



Mattec MES
Data Import Export
8.2

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Revision: March 11, 2015 8:35 a.m.

Total pages: 47

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Data Import Export

Use **Data Import Export** to share and integrate MES data with external applications.

You can use Data Import Export to share the following types of data:

- **Import** - Import tool IDs, part IDs, down codes, scrap codes, process sheets, job descriptors, preventative maintenance jobs and machine schedules into Mattec from an external database. Data is imported using a Mattec-defined, delimited ASCII text file.
- **Export** - Export raw production and SPC historical data, job descriptors, process sheets, part IDs and tool IDs.
- **DTR Data Export** - Integrate Mattec MES with DTR Software International's The Manufacturing Manager™ (TMM) software.

Data imports and exports can be performed manually or scheduled to run automatically.

You can also use Data Import Export to automatically schedule the run of Mattec reports and schedule the automatic export of Real-Time Display data to an HTML file for viewing with a web browser.

Data Import/Export is an optional Mattec MES feature.

Data Import Export Field Conventions

Use Field Conventions to see the available field types for data import and export.

Fields are identified by their position in the record and the sequence of the field descriptions reflects that. Required fields for Data Import are indicated by the Required value in the "FIELD" column.

In addition to its position or name, each field entry includes a type, format, description and whether it is a required field.

Some fields or groups of fields are allowed to appear multiple times in a record. Lists appear between two tildes (~). The tildes are required wherever a list is supported even if there is only a single entry or the list is empty.

Field Type	Field Description	Examples
Alphanumeric	Text that is a combination of letters, numbers, or both. When exported as "Fixed-length Data", string fields will have trailing spaces, if necessary.	abc 123 abc123
Float	A "real number" that may include decimal places. When exported as "Fixed-length Data", float fields will be a total of 20 characters, including the sign (if needed) and the decimal place.	1.23 1.00 1
Integer	A "whole number" that may not include decimal places. When exported as "Fixed-length Data", integer values will be a total of 10 characters.	1 23 456
Date	The month, day, and 4-digit year, in the form MM/DD/YYYY, DD/MM/YYYY, or YYYY/MM/DD, depending upon System Configuration	08/18/1999

Field Type	Field Description	Examples
	("Units" tab). A 4-digit year is required. When data is output using Data Export, the date delimiter will either be a "/" or ".", depending upon System Configuration. When exported as "Fixed-length Data", date fields will have 10 characters with leading 0's, if necessary.	12/31/2001 01/02/2003
Time	The time of day, using a 24-hour clock. Specified in the format hh:mm, where hh = hours using the 24-hour clock and mm = minutes. One or two digits are accepted for hours (hh), however, two digits are always required for minutes (mm). When data is output using Data Export, the time delimiter will either be a ":" or ".", depending upon System Configuration. When exported as "Fixed-length Data", time fields will have 5 characters with leading 0's, if necessary.	00:30 01:15 23:59 01:02

Data Import

Use the Data Import sheet to transfer data from an external system, such as a mainframe or ERP system, into Mattec MES.

Data such as Tool IDs, Part IDs, Down Codes, Defect Codes, Process Sheets, Job Descriptors, preventative maintenance jobs and Machine schedules can be imported into Mattec MES. The program reads an appropriately formatted ASCII text file and uses the information it contains to create or modify data.

Data imports can be scheduled or can be run manually. If errors occur during processing, Mattec MES generates an error report to notify you of the errors.

Data Import is an optional Mattec MES feature.

Data Import Fields

Fields for the current sheet are listed on this topic.

Some fields on the interface have a context menu, which is indicated by a triangle in the upper right corner of the field. To open the context menu, right-click on the field.

Data Import (Download)

If selected, data will be imported into the database from a Unicode formatted text file.

Source File Location

This field contains the full path to the location of the text file that is imported and the name of the imported file.

Manually Import Data from a Text File

Use the Import Data process to import data to the database from an external ASCII text file.

1. Press the Data Import/Export icon on the main window to launch the Data Import / Export wizard.
2. On the Welcome sheet of the Data Import/Export wizard, press **Next**.
3. Select the **Data Import** option to import data into Mattec MES.
4. Press **Next**.
5. In the **Source File Location** field, enter the file path to where the import file is located and enter the file name. Press the folder button to navigate to the input location through Windows Explorer.
6. Press **Next**. A summary of your selections display. Verify that all of the information is correct.
7. Press **Finish** to start the Data Import process. A Results Window displays a log of the records processed, errors and processing time. When the import is complete, a Processing COMPLETE message appears.

8. To save the import log results, press **Save Results**. The log file is saved to the source directory. It has the same file name as the import file with a .log extension.
9. Press **OK** to close the wizard. The data will now be imported successfully into the Mattec database.

Data Import Files

This section contains the file and record format information for the available import file.

For each data type, different information may be required or available for import. Import record details are displayed for each of the following data types:

- Tool IDs
- Part IDs
- Basic Process Sheet Information
- Process Specific Process Sheet Information
- Job Descriptors
- Family Job Descriptors
- Machine Schedules
- Material IDs
- Packed Part Production Data
- Operator IDs

The recommended order of imported data is also displayed.

Data Import File and Record Format

This section contains the suggested order of data imported into the Mattec MES database.

Each record in the ASCII file is essentially an action request and causes specific functions to occur during processing of that record.

Suggested Order	Action	Request Code
1	Create or modify a Tool ID.	T1630
2	Create or modify a Part ID.	PI630
3	Create or modify a Process Sheet (basic information).	PP630
4	Create or modify a Process Sheet (process-specific information).	PE630
5	Create or modify a Job Descriptor.	JB630
6	Create of modify a Family Job Descriptor.	JF630
7	Delete a Machine Schedule.	SD630
8	Create or append to a Machine Schedule.	SA630
9	Create or modify a Material ID.	MI
10	Modify Production Data with Packed Parts.	PK

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

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

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

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

Create or Modify a Tool ID

Use the Tool ID action request record to add tools to the database or modify existing tools.

The Tool ID action request record consists of a five-character request code (TI813), the name of the Tool Number, and additional fields.

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

#	Mattec Field	Description	Type	Req	Mattec DB
1	TI813	The request code (TI813)- 5 char.	String	Yes	N/A
2	MoldID	The name of the Tool Number - 20 char.	String	Yes	dbo.MoldIDs
3	NumCavs	Total cavities for the tool	Integer	No	dbo.MoldIDs
4	RunnerWt	Runner weight specified in grams	Float	No	dbo.MoldIDs
5	MoldDesc	Tool Description - 50 char.	String	No	dbo.MoldIDs
6	SetupTime	The setup time for the tool specified in minutes.	Integer	No	dbo.MoldIDs
7	TearDownTime	The teardown time for the tool specified in minutes.	Integer	No	dbo.MoldIDs
8	Active	Active Flag (0 = inactive, 1 = active)	Integer	No	dbo.MoldIDs
9	MiscInfo1	Miscellaneous Info 1 - 30 char.	String	No	dbo.MoldIDs
10	MiscInfo2	Miscellaneous Info 2 - 30 char.	String	No	dbo.MoldIDs
11	Maker	Maker - 20 char.	String	No	dbo.MoldIDs
12	MoldLocationNo	Location - 20 char.	String	No	dbo.MoldLocations
13	PmMapNo	The tool preventative maintenance map to assign to the tool	Integer	No	dbo.MoldIDs
14	Url	Setup URL - 250 char.	String	No	dbo.MoldSetupUrl

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



Note Examples of Tool ID import records:

- T1630,Tool1,3,4,5,My Tool,60
- T1630,Tool2,2,3,3,Another Tool

Create or Modify a Part ID

Use the Create or Modify a Part ID action request record to add parts to the database or modify existing parts.

The Part ID action request record consists of the five-character request code (PI630), the name of the Part Number, and additional fields.

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. If an optional field is omitted and the Part ID record already exists, the field is not modified. If an optional field is omitted and the Part ID record does not already exist, the field is set to blanks (Alphanumeric type) or 0 (Integer or Float types). A Material ID and Material Weight field exists for each material. The list of materials begins and ends with a tilde (~). If no previously defined material information exists, the first material in the list is considered "Primary".

Field	Description	Type	Length	Required
1	The request code (PI630).	Alphanumeric	5	Yes
2	The name of the Part Number.	Alphanumeric	25	Yes
3	Percent regrind.	Float		No
4	Part cost.	Float		No
5	Material Cost	Float		No
6	Description	Alphanumeric	50	No
7	Parts per case.	Integer		No
8	Setup material weight in Material Weight Units as defined in System Configuration.	Float		No
9	Material color rating	Integer		No
10	Material list - Contains 10a and 10b.	List	2 fields	No
10a	Material ID	Alphanumeric	22	No
10b	Material weight in Part Weight Units as defined in System Configuration.	Float		No
11	Active Flag (0 = inactive, 1 = active)	Integer		No

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



Note Examples of Part ID import records:

- PI630,Part1,10.1,2,3,FOUR,1000
- PI630,Part2,4,5.6,7.8,Round,12,9.1,30,~Mat1,2.3,Mat2,4.5~


Create or Modify a Part ID - No Material

Use the Create or Modify a Part ID - No Material action request record to add parts to the database or modify existing parts.

