# MICROSEAM V4

SOFTWARE INSTALLATION AND USER GUIDE - ISSUE G

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**PRODUCED FOR:-**

# ARUNDLE OPTICAL INSTRUMENTS

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AMENDMENT RECORD										
Issue	Date	Page No.	Reason							
А	31/07/06	ALL	1 <sup>st</sup> Issue.							
В	7/8/06	31	Updated format formula.							
С	14/8/06	14-17	Updated 'Edit the Program Configuration' dialogue box figures.							
D	2/8/2007	8 & 10	Replace DK12 dongle with DK3 USB dongle.							
Ш	6/8/2007	ALL	Updated for Vista support.							
F	17/8/2007	ALL	Storing app data in mis folder							
G	18/2/2008	ALL	Updated for codejock interface							

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#### 1 INTRODUCTION

The Microseam Inspection Software, from this point on referred to as Microseam, is a Windows based software package designed to receive, process and store dimensional data from a Visual Seam Gauge and other Digital Gauges used for inspecting the dimensional accuracy of seam joints in metal containers.

Captured data can be viewed in tabular form or graphically with clear indication of whether the measurements are within tolerance.

Many seam types can be inspected, and dimensional data and high quality images are held in the software database.

Microseam is Windows 2000, XP, and Vista compliant and is capable of being networked.



Visual Seam Gauge with Microseam Running on Laptop.

### 2 SCOPE

This document is intended to explain the installation and use of Microseam in a stand alone and networked PC environment.

It covers procedures for users and administrators/supervisors.

#### 3 GENERAL

The screen shots within this document are from a PC running Windows Vista.

# 4 DEFINITIONS

#### Format

A measuring format describes the measurements to be taken on a can to obtain the required dimensions. It includes information such as the images to use, whether a rotated image is included, the names of the dimensions, the way in which the dimensions are to be calculated from the measurements, the tolerances, etc.

It is held in a library with other formats and may be used with one or more Datafiles.

#### Datafile

A Datafile contains measurements made using a particular Format for a particular can type.

It is held in a library with other Datafiles.

#### Image File

An Image File is a .BMP file containing a view of a particular can seam configuration to be used when setting up dimensions within a Format File and when the operator takes measurements using a Datafile.

#### Operator

Any person using the Microseam system regardless of security classification.

#### Administrator

A person authorised by the company to set-up and maintain the Microseam system. Duties include allocating Supervisor and User identities.

#### Supervisor

An operator defined by the Administrator as a 'Supervisor'.

#### User

An operator defined by the Administrator as a 'User'.

#### XML

Stands for 'Extensible Markup Language', which is a cross-platform, extensible and text based standard for representing data. It is an option within Microseam for exporting data.

#### Directory

An MS DOS term for a named area of disk containing files. A Directory can contain a number of sub-directories.

#### Folder

A Microsoft Windows term for a named area containing files, equivalent to a directory in MS DOS. A folder can contain a number of folders within it.

#### 5 SECURITY

Microseam has 3 levels of password controlled security which enables different operators to be allowed access to different software features:-

#### • Administrator

Will have access to all functions within Microseam and can create new users, delete existing users and allocate the security level at which they can operate.

#### • Supervisor

Can perform all 'User' functions and in addition can delete or approve measurements.

• User

Can take measurements, add notes to measurements, print data, produce graphs and export data.

If an operator who is defined as a 'User' for security purposes, attempts to approve a measurement, which is a feature restricted to Supervisor and Administrator, the following message will be displayed.

Microsea	im Inspection Software	×
Å	A security level of supervisor or administrator is required to access this function.	

#### 5.1 Passwords

When first installed and run, Microseam has a fixed 'Operator ID' of 'Administrator' with 'Security Level' of 'Administrator' but with no password set.

The Administrator should allocate him/herself a password at the earliest opportunity after software installation to maximise data security. See paragraph 8 below.

#### 6 SOFTWARE INSTALLATION

Software installation should be carried out by a competent person with a working knowledge of the Microsoft Windows operating systems running on a PC platform.

If Microseam is to be run on a network then follow the procedure in paragraph 9 below.

#### 6.1 System Requirements

A PC running a 32 bit Windows operating system, i.e., Windows 2000, Windows XP, or Windows Vista operating systems.

#### 6.2 PC Video Mode

Microseam works best using a 256 colour (or greater) video mode which allows the seam images to be displayed to a reasonable degree of accuracy on the PC screen. A 16 colour video mode is not recommended since the displayed seam images will be of poor quality.

In Windows 2000 the video mode can be changed using the 'Display' icon in 'Control Panel' and selecting the 'Settings' tab.

Background Scre	een Saver   Appearance   Effects   Web   Settings
Display: COMPAG S720 0	alor Monitor on AlHin-Wonder 128 Pro AGP
Colors 256 Colors	Screen area Less More 1024 by 768 pixels
Extend my W	ndows desktop onto this monitor. Advanced

The Screen Area setting to be used depends on the size of the monitor and can be set after installation to give a clear view of the information screens. A screen area of 800 by 600 (or greater) is recommended.

#### 6.3 Demo Software

Before installing the software, inspect the computer to see if a demonstration version of the software (misdemo3.exe) has been previously installed to the PC. If a demo version has been installed, remove all of its components before attempting to install the full working version.

#### 6.4 Media

The Microseam software is supplied on a single CD-ROM. For copy protection, a 'dongle' is supplied (DESkey DK3-USB) and needs to be connected to the PC after software installation. (See paragraph 7 below).

#### 6.5 Installing the Software

- Insert the CD-ROM containing the Microseam software into the CD drive.
- From the Windows desktop click the Windows start button.
- The Start Menu appears. This will differ depending on the Windows version. A screen shot from a PC running Windows Vista is shown below.

Internet Explorer
Notepad
txf - Shortcut
🧼 Visual Studio 2005
Microsoft Word
Mozilla Thunderbird
Windows Explorer
Backup and Restore Center
PKZIP for Windows
Microseam
All Programs
Start Search

• Type 'run' into Start Search and a list of search results will be displayed.

Programs
12 Run
A Restart Runtime
Files
TradeAppPlatformClientCoreCOM.reg
🔮 NLog.xml
NAS-MKT.txt
ASE-MKT.txt
NETSHARE.TXT
₽ See all results
Search the Internet
run ×

• Select the 'Run' program and the 'Run' box appears.

1000	Type the name of a program, folder, document, or Internet
	resource, and Windows will open it for you.
<u>O</u> pen:	d:\microseam_setup_4v0v0v0.exe -

- Enter the drive letter of the CD ROM drive containing the software, a backslash and the name of the installation program e.g. microseam\_setup\_4v0v0v0.exe.
- Click the 'OK' button
- The Installation Wizard will automatically take you through the installation process for the Microseam software.

# 6.6 Identifying the Version of Software Installed

The version of software running can be found as follows:-

- From the main menu select 'Help'.
- From the drop down list select 'About Microseam'.
- The 'About Microseam' box appears, giving the software version.



#### 7 DESkey DONGLE INSTALLATION

Microseam is supplied with a matched DESkey DK3-USB dongle which must be attached to a USB port of the PC to operate correctly.

For the dongle to function, drivers must be installed also.

#### 7.1 DESkey Driver Software Installation

The DESkey DK3-USB dongle requires the DK3 dongle drivers to be installed on the PC on which the Microseam software is running.

The installation file for the dongle drivers is located in the dongle subdirectory of the Microseam executable directory, i.e. "C:\Program Files\Arundle Optics\Microseam\dongle", if the program is installed to the default directory.

To install the drivers, run the 'dk3wn32.exe' setup program and the Installation Wizard will automatically begin the installation process.

#### **IMPORTANT**

If the operating system is ever upgraded after installing the DESkey drivers, for example from Windows 2000 to Window XP, uninstall the drivers first and reinstall after the operating system upgrade. Further information can be found at http://www.deskey.co.uk

#### 7.2 Dongle Connection

• The dongle should be connected to a spare USB port on the PC.

#### 8 SETTING ADMINISTRATOR PASSWORD

When installation of Microseam and the dongle is completed, for security reasons, the 'Administrator' password should be set as soon as possible by running the software and Logging on as 'Administrator'.

#### 8.1 Run Microseam

The are a number of ways of starting Microseam, by double clicking an icon on the desktop (assuming a shortcut has been placed there) and via the Start Menu. Below is a description of starting from the Start Menu.

• From the Windows desktop click the Windows start button at the bottom left of the screen. The 'Start Menu' appears. This will differ depending on the Windows version.

