

# MeasureOD<sup>®</sup> User Guide

**TABLE OF CONTENTS**

I.	Introduction .....	3
II.	Reference Documents .....	3
III.	Necessary Components .....	3
IV.	Running the Program .....	4
V.	Using the MeasureOD® System .....	4
VII.	Reporting Errors .....	9

# MeasureOD® User Guide

## I. Introduction

Welcome to the MeasureOD® User Guide. This manual will provide you basic instructions on how to implement and use the MeasureOD® software. Use of this software is subject to the End Users License Agreement (EULA) which is located on our website at [www.measureod.com](http://www.measureod.com).

## II. Reference Documents

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

## III. Necessary Components

The following components are necessary in order to run the MeasureOD® system:

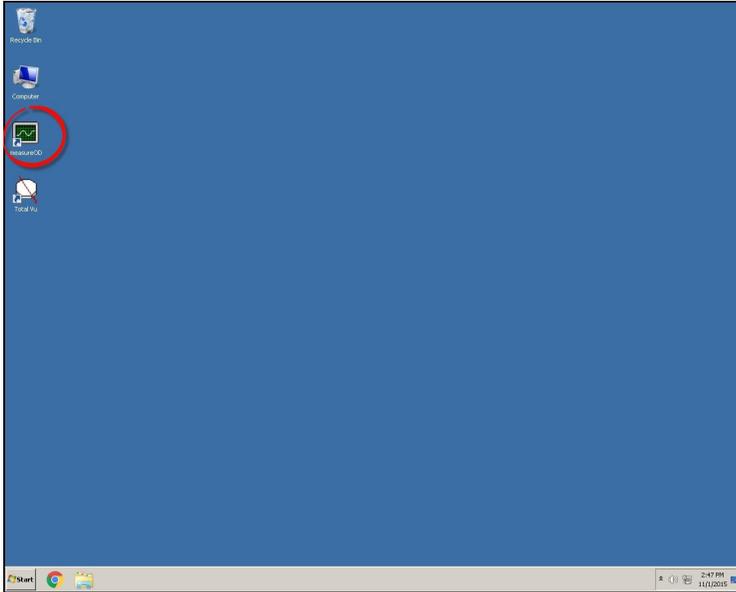
1. The software which is included on the Installation CD that was provided with your order. The latest released software may also be downloaded from our website at [www.measureod.com](http://www.measureod.com).
2. The MySQL ODBC driver must be loaded on your test computer.
3. Your computer that is used 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.
4. Your Laser Micrometer Measurement System:
  - Test Computer: The test computer performs the following functions:
    - (a) runs the MeasureOD® software,
    - (b) communicates with your Laser Micrometer, and
    - (c) communicates with the MySQL database which contains the configuration data and stores the test results
  - Laser Micrometer (not provided)
  - Applicable connection between the Test Computer and the Laser Micrometer System. Depending on the Laser Micrometer, your connection may be via (a) Shared memory, (b) Serial Port (RS-232), and/or (c) Data Acquisition System (A/D Support)

Note: The MeasureOD® System provided does NOT include the Laser Micrometer System.

# MeasureOD® User Guide

## IV. Running the Program

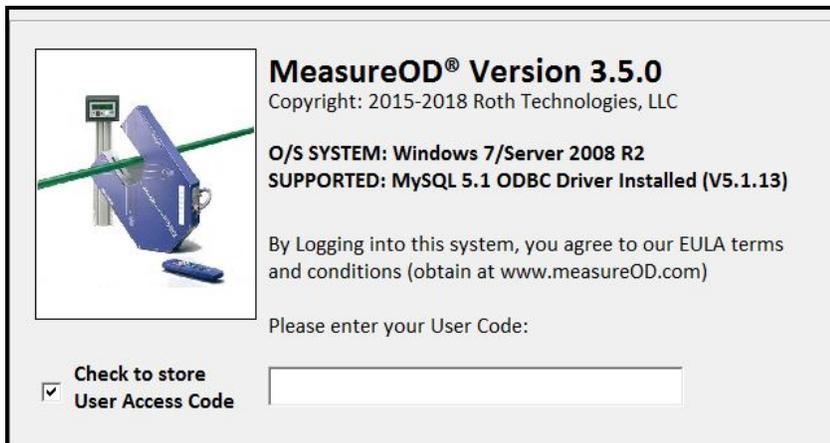
Execute the MeasureOD® program by double clicking program icon to execute it.