Once parts are imported using this action request record, you can assign materials to the part using Assign Materials to a Part ID action records.

The Part ID action request record consists of the five-character request code PI800, the name of the Part Number, and additional fields.

You can omit optional fields from an import Part ID request record. However, field separators (commas) are required as placeholders for a field unless the omitted field is at the end of the record.

 **Example** A part does not require a material cost value and the MatlCost field is blank. The import record's format would be P1800, PartID, PctReg, PartCost,, PartDesc, TearDownTime, PcsPerCtn,,,Active,,,,. The MatlCost value is left blank and the comma remains in place in the record as a placeholder for the field.

If an optional field is omitted and the Part ID record already exists, the field is not modified. If an optional field is omitted and the Part ID record does not already exist, the field is set to blanks for Alphanumeric type fields or 0 for Integer or Float type fields.

#	Mattec Field	Description	Type	Req	Mattec DB
1	PI800	The request code PI800. - 5 char	Alphanumeric	Yes	N/A
2	PartID	The name of the Part Number - 25 char	Alphanumeric	Yes	dbo.PartIDs
3	PctReg	Percent regrind	Float	No	dbo.PartIDs
4	PartCost	Part cost	Float	No	dbo.PartIDs
5	MatlCost	Material Cost	Float	No	dbo.PartIDs
6	PartDesc	Part Description truncated to 20 char	Alphanumeric	No	dbo.PartIDs
7	PcsPerCtn	Parts per case	Integer	No	dbo.PartIDs
8	SetupMaterial	Setup material weight in Material Weight Units as defined in System Configuration.	Float	No	dbo.PartIDs
9	MaterialColorRating	Material color rating	Integer	No	dbo.PartIDs
10	Active	Active Flag (0 = inactive, 1 = active)	Integer	No	dbo.PartIDs
11	MiscInfo1	Miscellaneous Info 1	Alphanumeric	No	dbo.PartIDs
12	MiscInfo2	Miscellaneous Info 2	Alphanumeric	No	dbo.PartIDs
13	PartInfo	Part Info	Alphanumeric	No	dbo.PartIDs
14	PartSetupUrl	Setup URL	Alphanumeric	No	dbo.PartSetupUrl

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

Create or Modify a Process Sheet - Basic Information

Use the Create or Modify a Process Sheet request to add basic process sheet information or modify basic information for existing process sheets.

The Process Sheet (Basic Information) action request record consists of the five-character request code (PP630), the name of the Machine Number, the name of the Tool Number, the name of the Part Number, and additional fields.


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


Some fields in the table are required if the record is new. If you are updating an existing record, the field is optional. If a field is required if new, If New is displayed in the Required column of the table.

#	Mattec Field	Description	Type	Req	Mattec DB
1	PP800	The request code PP800 - 5 char	Alphanumeric	Yes	
2	MachNo	The name of the machine number - 6 char	Alphanumeric	Yes	dbo.PSEng where MachNo = MachID in dbo.MachCon
3	MoldNo	The name of the tool number - 20 char	Alphanumeric	Yes	dbo.PSEng where MoldNo = MoldID in dbo.MoldIDs
4	PartNo	The name of the part number - 25 char	Alphanumeric	Yes	dbo.PSEng where PartNo = PartID in dbo.PartIDs
5	ExpPctUp	Expected percent up	Float	No	dbo.PSProd
6	ExpCycTm	Expected cycle time. This must be specified in the appropriate native units for the machine (e.g., seconds, cycles, meters).	Float	No	dbo.PSProd
7	ExpGood	Expected percent good.	Float	No	dbo.PSProd
8	LaborFactor	Labor hour factor.	Float	No	dbo.PSProd
9	LaborCost	Labor cost	Float	No	dbo.PSProd
10	MiscInfo1	Description 1 - 30 char	Alphanumeric	No	dbo.PSProd
11	MiscInfo2	Description 2 - 30 char	Alphanumeric	No	dbo.PSProd
12	NonProductionLimit	Non-production limit specified in seconds	Float	No	dbo.PSProd
13	SetupLaborFactor	Number of Setup Operators Required	Float	No	dbo.PSProd
14	AutoSpcEnable	Automatic SPC Enable (0 = Disabled, 1 = Enabled)	Integer	No	dbo.PSProd
15	AutoSpcPeriod	Automatic SPC Period in minutes	Integer	No	dbo.PSProd

#	Mattec Field	Description	Type	Req	Mattec DB
16	PartQualEnable	Part Qualification Enable (0 = Disabled, 1 = Enabled)	Integer	No	dbo.PSProd
17	AutoSpcSubgroup	Automatic SPC Sub-Group Size	Integer	No	dbo.PSProd
18	Active	Active Flag (0 = inactive, 1 = active)	Integer	No	dbo.PSProd
19	SampID	Sample Sheet. This value must match the QCSheet.SampID. - 18 char	Alphanumeric	No	QCSheet.SampID.
20	IndirectLaborFactor	Number of indirect labor operators required	Float	No	dbo.PSProd
21	Flags	Flags (0-127)	Integer	No	dbo.PSProd
22	CavityPsiTransfer	The Cavity PSI Transfer value. When the monitored cavity pressure reaches this value, the MIU will ignite a digital contact. This digital contact can be connected to the machine to cause the machine to transfer from injection pressure to hold pressure.	Float	No	dbo.PSProd
23	Url	Setup URL - 250 char	Alphanumeric	No	dbo.PSSetupUrl
24	ParameterRecordingFrequency	Parameter Recording Frequency. Value must be greater than zero.	Integer	No	dbo.PSProd
25	CyclesToDivertAfterDowntime	Cycles to divert after downtime. When the machine is coming up out of downtime, this many cycles will automatically be rejected. Value must be greater than zero.	Integer	No	dbo.PSProd
26	RejectDelayEnable	Enable reject delay feature. (0 = Disabled, 1 = Enabled)	Integer	No	dbo.PSProd
27	Special1	Special1	Float	No	dbo.PSProd
28	Special2	Special2	Float	No	dbo.PSProd
30	PulsesPerCycle	Pulses per Cycle. The number of input pulses to detect a cycle. The default is 1.	Integer	No	dbo.PSProd
26	AutoScrapActiveCavities	Auto scrap active cavities. Enables the use of active cavities for auto scrap. The default is 1. (0 = Disabled, 1 = Enabled)	Integer	No	dbo.PSProd

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

 **Important** When creating a Process Sheet, you must have one PP800 action request and multiple PE630 action requests, one for every parameter that is defined in the machine's configuration. The PP800 action request must be executed before the PE630 action request.

 **Note** If the PP800 and PE630 action requests are not done properly, the user will not be able to edit the Process Sheet via Edit Facilities. The Process Sheet record must be corrected using valid PP800 and PE630 action requests before Edit Facilities will work properly. In particular, the PE630 requests must correspond precisely with the parameter numbers that are defined in the machine's configuration program.

Create or Modify a Process Sheet - Process Specific Information

Use the Create or Modify a Process Sheet - Process Specific Information request to add basic process specific information or modify process specific information for existing process sheets. Process specific information includes process specification, control and part qualification settings.

The Process Sheet (Process-specific Information) action request record consists of the five-character request code (PE630), the name of the Machine Number, the name of the Tool Number, the name of the Part Number, and additional fields.

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

Field	Description	Type	Length	Required
1	The request code (PE630).	Alphanumeric	5	Yes
2	The name of the Machine Number.	Alphanumeric	6	Yes
3	The name of the Tool Number.	Alphanumeric	20	Yes
4	The name of the Part Number.	Alphanumeric	25	Yes
5	The parameter number. This number may have the values 0-63 and must correspond precisely with the parameters that are defined in the machine's configuration (and stored in the dbo.MachParm table in the field ParmNo).	Integer		Yes
6	The parameter's upper limit.	Float		No
7	The parameter's nominal value. This value may not exceed the parameter's upper limit or be below the parameter's lower limit.	Float		No
8	The parameter's lower limit.	Float		No
9	The parameter's delay value in seconds.	Float		No
10	Spc Enable (0 = off, 1 = on)	Integer		No
11	Spc Control Alarm (0 = off, 1 = on)	Integer		No
12	Spc Run Alarm (0 = off, 1 = on)	Integer		No
13	Process Specification Alarm (0 = off, 1 = on)	Integer		No
14	Process Control Alarm (0 = off, 1 = on)	Integer		No
15	Part Qualification Specification Enable (0 = off, 1 = on)	Integer		No
16	Part Qualification Control Enable (0 = off, 1 = on)	Integer		No

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

When creating a Process Sheet, you must have one PP800 action request and multiple PE630 action requests, one for every parameter that is defined in the machine's configuration. The PP800 action request must be executed before the PE630 action request.