C	Internet Internet Explorer
	Notepad
R.C.	txf - Shortcut
Ø	Visual Studio 2005
W	Microsoft Word
9	Mozilla Thunderbird
4	Windows Explorer
J.	Backup and Restore Center
	PKZIP for Windows
6	Corel PHOTO-PAINT 9
•	All Programs
Start	Search 👂

- Select 'All Programs'.
- Select Microseam in the program list and the program option 'Microseam' will be given.
- Select 'Microseam'. The 'splash screen' appears then the Logged Off screen as shown below.



# 8.2 Logon as Administrator

- From the main menu select the 'File' option.
- From the drop down list select 'Logon'.



• The 'Operator Logon' box will appear.



- In the 'Select Your Operator ID' box click on the down arrow on the right hand side and from the list that appears select 'Administrator', which is a fixed 'Operator ID' and cannot be changed.
- There is no password set for the 'Administrator', when the software is first run, so leave the 'Enter Your Password' box blank and click the 'OK' button.
- The Display Measurements screen will be displayed.

Micros	eam Inspectio	on Softwar	e									
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#### 8.3 Setting the Administrator Password

• From the main menu select the 'File' option.

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1       27/04/2004       13:20       1       1       1       NO       310000       1.22000       0.20000       0.19000       2.80500         2       27/04/2004       13:22       1       1       2       NO       310000       1.22000       0.20000       0.19000       2.80500         3       27/04/2004       13:22       1       1       3       NO       310000       1.22000       0.20000       0.19000       2.80500         Average       310000       1.22000       0.20000       0.19000       2.80000       Std.Dev.       0.00000 <t< th=""><th>List</th><th>Index Date</th><th>Time</th><th>Can</th><th>Head</th><th>Cut</th><th>Note</th><th>Approved</th><th>C</th><th>T</th><th>bt</th><th>ct</th><th>W</th><th></th></t<>	List	Index Date	Time	Can	Head	Cut	Note	Approved	C	T	bt	ct	W	
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3       2//04/2004       13:22       1       1       3       NO       310000       1.22000       0.20000       0.19000       2.80000         Average       310000       1.22000       0.20000       0.00000       0.00000       0.00000       0.00000         Std. Dev.       0.00000       0.00000       0.00000       0.00000       0.00000       0.00000         Std. Dev.       0.00000       0.00000       0.00000       0.00000       0.00000       0.00000         Take a Measurement       Number of Measurements       3       3       3       9         Approve       Note       Delete       Print       Graphs       Export	2	27/04/2004	13:21	1	1	2		NO	3.10000	1.22000	0.20000	0.19000	2.80500	
Average         5.1000         0.2000         0.12000         0.20000         0.00000           Std. Dev.         0.00000         0.00000         0.00000         0.00000         0.00000           Std. Dev.         0.00000         0.00000         0.00000         0.00000         0.00000           Std. Dev.         0.00000         0.00000         0.00000         0.00000         0.00000           Take a Measurement         Mumber of Measurements         3         3         3           Approve         Note         Delete         Print         Graphs         Export	3	27/04/2004	13:22	1	1	3		NO	3.10000	1.22000	0.20000	0.19000	2.79000	
Std: Dev.     0.0000     0.0000     0.0000     0.0000       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.     Image: Std: Dev.       Image: Std: Dev.	Ave	Parage							3.10000	1.22000	0.20000	0.19000	2.80000	
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export	Sta	. Dev.							0.00000	0.00000	0.00000	0.0000	0.00707	
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export														
Take a Measurement     3       Approve     Note       Delete     Print       Graphs     Export	<												>	
Approve Note Delete Print Graphs Export		Take a Measurement			Number	of Meas	urements	3						
	-	Approve	Note		D	elete		te di			Print	Graphs	Export	]

- From the drop down list select 'Change Password'.
- The 'Enter a New Password' box appears.



- Enter an alpha numeric password of up to 16 characters and click the 'OK' button. The password can be alpha numeric up to 16 characters and is not case sensitive i.e. PASSWORD, password or Password are all the same.
- The 'Re-type the New Password' box will appear and the password should be entered again.



- Click the 'OK' button.
- A password changed success box appears.

hanged OK

• Click the 'OK' button.

#### 8.4 Configuring the Software

The Administrator should configure the software as follows:-

- Run Microseam and 'Logon' as 'Administrator'.
- From the main menu Select the 'File' option and from the drop down list select 'Configuration'.
- The 'Edit the Program Configuration' box appears:-

Demo Mode NO 🔽	Digital Gauge COM	Port
	Port Number	Disable 🚩
Company Name Your Company Nam	e Baud Rate	4800
Display Date as DD/MM/YYYY ③	Parity	Even 🗸
Display Date as MM/DD/YYYYY O	Data Bits	7 🗸
Microseam COM Port COM1 🛩	Stop Bits	2
Path to Files		

**Demo Mode** – Set to 'YES' for demo mode or 'NO' for normal mode. This should usually be set to 'NO' but it can be set to 'YES' for demo mode where no connection is required to a seam gauge and pseudo-data is generated for display purposes by the software.

**Company Name** – enter name as required to appear on printed output.

**Display Date** – choose date display format from 'DD/MM/YY' or 'MM/DD/YY'.

**Microseam COM Port** - The communications port being used for the visual seam gauge connection can be selected. (See paragraph 10 below).

**Path to Files** – Normally, Microseam stores files in the **C:\mis** directory and in its sub-directories **\datafile**', **\formats**' and **\images**'.

The 'Path to Files' parameter can be used to specify an alternative path, and this can be used in network systems where a shared location is required for the datafiles. Refer to paragraph 9 below.

**Digital Gauge COM Port** - The communications port and other settings being used for the external digital gauge (if any) can be selected and set up. (See paragraph 11 below).

#### 9 Network Installation

It is possible for each PC in a network to share datafiles, format files and image files held on a shared drive. Before carrying out the following procedure, ensure the network is up and running and PC's are connected.

Carry out the following on each networked PC:-

- Install the Microseam software.
- Install the DESkey dongle and drivers.
- Set the 'Administrator' password.
- Run Microseam and 'Logon' as 'Administrator'.
- From the main menu Select the 'File' option and from the drop down list select 'Configuration'.
- The 'Edit the Program Configuration' box appears:-

Edit the Program Configuration		×			
Demo Mode NO 🖌	Digital Gauge COM Port				
	Port Number	Disable 💌			
Company Name Your Company Name	Baud Rate	4800			
Display Date as DD/MM/YYYY 💿	Parity	Even 💌			
Display Date as MM/DD/YYYY 🛛 🔿	Data Bits	7			
Microseam COM Port COM1	Stop Bits	2 👻			
Path to Files n:\misdata					
	ſ	Cancel OK			
	,				

 In the 'Path to Files' box add the following reference to the shared network drive:-

'n:\misdata' - where 'n' is the shared drive letter.

• Click the 'OK button.

Then carry out the following additional steps.

- On the shared network drive, create empty directories as follows:-
  - 'n:\misdata\datafile''n:\misdata\formats''n:\misdata\images' where 'n' is the shared drive.
- From one of the networked PC's, copy files from:-
  - 'C:\mis\datafile' to 'n:\misdata\datafile'
    'C:\mis\formats' to 'n:\misdata\formats'
    'C:\mis\images' to 'n:\misdata\images' where 'n' is the shared drive.
- Restart Microseam.

#### 10 VISUAL SEAM GAUGE CONNECTION

The Microseam software receives dimensional data from a Visual Seam Gauge using a serial communications protocol and will need to be connected to the PC serial port COM1, COM2, COM3 or COM4.

These ports will be 9 pin 'D' type plugs on the rear of the PC.

- Switch off the PC.
- Connect one end of the supplied serial cable to the Seam Gauge.
- Connect the other end to an unused COM port on the PC.
- Switch on the PC.

If the connection is not to COM 1 then re-configure the software as follows:-

- Run Microseam.
- 'Logon' as 'Administrator'.
- From the main menu Select the 'File' option.
- From the drop down list select 'Configuration'.
- The 'Edit the Program Configuration' box appears:-

Demo Mode	NO V	Digital Gauge COM Port		
		Port Number	Disable 💌	
Company Name	Your Company Name	Baud Rate	4800	
Display Date as [	οσιμμηγγγγγ	Parity	Even 💌	
Display Date as N	imiddiyyyyy 🔿	Data Bits	7 👻	
Microseam COM	Port COM1	Stop Bits	2 👻	
Path to Files	COM2			
	COM3 COM4			

- In the box titled 'Microseam COM Port', select the Microseam COM port into which the Visual Seam Gauge connection is made from the selection COM1, COM2, COM3 or COM4.
- Click the 'OK' button.

