



Predator MDC™ v8.0 – What's New

Latest features and benefits in v8.0

Before Installing v8.0

Predator MDC v8.0 requires Windows 2000, XP, 2003 Server or Vista. Existing customers that have older versions of Windows such as Windows 95, 98, ME or NT v4.0 must upgrade prior to installing v8.0 of Predator MDC.

Existing MDC customers should backup the database prior to upgrading. Predator MDC Administrator v8.0 will upgrade the database automatically from older v1.x, v2.x, v3.x or v7.x versions to v8.0. After the database has been upgrade to v8.0 older versions of Predator MDC will not be able to use the database.

NOTE: Microsoft Internet Explorer v5.x or later is required to be installed before installing Predator MDC v8.0.

Why v8.0?

By design, the primary goal of this release is intended to provide easier, faster and more detailed insight to shop floor productivity. Significantly 326 new reports and charts have been added for a total of 646. In addition, almost every existing report and chart has been improved. Numerous new features and improvements have been added for better data collection and day to day operation. Along the way support for Vista and 64 bit editions of Windows have been added. Details of what's new are explained throughout this document and within the online help.

NOTE: Predator MDC Xpress has been renamed to Predator MDC Express.

Installing v8.0

A new Install Wizard has been developed for v8. It is based on a single .MSI image and .CAB files have been eliminated. In addition, the Predator MDC Service has been added to the standard installation. If you are running Windows 98, ME or NT v4.0 you must upgrade to Windows 2000, XP, 2003 Server or Vista prior to installing v8.0 of Predator MDC.

NOTE: Predator MDC Service is installed automatically with Predator MDC.

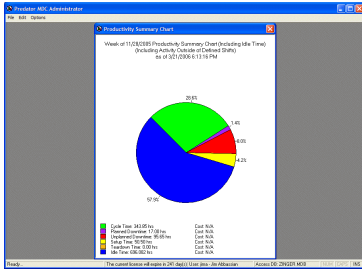
By default installation occurs in the \program files\predator software\mdc 8.0 directory. If you were previously running v7.x we recommend uninstalling v7.x prior to installing v8.0.

NOTE: Microsoft's .Net Framework v2.0 is now required.

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Predator MDC



v8.0 Serial Numbers and Access Codes

Version 8 includes a serial number and an access code that are required after the installation during registration of the software.

NOTE: The serial number must start with 08 if this is not the case contact us.

Network Installations of v8.0

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, suppose a user accidentally deletes pmdc.exe. Under normal circumstances he would be down and the software would fail to run. With v8.0 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.

The easiest way to perform a network installation is to step through the following:

1. Copy the contents of the CD to a \predator cd images\CD30\ or similar directory.
2. Run the setupmdc.exe from the CD30 directory.

NOTE: Should any automatic healing be necessary, Predator MDC will be able to automatically extract the necessary files from the appropriate files stored in the CD30 directory. If you install from a CD, Predator MDC will be forced to prompt for the CD.

What's New in v8.0?

New! Microsoft Windows Vista Support

Support for Microsoft Windows Vista has been added with v8.0 of Predator MDC.

New! Microsoft Windows 64 Bit Support

Support for Microsoft Windows XP Professional x64 Edition, Windows 2003 Server x64 Edition and Windows Vista x64 Editions have been added with v8.0 of Predator MDC.

New! Microsoft Office Access 2007 Support

Support for Access 2007 has been added with v8.0 of Predator MDC.

New! Oracle Database 11g Support

Support for Oracle Database 11g has been added with v8.0 of Predator MDC.

New! International Support

Internationalization of Predator MDC has been re-designed so a single PMDC.exe can support multiple languages. Our initial release includes English and Chinese. Additional languages can be added as they become available. Predator MDC automatically honors that appropriate languages based on Windows. This effort significant simplifies product releases and allows a worldwide customer base to run the same version.

