

mSPECIFY® User Guide

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I. Introduction

Welcome to the mSPECIFY® User Guide. This manual will provide you basic instructions on how to implement and use the mSPECIFY® software. This software program is utilized to create, review, and modify the process parameters (henceforth - referred to as "recipes") associated with the measureOD® Laser Micrometer program.

The mSPECIFY® may be run on ANY computer attached to the Internet. You do NOT have to run this software on the computer that is attached to the Laser Micrometer (but you may do so if you so desire).

- The recipes are stored on our MySQL Server at no charge.
- If you have your own Linux server running the MySQL Database Server -- we can migrate these tables to your server at no charge.
- The recipes created with your account code may be accessed by ANY computer running the measureOD® software program associated with your companies account codes.
- These recipes are only associated with your company.

II. Reference Documents

- **MeasureOD® End User License Agreement (EULA)**, Roth Technologies, LLC
- **mDATA® User Guide**, Roth Technologies, LLC
- **measureOD® User Guide**, Roth Technologies, LLC
- **measureOD® Install Guide**, Roth Technologies, LLC

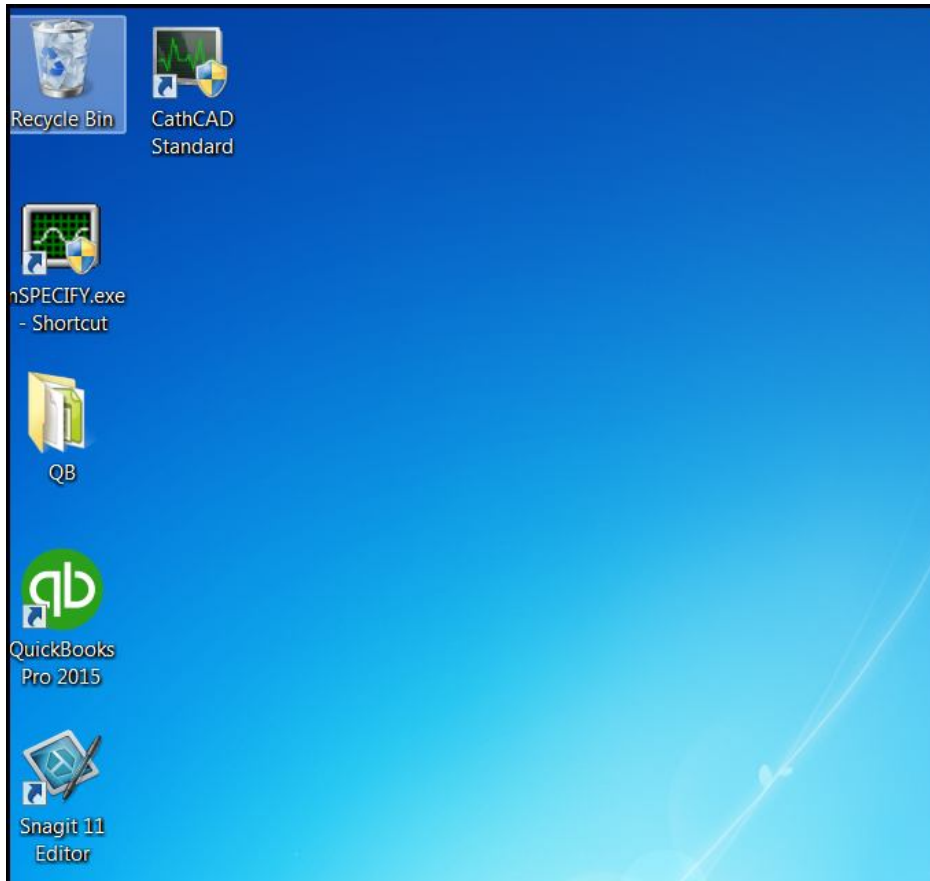
III. Necessary Components

The following components are necessary in order to run the mSPECIFY® software:

1. The software must be installed on your computer via the Installation CD that was provided with your order. The latest released software may also be downloaded from our website at www.measureod.com.
2. The MySQL ODBC driver must be loaded on your computer. This only needs to be done one time for each computer.
3. Your computer that is used to run the software MUST be connected to the Internet and Port 3306 must be open on your Test Computer and Network. There is an interchange of material data between the computer and the MySQL Server. If the interchange of data is slow and/or interrupted, the program may not run correctly or timeout.

