

ProHelp® EPM

Production & Process Monitoring System

Data Exchange Manual

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1. Introduction

MATTEC Corporation's ProHelp® EPM Production and Process Monitoring System is specifically designed for real time monitoring of all types of production equipment. It is used extensively in the plastics injection molding, extrusion, blow molding, blown film, metal stamping, die casting, printing, painting, and assembly industries. The basis behind the benefits from the ProHelp® EPM system is the rationale that plant managers and operational people will take corrective actions to solve problems on production equipment when they are aware of such problems. ProHelp® EPM is the device to alert employees to problems immediately when the problems occur. Therefore, tremendous savings can occur in increased productivity and decreased scrap parts.

The ProHelp® EPM system combines computer hardware, computer software, and Machine Interface Units (MIUs) into an efficient system to provide real time production monitoring, production reports, process alarms, plant scheduling aids, and SPC process and part capability analysis. Floor personnel can make use of the machine mounted terminals to signal different departments for help, to view production results at the machine site, and to enter downtime reasons or scrap reasons. Production, downtime, and scrap reports may be generated on a shift and daily basis, or the user may generate these reports for extended time periods by specifying a start and end date for the desired report. Job history data is continuously summarized and available for management's review.

This manual describes the ProHelp® EPM facilities which support the sharing of data with other computer systems or applications. Each of these facilities accomplishes its task by reading or writing to a file system accessible to the user. ProHelp® EPM utilizes the Microsoft Windows NT operating system and the Microsoft SQL Server database. Users may connect to the system from Windows NT, Windows 98, and Windows 95. As a result, ProHelp® EPM is quite powerful in its ability to share information with external systems.

Two facilities are described here:

Data Import

This optional feature is, for historical reasons, often referred to as "Download". It allows Tool (Mold) IDs, Part IDs, Process Sheets, Job Descriptors, and Machine Schedules to be imported into ProHelp® EPM from an external database. The format for data import is a MATTEC-defined, delimited ASCII file. Reference Section 2 for additional information.

Data Export

This optional feature allows raw data from Production History, SPC History, Job Descriptors, Process Sheets, Part IDs, and Tool (Mold) IDs to be exported from ProHelp® EPM. Reference Section 3 for additional information.

1.1 Conventions

Much of this document consists of record descriptions which in turn consist of field descriptions. Fields are identified by their position in the record and the sequence of the field descriptions reflects that. Required fields for Data Import are indicated by “(required)” in the “FIELD” column.

In addition to its position or name, each field entry includes a type, format, and description. A field’s type may be one of the following:

FIELD TYPE	DESCRIPTION	EXAMPLES
Alphanumeric	Text that is a combination of letters, numbers, or both.	abc 123 abc123
Float	A "real number" that may include decimal places.	1.23 1.00 1
Integer	A "whole number" that may not include decimal places.	1 23 456
Date	The month, day, and 4-digit year, in the form MM/DD/YYYY, DD/MM/YYYY, or YYYY/MM/DD, depending upon System Configuration ("Units" tab). A 4-digit year is required. When data is output using Data Export, the date delimiter will either be a "/" or ".", depending upon System Configuration.	08/18/1999 12/31/2001 01/02/2003
Time	The time of day, using a 24-hour clock. Specified in the format hh:mm, where <i>hh</i> = hours using the 24-hour clock and <i>mm</i> = minutes. One or two digits are accepted for hours (hh), however, two digits are always required for minutes (mm). When data is output using Data Export, the time delimiter will either be a ":" or ".", depending upon System Configuration.	00:30 01:15 23:59 01:02

1.2 Copyright Notice

The Data Import / Export program, database stored procedures, database views, and other related utilities are protected by copyright law and international treaties. Unauthorized reproduction or distribution of this program or related tools and utilities, or any portion thereof, may result in severe civil or criminal penalties, and will be prosecuted to the maximum extent possible under law.

It is a violation of Mattec's copyright to use the Data Import / Export program, database stored procedures, database views, or other related utilities without purchasing the Data Import / Export Option from Mattec Corporation.

