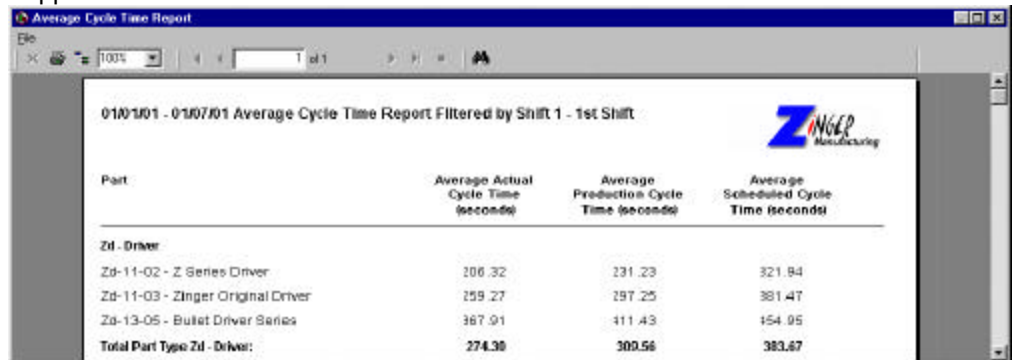
Job and Part number formatting is now optional and can be disabled or enabled. To disable job or part number formatting simply delete the format string within the format string dialog box.

Improved! Shift Summary Report

The shift summary report has been improved to support filtering by job. In addition, scheduled production percent has been added.

New! Average Cycle Time Report

A new average cycle time report has been added. This details the average actual cycle time, production cycle time and scheduled cycle time for one or more part numbers. This chart supports drilling down to a specific department, location, group, or machine with date and time options. Filters for part types, part numbers, jobs and shifts are also supported.



Part	Average Actual Cycle Time (seconds)	Average Production Cycle Time (seconds)	Average Scheduled Cycle Time (seconds)
Zd - Driver			
Zd-11-02 - Z Series Driver	206.32	231.23	321.84
Zd-11-03 - Zinger Original Driver	259.27	297.25	381.47
Zd-13-05 - Bullet Driver Series	367.91	411.43	454.95
Total Part Type Zd - Driver:	274.30	309.56	383.67

Improved! New Shift Summary Dialog

The new shift summary dialog has been improved for easier data entry.

Improved! Predator Tool Crib Compatibility

Predator MDC v1.3 is compatible with Predator Tool Crib v1.3 and both products can utilize the identical database.

Improved! Predator Gage Crib Compatibility

Predator MDC v1.3 is compatible with Predator Gage Crib v1.3 and both products can utilize the identical database.

Improved! Predator Travelers Compatible

Predator MDC v1.3 is compatible with Predator Travelers v1.3 and both products can utilize the identical database.

Bug Fix! New Shift Summary Dialog

Fixed a bug when entering new shift summaries. Occasionally some downtime events were recorded with zero time. This was causing problems with some downtime charts.

Bug Fix! User Downtime Chart

Fixed a bug when filtering with the user downtime chart.

For more information

For the latest information on Predator MDC, check our web site at <http://www.predator-software.com>