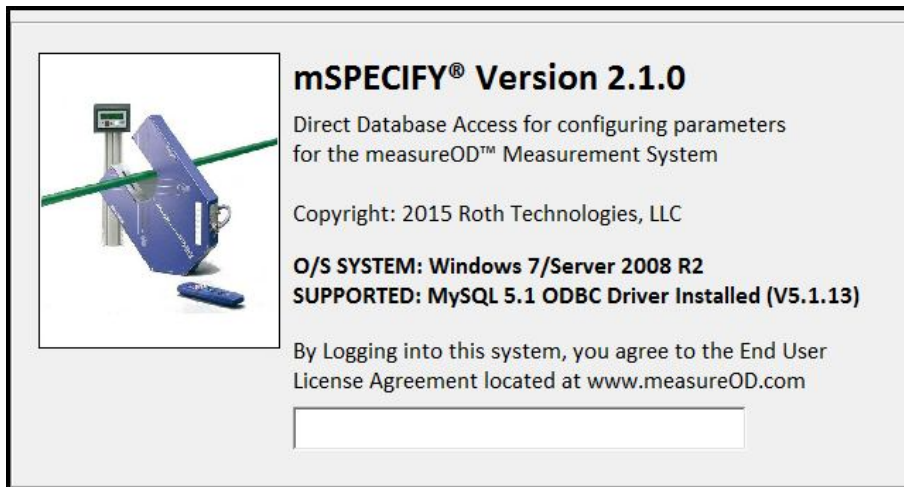
IV. Running the Program

Execute the mSPECIFY® program by double clicking program icon. This ICON is provided on the desktop as part of the software installation. It is also available under the PROGRAM manager.

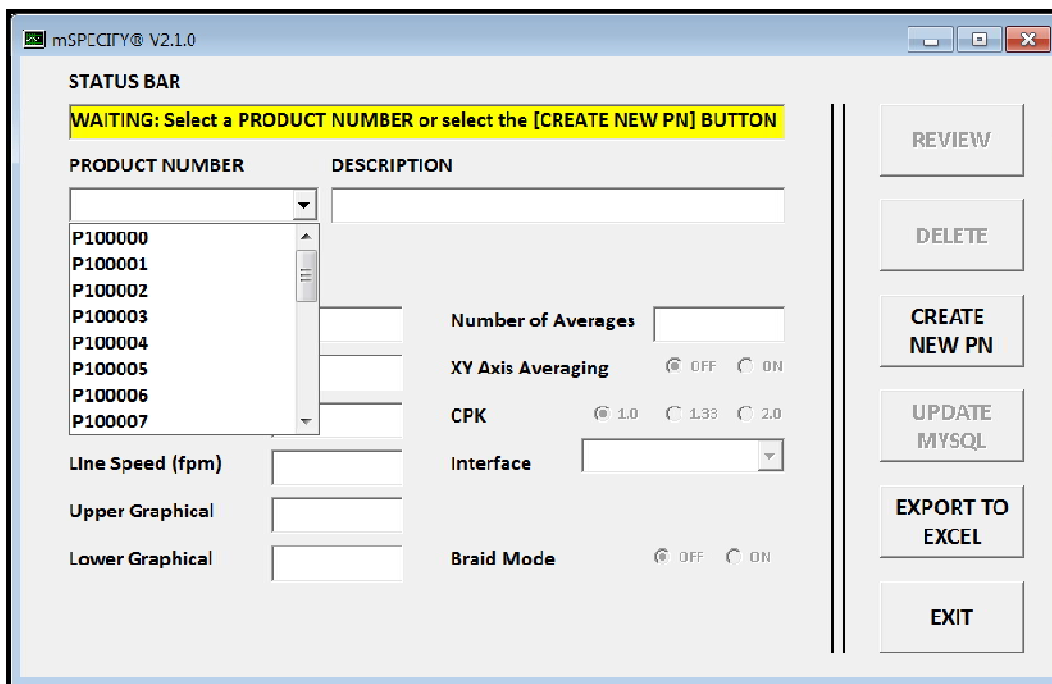


V. Using the mSPECIFY® Software

Step 1: Log into the system. Your company has been provided a twelve character length password for logging into the MeasureOD® system. You may submit a request to sales@cathcad.com to request a change to your password character string. This character string identifies your company within the MeasureOD® system. If you happen to lose control of your passcode, contact us.