Note If the PP800 and PE630 action requests are not done properly, the user will not be able to edit the Process Sheet via Edit Facilities. The Process Sheet record must be corrected using valid PP800 and PE630 action requests before Edit Facilities will work properly. In particular, the PE630 requests must correspond precisely with the parameter numbers that are defined in the machine's configuration program (and stored in the MachParm database table).



Note Examples of Process Sheet import records:

- PE630,01,Tool1,Part1,0,10,9.5,9
- PE630,01,Tool1,Part2,5,21,20.5,20
- PE630,01,Tool1,Part3,60,21.3,21.2,21.1

Create or Modify a Job Descriptor

Use the Create or Modify a Job Descriptor request to add job descriptors to the database or update existing job descriptors.

The Job Descriptor action request record consists of the five-character request code (JB813), the name of the Job Number, the name of the Machine Number, the name of the Tool Number, the name of the Part Number, and additional fields. The Job Descriptor action request may be used to create Single or Component jobs. Family jobs should be created using the Family Job Descriptor action request (JF630).

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

The Job Number that is specified must be a unique identifier for this job. Although Mattec MES supports non-unique Job Numbers (that is, multiple Job Descriptors with the same Job Number), the Data Import function requires unique Job Numbers.

#	Mattec Field	Description	Type	Req	Mattec DB
1	JB813	The request code JB813 - 5 char	Alphanumeric	Yes	JB813
2	JobID	The name of the production job number - 18 char	Alphanumeric	Yes	dbo.JobQueue
3	MachineID	The name of the machine number - 6 char	Alphanumeric	Yes	dbo.JobQueue where MachNo = MachID in dbo.MachCon
4	JobCategory	The job category <ul style="list-style-type: none"> • 0 = Standard • 1 = Non Production • 2 = Preventative Maintenance • 3 = Preventative Maintenance Required 	Integer	No	dbo.JobQueue
5	JobCategoryInfo	Additional data associated with the job category. For PM jobs, this is the PM code.	Integer	No	dbo.JobQueue

#	Mattec Field	Description	Type	Req	Mattec DB
6	MoldNo	The name of the tool number. This field is ignored for PM jobs. - 20 char	Alphanumeric	For non PM jobs	dbo.JobQueue where MoldNo = MoldID in dbo.MoldIDs
7	PartNo	The name of the part number. This field is ignored for PM jobs. - 25 char	Alphanumeric	For non PM jobs	dbo.JobQueue where PartNo = PartID in dbo.PartIDs
8	SchedStart	The job's desired start date. Must match system date format. - 10 char	Date	Yes	dbo.JobQueue
9	StartTime	The job's desired start time - 5 char	Time	No	dbo.JobQueue
10	SchedStop	The job's desired stop date. Must match system date format. - 10 char	Date	Yes	dbo.JobQueue
11	StopTime	The job's desired stop time - 5 char	Time	No	dbo.JobQueue
12	SchedQty	The lot size	Integer	Yes	dbo.JobQueue
13	CustomerID	The name of the customer - 18 char	Alphanumeric	No	dbo.JobQueue
14	MiscInfo1	Comment 1 - 30 char	Alphanumeric	No	dbo.JobQueue
15	MiscInfo2	Comment 2 - 30 char	Alphanumeric	No	dbo.JobQueue
16	SequenceNumber	Sequence number of this job within a work order - 6 char	Alphanumeric	No	dbo.JobQueue
17	JobDesc	Job Description - 50 char	Alphanumeric	No	dbo.JobQueue
18	Special1	Special1	Float	No	dbo.JobQueue
19	Special2	Special 2	Float	No	dbo.JobQueue
20	TaktTime	Takt Time	Float	No	dbo.JobQueue

The following describe the action that is taken for the "JB813" action request:

- If the specified Job Descriptor doesn't exist, the job will be created. It may then be scheduled using an Append to Machine Schedule ("SA630") request.
- If the specified Job Descriptor exists, all fields except the Machine Number, Tool Number, and Part Number will be updated. Any fields not present in the record are set to blanks (Alphanumeric) or 0 (Integer or Float types).



Note Examples of Job Descriptor record imports are:


- JB630,Job1,Mach1,Tool1,Part1,01/31/2001,23:01,12/31/2003,03:59,1000,cust1,comment 1,c2
- JB630,2-CHR,Mach1,Tool1,Part2,12/15/2001,12:00,12/25/2001,12:00,1500


Create or Modify a Family Job Descriptor

Use the Create or Modify a Family Job Descriptor request to add family job descriptors to the database or update existing family job descriptors.

The Family Job Descriptor action request record consists of the request code JF630, the name of the Family Job Number, the name of the Tool Number (optional), and additional fields.

You can omit optional fields from an import family job descriptor record. However, field separators (commas) are required as placeholders for a field unless the omitted field is at the end of the record.

 **Example** A family job descriptor does not require a family mold and the MoldNo field is blank. The import record's format would be JF630, JobID,, MaxSimultaneousSonJobs, JF630_05, JF630_06, JF630_07, JF630_08, JF630_09. The MoldNo value is left blank and the comma remains in place in the record as a placeholder for the field.

 **Note** The Family Job Number and all component Job Numbers that are specified must be unique identifiers for these jobs. Although Mattec MES supports non-unique Job Numbers (that is, multiple Job Descriptors with the same Job Number), the Data Import function requires unique Job Numbers.

#	Field	Description	Type	Req
1	JF630	The request code JF630 - 5 char	Alphanumeric	Yes
2	JobID	The name of the Family Job Number. - 20 char	Alphanumeric	Yes
3	MoldNo	The name of the Family Tool Number. - 20 char	Alphanumeric	No
4	MaxSimultaneousSonJobs	The number of active components to start when the job runs. A value between 1 and 100 is required.	Integer	Yes
5	JF630_05	The first name of an existing "single" job that will be "adopted" into this family job. - 20 char	Alphanumeric	No
6	JF630_06	Next Job of related JobPart	Alphanumeric	No
7	JF630_07	Next Job of related JobPart. The numbers continue to increment for each part.	Alphanumeric	No
8	JF630_08	Next Job of related JobPart. The numbers continue to increment for each part.	Alphanumeric	No
etc.	JF630_XX	Next Job of related JobPart. The numbers continue to increment for each part.	Alphanumeric	No

The following describe the action that is taken for the JF630 action request:

- If the specified Family Job Descriptor doesn't exist, the job is created. If the specified Family Job Descriptor exists, all fields are updated.
- Each existing single Job Descriptor will be adopted into the family job. At this point, the jobs stop being single jobs and become component Jobs.
- You may then schedule the individual component jobs using an Append to Machine Schedule SA630 request.

 **Note** The following are examples of Family job import records:

- JF630,FamilyJob1,Tool1,2,Component1,Component2,Component3

- JF630,FamilyJob2,,2,ComponentA,ComponentB,ComponentC

Delete a Machine Schedule

Use the Delete Machine Schedule action request record to delete the machine schedule for a machine.

The Delete Machine Schedule action request record consists of the two-character request code (SD630) and the name of the Machine Number. Job Descriptors that are scheduled on the current machine are deleted from the machine's schedule (except for the currently running job)

The Delete Machine Schedule action request can be used in combination with one or more Machine Schedule action requests (SA630) to rewrite a machine's schedule.

Field	Description	Type	Length	Required
1	The request code (SD630)	Alphanumeric	5	Yes
2	The name of the machine number	Alphanumeric	6	Yes



Note Examples of delete machine schedule records are the following:

- SD630,Mach1
- SA630,Mach1,Job1
- SA630,Mach1,Job2

Create or Append to a Machine Schedule

Use the Create or Append to a Machine Schedule action request to add or append a job to a machine's schedule.

The Machine Schedule action request record consists of the five character request code SA630, the name of the Machine Number, and the name of the Job Number to be scheduled.



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

Machine Schedule action requests may only contain jobs for which Job Descriptors already exist. The Job Descriptor may have just been created using a previous JB630 Job Descriptor action request.

#	Mattec Field	Description	Type	Req
1	SA630	The request code SA630. - 5 char	Alphanumeric	Yes
2	Field02	The name of the Machine Number. - 6 char	Alphanumeric	Yes
3	Field03	The name of the production Job Number. - 20 char	Alphanumeric	Yes

The Job Number that is specified must be a unique identifier for this job. Although Mattec MES supports multiple Job Numbers with the same job number name, the Data Import function requires unique Job Numbers.

The Job Number that is specified must be an existing single job or an existing component job. Family jobs may not be scheduled using this action request. Rather, each component job that is a member of the family job should be scheduled, in order, using Machine Schedule action requests.



Note Examples of machine schedule action records are the following:

- SA630,Mach1,Job1
- SA630,Mach1,Job2

Create or Modify a Material ID

Use the Create or Modify a Material ID request to add materials to or update materials in the database.

