B-DAQ to Bypass NDC-Plus
Instructions
December 14, 2007

Current versions of B-DAQ have the capability to transfer data to the Primac system without the need to route the data through the NDC-Plus Shop Floor Data Collection system (SFDC).

In order to do this there are a number of Telnet interface programs that need to be installed on the Primac computer. The DataLoad.ini file on the server also needs to change to allow DataLoad to transfer the associated records via the network.

Please follow the procedure sequentially and do not proceed until all prior steps have been successfully completed. If you have any problem with this change, please call NASTech at (888) 962-7832, Monday through Friday, between the hours of 8:30 am and 5:30 pm CST.

Prepare Primac Computer

- Create a **TELNETBP** file in CBA account if not already present. (CREATE.FILE DIR TELNETBP)
- Download **TELNETBP.zip** from the following link: http://www.nastechinc.com/SUPPORT/NDCSupport/Upgrade/TELNETBP.ZIP
- **UPPER AND LOWER CASE MATTERS WHEN YOU TYPE THE URL. YOU WILL NEED YOUR USERNAME AND PASSWORD TO ACCES THE FILE AS WELL.**
- Un-zip the telnet programs and store them in **TELNETBP**.
- There are two programs for TELNET.ROLL.SKID.INFO, TELNET.ROLL.SKID.INFO.11 and TELNET.ROLL.SKID.INFO.12.
  a. If you are on Primac revision 12, type, **COPY FROM TELNETBP TELNET.ROLL.SKID.INFO.12,TELNET.ROLL.SKID OVERWRITING**.
  b. For any other revision of Primac, use the TELNET.ROLL.SKID.INFO.11 program, type, **COPY FROM TELNETBP TELNET.ROLL.SKID.INFO.11,TELNET.ROLL.SKID OVERWRITING.**
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- Compile all the telnet programs using **PBASIC**.
  a. In the CBA directory at the colon prompt, type, **SELECT TELNETBP WITH @ID UNLIKE "_…"**
  b. At the ">" prompt, type **PBASIC TELNETBP**
- Create a user, password and **.profile,** if not already present, to log into TCL in JCS account or to main directory if running Rev 11 or later.
- Create a dictionary item in the INVENTORY file called "PDAQ_TYPE" as follows:
  - 001:1
  - 002: F5; @ID; @2[1,3]; @1;OCONV(@4,"TCATEGORY;X;8;8"); IF @5 = "L" OR @5 = "S" OR @5 = "1" THEN "Y" ELSE "N"
  - 003:
  - 004: /
  - 005: 1L
  - 006: S

- Modify **LOGIN** record in the **VOC** file to invoke the **TELNET.SERVER** program. The *username* in the first line should match the user ID created above.
    - IF %1 = "*username*" GO 600
    - GOTO 700
    - 660 C
    - HTELNET.SERVER
    - P
    - HBYE
    - P
    - 700 C

- Test by logging on to the new user created. No questions should be asked other than the password. If everything is OK, you will see a question mark. Typing **END** should log you off. (The program running has ECHO turned off, so you will not see what you type)
- Access the Download Maintenance screen in the Shop Floor menu. Create a **DOWNLOAD** record with the network ID equal to 250 minus the company number. For example: if your company number is 003 then the network ID will be 247. Set port number to 99 or another spare port number.

Disconnect TIM2B

- Allow the operator to finish the current form.
- When the form is complete, press the **End of Run** button on the B-DAQ Main screen.
- With B-DAQ running, open the TranLog table in the Stats.mdb database on the PC with Microsoft Access. Ensure that the status of all records in the TranLog are marked as complete in the status column. If they are not, wait until they get completed by SFDC before proceeding.
- In DataSync, click the "Scan" heading and allow DataSync to scan all tables.
- Once all TranLog records are complete, and DataSync has scanned all records, terminate B-DAQ by pressing the **Terminate** button.
- Terminate DataSync.
- Disconnect the TIM2B from the PC Serial Port, and from the SFDC network.
- On the Server, execute **DS-Pause** from the **BDAQ\Shared** directory, do NOT click the Resume button until you have read through this entire document.
- Execute B-DAQ and DataSync at the press. The operator can continue using the system at this time.

Modify Server Databases

- Modify the **PalletLog**, and **EmpLog**, tables on the server using the following procedure:

    o Using Microsoft Access, open the **BDAQ.mdb** (SQL Users) or **Stats.mdb** (non SQL Users) database on the server.
    o Open the associated table.
    o Filter to view ONLY those records that match the Cost Center you have just disconnected from SFDC. After filtering, scroll through all of the records to make sure that there are NO records for any other Cost Center present before proceeding.
    o Click the **Status** column heading to select all status column entries for all records.
    o Using the Find/Replace command, replace all RELEASE entries with a capital C.

Modify Bindery.ini

- Open **Bindery.ini** from the associated **BDAQ\B-###** directory on the server.
- In the **[Shop-Floor Interface]** section, change to port parameter to **Port = 0**.
- Save the file.

Modify DataLoad.ini

- Download DataLoadTEMP.ini from the following link, and save it to the **Shared\Init** directory on the server:
  http://www.nastechinc.com/SUPPORT/BDAQSupport/DataLoadTEMP.ini
- Make a backup copy of the DataLoad.ini file located in the **Shared\Init** directory on the server. Name this file DataLoadCOPY.ini.
- Open DataLoad.ini from the **Shared\Init** directory.
- Modify the DataLoadTEMP.ini file using your DataLoad.ini parameters.
- Save DataLoadTEMP.ini, and Delete DataLoad.ini.
- Rename DataLoadTEMP.ini to DataLoad.ini.
- The processes called LaborUpload and PalletUpload are the processes that take the place of shop floor.
- The 14th parameter of each of these tables defines the cost center. Add the 3 digit cost center you are converting to the 14th parameter in the LaborUpload and PalletUpload sections. The current default value is "NULL".
- As you convert each press, you will have to add the associated press to each of these 3 tables. Multiple cost centers are to be separated by carrots. (IE… 201^202^203)
- Each time DataLoad.ini is modified, DataLoad.exe must be terminated and re-executed to accept the change.

Final Steps

- On the Server, click the **Resume** button in **DS-Pause** to resume DataSync.