Press Management For Digital Presses

NASTech, Inc.

User Guide

Version 6

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Table of Contents

Chapter 1 Introduction

The ***NASTech*** **Pressroom Data Acquisition** system **(P-DAQdp)** performs real-time data acquisition using advanced electronic press monitoring techniques.

P-DAQdp is comprehensive system designed to provide management at all levels with the information needed to ensure maximum pressroom efficiency.

P-DAQdp supports all aspects of pressroom management including press productivity, performance, waste tracking, paper usage, ink usage and accurate skid counts. A real-time press status module increases efficiency in many areas outside the pressroom as well.

Many years of experience have gone into the design and development of this system. Simplicity, flexibility and high availability were the main criteria under which the software was developed. The system utilizes all the latest technology to provide a sound and long term solution for your business.

NASTech is committed to designing and developing the highest quality software possible and are confident that you will enjoy working with **P-DAQdp.** We look forward to working with you and wish you every success in the future.

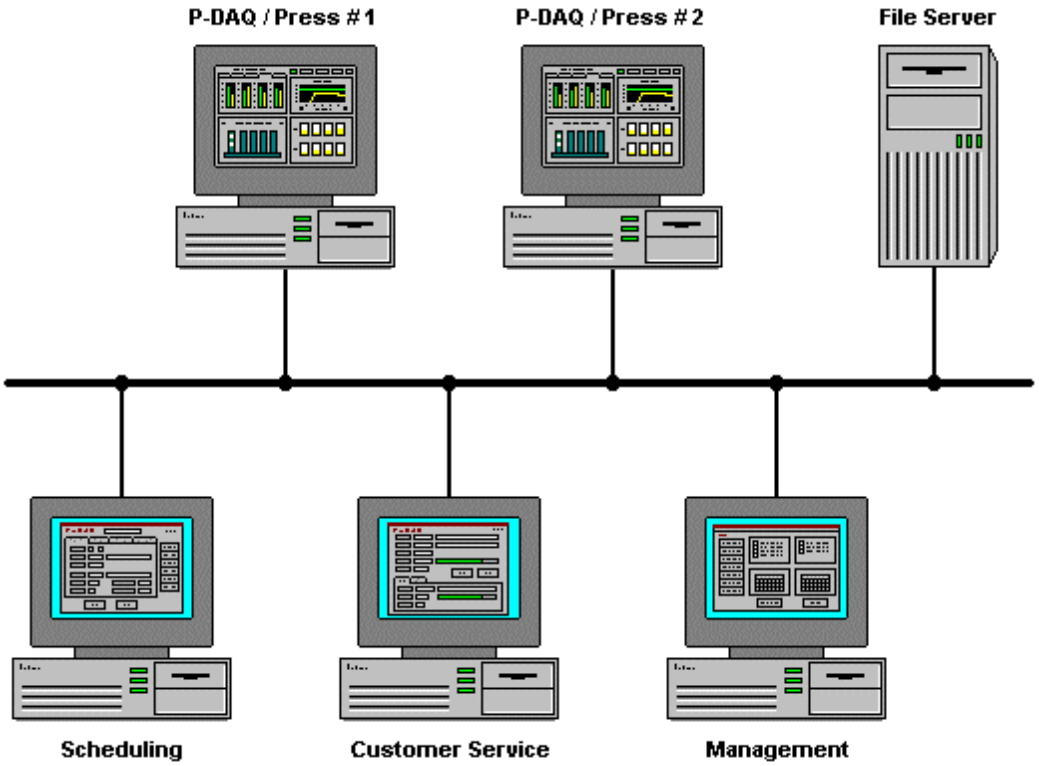
Visit our web site at www.nastechinc.com for current news and updates.

Overview

P-DAQdp consists of four primary modules, all operating together to provide the highest level of real-time data possible without compromising the fail-safe requirements of the system. Using our unique Bi-directional Data Synchronization Technology, (BDST), the local and remote databases are continuously synchronized.

- The **Press Module** collects real-time data from each press. The pressman records labor and down-time reason codes. Waste, paper consumption and ink usage are also tracked.
- The **Scheduling Module** is used to define the requirements of the jobs prior to going to press. Data may be provided automatically by an installed scheduling system.
- The **Press Status Module** is used throughout the company to view real-time pressroom status information.
- The **Management** / **Reporting Module** is used to define the various master files used by the system and to produce the various charts and reports necessary to track and measure pressroom performance.

The **File Server** contains databases common to all modules. The Management computer may be used as the server on small Peer-to-Peer networks.



System Features

- Utilizes standard PC computer hardware
- Microsoft Windows-NT/2000/XP/Vista/7 graphical interface
- Touch-screen technology
- Client / Server technology
- Shop-floor data collection interface

Basic Measurements

- Gross impression count / Feet of Paper
- Press speed
- Good count
- Employee Time

Statistics

(Maintained by press, by date, by shift, and by job)

- Makeready I time
- Makeready II time + gross + waste
- Run time + gross + waste
- Down time + waste (by reason code)
- Number of unscheduled stops
- Good count by job

Events Recorded

- Shift change
- Form started
- Makeready I started
- Makeready II started
- Run started
- Press stopped
- Press re-started
- Press speed change
- Count complete
- Form complete

Chapter 2 Hardware Installation

Hardware components necessary for data acquisition are provided and vary depending on the actual press configuration and the features to be implemented.

NASTech Supplied Devices

NASTech is responsible for providing the following hardware devices when applicable:

- EP210 DAQ device(s)
- Press Interface Module Electronics.
- Various cables as outlined on the System Cabling page of this guide. (Chapter 2 - Page 12)

Customer Supplied Devices

P-DAQDP utilizes standard PC hardware. Since the printing press is being monitored in real-time, the faster the press the faster the computer should be. The customer is responsible for providing the following hardware devices:

- **Server computer:**
  - At Least a 450 MHz CPU, 40GB HD, 128MB RAM.
  - SVGA Video Card, Network Interface Card..
  - Data Back-Up device.
- **Press Computers:**
  - At Least a 450 MHz CPU, 40GB HD, 128MB RAM.
  - SVGA Video Card, Network Interface Card.
  - Serial Port.
- Sensors, Buttons, Switches and associated Electrical wiring.
- Various cables as outlined on the System Cabling page of this guide. (Chapter 2 - Page 12)

Electrical Outlets

- The customer is responsible for providing power to the system.
- EP210 DAQ devices require AC outlets.
- AC power outlets are also required for the Laser Printer (Optional).

Input Signals

The customer is responsible for providing all input Sensor, PLC, and Control connections between the press and the **P-DAQDP Press Interface Module**. (Note: All input wiring should be shielded to prevent noise)

The input signals to be used vary depending on the configuration of the press and the features of **P-DAQdp** to be utilized. This section outlines the available options, and explains some common installation procedures. Upon installation, more detailed instructions and the necessary wiring diagrams will be provided.

Gross Impressions

- **Gross Count** - Encoder to record pulses used to gross feet of paper, and to derive press speed.

Net Impressions

- **Divert Gates** - A sensor or **PLC** signal that indicates that the divert gate is closed.

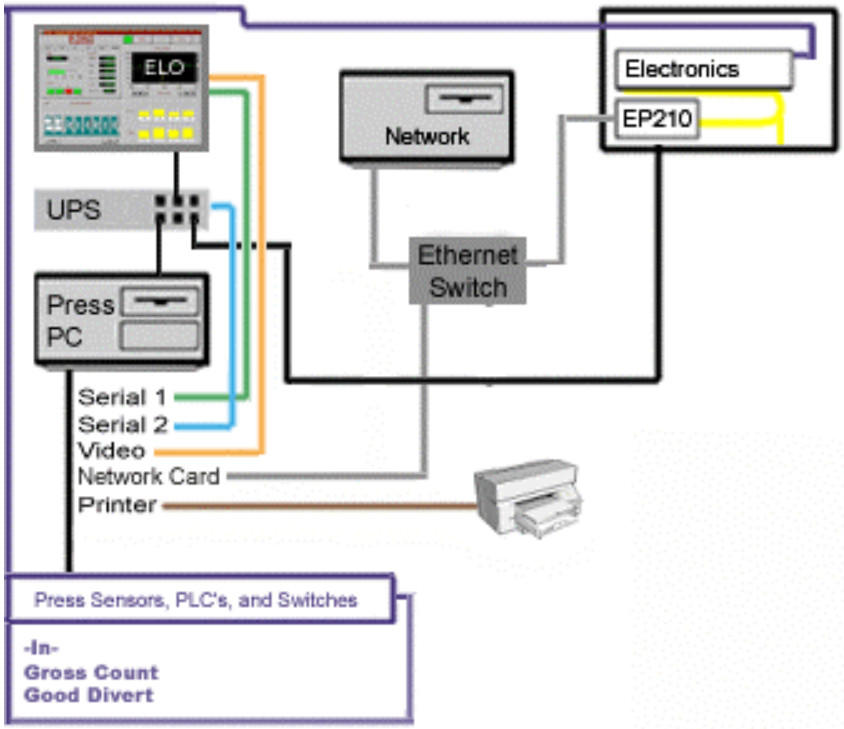
Install Press Computer Devices

- Install the network interface card. Refer to manufacturer's documentation for details.
- Install the ELO Touch monitor software and configure. The monitor should be configured to use Serial Port 1. Refer to ELO's documentation for more details.
- Install the Laser Printer and software drivers. Refer to the Manufacturer's documentation for details.

System Cabling

EP210 DAQ

The following diagram illustrates the basic cabling requirements of the press management system utilizing a sub-network of EP210 Data Acquisition cards and Ethernet connectivity to scales.



Electrical Wiring, supplied by user.

Video Cable, M14 to M14 supplied by manufacturer.

Serial Cable, F9 to M9 supplied by manufacturer. (ELO)

Serial Cable, F9 to M9 supplied by manufacturer. (UPS)

Serial Cable, F9 to F9 supplied by NASTech.

CAT5 Cables (straight through), supplied by user.

Printer Cable supplied by manufacturer.

Chapter 3 Software Installation

NASTech Supplied Software

NASTech is responsible for providing the following software:

- P-DAQdp Installation programs.

Customer Supplied Software

The customer is responsible for providing the following software:

- **Server computer**
  - Windows Server / XP / Vista / Windows 7.
  - Microsoft Access (Optional).
  - Microsoft SQL Server. (Optional)

- **Press Computers:**
  - Windows XP / Vista / Windows 7.

Initial Installation

P-DAQdp is installed onto your hard disk using a special installation program. The contents of the installation CD may be copied to your file server to simplify the installation for multiple presses. This must be the method used if a CD-ROM drive is not available on the **P-DAQdp** press computer(s). The **P-DAQdp** directory on the file server into which the system is installed must have read/write access from each of the client computers.

Server Installation

- Set **Control Panel** \ **Regional Settings** \ **Short Date** to “MM/dd/yy” and enter the correct date.
- Set **Control Panel** \ **Regional Settings** \ **Time** to “HH:mm:ss” and enter the correct time.
- Execute **PDAQdp-ServerInstall.exe** and follow the directions on the screen to set up **P-DAQdp**.
- Note: After Installation, you may be prompted to restart the server as various DLL and OCX files may need to be registered in Windows. You may continue the installation and schedule this restart at a more convenient time if necessary.
- Copy **PDAQdp-ServerInstall.exe** program and the press and client installs to the **PDAQdp\Install** directory.
- Copy all the **P-###** directories received from NASTech to the **PDAQdp** directory.
- Install SQL Database Software. Refer to Microsoft’s documentation for more information (Only if you will be using SQL databases).

Server Configuration

- Open the "**System.ini**" file located in the **C:\PDAQdp\Shared** directory. Edit and save the file as follows:
  - Init Path = "Init"
  - Local Base Path = "\PDAQdp"
  - Network Base Path = "*YourServer*\PDAQdp"
  - ' DBTYPE = "SQL" (If you are using a SQL server Database, remove the ' (apostrophe) at the beginning of the line.
- Edit **Security.ini** in the **PDAQdp\Shared\Init** directory. This will allow users to have read/write access to various programs. For example:
  - [P-Sched]
  - Default = "Read"
  - Administrator = "Update"
  - JOHN SMITH = "Update"
- Edit **DataPurge.ini** in the **PDAQdp\Shared\Init** directory. DataPurge.exe allows redundant data to be deleted from the server. The entries made to this file should be specified in military time, a short period of time right after the scheduled network backup. The "**DataPurge.exe**" file may be left running on the server at all times, or you may schedule the task using Windows Scheduler to perform the purge on a weekly or monthly basis. For example:
  - BegPurgeTime = 05:00
  - EndPurgeTime = 06:00
- Edit **DataSync.ini** in the **PDAQdp\Shared\InitPress** directory. "DataSync.exe" automatically transfers data to and from each press computer and the server. While this is a necessary function of the system, data should not be transferred while the server is performing its scheduled backup. The entries made to this file should be specified in military time, as a window of time at which the network backup occurs. For example, if the network backup begins at 2AM:
  - Beg Save Time = 01:00
  - End Save Time = 04:00

- Run **P-Maint.exe** from the **PDAQdp\Shared** directory and update the Following Tables. These tables may be set up by NASTech personnel prior to installation. (For more help on running **P-Maint**, refer to the **Utilities** section of this guide):
  - Press
  - Cost Center
  - OperCode
  - Form Type
  - Employee
  - Product

Server SQL Setup

- (Skip this section if you are not running SQL server).
- Install Microsoft SQL Server on P-DAQDP Server.
- Execute “Start…Programs…Microsoft SQL Server…Query Analyzer”.
- Open “P**DAQdp\Shared\Database\PDAQ6.SQL**”.
- Execute SQL script to create **PDAQ** database(s).
- Set permissions for P-DAQDP press and client computers.
- Execute “Start…Programs…Microsoft SQL Server…Import and Export Data”.
- If importing from Access Databases:
  Select Source = Microsoft Access =
  “PDAQdp\Shared\Database\Remote.mdb”.
- If importing from SQL Databases:
  Select Source = Microsoft SQL = “PDAQdp\Shared\Database\”.
- Select Destination = “PDAQdp” database.
- Select ALL tables. Un-select ALL Queries.
- Continue with import.
- Execute “Start…Programs…Microsoft SQL Server…Import and Export Data”.
- Select Source = Microsoft Access =
  “PDAQdp\Shared\Database\Stats.mdb”.
- Select Destination = “PDAQdp” database.
- Select ALL tables. Un-select ALL Queries.
- Continue with import.

Press Installation

- Set up a user on the machine as an administrator.
- Log Into the machine with the user you just created.
- Set **Control Panel** \ **Regional Settings** \ **Date** to “MM/dd/yy” and enter the correct date.
- Set **Control Panel** \ **Regional Settings** \ **Time** to “HH:mm:ss” and enter the correct Date & Time.
- Execute **PDAQdp-PressInstall.exe** and follow the directions on the screen to set up the **P-DAQdp Press Module.**
- Open the “**System.ini**” file located in the **C:/Program Files/PDAQdp** directory. Edit and save the file as follows:
    - Init Path = "Init"
    - Local Base Path = "C:\Program Files\PDAQdp"
    - Network Base Path = "*YourServer*\PDAQdp"
    - ‘ DBTYPE = "SQL" (If you are using a SQL server Database, remove the ‘ (apostrophe) at the beginning of the line.

Press SQL Setup

- Create ODBC Data Source Name (DSN) called **PDAQdp** for new PDAQdp SQL Server database.
    - Start - Settings - Control Panel - Administrative Tools - Data Sources - ODBC. Click “**Add**”. Select **SQL Server**, Click “**Finish**”.
    - Name the database (PDAQdp), and select the NASTech Server.
    - NT or SQL authentication? It is recommended that NT authentication is used. If so, the NT password setup on the computer will allow access to the SQL database.
    - NT or SQL authentication? If SQL authentication is used, the following lines of code MUST be added to the **C:/ProgramFiles/PDAQdp/System.ini** file:
        - DB Name = PDAQdp
        - Database = PDAQdp
        - User Name = *your computer’s User Name*
        - Password = *your SQL Password*

- Click "**Change Default DB to**", Select PDAQdp Database, Click **Next**.

Start P-DAQdp-Press

- Go to **Start Menu → Programs → P-DAQdp-Press Module → SysUpd**, right-click the **SysUpd** icon and select **Properties**. Edit and save the shortcut as follows:
  - Target: *YourServer*/PDAQdp/Shared/SysUpd.exe
  - Start In: C:/Program Files/PDAQdp/
- Run **Start Menu → Programs → PDAQdp-Press Module → SysUpd** and click the **Update** button.
- Run **DataSync** from the Desktop and click the **Continue** button.
- Data Sync will now transfer data from the server and populate the **Remote** database at the press. Please allow a few minutes for this process to take place.
- Start **P-DAQdp**, when prompted; enter the pallet ID format as B0000000. NASTech personnel will provide a list of pallet ID numbers prior to installation. You may also find the load ticket format in the associated Pressman.ini file located in the C:\Program Files\ PDAQdp\Init directory.

Client Setup

- Execute **PDAQdp-PressInstall.exe** and follow the directions on the screen to set up the **P-DAQdp Press Module.**
- Open the "**System.ini**" file located in the **C:/Program Files/PDAQdp-Client** directory. Edit and save the file as follows:
  - Init Path = "Init"
  - Local Base Path = "C:\Program Files\PDAQdp-Client"
  - Network Base Path = "*YourServer*\PDAQdp"
  - ' DBTYPE = "SQL" (If you are using a SQL server Database, remove the ' (apostrophe) at the beginning of the line.

Client SQL Setup

- Create ODBC Data Source Name (DSN) called **PDAQdp** for new PDAQdp SQL Server database.
  - Start - Settings - Control Panel - Administrative Tools - Data Sources - ODBC
  - Click "**Add**". Select **SQL Server**, Click "**Finish**".
  - Name database (PDAQdp), and select NASTech Server.
  - NT or SQL authentication? It is recommended that NT authentication is used. If so, the NT password setup on the computer will allow access to the SQL database.
  - NT or SQL authentication? If SQL authentication is used, the following lines of code MUST be added to the **C:/ProgramFiles/PDAQdp-Client/System.ini** file:
    - DB Name = PDAQdp
    - Database = PDAQdp
    - User Name = *your computer's User Name*
    - Password = *your SQL Password*
  - Click "**Change Default DB to**", Select PDAQdp Database, Click **Next**.
  - Test the connection.

Start PDAQdp-Client

- Go to **Start Menu → Programs → PDAQdp-Client Module → SysUpd**, right-click the **SysUpd** icon and select **Properties**. Edit and save the shortcut as follows:
  - Target: *YourServer*/PDAQdp/Shared/SysUpd.exe
  - Start In: C:/Program Files/PDAQdp-Client/
- Run **Start Menu → Programs → PDAQdp-Client Module → SysUpd** and click the **Update** button.
- Start **P-Sched**, **P-Status**, and **P-Admin**, from **Start Menu → Programs → PDAQdp-Client**

Add Shortcuts

- You should also create a folder on the desktop called **PDAQdp**. Add the following to the folder:
  - Shortcut to **P-Admin**
  - Shortcut to **P-Status**
  - Shortcut to **P-Sched**
  - Shortcut to our **Website** which is www.nastechinc.com
  - Shortcut to a new file called **"Password.txt"** (Create this file, add the following text, and save):
    - Username = *yourcompanyname* (all lowercase)
    - Password = support
- Let the users know that our **UserGuide** is available for viewing online. If you open it online versus downloading it, the worddoc contains hyperlinks in the Table of Contents. All of the report calculations are available there.

Software Updates

Customers will be notified by email when software updates are available for download. It is recommended that you update the software within a reasonable time frame as to avoid redundant support issues.

Manual Updates

Manual Updates to the software are handled as follows:

1. Delete all files from the **PDAQdp**/**Shared**/**SoftwareUpdate** directory.
2. Download and save the .zip file to the **PDAQdp**/**Shared**/**SoftwareUpdate** directory.
3. Unzip the downloaded file and save its contents to the **PDAQdp**/**Shared**/**SoftwareUpdate** directory.
4. Run **Install.bat** from the **PDAQdp**/**Shared**/**SoftwareUpdate** directory and wait for completion.

5. Run **DataComp.exe** from the **PDAQdp/Shared** directory, and click the **Continue** button. If database field mismatches are present...

    - With SQL 2003 and prior: Run the included **Update2003.SQL** script in **SQL Query Analyser**, and run **DataCopy.exe** from the **Start Menu** at EACH press between forms.
    - With SQL 2005: Run the included **Update2005.SQL** script in **SQL Query Analyser**, and run **DataCopy.exe** from the **Start Menu** at EACH press between forms.
    - Without SQL: Run **DataCopy.exe** from the **PDAQdp/Shared** directory on the server, and from the **Start Menu** at EACH press between forms.

6. **Client PC Update:** The updated files will be transferred and installed at each client computer automatically when each associated program is terminated and re-executed.

7. **Press PC Update:** The updated files will be transferred and installed at each press computer automatically between forms, or to select press computers as per the entries in the **Update.ini** file.

8. **SysUpd.exe:** The updated files may be transferred and installed manually to each Press/Client computer by running the **SysUpd.exe** program at the associated computer. NOTE: This option overrides the Update Day and Time parameters added to the Pressman.ini file.

Initialization File

The **Pressman.ini** file is used to set the editable parameters of the system. NASTech will provide a custom Pressman.ini file based on the parameters determined to be needed during the implementation phase of the project.

These parameters may be changed at any time by the customer when needed. Changes should be made to the Pressman.ini file that resides on the P-DAQDP server in the P-### directories. Pressman.exe must be restarted when changes are made to this file.

The parameters are divided into multiple sections as described below. Entries may be added or modified as required. Upper and lower case may be used as desired with additional spacing for readability since all characters are converted to lower case and imbedded spaces are discarded prior to evaluation.

Constants

Parameter	Default	Description	
Cost Center		Press cost center ID. Example: Cost Center = “451”	
Cost Center Desc		Type and model of press. Example: Cost Center Desc = “Harris M-1000”	
Crew ID	Emp ID	This entry defines whether the crew ID will be defined by the shift number or by the employee ID. Auto gets shift info from employee table, manual defaults from employee table and allows it to be changed. (Shift, Emp ID, Auto, Manual) Example: Crew ID = Emp ID	
Default Idle Code		This entry is used to define the code used for Idle-time between forms. Example: DefaultIdleCode = 0999	
Emp Overlap Code		**P-DAQDP** needs to know the non-chargeable operation code to use for shift overlap when passing information on to job costing. This is done to prevent double charging a job. Example: Emp Overlap Code = “8001”	**

Parameter	Default	Description	
Labor	No	This entry is used to record Labor by operation code for use by cost accounting. Secondly, this entry is used to warn or force the pressman to enter the MR1 and Run codes in the Setup Folder of the main screen. Also allows these codes to be cleared for subsequent entry when a new form is started. The following are the possible entries and the associated results. Examples: Labor = Yes (Forces) Labor = Yes, Warn (Warns) Labor = Yes, Force, Clear (Forces, Clears) Labor = Yes, Warn, Clear (Warns, Clears)	
Press Cutoff Speed	3000 minus 50%	This is the minimum (Turn On) speed which must be reached by the press in order to be considered running by **P-DAQDP**. (Generally the minimum speed at which product can be saved). The second number is the (Turn off) speed reached by the press to be considered NOT running by P-DAQDP. If there is no second number, the default is 50% of the cutoff (Turn On) speed. (Impressions per Hour) Example: Press Cutoff Speed = 4000, 1000	**
Press Speed Variance	1800	This is the minimum change in press speed (IMP/HR) which is to be recoded in the Press Log. Example: Press Speed Variance = 3000	**
Rated Speed	60000	The maximum rated speed of the press. Example: Rated Speed = 70000	
Report Idle Time	no	Used to report the “Default Idle Code” to the cost accounting system. Example: Report Idle Time = yes	
Shift Report Printer		Specifies the printer to be used for Shift Reports. Example: Shift Report Printer =“\\SERVER\HPLaserjet4P”	
Shift Time-1 Shift Time-2 Shift Time-3		Specifies the start time for shift 1, 2 and 3. At least 2 shifts must be defined and the duration of each shift must be the same. Example: ShiftTime-1 = 07:00 ShiftTime-2 = 15:00 ShiftTime-3 = 23:00	

Parameter	Default	Description	
Speed Timer Interval	500	The interval in milliseconds at which to read the hardware counters. Entries less than 100 should not be used on computers running at less than 400 megahertz. Valid intervals are 10 to 1000 inclusive. Example: Speed Timer Interval = 250	**
Stop Minimum Time	0	This is the time in seconds needed to elapse before a Press Stop or Automatic Manual Entry is to remain entered in the Shift Log. Example: Stop Minimum Time = 90	
Update Days	"MON, TUE, WED, THU, FRI"	Allows user to control when updates are allowed to install on the press computer. Multiple days of the week may be specified. Example: Update Days = "MON, TUE"	
Update Times	"08:00-16:00"	Allows user to control when updates are allowed to install on the press computer. Multiple times of the day may be specified. Example: Update Times = "08:00-12:00, 13:00-16:00"	

Database

Parameter	Default	Description
Data Path 1		Specifies the location and name of the **P-DAQDP** working database.
Data Path 2		Specifies the location and name of the **Master File** and **Scheduler** database.
Data Path 3		Specifies the location and name of the **Statistical** database.

