



Predator MDC™ v3.0 – What's New

Latest features and benefits in v3.0

Before Installing v3.0

Existing Predator MDC administrators must read the MDC Upgrade to 3.0 from v1.3 document before installing v3.0. There are lots of changes and your local Predator reseller should be consulted prior to upgrading.

NOTE: Customers that were beta testing v2.0 must read the MDC Upgrade to 3.0 from 2.0 document before installing v3.0. There are lots of 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 v3.0. If Predator DNC or Desktop will be used with MDC v3.0 then v4.1 of Predator DNC or Desktop is required.

Backup everything; especially your Oracle space, SQL Server table space or Access MDB file. Running Predator MDC Administrator v3.0 will upgrade the data from v1.3 or v2.0 to v3.0 automatically and it will no longer be compatible with v1.3 or v2.0. Predator MDC will always upgrade the data forward but not backwards.

What happened to v2.0?

Development for v3.0 went faster than planned and V2.0 of Predator MDC was never released to the public.

Why v3.0?

By design, this release was intended to implement a new database design to simplify adding customer requests and new products within the Predator SFC family. For example, with this release we are introducing a new light version of Predator MDC called Predator MDC*Xpress*. In addition, over 50 customer requests for new features and other improvements have been added. Details of the new features are explained throughout this document and within the online help.

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Installing v3.0

By default, installation occurs in the \program files\predator software\mdc 3.0\ directory. If you were running v1.3 simply proceed with the installation normally. If you were running a beta version of 2.0, please un-install it prior to installing v3.0. Predator MDC Administrator v3.0 will upgrade your data from v1.3 or any 2.0 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 6 or greater is required to be installed prior to installing Predator MDC v3.0

Network Installations of v3.0

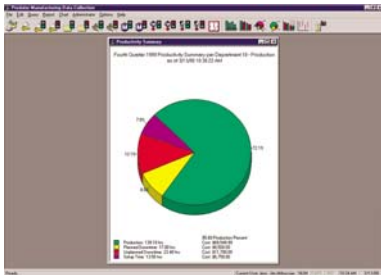
By committing to store the product installation on a server, users will enjoy automatic healing of all critical files upon running Predator MDC. For example, a user accidentally deletes pmdc.exe. Under normal circumstances he would be down and the software would fail to run. With v3.0, when the user 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.

Predator MDC



What's New in v3.0?

New! Predator MDCXpress License

Predator MDCXpress is a new licensing option for those needing manual data collection only. Predator MDCXpress does not support real-time data collection. Customers that purchase Predator MDCXpress can upgrade at any time to Predator MDC. Customer data created with Predator MDCXpress will automatically upgrade to Predator MDC.

New! Operation Time Tracking

Predator MDC can now track time per operations. Operation time tracking is optional and not required. All report and chart dialogs have been updated to support filtering by a specific operation.

New! Teardown Time Tracking

Predator MDC can now track teardown time as a separate machine status. Teardown time tracking is optional and not required. All appropriate reports and charts have been updated to include teardown time.

New! Scrap Reasons

Predator MDC can now track scrap reasons. An unlimited number of scrap reasons along with tracking specific scrap quantities per reason are supported. Tracking scrap reasons is optional and not required.

New! Scrap Code Summary Chart

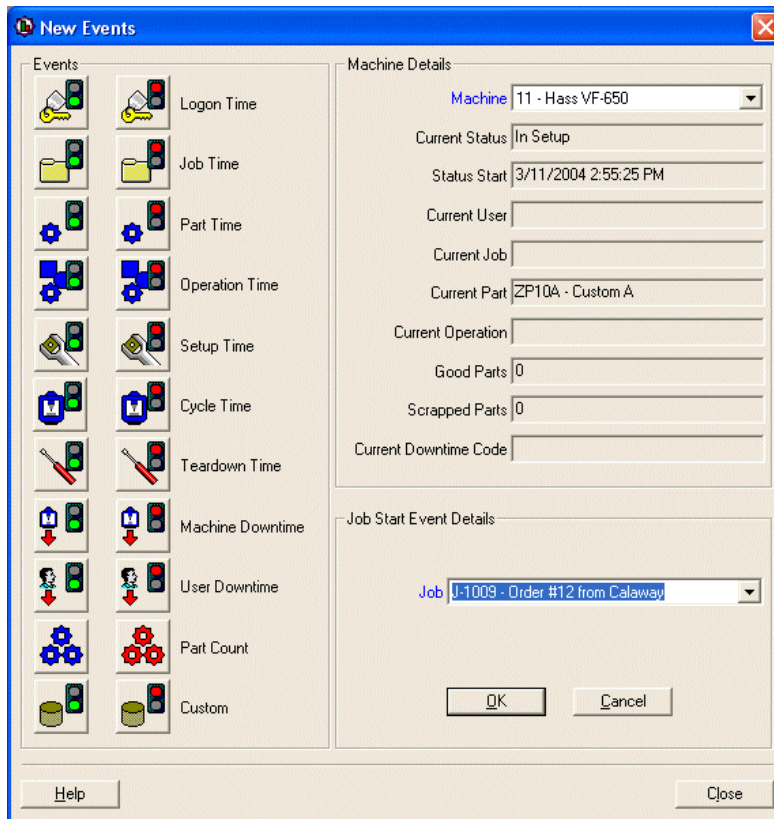
A new scrap code summary chart has been added to graph scrap reasons. This pie chart graphs the total time per scrap reason. This chart supports a complete set of filtering to drill down to specific departments, locations, groups, machines, part types, parts, machinists, operations, jobs and shifts in any combination. The scrap code summary chart supports an optional other slice. A new right mouse menu has been added to display the other slices.