The Material ID action request record consists of the five-character request code (MI710), the name of the Material, and additional fields as defined below:

Field	Description	Type	Length	Required
1	The request code (MI710).	Alphanumeric	5	Yes
2	The material identifier.	Alphanumeric	22	Yes
3	Material type. (0 = Standard, 1 = Auxiliary)	Integer		Yes
4	Material cost	Float		No
5	Alphanumeric	Auxiliary Units	10	No
6	Description(Comment) 1.	Alphanumeric	30	No
7	Description(Comment) 2.	Alphanumeric	30	No
8	Material Description	Alphanumeric	20	No

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

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



Note Examples of Material ID action request records are the following:

- MI710,Mat1,0,4.5
- MI710,Mat2,1,1.3,each,red,box
- MI710,Mat3,0,7.25,,dark,green,soft

Assign Materials to a Part ID

Use the Assign a Material ID request to assign existing materials to an existing Part ID. This request can be used instead of P1630 part ID import. It allows one record per material instead of multiple materials per one part record.

The Material ID Assignment action request record consists of the five-character request code (MP800), the name of the Material, the name of the Part and additional fields as defined below:

Field	Description	Type	Length	Required
1	The request (MP800).	Alphanumeric	5	Yes
2	Part ID	Alphanumeric	25	Yes

Field	Description	Type	Length	Required
3	Material ID	Integer	22	Yes
4	Weight per Part	Float		No

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



Note Each time a Material ID is imported, it is appended to the existing material list. This can be problematic. It is recommended that the MC770 Clear Part ID is run prior to importing the material list.

Modify Production Data with Packed Parts

Use the Modify Production Data with Packed Parts request to add materials to or update materials in the database. All Modify Production Data with Packed Parts request records contain a PK760 request code plus additional fields.

Field	Description	Type	Length	Required
1	The request code (PK760).	Alphanumeric	5	Yes
2	The job identifier.	Alphanumeric	20	Yes
3	Date of production. (0 = Standard, 1 = Auxiliary)	Date	10	Yes
4	Shift of production	Alphanumeric	2	Yes
5	Amount of production packed.	Float		Yes
6	Production Quantity Units (PQU) (0 = Parts, 1 = Cases)	Integer		No

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



Note Examples of Modify Production Data with Packed parts action request records are the following:

- PK760,Job01,4/10/2008,1,12,1
- PK760,Job09,3/3/2008,A,2000

Clear Part ID Material List

Use the Clear Part ID Material List request to clear the material list for a part.

This operation deletes all Material List entries for the specified Part ID. Its purpose is to clear a list in anticipation of a following Import Part ID operation that establishes a new Material List. It is not required to add a material to an existing list or to alter the weight field of an existing list entry.

All Clear Part ID Material List request records contain a PI630 request code plus additional fields.

Field	Description	Type	Length	Required
1	The request code (PI630)	Alphanumeric	5	Yes
2	The name of the Part number	Alphanumeric	25	Yes



Note An example of a Clear Part ID Material List action request records is the following:

- MC770,Part1

Create Downtime Codes

Use the Create Downtime Codes action request record to add downtime codes to the database.

Once you import downtime codes, you must associate them with a down map. The down map is then assigned to a machine and you can start entering down time information against the imported down codes.

The Down Code action request record consists of the five-character request code DC813, the name of the down code and additional fields as defined below:

#	Mattec Field	Description	Type	Req	Mattec DB
1	ID	The request code DC813 - 5 char.	String	Yes	N/A
2	DownCode	Down Code - 20 char.	String	Yes	dbo.DownCodes
3	DownDesc	Description - 50 char.	String	Yes	dbo.DownCodes
4	DownColor	Down Color	Integer	No	dbo.DownCodes
5	GroupNo1	Group No 1	Integer	No	dbo.DownCodes
6	GroupNo2	Group No 2	Integer	No	dbo.DownCodes
7	VoiceEnabled	Voice Enabled (0 = inactive, 1 = active)	Integer	No	dbo.DownCodes
8	VoiceFile	Voice File - 20 char.	String	No	dbo.DownCodes
9	EmailEnabled	Email Enabled (0 = inactive, 1 = active)	Integer	No	dbo.DownCodes
10	ExcludeFromOEE	Exclude from OEE (0 = inactive, 1 = active)	Integer	No	dbo.DownCodes

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



Note Once down codes are imported, the code cannot change.

Create Scrap Codes

Use the Create Downtime Codes action request record to add downtime codes to the database.

Once scrap codes are imported into Mattec, they must be associated with a scrap map. The scrap map is then assigned to a machine and scrap information can start being entered against the imported scrap codes.

The Scrap Code action request record consists of the five-character request code DF813, the name of the scrap code and additional fields as defined below:

#	Field	Description	Type	Req	Mattec DB
1	DF813	The request code DF813 - 5 char	String	Yes	DF813
2	DefCode	Defect Code - 20 char	String	Yes	dbo.DefCodes
3	DefDesc	Description - 50 char	String	Yes	dbo.DefCodes
4	GroupNo1	Group No 1	Integer	No	dbo.DefCodes
5	GroupNo2	Group No 2	Integer	No	dbo.DefCodes
6	ExcludeFromOEE	Exclude from OEE	Integer	No	dbo.DefCodes

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

The Last Update field for the scrap code is automatically updated with the current date and time. Other fields in the scrap code record are not modified.



Note Once scrap codes are imported, the code cannot change.

Create or Modify an Operator ID

Use the Create or Modify and Operator ID request to add operators to the database or modify existing operators.

All Create or Modify an Operator ID request records contain an OI770 request code, the operator identifier plus additional fields.

#	Mattec Field	Description	Type	Req	Mattec DB
1	ID	The request code OI770. - 5 char	Alphanumeric	Yes	O1770
2	OperNo	The operator identifier. - 18 char	Alphanumeric	Yes	dbo.OperatorID
3	Password	Password - 18 char	Alphanumeric	No	dbo.OperatorID
4	Description	Employee Name - 35 char	Alphanumeric	No	dbo.OperatorID
5	WorkLocation	Work Location - 35 char	Alphanumeric	No	dbo.OperatorID
6	Active	Active Flag (0 = inactive, 1 = active)	Integer	No	dbo.OperatorID
7	PermitScrap	Scrap Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
8	PermitDown	Down Reason Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
9	PermitHelp	Help Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
10	PermitJobControl	Job Control Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
11	PermitJobNextControl	Next Job Control Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
12	PermitManualSQC	Manual SQC Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID

#	Mattec Field	Description	Type	Req	Mattec DB
13	PermitVariableSQC	Variable SQC Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
14	PermitAttributeSQC	Attribute SQC Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
15	PermitMaterialLot	Material Lot Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
16	PermitSetupMaterial	Setup Material Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
17	PermitCavities	Active Cavities Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
18	PermitPercentRegrind	Percent Regrind Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
19	PermitSaveProfile	Save Profile Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
20	PermitCalibration	Analog Calibration Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
21	PermitMachinePM	Machine PM Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
22	PermitToolPM	Tool PM Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
23	PermitLanguage	Language Select Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID
24	PermitPreferences	Preferences Permission (0 = off, 1 = on)	Integer	No	dbo.OperatorID

Optional fields may be omitted though the field separators (commas) are required unless they are at the end of the record. If an optional field is omitted and the Operator ID record already exists, the field is not modified. If an optional field is omitted and the Operator ID record does not already exist, the field is set to blanks (Alphanumeric type) or 0 (Integer or Float types). The password is an exception. If omitted and the Operator ID record does not exist, it is set to an unusable value. If the MIU Security option is present, a password must then be established through System Configuration before the operator can log in.

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



Note An example of a Create or Modify Operator ID action request record is the following:

- OI770,Opey,123abc,short,basement,1,1,0,1,0,1,0,1,0,1,0,1,0,1,0,1,0

Data Export

Use the Data Export program to manually export data to an external ASCII or Unicode text file. The data can then be imported into external applications such as an ERP application.

Data such as production, SPC or job history, process sheets, parts, tools, operator tracking information, scheduling data, machine odometers or special data can be exported from Mattec MES. The program exports data into an appropriately formatted ASCII or Unicode text file.

For some types of data, you can filter export data by department, date and shift. You can also choose to export data based on the database for the current software release or for a previous release.

Data Export Weighted Values

Weighted values are used in Production History and Job Descriptor data export to display overall family-specific information such as weighted right time and down time for family molding.

Weighted values apply primarily to the Production History data export and the Job Descriptor data export. Weighted values are used for family molding. Weighted values are stored for single jobs, but the weighted value (e.g., weighted down time) will contain the same value as the non-weighted value (e.g., down time).

When considering family molding, however, weighted values are very important. These values allow for the display of overall family-specific information.

Consider this example: Component jobs "component1" and "component2" ran for 8 hours at the same time. These are related family jobs. A production report would display 8 hours of run time for "component1" and 8 hours of run time for "component2". However, the total and grand total for the report would show only 8 hours of run time, not 16 hours of run time. That's because the family only ran for 8 hours.