Shop-Floor Interface

Parameter	Default	Description
Auto Start Tran	no	If reporting labor, this entry specifies whether or not to send “Operation Started” transactions to the **NASTech** shop-floor data collection system.
Class Codes		
Company		The company identifier to be used when reporting activity to the job costing system. Example: Company = “001”
Department		The department identifier to be used when reporting activity to the job costing system. Example: Company = “04”
Division		The division identifier to be used when reporting activity to the job costing system. Example: Company = “02”
Force MR1 Code Force MR2 Code Force Run Code Force Wsh Code	no	This entry is used in conjunction with the “Labor” parameter. This parameter causes the system to display an error when the associated code has not been entered into the Setup Folder of the main screen. Example: Force MR1Code = Yes
Ink Test Emp		
Ink Usage	no	Specifies whether or not to pass ink consumption data to the **NASTech** shop-floor data collection system.

Parameter	Default	Description
Labor	no	Specifies whether or not to pass job costing & labor data to the **NASTech** shop-floor data collection system. Also, the EmpLog table is used to record each employee's activity for the shift. This parameter can also be used to force or warn the operator if the make-ready and run operation codes are not specified. Example: Labor = yes,force Labor = yes,warn
Labor Lunch Oper		
Labor Minimum Time	0	The minimum number of seconds that the press must be down before reporting the fault to the job Costing system. Example: Labor Minimum Time = 120
Labor Prompt	Function	Specifies the initial prompt message which appears on the **NASTech** shop-floor data collection system. Example: Labor Prompt = "Tran Type"
Labor Test Emp		
Non-Charge Job Number	no	Causes a job number to be associated with non-chargeable transactions. If the parameter is "no", the job number, form ID, etc are left blank. Example: Non-Charge Job Number = yes
Parity	none	Specifies the parity to be used to communicate to the **NASTech** shop-floor data collection system. This entry must be compatible with the **TIM2B** to which the port is connected.
Port	0	Specifies the PC serial port to be connected to the **NASTech** shop-floor data collection system.
Report Idle Time	No	Determines weather the "Default Idle Code" gets transferred to the cost accounting system. Example: Report Idle Time = Yes
Stopbits	1	Specifies the number of stop bits to be used when sending data to the **NASTech** shop-floor data collection system. This entry must be compatible with the **TIM2B** to which the port is connected.
Transaction Sequencing	no	A technique used to ensure that data sent to the **NASTech** shop-floor data collection system is properly received. May be used in conjunction with the "Transaction Validation" parameter. Example: Transaction Sequencing = yes

Parameter	Default	Description
Transaction Validation	no	A technique used to ensure that data sent to the **NASTech** shop-floor data collection system is properly received. May be used in conjunction with the "Transaction Sequencing" parameter. Example: Transaction Validation = yes
Work In Process	no	Specifies whether or not to pass WIP pallet transactions to the **NASTech** shop-floor data collection system.

Network

Parameter	Default	Description
Parity	none	Specifies the parity to be used to communicate with the delivery and roll stand data terminals. This entry must be compatible with the **TIM1B** to which the port is connected. (odd, even, none) Example: Parity = even
Port	1	Specifies the PC serial port to be used to communicate with the delivery and roll stand data terminals. (1 or 2) Example: Port = 1
Speed	9600	Specifies the baud rate to be used to communicate with the delivery and roll stand data terminals. This entry must be compatible with the **TIM1B** to which the port is connected. Example: Speed = 9600
Stopbits	1	Specifies the number of stop bits to be used to communicate with the delivery and roll stand data terminals. This entry must be compatible with the **TIM1B** to which the port is connected. (1 or 2) Example: Stopbits = 2

Telnet Interface

Parameter	Default	Description
App Type		Application for Telnet communications. Example: App Type = "Primac"
Conn Type		The connection type of the machine to be interfaced to. Example: Conn Type = "Unidata"

Parameter	Default	Description
Host Type		Operating system of machine to be interfaced to. Example: Host Type = “Unix”
IP Address		IP address of the machine to be interfaced to. Example: Parity = even
Password		The password set up on the host computer for access to the requested data. Example: Password = “pdaqpress1”
Port No	23	The port number as predefined by the Telnet Connection. Example: Port No = 23
User ID		The User Name set up on the host computer for access to the requested data. Example: User ID = “pdaqpress1”

Edit

This section is used to alter the data edit criteria of the system. The entries in this section consist of a Field Name followed by an equal sign, followed by a series of keywords and their associated values. The keyword and values sets are separated by semicolons. The use of spaces is optional.

Keyword	Default	Description
type	1	0 = Display Only 1 = Alphabetic or Numeric 2 = Alphabetic 3 = Numeric (no decimal) 4 = Numeric (decimal allowed) 5 = Date 6 = Time 8 = Yes/No
minl	1	Minimum number of characters which may be entered. Example: minl=3
maxl		Maximum number of characters which may be entered. Example: maxl=8
optreq	R	“R” = required, entry is required. “O” = optional, entry may be left blank. When left blank, the value defined by the “default” is inserted as if it were keyed by the operator. Example: optreq=o
default		Default value to be used if user leaves the entry blank. If the data is optional this entry is displayed automatically. Example: Default=1
format		Formats the parameter to allow for leading zeros, or the elimination of leading zeros. Example: format=00 (adds a leading zero to single digit number) Example: format=#0 (removes leading zero from 2 digit number)
minv		Minimum numeric value which may be entered. Example: minv=1
maxv		Maximum numeric value which may be entered. Example: maxv=999
scaler	2	Maximum number of digits which may follow decimal point. Example: scaler=2
pattern		A sequence of element size, type and constants. Multiple patterns are separated by commas. For example, a telephone number pattern might be: pattern=3N-4N, 3N-3N-4N

Keyword	Default	Description
level	1	0 = field may not be changed. 1 = field may only be changed when **P-DAQDP** is in STOP mode. 2 = field may be changed at any time. (Check with NASTech before using this feature).
valdat		Used to define the valid entries for a given parameter. Valid entries are separated by commas. Example: valdat=a,b,c,d
Verify	No	Verifies the employee against the Employee table. Example: verify=yes

The following describes the default edit criteria for each entry field. The last group defines the edit criteria for entry fields on the remote terminals. To alter the edit criteria, place the command in the **Edit** section of the **Pressman.ini** file. To force a 7 digit numeric job number, enter the following command.

Parameter	Default Edit Criteria
CrewEmpID	“type=1; maxl=6; optreq=o; level=2”
CrewEmpName	“type=1; maxl=30; optreq=o; level=2”
CrewID	“type=1; maxl=4; optreq=o; level=2; valdat=a,b,c,d”
JobNo	“type=1; maxl=8”
JobDesc	“type=1; maxl=30; level=2”
JobCust	“type=1; maxl=6; level=2”
JobCustName	“type=1; maxl=30; level=2”
JobQuantity	“type=3; maxl=10; minv=1; maxv=99999999; level=2”
JobFormID	“type=1; maxl=6”
JobFormDesc	“type=1; maxl=30; level=2”
JobFormType	“type=1; maxl=6; level=2”
JobFormTypeDesc	“type=1; maxl=30”
JobFormRunNo	“type=1; maxl=6”
JobFormRerun	“type=3; maxl=3; minv=1; maxv=999”
JobFormSigs	"type=3; maxl=1; minv=1; maxv=8"
MR1OperCode	“type=1; minl=2; maxl=6; level=2”
MR2OperCode	“type=1; minl=2; maxl=6; level=2”

Label

This section is used to alter selected headings within the system to match those used by your company. The entries in this section consist of a Keyword followed by an equal sign, followed by the new heading to be used. If the new heading is too long, it may be truncated.

Keyword	Default	Description
Crew Crew: ***	Crew	Heading on folder tab. Heading for associated text box.
Job Job: ***	Job	Heading on folder tab. Heading for associated text box.
Sigs Sigs: ***	Sigs	Heading on folder tab. Heading for associated text box.

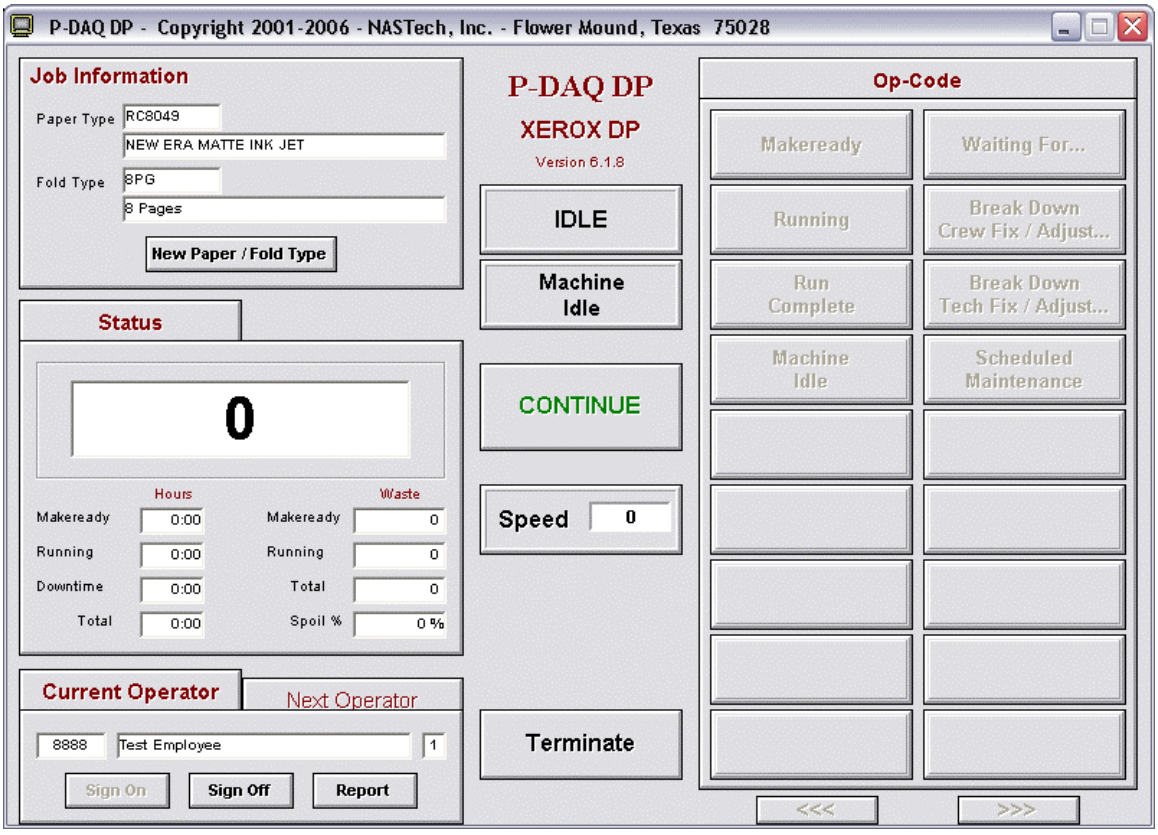
*** Represents the original heading to be changed.

Examples:

Crew = “Emps”	Changes heading on folder tab.
Crew: 1st Pressman = “Lead Pressman”	Changes 1st pressman’s title
Job: Sigs/Form = “Num On”	
Sigs: Sigs/Imp = “Number Up”	

Chapter 4 Press Module

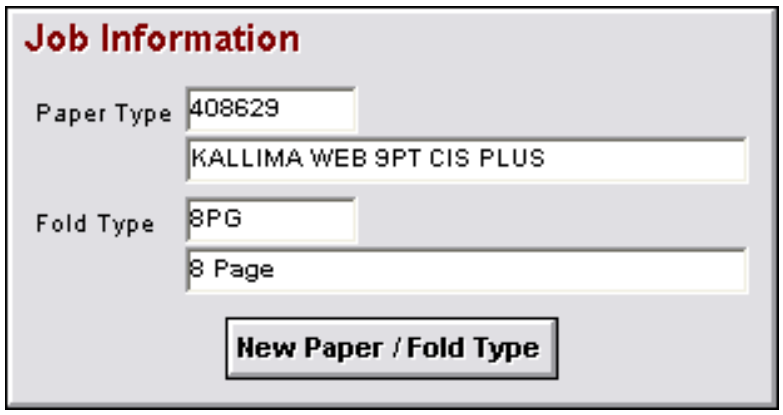
Main Screen



The following pages will describe each section of the Main Screen in detail.

Job Information Panel

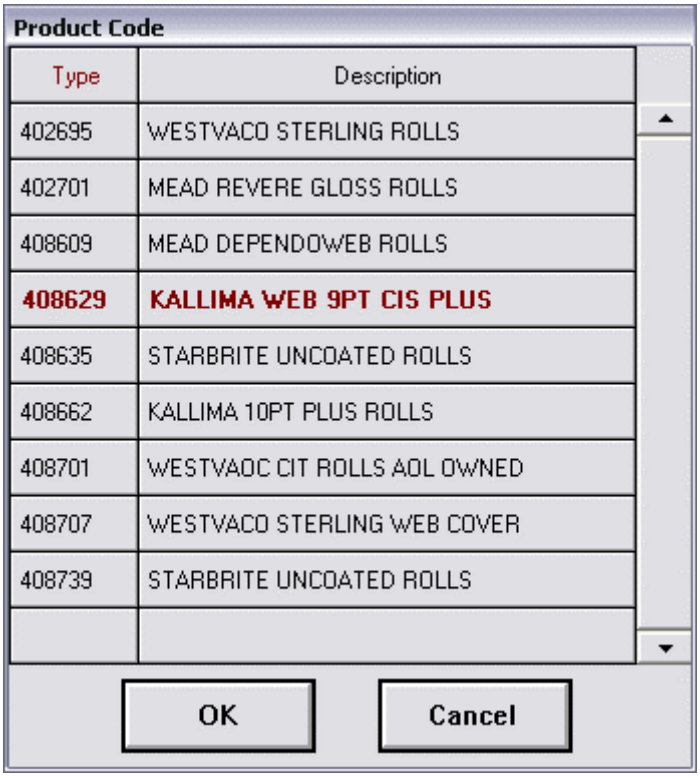
The Job Information Panel displays the current Job.



Details

Paper Type	Displays the Paper Type Code as selected from the Product Code table.
	Displays the Paper Type Description as selected from the Product Code table.
Fold Type	Displays the Fold Type Code as selected from the Form Type table.
	Displays the Fold Type Description as selected from the Form Type table.
New Paper Button	Used to display the Product Code and Form Type screens for subsequent entry.

Product Code Screen

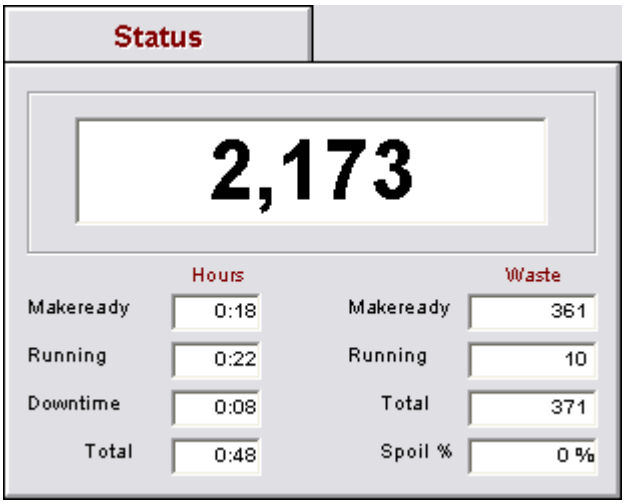


Details

Type	The Paper Code as entered into the Product table.
Description	The Paper Code Description as entered into the Product table.
OK	Enters the selected Paper Type into the system and closes the dialog box.
Cancel	Used to close the dialog box, without starting a new job and without changing Paper.

Status Panel

This folder is used to display the current status of the Paper Type being run.



Details

Good (Large)	Good Quantity (Linear Feet)
Hours	
Makeready	Makeready Hours.
Running	Running Hours.
Downtime	Downtime Hours.
Total	Total Hours.
Waste	
Makeready	Makeready Waste (Linear Feet).
Running	Running Waste (Linear Feet).
Total Waste	Total Waste (Linear Feet).
Spoil %	Waste Percentage. (= Waste / Gross * 100)

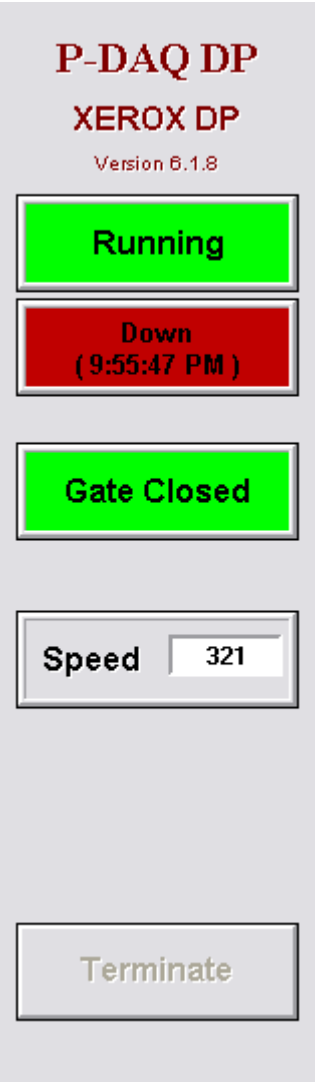
Operator Panel

This Operator Panel identifies the pressmen on the associated shift. This information should be defined prior to the start of each shift.

Details

Employee #	Employee ID Number.
Employee Name	Employee Name.
Shift #	Shift Number.
Sign-On	Used to sign on to the system.
Sign-Off	Used to sign off the system.
Report	Used to view or print the Shift Detail Report.

Center Panel



Run Indicator	Displays the Status or the Run.
Operation Indicator	Displays the current operation being performed.
Gate Position	The position of the Dump Gate.
Speed	Displays the current press speed.
Continue	Used to initialize the counters when starting or re-starting the system.
Terminate	Used to terminate the application.

Operations Panel

The Operations Panel is used to provide for the selection of operation codes.

The buttons displayed here are user defined and used controlled. Therefore, only those codes that are valid for your plant / press are presented to the operator.

Operation Codes are defined in the Pressman.ini file.

These codes are also dynamically displayed, for example, only those codes that are valid at any particular point in the run are enabled for selection. **Fig.1**

The buttons used for operation codes can also be presented to the operator using multi level control. **Fig.2** shows the operations displayed after the **Waiting** button has been pressed.

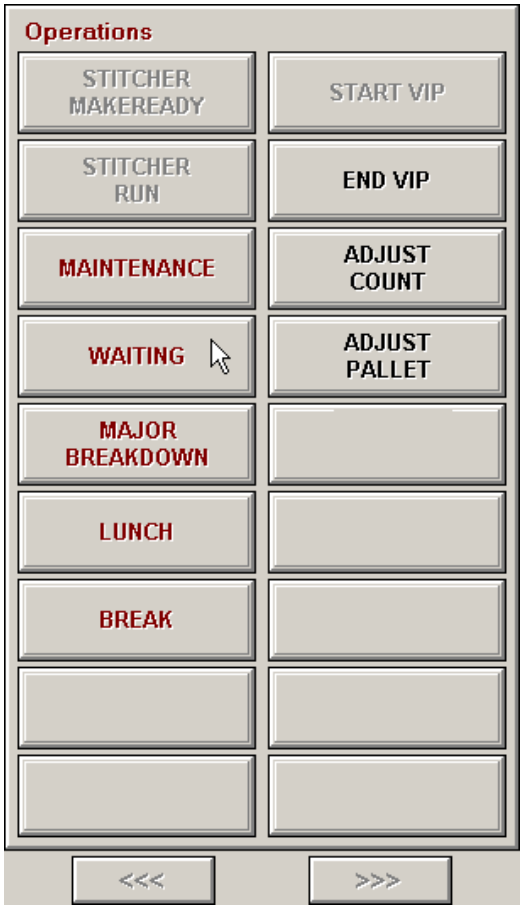


Figure 1

Figure 2

Functions

Buttons in the Operations Panel are typically used to enter the following Operations:

Break	Used to indicate that an operator break has begun.
Lunch	Used to indicate that an operator lunch break has begun.
Make-Ready	Used to select the Makeready Operation Code.
Run	Used to select the Run Operation Code.
Downtime	Used to select Downtime Activity Codes.
Run Complete	Used to indicate that the current run has been completed.
Machine Idle	Used to place the system into an Idle state.

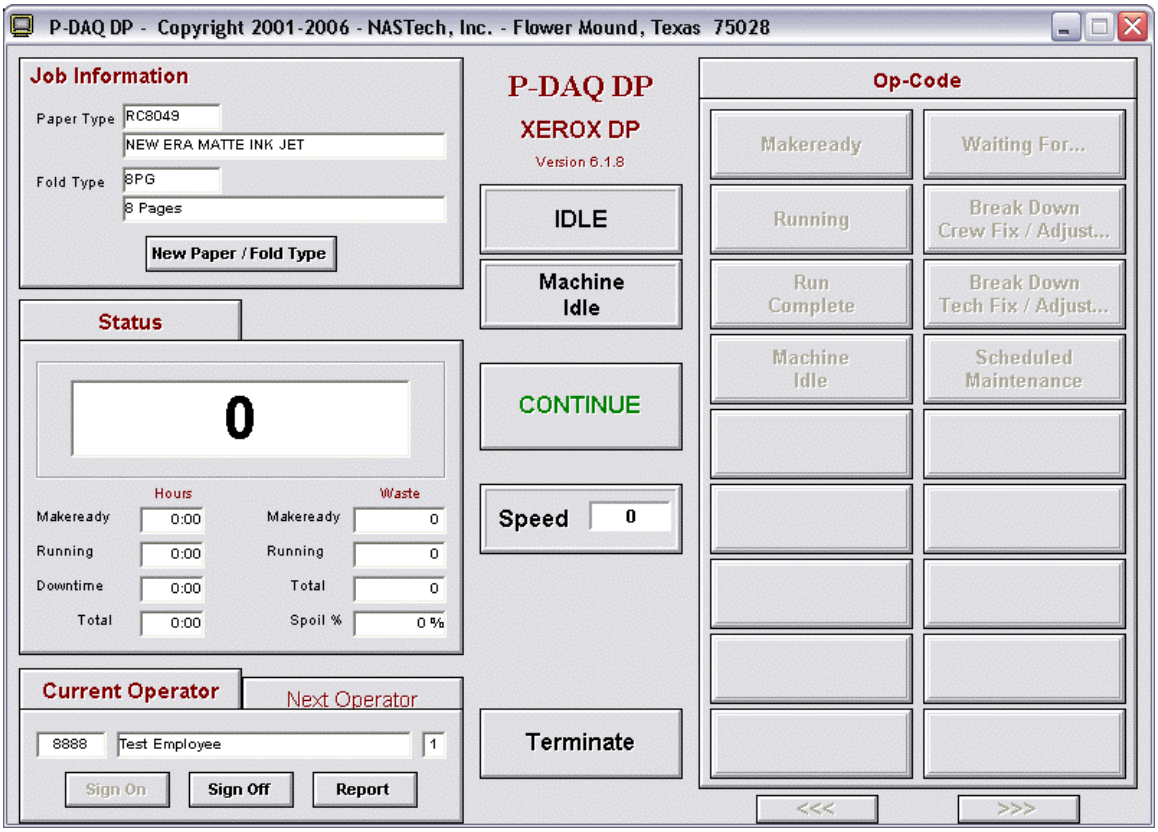
Chapter 5 Procedures

Start-Up

To start the system, double-click the desktop **P-DAQDP** icon.

Start the **DataSync** program if not already running.

When starting or Re-starting the system, click the **Continue** button on the Center Panel.



To terminate, click the **Terminate** button.

Sign-On

Before any activity is performed, the Pressman performing the activity must be signed on to the system.

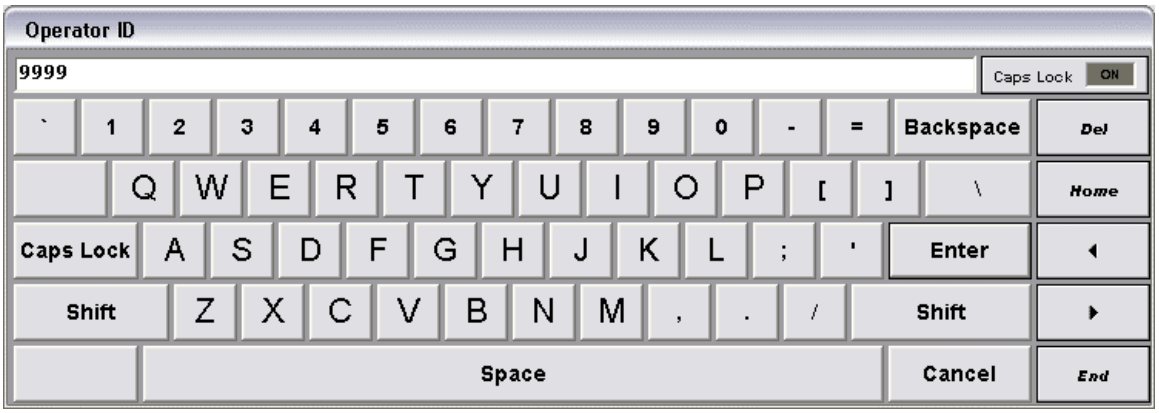
If you arrive at work and there is nobody currently signed on to the system, click the **Current Operator** Tab.

If you are relieving a currently signed on employee click the **Next Operator** Tab.