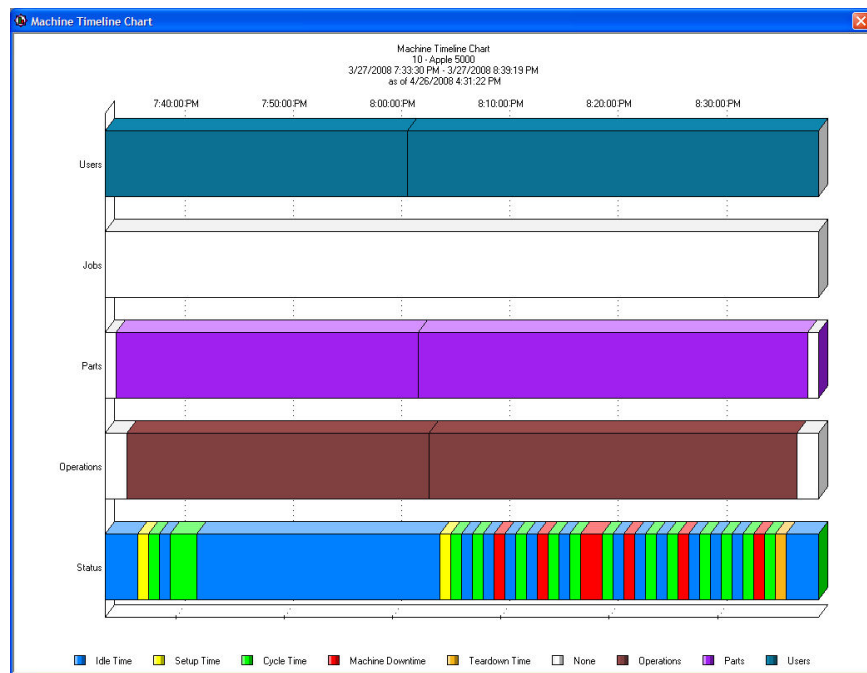
New! Machine and Job Status Panel

A new machine status and job status panel has been added to the left hand side of the application. This panel is updated every X seconds to provide real-time summary status of the number of machines in setup, cycle, down, idle and teardown. In addition it shows the percentage of time spent in each status for today. Finally, the panel shows the number of jobs that should have started and finished along with the number of jobs that actually started and finished. These job summaries are shown for today and for the current week.

NOTE: Machine Status Panel is not available with Predator MDC Express.

New! Machine Timeline Chart

A new real time machine status chart has been added to Predator MDC v8. Left clicking on each section of the stacked bar will display a tool tip for the individual user, job, part, operation, idle, cycle, setup, down and teardown. Right clicking on one or more elements with the chart selects the item and then selecting Zoom will zoom into the item's timeline.