If you looked at the raw data, the Production History database table would contain 8 hours of total time for "component1" and 4 hours of weighted total time for "component1". The same would be true for "component2". Thus, the detail records in the report would display total time, whereas the total lines would display the sum of the weighted total times.

(Some people want to see the sum of the non-weighted values in the totals and grand totals displays. Thus, in the example above, the report would display 8 hours of run time for "component1", 8 hours of run time for "component2", and 16 hours of total run time. Obviously this can be accomplished by displaying the sum of the non-weighted total times.)

Weighted values are accumulated in real-time and vary depending on the number of component jobs that are currently running for the family. Thus, if two component jobs are running, each job gets half of the run time (actually total time), down time, etc. stored in its weighted values. If three component jobs are running, each job gets a one third weighting, etc.

Data Export Fields

Fields for the current sheet are listed on this topic.

Output File Location

This field contains the full path to the location where the export will be created and the name of the exported file.

File Types

If selected, this type of data will be exported into a text file.

Compatibility

This field indicates the Mattec release level with which the exported text file will be compatible. Based on the type of data being exported, there can be database differences between releases.

With each release, new data fields may appear and others become obsolete and disappear. To ease the transition to newer releases, the Data Export function allows you to select either the current format or certain older formats for exported data if it is required.

Select Department

This field allows you to export data for only a selected department. The default is to export data for all departments

Current Day

If selected, only data for the current day will be exported.

Previous Day

If selected, only data for the previous day will be exported.

Date Range

If selected, only data for a specified date range will be exported.

Date Range From and To

The From and To fields contain the start and end dates of the date range for the data that is exported. If the Date Range option is not selected, these fields are not used.

Specific Shift

If selected, only data for a specific shift will be exported.

Specific Shift From and Shift

The From and Shift fields contain the date and shift for data exported for a specific shift. If the Specific Shift option is not selected, these fields are not used.

When you select to export data for a specific shift, the shift field includes the options 1-10. These correspond to the internal ShiftSeq field that is used in the database (ShiftProd, ShiftSeq), where 1 represents the first shift of the specified day, 2 represents the second shift of the specified day.

Quoted Text

If this option is selected, text field data is exported with double quotes. If this option is not selected, text fields are exported without quotes.

Fixed Length Text

If this option is selected, text fields are the maximum fixed length for the field and are padded with zeros if required. If this option is not selected, field lengths are variable based on the length of the data.

ASCII Encoding

If selected, the data will be exported in an ASCII text format.

Unicode Encoding

If selected, the data will be exported in a Unicode text format.

Export Data to a Text File

Use the Export Data process to export data to an external ASCII or Unicode text file for use by external applications.

1. Press the Data Import/Export icon on the main window to launch the Data Import / Export wizard.
2. On the Welcome sheet of the Data Import/Export wizard , press **Next**.
3. Select the **Data Export** option to export data out of Mattec MES.
4. Press **Next** to go to the next screen.
5. In the **Output File Location** field, enter the file path to where the created export file should be created. The default file name can be overwritten. Press the folder button to navigate to the output location through Windows Explorer.
6. Press **Next** to go to the next screen.
7. In the **File Types** section, select the type of data you wish to export.
8. In the **Compatibility** field, select the release of Mattec MES with which the export file should be compatible. The available options vary based on the selected type of data.
9. Press **Next** to go to the next screen. The fields that appear on this screen vary based on the type of export data.
10. In the **Select Department** field, select a department if the exported data should only contain data for a specific department. By default, data for all departments is selected.
11. Select **Current Day** if only data for the current date should be exported.

12. Select **Previous Day** if only data for the previous day should be exported.
13. Select **Date Range** if data for a specified date range should be exported. Select the **From** date and **To** date for the export date range.
14. Select **Specific Shift** if only data for a specific shift should be exported. Select the **From** date and the **Shift** number to determine the shift for which the data will be exported.
15. Press **Next** to go to the next screen.
16. Select **Quoted Text** if exported text fields should have double quotations around them. For example, ProdHist1 would appear as "ProdHist1".
17. Select **Fixed-length Text** if exported text fields should be a fixed length and padded by zeros if required.
18. Select **ASCII** if the exported text file should be in an ASCII text format.
19. Select **Unicode** if the exported text file should be in a Unicode text format.
20. Press **Next** to go to the next screen. A summary of your selections are displayed. Verify that all of the information is correct.
21. Press **Finish** to start the Data Export process. A Results Window will display a log of the records processes, errors and processing time. When the export is complete, a Processing COMPLETE message will appear.
22. To save the export log results, press **Save Results**. The log file will be saved to the export directory. It will have the same file name as the export file with a .log extension.
23. Press **OK** to close the wizard. The export file is in the selected directory and is now ready for use by external applications.

Data Export Files

This section contains file and data record format information for the available export files.

For each data type, different information is available for export. The following types of information can be exported:

- Production history
- SPC History
- Job History
- Process Sheets
- Part IDs
- Tool IDs
- Operator Tracking
- Scheduling
- Machine Odometer
- Special Data
- The Manufacturing Manager (DTR) Data

Production History Data Export

Use Production History Data Export to export production-related information by shift or production date.

Production history data can be exported by production date, date range or for a specific shift. It can also be filtered to only export the data for a selected department.

The following production data is exported during the Production History Date Export process:

Number	Field	Description	Type	Length	DB Source
1	JobID	The name of the job number.	Alphanumeric	20	JobQueue
2	MachID	The name of the machine number.	Alphanumeric	6	MachCon
3	PartID	The name of the Part Number.	Alphanumeric	25	PartIDs
4	MoldID	The name of the Tool Number	Alphanumeric	20	MoldIDs
5	CustomerID	The name of the Customer.	Alphanumeric	18	JobQueue
6	Shift Date	The date of the shift.	Date		ShiftProd
7	Shift Index	The shift index for the day. The first shift of the production day is 1. Values can range from 1-10.	Integer		ShiftProd
8	Shift Name	The name (tag) of the shift.	Alphanumeric	2	ShiftProd
9	CycCnt	Total number of machine cycles for the shift.	Integer		ShiftProd
10	WtCycCnt	The weighted total number of machine cycles for the shift.	Float		ShiftProd
11	CycOutSpec	Total number of out-of-spec cycles for the shift. Any cycle in which one or more process parameters are out-of-spec is an out-of-spec cycle.	Integer		ShiftProd
12	ExpProdQty	Expected number of parts to be produced based on information in the process sheet.	Float		ShiftProd
13	CalProdQty	The total number of parts produced for the shift as monitored by the MIU.	Float		ShiftProd
14	PakProdQty	Packed parts reported for the shift.	Float		ShiftProd
15	DefectQty	Scrap parts reported for the shift.	Float		ShiftProd
16	TotTime	Total time (run time plus down time) in seconds for the shift.	Integer		ShiftProd
17	WtTotTime	The weighted total time in seconds for the shift.	Float		ShiftProd
18	DownTime	Down time in seconds for the shift.	Integer		ShiftProd
19	WtDownTime	The weighted down time in seconds for the shift.	Float		ShiftProd
20	NumDownTm	The number of downtime occurrences for the shift.	Integer		ShiftProd

Number	Field	Description	Type	Length	DB Source
21	WtNumDownTm	The weighted number of downtime occurrences for the shift.	Float		ShiftProd
22	LaborTime	Amount of labor time in seconds calculated for the shift.	Integer		ShiftProd
23	WtLaborTime	The weighted amount of labor time in seconds calculated for the shift.	Float		ShiftProd
24	MinCycTm	Minimum cycle time value that occurred during the shift.	Float		ShiftProd
25	MaxCycTm	Maximum cycle time value that occurred during the shift.	Float		ShiftProd
26	SumCycTm	Sum of the cycle time values that occurred during the shift. Useful in calculating the average for cycle time.	Float		ShiftProd

SPC History Data Export

Use the SPC History data export selection to export information about collected automatic statistical process control data.

This export data type can be useful for updating external systems with SPC data that has been collected by an MIU. Data may be exported for the current day, previous day, or a date range for one or all departments.

The following statistical process control data is exported during the SPC History Data Export process:

Number	Field	Description	Type	Length	DB Source
1	MachID	The name of the Machine Number.	Alphanumeric	6	MachCon
2	JobID	The name of the Job Number.	Alphanumeric	20	JobQueue
3	Name	The name of the Parameter.	Alphanumeric	10	ParmSet
4	Sample Date	The date the sample was taken.	Date		LongTermEng
5	Sample Time	The time the sample was taken.	Time		LongTermEng
6	ParmNo	The zero-based parameter number.	Integer		LongTermEng
7	LtCycleIndex	The long-term cycle index for each period (0 for the first cycle, up to "N-1", where N is the subgroup size).	Integer		LongTermEng
8	Value	The process parameter value	Float		LongTermEng
9	Flag	A flag indicating the status of this particular sample, where: '.' is in spec; '-' is below lower spec, '+' is above upper spec, 'x' is invalid parameter value (unable to calculate), '?' is unknown.	Alphanumeric	1	LongTermEng

Job History Data Export

Use the Job History Data Export selection to export information about all jobs that have been run. The export file includes data for running, suspended and completed jobs.