#### 11 DIGITAL GAUGE CONNECTION

Microseam caters for measurements to be taken using an external Digital Gauge which can be connected to the PC serial port COM1, COM2, COM3 or COM4 using an RS232 (serial) cable which is usually supplied with the gauge.

Carry out the following steps:-

- Switch off the PC.
- Connect one end of the serial cable to the Digital Gauge.
- Connect the other end to an unused COM port on the PC.
- Switch on the PC.
- Run Microseam.
- 'Logon' as 'Administrator'.
- From the main menu Select the 'File' option.
- From the drop down list select 'Configuration'.
- The 'Edit the Program Configuration' box appears:-

Edit the Program Configuration		
Demo Mode NO   Company Name Your Company Name   Display Date as DD/MM/YYYY Image: Company Name   Display Date as MM/DD/YYYY Image: Company Name   Microseam COM Port COM1   Path to Files	Digital Gauge COM Port Port Number Baud Rate Parity Data Bits Stop Bits	COM2 V 4800 V Even V 7 V 2 V
	Ca	ncel OK

- Select the COM port into which the Digital Gauge is connected from the selection COM1, COM2, COM3 or COM4.
- Set COM port parameters to match the Digital Gauge (Baud Rate, Parity, Data Bits, and Stop Bits).
- Click the 'OK' button.

#### 12 SYSTEM BACKUP

Microseam has NO 'built in' automatic data back up function.

#### IMPORTANT

Users are strongly advised to include format, data and image files in their normal routine PC or network backup procedures as applicable.

#### 12.1 Format files

These files have extensions '.fmt' and '.rft' and are stored in the 'formats' subdirectory of the c:\mis directory.

#### 12.2 Datafiles

Data files with filename extensions '.dat' are normally stored in the 'Datafile' subdirectory of the c:\mis directory.

#### 12.3 Image Files

Files associated with images have extensions '.bmp' and '.txt' and are normally stored in the 'c:\mis\images' directory.

#### 12.4 Networked System

If a networked system is in use then datafiles, format files and image files may reside on a shared drive.

#### For example:-

'Datafiles' may be located at 'n:\misdata\datafile'

'Format files' may be located at 'n:\misdata\formats'

'Image files' may be located at 'n:\misdata\images' - where 'n' is the shared drive letter.

#### 13 IMAGE FILES

When a new format is created, it is linked to an image of the seam to provide a visual aid, both when setting the format up and when taking measurements.

Microseam is supplied with a set of standard seam images. Arundle Optical Instruments can supply additional image files at nominal cost to users without image scanning facilities who wish to measure different seam configurations. Alternatively most Office Bureaus will scan images for a small fee.

#### **13.1** Viewing Seam Images in the Library

Images of seams already in the library can be viewed by any operator.

• From the 'Main Menu' select 'Image' and then 'View Images' from the drop down menu.

View Images in I	mage Library	×
Filename	Description	
00000001.BMP 00000002.BMP 00000003.BMP 00000004.BMP 00000005.BMP 00000006.BMP	Ring-Pull Can Ring-Pull Can Rotated Standard Can Standard Can Rotated Triple Seam Triple Seam Rotated	
00000007.BMP 00000008.BMP 00000009.BMP 00000010.BMP 00000011.BMP	200 Can Seam 200 Can Seam Rotated 206 & 202 Can Seam 206 & 202 Can Seam Rot. 206 & 202 Can Seam Rot.	
	Edit Delete	Exit

• The 'View Images in Image Library' box appears.

Both the filename and the more meaningful descriptive name given when they were stored is shown.

- Click on an image file.
- The seam image appears at the top left of the screen.



• Select other images to view or click 'Exit' to return to the main menu.

#### 13.2 Adding Seam Images to the Library

Images of seams for use by Microseam should be scanned in as 256 grayscale Windows bitmaps with aspect ratio ideally of 4:5 for best results.

Microseam will automatically scale the image on the screen, but the quality will depend on the resolution of the scanned image.

When images of seams are added to the library they are automatically allocated a filename by the software. A more meaningful descriptive name can also be added to make recognition easier when the image is used.

This function is restricted to a security level of 'Administrator'.

- Scan the new seam image into the C:\mis\images directory.
- From the 'Main Menu' select 'Image' and then 'Add Image' from the drop down menu.
- A box appears as below, showing the contents of the \images subdirectory If not navigate to C:\mis\images. The new seam image file should be shown.

🐻 Open						
Look in:	鷆 images			🔽 🛛 🖸	t 📂 🖽 •	•
Recent Places Desktop Phil Haynes	Name Name 00000014. 00000015. 00000016. 00000017. 00000019. 00000019. 00000020. 00000021. 00000022. 00000022.	Date taken DIVIP BMP BMP BMP BMP BMP BMP BMP BMP BMP	Tags	Size	Rating	
Computer Vetwork	00000023.     00000024.     00000024.     00000024.     000000024.     000000024.     000000024.     000000024.     0000000024.     0000000024.     000000000024.     00000000024.     00000000024.     00000000024.     00000000024.     00000000024.     00000000024.     00000000024.     00000000024.     0000000024.     00000000024.     00000000024.     00000000000024.     00000000024.     000000000000000000000000000000000	BMP NNED IMAGE.BI NEW SCANI Bitmap Files	MP NED IMAGE.B (*.bmp) sad-only	MP	~	Qpen Cancel

- If the file has not been scanned into the \images sub-directory then use the 'Look in' box to locate the folder containing the scanned file by clicking on the down arrow on the right.
- Select the file containing the new scanned image and click the 'Open' button.
- Microseam displays the selected image on the screen together with a confirmation box.



- Click the 'Yes' button to proceed (or 'No' to abort).
- A dialogue box appears. Enter a descriptive name to help identify the image in the future and click the 'OK' button. (or 'Cancel' to abort).



• A successful completion box appears, click the 'OK' button.



• The 'Open' dialogue box re-appears showing the added image file which in this case is 00000025.BMP.

📴 Open						
Look in:	🌗 images			<b>v</b> 0	1 🖻 🛄 -	6
Recent Places	Name A	Date taken Divip BMP	Tags	Size	Rating	
Desktop	<pre>     00000017.     00000018.     00000018.     00000019. </pre>	BMP BMP BMP				
Dhil Haynes	<pre>     00000020.     00000021.     00000022. </pre>	BMP BMP BMP				
Computer	<pre>     00000023.     00000024.     00000024.     00000025. </pre>	BMP BMP BMP				
	NEW SCA	NNED IMAGE.B	MP			~
Network	File <u>n</u> ame:	00000025.B	MP		~	<u>Open</u>
	Files of type:	Bitmap Files	(*.bmp) ead-only		¥	Cancel

- The original file which was scanned in can now be deleted by right clicking on it and selecting 'Delete' from the list of options.
- Further images may be added as above or click the 'Cancel' button to return to the Display Measurements screen.

#### 13.3 Editing/Deleting Seam Images in the Library

Images of seams in the library can be edited (description modified) or deleted as follows:-

This function is restricted to a security level of 'Administrator'.

- From the 'Main Menu' select 'Image' and then 'Edit Images' from the drop down menu.
- The 'View and Edit Images in Image Library' box appears.

Vi	ew and Edit In	nages in Image Library	
	Filename	Description	
	00000001.BMP 00000002.BMP 00000003.BMP 00000004.BMP	Ring-Pull Can Ring-Pull Can Rotated Standard Can Standard Can Rotated	~
	00000005.BMP 00000006.BMP 00000007.BMP 00000008.BMP 00000009.BMP 00000009.BMP	Triple Seam Rotated 200 Can Seam 200 Can Seam 200 Can Seam Rotated 206 & 202 Can Seam 206 & 202 Can Seam Rot.	
1	_00000011 BMP_	Edit Delete	Exit

Both the filename and the more meaningful descriptive name given when they were stored is shown.

- Click on an image.
- The image appears at the top left of the screen.

🗟 Microseam Insp	ection So	ftware				E ×
Eile Measurement	Format	Image	Help	Print	Administrator is logged on	
Display Images						
5					View and Edit Images in Image Library       Image         Flename       Description         00000002 BMP       Standard Can         00000003 BMP       Standard Can         00000005 BMP       Standard Can         00000005 BMP       Standard Can         00000005 BMP       Trajle Seam         00000005 BMP       Trajle Seam         00000005 BMP       Trajle Seam         00000005 BMP       200 Can Seam Rotated         00000005 BMP       200 Can Seam Rot         00000001 BMP       206 & 202 Can Seam Rot         00000001 BMP       206 & 202 Can Seam Rot         0000001 BMP       206 Kan Seam Rot	

#### 13.3.1 Delete an Image

- To 'Delete' the selected image click the 'Delete' button.
- A confirmation box appears click the 'Yes' button.