1.3 Contacting Mattec

Before executing Data Import or Data Export, you must purchase the Data Import / Export option from Mattec Corporation. For additional information, please contact Mattec's Sales Department at 1-513-683-1802.

It is easiest to obtain technical support by visiting Mattec's website at <http://www.mattec.com> or by emailing the help desk at helpdesk@mattec.com.

2. Data Import (Download)

The optional Data Import program provides a means for transferring Tool (Mold) IDs, Part IDs, Process Sheets, Job Descriptors, and Machine Schedules from an external system, such as a mainframe or mini-computer, to ProHelp® EPM. This program reads an appropriately formatted ASCII text file and uses the information it contains to create or modify data. If errors are encountered during processing, an error report is generated by ProHelp® EPM and the user is notified.

2.1 File and Record Format

Each record in the ASCII file is essentially an action request and causes specific functions to occur during processing of that record by ProHelp® EPM. Several such actions may be requested:

SUGGESTED ORDER	ACTION	REQUEST CODE
1	Create or modify a Tool (Mold) ID. Refer to Section 2.2.	TI
2	Create or modify a Part ID. Refer to Section 2.3.	PI
3	Create or modify a Process Sheet (basic information). Refer to Section 2.4.	PP
4	Create or modify a Process Sheet (process-specific information). Refer to Section 2.5.	PE
5	Create or modify a Job ID. Refer to Section 2.6.	JB
6	Delete a Machine Schedule. Refer to Section 2.7.	SD
7	Create or append to a Machine Schedule. Refer to Section 2.8.	SA

The suggested order takes into account dependencies between the various actions. For example, a PE (Process Sheet, process-specific information) record can only include existing process sheets, including those created by PP records in the same file; before a PP or PE record can reference a Tool (Mold) ID or Part ID, the Tool ID and Part ID must already exist, and so forth.

All types of records need not be present in the file. For example, if a record requests the creation of a Process Sheet (PP/PE) using Part ID "123", and ProHelp® EPM already has a record for Part ID "123", then there is no need to precede the request with a Part ID (PI) creation request.

All fields within a record are separated by commas (","). All records must be terminated with a carriage return and line feed. The first field of each line always consists of one of the 2-character request codes listed above.

Character fields can optionally be included in double quotes (" "). However, single quotes (' ') may not be used. Because of this, it is preferred that you do NOT use quote marks at all.

2.2 Create or Modify a Tool (Mold) ID

The Tool (Mold) ID action request record consists of a 2-character request code (TI), the name of the Tool ID (up to 18 characters), and additional fields as defined below:

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (TI).
2 (required)	Alphanumeric	18	The name of the Tool ID.
3	Integer		Total cavities for the tool.
4	Integer		Active cavities for the tool. May not exceed the total cavities.
5	Float		Runner weight.
6	Alphanumeric	20	Description.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. If an optional field is omitted and the Tool ID record already exists, the field is not modified. If an optional field is omitted and the Tool ID record does not already exist, the field is set to blanks (Alphanumeric type) or 0 (Integer or Float types).

The "Last Update" field for the Tool ID will be automatically updated with the current date and time. Other fields in the Tool ID record will not be modified.

Examples:

```
TI,Tool1,3,2,4.5,My Tool  
TI,Tool2,3,3,3,Another Tool
```

2.3 Create or Modify a Part ID

The Part ID action request record consists of the two character request code (PI), the name of the Part ID, and additional fields as defined below:

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (PI).
2 (required)	Alphanumeric	18	The name of the Part ID.
3	Alphanumeric	25	Material ID.
4	Alphanumeric	25	Color ID.
5	Float		Percent regrind.
6	Float		Part weight.
7	Float		Part cost.
8	Float		Material cost.
9	Alphanumeric	20	Description.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. If an optional field is omitted and the Part ID record already exists, the field is not modified. If an optional field is omitted and the Part ID record does not already exist, the field is set to blanks (Alphanumeric type) or 0 (Integer or Float types).