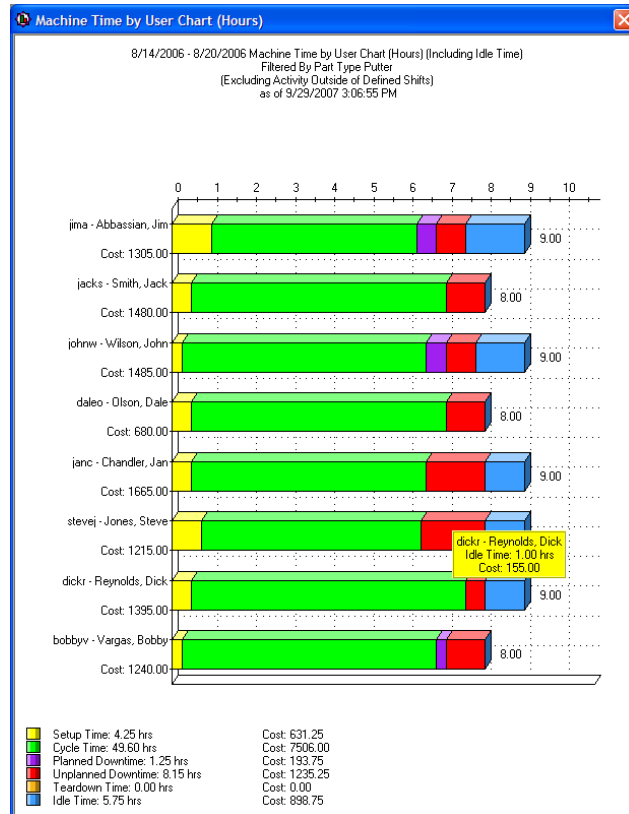


The above chart has a landscape orientation to facilitate longer time lines. If the number of events is significant or the event's length of time is short then a lot of black lines will be shown until you leverage the Zoom feature of this chart.

NOTE: Machine Timeline Chart is not available with Predator MDC Express.

New! 20 Machine Time and Cost Charts

Twenty new stacked bar charts displaying machine costs and time have been added to Predator MDC v8. Clicking on each section of the stacked bar will display a tool tip for the individual idle, cycle, setup, down and teardown. Charting costs or time is supported and the chart can be grouping by department, location, group, machine, shift, user, part type, part, job and operation. Finally, all charts can optionally chart time or costs as a percentage.



New! 250 Performance Ranking Charts

Seven new Performance Ranking groupings have been added including By Department, By Location, By Group, By Part Type, By Part, By Job, and By Operation. In addition, ten new performance ranking charts have been added including Finished Cycles, Machine Downtime, Machine Downtime Percent, Total Cycles, Total Downtime, Total Downtime Percent, Total Parts, Unfinished Cycles, User Downtime and User Downtime Percent. Between the new groupings and charts over 250 new charts have been added. A total of 460 performance ranking charts can now be displayed with Predator MDC v8.

New! 10 Trend Analysis Charts

Ten new trend analysis charts have been added to Predator MDC v8 including Finished Cycles, Machine Downtime, Machine Downtime Percent, Total Cycles, Total Downtime, Total Downtime Percent, Total Parts, Unfinished Cycles, User Downtime and User Downtime Percent. A total of 46 trend analysis charts can now be displayed.

New! User Command Line

A new command line argument has been added to automatically specify the user name for the login. For example:

```
pmdc.exe -user jima
```

New! Password Command Line

A new command line argument has been added to automatically specify the password for the login. For example:

```
pmdc.exe -password predator
```

NOTE: The user and the password can be combined in a single command line. For example:

```
pmdc.exe -user jima -password predator
```

New! View Machine Status Command Line

A new command line argument has been added to automatically start the Machine Status view. For example:

```
pmdc.exe -machinestatus
```

NOTE: Multiple command line arguments can be combined in a single command line. For example:

```
pmdc.exe -user jima -password predator -machinestatus
```

New! View Jobs Command Line

A new command line argument has been added to automatically start the View Jobs. For example:

```
pmdc.exe -viewjobs
```

NOTE: Multiple command line arguments can be combined in a single command line. For example:

```
pmdc.exe -user jima -password predator -viewjobs
```

New! View Parts Command Line

A new command line argument has been added to automatically start the View Parts. For example:

```
pmdc.exe -viewparts
```

NOTE: Multiple command line arguments can be combined in a single command line. For example:

```
pmdc.exe -user jima -password predator -viewparts
```

New! Shop floor Command Line

A new command line argument has been added to automatically to allow Predator MDC Administrators to run as a Predator MDC Shop floor license. For example:

```
pmdc.exe -shopfloor
```

New! Client Command Line

A new command line argument has been added to automatically allow Predator MDC Administrators to run as a Predator MDC Client license. For example:

```
pmdc.exe -client
```

New! View Jobs Toolbar Button

Predator MDC v8.0 includes a new View Jobs toolbar button.

New! View Parts Toolbar Button

Predator MDC v8.0 includes a new View Parts toolbar button.

New! Automatic Job Release

Predator MDC v8.0 includes a new checkbox option to automatically release jobs during the New Job and Edit Job wizards.