 The 'View and Edit Images in Image Library' box re-appears with the deleted item missing.
 Either select another image file to delete or click the 'Exit' button to return

#### 13.3.2 Edit an Image Description

to the main menu.

• To 'Edit' an Image Description, select the file and click the 'Edit' button.

• The 'Enter Image Description' box appears containing the current description.



• Amend the description as required.

Enter Image Description	. 🛛 🕅
Enter a short description	Ring-Pull Can 220ml
	Cancel OK

- Click the 'OK' button. (or Cancel).
- The 'View and Edit Images in Image Library' box re-appears showing the modified description.

Filename	Description	
00000001.BMP	Ring-Pull Can 220ml	^
00000002.BMP	Ring-Pull Can Rotated	
00000003.BMP	Standard Can	
00000004.BMP	Standard Can Rotated	
00000005.BMP	Triple Seam	_
00000006.BMP	Triple Seam Rotated	
00000007.BMP	200 Can Seam	
00000008.BMP	200 Can Seam Rotated	
00000009.BMP	206 & 202 Can Seam	
00000010.BMP	206 & 202 Can Seam Rot.	1272
00000011 RMP	206 % 202 Can Seam Bot	<u>×</u>

• Either select another image file to edit or click the 'Exit' button to return to the main menu.

#### 14 FORMAT FILES

A measuring format describes the measurements to be taken on a can to obtain the required dimensions. It includes information such as the images to use, whether a rotated image is included, the names of the dimensions, the way in which the dimensions are to be calculated and the tolerances etc.

Format files are held in a library (normally C:\mis\formats) and may be used with one or more datafiles.

When a new format is created it is automatically given a filename by the system. As this name is not meaningful a more descriptive name should also be given to identify the format in future.

#### **14.1** Viewing Formats in the Library

Any operator can view formats in the library.

- From the 'Main Menu' select 'Format' and then 'View Formats' from the drop down menu.
- The 'Select a Format' box appears with the filename and the more meaningful description given when the format was stored.

Filename	Description	
00000001.FMT	202 bev	~
00000002.FMT	211 bev can	100
00000003.FMT	301 CAN	
00000004.FMT	307 CAN	
00000005.FMT	401 CAN	
00000006.FMT	603 CAN	3
00000007.FMT	1st op. 200ml	
00000008.FMT	1st op. 340ml	
00000009.FMT	1st op. 450ml	
00000010 FMT	1ston 500ml	
dit		

• Click on a Format file. The associated image appears on the screen.



• Press Exit to return to the main menu.

#### 14.2 Creating a New Format

A new format may need to be created or an existing one edited if, for example, a different style of can was introduced for which different dimensions need to be taken or different tolerances applied.

A Format File may contain either a Normal Image or a Normal and Rotated Image but note that Rotated Images are only applicable if the seam gauge used supports this feature.

This function is restricted to a security level of 'Administrator'.

- From the 'Main Menu' select 'Format' and then 'Create New Format' from the drop down menu.
- A confirmation box appears asking 'Will this measuring format include a rotated image?'

Microseam Inspection Software	
Will this measuring format include a rotated image?	
Yes No	

• Depending on the answer chosen above, follow either the 'Normal and Rotated Image' procedure or 'Normal Image' procedure described below.

#### 14.2.1 Normal and Rotated Image

• The 'Select Normal Image to be used in Format' box appears.

Filename	Description	
00000001.BMP	Ring-Pull Can 220ml	~
00000002.BMP	Ring-Pull Can Rotated	100
00000003.BMP	Standard Can	
00000004.BMP	Standard Can Rotated	
00000005.BMP	Triple Seam	
00000006.BMP	Triple Seam Rotated	
00000007.BMP	200 Can Seam	
00000008.BMP	200 Can Seam Rotated	
00000009.BMP	206 & 202 Can Seam	
00000010.BMP	206 & 202 Can Seam Rot.	1272
00000011 BMP	206 % 202 Can Seam Bot	~

- Click on a Normal Image file.
- The seam image appears at the top left of the screen.

Microseam Inspection Software				
Eile Measurement Format Image	elp <u>P</u> rint Administra	itor is logged on		
Display Images				
	Select Normal Fiename 0000002 EM 00000005 EM 0000005 BM 0000005 BM 0000005 BM 0000005 BM 0000005 BM	Image to be used in Form Description Pring-Puil Can Rotated Standard Can Standard Can Rotated Triple Seam Rotated 200 Can Seam 200 Can Seam 200 Can Seam Rotated 206 & 202 Can Seam Rot 206 & 202 Can Seam Rot 206 & 202 Can Seam Rot Edit Cancel	at X	

- Select the required image and click the 'OK' button.
- The 'Select Rotated Image to be used in Format' box appears.

Filename	Description	
00000001.BMP	Ring-Pull Can 220ml	~
00000002.BMP	Ring-Pull Can Rotated	100
00000003.BMP	Standard Can	
00000004.BMP	Standard Can Rotated	
00000005.BMP	Triple Seam	_
00000006.BMP	Triple Seam Rotated	
00000007.BMP	200 Can Seam	
00000008.BMP	200 Can Seam Rotated	
00000009.BMP	206 & 202 Can Seam	
00000010.BMP	206 & 202 Can Seam Rot.	12524
0000011 BMP	206 & 202 Can Seam Bot	~

- Click on a Rotated Image file.
- The rotated seam image appears on the screen in addition to the previous image.



- Select the required image and click the 'OK' button.
- The 'Enter the Format Parameters' box appears.

Enter the Format Parameters	
Description of format	
Number of closing heads	
Number of cuts per can	
Normal	
Number of measurement points	
Number of dimensions	
Rotated	
Number of measurement points	
Number of dimensions	
	Cancel OK

**Description of format** - Enter a name for the format. The characters can be alpha/numeric and the number of characters will depend on what will fit the box, but will average about 15 characters.

Number of closing heads – Enter a number from 1 to 100.

Number of cuts per can – Enter a number from 1 to 100.

**Number of measurement points** – Enter a number from 2 to 20 for the Normal and Rotated image.

**Number of dimensions** – Enter a number from 1 to 100 for the Normal and Rotated image.

• The completed 'Edit the Format Parameters' box will look similar to the example shown below.

Enter the Format Parameter	s 🔀
Description of format	RING PULL
Number of closing heads	2
Number of cuts per can	2
Normal	
Number of measurement points	5
Number of dimensions	3
Rotated	
Number of measurement points	2
Number of dimensions	1
	Cancel OK
- Click the 'OK' button to continue.
- The screen displays the library image of the normal seam image with numbered vertical cursors indicating the measurement positions. The cursor lines are numbered and represent the point on the seam image at which a measurement should be made and in the order in which they are made.

The 'Edit the Format Dimensions' box is also displayed ready to enter the name of the can dimensions to be measured with the tolerances and the measurements from which the dimensions are obtained.

🗟 Microseam II	Inspection Software	
Eile Measurem	nent Format Image Help Print Administrator is logged on	
Display Image	es	
1		
	Edit the Format Dimensions         Name of       Type of       Reading       Reading       Reading       Lower       Upper         Dimension       Measurement       A       B       C       D       Tolerance       Tolerance         Dimension 1       Undefined       Undefined       Undefined       Undefined       Undefined	
	Prev Next Left Right Delete Edit New Cancel OK	

• The position of each cursor can be adjusted onto a desired measurement point by clicking the **Previous** or **Next** button in the 'Edit the Format Dimensions' box to select the cursor (Active cursor is red) and the **Left** or **Right** button to position the cursor in a suitable position. This is shown completed below:-



- Select one of the dimensions in the list and click the Edit button.
- The 'Edit a Dimension' box appears.

Name of Dimension Dimension 1	Type of Measurement	Reading A	Reading B	Reading C	Reading D	Lower Tolerance	Upper Toleranc
Other							

- Enter a meaningful name for the dimension being measured in the 'Name of Dimension' box.
- In the 'Type of Measurement' box use the drop down list to select between:-

**'Undefined'** – Initial state if no other choice is made.

'**Difference'** – The difference between readings A and B, i.e., (A - B) '**Keyboard'** – A value entered on the keyboard, e.g., the body wall thickness

'**Digital Gauge'** – Value read from a digital gauge connected to an RS232 port.