The "Last Update" field for the Part ID will be automatically updated with the current date and time. Other fields in the Part ID record will not be modified.

Examples:

```
PI,Part1,Material1,Color1,10.1,2,3,4  
PI,Part2,Material2,,6,1.1,2.2,3.3,4.4
```

2.4 Create or Modify a Process Sheet (Basic Information)

The Process Sheet (Basic Information) action request record consists of the two character request code (PP), the name of the Machine ID, the name of the Tool ID, the name of the Part ID, and additional fields as defined below:

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (PP).
2 (required)	Alphanumeric	5	The name of the Machine Number.
3 (required)	Alphanumeric	18	The name of the Tool ID.
4 (required)	Alphanumeric	18	The name of the Part ID.
5	Float		Expected percent uptime.
6	Float		Expected cycle time.
7	Float		Expected percent good.
8	Float		Labor hour factor.
9	Float		Labor cost.
10	Alphanumeric	20	Description 1.
11	Alphanumeric	20	Description 2.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. If an optional field is omitted and the Process Sheet record already exists, the field is not modified. If an optional field is omitted and the Process Sheet record does not already exist, the field is set to blanks (Alphanumeric type) or 0 (Integer or Float types).

The "Last Update" field for the Process Sheet will be automatically updated with the current date and time. Other fields in the Process Sheet record will not be modified.

When creating a Process Sheet, you must have one PP action request and multiple PE action requests, one for every parameter that is defined in the machine's configuration. The PP action request must be executed before the PE action request.

Note: If the PP and PE action requests are not done properly, the user will not be able to edit the Process Sheet via Edit Facilities. The Process Sheet record must be corrected using valid PP and PE action requests before Edit Facilities will work properly. In particular, the PE requests must correspond precisely with the parameter numbers that are defined in the machine's configuration program. Reference Section 2.5 for additional information.

Examples:

```
PP,Mach1,Tool1,Part1,99,10.5,94,1.5,4.53,Description1,Description2  
PP,01,123501,124F-13,98.5,10,94.5
```

2.5 Create or Modify a Process Sheet (Process-specific Information)

The Process Sheet (Process-specific Information) action request record consists of the two character request code (PE), the name of the Machine ID, the name of the Tool ID, the name of the Part ID, and additional fields as defined below:

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (PE).
2 (required)	Alphanumeric	5	The name of the Machine ID.
3 (required)	Alphanumeric	18	The name of the Tool ID.
4 (required)	Alphanumeric	18	The name of the Part ID.
5 (required)	Integer		The parameter number. This number may have the values 0-63 and must correspond precisely with the parameters that are defined in the machine's configuration (and stored in the ParmSet table).
6	Float		The parameter's upper limit.
7	Float		The parameter's nominal value. This value may not exceed the parameter's upper limit or be below the parameter's lower limit.
8	Float		The parameter's lower limit.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. Any fields not present in the record are set to 0 (Integer or Float types).

The "Last Update" field for the Process Sheet will be automatically updated with the current date and time. Other fields in the Process Sheet record will not be modified.

When creating a Process Sheet, you must have one PP action request and multiple PE action requests, one for every parameter that is defined in the machine's configuration. The PP action request must be executed before the PE action request.

Note: If the PP and PE action requests are not done properly, the user will not be able to edit the Process Sheet via Edit Facilities. The Process Sheet record must be corrected using valid PP and PE action requests before Edit Facilities will work properly. In particular, the PE requests must correspond precisely with the parameter numbers that are defined in the machine's configuration program (and stored in the ParmSet database table).