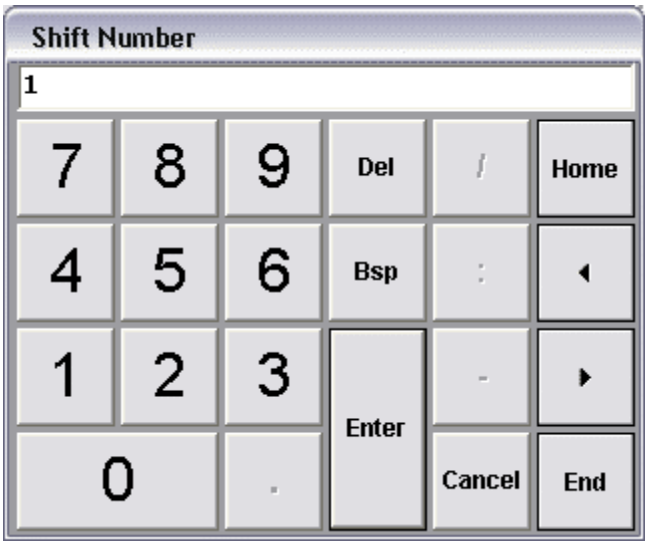
Use the following procedure to complete the sign on…

Click the **Sign-On** Button.

Enter your **Employee ID**.



3. Enter the **Shift Number**.



Job Setup

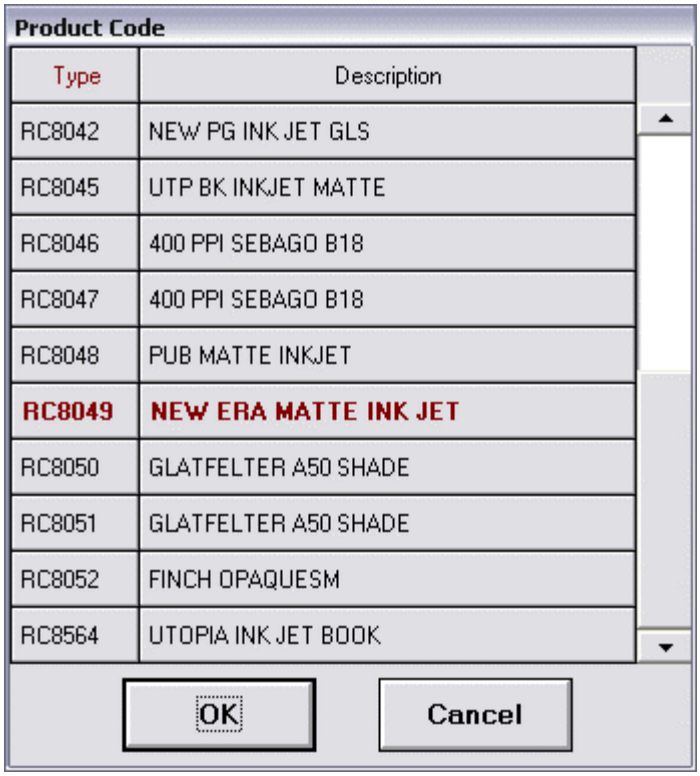
In the case of Digital Presses P-DAQdp defines a job as a Paper Type and Fold Type combination that is to be run. Actual job numbers used by the system are auto-generated. In an effort to properly track jobs by Paper and Fold Type, when changing Paper Type, a new Job must be started.

To Select the Paper Type and Fold Type on a new run, use the following procedure…

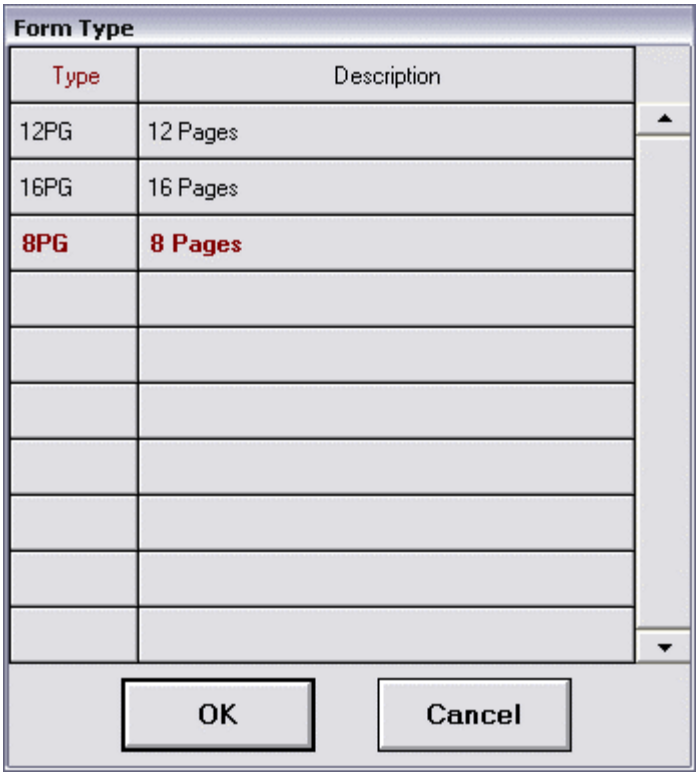
1. To ensure that the previous run has been completed, click the **Run Complete** button on the Operations Panel.

2. Click the **New Paper** / **Fold type** Button.

3. Select the Paper Type from the **Product Code** Screen.

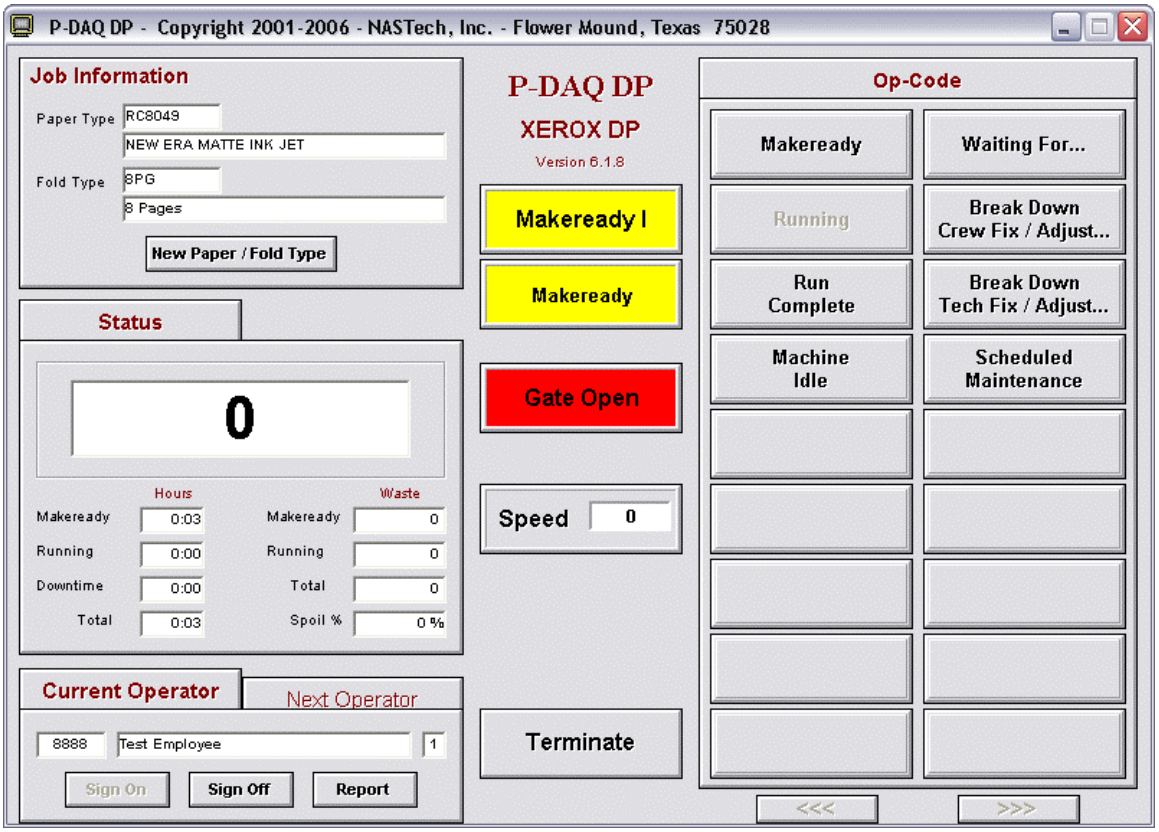


4. Select the Fold Type from the **Product Code** Screen.



Makeready 1

After a new Paper Type / Form Type is selected, P-DAQdp automatically enters into its Makeready 1 Status. All time and waste incurred is now being recorded against the new job.



The Center Panel's Run Status Indicator will turn Yellow and display "Makeready 1".

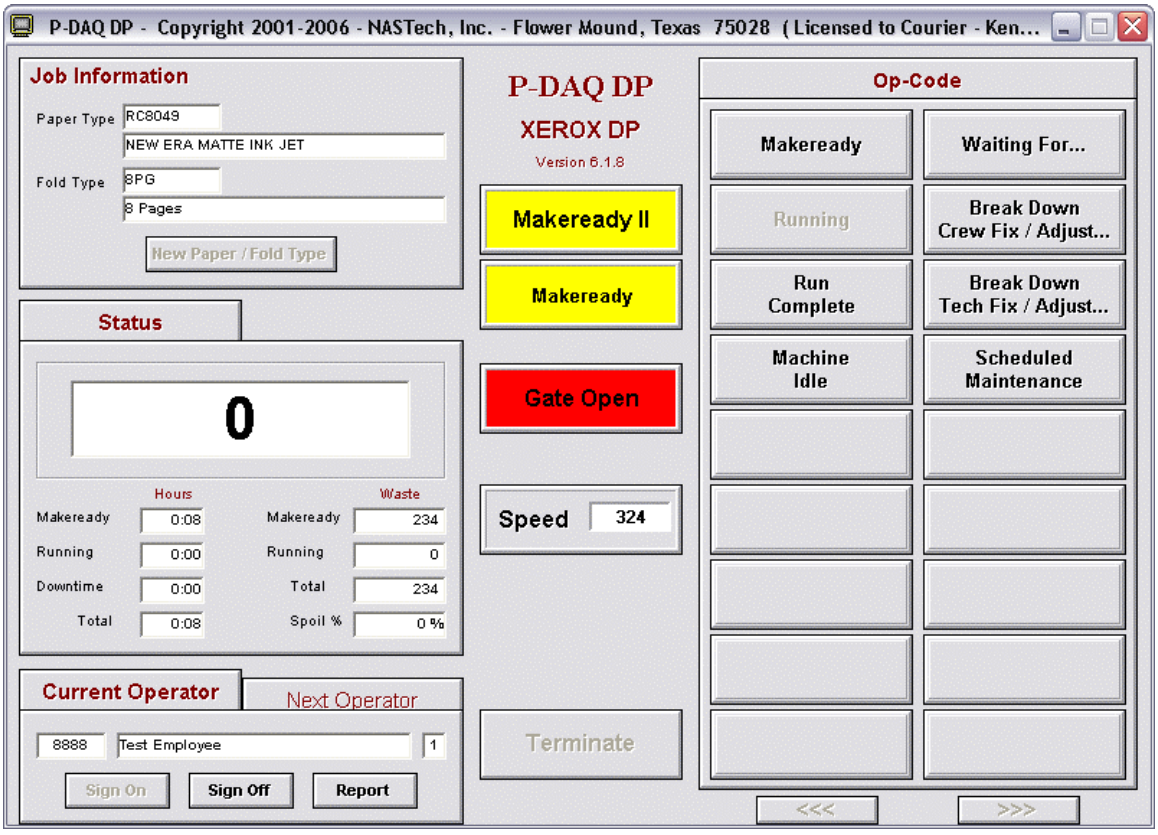
The Center Panel's Operation Indicator will turn Yellow and display the Makeready 1 Operation Code Description.

The Status Panel will begin to update the Makeready Time and Waste statistics.

NOTE: Press Stops during Makeready are not tracked.

Makeready 2

When the press starts and reaches speed above 100 Feet / Minute, P-DAQdp enters into its Makeready 2 Status.



The Center Panel's Run Status Indicator will turn Yellow and display "Makeready 2".

The Center Panel's Operation Indicator will turn Yellow and display the Makeready 2 Operation Code Description.

The Status Panel will continue to update the Makeready Time and Waste statistics.

NOTE: Press Stops during Makeready are not tracked.

Running

Once good product is being produced, closing the dump gate initializes the Good Counter and P-DAQdp enters into its Running Status.

The Center Panel's Press Indicator will turn Green and display "Running".

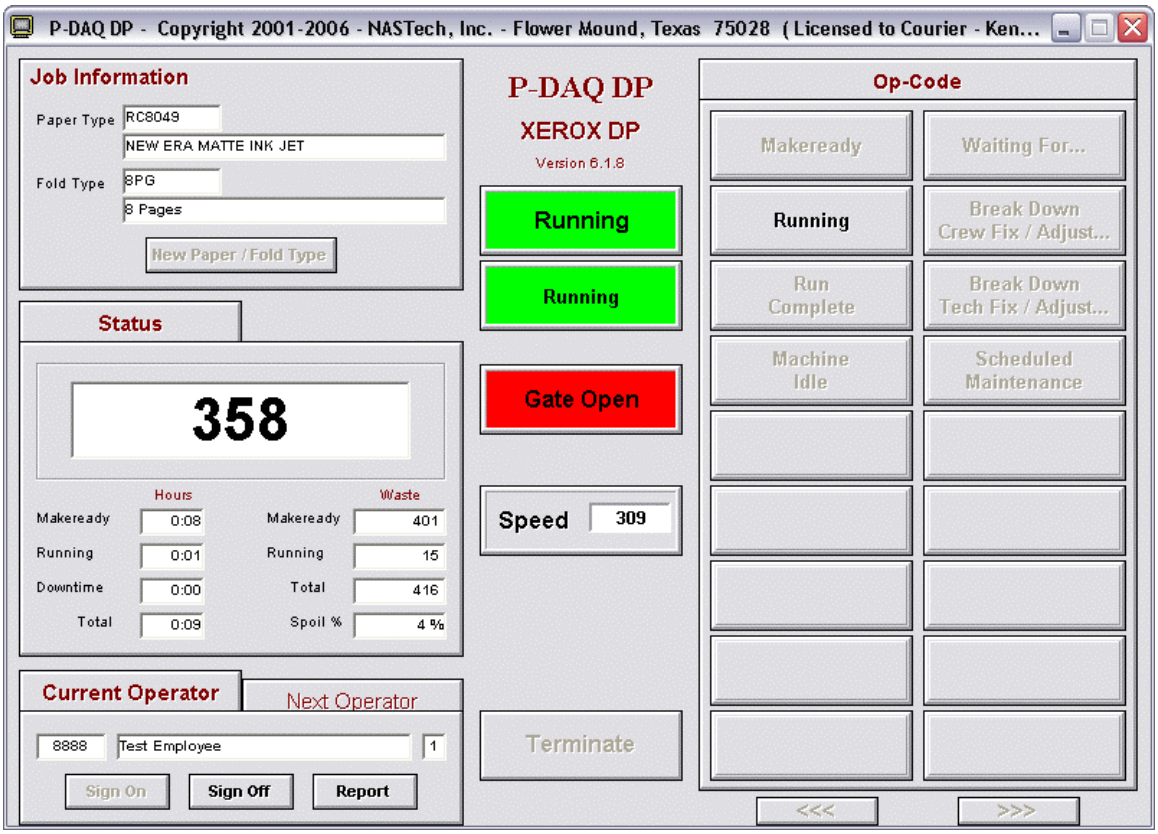
The Center Panel's Operation Indicator will turn Green and display the Run Operation Code Description.

The Gate Position Indicator will turn Green.

The Status Panel will update the Run Time and Waste statistics.

Run Waste

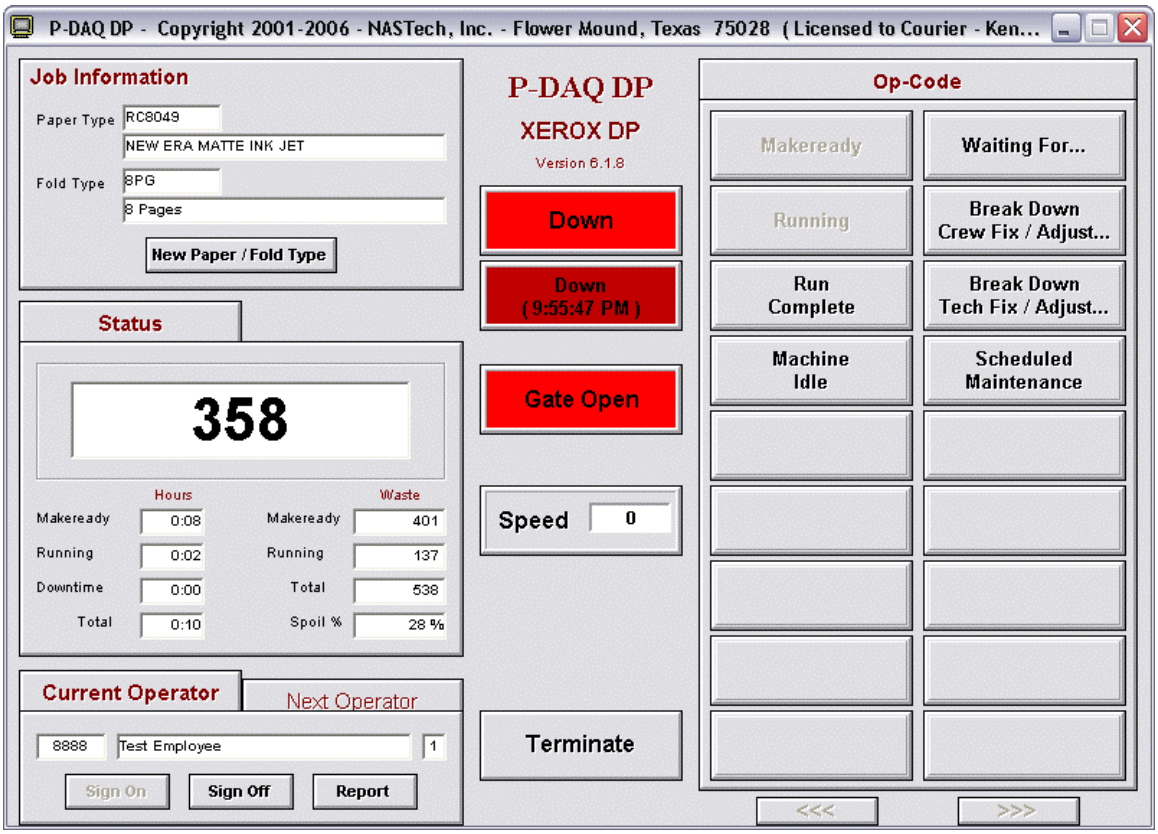
When the press is running and the dump gate is opened, the Gat Position Indicator will turn Red and the product will be counted as Running Waste.



The Status Panel will update the Run Waste statistics.

Press Stops

When the press stops for longer than 1 minute during Running, P-DAQdp enters into its Down Status.

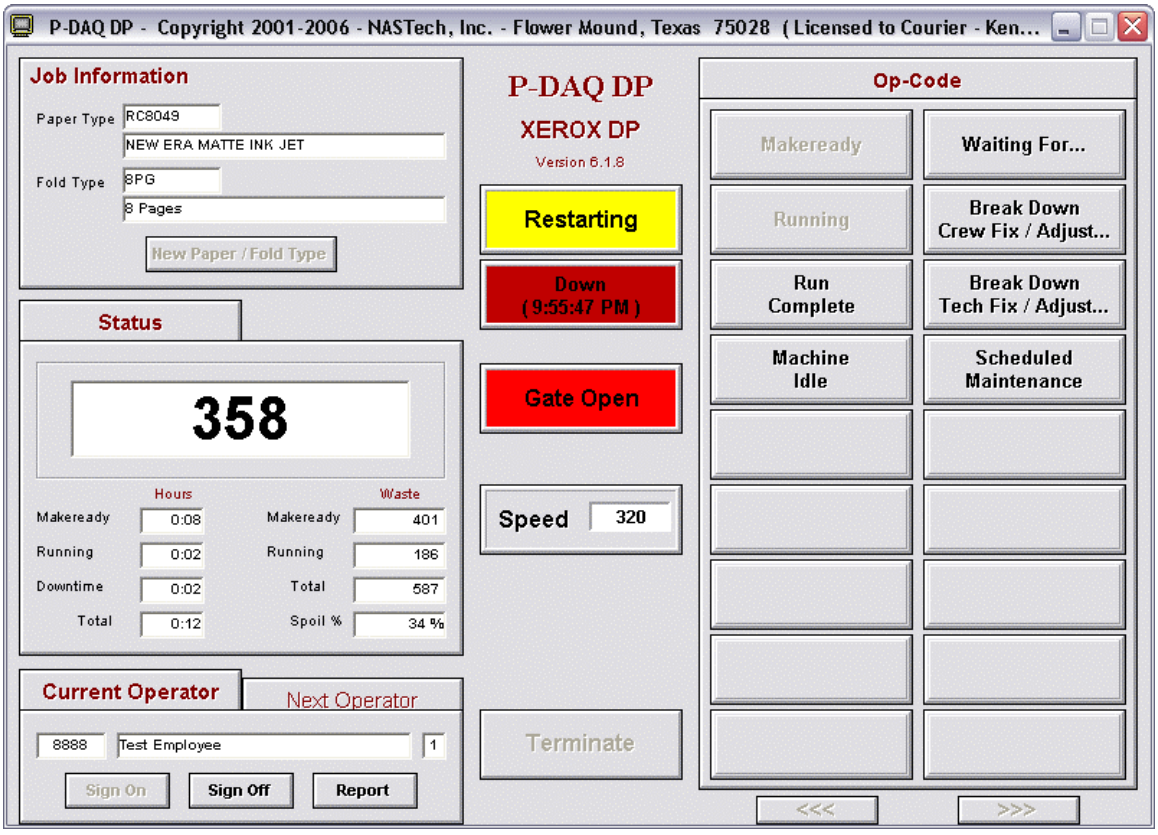


The Center Panel's Run Status Indicator will turn Red and display "Down".

The Center Panel's Operation Indicator will flash Red and display the time of the failure.

Restarting

When the press re-starts and reaches speed above 100 Feet / Minute, P-DAQdp enters into its Restarting Status.



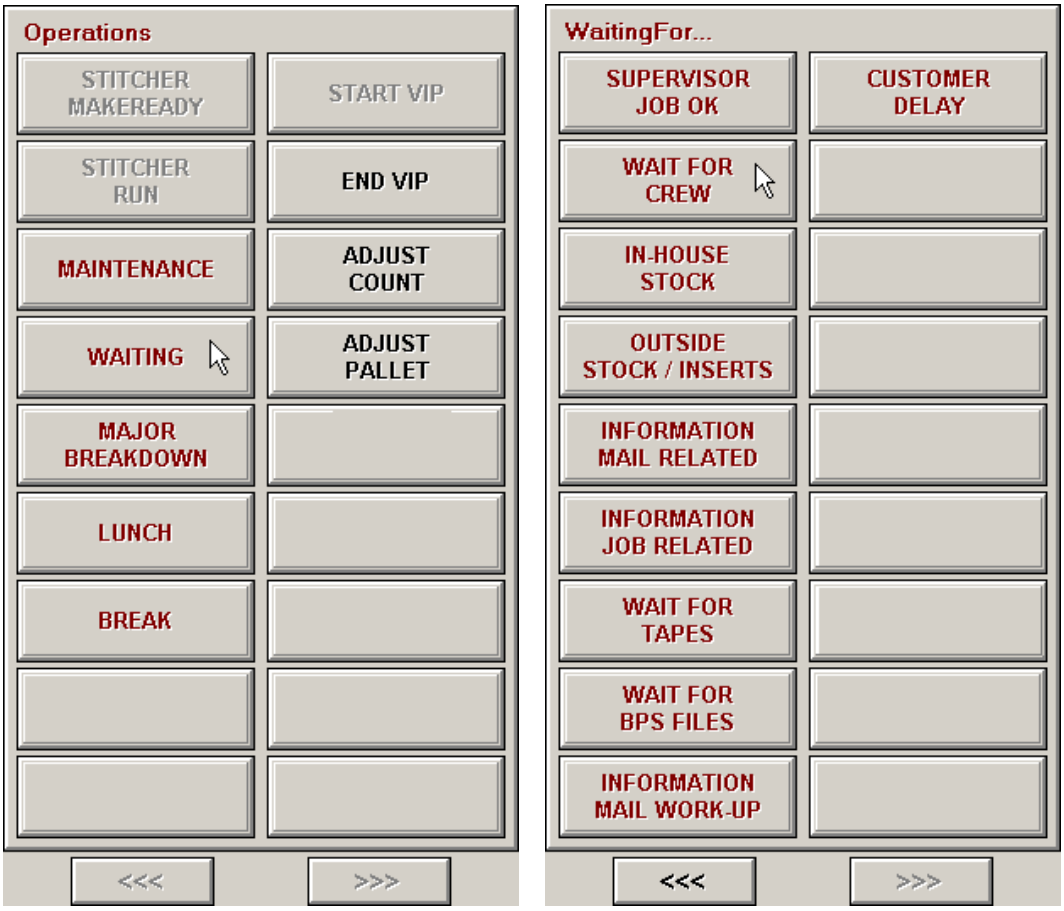
The Center Panel's Run Status Indicator will turn Yellow and display "Restarting".

When the dump gate is closed, the Center Panel's Press Status Indicator will turn Green and display the Running Status of the Press.

The Center Panel's Operation Indicator will remain flashing Red until a Downtime Reason Code has been selected for the press stop.