Exporting job history data can be useful for updating external systems with production-related information for jobs, including the total number of parts produced and the total number of packed parts.

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

The following job data is exported during the Job History Data Export process:

#	Field	Description	Type	Length	DB Source
1	JobID	The name of the Job Number.	Alphanumeric	20	JobQueue
2	MachID	The name of the Machine Number.	Alphanumeric	6	MachCon
3	PartID	The name of the Part Number	Alphanumeric	25	PartIDs
4	MoldID	The name of the Tool Number.	Alphanumeric	20	MoldIDs
5	CustomerID	The name of the Customer	Alphanumeric	18	JobQueue
6	StartDate	The job's actual start date	Date		JobQueue
7	StartTime	The job's actual start time in the format hh:mm.	Time		JobQueue
8	StopDate	The job's actual stop date. If the job has not ended yet, the value 0/0/0 will be used.	Date		JobQueue
9	StopTime	The job's actual stop time in the format hh:mm or hh.mm. If the job has not ended yet, the value 0:0 will be used.	Time		JobQueue
10	SchedQty	The lot size	Integer		JobQueue
11	CycCnt	Total number of machine cycles for the job.	Integer		JobProd
12	WtCycCount	The weighted total number of machine cycles for the job.	Float		JobProd
13	CycOutSpec	Total number of out-of-spec cycles for the job. Any cycle in which one or more process parameters are out-of-spec is an out-of-spec cycle.	Integer		JobProd
14	ExpProdQty	Expected number of parts to be produced based on information in the process sheet.	Integer		JobProd
15	CalProdQty	The total number of parts produced for the job as monitored by the MIU.	Integer		JobProd
16	PakProdQty	Packed parts reported for the job.	Integer		JobProd
17	DefectQty	Scrap parts reported for the job.	Integer		JobProd
18	TotTime	Total time (run time plus down time) in seconds for the job.	Integer		JobProd

#	Field	Description	Type	Length	DB Source
19	WtTotTime	The weighted total time in seconds for the job.	Float		JobProd
20	DownTime	Down time in seconds for the job.	Integer		JobProd
21	WtDownTime	The weighted down time in seconds for the job.	Float		JobProd
22	NumDownTm	The number of downtime occurrences for the job.	Integer		JobProd
23	WtNumDownTm	The weighted number of downtime occurrences for the job.	Float		JobProd
24	LaborTime	Amount of labor time in seconds calculated for the job.	Integer		JobProd
25	WtLaborTime	The weighted amount of labor time in seconds calculated for the job.	Float		JobProd
26	MinCycTm	Minimum cycle time value that occurred during the job.	Float		JobProd
27	MaxCycTm	Maximum cycle time value that occurred during the job.	Float		JobProd
28	SumCycTm	Sum of the cycle time values that occurred during the job. Useful in calculating the average for cycle time.	Float		JobProd
29	SumSqCycTm	Sum of the squares of the cycle time values that occurred during the job. Useful in calculating the standard deviation for cycle time.	Float		JobProd
30	NumCavs	The total cavities for the tool.	Float		MoldIDs
31	PctReg	Percentage regrind of total for the material.	Float		PartIDs
32	PcsPerCtn	Pieces per carton or box	Integer		PartIDs
33	PartCost	Part cost in \$ per unit.	Float		PartIDs
34	MatlCost	Material cost in \$ per unit.	Float		PartIDs
35	Job Status	The job's status, PEND (Pending), RUN (Running), SUSP (Suspended), or COMP (Completed).	Alphanumeric	4	JobQueue
36	ActCavs	The actual number of cavities used	Float		JobProd

Process Sheet Data Export

Use the Process Sheet Data Export selection to export information about process sheets. Process sheets document the production process for performing a job.

This selection can be useful for updating external systems with process parameter-related information from process sheets.

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

The following job data is exported during the Process Sheet data export process:

#	Field	Description	Type	Length	DB Source
1	MachID	The name of the Machine Number	Alphanumeric	6	MachCon
2	PartID	The name of the Part Number	Alphanumeric	20	PartIDs
3	MoldID	The name of the Tool Number	Alphanumeric	20	MoldIDs
4	SamplID	The name of the Sample ID	Alphanumeric	18	QCSheet
5	Name	The name of the Parameter	Alphanumeric	10	ParmSet
6	ParmNo	The zero-based parameter number	Integer		PSEng
7	UpperLim	The engineering upper specification limit	Float		PSEng
8	NomVal	The engineering nominal value	Float		PSEng
9	LowerLim	The engineering lower specification limit	Float		PSEng
10	ExpPctUp	Standard percent uptime	Float		PSProd

Part ID Data Export

Use the Part ID Data Export selection to export information about produced parts.

The following part data is exported during the Part ID Data Export process:

#	Field	Description	Type	Length	DB Source
1	PartID	The name of the Part Number	Alphanumeric	25	PartIDs
2	PartDesc	A description for the part	Alphanumeric	50	PartIDs
3	PctReg	Percent regrind of total material requirement	Float		PartIDs
4	PcsPerCtn	Pieces per container	Integer		PartIDs
5	PartCost	Part cost	Float		PartIDs
6	MatlCost	Material cost	Float		PartIDs
7	Misclnfo1	Part description 1	Alphanumeric	30	PartIDs
8	Misclnfo2	Part description 2	Alphanumeric	30	PartIDs
9	PartInfo	Part information	Alphanumeric	40	PartIDs

Tool ID Data Export

Use the Tool ID Data Export selection to export information about tools used to perform production.

This export selection can be useful for updating external systems with information for a physical tool, mold, die, fixture, or other apparatus that is used in conjunction with a machine to produce a certain part or a group of parts.

The following tool data is exported during the Tool ID Data Export process:

#	Field	Description	Type	Length	DB Source
1	MoldID	The name of the Tool Number	Alphanumeric	20	MoldIDs
2	MoldDesc	A description of the tool	Alphanumeric	50	MoldIDs
3	MachReq	User-defined description field for machine type	Alphanumeric	20	MoldIDs
4	NumCavs	Total cavities for the tool	Integer		MoldIDs
5	Maker	User-defined description field for describing the tool's maker	Alphanumeric	20	MoldIDs
6	Location	User-defined description field for describing the tool's current location	Alphanumeric	20	MoldIDs
7	RunnerWt	Runner weight in grams. This value does not get converted to the display unit from System Configuration	Float		MoldIDs
8	MiscInfo1	Tool description 1	Alphanumeric	30	MoldIDs
9	MiscInfo2	Tool description 2	Alphanumeric	30	MoldIDs
10	SetupTime	The setup time in minutes for the tool	Integer		MoldIDs

Operator Tracking Data

Use the Operator Tracking Data Export selection to export information about all machine operators who have logged in for Operator Efficiency or Operator Tracking.

This export selection can be useful for updating external time tracking systems.

The following operator tracking data is exported during the Operator Tracking Data Export process:

#	Field	Description	Type	Length	DB Source
1	OperatorID	The Operator's ID	Alphanumeric	18	OperatorLogin
2	MachID	The name of the Machine Number the operator logged in to	Alphanumeric	6	MachCon
3	LoginDate	The login date	Date		OperatorLogin
4	LoginTime	The login time in the format hh:mm	Time		OperatorLogin
5	LogoutDate	The logout date. If the operator has not logged out yet, the value 0/0/0 will be used.	Date		OperatorLogin

#	Field	Description	Type	Length	DB Source
6	LogoutTime	The logout time in the format hh:mm. If the operator has not logged out yet, the value 0:0 will be used.	Time		OperatorLogin
7	ElapsedTime	The elapsed login time specified in seconds. If the operator has not logged out yet, the value 0 will be used.	Integer		OperatorLogin
8	Description	A description of the login type, usually Operator Efficiency or Operator Tracking.	Alphanumeric	20	OperatorLoginTransType

Schedule Summary Data

Use the Schedule Summary Data Export selection to export information about all currently scheduled jobs.

The Schedule Summary Data Export selection is identical in format to the report available from the scheduler application. However, the full prediction facilities of the scheduler are not available so the content of fields dealing with the future may not exactly match those of a Scheduler Summary Report.