## V. Using the MeasureOD® System

In a production environment, the following steps may be taken for obtaining data using the MeasureOD® system once it has been configured using the mSPECIFY® software utility program.

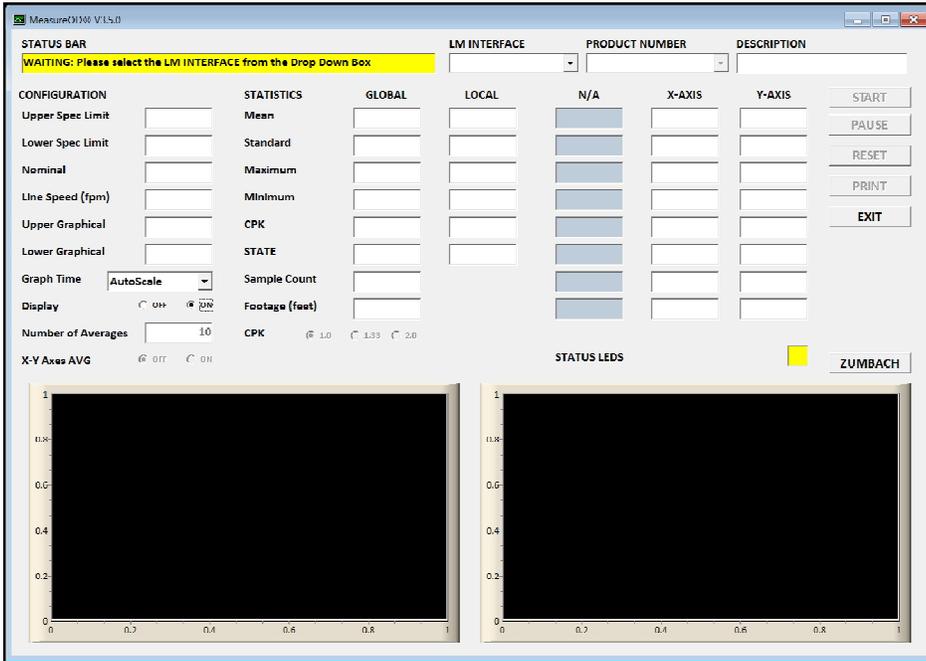
Step 1: Log into the system. Your company has been provided a twelve to sixteen character length password for logging into the MeasureOD® system. You may submit a request to [sales@cathcad.com](mailto:sales@cathcad.com) to change your password character string. This character string identifies your company within the MeasureOD® system.