Downtime Codes

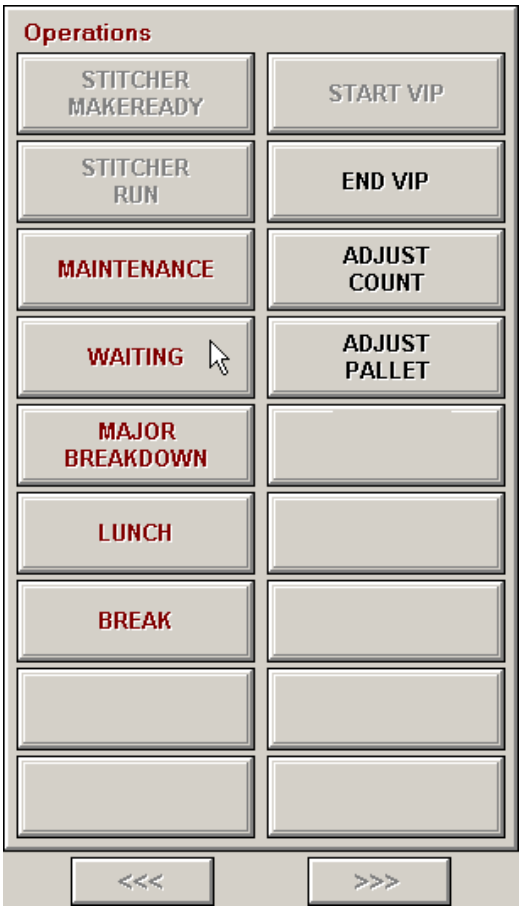
To select the Downtime Reason code, click the Downtime Code category, then select the actual code from the list.



Idle Codes

Idle Operation Codes are used to account for time where the operator is not running the press. Idle codes are used for Breaks, Scheduled Maintenance, and when signing off with no shift relief.

To put the machine into an idle stats, simply click an idle code button.



Sign-Off

If you are signing of and there is nobody relieving you, click the “Press Idle” button.

If local management requires, click the Report Button to print your shift detail report.

If you are signing of and the next operator is defined and has signed on, click the Sign-Off button.

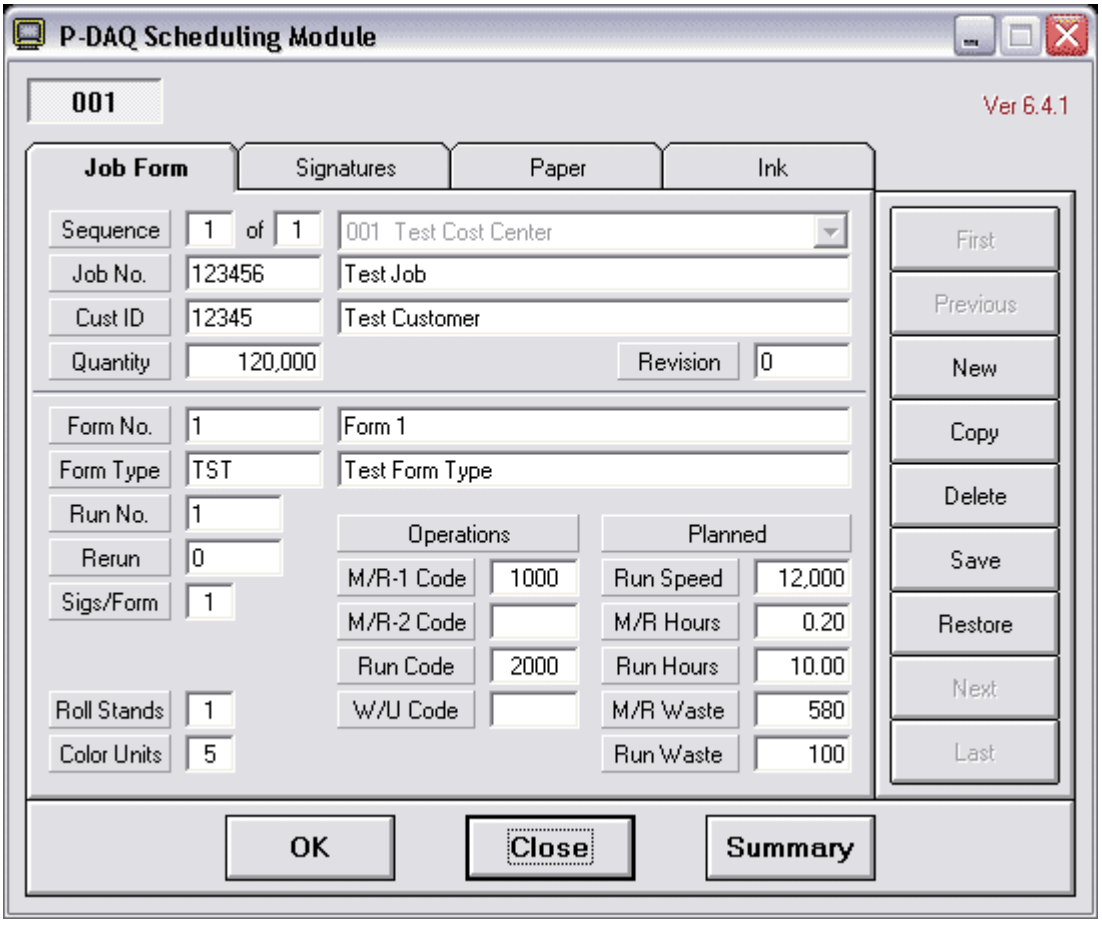
Chapter 6 Job Scheduling Module

Overview

The Job Scheduling module is used to store the jobs which are scheduled to run on press. The data defined here is stored until the Pressman selects the job from the **P-DAQDP** console. This saves time and eliminates the need for the Pressman to enter the information required to monitor job activity.

Main Screen

The main screen is used to define the job and form to be run. This screen also defines the number of different signatures on the form and the expected hours and waste for the form.



Details

Sequence — The current job being viewed and the total number of jobs in the schedule.

Job No.	The job number and description of the job being run. The job description is displayed automatically if present on the job master file.
Cust ID	The customer ID and customer name. The customer name is displayed automatically if present on the Customer master file.
Press ID	The press the job is scheduled to run on. The job may be moved to different press by selecting the press from the drop down list.
Form No.	The form number and description of the form being run.
Form Type	The form type and description of the form being run. The description is displayed automatically if present on the Form Type master file.
Run No.	The run number of the form being run.
Rerun	The rerun number of the form on press.
Sigs/Form	The number of different signatures being delivered.
Roll Stands	The number of roll stands used for this job.
Color Units	The number of color units used for this job.

The scheduled hours and waste figures are used by **P-DAQdp** to compare actual hours and waste to that of the schedule. These figures are also graphed in the Press Module (Performance Screen) for pressmen to determine whether or not he or she is performing on schedule.

Controls

First	View first job in the schedule. Disabled if job sequence number 1 is currently being displayed.
Previous	View prior job in the schedule. Disabled if job sequence number 1 is currently being displayed.
New	Creates a new job sequence number and clears all fields for subsequent entry.
Copy	Copies the data from the currently displayed job to a new job sequence number. The copied job definition may then be selectively modified to define the specifications of the new job.
Delete	Deletes the currently displayed job from the schedule. A warning message is displayed to help eliminate accidental deletions.

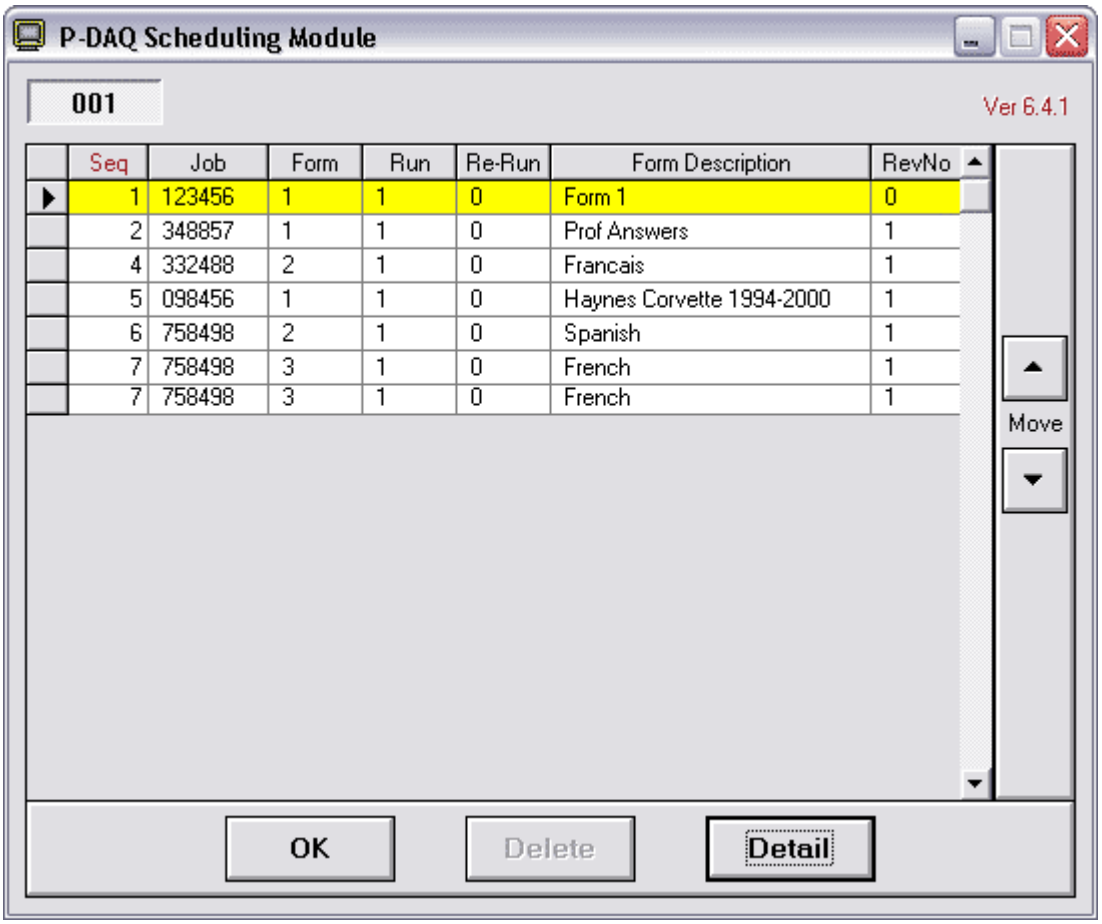
Save	Saves the current job schedule in the database.
Restore	Reads the data from the database for the current job. This function is used to negate any and all changes made to the current job since the last time it was saved to the database.
Next	View next job in the schedule. Disabled if the last job sequence number is currently being displayed.
Last	View last job in the schedule. Disabled if the last job sequence number is currently being displayed.

Screen Menu Options

OK	Saves the current job and exits the program.
Cancel	Exits the program without saving the current job.
Summary	Displays the Job Summary screen. The current job remains selected.

Summary Screen

This screen is used to quickly locate a record to be edited. Records may also be deleted and their priorities may be increased or decreased.



Details

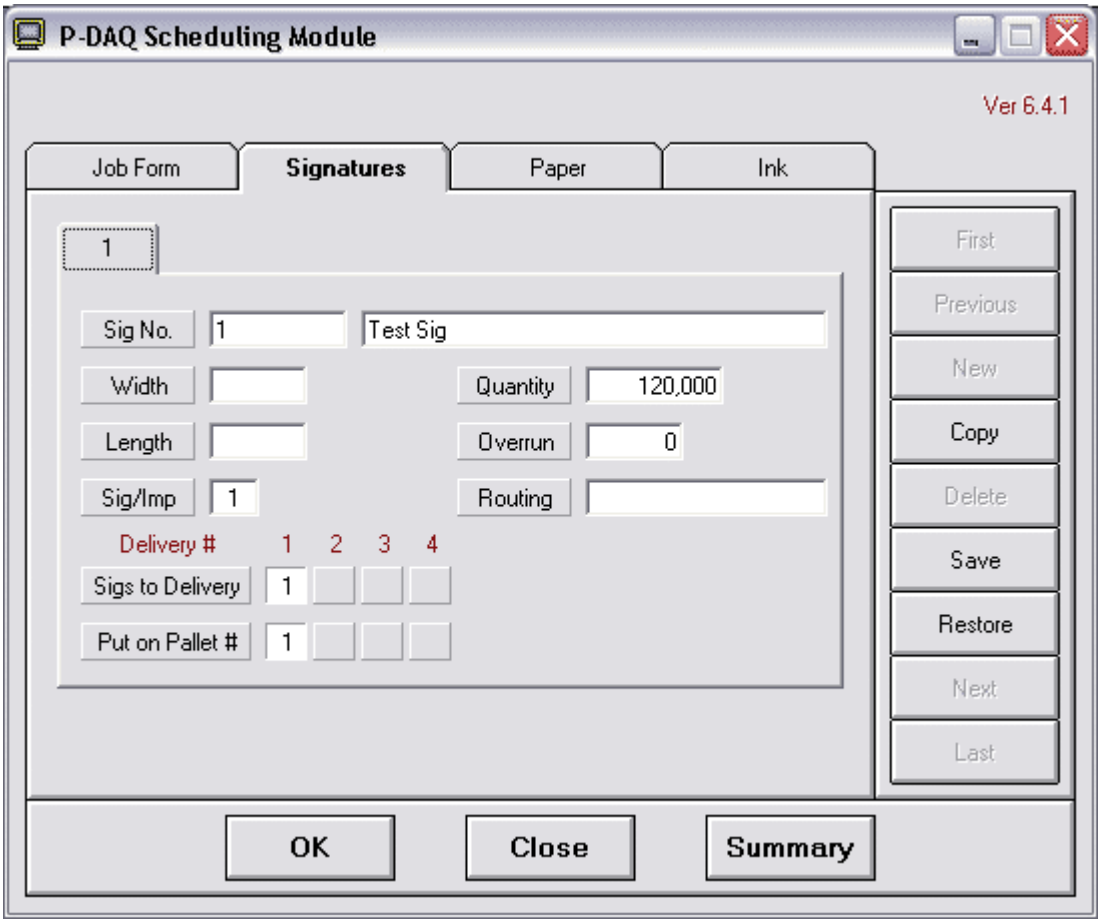
Customer Name	The job or the form description may be displayed in lieu of the customer name by adding a parameter to the constants section of the P-Sched.ini file as follows: Job Sched Desc = “J” or Job Sched Desc = “F”
Move UP	Increase the priority of the currently selected record.
Move DOWN	Decrease the priority of the currently selected record.

Screen Menu Options

OK	Saves the current record and exits the program.
Delete	Delete the currently selected record. A warning message is displayed to help eliminate accidental deletions.
Detail	Display the Job Detail screen. The currently selected record is displayed on the Main Screen.

Signature Definition

This folder identifies the associated signature. The data displayed here is normally defined by the scheduling module and displayed here for reference only. The number of tabs present is based on the signatures associated to the current form. This data may be modified if necessary.



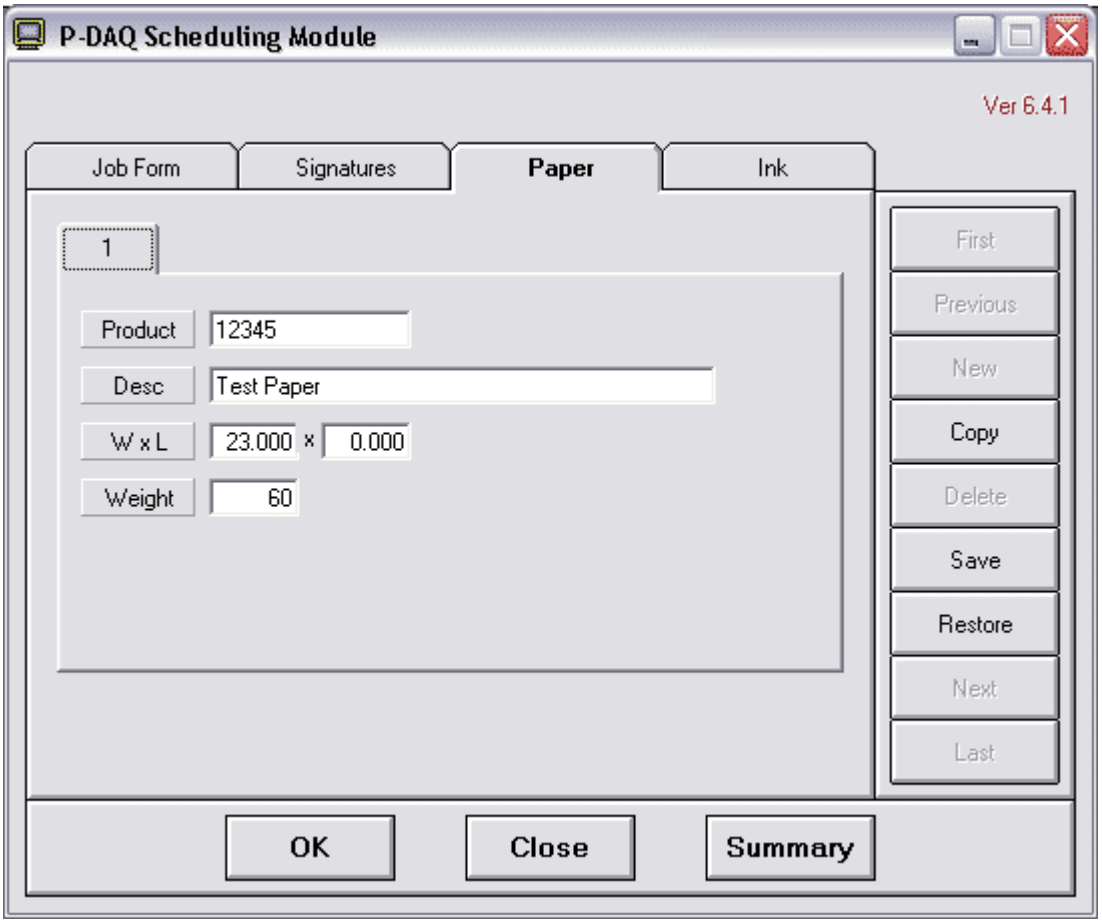
Details

Sig No.	Signature ID and description.
Width	The width of the signature.
Length	The length of the signature.
Quantity	The number of signatures required.
Overrun	The allowable overrun for the signature.
Current	The number of good signatures produced thus far.
Waste	The number of waste signatures produced thus far.
Sigs/Imp	The number of signatures of this type produced for each impression.

Sigs/Del	The deliveries receiving the signature. Each button refers to a delivery. The value within the depressed button refers to the number of signatures of this type which are passed to the delivery. Each time the button is pressed, the number within is incremented by 1. A blank faced button is used to indicate that a delivery is not used for the signature. In the example above, we are getting 2 signatures of this type from each impression. The first signature is delivered to Delivery #1 and the second to Delivery #2. The same delivery may not be used for different signatures.
Sigs/Pal	The pallets receiving the signature. Each button refers to a pallet position. The value within the depressed button refers to the number of signatures of this type which are accumulated on the pallet. Each time the button is pressed, the number within is incremented by 1. A blank faced button is used to indicate that a pallet position is not used for the signature. In the example above, we are getting 2 signatures of this type from each impression. The first signature is delivered to Delivery #1 and the second to Delivery #2, however, signatures from both deliveries are accumulated on the same pallet at position #1. The same pallet may not be used for different signatures.
Lift Count	The average number of signatures accumulated at the stacker for delivery to the pallet. This number is calculated by averaging the 5 largest lifts placed on the first pallet. This data may be changed from the terminal located at the delivery station.
Lifts/Skid	The number of lifts of the size defined above which can be placed on the pallet. This data may be changed from the terminal located at the delivery station.
Routing	Optional entry which may be printed on the load ticket to identify the destination of the pallet.

Paper Definition

This folder identifies the stock being used at each of the roll stands. The data displayed here is normally defined by the scheduling module and displayed here for reference only. The number of tabs present is based on the number of roll stands being used. This data may be modified if necessary.

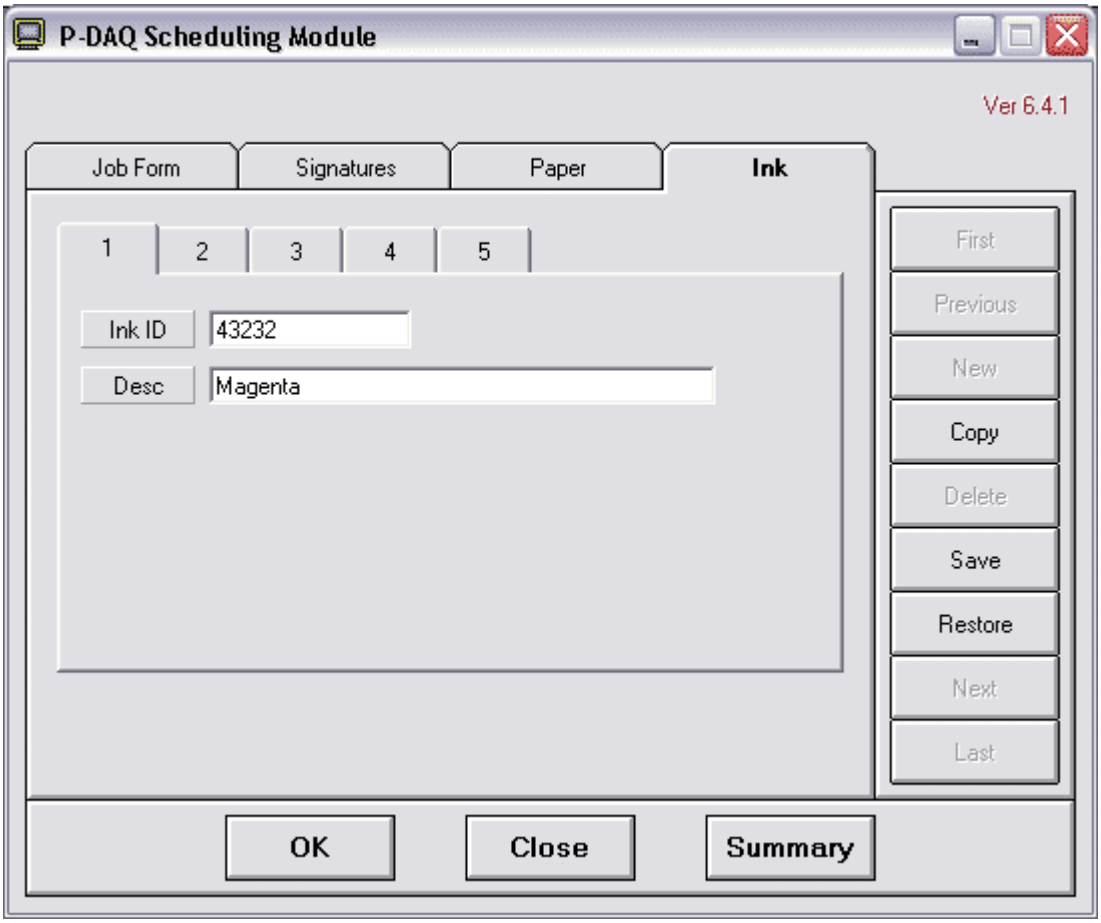


Details

Product	The paper inventory product ID being used.
Desc	The description of the stock being used.
Width	The roll width of the stock being used.
Weight	Basis weight of the stock being used.

Ink Definition

This folder identifies the ink to be used in conjunction with each of the color units. If one or more of the color units will not be used, the ink information may be omitted.



Details

Ink ID	The inventory product identifier for the ink being used.
Desc	The description of the ink being used.
Ink Color	The color of the ink being used.

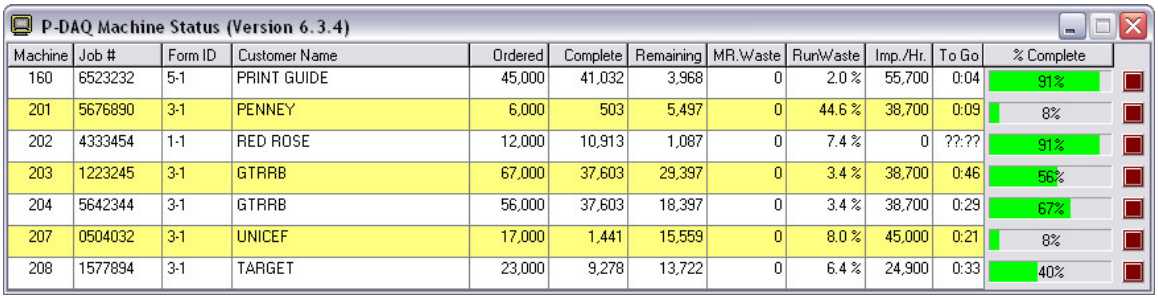
Chapter 7 Press Status Module

Overview

P-Status can be used by scheduling, customer service, and management to determine the current status of jobs on press.

Status Summary Screen

This screen is used to view the status of up to 20 presses at once. To view status details, click any field for the associated press, job or form.