**'Percentage'** – The ratio of two differences expressed as a percentage, i.e., 100 x (A - B) / (C - D)

'**Other'** – A user defined item which allows the user to create a specific calculation by entering a formula in the 'Other' box.

The formula may use the following operators:-

Addition	+
subtraction	-
multiplication	*
and division	/

Constants may also be entered as well as brackets () to force the order of calculation.

The names of dimensions may also be used in a formula and should be entered in quotes as shown in the following examples.

Note the blank spaces used to help make the expression more readable and the use of brackets to force the order of calculation.

# Using named dimensions:

The formula for percentage overlap becomes:

( ("body hook length" + "end hook length" + (1.1 \* "end component thickness") - "seam length" ) / ("seam length" - (2.2 \* "end component thickness") - (1.1 \* "body wall thickness") ) ) \* 100

Where "body hook length", "end hook length", "end component thickness", "seam length", and "body wall thickness" are named dimensions.

# Using a combination of named dimensions and readings from the seam gauge:

The formula for overlap becomes:

(M4-M2) + (M3-M1) + (1.1 \* "end component thickness") - (M5-M1)

Where M1 is the reading at measurement position 1, M2 is the reading at measurement position 2, etc. and "end component thickness" is a named dimension.

Note:- Named dimensions or readings from the normal image cannot be combined with named dimensions or measurements from the rotated image in a formula. • Depending on the type of measurement selected, some of the boxes will be 'grayed out'.

easurement	A	B	C	D	Tolerance	Upper Tolerance
ifference	✓ 5	1			2.97	3.23
i	fference	fference 💽 5	fference S	fference V 5 1	fference V 5 1	Image: Second and the second

- Once the dimension has been defined as in the above example, click the 'OK' button to continue.
- Follow the same procedure to define the other dimensions.
- The resulting 'Edit the Format Dimensions' box should look similar to the following example.

Vame of Dimension	Type of Measurement	Reading A	Reading B	Reading C	Reading D	Lower Tolerance	Upper Tolerance	
Seam Length	Difference	5	1			2.97000	3.23000	
Body Hook Lth	Difference	4	2			1.83000	2.23000	
End Hook Lth	Difference	3	1			1.83000	2.23000	

- If not satisfied, click on a dimension and then click 'Edit' to make changes, otherwise click the 'OK' button.
- A dialogue box will ask if the new format should be saved. Click the 'Yes' button.



 A box appears stating that the normal image format has been saved and that the format for the rotated image can now be defined. Click the 'OK' button.



• The following screen appears containing the rotated image and the 'Edit the Format Parameters' box.

🗟 Mi	roseam Inspection Software	_ B 🗙
Eile Eile	Measurement Format Image Help Print Administrator is logged on	
Dis	ay Images	
	Edit the Format Dimensions	
	Name of Type of Reading Reading Reading Lower Upper Dimension Measurement A B C D Tolerance Tolerance	
	Dimension 1 Undefined	
	Prov. New Left Binkt Delete Edit New Cancel OK	
	1 2	
	DAI DAI	
	33 11	
	T In the second s	
		1
		4

- Use the procedures described above to move cursors and to complete the 'Edit the Format Dimensions' box.
- When satisfied, click the 'OK' button in the 'Edit the Format Dimensions' box.
- A dialogue box will ask if the new format should be saved. Click the 'Yes' button.



 A box appears stating that the new format for the rotated image has been saved to a file.



• Click the 'OK' button to return to the Display Measurements screen.

## 14.2.2 Normal Image

The procedure for creating a new format containing only a normal image is very similar to that described above in paragraph 14.2.1 above for a format containing both a normal and rotated image.

In general, ignore any references to the rotated image and note that some screens and information boxes are slightly different.

The 'Enter the Format Parameters' box is different with no reference to rotated image. Example below:-

Enter the Format Parameters	s 🚺
Description of format	RINGPULL 2
Number of measurement points	5
Number of dimensions	3
Number of cuts per can	2
Number of closing heads	2
	Cancel OK

The box indicating successful saving of the file is slightly different making no reference to continuing with the rotated image.



# 14.3 Editing an Existing Format

Existing formats can be edited or a copy can be made of an existing format on which to base a new format. After selecting a format to edit, the procedures and screens are identical or very similar to those described in 'Creating a New Format' in paragraph 14.2 above.

This function is restricted to a security level of 'Administrator'.

• From the 'Main Menu' select 'Format' and then 'Edit Formats' from the drop down menu. The 'Select a Format' box appears.

r ilonanio	Description	
00000011.FMT	206/211 200ml	~
00000012.FMT	206/211 340ml	
00000013.FMT	206/211 450ml	
00000014.FMT	206/211 500ml	
00000015.FMT	USC bottom	
00000016.FMT	USC top	178
00000017.FMT	200 mini seam	
00000018.FMT	RING PULL	3
00000019.FMT	RINGPULL 2	
Hit		

- Click on a format file.
- The seam image linked to the format appears on the screen and also the rotated image, if the format uses one.



- Select the required format from the list.
- Click on one of the buttons at the bottom of the 'Select a Format' box.

**'Values'** button - Displays the 'Enter the Format Parameters' box allowing settings to be modified.

**'Normal'** button - Adjusts positions of the cursors and to access the 'Edit the Format Dimensions' box for the normal image.

**'Rotated'** button - Adjusts positions of the cursors and to access the 'Edit the Format Dimensions' box for the Rotated image.

**'Copy'** button - To make a copy of the current format to a new file which can then be edited to create a new format.

**'Delete'** button - To delete the highlighted format in the list. There is a Yes/No box to prevent unintentional deletion.

'Exit' button - Click to return to the main screen once editing is completed.

## 15 DATAFILES

Datafiles are created, edited and selected to take measurements from the Display Measurements screen.

The Display Measurements screen can be reached by any operator from the main menu by selecting 'Measurement' and then selecting 'Display' from the drop down list.

B Microseam Inspection Software Eile Measurement Format Image Help Print Administrator is logged on **Display Measurements** Format Parameters Cuts per Can **Display Parameters** Closing Heads Description Edit Format Datafile Parameters Edit Datafile Filename New Datafile Select Datafile Select Head Select Date List Index Date Time Head Cut Note Approved C т bt ct W Can 27/04/2004 13:20 NO 3.10000 1.22000 0.20000 0.19000 2.80500 1 1 3,10000 1.22000 0.20000 0.19000 2.80500 27/04/2004 13:21 NO 2 2 1 1 3 27/04/2004 13:22 1 1 3 NO 3,10000 1.22000 0.20000 0.19000 2,79000 Average 3.10000 1,22000 0.20000 0.19000 2.80000 Std. Dev 0.00000 0.00000 0.00000 0.00000 0.00707 > Number of Measurements Take a Measurement Approve Note Delete Print Graphs Export

An example screen is shown below, with some measurements taken:-

Before measurements can be made, the correct datafile containing the correct format and images for the can to be measured must be selected (See paragraph 15.4 below.

## 15.1 Parts of the Screen

The Display Measurements screen has three main areas, 'Format Parameters', 'Datafile Parameters' and 'Data Table'.

#### **15.1.1 Format Parameters**

This area, at the top of the screen, displays brief information about the format to be used to take the measurements.

The following information is displayed:-

**'Description'** - Descriptive name for the format.

'Cuts per Can' - The number of cuts per can to be measured.

'Closing Heads' - The number of closing heads on the machine.

There are also two 'Buttons':-

**'Display Parameters'** - Displays an information box showing Format Parameters as per the following example:-

m Inspection Software		
The format parameters are	as follows:	
Description	202 bev	/
Cuts per can	3	201
Number of heads	6	
Normal Image		
Number of dimensions		11
Number of measurement	points	7
Rotated Image		
Number of dimensions		N/A
Number of measurement	points	N/A
	(T)	
	L	UK
	m Inspection Software The format parameters are Description Cuts per can Number of heads Normal Image Number of dimensions Number of measurement p Rotated Image Number of dimensions Number of measurement p	m Inspection Software The format parameters are as follows: Description 202 bev Cuts per can 3 Number of heads 6 Normal Image Number of dimensions Number of measurement points Rotated Image Number of dimensions Number of measurement points

**'Edit Format'** - . The 'Edit Format' button is only available to 'Administrators' and allows editing of the format.

# **15.1.2 Datafile Parameters**

This area of the screen displays brief information about the datafile to be used to take the measurements.