New! Release Job to Shop Floor Shortcut

Predator MDC v8.0 includes a new shortcut (right mouse menu) option to Release Job to the Shop Floor within the View Jobs dialog.

New! Finish Job Shortcut

Predator MDC v8.0 includes a new shortcut (right mouse menu) option to Finish Job within the View Jobs dialog.

New! Consolidate/Drill Down Chart Preference

Consolidate/Drill Down Chart preference has been added within Predator MDC v8.0 which is automatically saved per user.

New! 2D/3D Chart Preference

A new modal 2D/3D Chart preference has been added within Predator MDC v8.0 which is automatically saved per user.

New! Horizontal/Vertical Chart Preference

A new modal Horizontal/Vertical Chart preference has been added within Predator MDC v8.0 which is automatically saved per user.

New! Shortcut Menus to view 29 charts from View Machine Status

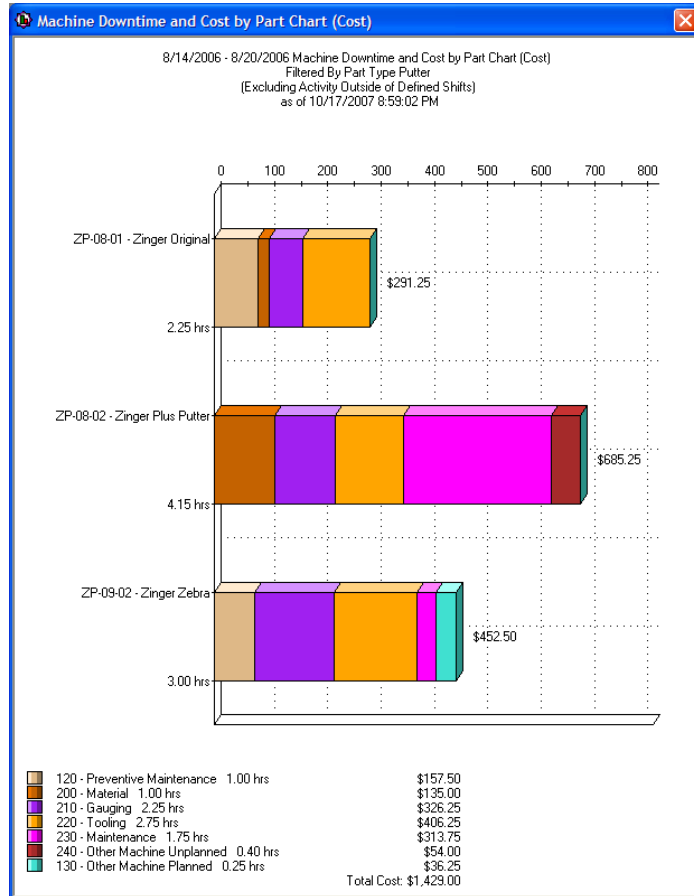
When viewing the Machine Status a new right mouse menu has been added to the resource tree as a shortcut to 29 popular charts with pre-selects for the highlighted resource with the current day as the date range.

New! MDC for Haas Object

A new MDC for Haas Object, provides automatic idle time, cycle time, machine alarm, single block and feed hold status. Additional options include using the Haas parts counter to automatically indicate good parts and the program number for part numbers. Optionally a user can be automatically logged on and off when the Haas machine is powered on and off. This object does not require a Predator MDC Adapter or any third party hardware to be installed and works with all Haas CNCs with version 11 or newer. This new object can be combined with Remote Autaname/Remote Start commands as well.

New! 20 Downtime and Cost Charts

Twenty new stacked bar charts displaying downtime costs and time have been added to Predator MDC v8. Clicking on each section of the stacked bar will display a tool tip for the individual downtime reasons. Downtime costs or time is supported and the chart can be grouping by department, location, group, machine, shift, user, part type, part, job and operation. Finally, all charts can optionally chart downtime or costs as a percentage.