Examples:

```
PE,01,Tool1,Part1,0,10,9.5,9
PE,01,Tool1,Part2,5,21,20.5,20
PE,01,Tool1,Part3,60,21.3,21.2,21.1
```

2.6 Create or Modify a Job ID

The Job ID action request record consists of the two character request code (JB), the name of the Job ID, the name of the Machine ID, the name of the Tool ID, the name of the Part ID, and additional fields as defined below:

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (JB).
2 (required)	Alphanumeric	18	The name of the production Job ID.
2 (required)	Alphanumeric	5	The name of the Machine ID.
3 (required)	Alphanumeric	18	The name of the Tool ID.
4 (required)	Alphanumeric	18	The name of the Part ID.
5	Date	10	The job's scheduled start date.
6	Time	5	The job's scheduled start time.
7	Date	10	The job's scheduled stop date.
8	Time	5	The job's scheduled stop time.
9	Integer		The lot size.
10	Alphanumeric	18	The name of the Customer ID.
11	Alphanumeric	20	Comment 1.
12	Alphanumeric	20	Comment 2.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record.

The Job ID that is specified must be a unique identifier for this job. Although ProHelp® EPM supports non-unique Job IDs (that is, multiple Job IDs with the same name), the Data Import function requires unique Job IDs.

Only "Production" jobs (jobs with lot sizes) may be imported. "Tool (Mold) Change", "Maintenance", and "Off Line" jobs may not be created using this action request.

The following describe the action that is taken for the "JB" action request:

- If the specified Job ID doesn't exist, the job will be created and added to the list of unscheduled jobs (Job Pool).
- If the specified Job ID exists in the Job Pool, all fields will be updated. Any fields not present in the record are set to blanks (Alphanumeric) or 0 (Integer or Float types).
- If the specified Job ID exists in the machine schedule or is currently running, the lot size will be updated. No other modifications will be made.
- If the specified Job ID exists and the job has completed, no modifications will be made.

Examples:

```
JB,Job1,Mach1,Tool1,Part1,01/31/2001,23:01,12/31/2003,03:59,1000,cust1,comment 1,c2
JB,2-CHR,Mach1,Tool1,Part2,12/15/2001,12:00,12/25/2001,12:00,1500
```

2.7 Delete a Machine Schedule

The Delete Machine Schedule action request record consists of the two character request code (SD) and the name of the Machine ID. Job IDs that are scheduled on the current machine are moved to the Job Pool and the machine's schedule is deleted (except for the currently running job).

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (SD).
2 (required)	Alphanumeric	5	The name of the Machine ID.

The Delete Machine Schedule action request can be used in combination with one or more Machine Schedule action requests (SA) to rewrite a machine's schedule.

Examples:

```
SD,Mach1  
SA,Mach1,Job1  
SA,Mach1,Job2
```

2.8 Create or Append to a Machine Schedule

The Machine Schedule action request record consists of the two character request code (SA), the name of the Machine ID, and the name of the Job ID to be scheduled.

The Job ID in the action request record is appended to the end of the current schedule. If the Job ID is already scheduled, or if the job is currently running, the action request is aborted and an error is reported.

FIELD	TYPE	LENGTH	DESCRIPTION
1 (required)	Alphanumeric	2	The request code (SA).
2 (required)	Alphanumeric	5	The name of the Machine ID.
3 (required)	Alphanumeric	18	The name of the production Job ID.

Machine Schedule action requests may only contain jobs for which Job IDs already exist in the list of unscheduled jobs (Job Pool). The Job ID may have just been created using a previous Job action request (JB).

The Job ID that is specified must be a unique identifier for this job. Although ProHelp® EPM supports non-unique Job IDs (that is, multiple Job IDs with the same name), the Data Import function requires unique Job IDs.

Examples:

```
SA,Mach1,Job1  
SA,Mach1,Job2
```

3. Data Export

The Data Export program is actually comprised of many separate programs that allow the user to export the following information:

DATA EXPORT TYPE
Production History. Refer to Section 3.2.
SPC History. Refer to Section 3.3.
Job Descriptor information. Refer to Section 3.4.
Process Sheet information. Refer to Section 3.5.
Part ID Information. Refer to Section 3.6.
Tool ID information. Refer to Section 3.7.

The following sections describe each of these Data Export programs.