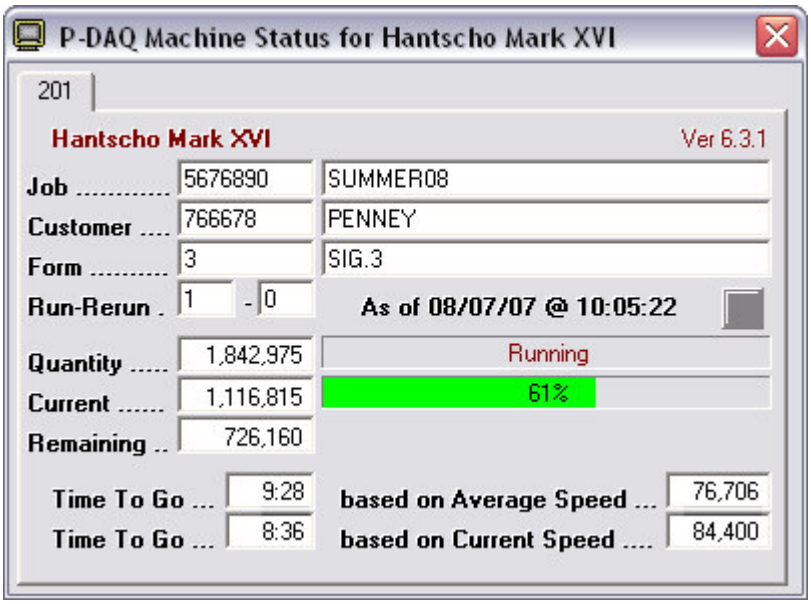
Machine	Job #	Form ID	Customer Name	Ordered	Complete	Remaining	MR.Waste	RunWaste	Imp./Hr.	To Go	% Complete
160	6523232	5-1	PRINT GUIDE	45,000	41,032	3,968	0	2.0 %	55,700	0:04	91%
201	5676890	3-1	PENNEY	6,000	503	5,497	0	44.6 %	38,700	0:09	8%
202	4333454	1-1	RED ROSE	12,000	10,913	1,087	0	7.4 %	0	??:??	91%
203	1223245	3-1	GTRRB	67,000	37,603	29,397	0	3.4 %	38,700	0:46	56%
204	5642344	3-1	GTRRB	56,000	37,603	18,397	0	3.4 %	38,700	0:29	67%
207	0504032	3-1	UNICEF	17,000	1,441	15,559	0	8.0 %	45,000	0:21	8%
208	1577894	3-1	TARGET	23,000	9,278	13,722	0	6.4 %	24,900	0:33	40%

Details

Machine	The cost center number.
Job #	The job number.
Form ID	The form, run and rerun numbers.
Customer Name	The customer name.
Ordered	The quantity requested.
Complete	The total number of completed net signatures.
Remaining	The number of remaining net signatures.
Waste	The current waste sigs for the associated form.
Imp/Hr.	The speed of the press in impressions per hour.
To Go	The time to go based on the current speed.
% Complete	The percentage of completed signatures.

Status Detail Screen

The folder tabs represent the presses that may be viewed. Once selected, the current status is displayed. The status is then updated approximately every 15 seconds. The last date and time the status was updated is displayed below the form description. If for any reason, the status cannot be updated for 60 seconds or more, the red indicator to the right will turn on and begin to flash. This can occur if the Network Server is not available or when a system back up is in process.



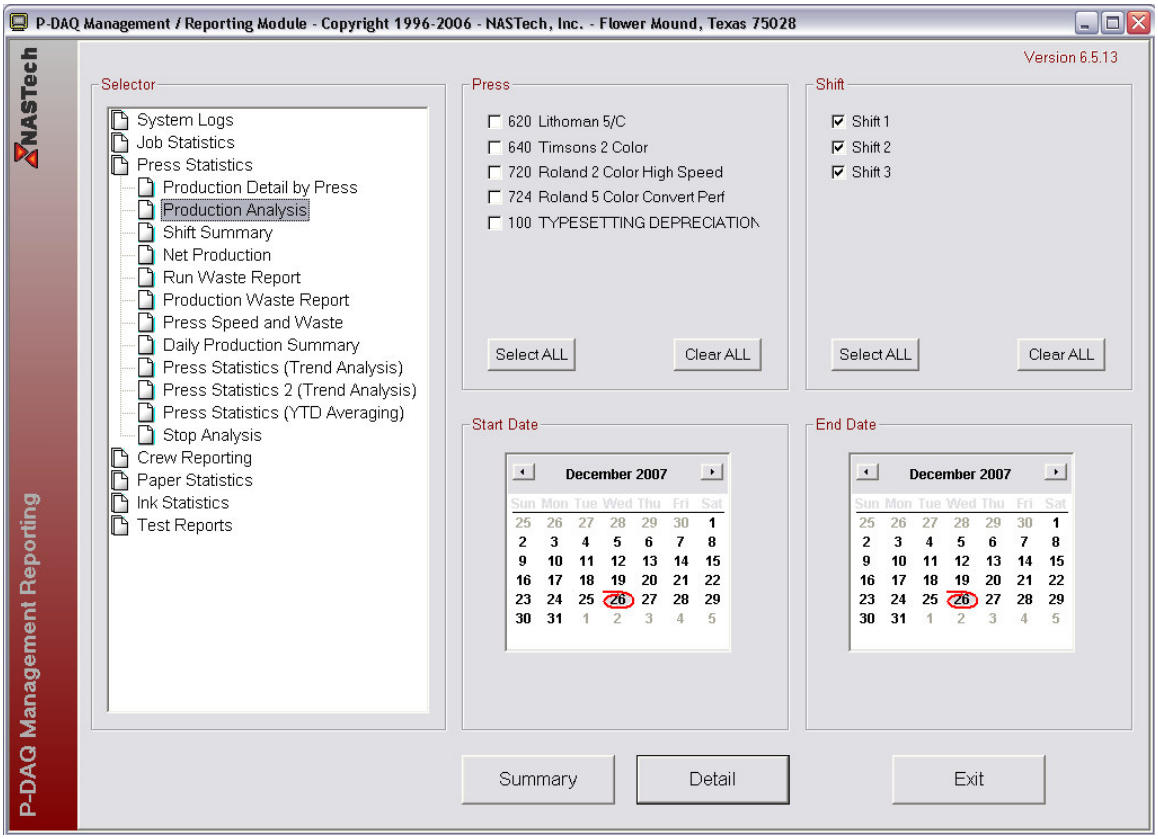
Details

Job	The job number and associated description.
Customer	The customer number and name.
Form	The form and form description.
Run-Rerun	The run and rerun numbers.
Quantity	The quantity requested.
Status	The current press status.
Current	The total number of completed signatures.
% Complete	The percentage of the form which is complete.
Remaining	The number of remaining signatures.
Waste	The total waste for the associated form.
Imp/Hr.	The speed of the press in impressions per hour.
To Go (Average)	The time to go based on the average speed.
To Go (Current)	The time to go based on the current speed.

Chapter 8 Management / Reporting Module

Overview

The Management / Reporting module is used to display and/or print selected reports. Each report contains selection criteria that may be specified to limit the amount of data reported.



The available reports are presented as a series of buttons on the left hand side of the screen.

When a report is selected, the four panels to the right are used to specify the selection criteria required for the particular report. Once the selection criterion has been specified, the report may be displayed by clicking on the Summary, Detail, or Process button.

Once a report is displayed, it may be printed in its entirety or selectively by page.

Upon selecting a report and by clicking the Process, Summary, or Detail button, the **P-DAQDP** reporting system analyzes the system logs and builds a summary database which summarizes all data needed for the selected report.

When a report is not run periodically, the next time you run the report, the system needs to update the summary databases. Depending on the amount of data to be summarized, this process may take a while and the given report may not display right away. There are a few ways to make sure that the summary databases are up to date as outlined in the following procedures:

- From the **P-Admin** main screen, without selecting a report, click the Process button. This will summarize all data for all reports at one time. Performing this task periodically reduces the amount of time it takes for reports to display.

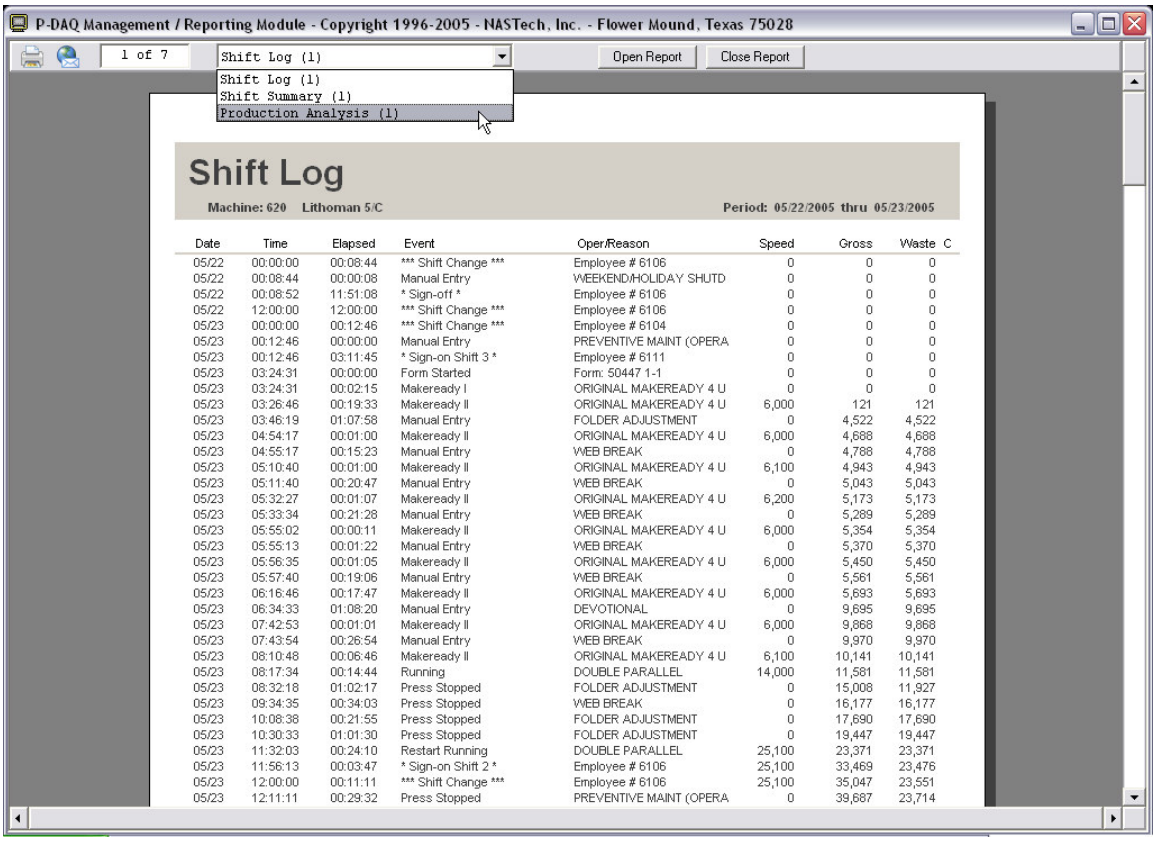
- Using Windows "Scheduled Tasks", you may schedule **P-Admin** to run periodically, and the summary databases to be updated automatically. This ensures that the summary databases are always up to date. The following is the procedure to set up the task:

    - Choose **Start\ControlPanel\SheduledTasks**.
    - Click "Add Scheduled Task".
    - Click "Next".
    - Click the "*Browse*" button and browse the server to the **PDAQdp\Shared** directory and select the **P-Admin.exe** file.
    - Follow the instructions to select the time and enter the user name and password when prompted.
    - Check the box marked "*Open Advanced Properties for this Task when I click Finish*" button and click the finish button.
    - In the *Run* field, change the path to read exactly as in the following: **C:\PDAQdp\Shared\P-Admin.exe AUTO**
    - In the *Start In* field, make sure the path is as following: **C:\PDAQdp\Shared**

Multiple Report View

Multiple reports can be opened simultaneously. Once a report is open, the **Open Report** button is used to produce another report.

Once multiple reports are opened, you may toggle the reports to be viewed using the dropdown list. To close the associated report, use the **Close Report** button.

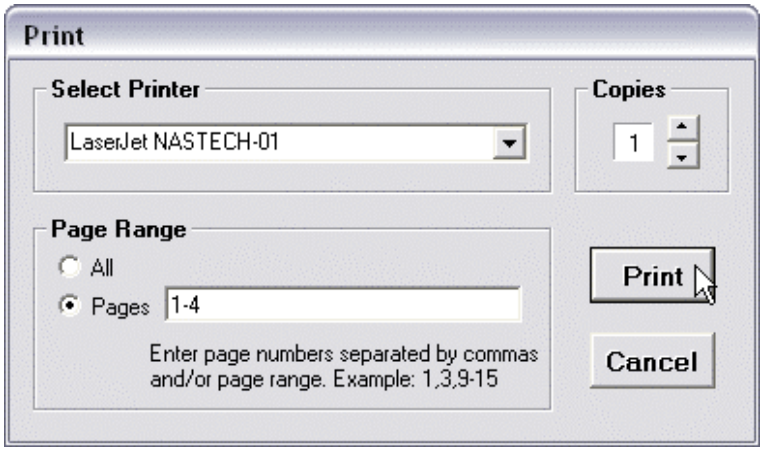


Date	Time	Elapsed	Event	Oper/Reason	Speed	Gross	Waste	C
05/22	00:00:00	00:08:44	*** Shift Change ***	Employee # 6106	0	0	0	
05/22	00:08:44	00:00:08	Manual Entry	WEEKEND/HOLIDAY SHUTD	0	0	0	
05/22	00:08:52	11:51:08	* Sign-off *	Employee # 6106	0	0	0	
05/22	12:00:00	12:00:00	*** Shift Change ***	Employee # 6106	0	0	0	
05/23	00:00:00	00:12:46	*** Shift Change ***	Employee # 6104	0	0	0	
05/23	00:12:46	00:00:00	Manual Entry	PREVENTIVE MAINT (OPERA	0	0	0	
05/23	00:12:46	03:11:45	* Sign-on Shift 3 *	Employee # 6111	0	0	0	
05/23	03:24:31	00:00:00	Form Started	Form: 50447 1-1	0	0	0	
05/23	03:24:31	00:02:15	Makeready I	ORIGINAL MAKEREADY 4 U	0	0	0	
05/23	03:26:46	00:19:33	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	121	121	
05/23	03:46:19	01:07:58	Manual Entry	FOLDER ADJUSTMENT	0	4,522	4,522	
05/23	04:54:17	00:01:00	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	4,688	4,688	
05/23	04:55:17	00:15:23	Manual Entry	WEB BREAK	0	4,788	4,788	
05/23	05:10:40	00:01:00	Makeready II	ORIGINAL MAKEREADY 4 U	6,100	4,943	4,943	
05/23	05:11:40	00:20:47	Manual Entry	WEB BREAK	0	5,043	5,043	
05/23	05:32:27	00:01:07	Makeready II	ORIGINAL MAKEREADY 4 U	6,200	5,173	5,173	
05/23	05:33:34	00:21:28	Manual Entry	WEB BREAK	0	5,289	5,289	
05/23	05:55:02	00:00:11	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	5,354	5,354	
05/23	05:55:13	00:01:22	Manual Entry	WEB BREAK	0	5,370	5,370	
05/23	05:56:35	00:01:05	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	5,450	5,450	
05/23	05:57:40	00:19:06	Manual Entry	WEB BREAK	0	5,561	5,561	
05/23	06:16:46	00:17:47	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	5,693	5,693	
05/23	06:34:33	01:08:20	Manual Entry	DEVOTIONAL	0	9,695	9,695	
05/23	07:42:53	00:01:01	Makeready II	ORIGINAL MAKEREADY 4 U	6,000	9,868	9,868	
05/23	07:43:54	00:26:54	Manual Entry	WEB BREAK	0	9,970	9,970	
05/23	08:10:48	00:06:46	Makeready II	ORIGINAL MAKEREADY 4 U	6,100	10,141	10,141	
05/23	08:17:34	00:14:44	Running	DOUBLE PARALLEL	14,000	11,581	11,581	
05/23	08:32:18	01:02:17	Press Stopped	FOLDER ADJUSTMENT	0	15,008	11,927	
05/23	09:34:35	00:34:03	Press Stopped	WEB BREAK	0	16,177	16,177	
05/23	10:08:38	00:21:55	Press Stopped	FOLDER ADJUSTMENT	0	17,690	17,690	
05/23	10:30:33	01:01:30	Press Stopped	FOLDER ADJUSTMENT	0	19,447	19,447	
05/23	11:32:03	00:24:10	Restart Running	DOUBLE PARALLEL	25,100	23,371	23,371	
05/23	11:56:13	00:03:47	* Sign-on Shift 2 *	Employee # 6106	25,100	33,469	23,476	
05/23	12:00:00	00:11:11	*** Shift Change ***	Employee # 6106	25,100	35,047	23,551	
05/23	12:11:11	00:29:32	Press Stopped	PREVENTIVE MAINT (OPERA	0	39,687	23,714	

Print Dialog Box

Reports can be printed selectively or in their entirety using the print dialog box.

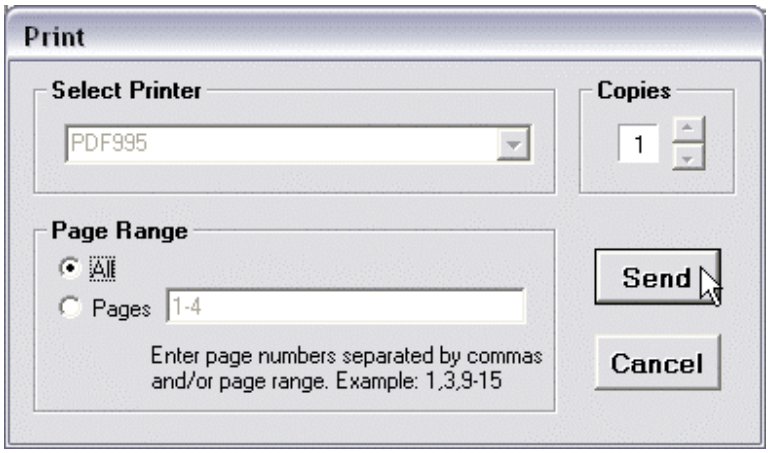
Select the printer to print to, select all pages or enter a page range as shown, and click the **Print** button.



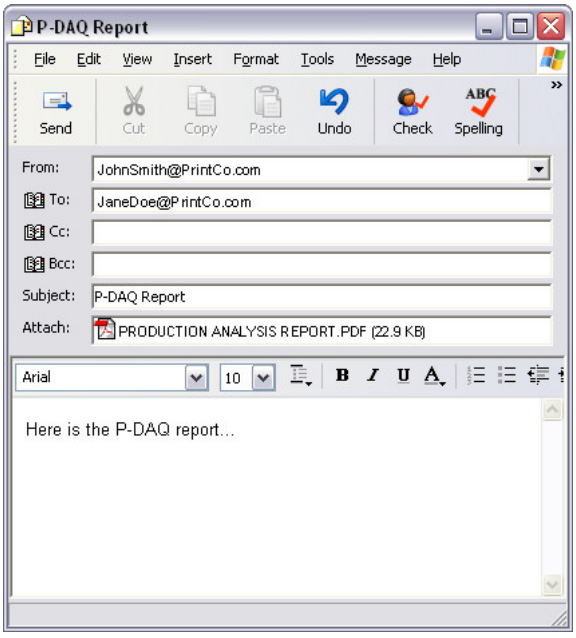
Email Dialog Box

Reports can be sent via email using the default email program on the associated client computer. Third party software called “PDF995” is required to convert the report into a PDF file. Please contact a NASTech representative for more information about this software.

Select all pages or enter a page range as shown, and click the **Send** button.



P-Admin will automate the PDF conversion process, open the email client, and attach the PDF file to the message.



Charts

Press Statistics

The Press Statistics Report Charts can be customized for your plant. There are 12 charts in total, they are titled as follows:

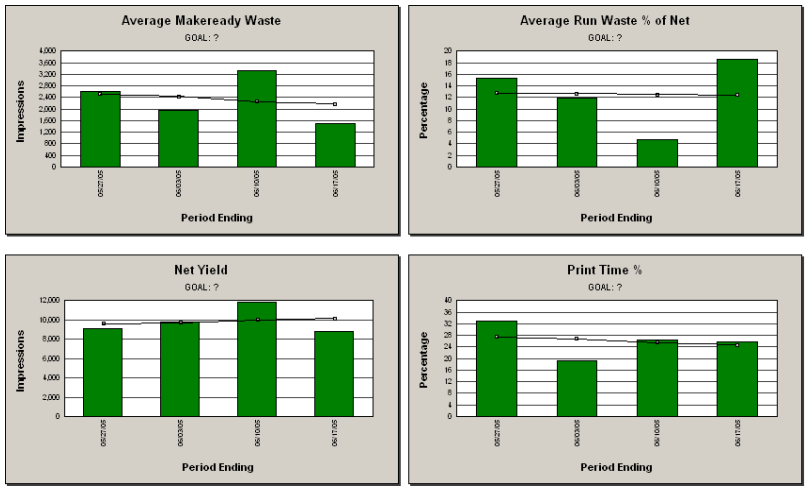
- Makeready Waste
- Run Waste
- Net Yield
- Print Time
- Makeready Time
- Net Speed
- Stop Time
- Impressions Per Stop
- Average Initial Makeready Time
- Average Initial Makeready Waste
- Average Subsequent Makeready Time
- Average Subsequent Makeready Waste

These charts are available for both the **Press Statistics** / **Trend Analysis** reports, and for the **Press Statistics** / **Year to Date** reports. Both of these reports are also available by Crew/Operator, and by Crew/Shift.

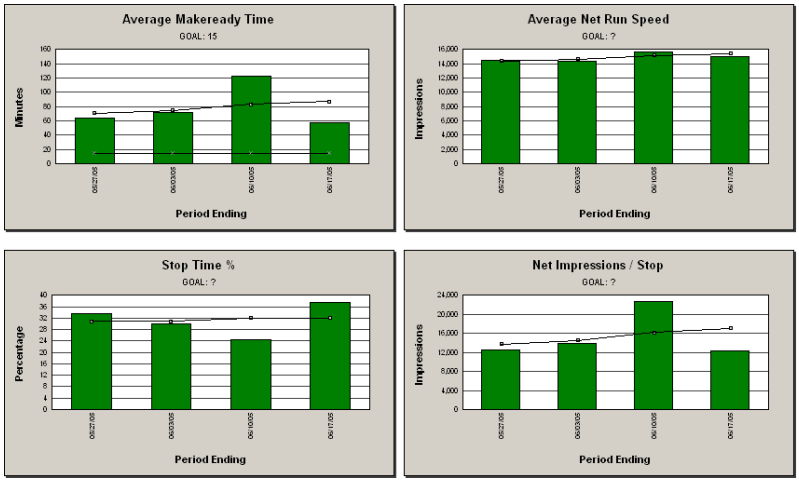
P-Admin allows you to print any 1, 2 or 4 of these charts on the associated report.

You may also have multiple reports set up, for example, you can have a **Press Statistics** / **Trend Analysis 1**, and a **Press Statistics** / **Trend Analysis 2...** You can then choose to display any combination of the charts on each of these reports. For example:

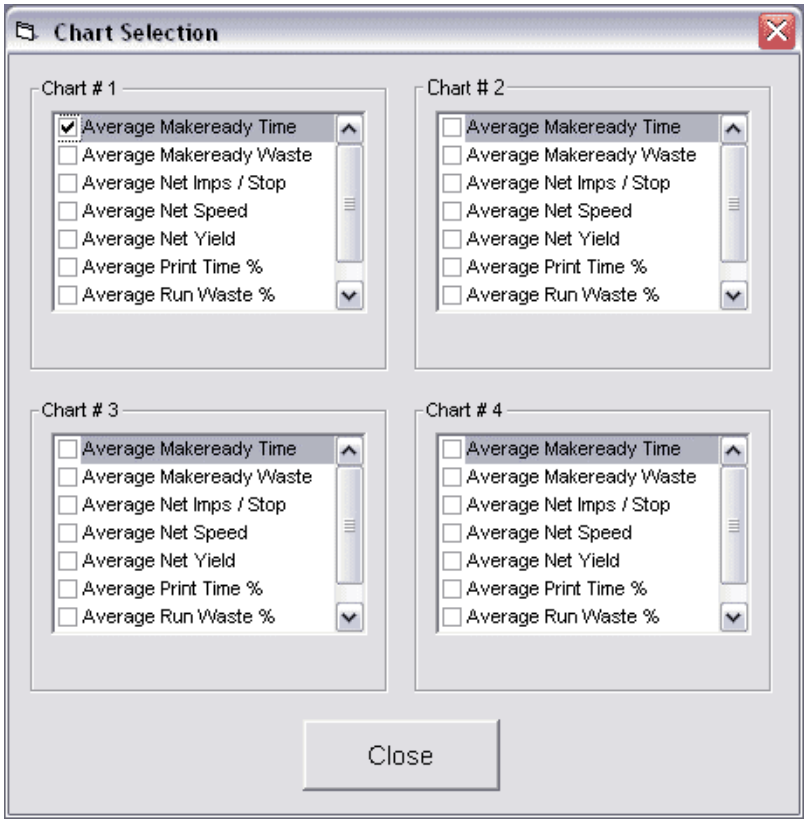
Press Statistics 1 (Trend Analysis)



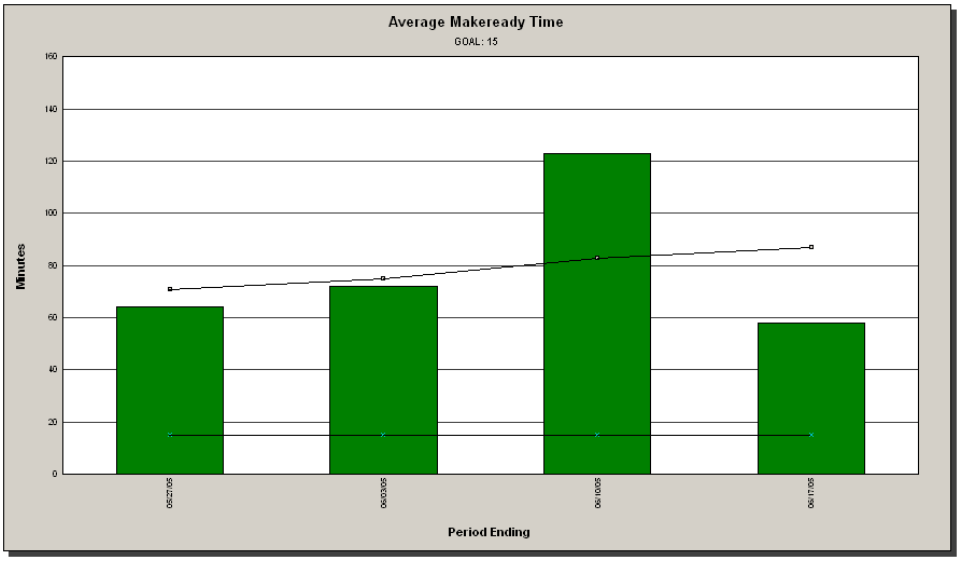
Press Statistics 2 (Trend Analysis)



You may also choose to not predefine the charts; in this case the user will be prompted to select the charts he or she wishes to view on the associated report. For example:



You may predefine, or the user can select 1 or 2 charts for viewing; in this case, the chart(s) will expand to fit the entire width of the screen. For example:



To predefine the charts to be viewed, edit the **P-Admin.ini** file located in the **PDAQdp\Shared\Init** directory on the server. Contact a NASTech representative for further assistance in editing this file.