New! Shifts per Machine Chart

A new Shifts per Machine chart has been added to Predator MDC v8. This administrator only chart is designed to simplify management of complex shift assignments.

New! 10 Machine Cost Reports

Ten new Machine Cost reports have been added to Predator MDC v8.0. Costs for machine time, cycle time, setup time, teardown time and idle time are detailed. The reports can be grouped by department, location, group, machine, shift, user, part type, part, job and operation.

New! 8 Machine Time Reports

Eight new Machine Cost reports have been added to Predator MDC v8.0 for a total of ten. Hours for machine time, cycle time, setup time, teardown time and idle time are detailed. The reports can be grouped by department, location, group, machine, shift, user, part type, part, job and operation

New! 6 Production Details Reports

Six new Production Details reports have been added to Predator MDC v8.0 for a total of ten. Quantities for good parts, scrapped parts, quality and parts per hour, etc. are detailed. The reports can be grouped by department, location, group, machine, shift, user, part type, part, job and operation

New! Average Part Time Report

A new Average Part Time report has been added to Predator MDC v8.0. This is similar to the Average Cycle Time report.

New! Menu Permissions

Administrators can control access to the new reports and charts via new menu permissions. These permissions can be set per user, group or combination.

New! Chart Keyboard Shortcuts

All charts that display multiple pages or sets can be navigated with the home, end, pgup and pgdn keys.

New! Background Option

A new optional background image has been added. The default image is a MDC work flow image. This image can be customized by replacing pmdc.bmp within the MDC 8.0 folder. Background images can be toggled on and off with the Option > Background menu and it also can be managed with permissions.

Improved! International Style Date Formats

All dialogs, reports and charts have been improved to support a wider range of international date formats and styles.

Improved! Productivity Chart

The productivity chart has been improved with a more readable legend and the total cost has been added. Finally, costs are displayed for all filter options.

Improved! Scrap Chart

The scrap chart has been improved with a more readable legend and the total number of scrapped parts has been added.

Improved! Machine Service Chart

The machine service chart has been improved with a more readable legend and the total number of hours has been added.

Improved! Performance Ranking Charts

The performance ranking charts have been improved with total hours or total quantities.

Improved! Chart Labels

All bar charts have been improved with better positioning of the chart labels for improved readability.

Improved! Predator MDC Service

The Predator MDC Service has been improved for faster performance. Real-time summarization is now 2 – 50 times faster than previous versions. In addition a more intelligent service startup allows for slow database startup. This can often occur when the database and the Predator MDC Service are installed on the same PC.

The MDC Service has also been improved to better support complex shift assignments per machine and inappropriate end events are automatically ignored.

Improved! MDC Objects

Three MDC Objects, one for each database, have been improved with a new configurable cycle end time. This allows for machines that have extensive material handling requirements or when cycle time monitoring needs to be adjusted. Common applications including monitoring the torch, laser, burn, or plasma operation with a Predator MDC Adapter or PLC.

In addition, support for negative scrap has been added. Negative scrap is automatically subtracted from good parts. This feature can simplify the data collection process by allowing machines to automatically assume good parts per cycle.

Improved! View Machine Status

Predator MDC v8.0 improves the machine status by automatically saving all preferences per user upon exiting of the application. New preferences allow individual columns and the resource tree to be hidden. New options for changing the font, time and status colors have been added. These new features are designed to support LCD and Plasma based digital signage. New Status filters have been added so only machines that are in setup, cycle, teardown, idle or down can be displayed.

Improved! Select Shifts per Machine

A new filter has been added to the Select Shifts per Machine wizard to simplify assigning complex shift assignments.

Improved! Print Bar Code Labels

Bar Code labels have been improved for better readability. In addition, User bar codes now display first and last name.

Improved! Chart Dates

All bar charts have been improved with better positioning of the chart dates, days of the week and other date ranges for improved readability.