The datafile parameters define the closing machine to which the measurements relate, the product in the can, the units of measurement and the descriptive name of the datafile.

The following information is displayed:-

'Description' - Descriptive name for the datafile.

'Filename' - Computer generated filename e.g. 00000018.DAT

'Machine' - The identity of the closing machine used.

'**Product**' - The product in the can.

'Units' - The unit of measurement.

There are also three 'Buttons':-

'**Select Datafile**' - Allows selection of a datafile from a list of all files available.

'Edit Datafile' - Allows editing of a datafile (Admin only).

**'New Datafile'** - Allows creation of a new datafile into which measurements can be written (Admin only).

#### 15.1.3 Data Table

The Data Table shows the can dimensions etc. as defined in the format file, and the date and time at which the measurements were made.

If a note has been added to the data, this will be displayed (in a truncated form) in the 'Note' column. A 'Note' is generated automatically by the system when a measured dimension is out of tolerance. An operator can add to an existing note or create a new one but a note can not be deleted.

Approved data is indicated by a 'YES' in the 'Approved' column.

If there are more dimensions than can be fitted into the width of the table, the scroll bar can be used to shift left or right.

There are also two buttons above the Data Table:-

**'Select Head**' – Click here to select for which 'Head Number' measurements are displayed. Select a Head Number or All. The default is 'All' and the current selection is displayed in the adjacent box

'Select Date' - Click here to select for which 'Dates' measurements are displayed. The 'Select measurement dates' box appears allowing either 'All' Days, 'Particular Day' or 'Range of Days' to be selected. The default is 'All' and the current selection is displayed in the adjacent box.

There are eight 'Buttons' below the Data Table:-

**'Take a Measurement**' – Enables measurements to be made by any operator and recorded in the table (Described in detail in paragraph 15.5 below).

'**Approve**' - Allows the Administrator/Supervisor to approve a selected measurement. This will change a 'No' in the 'Approved' column to 'Yes'.

Microseam Inspection		Microseam Inspection Software
1 measuremen	will now be	1 measurement has been selected from the list and v
approved. Do y	on?	approved. Do you wish to proceed with this operation

**'Note'** - Allows any operator to view and create notes . (Described in detail in paragraph 15.7 below).

**'Delete'** - Allows the Administrator/Supervisor to delete a selected measurement. (Described in detail in paragraph 15.8 below).

**'Print'** - Allows any operator to print selected dimensional data in a report (Described in detail in paragraph 15.9 below).

'**Graphs**' - Allows any operator to produce a graph of selected dimensions which can be subsequently printed (Described in detail in paragraph 15.10 below).

**'Export**' - Allows any operator to export selected data to a text file to be read by other database software (Described in detail in paragraph 15.11 below).

# **15.2 Create a New Datafile**

A new datafile can be created from scratch or by copying an existing datafile and editing it to suit. A security level of Administrator is required to perform this function.

- From the main menu select 'Measurement' and from the drop down list select 'Display'.
- If not already logged on the 'Operator Logon' box will appear. Logon as 'Administrator'.
- Microseam Inspection Software Administrator is logged on Eile Measurement Format Image Help Print **Display Measurements** Format Parameters Cuts per Can **Display Parameters** Description Closing Heads Edit Format Datafile Parameters Description 202 BEV CAN Mach Units Edit Datafile UNKNOWN Filename Product Select Datafile New Datafile Select Head Select Date List Index Date Time Can Head Cut Note Approved C Т bt ct w 27/04/2004 3.10000 1.22000 0.20000 0.19000 2.80500 13:20 NO 1 1 1 1 NO 0.19000 2 27/04/2004 13:21 1 1 2 3.10000 1.22000 0.20000 2.80500 3 27/04/2004 13:22 1 3 NO 3.10000 1.22000 0.20000 0.19000 2,79000 1 Average 3.10000 1.22000 0.20000 0.19000 2.80000 Std. Dev 0.00000 0.00000 0.00000 0.00000 0.00707 < > Number of Measurements Take a Measurement Approve Note Delete Print Graphs Export
- The Display Measurements screen appears as shown below:-

- Click on the 'New Datafile' button located on the right of the 'Datafile Parameters' area of the screen.
- The 'Create New Datafile' box appears with text within the box explaining the options available.

Create New Datafile	
You have three options for creating a datafile which a follows:- (1) Use the Cancel button to go back to the measurements dialogue box. (2) Use the New button a new datafile with new parameters. (3) Use the Copy copy the datafile parameters from an existing datafile case a new datafile will be created which has the sar parameters as the existing datafile but will contain no measurements initially.	are as to create Jutton to in which me
Cancel New Copy	

- a. Use the 'Cancel' button to go back to the 'Display Measurements' screen.
- b. Use the 'New' button to create a new datafile with new parameters.
- c. Use the 'Copy' button to copy the datafile parameters from an existing datafile in which case a new datafile will be created which has the same parameters as the existing datafile but will contain no measurements initially.
- Click the 'New' button.
- The 'Enter the Parameters of the New Datafile' box appears.

Enter the Parame	ters of the New Datafile	X
Description		
Machine		
Product Units		
	Cancel	ок

Complete the box with the following information:-

**'Description**' – Descriptive name for the datafile.

'Machine' – The identity of the closing machine used.

'**Product**' – The product in the can.

'Units' - .The unit of measurement, choose between 'Inches' or 'Metric'.

• The completed box should look something like the following:-

Description	RINGPULL3
Machine	E67
Product	TANGO
Units	Metric 🔽

• When satisfied click the 'OK' button. The 'Select a Format' box appears:-

Se	lect a Format		
	Filename	Description	
	00000011.FMT 00000012.FMT 00000013.FMT 00000014.FMT 00000015.FMT 00000016.FMT 00000016.FMT	206/211 200ml 206/211 340ml 206/211 450ml 206/211 500ml USC bottom USC top 200 cimi secon	
	00000017.FMT 00000018.FMT 00000019.FMT	RING PULL RINGPULL 2	×
E	dit Values Normal	Rotated Copy Cancel	OK

- Click on a format file.
- The images associated with the format are displayed in addition to the 'Select a Format' box.

Microseam Inspection Software		- Ē 🞽
<u>File Measurement Format Image Help Print</u>	Administrator is logged on	
Display Images		
	Select a Format	
	Filename Description	
	00000010 FMT         1 st op. 500ml           00000011 FMT         206/211 200ml           00000012 FMT         206/211 340ml           00000013 FMT         206/211 450ml           00000014 FMT         206/211 500ml           00000015 FMT         206/211 500ml           00000015 FMT         206/211 500ml           00000015 FMT         USC bottom           00000016 FMT         USC top           00000017 FMT         200 mini seam           00000018 FMT         FING FULL	
	Edit	
	Values Normal Rotated Copy	Cancel OK
	-	

• When satisfied, Click the 'OK' button. A confirmation box appears:-



• Click the 'Yes' button. The Display Measurements screen re-appears showing the new datafile ready for taking measurements.

Measurement	Format	Image	Help	Print			Administrat	tor is loone	ed on				
lav Measurem	ionts	Sunde	Teb	Chine			Administration of	tor is logge					
nay measurem	ento												
mat Parameters							Cuts per Can		2			Die	rolau Parameters
	Louis of	SUL C											spiagraianecers
scription	HINGE	YULL					Closing Heads		2				Edit Format
atafile Parameters	Dision	111.5					1				No.		
escription	nivar	OLLS			м	lachine	l	Eor		Units	Medic		Edit Datafile
lename	000000	18.DAT			Pr	roduct		TANGO			Select Datafile		New Datafile
Select Head	All	1		Select Da	ite	All							
	171	1		100.05 0010						B. J. H. J. M.		D' '	1 0 1
ist index Date	110				c .	1		100000000	and the second se				
		ie	Can	Head	Cut	Note	Ap Ther	pproved re are no it	Seam Length	Body Hook Ltn	End Hook Lth	Dimension	operator
		10	Can	Head	Cut	Note	AF	pproved re are no it	Seam Length	BOOY HOOK LT	End Hook Lth	Dimension	Operator
C			Can	Head	Cut	Note	AF	pproved re are no it	Seam Length	BOOY HOOK LTD	End Hook Lth	Dimension	
C Take a Measureme	ont			Number c	f Measu	Note	0	pproved re are no it	Seam Length	BOOY HOOK LTD	End Hook Lth	Dimension	

# **15.3 Editing an Existing Datafile**

An existing datafile can be edited if required.

This function is restricted to a security level of 'Administrator'.

• From the main menu select 'Measurement' and from the drop down list select 'Display'.