After logging into the system, the Main Menu will appear on the screen as shown. The software at this point is waiting for a product to be selected from the PRODUCT NUMBER drop down menu OR you can create a new PN with the CREATE NEW P/N command button.



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Upon loading a PRODUCT NUMBER, the software command buttons become functional as shown.

The screenshot shows the mSPECIFY V2.1.0 software window. At the top, a status bar displays a yellow warning: "WAITING: Update the Product Parameters OR Use the Command Buttons". Below this, the "PRODUCT NUMBER" is set to "P100000" and the "DESCRIPTION" is "0.0235" +/- 0.0005". The "CONFIGURATION" section includes input fields for "Upper Spec Limit" (0.024000), "Lower Spec Limit" (0.023000), "Nominal" (0.023500), "Line Speed (fpm)" (8.0), "Upper Graphical" (0.024500), and "Lower Graphical" (0.022500). It also features radio buttons for "Number of Averages" (5), "XY Axis Averaging" (OFF), "CPK" (1.0), and "Braid Mode" (OFF). A dropdown menu for "Interface" is set to "LaserLinc Total Vu". On the right side, a vertical column of buttons includes "REVIEW", "DELETE", "CREATE NEW PN", "UPDATE MYSQL", "EXPORT TO EXCEL", and "EXIT".

VI. CONFIGURATION PARAMETERS

The following configuration parameters are required to create a complete recipe that may be accessed and used by the measureOD® program.

- Product Number: These are automatically created by the mSPECIFY® program. You cannot change them.
- Description: This is a description of the product. It must be alphanumeric. It will show up on your graphs, display, etc.
- Upper Spec Limit: This is the upper specification limit for the product being measured. The units of measure is inches.
- Lower Spec Limit: This is the lower specification limit for the product being measured. The units of measure is inches.
- Nominal: This is the computed nominal value based on the USL and LSL. The units of measure is inches.

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Line Speed:	This is the expected line speed of the manufacturing run. The units of measure is feet per minute.
Upper Graphical:	The upper graphical limit is the upper limit used for graphing purposes (default). The units of measure is inches. The User can change this at the time the measureOD® program is run.
Lower Graphical:	The lower graphical limit is the lower limit used for graphing purposes (default). The units of measure is inches. The User can change this value at the time the measureOD® program is run.
Averaging:	The number of averages value is used for averaging measurements.
XY Averaging:	If you have a dual axis laser micrometer -- you can a choice of treating the readings as INDEPENDENT and/or the system will take the x and y reading and average them.
CPK:	You can set the CPK pass/fail limit with this setting. This may be set to 1.0, 1.33, or 2.0
INTERFACE:	You can set your primary interface setting with this parameter.
BRAID MODE:	This is a feature that will be implemented at a later release of the software. This setting will allow measurement of textured braided products to be equivalent to using a hand micrometer, that is, only the high points are measured and the lower points (in between the braid checks) are ignored.