Improved! Chart Costs

All charts that display costs in the legends have been improved to display total costs when multiple machines are included within the filters. This eliminates the N/A that was often displayed in previous versions.

Improved! Average Cycle Time Report

Within Predator MDC v8.0 the average cycle time report has been improved with an additional column for total cycles.

Improved! Machine Time Report

Additional filters for part type and part have been added to the machine time report within Predator MDC v8.0.

Improved! View Components

Predator MDC v8.0 improves the 16 different View Components dialogs by adding a dynamic search feature. Searching defaults to the component number field. By clicking any field, Predator automatically sorts the components and changes the search field. The search field is dynamic with each keystroke so as soon as a match is found the component is automatically highlighted. Within the search field the following special characters can be used * for wildcards, > for greater than, < for less than, >= for greater than or equal, and finally <= for less than or equal. For example, typing ST will automatically jump to the first component that starts with an ST including STAR, STARRET etc. If you typed *ST then the following components will be found 1000ST, 41ST etc. The greater than and less than special characters require numeric or date fields.

In addition the direction of column sorting defaults to ascending A-Z if descending Z-A sort order is desired simply click the column a second time.

Finally, when using the New and Edit shortcuts the dialog is now automatically centered within the application window.

Improved! Time and Attendance Report

Within Predator MDC v8.0 the time and attendance report has been improved with sub totals per department and a grand total.

Improved! Logon

Within Predator MDC v8.0 the login is automatically remembered from the previous session so only the password has to be entered each time. In addition, a Caps Lock and Num Lock reminder has been added.

Improved! Chart and Report Performance

Within Predator MDC v8.0 the time to summarize and display charts and reports has been significantly improved. This is especially true when large date ranges have been selected. Some charts and reports are 2 – 50 times faster than previous versions of Predator MDC.

Improved! New Event

Predator MDC v8.0 adds machine status color and a real-time display of elapsed time. In addition a display of user downtime reasons has been added. USB and keyboard style based bar code support has been added. F2-F12 function key support has been added to start each event and CTRL+F2 through CTRL+F12 function key support has been added to stop each event. Finally, any user can logon to any machine. Previously only the logged in user could logon to a machine.

Finally, support for negative scrap has been added. Negative scrap is automatically subtracted from good parts. This feature can simplify the data collection process by allowing machines to automatically assume good parts per cycle.

Improved! Fix Data Collection Errors

Fix data collection errors has been improved to support fixing a subset of data collection errors by closing early without requiring the user to step through every error and complete the entire wizard. In addition, less memory is required when dealing with a large number of data collection errors.

Improved! Report Totals

All report totals have been standardized to immediately follow the group footer vs. the bottom of the last page.

Improved! Import Data

Importing of CSV files has been improved to provide a progress bar and support for a greater number of components with less memory requirements. Importing a CSV file is now a two step process with the first step analyzing the CSV file for formatting issues and duplicates. The second step imports the actual data into the database.

Improved! MDC APIs

Additional APIs (application programming interfaces) have been added and several existing ones have been improved. Refer to the MDC API specific help file for additional details.

Improved! Extended Desktop Support

All reports, forms and the application itself will automatic re-position their windows when the position of any extended desktop monitor is moved or eliminated.

Improved! HTML based Online Help

Updated online help expands several topics with new details.

Improved! Floating Network Licensing

v8.0 of Predator MDC eliminates the three seat minimum requirement. A single license can be floated if desired.

Improved! MDC Express Splash Screen

v8.0 of Predator MDC Express displays the appropriate splash screen when launched from the command line.

Bug Fix! Fix Data Collection Errors

Fixed a bug adding new components within the Fix Data Collection Error dialog within Microsoft SQL Server and Oracle.

Bug Fix! Initial Login

Fixed a bug when performing the initial login on a Windows workgroup style network running Microsoft SQL Server Express.

For the latest on Predator MDC, check our web site at

<http://www.predator-software.com>