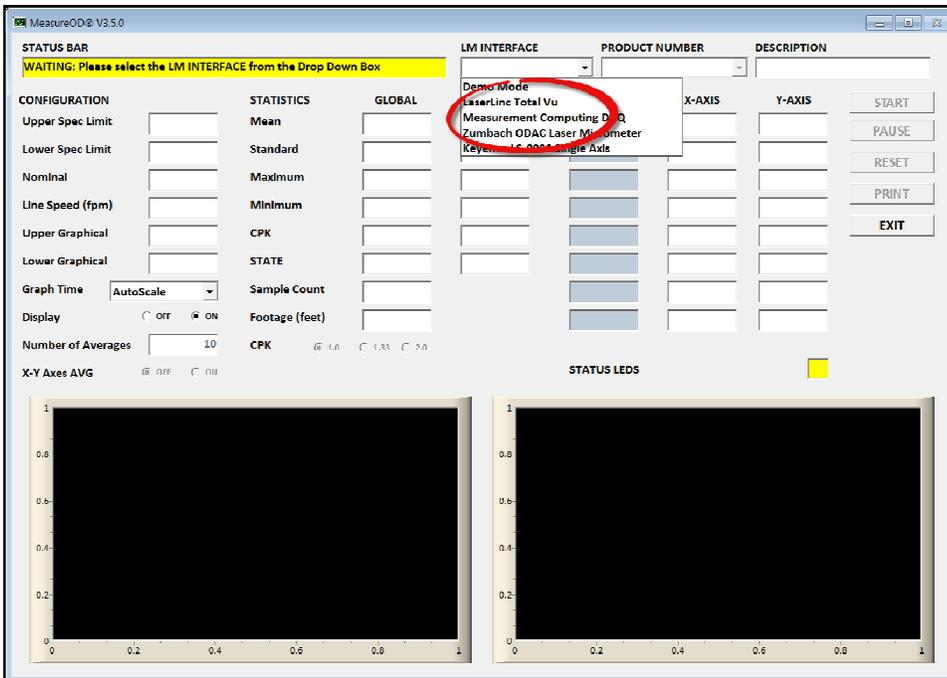
# MeasureOD® User Guide

After logging into the system, the Main Form will appear on the screen as shown. The software at this point is waiting for the LM Interface and Product Number to be selected from the drop down menus.

- Configuration of a test part number is done via the utility program, mSPECIFY®.
- Optionally, the test parameters may be entered at the time of running the software by selecting MANUAL from the Product Number drop down menu.

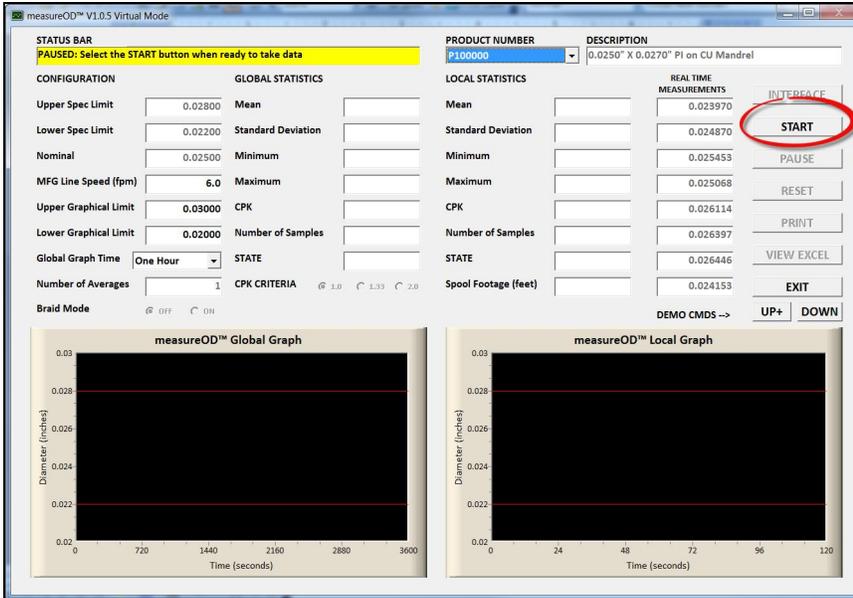


The LM Interface may be selected from the drop down menu



## MeasureOD® User Guide

Upon selecting a valid Product Number, the START button becomes active. When you are ready to begin taking data, select the START button