• If not already logged on the 'Operator Logon' box will appear. Logon as 'Administrator'.

Micro	oseam Inspect	tion Softwar	е										B
Eile [	<u>M</u> easurement F	- <u>o</u> rmat <u>I</u> mag	e <u>H</u> elp	<u>Print</u>			Administrator is lo	ogged on					
Displa	y Measureme	nts											
Formati	Parameters						Cuts per Can	3				isplay Parameters	
Descripti	ion	202 bev					Closing Heads	6				Edit Format	
Datafile Descripti	Parameters ion	202 BEV CAN	3		1	Aachine	UNKNO	3WN -	Units	Metric		Edit Datafile	
Filename	r	00000001.DAT			F	Product	UNKNO	DWN.		Select Datafi	ile 🗌	New Datafile	
Se	lect Head	All		Select [	Date	All							
List In	dex Date	Time	Can	Head	Cut	Note	Approv	ed C	T	bt	ct	W	
1	27/04/2004	13:20	1	1	1		NO	3.10000	1.22000	0.20000	0.19000	2.80500	
2	27/04/2004	13:21	1	1	2		NO	3.10000	1.22000	0.20000	0.19000	2.80500	
3	27/04/2004	13:22	1	1	3		NO	3.10000	1.22000	0.20000	0.19000	2.79000	
Averag	je							3.10000	1.22000	0.20000	0.19000	2.80000	
. <b>&lt;</b>	ake a Measuremen	:		Number	r of Mea:	surements	3	]					×
-	Approve	Note		D	elete					Print	Graphs	Export	

• The Display Measurements screen appears:-

Microseam automatically displays the data from the last used datafile so measurement data may or may not be present.

- Click on the 'Edit Datafile' button located on the right of the 'Datafile Parameters' area of the screen.
- The 'Select a Datafile' box appears which has the options of Editing or Deleting a Datafile or to 'Exit' with no change.

Filename	Description
00000009.DAT	450ml 206/211
00000010.DAT	500ml 206/211
00000011.DAT	1st. Op. 200ml
00000012.DAT	1st. Op. 340ml
00000013.DAT	1st. Op. 450ml
00000014.DAT	1st. Op. 500ml
00000015.DAT	USC bottom
00000016.DAT	USC top
00000017.DAT	200 mini seam
00000018.DAT	RINGPULL3
	<u> </u>

• Click on a Datafile and click the 'Edit' button.

• The 'Edit the Parameters of a Datafile' box appears.

Description	RINGPULL3	
Machine	E67	
Product	TANGO	
Units	Metric 🔽	

• Make required changes to the following information:-

'**Description**' – Descriptive name for the datafile.

'Machine' – The identity of the closing machine used.

'**Product**' – The product in the can.

'Units' - .The unit of measurement, choose between 'Inches' or 'Metric'.

• The completed box should look something like the following, with a changed Product:-

Description	RINGPULL3
Machine	E67
Product	COLA
Units	Metric 💌

- If satisfied Click the 'OK' button.
- The 'Select a Datafile' box re-appears.

Filename	Description
00000009.DAT	450ml 206/211
00000010.DAT	500ml 206/211
00000011.DAT	1st. Op. 200ml
00000012.DAT	1st. Op. 340ml
00000013.DAT	1st. Op. 450ml
00000014.DAT	1st. Op. 500ml
00000015.DAT	USC bottom
00000016.DAT	USC top
00000017.DAT	200 mini seam
00000018.DAT	RINGPULL3
	×

- Unless there are further Datafiles requiring editing or deleting, click the 'Exit' button.
- The Display Measurements screen re-appears.

# 15.4 Selecting a Datafile

Any operator can select and view a datafile:-

- From the main menu select 'Measurement' and from the drop down list select 'Display'.
- If not already logged on, the 'Operator Logon' box will appear and will need to be completed.
- The 'Display Measurements' screen appears as shown in the example screen-shot below:-

e M_	easurement	Format Ir	mage <u>H</u> elp	e <u>P</u> rint		A	Administrator is logge	d on				
play	Measurem	ents										
ormat P	arameters							6				
						Cuts	s per Can				Di	splay Parameters
scriptic	n	202 bev				Clos	sing Heads	6				Edit Format
Jatafile F	arameters			-						4		
escriptic	n	202 BEV 0	DAN		N	lachine	UNKNOWN		Units	Metric		Edit Datafile
lename		00000001.1	DAT		F	roduct	UNKNOVN	J		Select Datafil		New Datafile
										<u></u>		
Sele	ot Head	All		Select [	Date	All						
ist Ind	ex Date	Time	Can	Head	Cut	Note	Approved	C	T	bt	ct	W
_	27/04/200	4 13:20	1	1	1		NO	3.10000	1.22000	0.20000	0.19000	2.80500
	27/04/200	4 13:21	1	1	2		NO	3.10000	1.22000	0.20000	0.19000	2.80500
	27/04/200	4 13:22	1	1	3		NO	3.10000	1.22000	0.20000	0.19000	2.79000
verage	2							3.10000	1.22000	0.20000	0.19000	2.80000
td. De	ι.							0.00000	0.00000	0.00000	0.00000	0.00707

Microseam automatically displays the data from the last used datafile so measurement data may or may not be present.

- Click on the 'Select Datafile' button located towards the right of the 'Datafile Parameters' area of the screen.
- The 'Select a Datafile' box appears.

Filename	Description	
00000001.DAT	202 BEV CAN	1
00000002.DAT	211 BEV CAN	
00000003.DAT	301 CAN	
00000004.DAT	307 CAN	
00000005.DAT	401 CAN	
00000006.DAT	603 CAN	
00000007.DAT	200ml 206/211	
00000008.DAT	340ml 206/211	
00000009.DAT	450ml 206/211	
00000010.DAT	500ml 206/211	120
00000011 DAT	1st On 200ml	

• Scroll as necessary and select the Datafile.

Filename	Description
00000001.DAT	202 BEV CAN
00000002.DAT	211 BEV CAN
00000003.DAT	301 CAN
00000004.DAT	307 CAN
00000005.DAT	401 CAN
00000006.DAT	603 CAN
00000007.DAT	200ml 206/211
00000008.DAT	340ml 206/211
00000009.DAT	450ml 206/211
00000010.DAT	500ml 206/211
00000011 DAT	1 et On 200ml 🛛 🖄

• Click on the 'OK' button and the selected Datafile will be displayed as shown below.

Micros	eam Inspec	tion Sol	ftware										
ile <u>M</u> e	easurement	F <u>o</u> rmat	Image	Help	Print			Administrator is logge	d on				
splay	Measureme	ents											
ormat Pa	rameters												
								Cuts per Can	3				lisplay Parameters
scriptior	i	211 bev	can					Closing Heads	6				Edit Format
									L				
itafile Pa	arameters	211 BEV	CAN		-	N	lachina	[UNKNOVN		Unite	Metric	1 -	Edit During
senption							laoinne				1		Edit Datanie
iname		000000	02.DAT			F	roduct	UNKNOWN			Select Datafile		New Datafile
				_									
Seler	t Head	All			Select E	)ate	All						
st Inde	ex Date	Tin	ne	Can	Head	Cut	Note	Approved	C	т	w	bt	ct
	27/04/200	4 13:3	30	1	1	1	. Providence	NO	3.10000	1.22000	2.80500	0.20000	0.19000
	27/04/200	4 13:3	31	1	1	2		NO	3.10000	1.22000	2.80500	0.20000	0.19000
	27/04/200	4 13:3	32	1	1	3		NO	3.10000	1.22000	2.81500	0.20000	0.19000
erage									3.10000	1.22000	2.80833	0.20000	0.19000
l. Dev									0.00000	0.00000	0.00471	0.00000	0.00000
									- i				8
Tak	e a Measuremer	nt			Number	of Meas	urements	3					

## **15.5 Taking Measurements**

The main display for the measurements made on a can or series of cans is the Display Measurements screen which is also used for taking measurements on a can.

A User can take measurements.

A Supervisor can take measurements and delete or approve data.

The Administrator can perform all functions.

- From the main menu select 'Measurement' and from the drop down list select 'Display'.
- If not already logged on the 'Operator Logon' box will appear. Logon as required.
- Microseam Inspection Software Eile Measurement Format Image Help Print Administrator is logged on **Display Measurements** Format Parameters Cuts per Can **Display Parameters** Edit Format Description **Closing Heads** Datafile Parameters RINGPULLS Description Units Edit Datafile Filename Produci Select Datafile New Datafile Select Head Select Date List Index Date Time Head Cut Body Hook Lth End Hook Lth Can Note Approved Seam Length Dimension 1 Operator There are no items to show Number of Measurements Take a Measurement Print Graphs Approve Note Delete Export
- The Display Measurements screen appears as shown below:-

Microseam automatically displays the data from the last used datafile so measurement data may or may not be present. In the above example no measurement data is present as indicated by the 'There are no items to show' text.