3.1 Limiting The Amount Of Exported Data – Shift Numbers

When you select to export Production History data and specify the "Specific Shift" filter, the "Shift" that is displayed always includes the numbers 1-10. These correspond to the internal "ShiftSeq" field that is used in the database (ShiftProd.ShiftSeq), where "1" represents the first shift of the specified day, "2" represents the second shift of the specified day, etc.

These numbers are not the "Shift Name" that is specified in the Shift Boundaries Edit Facilities program.

3.2 Production History Data Export

The Production History data export selection allows the user to export production-related information by shift. This program can be useful for updating external systems with production-related information for jobs by shift, including the number of parts produced for a shift and the number of packed parts for a shift.

The Production History data export is very similar to the Job History data export. The Production History selection exports data by shift, whereas the Job History selection exports data for the entire job. Data may be exported for the current day, previous day, or a date/shift range for one or all departments.

The following table describes the fields that are exported in the Production History data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	JobID	Alphanumeric (18)	JobQueue	The name of the Job ID.
2	MachID	Alphanumeric (5)	MachCon	The name of the Machine ID.
3	PartID	Alphanumeric (18)	PartIDs	The name of the Part ID.
4	MoldID	Alphanumeric (18)	MoldIDs	The name of the Tool ID.
5	SampID	Alphanumeric (18)	QCSheet	The name of the Sample ID.
6	MatID	Alphanumeric (25)	PartIDs	The name of the Material ID.
7	ColorID	Alphanumeric (25)	PartIDs	The name of the Color ID.
8	CustomerID	Alphanumeric (18)	JobQueue	The name of the Customer ID.
9	Shift Date	Date	ShiftProd	The date of the shift.
10	Shift Index	Integer	ShiftProd	The shift index for the day. The first shift of the production day would be 0. Values can range from 0-9.
11	CycCnt	Integer	ShiftProd	Total number of machine cycles for the shift.
12	CycOutSpec	Integer	ShiftProd	Total number of out-of-spec cycles for the shift. Any cycle in which one or more process parameters are out-of-spec is an out-of-spec cycle.
13	ExpProdQty	Integer	ShiftProd	Expected number of parts to be produced based on information in the process sheet.
14	CalProdQty	Integer	ShiftProd	The total number of parts produced for the shift as monitored by the MIU.
15	PakProdQty	Integer	ShiftProd	Packed parts reported for the shift.
16	DefectQty	Integer	ShiftProd	Scrap parts reported for the shift.
17	TotTime	Integer	ShiftProd	Total time (run time plus down time) in seconds for the shift.
18	DownTime	Integer	ShiftProd	Down time in seconds for the shift.

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
19	NumDownTm	Integer	ShiftProd	The number of downtime occurrences for the shift.
20	LaborTime	Integer	ShiftProd	Amount of labor time in seconds calculated for the shift.
21	MinCycTm	Float	ShiftProd	Minimum cycle time value that occurred during the shift.
22	MaxCycTm	Float	ShiftProd	Maximum cycle time value that occurred during the shift.
23	SumCycTm	Float	ShiftProd	Sum of the cycle time values that occurred during the shift. Useful in calculating the average for cycle time.
24	SumSqCycTm	Float	ShiftProd	Sum of the squares of the cycle time values that occurred during the shift. Useful in calculating the standard deviation for cycle time.
25	NumCavs	Float	MoldIDs	The total cavities for the tool.
26	RunnerWt	Float	MoldIDs	Runner weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
27	PctReg	Float	PartIDs	Percentage regrind of total for the material.
28	PartWt	Float	PartIDs	Part weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
29	PcsPerCtn	Integer	PartIDs	Pieces per carton or box.
30	PartCost	Float	PartIDs	Part cost in \$ per unit.
31	MatlCost	Float	PartIDs	Material cost in \$ per unit.

3.3 SPC History Data Export

The SPC History data export selection allows the user to export information about long term SPC. This program can be useful for updating external systems with SPC data that has been collected by an MIU. Data may be exported for the current day, previous day, or a date range for one or all departments.