New! Scrap Code Summary Report

A new scrap code summary report has been added for scrap reasons. This report details the total time per scrap reason. This report supports a complete set of filtering to drill down to specific departments, locations, groups, machines, part types, parts, machinists, operations, jobs and shifts in any combination.

New! PC-Based Real-Time Data Collection

A new dialog has been designed for PC based real-time data collection. This single data entry screen also provides real-time status and feedback. In addition it supports switching from one machine to another to allow a single PC per cell implementations.



New! Multiple Parts per Job

A new option called Allow Multiple Parts per Job can be enabled or disabled. This option changes the New Job wizard and the Edit Job wizard to simplify or expand both processes. Typically, this option is based on accounting/ERP methods established at each facility.

New! Automatic Part Start/Stop

A new option to automatically start and stop part numbers based on a job start and stop has been added. When enabled this option will automatically track the first part number within a job. This option should not be enabled if multiple parts per job are utilized.

NOTE: For most manufacturers one part number per job number is typical. By enabling this option it simplifies the data collection process for tracking both job numbers and part numbers.

New! Parts per Job Summary Report

A new parts per job summary report has been added for to track work-in-process and complete details. This report lists the parts and there status within a specific job.

New! International Support

The entire application has been re-tooled to support international date formats, international date calculations, and international resources. Internationalization of Predator MDC includes all menus, dialogs, tooltips, reports and charts.

New! Predator MDC SDK

Predator MDC now includes a comprehensive SDK or software development kit with over 250 API calls. This SDK allows Predator Software or third parties to develop integrations with ERP, MRP, accounting or CAD/CAM applications. The SDK can also be used to add additional customer specific functionality to Predator MDC. Extensive online help is provided detailing each API call along with usage examples in Microsoft C++ and Visual Basic. Support for VB Script has also been added and integration with Predator DNC/Desktop with the VB Script option is also fully supported.

New! Custom Menus

Up to four custom menus can be added to Predator MDC. Commands for creating new custom menus, editing existing custom menus and executing the custom menus have been added. Each custom menu can execute any Predator or third party application.

New! Part Revision Formatting

New automatic formatting for part number revisions have been added. These can be configured to automatically increment using letters or numbers.

New! Operation Revision Formatting

New automatic formatting for operation number revisions have been added. These can be configured to automatically increment using letters or numbers.

New! OEE Report

Two new OEE reports have been added. OEE stands for Overall Equipment Effectiveness and provides manufacturers a single performance metric to monitor shop floor performance and productivity. The two new reports provide OEE results grouped by machine or part number.

Part	Quality Percent	Scheduled Production Percent	Performance Efficiency Percent	OEE
10 - Production				
10A - Building A				
10 - Mill Cell				
10 - Fadal VMC 4020				
ZD-11-02 - Z Series Driver	96.90	88.24	115.74	98.96
ZD-11-03 - Zinger Original Driver	86.76	70.59	131.11	80.30
ZP-08-01 - Zinger Original	86.84	88.24	195.56	149.85
11 - Hass VF-650				
ZD-11-03 - Zinger Original Driver	85.88	74.19	108.15	68.91
ZD-13-05 - Bullet Driver Series	92.08	80.00	154.92	114.12
12 - Mori Seiki GV503				
ZD-11-03 - Zinger Original Driver	79.17	93.94	31.67	23.55
ZP-08-01 - Zinger Original	90.16	90.91	30.56	25.05

New! Standard Time Wizards

Two new standard time wizards have been added to allow standard part times per machine have been added. This allows flexibility and accuracy of OEE reports to account for running the same part number on different machines with different standard times. The two new wizards provide input grouped by machine or part number.