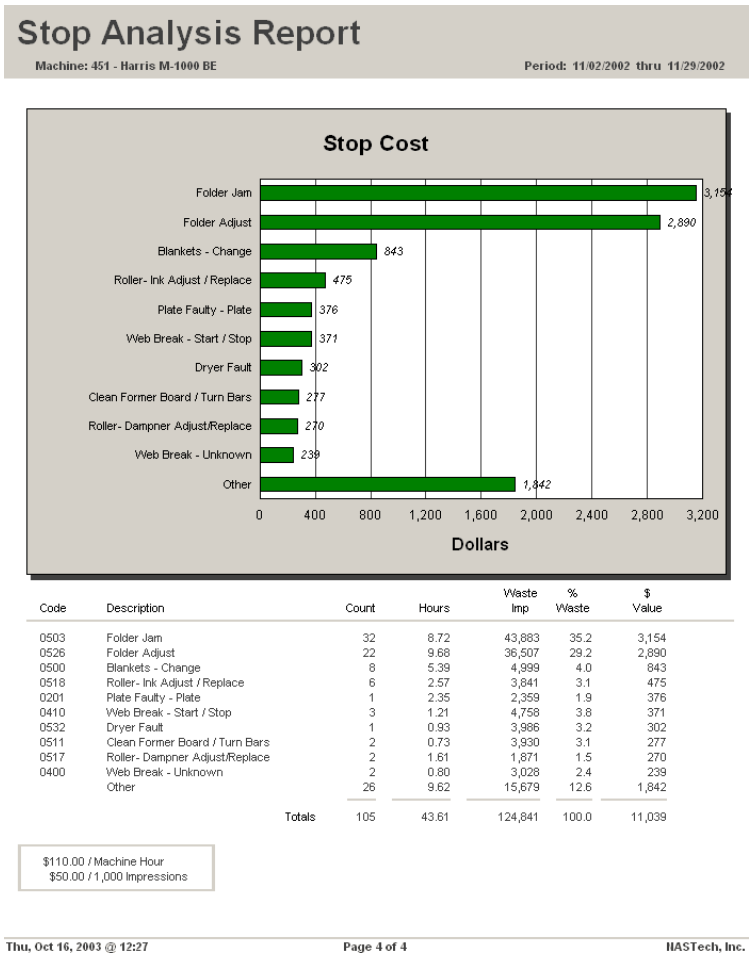
To predefine the Goal lines used on these reports, add the goals to the **Press Goal** table using the **P-Maint** program. Contact a NASTech representative for further assistance in editing this database table.

Stop Analysis

The Stop Analysis Reports chart the top ten reasons for press stops based on 4 different criteria. They are as follows:

- Occurrences
- Down-Time
- Waste
- Cost

For Example:



Stop Analysis Report

Machine: 451 - Harris M-1000 BE Period: 11/02/2002 thru 11/29/2002

Code	Description	Count	Hours	Waste Imp	% Waste	$ Value
0503	Folder Jam	32	8.72	43,883	35.2	3,154
0526	Folder Adjust	22	9.68	36,507	29.2	2,890
0500	Blankets - Change	8	5.39	4,999	4.0	843
0518	Roller- Ink Adjust / Replace	6	2.57	3,841	3.1	475
0201	Plate Faulty - Plate	1	2.35	2,359	1.9	376
0410	Web Break - Start / Stop	3	1.21	4,758	3.8	371
0532	Dryer Fault	1	0.93	3,986	3.2	302
0511	Clean Former Board / Turn Bars	2	0.73	3,930	3.1	277
0517	Roller- Dampner Adjust/Replace	2	1.61	1,871	1.5	270
0400	Web Break - Unknown	2	0.80	3,028	2.4	239
	Other	26	9.62	15,679	12.6	1,842
	Totals	105	43.61	124,841	100.0	11,039

$110.00 / Machine Hour
$50.00 / 1,000 Impressions

Thu, Oct 16, 2003 @ 12:27 Page 4 of 4 NASTech, Inc.

In order to calculate cost, you must define the cost center's **Rate per Hour**, and **Rate per 1000 Impressions**. Set these numbers up in the **Cost Center** table using the **P-Maint** program. Contact a NASTech representative for further assistance in editing this database table.

System Logs

Pallet Log

This report shows the pallets that were produced during a specified period of time. Adjustments made to the pallets are also shown. The report is displayed in chronological order.

Heading

Heading	The press number, description, and the time period for the report.

Body

Date	The actual date on which the associated pallet was created or adjusted.
Time	The actual time at which the associated pallet was created or adjusted.
Event	Indicates whether the pallet was created or adjusted.
Seq	The pallet sequence number.
Pallet ID	The unique pallet identifier for the pallet.
Quantity	The original pallet quantity or the quantity after the adjustment was made.
Job Number	The job number for which the pallet was produced.
Sig ID	The Signature identifier for the associated job.
Description	The description of the product on the pallet.
Type	The type of product on the pallet. Used to indicate samples, VIP's etc.

Footing

Footing	The date and time the report was run, the page number and the company name.

Paper Log

This report shows the roll stock that was consumed during a specified period of time. The report is displayed in chronological order.

Heading

Heading	The press number, description, and the time period for the report.

Body

Date	The actual date on which the associated event occurred.
Time	The actual time at which the associated event occurred.
Event	The entry made when a reading is taken, or when the counter has been reset.
Pos	The Position of the roll (upper or lower) on the roll stand. Web Presses.
Prod ID	The inventory product ID of the stock which was consumed.
Roll ID	The bar-code roll ID of the roll consumed.
Quantity	The amount of stock consumed. Number of Pounds for Web Presses. Number of Sheets for Sheet-Fed Presses.
Wrap	The amount of Wrapper waste in pounds. Web Presses.
Slab	The amount of Slab-off waste in pounds. Web Presses.
Core	The amount of Core Waste remaining on a roll when the roll will not be returned to inventory. Web Presses.
Job Number	The job for which the stock was consumed.
Form	The Form and Run numbers for which the stock was consumed.

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Log

This report shows the press speed fluctuations that occurred for a specified period of time. The press speed must change by the amount specified by the *Press Speed Variance* parameter in the **Pressman.ini** file. The report is displayed in chronological order.

Heading

Heading	The press number, description, and the time period for the report.

Body

Date	The actual date on which the associated event occurred.
Time	The actual time at which the associated event occurred.
Elapsed	The elapsed hours, minutes and seconds of the event.
Event	The description of the event.
Speed	The speed of the press at the time the event occurred.
Gross	The gross impression count for the currently running form at the time the event occurred.
Waste	The calculated impression waste for the currently running form at the time of the event.

Footing

Footing	The date and time the report was run, the page number and the company name.

Shift Log

This report shows the events that have occurred on press for a specified period of time. The report is displayed in chronological order.

Heading

Heading	The press number, description, and the time period for the report.

Body

Date	The actual date on which the associated event occurred.
Time	The actual time at which the associated event occurred.
Elapsed	The elapsed time of the event.
Event	The description of the event.
Oper/Reason	The description of the operation performed or the reason for the Down-Time.
Speed	The speed of the press at the time the event occurred.
Gross	The gross impression count for the currently running form at the time the event occurred.
Waste	The calculated impression waste for the currently running form at the time of the event.
Comments	The comments entered by the Pressman to provide additional information about the associated event.

Footing

Footing	The date and time the report was run, the page number and the company name.

Job Statistics

Job Statistics Report

This report shows Makeready and Run statistics for a specified job. All Forms, runs and Re-Runs for the specified job are printed. Totals are provided for the entire job.

Demographics

Job Number	The number and description of the job for which the report was requested.
Customer #	The customer ID and name for which the job was run.

Body

Form/Run/Re-Run	The form ID for each of the forms associated with the job being reported.
Description	The description of the form and the form type.
Start Date	The date this occurrence of the form was started.
Start Time	The time this occurrence of the form was started.
M/R Hours	The number of hours expended for Makeready I and Makeready II.
Run Hours	The number of hours expended for Makeready III and the Run.
Down-Time	The number of hours expended for Down-Time including press restarts.
M/R Impressions	The number of waste impressions accumulated during Makeready.
Gross Impressions	The total impressions accumulated for the form. Includes all impressions from the beginning to the end of the form.
Ordered	The quantity ordered.
Net Impressions	The number of net impressions accumulated during Makeready III and the Run.
Run/Waste %	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Detail by Form

This report shows Makeready, Run, and Down-Time statistics for one or more forms within a specified job. If all forms for the job are selected, a summary report will also be displayed for the entire job. The following describes both the Detail and Summary report options. The Summary report does not break out Down-Time statistics and does not break out stop codes.

Heading

Heading	The press the form was run on, and the start and end dates for the form.

Demographics

Job Number	The job number and associated description.
Form ID	The form ID for each of the forms associated with the job being reported, and the signature numbers.
Run	The Run number for each of the associated forms being reported.
Re-Run	The occurrence of the particular Run. Used if the form and run is run on different occasions.
Customer	The customer ID and associated customer name.
Ordered	The order quantity.

Shift Detail

Shift	The shift number.
Gross (Imp)	The total accumulated gross count by shift.
Net (Imp)	The total accumulated net count by shift.
Waste (Imp)	The total accumulated waste count by shift.
% Waste Net	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Print-Time	= (MR2 + MR3 + Run) in hours.

Event Detail

Gross (Imp)	Includes gross impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time +Restarting), Production/DT, and Non/Charge.
Net (Imp)	Includes net impressions accumulated during Production (MR3 + Run + Down-Time +Restarting).

Waste (Imp)	Includes waste impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time +Restarting) Production/DT, and Non-Charge.
Hours	Total Time for the associated event in hours.
Pct	The percentage of time for the associated event.
Num	The number of occurrences for the associated event.

Speed Detail

Gross	The average gross impressions per hour during Press/Run (MR3 + Run + Restart). = Gross Impressions / Run Hours.
Net	The average net impressions per hour during Press/Run (MR3 + Run + Restart). = Net Impressions / Run Hours.

Yield

Gross	The average number of gross impressions per hour during Press/Run (MR3 + Run + Restart). = Gross Impressions / Run Hours.
Net	The average number of net impressions per hour during Press/Run (MR3 + Run + Restart). = Net Impressions / Run Hours.

Stop Detail

Stops	M = Makeready, I = Idle. (Detail Report only)
Code	The down time code.
Description	The code description.
Waste (Imp)	The total waste impressions accumulated for the associated event.
Hours	The total time for the associated event in hours.
Pct	The percentage of the total time for the associated event.
Num	The number of occurrences for the associated event.
Manual Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
System Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
Idle Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).

Down-Time	Summary of all Down-Time by waste impressions, hours, time percentage and occurrences. Summarizes all Down-Time including Manual Entries, System Entries and Idle Entries. (Summary Report only).

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Statistics

Net Production Report

This report lists all jobs run on the specified press for the requested period. The jobs are listed in the order in which they were run.

Heading

Heading	The press number, description, and the time period for the report.

Body

Job #	The job identification number.
Customer Name	The customer's name.
Job Description	The description of the job.
Form-Run	The form and run numbers.
Form Type	The form type.
Net Imps	The number of impressions produced.
Ordered	The number of impressions requested.
Last Activity	The date and time of the last activity for this form.

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Speed & Waste

This report lists the speed and waste percentages for all jobs run on the specified press(s) for the requested period. The jobs are listed in the order in which they were run.

Heading

Heading	The time period for the report.

Body

Press #	The press number.
Date	The actual date on which the associated event occurred.
Job #	The job identification number.
Form-Run	The form and run numbers.
Net Imps	The number of net impressions produced.
Ordered	The number of impressions ordered.
Overs	The number of overs produced.
Over %	= Overs / Ordered * 100
MR Imps	Number of Makeready impressions produced.
Run-Waste %	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Run Speed	= Net Impressions / (MR3 + Run hours).
Form Desc	The form description.

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Statistics Report (Trend Analysis)

This report shows press statistical information summarized weekly by press and by shift. This report can display 4 charts simultaneously out of 12 possible charts. Multiple reports can be setup via the P-Admin.ini file to display different charts or combinations of these charts.

Heading

Heading	The press number, description, and the time period for the report.
Shift	The shift number(s).

Charts

- **Average Makeready Waste** impressions is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Makeready Time** is charted for each week in the specified period. Goal trend lines are also charted.
- **Average Initial Makeready Time** is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Subsequent Makeready Time** is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Initial Makeready Waste** impressions is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Subsequent Makeready Waste** impressions is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Run-Waste** as a percentage of gross run impressions is charted for each week in the specified period. Goal and trend lines are also charted.
- **Net Yield** is charted for each week in the specified period. Goal and trend lines are also charted.
- **Net Impressions** is charted for each week in the specified period. Goal and trend lines are also charted.
- **Net Speed** is charted for each week in the specified period. Goal and trend lines are also charted.
- **Stop Time** percentage is charted for each week in the specified period. Goal and trend lines are also charted.
- **Average Impressions per Stop** is charted for each week in the specified period. This is the average number of impressions to start saving after a press stop. Goal and trend lines are also charted.

Body

Period Ending	The date of the last day of the week. The first and last days of the week are defined in the P-Admin.ini file.
Net Impressions	The number of net impressions produced in the specified period.
M/R Count	The number of Makereadies performed during the specified period.
M/R-1 Hours	The number of hours expended for Makeready I for the specified period.
M/R-2 Hours	The number of hours expended for Makeready II for the specified period.
M/R Waste	The number of waste impressions accumulated during Makeready for the specified period.
Stop Count	The number of Press-Stops which occurred during Makeready III and Press Running for the specified period.
Stop Hours	The total Down-Time which occurred during Makeready III and Press Running for the specified period.
Run-Waste	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Run Hours	The number of hours expended for Makeready III and Press Running for the specified period.
Print Hours	The number of hours expended for Makeready II, Makeready III and Press Running for the specified period.
Total Hours	The total hours for the selected period.
Net Speed	= Net Impressions / Print Time (MR2 + MR3 + Run) * 100
% Run-Waste	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Net Yield	= Net Impressions / (MR3 + Run + Down-Time hours)
Print-Time %	= Print Hours (MR2 + MR3 + Run) / Scheduled Hours * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Statistics Report (YTD Averaging)

This report shows press statistical information summarized weekly by press and by shift. This report can display 4 charts simultaneously out of 12 possible charts. Multiple reports can be setup via the P-Admin.ini file to display different charts or combinations of these charts.

Heading

Heading	The press number, description, and the time period for the report.
Press #	The press number.

Charts

- **Average Makeready Waste** impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Makeready Time** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Initial Makeready Time** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Subsequent Makeready Time** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Initial Makeready Waste** impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Subsequent Makeready Waste** impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Run-Waste** as a percentage of gross run impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Net Yield** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Net Impressions** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Net Speed** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Stop Time** percentage is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Impressions per Stop** is charted for each week in the specified period. This is the average number of impressions to start saving after a press stop. Goal and YTD averages are also charted.

Body

Period Ending	The date of the last day of the week. The first and last days of the week are defined in the P-Admin.ini file.
Net Impressions	The number of net impressions produced in the specified period.
M/R Count	The number of Makereadies performed during the specified period.
M/R-1 Hours	The number of hours expended for Makeready I for the specified period.
M/R-2 Hours	The number of hours expended for Makeready II for the specified period.
M/R Waste	The number of waste impressions accumulated during Makeready for the specified period.
Stop Count	The number of Press-Stops which occurred during Makeready III and Press Running for the specified period.
Stop Hours	The total Down-Time which occurred during Makeready III and Press Running for the specified period.
Run-Waste	The total waste accumulated during Makeready III and Press Running for the specified period.
Run Hours	The number of hours expended for Makeready III and Press Running for the specified period.
Print Hours	The number of hours expended for Makeready II, Makeready III and Press Running for the specified period.
Total Hours	The total hours for the selected period.
Net Speed	= Net Impressions / (MR3 + Run)
% Run-Waste	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Net Yield	= Net Impressions / (MR-3 + Run + Down-Time hours).
Print-Time %	= Print Hours (MR2 + MR3 + Run) / Total Hours * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Analysis Report

This report summarizes key operating indicators for the specified period. The report may include statistical data for multiple presses and/or shifts. The following describes both the Detail and Summary report options. The Summary report combines shift statistics for all shifts.

Heading

Heading	The press number, description, and the time period for the report.
Shift	The shift number(s).

Counts

Gross Impressions	The total number of impressions accumulated for the specified period.
Net Impressions	The total number of net impressions accumulated for the specified period.
Net Signatures	The total number of net signatures accumulated for the specified period.
Net Yield	= Net Imp / (MR3 + Run + Down-Time + Wash-Up Hours).

Makeready

Number	The number of Initial, Subsequent and Total Makereadies.
M/R-1	The time for Initial, Subsequent, and total MR1 in hours.
M/R-2	The time for Initial, Subsequent, and total MR2 in hours.
Waste	The number of waste impressions accumulated during Initial, Subsequent and Total Makereadies, and the average number of Impressions per Makeready.

Stops

Number	The number of Press-Stops which occurred for the specified period. Only those stops incurred during Makeready III and Press Running are included
Time	The total number of Down-Time hours expended for the specified period. Only the Down-Time incurred during Makeready III and Press Running are included.

Wash-Up

Wash-Up	The total Wash-Up time in hours.

Waste

Run	Total waste impressions during Run, and the Run-Waste percentage. = (MR3 + Run + Restarting) / Net Impressions * 100
Idle	The number of impressions accumulated during Idle-Time.
Total Signatures	Total waste impressions, and total Run-Waste percentage. = Total Waste / Net Impressions * 100

Productivity

Print-Time	Total Print-Time (MR2 + MR3 + Run)
Print-Time%	= (Print-Time / Scheduled-Time).
Sched	Total Scheduled Time in hours.
Idle	Total Idle-Time in hours.
Total	Total Time in hours.

Shift Detail

Period Ending	The date.
Shift	The shift number.
Gross Imps	Gross impressions.
MR Waste	Total MR waste impressions (MR2 + MR3).
Run-Waste	Total Run-Waste (MR3 + Run + Restart).
Net Imps	Total net impressions.
Net Sigs	Total net signatures.
Waste Imps	Total waste impressions.
Tot Wst / Net	= Total Waste / Net Impressions * 100.
Run Wst / Net	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Detail by Press

This report summarizes pressroom activity by operation and Down-Time for the associated shift(s) and press during the specified period. The following describes both the Detail and Summary report. The Summary report does not break out Down-Time statistics and does not break out stop codes.

Heading

Heading	The press(s) the form was run on, and the start and end dates for the form.

Shift Detail

Shift	The shift number.
Gross (Imp)	The total accumulated gross count by shift.
Net (Imp)	The total accumulated net count by shift.
Waste (Imp)	The total accumulated waste count by shift.
% Waste Net	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Print-Time	= (MR2 + MR3 + Run) in hours.

Event Detail

Gross (Imp)	Includes gross impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time +Restarting), Production/DT, and Non/Charge.
Net (Imp)	Includes net impressions accumulated during Production (MR3 + Run + Down-Time +Restarting).
Waste (Imp)	Includes waste impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time +Restarting), Production/DT, and Non/Charge.
Hours	Total time for the associated event in hours.
Pct	The percentage of time for the associated event.
Num	The number of occurrences for the associated event.

Speed Detail

Gross	The average gross impressions per hour during Press Run (MR3 + Run + Restart). = Gross Impressions / Run Hours.

Net	The average net impressions per hour during Press Run (MR3 + Run + Restart). = Net Impressions / Run Hours.

Yield

Gross	The average number of gross impressions per hour during Press Run (MR3 + Run + Restart). = Gross Impressions / Run Hours + Downtime + Washup.
Net	The average number of net impressions per hour during Press Run (MR3 + Run + Restart). = Net Impressions / Run Hours + Downtime + Washup.

Stop Detail

Stops	I = Idle D = Downtime (Summary Report) M = Manual Entry Downtime (Detail Report) S = Press Stopped Downtime (Detail Report)
Code	The Down-Time code.
Description	The code description.
Waste (Imp)	The total waste impressions accumulated for the associated event.
Hours	The total time for the associated event in hours.
Pct	The percentage of the total time for the associated event.
Num	The number of occurrences for the associated event.
Manual Entries	waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
System Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
Idle Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
Down-Time	Summary of all Down-Time by waste impressions, hours, time percentage and occurrences. (Summary Report).

Footing

Footing	The date and time the report was run, the page number and the company name.

Daily Production Summary

This report summarizes daily pressroom activity by press and by shift. Includes the number of Makereadies, The total number of impressions produced, and the total Print-Time in hours.

Heading

Heading	The date of the report.
Press #	The Cost Center number.

Shift Data

Form Detail	The associated job, form, run, re-run, and form description.
Run Detail	Makeready Time in hours, (Number of Makereadies), and rounded net quantities by form.
Print-Time	The total hours of Print-Time (MR2 + MR3 + Run) during the shift.

Totals

Total Net	The total number of impressions accumulated for the specified shift.
Total # of MR	The total number of Makereadies for the entire day.
Total # of Net	The total number of net impressions produced on the associated press for the entire day.
Grand Total # M/R	The total number of Makereadies performed on the associated press for the entire day.

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Waste Report

This report summarizes daily waste percentage statistics for selected presses.

Heading

Heading	The time period for the report.

Body

Press #	The Cost Center number.
Date	The date the form was run.
Shift	The associated shift number.
Job	The associated job number.
Job Name	The associated job description.
Form	The form number.
Run	The Run number.
Gross Imps	The total impressions accumulated during the specified period.
Waste Count	The total number of waste impressions accumulated for the specified period.
Net Count	The total number of net impressions accumulated for the specified period.
Waste %	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Shift Summary Report

This report summarizes pressroom activity by operation and Down-Time for the requested period and shift(s). The following describes both the Detail and Summary report. The Summary report does not break out Down-Time statistics and does not break out stop codes.

Heading

Heading	The press number, and the start and end dates for the report.
Shift	The shift number(s).
Gross Count	The total impressions accumulated during the specified period.
Net Count	The total number of net impressions accumulated for the specified period.
Waste Count	The total number of waste impressions accumulated for the specified period.

Event Detail

S,M,I	These print based upon whether the code is (I)dle, entered as a (M)annual Entry, or if the operation code was the initial cause of a press (S)top.
Code	The operation code of the associated activity. The body of the report is sorted by this code.
Description	The description of the operation code.
Count	The total number of occurrences of the associated operation or Down-Time.
Hours	The total number of hours expended for the associated operation or Down-Time.
Gross	The number of gross impressions.
Good	The number of net impressions.
Waste Imp	The total number of waste impressions accumulated during the specified period.
Waste %	Waste for the associated operation or Down-Time as a percentage of the total waste. = Waste / Total Waste * 100
Manual Entries	Waste impressions, hours, time percentage, and number of occurrences by shift. (Detail Report only).
System Entries	Waste impressions, hours, time percentage, and number of occurrences by shift. (Detail Report only).

Idle Entries	Waste impressions, hours, time percentage, and number of occurrences by shift. (Detail Report only).
Down-Time	Summary of all Down-Time by waste impressions, hours, time percentage and occurrences. (Summary Report).

Footing

Footing	The date and time the report was run, the page number and the company name.

Stop Analysis Report

This report is used to analyze Press-Stops based on several different criteria. Several charts are produced which rank the reasons for the stops.

Heading

Heading	The selected press numbers, press description, and the start and end dates for the report.

Charts

- Top 10 causes of Press-Stops based on frequency of the stop.
- Top 10 causes of Press-Stops based on Down-Time hours.
- Top 10 causes of Press-Stops based on accumulated waste.
- Top 10 causes of Press-Stops based on aggregate cost.

Body

Oper Code	The Press-Stop code.
Description	The reason for the Press-Stop.
Count	The number of Press-Stops for the specified period.
Hours	The total number of Down-Time hours expended for the Press-Stop.
Waste Imp	The total number of waste impressions accumulated as a result of restarting the press after the Press-Stop.
%	Percentages of total Stops, total Waste, total Hours, and total Cost is displayed dependant of the report page.
$ Value	The dollar value based on the machine rate and the cost per 1000 impressions based on the values defined in **P-Maint.**

Footing

Footing	The date and time the report was run, the page number and the company name.

Crew Reporting

Press Statistics Report (Trend Analysis)

This report shows press statistical information summarized weekly by press and by crew.

Heading

Heading	The press number, description, and the time period for the report.

Charts

- **Average Makeready Waste** impressions is charted for each week in the specified period. Goal and Trend lines are also charted.
- **Average Run-Waste** as a percentage of gross run impressions is charted for each week in the specified period. Goal and Trend lines are also charted.
- **Net Yield** is charted for each week in the specified period. Goal and Trend lines are also charted.
- **Print-Time Percentage** is charted for each week in the specified period. Goal and Trend lines are also charted.