The following table describes the fields that are exported in the SPC History data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	MachID	Alphanumeric (5)	MachCon	The name of the Machine ID.
2	JobID	Alphanumeric (18)	JobQueue	The name of the Job ID.
3	Name	Alphanumeric (10)	ParmSet	The name of the Parameter.
4	Sample Date	Date	LongTermEng	The date the sample was taken.
5	Sample Time	Time	LongTermEng	The time the sample was taken.
6	ParmNo	Integer	LongTermEng	The zero-based parameter number.
7	LtCycleIndex	Integer	LongTermEng	The long term cycle index for each period (0 for the first cycle, up to "N-1", where N is the subgroup size).
8	Value	Float	LongTermEng	The process parameter value.
9	Flag	Alphanumeric (1)	LongTermEng	A flag indicating the status of this particular sample, where: <ul style="list-style-type: none"> • ‘.’ is in spec; • ‘-’ is below lower spec, • ‘+’ is above upper spec, • ‘x’ is invalid parameter value (unable to calculate), • ‘?’ is unknown due to no process sheet (no spec limits)

3.4 Job Descriptor Data Export

The Job Descriptor data export selection allows the user to export information about running or completed jobs. Data for pending or non-running jobs is not included in the data export. This program can be useful for updating external systems with production-related information for jobs, including the total number of parts produced and the total number of packed parts.

The Job History data export is very similar to the Production History data export. The Job History selection exports data for the entire job, whereas the Production History selection exports data by shift.

The following table describes the fields that are exported in the Job Descriptor data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	JobID	Alphanumeric (18)	JobQueue	The name of the Job ID.
2	MachID	Alphanumeric (5)	MachCon	The name of the Machine ID.
3	PartID	Alphanumeric (18)	PartIDs	The name of the Part ID.
4	MoldID	Alphanumeric (18)	MoldIDs	The name of the Tool ID.
5	SampID	Alphanumeric (18)	QCSheet	The name of the Sample ID.
6	MatlID	Alphanumeric (25)	PartIDs	The name of the Material ID.
7	ColorID	Alphanumeric (25)	PartIDs	The name of the Color ID.
8	CustomerID	Alphanumeric (18)	JobQueue	The name of the Customer ID.
9	StartDate	Date	JobQueue	The job's actual start date .
10	StartTime	Time	JobQueue	The job's actual start time in the format hh:mm.
11	StopDate	Date	JobQueue	The job's actual stop date. If the job has not ended yet, the value 0/0/0 will be used.
12	StopTime	Time	JobQueue	The job's actual stop time in the format hh:mm or hh.mm. If the job has not ended yet, the value 0:0 will be used.
13	SchedQty	Integer	JobQueue	The lot size.
14	CycCnt	Integer	JobProd	Total number of machine cycles for the job.
15	CycOutSpec	Integer	JobProd	Total number of out-of-spec cycles for the job. Any cycle in which one or more process parameters are out-of-spec is an out-of-spec cycle.
16	ExpProdQty	Integer	JobProd	Expected number of parts to be produced based on information in the process sheet.
17	CalProdQty	Integer	JobProd	The total number of parts produced for the job as monitored by the MIU.
18	PakProdQty	Integer	JobProd	Packed parts reported for the job.

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
19	DefectQty	Integer	JobProd	Scrap parts reported for the job.
20	TotTime	Integer	JobProd	Total time (run time plus down time) in seconds for the job.
21	DownTime	Integer	JobProd	Down time in seconds for the job.
22	NumDownTm	Integer	JobProd	The number of downtime occurrences for the job.
23	LaborTime	Integer	JobProd	Amount of labor time in seconds calculated for the job.
24	MinCycTm	Float	JobProd	Minimum cycle time value that occurred during the job.
25	MaxCycTm	Float	JobProd	Maximum cycle time value that occurred during the job.
26	SumCycTm	Float	JobProd	Sum of the cycle time values that occurred during the job. Useful in calculating the average for cycle time.
27	SumSqCycTm	Float	JobProd	Sum of the squares of the cycle time values that occurred during the job. Useful in calculating the standard deviation for cycle time.
28	NumCavs	Float	MoldIDs	The total cavities for the tool.
29	RunnerWt	Float	MoldIDs	Runner weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
30	PctReg	Float	PartIDs	Percentage regrind of total for the material.
31	PartWt	Float	PartIDs	Part weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
32	PcsPerCtn	Integer	PartIDs	Pieces per carton or box.
33	PartCost	Float	PartIDs	Part cost in \$ per unit.
34	MatlCost	Float	PartIDs	Material cost in \$ per unit.