VII. COMMAND FUNCTIONS

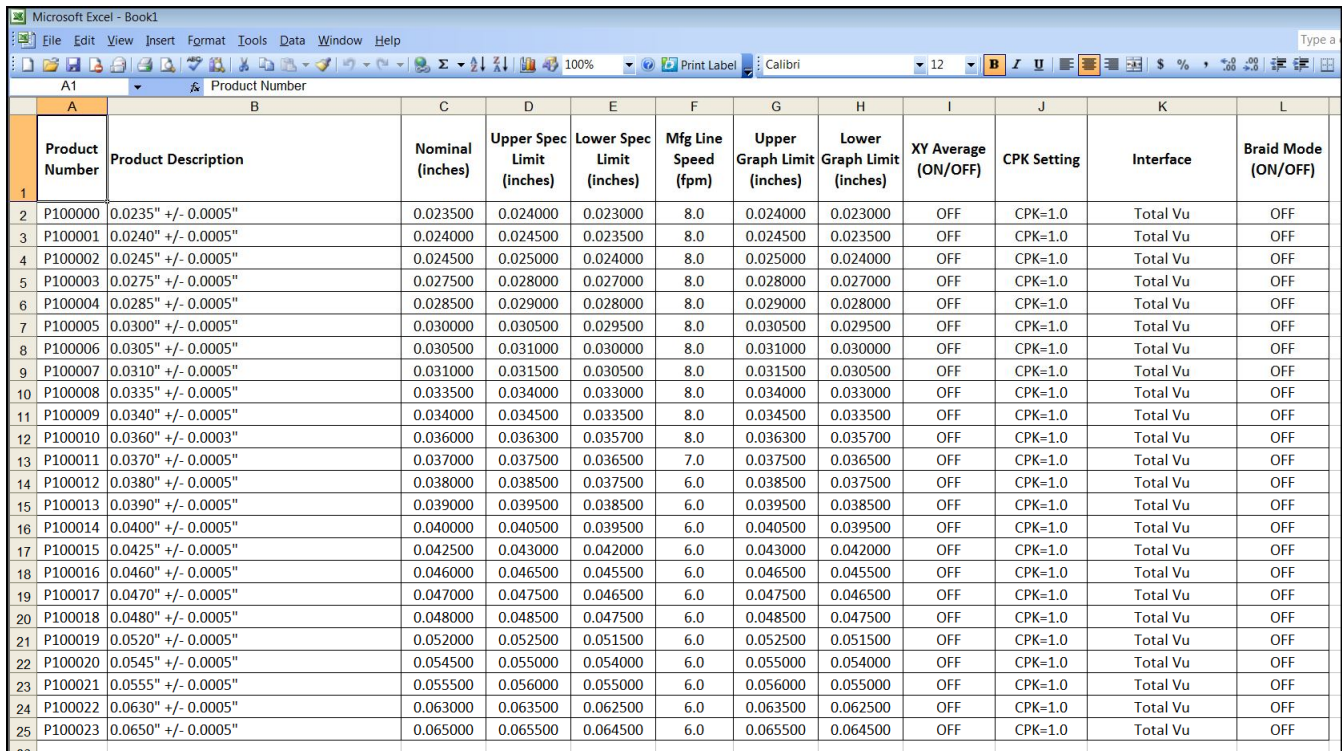
The following summarizes the command function/buttons associated with the software.

REVIEW:	The software will review your configuration data and make sure that it is proper. This is automatically done with you select the UPDATE MYSQL function as well but sometimes it is nice to check the data in advance of saving it.
DELETE:	This function will DELETE a recipe from the MySQL Database. Permanently. You will be asked to confirm this function first.
CREATE:	This function will create a new product number. It will offer you a choice of using the current loaded parameters and/or start from our standard configuration.

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UPDATE: This function will update the MySQL Database with your configuration. It will first review the parameters to make sure they are proper. If they have a mistake in them -- the configuration will NOT be saved.

EXPORT: This function allows you to export ALL recipes from the MySQL Database to Microsoft Excel. Note that that Excel must be loaded on your computer for this function to work. We do NOT provide this program as part of our software.



The screenshot shows a Microsoft Excel spreadsheet titled "Microsoft Excel - Book1". The spreadsheet contains a table with 12 columns and 25 rows of data. The columns are labeled as follows: A1 (Product Number), B (Product Description), C (Nominal (Inches)), D (Upper Spec Limit (Inches)), E (Lower Spec Limit (Inches)), F (Mfg Line Speed (fpm)), G (Upper Graph Limit (Inches)), H (Lower Graph Limit (Inches)), I (XY Average (ON/OFF)), J (CPK Setting), K (Interface), and L (Braid Mode (ON/OFF)). The data rows show various product numbers (P100000 to P100023) and their corresponding specifications.