Body

Period Ending	The date of the last day of the week. The first and last days of the week are defined in the **P-Admin.ini** file.
Net Impressions	The number of net impressions produced in the specified period.
M/R Count	The number of Makereadies performed during the specified period.
M/R-1 Hours	The number of hours expended for Makeready I for the specified period.
M/R-2 Hours	The number of hours expended for Makeready II for the specified period.
M/R Waste	The number of waste impressions accumulated during Makeready for the specified period.
Stop Count	The number of Press-Stops which occurred during Makeready III and Running for the specified period.
Stop Hours	The total Down-Time which occurred during Makeready III and Press Running for the specified period.
Run-Waste	The total waste accumulated during Makeready III and Press Running for the specified period.

Run Hours	The number of hours expended for Makeready III and Press Running for the specified period.
Print Hours	The number of hours expended for Makeready II, Makeready III and Press Running for the specified period.
Total Hours	The total hours for the selected period.
Net Speed	= Net Impressions / Print Hours (MR2 + MR3 + Run) * 100
% Run-Waste	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Net Yield	= Net Impressions / (MR-3 + Run + Down-Time hours)
Print-Time %	= Print Hours (MR2 + MR3 + Run) / Scheduled Hours * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Press Statistics Report (YTD Averaging)

This report shows press statistical information summarized weekly by press and by crew.

Heading

Heading	The press number, description, and the time period for the report.

Charts

- **Average Makeready Waste** impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Average Run-Waste** as a percentage of gross run impressions is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Net Yield** is charted for each week in the specified period. Goal and YTD averages are also charted.
- **Net Impressions** per Press-Stop is charted for each week in the specified period. Goal and YTD averages are also charted.

Body

Period Ending	The date of the last day of the week. The first and last days of the week are defined in the P-Admin.ini file.
Net Impressions	The number of net impressions produced in the specified period.
M/R Count	The number of Makereadies performed during the specified period.
M/R-1 Hours	The number of hours expended for Makeready I for the specified period.
M/R-2 Hours	The number of hours expended for Makeready II for the specified period.
M/R Waste	The number of waste impressions accumulated during Makeready for the specified period.
Stop Count	The number of Press-Stops which occurred during Makeready III and Press Running for the specified period.
Stop Hours	The total Down-Time which occurred during Makeready III and Press Running for the specified period.
Run-Waste	The total waste accumulated during Makeready III and Press Running for the specified period.
Run Hours	The number of hours expended for Makeready III and Run for the specified period.

Print Hours	The number of hours expended for Makeready II, Makeready III and the Press Running for the specified period.
Total Hours	The total hours for the selected period.
Net Speed	= Net Impressions / Print Hours (MR2 + MR3 + Run)* 100.
% Run-Waste	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Net Yield	= Net Impressions / (MR-3 + Run + Down-Time hours)
Print-Time %	= Print Hours (MR2 + MR3 + Run) / Scheduled Hours * 100.

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Analysis Report

This report summarizes key operating indicators for the specified period. The report may include statistical data for multiple presses and/or crews. The following describes both the Detail and Summary report. The Summary report does not break out shift statistics by shift number.

Heading

Heading	The press number, description, and the time period for the report.
Shift	The shift number(s).

Counts

Gross Impressions	The total number of impressions accumulated for the specified period.
Net Impressions	The total number of net impressions accumulated for the specified period.
Net Signatures	The total number of net signatures accumulated for the specified period.
Net Yield	= Net Impressions / (MR3 + Run + Down-Time hours).

Makeready

Number	The number of Initial, Subsequent and total Makereadies.
MR1	The time for Initial, Subsequent, and total MR1 in hours.
MR2	The time for Initial, Subsequent, and total MR2 in hours.
Waste	The number of waste impressions accumulated during Initial, Subsequent and total Makereadies, and the average number of impressions per Makeready.

Stops

Number	The number of Press-Stops which occurred for the specified period. Only those stops incurred during Makeready III and Press Running are included
Time	The total number of Down-Time hours expended for the specified period. Only the Down-Time incurred during Makeready III and Press Running are included.

Wash-Up

Wash-Up	The total Wash-Up time in hours.

Waste

Run	Total waste impressions during Run, and the Run-Waste percentage. = (MR3 + Run + Restarting) / Net Impressions * 100
Idle	The number of Impressions accumulated during Idle-Time.
Total Signatures	Total waste impressions, and total Run-Waste percentage. = Total Waste / Net Impressions.

Productivity

Print-Time	= (MR2 + MR3 + Run) in hours.
Print-Time %	(Print-Time / Scheduled-Time * 100).
Sched	Total Scheduled Time in hours.
Idle	Total Idle-Time in hours.
Total	Total Time in hours.

Shift Detail

Period Ending	The date.
Shift	The shift number.
Gross Imps	Gross impressions.
MR Waste	Total MR waste impressions (MR2 + MR3).
Run-Waste	Total Run-Waste (MR3 + Run + Restart).
Net Imps	Total net impressions.
Net Sigs	Total net signatures.
Waste Imps	Total waste impressions.
Tot Wst / Net	= Total Waste / Net Impressions.
Run Wst / Net	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Detail by Press

This report summarizes pressroom activity by operation and Down-Time for the associated crew(s) and press during the specified period. The following describes both the Detail and Summary report. The Summary report does not break out Down-Time statistics and does not break out stop codes.

Heading

Heading	The press number the form was run on, and the start and end dates for the form.

Shift Detail

Shift	The shift number.
Gross (Imp)	The total accumulated gross count by shift.
Net (Imp)	The total accumulated net count by shift.
Waste (Imp)	The total accumulated waste count by shift.
% Waste Net	The percentage of waste which occurred during MR3 + Run. =(MR 3 Waste + Run Waste + Restart Waste) / Net Impressions * 100
Print-Time	= (MR2 + MR3 + Run) in hours.

Event Detail

Gross (Imp)	Includes gross impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time + Restarting), Production/DT and Non/Charge.
Net (Imp)	Includes net impressions accumulated during Production (MR3 + Run + Down-Time +Restarting).
Waste (Imp)	Includes waste impressions accumulated during MR2. Also includes gross impressions accumulated during Production (MR3 + Run + Down-Time +Restarting), Production/DT, and Non/Charge.
Hours	Total Time for the associated event in hours.
Pct	The percentage of time for the associated event.
Num	The number of occurrences for the associated event.

Speed Detail

Gross	The average gross impressions per hour during Press/Run (MR3 + Run + Restart). = Gross Impressions / Run Hours.

Net	The average net impressions per hour during Press/Run (MR3 + Run + Restart). = Net Impressions / Run Hours.

Yield

Gross	The average number of gross impressions per hour during Press/Run (MR3 + Run + Restart). = Gross Impressions / Run Hours.
Net	The average number of net impressions per hour during Press/Run (MR3 + Run + Restart). = Net Impressions / Run Hours.

Stop Detail

Stops	M = Makeready, I = Idle. (Detail Report only)
Code	The Down-Time code.
Description	The code description.
Waste (Imp)	The total waste impressions accumulated for the associated event.
Hours	The total time for the associated event in hours.
Pct	The percentage of the total time for the associated event.
Num	The number of occurrences for the associated event.
Manual Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
System Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
Idle Entries	Waste impressions, hours, time percentage, and number of occurrences by form. (Detail Report only).
Down-Time	Summary of all Down-Time by waste impressions, hours, time percentage and occurrences. (Summary Report).

Footing

Footing	The date and time the report was run, the page number and the company name.

Production Summary Report

This report shows production information summarized weekly by press and by crew.

Heading

Heading	The press number the form was run on, and the start and end dates for the form.

Charts

- **Net impressions** are charted for each week in the specified period.
- **Run-Waste** as a percentage of net impressions is charted for each week in the specified period.

Body

Week Beginning	The date of the first day of the week (Sunday).

Yield

Gross Count	The total number of impressions accumulated for the specified period.
Net Count	The total number of net impressions accumulated for the specified period.

Speed

Gross	= Gross Count / (MR-2 + MR-3 + Run Hours)
Net	= Net Impressions / (MR-2 + MR-3 + Run Hours)

Waste

Makeready	The number of waste impressions accumulated during Makeready for the specified period.
Running	The total waste accumulated during Makeready III and Run for the specified period.
Restart	The total number of waste impressions accumulated as a result of restarting the Press after Makeready III and Run Down-Time for the specified period.
Imps / Stop	= Restart Waste / Number of Stops

Time

Makeready I	The number of hours expended for Makeready I for the specified period. Down-Time incurred during Makeready I is included in this number. The Down-Time which occurred during Makeready I is displayed in parenthesis to the right of this number.

Makeready II	The number of hours expended for Makeready II for the specified period. Down-Time incurred during Makeready II is included in this number. The Down-Time which occurred during Makeready II is displayed in parenthesis to the right of this number.
Running	The total number hours expended during Makeready III and Run for the specified period.
Down-Time	The total number of Down-Time hours expended for the specified period. Down-Time incurred during Makeready I and Makeready II is NOT included in this number.
Total Time	The total hours for the selected period.

Footing

Footing	The date and time the report was run, the page number and the company name.

Shift Summary Report

This report summarizes pressroom activity by operation and Down-Time for the requested period and shift(s).

Heading

Heading	The press number the form was run on, and the start and end dates for the form.

Counts

Gross Count	The total impressions accumulated during the specified period.
Net Count	The total number of net impressions accumulated for the specified period.
Waste Count	The total number of waste impressions accumulated for the specified period.

Body

S,M,I	These print based upon whether the code is (I)dle, entered as a (M)annual Entry, or if the operation code was the initial cause of a press (S)top.
Code	The operation code of the associated activity. The body of the report is sorted by this code.
Description	The description of the operation code.
Count	The total number of occurrences of the associated operation or Down-Time.
Hours	The total number of hours expended for the associated operation or Down-Time.
Waste Imp	The total number of waste impressions accumulated during the specified period.
Waste %	Waste for the associated operation or Down-Time as a percentage of the total waste. = Waste / Total Waste * 100

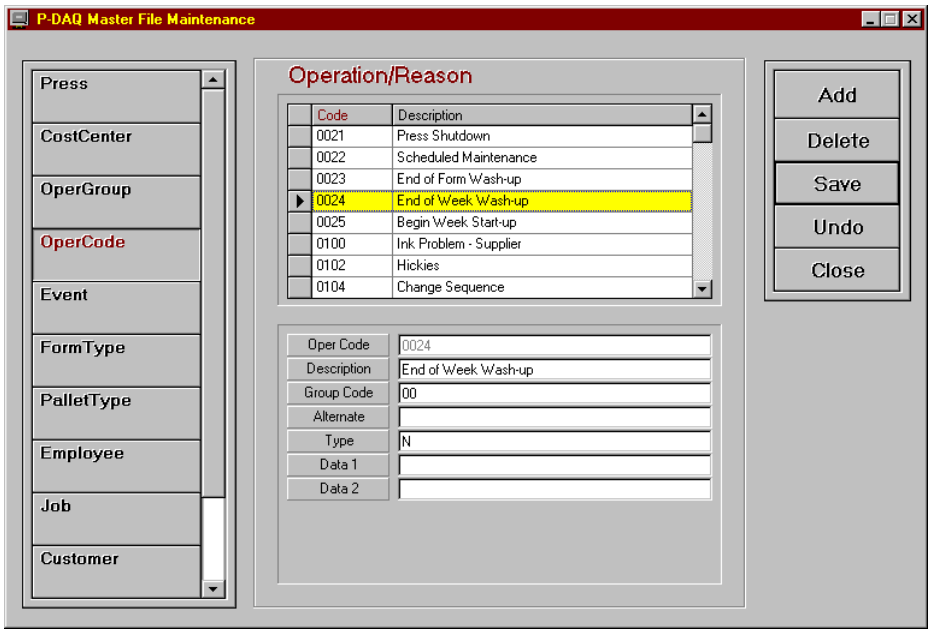
Footing

Footing	The date and time the report was run, the page number and the company name.

Chapter 9 Utilities

Overview

The **P-DAQDP** system contains several programs designed to perform system maintenance, to perform system updates, and to be used when **P-DAQDP** is to communicate with other systems. The following describes these programs in detail.



P-Maint

P-Maint is used to update tables that are stored in the Database.

To execute, from the client computer (this client must have permission as per the Security.ini file on the server), choose **Start/Programs/PDAQdp-Client/P-Maint.**

The buttons on the left side of the screen represent the tables to be edited. To edit a table, click on its associated button and use the center of the screen to enter the associated data.

The following pages list the fields to be edited and give a brief explanation of the required entries.

Code / Description fields

Code	This field is used to display the operation code, press number, employee number, etc…
Description	This field is used to provide a description of the code to be used.

Press

Press	The unique press number assigned by NASTech.
Cost Center	The cost center number assigned to the press.
Roll Stands	The number of roll stands.
Color Units	The number of color units.

Cost Center

Cost Center	The cost center number assigned to the press.
Description	A description of the press, IE. “Harris-M3000”
Cutoff length	The cutoff length of the Impression cylinder.
Rate/Hour	The hourly rate of the press in dollars.
Rate/M Imp	The average cost of materials per 1000 impressions.

Oper Group

Group Code	The group code.
Description	A description of the associated group.

Oper Code

Oper Code	The Oper Code number.
Description	A description of the code.
Group Code	The associated group the code belongs to.
Alternate	The code to be used to report the associated activity to the Cost Accounting system.
Type	Indicates weather the Code is: Chargeable (leave blank) Non Chargeable (N), Idle (I), Spoilage (S).
Machine Related	Indicates that the code is related to a press fault, stacker jam etc... Yes (Y), or No (N).
Man Related	Indicates that the code is related to human error. Yes (Y), or No (N).
Material Related	Indicates that the code is related to material problems. Yes (Y), or No (N).

External Cause	Indicates that the code is related to an external problem. Yes (Y), or No (N).
Makeready 1	Indicates that the code is a makeready 1 code. Yes (Y), or No (N).
Makeready 2	Indicates that the code is a makeready 2 code. Yes (Y), or No (N).
Run	Indicates that the code is a run code. Yes (Y), or No (N).
Wash-up	Indicates that the code is a Wash-up code. Yes (Y), or No (N).
Press Stop	Indicates that the code is a Press Stop code. Yes (Y), or No (N).
Manual Entry	Indicates that the code is available for a Manual Entry. Yes (Y), or No (N).
Run Waste	Indicates that the code is a Run Waste Code. Yes (Y), or No (N).
Data 1	Used to define additional data to be sent to Cost Accounting, usually when gross or net counts are to be sent along with the associated record.
Data2	Used to define Makereadies as Initial (I), or Subsequent (S).

OperListQuery

Center	The cost center number assigned to the press.
Oper Code	The associated operation code.
Description	The description of the operation code.
Active	Indicates that the code is valid for the associated press. Y or N.

OperTeleData

Cost Center	The operation code.
Category	The category, I.E. Man, Machine, Material, External…

Event

Event Code	The NASTech assigned Event Code.
Description	The description of the code.
Reason Reqd	Denotes whether a reason is required for the associated event. True or False.
OperCode	The default Operation Code for the associated event.

FormType

Form Type	The form type code.
Description	The description of the form type.

PalletType

Pallet Type	The pallet type code.
Description	The description of the pallet type.

Employee

Emp ID	The Employee number.
Name	The Employee's name.

Job

Job Number	The job number.
Description	The description of the job.
Cust ID	The customer number.
Cust Name	The customer name.
Quantity	The required quantity to be produced.
Master Job	The associated master Job number, used when the job is a Sub-Job.

Customer

Cust ID	The Customer ID number.
Company Name	The Company name.

PaperMill

Mill ID	The Mill ID number.
Mill Name	The Mill's name.

Product

Product	The paper stock product ID.
Description	The description of the stock.
Type	The Stock Type. I.E. Matte, Gloss…
U/M	
Width	The width of the roll.
Length	The length of the roll.
Basis Weight	The basis weight of the stock.

PressGoal

Cost Center	The cost center number designated for the press.
MR Waste Imps	Expected MR waste impressions.
Run Waste %	Expected Run Waste percentage.
Net Yield Imps	Expected net yield impressions.
Print Time %	Expected Print Time percentage.
Imps / Stop	Expected impressions per Stop. This is the number of Restart impressions it takes to save good signatures after the press stops.
Net Speed	Expected net speed.
Stop Time %	Expected Stop Time percentage.

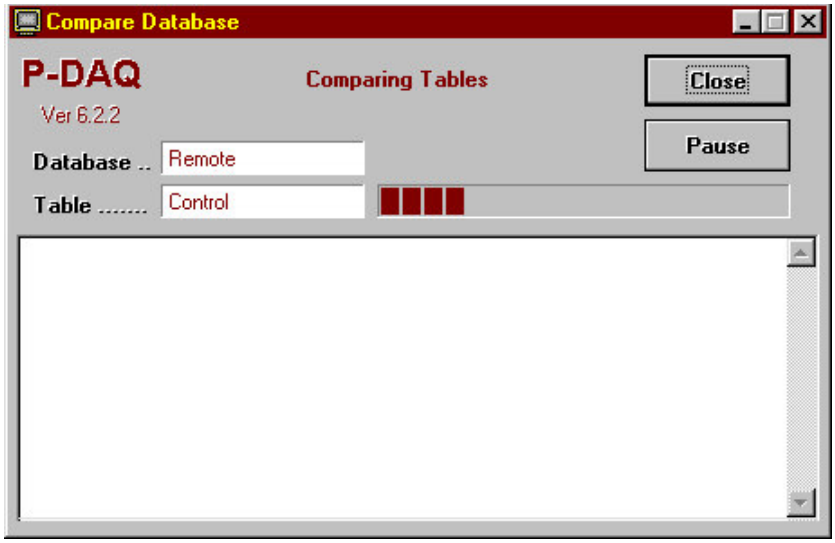
DataComp

In some cases when the software is updated, new fields are added, deleted or changed in the **P-DAQDP** database. DataComp is used to compare tables in the current database to the new tables in the updated database to indicate any changes that have been made.

DataComp should be executed on the Server and on the Press Computer whenever a system update is provided.

To execute on the Server, double click the **DataComp** icon in the **PDAQdp\Shared** directory.

To execute on the Press Computer, choose **Start/Programs/PDAQdp-Press Module/DataComp.**



To begin the compare process, click the **Continue** button. Any table structure that has been changed will appear in the display area of the screen.

If new fields have been added, use the **DataCopy** program to copy the old data to the new table as described in the following pages.

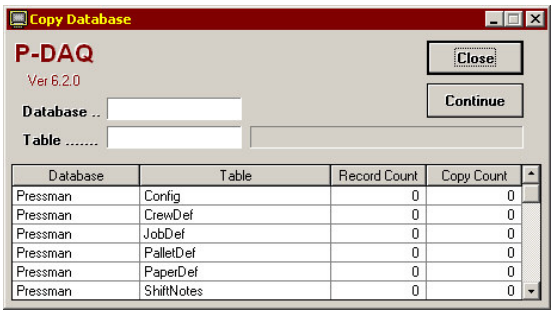
DataCopy

In some cases when the software is updated, new fields are added, deleted or changed in the **P-DAQDP** database. DataCopy is used to copy tables in the current database to the new tables in the updated database.

DataCopy should be executed on the server and on the Press Computer whenever DataComp shows a difference between the current and new database structures. However, when using SQL server, Data Copy is not required to be run on the server. A SQL script is provided for this purpose.

To execute from the Server, double click the **DataComp.exe** in the **PDAQdp\Shared** directory.

To execute from the Press Computer, choose **Start/Programs/PDAQdp-Press Module/DataComp**.



To begin the copy process, click the **Continue** button.

Auto DataCopy

DataCopy can be configured to run automatically on the first Tuesday of every month, after 9am when a new form is started. This feature was added to manage the size of the Stats.mdb file at press.

To turn this feature on, open the **DataSync.ini** file located in the ***PDAQdp/Shared/InitPress*** directory…

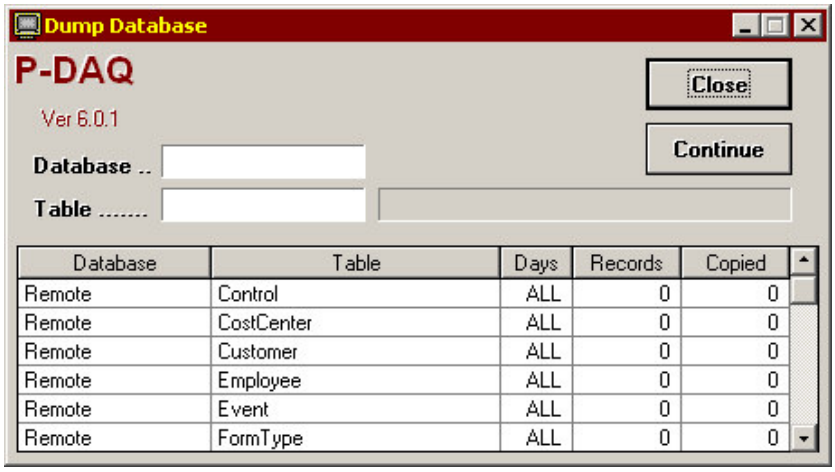
- Add the following parameter to the **[Constants]** section of the file:
  - AutoDataCopy = Yes

- Add the following to the very bottom of the file:
  - Database Name = "Other"
  - Copy Mode = "Update"
  - Table Name = "DataCopy"
- Save the file.

DataDump

Data Dump is used to extract data from PDAQdp databases to be sent via email to NASTech personnel for troubleshooting purposes.

To execute, double click the **DataDump** icon in the **PDAQdp\Shared** directory on the server.



Database	Table	Days	Records	Copied
Remote	Control	ALL	0	0
Remote	CostCenter	ALL	0	0
Remote	Customer	ALL	0	0
Remote	Employee	ALL	0	0
Remote	Event	ALL	0	0
Remote	FormType	ALL	0	0

The default records to be copied are pre-determined by the **DataDump.ini** file located in the **PDAQdp\Shared\Init** directory on the server. Under normal circumstances, the default values will suffice. However, during troubleshooting, a NASTech representative may ask the customer to include more or less data. To do so, on the Data Dump screen, enter the number of days prior to the current date to include in the Days field for each table to be copied.

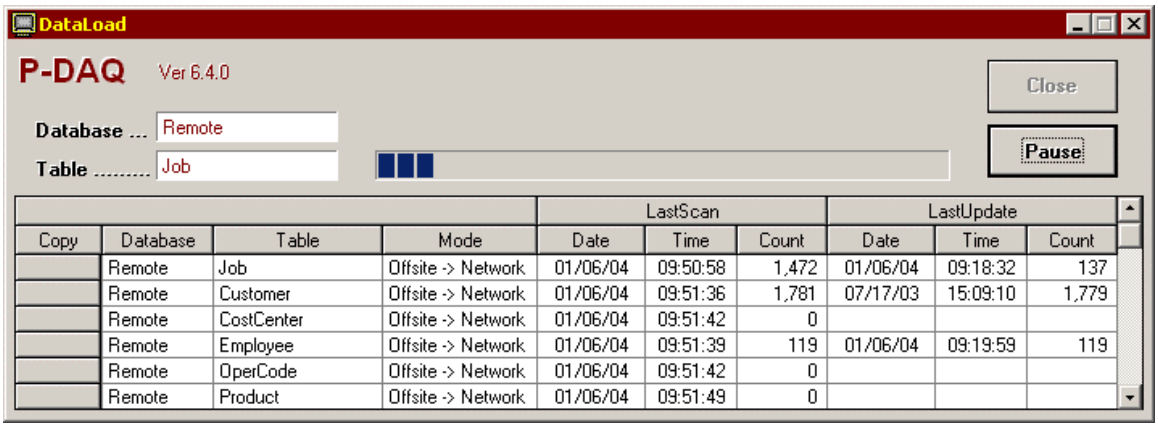
To begin the dump process, click the Continue button. Any table that has been copied will appear in the body of the program.

When completed, the copied databases will appear in the **PDAQdp\Shared\Database\Dump** directory on the server. The entire **Dump** directory should be Zipped and e-mailed to NASTech personnel for evaluation.

DataLoad

Data Load is used to extract and transfer data from the Primac Master Files to the **P-DAQDP** remote database. The DataLoad download criterion is user defined in the **DataLoad.ini** file located in the **PDAQdp\Shared\Init** directory on the server. The file itself contains a description of each required parameter.

To execute, double click the **DataLoad.exe** in the **PDAQdp\Shared** directory on the server.



				LastScan			LastUpdate		
Copy	Database	Table	Mode	Date	Time	Count	Date	Time	Count
	Remote	Job	Offsite -> Network	01/06/04	09:50:58	1,472	01/06/04	09:18:32	137
	Remote	Customer	Offsite -> Network	01/06/04	09:51:36	1,781	07/17/03	15:09:10	1,779
	Remote	CostCenter	Offsite -> Network	01/06/04	09:51:42	0			
	Remote	Employee	Offsite -> Network	01/06/04	09:51:39	119	01/06/04	09:19:59	119
	Remote	OperCode	Offsite -> Network	01/06/04	09:51:42	0			
	Remote	Product	Offsite -> Network	01/06/04	09:51:49	0			

To begin the copy process, click the **Continue** button. To expedite the flow of data to and from the server, tables can be copied in real time by clicking the associated **Copy** button.