3.5 Process Sheet Data Export

The Process Sheet data export selection allows the user to export information about process sheets. This program can be useful for updating external systems with process parameter-related information from process sheets.

The following table describes the fields that are exported in the Process Sheet data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	MachID	Alphanumeric (5)	MachCon	The name of the Machine ID.
2	PartID	Alphanumeric (18)	PartIDs	The name of the Part ID.
3	MoldID	Alphanumeric (18)	MoldIDs	The name of the Tool ID.
4	SampID	Alphanumeric (18)	QCSheet	The name of the Sample ID.
5	Name	Alphanumeric (10)	ParmSet	The name of the Parameter.
6	ParmNo	Integer	PSEng	The zero-based parameter number.
7	UpperLim	Float	PSEng	The Engineering upper specification limit.
8	NomVal	Float	PSEng	The Engineering nominal value.
9	LowerLim	Float	PSEng	The Engineering lower specification limit.
10	ExpPctUp	Float	PSProd ¹	Expected percent Uptime.
11	ExpCycTm	Float	PSProd	Expected cycle time.
12	ExpGood	Float	PSProd	Expected percent good parts.
13	HistPctUp	Float	PSProd	Historical percent uptime.
14	HistCycTm	Float	PSProd	Historical cycle time.
15	HistGood	Float	PSProd	Historical percent good parts.
16	LaborFactor	Float	PSProd	Standard labor factor.
17	LaborCost	Float	PSProd	Cost in \$ per unit time of an operator. Used as a multiplier of labor time to produce a cost of direct labor for a period of time.

¹ Fields from the PSProd table do not vary as the process parameter (ParmNo field in PSEng database table) varies. They are included in this data export file to simplify the process of taking process sheet information to an external system.

3.6 Part ID Data Export

The Part ID data export selection allows the user to export information about parts. This program can be useful for updating external systems with information specific to a produced part or item.

The following table describes the fields that are exported in the Part ID data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	PartID	Alphanumeric (18)	PartIDs	The name of the Part ID.
2	PartDesc	Alphanumeric (20)	PartIDs	A description for the part.
3	MatlID	Alphanumeric (25)	PartIDs	Material ID.
4	PctReg	Float	PartIDs	Percentage regrind of total material requirement.
5	PartWt	Float	PartIDs	Part weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
6	PcsPerCtn	Integer	PartIDs	Pieces per container.
7	PartCost	Float	PartIDs	Part cost.
8	MatlCost	Float	PartIDs	Material cost.
9	ColorID	Alphanumeric (25)	PartIDs	Color ID.
10	MiscInfo1	Alphanumeric (20)	PartIDs	Part description 1.
11	MiscInfo2	Alphanumeric (20)	PartIDs	Part description 2.
12	PartInfo	Alphanumeric (40)	PartIDs	Part information.

3.7 Tool ID Data Export

The Tool ID data export selection allows the user to export information about tools (molds). This program can be useful for updating external systems with information for a physical tool, mold, die, fixture, or other apparatus that is used in conjunction with a machine to produce a certain part or a group of parts.