Product Number	Product Description	Nominal (Inches)	Upper Spec Limit (Inches)	Lower Spec Limit (Inches)	Mfg Line Speed (fpm)	Upper Graph Limit (Inches)	Lower Graph Limit (Inches)	XY Average (ON/OFF)	CPK Setting	Interface	Braid Mode (ON/OFF)
P100000	0.0235" +/- 0.0005"	0.023500	0.024000	0.023000	8.0	0.024000	0.023000	OFF	CPK=1.0	Total Vu	OFF
P100001	0.0240" +/- 0.0005"	0.024000	0.024500	0.023500	8.0	0.024500	0.023500	OFF	CPK=1.0	Total Vu	OFF
P100002	0.0245" +/- 0.0005"	0.024500	0.025000	0.024000	8.0	0.025000	0.024000	OFF	CPK=1.0	Total Vu	OFF
P100003	0.0275" +/- 0.0005"	0.027500	0.028000	0.027000	8.0	0.028000	0.027000	OFF	CPK=1.0	Total Vu	OFF
P100004	0.0285" +/- 0.0005"	0.028500	0.029000	0.028000	8.0	0.029000	0.028000	OFF	CPK=1.0	Total Vu	OFF
P100005	0.0300" +/- 0.0005"	0.030000	0.030500	0.029500	8.0	0.030500	0.029500	OFF	CPK=1.0	Total Vu	OFF
P100006	0.0305" +/- 0.0005"	0.030500	0.031000	0.030000	8.0	0.031000	0.030000	OFF	CPK=1.0	Total Vu	OFF
P100007	0.0310" +/- 0.0005"	0.031000	0.031500	0.030500	8.0	0.031500	0.030500	OFF	CPK=1.0	Total Vu	OFF
P100008	0.0335" +/- 0.0005"	0.033500	0.034000	0.033000	8.0	0.034000	0.033000	OFF	CPK=1.0	Total Vu	OFF
P100009	0.0340" +/- 0.0005"	0.034000	0.034500	0.033500	8.0	0.034500	0.033500	OFF	CPK=1.0	Total Vu	OFF
P100010	0.0360" +/- 0.0003"	0.036000	0.036300	0.035700	8.0	0.036300	0.035700	OFF	CPK=1.0	Total Vu	OFF
P100011	0.0370" +/- 0.0005"	0.037000	0.037500	0.036500	7.0	0.037500	0.036500	OFF	CPK=1.0	Total Vu	OFF
P100012	0.0380" +/- 0.0005"	0.038000	0.038500	0.037500	6.0	0.038500	0.037500	OFF	CPK=1.0	Total Vu	OFF
P100013	0.0390" +/- 0.0005"	0.039000	0.039500	0.038500	6.0	0.039500	0.038500	OFF	CPK=1.0	Total Vu	OFF
P100014	0.0400" +/- 0.0005"	0.040000	0.040500	0.039500	6.0	0.040500	0.039500	OFF	CPK=1.0	Total Vu	OFF
P100015	0.0425" +/- 0.0005"	0.042500	0.043000	0.042000	6.0	0.043000	0.042000	OFF	CPK=1.0	Total Vu	OFF
P100016	0.0460" +/- 0.0005"	0.046000	0.046500	0.045500	6.0	0.046500	0.045500	OFF	CPK=1.0	Total Vu	OFF
P100017	0.0470" +/- 0.0005"	0.047000	0.047500	0.046500	6.0	0.047500	0.046500	OFF	CPK=1.0	Total Vu	OFF
P100018	0.0480" +/- 0.0005"	0.048000	0.048500	0.047500	6.0	0.048500	0.047500	OFF	CPK=1.0	Total Vu	OFF
P100019	0.0520" +/- 0.0005"	0.052000	0.052500	0.051500	6.0	0.052500	0.051500	OFF	CPK=1.0	Total Vu	OFF
P100020	0.0545" +/- 0.0005"	0.054500	0.055000	0.054000	6.0	0.055000	0.054000	OFF	CPK=1.0	Total Vu	OFF
P100021	0.0555" +/- 0.0005"	0.055500	0.056000	0.055000	6.0	0.056000	0.055000	OFF	CPK=1.0	Total Vu	OFF
P100022	0.0630" +/- 0.0005"	0.063000	0.063500	0.062500	6.0	0.063500	0.062500	OFF	CPK=1.0	Total Vu	OFF
P100023	0.0650" +/- 0.0005"	0.065000	0.065500	0.064500	6.0	0.065500	0.064500	OFF	CPK=1.0	Total Vu	OFF

EXIT: Upon confirmation, the program is exited. The software will ask for a confirmation from the User.

VIII. Reporting Errors

Please report errors via email to sales@cathcad.com. Please provide as much information as possible with regards to the setup of the program when the error occurred.