## MANUAL CONFIGURATION

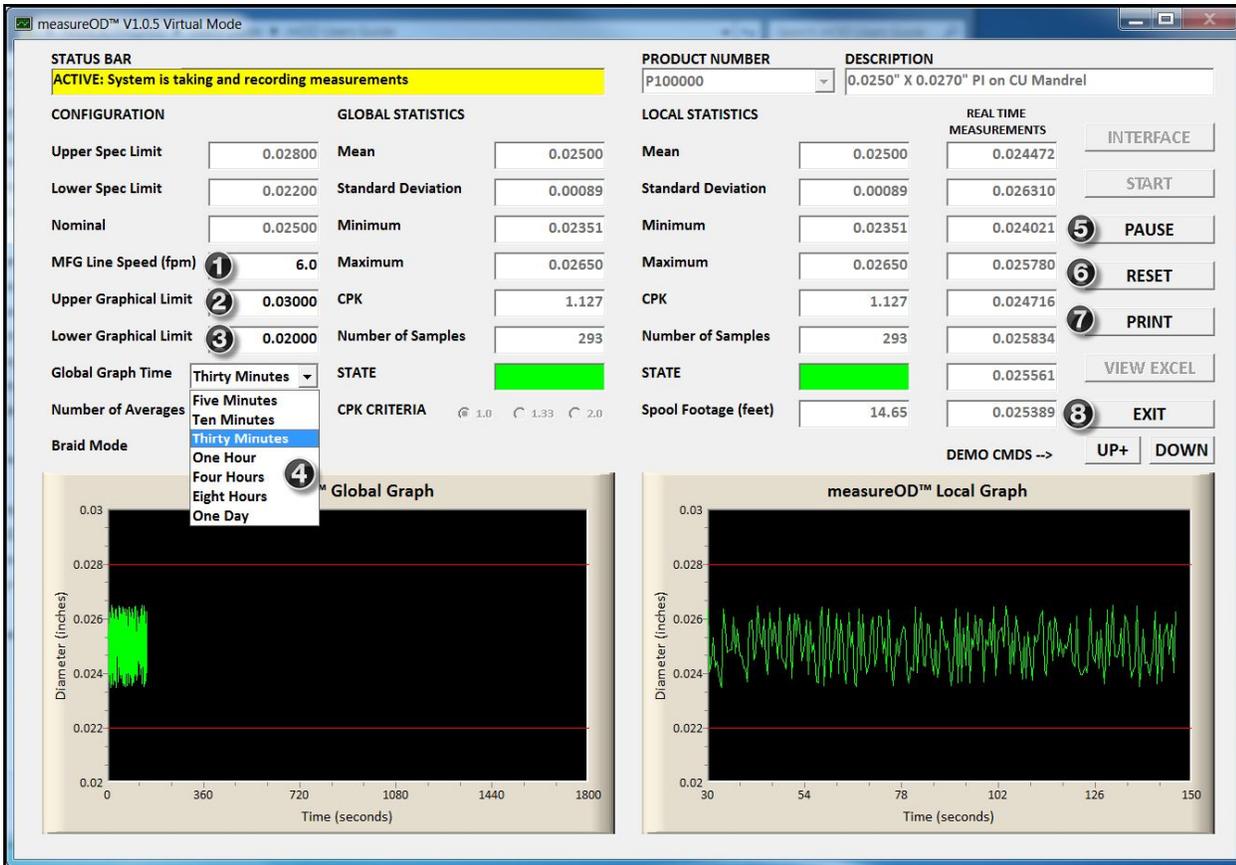
In order to configure a MANUAL configuration the following items must be entered in order to a product measurement to be made by the MeasureOD® software:

- Upper Spec Limit (in inches)
- Lower Spec Limit (in inches)
- Mfg Line Speed (in feet per minute)
- Upper Graphical Limit (in inches)
- Lower Graphical Limit (in inches)
- Number of Averages (range from 1 to 25 with the default at 2)
- XY Axis Averaging (if OFF, then the X-Y measurements are treated independently and if ON then the X-Y measurements are averaged). This option only applies to dual or trio based laser micrometer systems.
- CPK level (1.0, 1.33, or 2.0)

# MeasureOD® User Guide

## RUN MODE

The following options are available when the system is in RUN mode:



**MFG Line Speed:** The approximate manufacturing line speed may be entered here. This will result in a more accurate estimate of the tubing OD as a function of footage