The following schedule summary data is exported during the Schedule Summary Export process:

#	Field	Description	Type	Length	DB Source
1	MachineID	The name of the Machine Number	Alphanumeric	6	MachCon
2	DeptID	The name of the Department	Alphanumeric	10	Department
3	JobID	The name of the Job Number.	Alphanumeric	20	JobQueue
4	FatherJobID	The name of the Family Job Number. Blank for single jobs.	Alphanumeric	20	FatherJobQueue
5	PartID	The name of the Part Number.	Alphanumeric	25	PartIDs
6	MoldID	The name of the Tool Number.	Alphanumeric	20	MoldIDs
7	Status	The status of the job, either PEND, RUN or SUSP.	Alphanumeric	4	JobStatus
8	Parts To Go	Parts required to complete the job	Integer		JobQueue, JobProd
9	Hours To Go	Estimated time required to complete the job.	Float		JobQueue, JobProd
10	Desired Start Date	Date		JobQueue	User specified start date.
11	Desired Start Time	User specified start time.	Time		JobQueue
12	Desired End Date	User specified end date.	Date		JobQueue
13	Desired End Time	User specified end time.	Time		JobQueue
14	Forecasted Start Date	This is set to the "actual" start date for a running job or the "desired" start date for a pending job.	Date		JobQueue

#	Field	Description	Type	Length	DB Source
15	Forecasted Start Time	This is set to the "actual" start time for a running job or the "desired" start time for a pending job.	Time		JobQueue
16	Forecasted End Date	This is calculated for running jobs and is the "desired" end date for pending jobs.	Date		JobQueue
17	Forecasted End Time	This is calculated for running jobs and is the "desired" end time for pending jobs.	Time		JobQueue
18	Level Of Next	Number indicating intended sequence.	Integer		FutureJobs
19	Son Level Of Next	Number indicating intended sequence.	Integer		FutureJobs
20	Overdue Flag	Always blank.	Alphanumeric	1	

Machine Odometer Export

Use the Machine Odometer Export selection to export machine odometer information.

Machine Odometer information can be exported in two different ways.

The following machine odometer data is exported during the Machine Odometer Export process:

#	Field	Description	Type	Length	DB Source
1	MachID	The name of the machine number.	Alphanumeric	6	MachCon
2	MachDesc	A description of the machine.	Alphanumeric		MachCon
3	DeptName	The name of the department number.	Alphanumeric		Department
4	DeptDesc	The description of the department	Alphanumeric		Department
5	CumTime	Cumulative run time of the machine.	Integer		MachOdometer
6	CumCycle	Cumulative number of cycles for the machine.	Integer		MachOdometer

Special Data Export

Use the Special Data selection to export specialized data using custom programming from Epicor Mattec MES.

This allows your company to export data outside the standard Import/Export offerings. This is an optional feature. To implement specialized data exporting, contact Epicor Mattec MES Professional Services for assistance.

The Manufacturing Manager DTR Export

Use the Schedule Summary Data Export selection to export shift history information using the TMM Standard format.

This allows Mattec MES to be easily integrated with DTR Software International's The Manufacturing Manager™ (TMM) software. The DTR data export is an optional feature.

Automatic Execution of Data Import and Export

Use the Automatic Execution command line to schedule the automatic execution of data imports and exports.

The Data Import/Export program is typically located in the installation **bin** directory, for example **C:\Program Files\Mattec\ProHelp\Bin** and is named **DataImportExport.exe**.

The Data Import/Export program may be executed using command line parameters. This permits the program to be scheduled to run automatically via the Scheduled Tasks Wizard (Accessories -> System Tools -> Scheduled Tasks) that is included with Microsoft Windows.

Automatically Execute Data Import

Use the Data Import/Export command line to schedule automatic data imports.

The Data Import/Export program may be executed from the command line without user interaction. This allows you to automatically execute the Data Import/Export program and instruct the program to perform an import to update the database with data from an external application.



Note This action should only be performed by a Mattec administrator.

Schedule Automatic Import

Use the Data Import command line to schedule the automatic import of data into the Mattec database from Unicode ASCII text files.

1. On your Mattec server, go to the command line. In your Windows menu, type **cmd** in the **Search Programs and Files** field and press **Enter** to launch the command line window.
2. Type the import command, using this syntax: **DataImportExport.exe -auto -import -file:FILE_TO_BE_IMPORTED [options]**, where "DataImportExport.exe" is the name of the Data Import/Export program, "-auto", "-import" and "-file:" are required and must be entered exactly as shown, and "FILE_TO_BE_IMPORTED" should be replaced with the full path name of the data file to be imported.

Schedule Automatic Import Command Line Syntax

Use this Automatic Import Syntax table to reference the command line syntax when scheduling automatic execution of the Data Import/Export program.

Description	Default	Allowable Values
System Number		xxx The system number (as defined by the System Names Edit program). xxx is a number that may not be preceded by a "-" and must be the first command line option that is specified. This field is optional unless more than one system is defined in System Names Edit.

Description	Default	Allowable Values
Automatic execution		-auto Indicates that the Data Import/Export program will be run using command line arguments. Failure to specify this option will cause the program to be run interactively.
Data Import	-import	-import Indicates that the Data Import/Export program will be importing data. -export Indicates that the Data Import/Export program will be exporting data.
File to be imported		-file: "FILE_TO_BE_IMPORTED" The name of the data file to be imported. You must replace FILE_TO_BE_IMPORTED with the full path name of the data file to be imported.
Import file disposition	-nodelete	-delete Always delete the data file. -nodelete Never delete the data file. -delnoerr Delete the data file only if no errors were encountered during processing.
Error logging		-error:ERROR_FILE_NAME The name of the error file. This value is optional. If you do not specify an error file, the value "C:\DataImportExportError.txt" will be used.

Automatically Execute Data Export

Use the Data Import/Export command line to schedule automatic data exports.

The Data Import/Export program may be executed from the command line without user interaction. This allows you to automatically execute the Data Import/Export program and instruct the program to perform an export of data from the Mattec MES database to a text file that can be used by external applications.

The Data Import/Export program is typically located in the installation "bin" directory, for example "C:\Program Files\Mattec\ProHelp\Bin" and is named "DataImportExport.exe". The Data Import/Export program may be executed using command line parameters. This permits the program to be scheduled to run automatically via the Scheduled Tasks Wizard (Accessories -> System Tools -> Scheduled Tasks) that is included with Microsoft Windows.



Note This action should only be performed by a Mattec administrator.

Schedule Automatic Export

Use the Data Export command line to schedule the automatic export of data from the Mattec database to ASCII text files.

1. On your Mattec server, go to the command line. In your Windows menu, type **cmd** in the **Search Programs and Files** field and press **Enter** to launch the command line window.
2. Type the export command, using this syntax: **DatImportExport.exe -auto -export -type -file:FILE_TO_BE_EXPORTED [options]**, where **DatImportExport.exe** is the name of the Data Import/Export program, **-auto**, **-export** and **-file:** are required and must be entered exactly as shown, and **FILE_TO_BE_EXPORTED** should be replaced with the full path name of the data file to be exported.


Schedule Automatic Export Command Line Syntax


Use this Automatic Export Syntax table to reference the command line syntax when scheduling automatic execution of the Data Import/Export program to export data.


Description	Default	Allowable Values
System Number		xxx The system number (as defined by the System Names Edit program). xxx is a number that may not be preceded by a "-" and must be the first command line option that is specified. This field is optional unless more than one system is defined in System Names Edit.
Automatic execution		-auto Indicates that the Data Import/Export program will be run using command line arguments. Failure to specify this option will cause the program to be run interactively.
Data Import	-import	-import Indicates that the Data Import/Export program will be importing data.. -export Indicates that the Data Import/Export program will be exporting data. Export should always be entered if you are exporting data.
File to be exported		-file: "FILE_TO_BE_EXPORTED" The name of the data file to be created. You must replace FILE_TO_BE_EXPORTED with the full path name of the data file to be exported.
Export type		-prod Production history export. -spc SPC history export.

Description	Default	Allowable Values
		-job Job descriptor export. -process Process Sheet export. -part Part ID export. -tool Tool ID export. -operator Operator history export. -dtr DTR Data Export. -schedule Schedule Summary Report
Quoted text	-noquoted	-noquoted Text fields are exported without quotes. -quoted Text fields are exported with double quotes.
Fixed-length text	-nofixed	-nofixed Text fields are variable-length. -fixed Text fields are a fixed-length and padded with spaces.
Encoding	-unicode	-ascii ASCII text format. -unicode Unicode text format.
Department	All	-deptno:xxx The internal DeptNo of the department to export, where xxx is a number between 1 and 99.
Start date	-startdate:0 (current day)	-startdate:xxx Where xxx is zero or a negative number relative to today (e.g., "-startdate:-1" instructs the program to start one day before today).
End date	-enddate:0	-enddate:xxx

Description	Default	Allowable Values
	(current day)	Where xxx is zero or a negative number relative to today (e.g., "-enddate:-1" instructs the program to end one day before today).
Shift Index	All	-shift:xxx The shift index for the data to be exported, where xxx is the specific shift index. The first shift of the production day is 1. Values can range from 1-10.
Error logging		-error:ERROR_FILE_NAME The name of the error file. This value is optional. If you do not specify an error file, the value "C:\DataImportExportError.txt" will be used.