DataLoad should be left running on the server at all times, however, you may Schedule the task as outlined in the following:

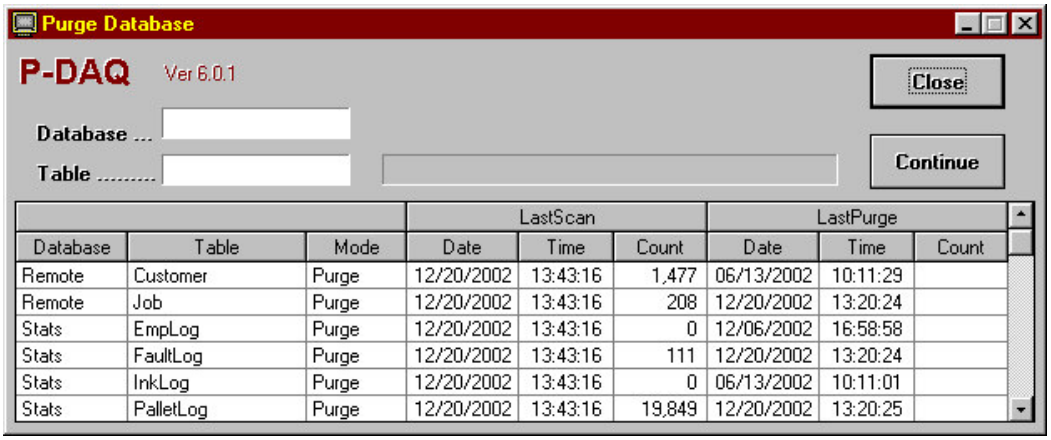
Using Windows “Scheduled Tasks”, you may schedule **DataLoad** to run periodically. The following is the procedure to set up the task:

- Choose **Start\ControlPanel\SheduledTasks**.
- Click “Add Scheduled Task”.
- Click “Next”.
- Click the “*Browse*” button and browse the server to the PDAQdp\Shared directory and select the **DataLoad.exe** file.
- Follow the instructions to select the time and enter the user name and password when prompted.
- Check the box marked “*Open Advanced Properties for this Task when I click Finish*” button and click the finish button.
- In the *Run* field, change the path to read exactly as in the following: **C:\PDAQdp\Shared\DataLoad.exe AUTO**
- In the *Start In* field, make sure the path is as following: **C:\PDAQdp\Shared**

DataPurg

DataPurg is used to delete un-needed historical data from the system. The tables to be purged and the data to be retained are both pre-determined by the **DataPurg.ini** file located in the **PDAQdp\Shared\Init** directory of the server. Under normal circumstances, the default values should suffice.

To execute, double click the **DataPurg** icon in the **PDAQdp\Shared** directory on the server.



			LastScan			LastPurge		
Database	Table	Mode	Date	Time	Count	Date	Time	Count
Remote	Customer	Purge	12/20/2002	13:43:16	1,477	06/13/2002	10:11:29	
Remote	Job	Purge	12/20/2002	13:43:16	208	12/20/2002	13:20:24	
Stats	EmpLog	Purge	12/20/2002	13:43:16	0	12/06/2002	16:58:58	
Stats	FaultLog	Purge	12/20/2002	13:43:16	111	12/20/2002	13:20:24	
Stats	InkLog	Purge	12/20/2002	13:43:16	0	06/13/2002	10:11:01	
Stats	PalletLog	Purge	12/20/2002	13:43:16	19,849	12/20/2002	13:20:25	

To begin the Purge process, click the **Continue** button.

DataPurg can be left running on the server, however it is recommended that you Schedule the task as outlined below. It is also recommended that DataPurg be scheduled at a time right after the network backup is performed.

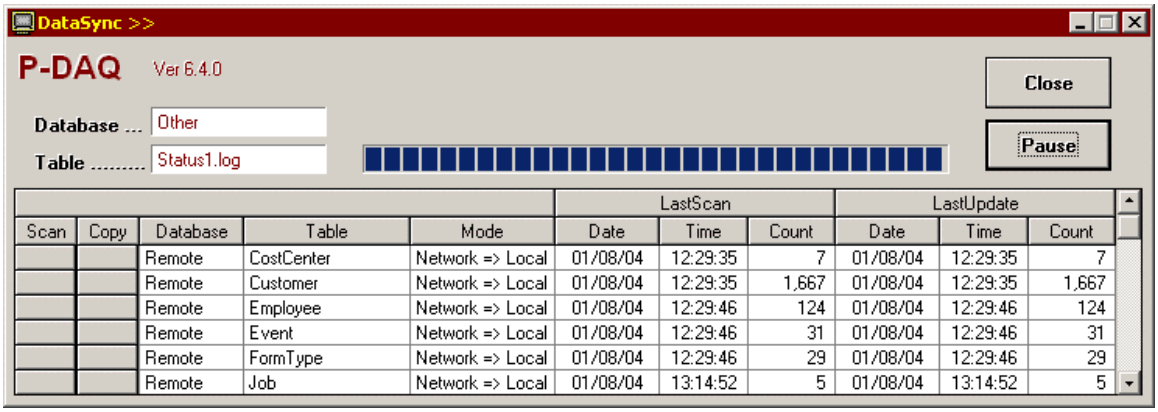
Using Windows “Scheduled Tasks”, you may schedule the **DataPurg** to run periodically. The following is the procedure to set up the task:

- Choose **Start\ControlPanel\SheduledTasks**.
- Click “Add Scheduled Task”.
- Click “Next”.
- Click the “*Browse*” button and browse the server to the **PDAQdp\Shared** directory and select the **DataPurg.exe** file.
- Follow the instructions to select the time and enter the user name and password when prompted.
- Check the box marked “*Open Advanced Properties for this Task when I click Finish*” button and click the finish button.
- In the *Run* field, change the path to read exactly as in the following: **C:\PDAQdp\Shared\DataPurg.exe AUTO**
- In the *Start In* field, make sure the path is as following: **C:\PDAQdp\Shared**

DataSync

DataSync is used to transfer data to and from the Press Computer and the Server. DataSync should be left running on the Press Computer AT ALL TIMES.

To execute, double click the **DataSync** icon on the Press Computer's desktop.



					LastScan			LastUpdate		
Scan	Copy	Database	Table	Mode	Date	Time	Count	Date	Time	Count
		Remote	CostCenter	Network => Local	01/08/04	12:29:35	7	01/08/04	12:29:35	7
		Remote	Customer	Network => Local	01/08/04	12:29:35	1,667	01/08/04	12:29:35	1,667
		Remote	Employee	Network => Local	01/08/04	12:29:46	124	01/08/04	12:29:46	124
		Remote	Event	Network => Local	01/08/04	12:29:46	31	01/08/04	12:29:46	31
		Remote	FormType	Network => Local	01/08/04	12:29:46	29	01/08/04	12:29:46	29
		Remote	Job	Network => Local	01/08/04	13:14:52	5	01/08/04	13:14:52	5

To begin the data transfer process, click the Continue button. To minimize the program on the screen, click the **P-DAQ** logo.

To expedite the flow of data to and from the server, tables can be scanned, or copied in real time by clicking the associated **Scan** or **Copy** button.

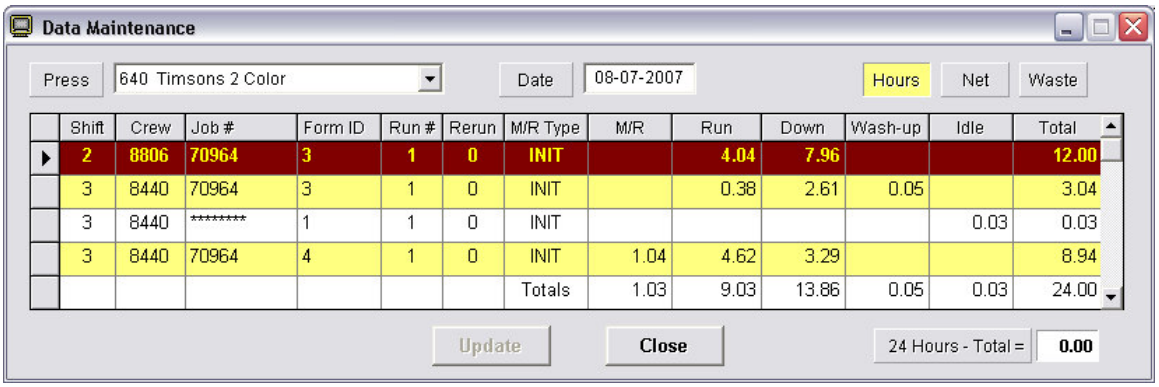
DB_Maint

DB_Maint is used to edit the Summary Database tables used by P-Admin to generate reports. Editing data with this tool will change the numbers on all those reports which use the associated data.

DISCLAIMER: Any changes made to this data, and any problems related to the editing of this data, will NOT be supported by NASTech personnel. When problems with reports are reported, NASTech personnel will require that the summary tables be re-built before troubleshooting.

Changes made to the summary tables will not affect the raw data collected by the system. Any changes made can be un-done by utilizing the rebuild functionality of P-Admin as discussed in the **P-Admin - Overview** section of this Guide.

To execute, double click **DB_Maint** in the **PDAQdp/Shared** directory on the P-DAQDP Server.

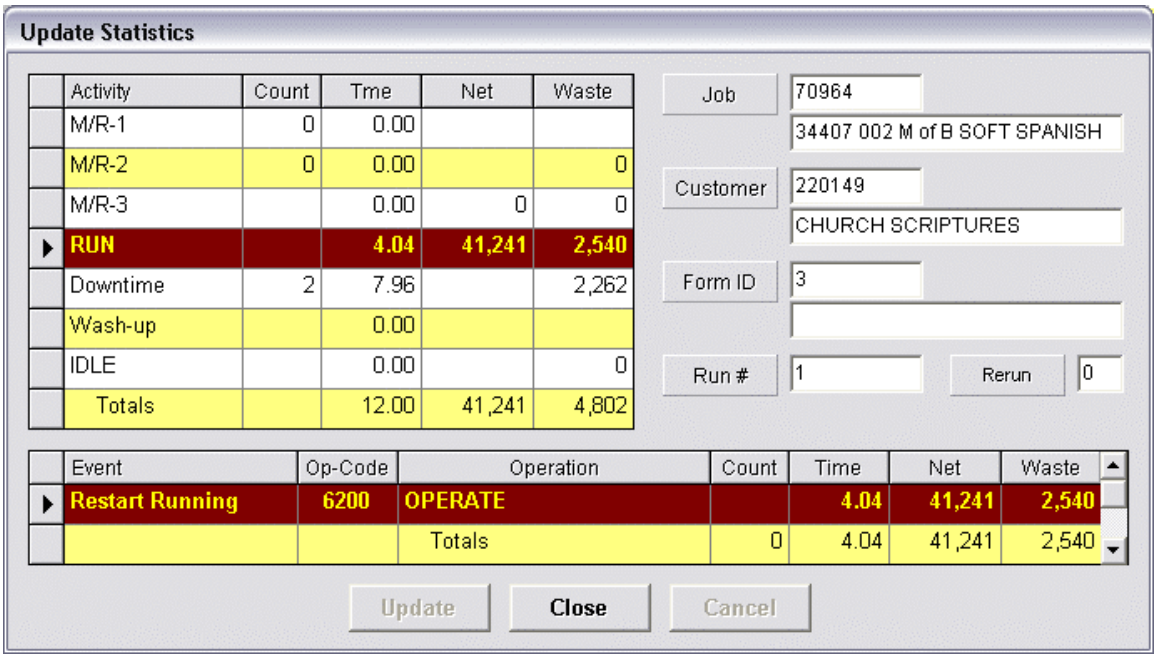


Shift	Crew	Job #	Form ID	Run #	Rerun	M/R Type	M/R	Run	Down	Wash-up	Idle	Total
2	8806	70964	3	1	0	INIT		4.04	7.96			12.00
3	8440	70964	3	1	0	INIT		0.38	2.61	0.05		3.04
3	8440	********	1	1	0	INIT					0.03	0.03
3	8440	70964	4	1	0	INIT	1.04	4.62	3.29			8.94
						Totals	1.03	9.03	13.86	0.05	0.03	24.00

Select the Press and Date of the data to be edited using the dropdown lists provided.

Select the statistics you wish to modify using the Hours, Net, or Waste buttons.

Click in the associated table cell of the record you want to modify and the "Update Statistics" screen opens.



Click the associated Time, Net, or Waste record to be edited and enter the new numbers on the dialog box presented.

When you are finished, click the Update button to complete the transaction.

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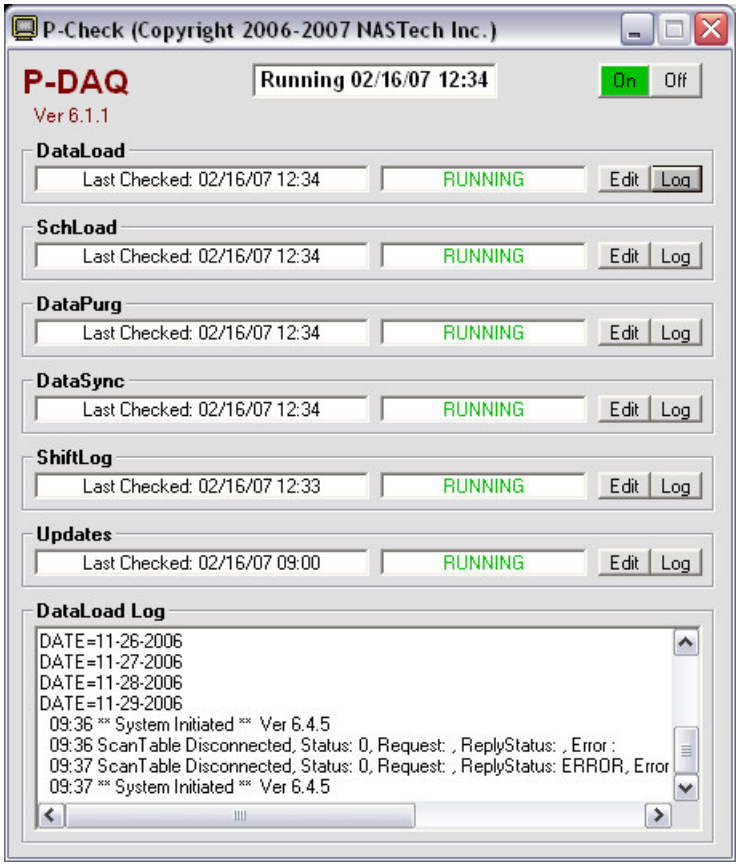
P-Check

P-Check is used to continuously monitor the status of some key P-DAQDP system applications, and is also used to provide local P-DAQDP system administrators with information about system updates, and problems with the P-DAQdp database.

When one of the monitored applications fails to execute or when there is a database problem, up to 3 administrators and 3 supervisors can be notified automatically via email. This ensures that P-DAQDP system applications that are scheduled to run are indeed running as required.

To execute, double click the **P-Check** icon in the **PDAQdp\Shared** directory on the server.

P-Check should be left running on the server at all times. (When minimized, the application will appear in the task list on the bottom right-hand corner of the PC)



The top center of the screen displays P-Check's status and the current time. The top right of the screen provides an **On** and **Off** button to start and stop all of the check processes.

The following is the applications and processes that may be monitored:

DataLoad	Checks to make sure that DataLoad.exe is running and that there are no communication issues with the host computer.
SchLoad	Checks to make sure that SchLoad.exe is running and that there are no communication issues with the host computer.
DataPurg	Checks to make sure DataPurg has executed at the scheduled time.
DataSync	Checks to make sure that DataSync is running on all Press Computers. Shift supervisors can also be notified to remind the pressman re-run the application upon failure.
ShiftLog	Checks to make sure that there are no HOLDS in the ShiftLog older than 14 days. If so, the Administrator will be required to manually COMPLETE them on the server.
Updates	Checks for the latest updates on our website, and provides the P-DAQDP administrator with a list or current and available system applications.

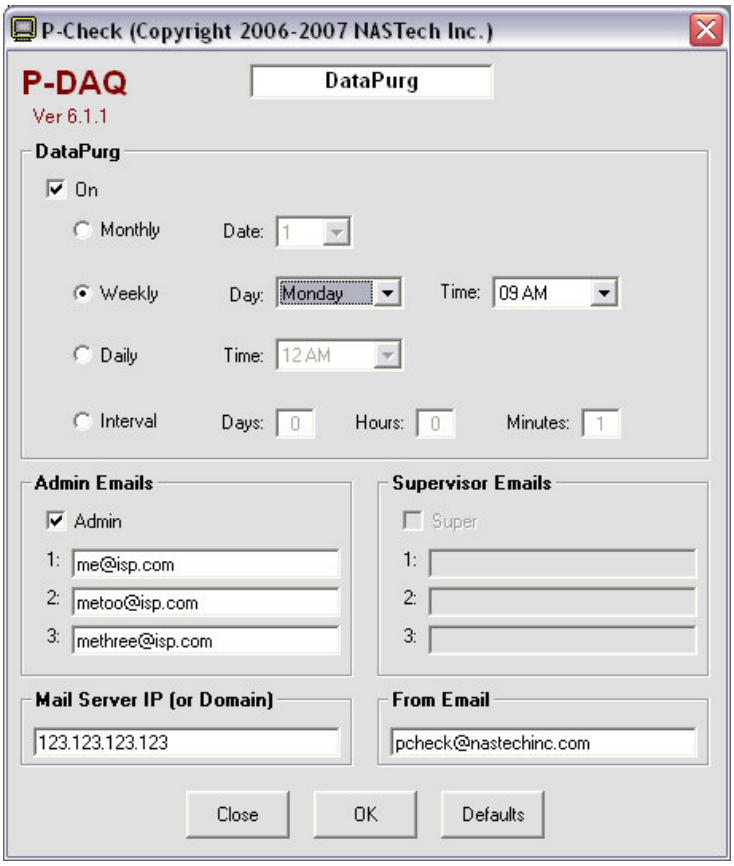
P-Check will send a Daily report via email of all running applications and processes at 9am during weekdays to the P-DAQDP administrator(s).

Schedules should be set up in such a way to ensure that enough time has passed to allow an application that is scheduled with the windows scheduler to have executed. For example, if DataPurg is scheduled to run weekly, then the schedule for DataPurg should be set to check DataPurg weekly as well.

Each of the applications and processes displays the last time the associated check was performed, the status of the check, an **Edit** button, and a **Log** button.

The **Log** button is used to display the log file for the associated process on the bottom of the screen.

Clicking the **Edit** button opens the Edit screen for each process as described on the following page.



App Section	Used to enable the check for the associated application or process, and to schedule the check on the selected date, time, or interval.
Admin	Used to turn on the email feature and to list the administrator(s) email address(s). (Email settings are global to all processes)
Supervisor	Used to turn on the email feature and to list the supervisor(s) email address(s). (Available for the DataSync application only)
Mail Server	Enter the Mail Server's IP Address or Domain name.
From Email	The "From" property on the associated email.
Close	Used to close the Edit window without applying changes.
OK	Used to apply the changes.
Defaults	Used to restore the default settings.

Appendix A Hardware Devices

EP-210

The Computerwise EP-210 module is used to collect data from the press sensors, PLC's or Switches. The following information is provided for quick reference only. For more detail or for information regarding hardware options installed, consult the EP-210 manual.

Before the EP-210 may be used with **P-DAQDP**, the module must first be configured. Failure to do so may cause the module and other modules on the sub-net to operate improperly.

Configure

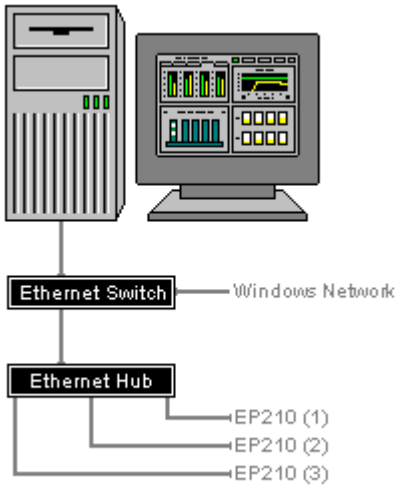
- Before you can use the EP210 with the P-DAQDP system, you must configure the IP address of the unit. Each unit should have a unique IP address.
- When connected to the P-DAQDP PC, the EP210 must be segregated from the existing network via an Ethernet Switch or a Router.
- When connecting multiple EP210's you must use a Hub or a switch with enough ports for all units. See the Diagram on the next page for an illustration of this.
- To configure the unit's IP address, Subnet Mask, or Default Gateway, you must connect the EP210 to a PC serial port with a serial crossover 9pin Female to 9pin Female cable and power the unit.
- Once connected, run HyperTerminal from the Windows Start Menu: **Start – Programs – Accessories – Communications – HyperTerminal**.
- Type "EP210" as the name for the connection and click **OK**.
- Select the **COM** port you have connected the unit to and click **OK**.
- For **Port Settings**, set to **9600** Bits Per Sec, **8** Data Bits, **None** Parity, **1** Stop Bit, and **Hardware** Flow Control. Click **OK**.
- Once you have connected to the unit, hold the **[CTRL]** key and press the **V** key on your keyboard 3 times to enter setup mode.
- Type **SHOW** followed by **[Enter]** to view the current parameters.
- To make a change to a given parameter, type the parameter name, followed by the **=** equal sign, followed by the new value, followed by **[Enter].** For example: MYIP=123.123.123.123[Enter]
- Repeat this process until all parameters have been set.
- When completed, type **SAVE** followed by **[Enter].**
- Disconnect and re-connect the unit from Power. Re-enter setup mode using HyperTerminal and type **SHOW** followed by **[Enter]** to double check the new parameters.

Install

- The EP210 is typically installed in the press cabinet in close proximity to the signals it will acquire, but may also be installed in the P-DAQDP console.

Connect

- The EP-210 is connected to the press signal terminal blocks with a DB-25 cable, and to the PC hub (or Switch or Router) with an Ethernet cable.



Proximity Sensor / Encoder

Proximity Sensors or Encoders are used to provide Gross Count to the system.

Proximity Sensors and Encoders are purchased and installed by local plant personnel.

Proximity Sensors used should be of the 3 wire PNP (sourcing) type, providing a positive12v DC voltage.

NASTech recommends TURCK brand sensors of this type which have Schmidtt Triggers built in.

Install

- For Gross Count, the Sensors are typically installed at the cutoff cylinder of the folder, but may be installed on the main shaft as well.
- For Divert Gate signals, the Sensors are typically installed to provide 12v DC when the divert gate is closed.
- For Roll Speed, the Sensors are typically in close proximity to the roll shaft.
- For best performance, all Proximity Sensors should be installed within 1/16 of an inch to the medium that it is sensing.

Connect

- Sensors are connected to the Terminal block provided by NASTech as per the included wiring diagram.

Troubleshoot

- When behaving erratically, make sure the Sensor is tightly connected to its chassis and that it is mounted perpendicular to the medium that it is sensing.
- Ensure that the unit is within 1/16 of the medium that it is sensing.
- Check all wiring from the sensor to the NASTech terminal block.

Appendix B Glossary

Count Complete	Event	=	When the required number of each unique signature has been produced.
Down-time	Time	=	From the time the press stops until good signatures are again produced. By definition, down-time can only occur while Makeready III or Press Running is active.
Form Started	Event	=	Start button depressed after a new job is defined or the system reset button is pressed.
Idle-time	Time	=	Accumulated time between forms, and elapsed time for operations defined as Idle in the “Opercode” table.
Makeready I (MR1)	Event	=	Immediately following the Form Started event.
	Time	=	Time from initial event to Makeready II event. Does NOT include Down-Time or Idle-Time.
	Count	=	Number of events that occurred during a specified period or for a specified job or form.
Makeready II (MR2)	Event	=	When Makeready I is active and the press reaches the Press Cutoff Speed.
	Time	=	Time from initial event until at least one good signature of each unique signature on the form is counted. Does NOT include Down-Time or Idle-Time.
	Count	=	Number of events that occurred during a specified period or for a specified form.
	Waste	=	The number of impressions or signatures that were discarded during the event.

Makeready III (MR3)	Event	=	When Makeready II is active and at least one good signature of each unique signature on the form is counted.
	Time	=	From the time of the initial event until the press OK is indicated by the pressman. Does NOT include Down-Time or Idle-Time.
	Net	=	The number of impressions or signatures that were saved during the event.
	Waste	=	The number of impressions or signatures that were discarded during the event. Waste accumulated during a press Re-Start is NOT included.
Net Speed			The number of net impressions produced divided by (MR3 + Run) hours.
Net Yield			The number of net impressions produced divided by (MR3 + Run + Down-Time) hours.
Non-Charge Time	Time	=	All time accumulated while **P-DAQDP** is in Stop Mode.
Press Running	Event	=	When Makeready III is active and the press OK is indicated by the pressman.
	Time	=	From the time of the initial until the required signature counts are accumulated and then the press speed drops below the Press Cutoff Speed.
	Net	=	The number of impressions or signatures that were saved during the event.
	Waste	=	The number of impressions or signatures that were discarded during the event. Waste accumulated during Restarting is NOT included.
	Count	=	Number of times the press stopped during a specified period or for a specified job or form.
	Waste	=	See Restart events.
Print-time	Time	=	All time that Ink is being printed (MR2 + MR3 + Run + Restart).
	Count	=	Impressions produced from the time the Press starts running until the end of the form, including Down-Time.

Restart MR3	Event	=	When the press speed reaches the Press Cutoff Speed after a press stop event. This event is recorded if the associated press stop occurred during Makeready III.
	Time	=	From the time the press speed reaches the Press Cutoff Speed until the time at least one good signature of each unique signature on the form is counted.
Restart Run	Event	=	When the press speed reaches the Press Cutoff Speed after a press stop event. This event is recorded if the associated press stop occurred during Run.
	Waste	=	All impressions produced from the time the press stopped until good count is achieved.
Schmidtt Trigger			A Schmitt trigger is a comparator circuit that incorporates positive feedback. When the input is higher than a certain chosen threshold, the output is high; when the input is below another (lower) chosen threshold, the output is low; when the input is between the two, the output retains its value.