**Upper Graphical Limit:** The graphical upper limit may be adjusted during the manufacturing run.

**Lower Graphical Limit:** The graphical lower limit may be adjusted during the manufacturing run.

**Global Graph Time:** The Global Graph (the left side graph) time scale may be adjusted per the drop down menu.

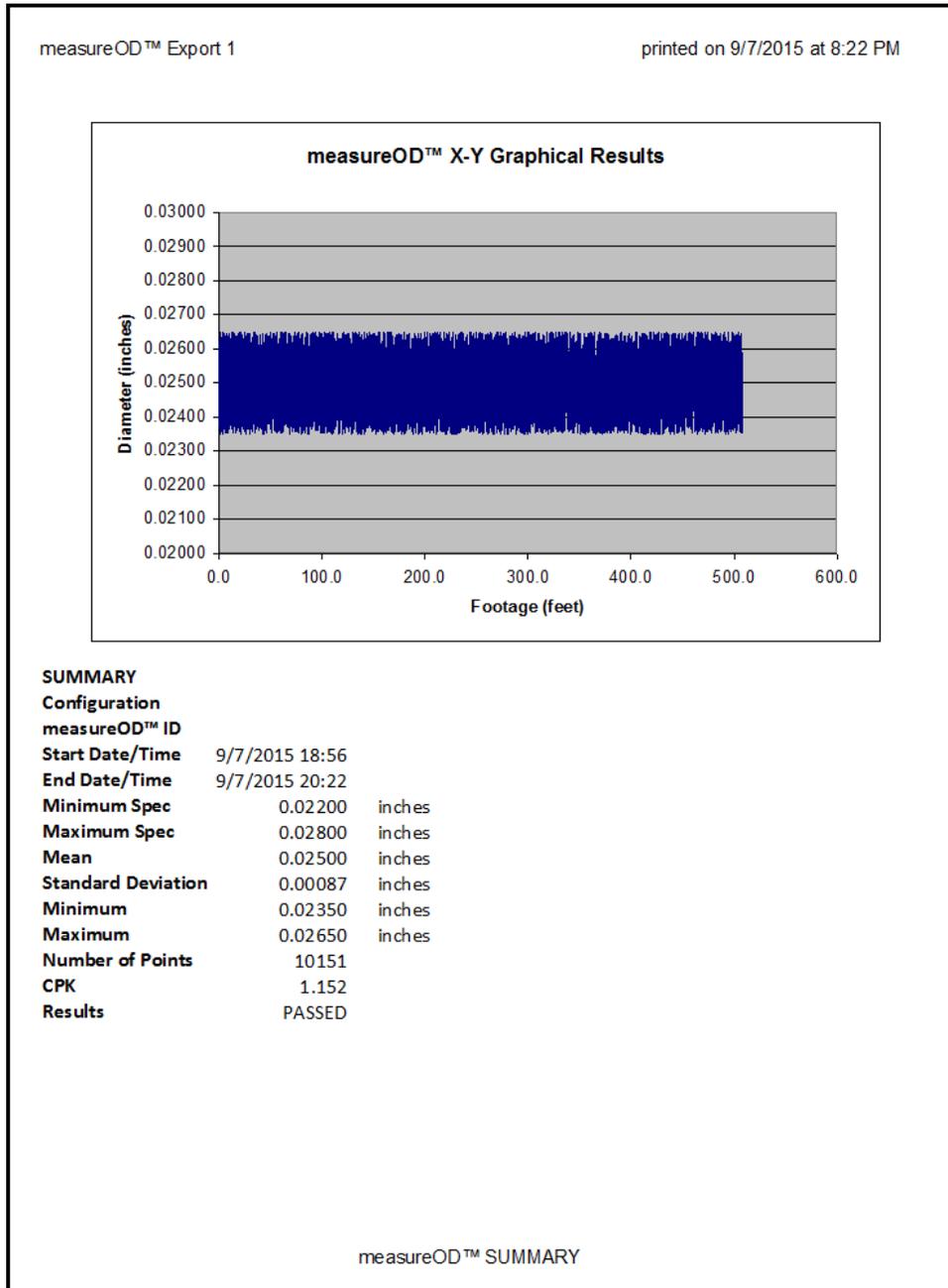
**PAUSE:** The laser micrometer readings may be paused at any time.

**RESET:** The reset allows the real time SPC results to be reset. The software will ask for a confirmation from the User.

## MeasureOD® User Guide

PRINT: The PRINT button exports the current results to Microsoft Excel and allows the graphical results and the SPC summary to be printed by the User. The User may also save the spreadsheet that the data was exported.

The following figure illustrates the typical output.



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

**VII. Reporting Errors**

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