NOTE: We have eliminated the fields for cost per hour and parts per hour from the new and edit wizards from departments, locations and groups. These fields are no longer used by the OEE Reports.

New! Operation Revision Formatting

New automatic formatting for operation revisions have been added. These can be configured to automatically increment using letters or numbers.

New! Performance Ranking by Shift Charts

38 New performance ranking by shift charts have been added.

NOTE: The stand alone Good Parts Summary Chart has been eliminated.

New! Chart Options

All charts that can return more than ten bars or ten pie slices have two new right mouse menus. These new menus are Previous Set and Next Set. These new menus improve the chart display quality while allowing additional information to be easily accessed.

Additionally, all appropriate chart dialogs have a new option Exclude Activity Outside Defined Shifts. This filter allows charts to display only the activity that occurs within shifts vs. all possible activity.

New! Report Options

All appropriate report dialogs have a new option Exclude Activity Outside Defined Shifts. This filter allows reports to display only the activity that occurs within shifts vs. all possible activity.

New! USB Licensing

A new option for USB based SIMs has been added to Predator MDC. This USB option has been added to address the issue of newer PCs that do not support legacy ports.

NOTE: We are still supporting parallel SIMs and will continue to do so.

New! MDC Service

A new MDC Service has been added as part of the Predator MDC Administrator license. This new service is designed to improve the overall reliability of data collection, especially when large numbers of PCs, CNCs, PLCs, and MDC Adapters are used. Ideally, this service is installed on database server to maximize performance and to eliminate network latency.

Improved! Licensing

Licensing has been enhanced to be more flexible with Verisign.

Improved! Historical Reports and Charts

All historical reports and charts have been improved to include real-time data.

Improved! HTML based Online Help

Updated HTML based, context sensitive, online help details the new features and changes made in v3.0 of Predator MDC. Refer to the What's New section for v3.0 specifics.

Improved! MDC Objects

MDC Objects used within Predator DNC or Desktop have been improved to support operations, teardown time, scrap reasons and international date formats. In addition, they have been enhanced to automatically retry transactions when the database server is busy or when the number of simultaneous transactions exceed the available processing power. Eliminated MDC commands from triggering the 'Command Not Found' remote message. Finally, the objects have been improved to support the new MDC Service.

NOTE: These new MDC objects will not require changes to existing bar code labels, CNC programs or other data collection methods if upgrading from Predator MDC v1.3.

Improved! New Components

Creating new components within Predator MDC has been improved with a true wizard based process with integrated history. Duplicate components are identified within the wizard making it easier to perform data entry. Multiple components are now easier to add to the system.

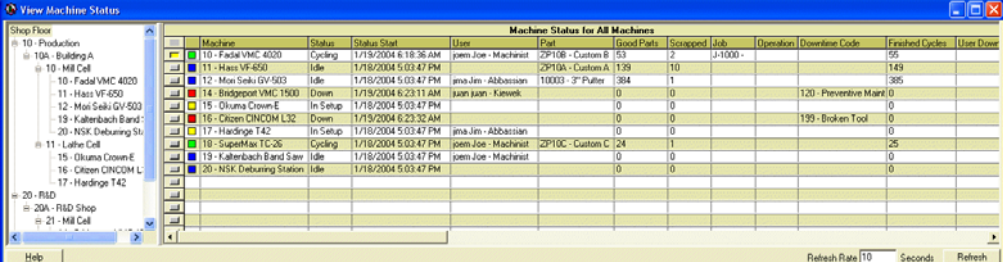
NOTE: Updated components include departments, locations, groups, machines, part types, part numbers, jobs, customers, shifts, vendors, commands, downtime reasons, and scrap reasons.

Improved! View Components

Every view component command has been improved with new right mouse menus for new component and edit existing component.

Improved! View Machine Status

The view machine status has been improved with four additional real-time columns. These new columns include current operation, status time, finished cycles and user downtime. In addition, a new status has been added for teardown time. Teardown utilizes an orange status color.



The screenshot shows a software window titled "View Machine Status" with a tree view on the left and a data table on the right. The table is titled "Machine Status for All Machines" and contains the following columns: Machine, Status, Status Start, User, Part, Good Parts, Scraped, Job, Operation, Downtime Code, Finished Cycles, and User Downtime. The data rows show various machines with their current status and associated metrics.