The following table describes the fields that are exported in the Tool ID data export program:

#	FIELD	TYPE (LENGTH)	DB SOURCE	DESCRIPTION
1	MoldID	Alphanumeric (18)	MoldIDs	The name of the Tool ID.
2	MoldDesc	Alphanumeric (20)	MoldIDs	A description of the tool.
3	MachReq	Alphanumeric (20)	MoldIDs	User-defined description field for machine type.
4	NumCavs	Float ¹	MoldIDs	Total cavities for the tool.
5	ActCavs	Float	MoldIDs	Active cavities for the tool. May not exceed the total cavities.
6	Maker	Alphanumeric (20)	MoldIDs	User-defined description field for describing the tool's maker.
7	Location	Alphanumeric (20)	MoldIDs	User-defined description field for describing the tool's current location.
8	RunnerWt	Float	MoldIDs	Runner weight in grams. This value does <u>not</u> get converted to the display unit from System Configuration.
9	MiscInfo1	Alphanumeric (20)	MoldIDs	Tool description 1.
10	MiscInfo2	Alphanumeric (20)	MoldIDs	Tool description 2.

¹ Although the **NumCavs** and **ActCavs** fields are Floats, data is stored in whole numbers only. In other words, data is stored as if these fields were Integers.

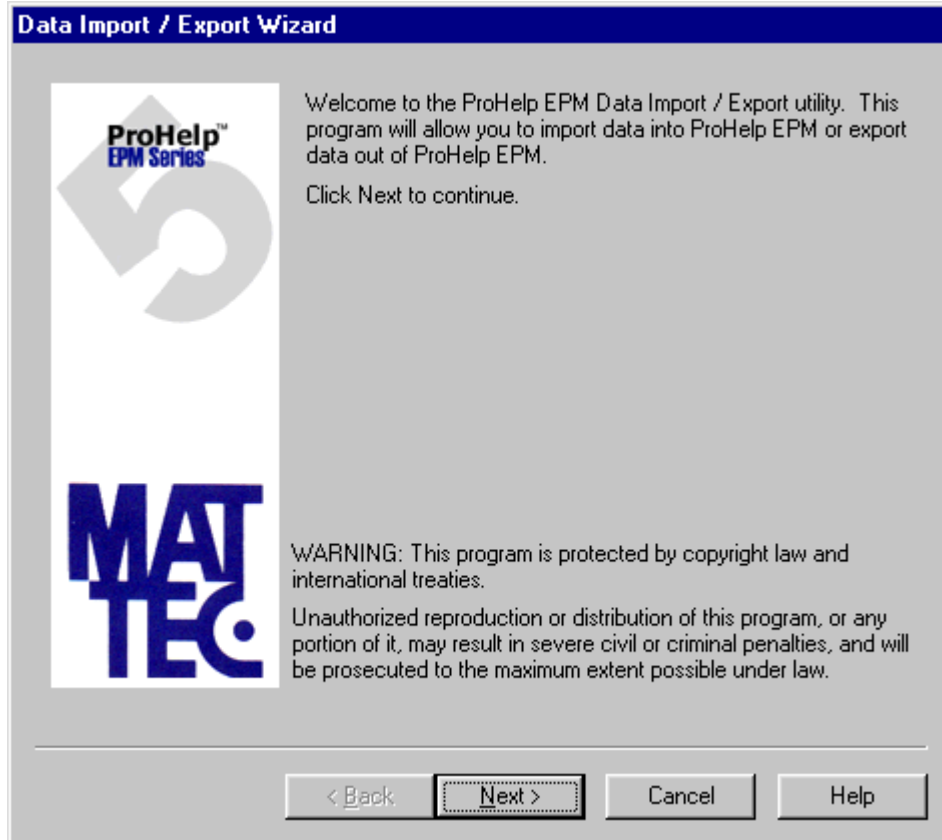
4. Operation

Before executing Data Import or Data Export, you must purchase the Data Import / Export option from Mattec Corporation. For additional information, please contact Mattec's Sales Department at 1-513-683-1802.

To execute the Data Import / Export program, follow these steps:

- Install the ProHelp® EPM software on your computer.
- Click on the **Start Menu**.
- Select **Programs**.
- Select the **Mattec** folder.
- Select the **utilities** folder.
- Select the **Data Import / Export** program.

The Data Import / Export Wizard will be displayed:



Follow the onscreen prompts as required. The status of the Data Import or Data Export will be shown, as appropriate.