 **Note** The department (-deptno), start date (-startdate), and end date (-enddate) or shift index (-shift) are available for the Production history export (-prod), the Operator history export (-operator), and the DTR Data Export (-dtr). The department (-deptno), start date (-startdate), and end date (-enddate), but not the shift index (-shift), are available for the SPC history export (-spc).

 **Note** The optional settings for end date (-enddate) and shift index (-shift) may not be used together. Both of these settings combine with the setting for start date (-startdate) to limit the amount of data that will be exported.


 **Note** Some additional types may be supported to allow data to be exported in an older format.

Automatically Run Real-Time Display HTML Export

Use the Automatic Real-Time Display HTML Export feature to schedule the automatic export of Real-Time Display data to an HTML file for viewing with a web browser.

This functionality can be useful for displaying real-time display data on a display on the shop floor.

This feature can only be accessed from the command line and is not available when the Data Import/Export program is run interactively.

 **Note** This action should only be performed by a Mattec administrator.

Schedule Automatic Export of Real-Time Display HTML Data

Use the Data Export command line to schedule the automatic export of Real-Time display data from the Mattec database to HTML files.

1. On your Mattec server, go to the command line. In your Windows menu, type **cmd** in the **Search Programs and Files** field and press **Enter** to launch the command line window.
2. Type the export command, using this syntax: **DataImportExport.exe -auto -export -realtime -displayno:REAL_TIME_DISPLAY_NUMBER -file:FILE_TO_BE_EXPORTED [options]**, where "DataImportExport.exe" is the name of the Data Import/Export program, "-auto", "-export", "-realtime", "-displayno:", and "-file:" are required and must be entered exactly as shown,

"REAL_TIME_DISPLAY_NUMBER" should be replaced with the number of the desired display as shown on the Real-Time Display Writer screen, and "FILE_TO_BE_EXPORTED" should be replaced with the full path name of the data file that will be created.

Schedule Automatic Real-Time Display Data Export Command Line Syntax

Use this Automatic Export Syntax table to reference the command line syntax when scheduling automatic execution of the Data Import/Export program to export Real-Time Display data to HTML.

Description	Default	Allowable Values
System Number		xxx The system number (as defined by the System Names Edit program). xxx is a number that may not be preceded by a "-" and must be the first command line option that is specified. This field is optional unless more than one system is defined in System Names Edit.
Automatic execution		-auto Indicates that the Data Import/Export program will be run using command line arguments. Failure to specify this option will cause the program to be run interactively.
Data direction		-export Indicates that the Data Import/Export program will be exporting data.
Type		-realtime Indicates that the Data Import/Export program will be exporting a Real-Time display.
Display number		-file:"REAL_TIME_DISPLAY_NUMBER" The internal numeric identifier of the display. This number is shown on the Real-Time Display Writer screen. You must replace REAL_TIME_DISPLAY_NUMBER with this number.
File to be exported		-displayno:"FILE_TO_BE_EXPORTED" The name of the data file to be created. You must replace FILE_TO_BE_EXPORTED with the full path name of the data file to be exported.
Refresh		-refresh:xxx Where xxx is the desired refresh interval in seconds. This number is placed in the HTML file to indicate to the browser how often it should refresh its display. Rerunning the export operation refreshes the data that is displayed.
Department	All	-deptno:xxx The internal DeptNo of the department to export, where xxx is a number between 1 and 99.

Automatically Run Reports

Use the SystemReports command line to schedule the automatic run of Mattec reports.

The System Reports program allows you to automatically schedule the run of Mattec reports. When a report is scheduled to run automatically, you can select to copy the report data to a file and or automatically print the report.



Note This action should only be performed by a Mattec administrator.

Schedule Automatic Report Runs

Use the SystemReports command line to schedule the automatic running of reports. Reports can be copied to a file and or printed on a printer in your facility.

1. On your Mattec server, go to the command line. In your Windows menu, type **cmd** in the **Search Programs and Files** field and press **Enter** to launch the command line window.
2. Type the SystemReports command, using this syntax: **SystemReports.exe -auto -report:REPORT_FILE_NAME -error:ERROR_FILE [-output:OUTPUT_FILE_NAME] [-type:OUTPUT_TYPE] [-print] [options]**, where "SystemReports.exe" is the name of the SystemReports program and "-auto" is required and must be entered exactly as shown.

Schedule Automatic Report Runs Command Line Syntax

Use this Automatic Report Run Syntax table to reference the command line syntax when scheduling automatic execution of the System Reports program to run reports. Reports can be saved to an Excel, PDF or Word format and automatically printed.

Description	Allowable Values
System Number	xxx The system number (as defined by the System Names Edit program). xxx is a number that may not be preceded by a "-" and must be the first command line option that is specified. This field is optional unless more than one system is defined in System Names Edit.
Automatic execution	-auto Indicates that the System Reports program will be run using command line arguments. Failure to specify this option will cause the program to be run interactively.
Report to execute	-report: "REPORT_FILE_NAME"

Description	Allowable Values
	The name of the report file to be executed, without the .RPT extension (e.g. "-report:DailyProd").
Error Logging	-error:ERROR_FILE_NAME The name of the error file. This value is optional. If you do not specify an error file, the value "C:\AutoReport.txt" will be used.
Output File Name	-output:OUTPUT_FILE_NAME The name of the output file. This value is optional if you are printing the report.
Output Type	-type:charseparated Character-separated file format. -type:excel97 Microsoft Excel format. -type:pdf PDF format. -type:word Microsoft Word for Windows format
Print Output	-print Causes the report output to be printed to the default printer. If a default printer is not defined, the report will not be printed.
Start Date	-startdate:xxx Where xxx is zero or a negative number relative to today (e.g., "-startdate:-1" instructs the report to start one day before today).
End Date	-enddate:xxx Where xxx is zero or a negative number relative to today (e.g., "-enddate:-1" instructs the report to end one day before today).
PM Due Date	-pmdueby:xxx Where xxx is zero or a positive number relative to today (e.g., "-pmdueby:7" instructs the report to display all preventive maintenance that is due in the next 7 days).
Running Jobs Only	-runningjobsonly Causes the report to be generated for running jobs only.
Job Start Date	-jobstart:xxx Where xxx is zero or a negative number relative to today (e.g., "-jobstart:-2" instructs the report to include all jobs that ran anytime where their start date was 2 days before today.)

Description	Allowable Values
Job End Date	-jobend:xxx Where xxx is zero or a negative number relative to today (e.g., "-jobend:-1" instructs the report to include all jobs that ran anytime where their end date was 1 day before today.)
Where Clause	-where:xxx Where xxx is any valid "where clause" that can be used with the report to limit data that will be displayed (e.g., "-where: "MachNo=3 OR MachNo=4" instructs the report to display data for MachNo's 3 and 4.



Note The start date (-startdate) and end date (-enddate) are available for reports that include a ShiftSeq, such as the Daily Production Report.



Note The PM Due Date (-pmduedate) is available for the Machine PM Due Report or the Tool PM Due Report.



Note The running jobs only flag (-runningjobonly), job start date (-jobstart), and job end date (-jobend) are only available for Job reports that include the Status, StartTime, and StopTime fields, such as the Job Production Report.

Data Integration

This section contains an overview of Mattec MES Data Integration.

As well as standard data import and export options, Epicor offers a more tightly integrated data flow with the following two Epicor ERP products:

- Epicor ERP 10
- Epicor CMS

Data Integration with Epicor ERP and Mattec MES

Use Data Integration to manage production from a central location and seamlessly integrate data flow between Epicor ERP and Mattec MES. This integration allows you to reduce errors from manual data entry in both applications and get timely and accurate data to enable better manufacturing decisions.

Epicor ERP production planning and job data are exported to Mattec MES for use when performing and monitoring shop floor activities. In Mattec MES, production data is monitored and recorded for use in process and quality control monitoring and analysis.

Labor and production data recorded in Mattec MES will then flow back to Epicor ERP where the data can be used for costing, reporting and production analysis.



Note In Epicor ERP, you can only export ERP database entry records marked as Machine MES and records linked to them.

Data Integration with Epicor CMS

Use Data Integration to tightly integrate Epicor CMS and Mattec MES in real-time.

There are the following three methods for integrating data between CMS and Mattec MES:

- Static data, such as master files, work orders, and schedules are passed from CMS directly into the Mattec MES database.
- CMS batch data, such as production history, is passed directly from the Mattec MES database into iVP. Data can be passed frequently or once per shift and can be posted automatically or reviewed by a user and then posted.
- CMS event based data, such as job changes, shift changes, and production information, is passed directly from the Mattec MES system into CMS via CMS's Event Based interface.

EPICOR.

Additional information is available at the Education and Documentation areas of the EPICweb Customer Portal. To access this site, you need a Site ID and an EPICweb account. To create an account, go to <http://support.epicor.com>.