Machine	Status	Status Start	User	Part	Good Parts	Scraped	Job	Operation	Downtime Code	Finished Cycles	User Downtime
10 - Fadal VMC 4020	Cycling	1/18/2004 6:18:36 AM	joem.joe - Machinist	ZP108 - Custom B	153	2	J-1000 -			156	
11 - Hass VF-650	Idle	1/18/2004 5:03:47 PM		ZP10A - Custom A	129	10				149	
12 - Mori Seiki GV-503	Idle	1/18/2004 5:03:47 PM	ima.jim - Abbotsdon	110003 - 3" Pulley	384	1				385	
14 - Bridgeport VMC 1500	Down	1/18/2004 6:23:11 AM	juan.perez - Kiewit		0	0			120 - Preventive Maint	0	
15 - Okuma Crown-E	In Setup	1/18/2004 6:03:47 PM			0	0				0	
16 - Citizen CHNCOM L32	Down	1/18/2004 6:23:32 AM			0	0			199 - Broken Tool	0	
17 - Hardinge T42	In Setup	1/18/2004 5:03:47 PM	ima.jim - Abbotsdon		0	0				0	
18 - SuperMax TC-26	Cycling	1/18/2004 6:03:47 PM	joem.joe - Machinist	ZP10C - Custom C	24	1				25	
13 - Kallenbach Band Saw	Idle	1/18/2004 5:03:47 PM	joem.joe - Machinist		0	0				0	
20 - NSK Deburring Station	Idle	1/18/2004 5:03:47 PM			0	0				0	

Improved! Edit Components

Editing existing components within Predator MDC has been improved with a true wizard based process with integrated history. Duplicate components are identified within the wizard making it easier to perform data entry.

NOTE: Updated components include departments, locations, groups, machines, part types, part numbers, jobs, customers, shifts, vendors, commands, downtime reasons, and scrap reasons.

NOTE: The part type number field has been deleted to standardize it in relation with the other component types.

Improved! Release Job to shop Floor

The release job to shop floor command has been improved with a true wizard based process with integrated history.

Improved! Finish Job

The finish job command has been improved with a true wizard based process with integrated history.

Improved! Job Wizards

The new and edit job wizards have been improved with the ability to attach a traveler per part number.

Improved! Customers

The new and edit customer wizards have been improved to support a notes field per customer. In addition, each customer can have an unlimited number of reference attachments.

Improved! Vendors

The new and edit vendor wizards have been improved to support a notes field per vendors. In addition, each vendor can have an unlimited number of reference attachments.

Improved! Downtime Codes

The new and edit downtime code wizards have been improved to support a notes field per downtime code. In addition, each downtime code can have an unlimited number of reference attachments.

Improved! Downtime Report

The downtime report has been improved with a new notes column.

Improved! Job Report

The job report has been improved with a new status column.

Improved! Machine Service Chart

The machine service chart has been improved with an optional other slice. A new right mouse menu has been added to display the other slices.

Improved! Machine Downtime Chart

The machine downtime chart has been improved with an optional other slice. A new right mouse menu has been added to display the other slices.

NOTE: The stand alone Other Planned Machine Downtime Chart and Other Unplanned Machine Downtime Chart has been eliminated.

Improved! User Downtime Chart

The user downtime chart has been improved with an optional other slice. A new right mouse menu has been added to display the other slices.

NOTE: The stand alone Other Planned User Downtime Chart and Other Unplanned User Downtime Chart has been eliminated.

Improved! Scrap Codes

The new and edit scrap code wizards have been improved to support a notes field per scrap code. In addition, each scrap code can have an unlimited number of reference attachments.

Improved! Departments

The new and edit department wizards have been improved to support an unlimited number of reference attachments.

Improved! Locations

The new and edit location wizards have been improved to support an unlimited number of reference attachments.

Improved! Groups

The new and edit group wizards have been improved to support an unlimited number of reference attachments.

Improved! Assign Permissions

The assign permissions command has been improved with a true wizard based process with integrated history.

Improved! Assign Users to Users Group

The assign users to users group command has been improved with a true wizard based process with integrated history.

Improved! Predator Travelers™ Compatible

Predator MDC v3.0 is compatible with Predator Travelers v3.0 and both products can utilize the identical database.

Improved! Predator Tracker™ Compatible

Predator MDC v3.0 is compatible with Predator Tracker v3.0 and both products can utilize the identical database.

NOTE: Predator Tracker was previously marketed as Predator Tool Crib and Predator Gage Crib.

Bug Fix! Delete Collected Data

Fixed a bug with the delete collected data command so it will work in every case.

For more information

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