• If the datafile displayed in not the one needed to take measurements then select a different datafile, as described in paragraph 15.4 above, or create a new one, as described in paragraph 15.2 above).

- Click on the 'Take a Measurement' button at the bottom left of the screen.
- The 'Enter the Measurement Parameters' box appears:-

Head Number	1	
Can Number	1	
Batch Number	Batch 1	
Measure all outs	۲	
	-	
Measure selecte	ed cut 🔾	
Measure selecte Cut Number	N/A	

Microseam automatically increments the head, can and cut values according to the information given when the format was created and depending on what, if any, measurements have already been made.

If a can is to be measured out of sequence, the displayed values may be altered appropriately but Microseam issues a warning if the entered combination of values is not unique.

'**Head Number**' – The number of the closing head to be measured is displayed but can be altered. If no measurements have been taken in the datafile previously then 'Head Number' will be automatically completed with a value of '1'.

If required, enter a number within the range specified in the format for the number of closing heads.

**'Can Number'** – The number of the can to be measured is displayed but can be altered. If no measurements have been taken in the datafile previously then 'Can Number' will be automatically completed with a value of '1'.

'**Batch Number**' – This must be completed, but if not used just insert a dash.

'**Measure all cuts**' – If this button is selected then all cuts will be measured.

'**Measure selected cut**' – If this button is selected then a particular cut number can be selected for measurement. The 'Cut Number' box which was 'grayed out' turns white to allow a number to be entered.

**'Cut Number**' – This is normally 'grayed out' and is only enabled if the 'Measure selected cut' button above is enabled. Enter the cut number to be measured.

 Click the 'OK' button. A screen showing the normal seam image appears with a series of vertical cursors, as defined in the format. The red cursor is the current measurement point. Also displayed is the 'Take Measurements' box. Under the seam image is displayed, in red, the current reading from the seam gauge.



ut 1of 2	
Dimensions -	Dim. Info.
Seam Length	
Bodu Hook Lt	h
End Hook Lth	
Seam Thickne	ss
Bodu Wall Thic	
Measurement	s
Measurement	····· 🔨
Measurement 1 normal 2 normal	·s
Measurement 1 normal 2 normal 3 normal	s 
Measurement 1 normal 2 normal 3 normal 4 normal	s 
Measurement 1 normal 2 normal 3 normal 4 normal 5 normal	:s
Measurement 1 normal 2 normal 3 normal 4 normal 5 normal 1 rotated	

The 'Take Measurements' box, at the top, shows the Can, Head and Cut numbers.

In the box headed 'Dimensions' are the names of the dimensions to be measured as defined in the format. Also as measurement progresses, the actual dimensions will appear also.

In the box headed 'Measurements' are the cursor measuring points in number order as defined in the format. Each cursor number is also notated with the word 'normal' or 'rotated' depending on whether the format has a rotated image or not.

- Zero the seam gauge.
- The reading on screen should change to 0.0000.
- Click the 'Next' button in the 'Take Measurements' box. The reading 0.0000 will appear next to '1 normal' and the next dimension will turn pink. Cursor 2 will turn red.



• Adjust the seam gauge to take a reading at cursor position 2.



• Click the 'Next' button in the 'Take Measurements' box. The reading will appear next to '2 normal' and the next dimension will turn pink. Cursor 3 will turn red.

If an error is made it is possible to go back and re-measure a point using the 'Previous' button.



- Continue in the same way until all the 'normal' measurements are taken. At this point the seam image will change to the rotated image.
- Zero the seam gauge. The reading on screen should change to 0.0000.



• Click the 'Next' button. The reading 0.0000 will appear next to '1 rotated' and the next dimension will turn pink. Cursor 2 will turn red.



- Adjust the seam gauge to take a reading at cursor position 2.
- Click the 'Next' button. The reading will appear next to '2 rotated' and the next dimension will turn pink. Because the next dimension is entered with the keyboard, an insertion point flashes in the 'Body Wall Thick' box.



• Enter a dimension via the keyboard e.g. 0.8 and click the 'Next' button. All measurements are now complete.



• If all dimensions were within tolerance the dimensions in the 'Dimensions' box will all be black. If any are red they are out of tolerance.

ut 10/2	Dim. Info.
Dimensions	
Seam Length	0.89750
Body Hook Lth	0.44470
End Hook Lth	0.50950
Seam Thickness	2.36720
Body Wall Thick	0.80000
Shonnar	0.0030
3 normal	0.5095
	0.7044
4 normal	0.7244
4 normal 5 normal	0.7244
4 normal 5 normal 1 rotated	0.7244 0.8975 0.0000
4 normal 5 normal 1 rotated 2 rotated	0.7244 0.8975 0.0000 2.3672

• Click the 'Next' button. A box appears stating that data entry is complete and within tolerance and asking 'Do you wish to proceed to the next cut?'.



- Click the 'Yes' button.
- At this point the 'Take Measurements' box will show cut 2 of 2 and the same procedure can be followed to take dimensions of cut 2.

	ad 1
	Dim. Info.
Dimensions	
Seam Length	
Body Hook Lth	
End Hook Lth	
Seam Thickness	
Body Wall Thick	
Inormal	^
2 normal	
3 normal	
4 normal	
5 normal	
1 rotated	🗸
1	

• When all the measurements for cut 2 are completed, the following box will appear if there are no errors:-

Microseam Inspection Software	
The data entry is complete and Do you wish to save the measu	the dimensions are within tolerance. nents to the datafile? <u>Y</u> es <u>N</u> o

- Click Yes to save the measurements. The 'Display Measurements' screen will appear with the completed measurements shown. (see below).
- If there are out of tolerance errors then the following box will appear:-



If it is thought the out of tolerance dimension is caused by a measurement error then click the 'Repeat' button and repeat the measurements, otherwise click the 'Save' button and the 'Display Measurements' screen will appear with the completed measurements shown.

arameters ormat t Datafile # Datafile
arameters ormat t Datafile
arameters ormat t Datafile
arameters ormat t Datafile
ormat t Datafile w Datafile
t Datafile
t Datafile w Datafile
v Datafile
w Datafile
Body Wall Thi
0.80000
0.80000
0.87000
0.81000
0.82000
0.02915

The above screen shows the measurements similar to those just taken. Lines with no errors are shown in black and lines containing out of tolerance dimensions are shown in blue with the offending dimensions highlighted in red and with the 'Note' column explaining the error.

## **15.6 Approving Measurements**

At the bottom of the 'Display Measurements' screen is an 'Approve' button which can be used by the Administrator and Supervisor to approve measurements.

More than one measurement can be approved at one time by selecting the measurements required using the standard Windows selection technique i.e.

Click and drag.

Select first item, hold shift, select last.

Hold Ctrl and click each measurement individually.

To Approve a measurement proceed as follows:-

- Select the measurement/measurements which are to be approved.
- Click the 'Approve' button at the bottom of the screen. A confirmation box appears:-

Microseam Inspection Software		
1 measurement has been select approved. Do you wish to proce	ed from the list and w eed with this operation <u>Y</u> es	rill now be n? <u>N</u> o

- Click 'Yes' to save the approval or 'No' to quit.
- The 'Display Measurements' screen will re-appear. There will now be a 'Yes' in the 'Approved' column.

# 15.7 Notes

A note can be added, by any operator, to a measurement to hold any information that may be thought to be relevant.

Notes can be added to any measurements displayed on the 'Display Measurements' screen.

#### 15.7.1 Adding Notes

A note can be added in two ways, automatically by the system when a dimension is out of tolerance as per the following example, or by any operator:-

Note Pad	×
Existing Note	
Time=16:29:43 Date=18/02/2008 Operator=Administrator The following out of tolerance dimensions were measured: 'Body Wall Thick' has value 0.87000, it should be 0.00000 to 0.85000.	~
New Note	
Cancel	ĸ

Example of Automatically Added Note

Each time a new note is added, the information is appended to the existing note. The system also automatically adds the time, date and operator to the top of the note.

- Select the measurement to which to add the note.
- Click the 'Note' button. The 'Note Pad' box appears:-

Note Pad	
Existing Note	
	<u></u>
	~
New Note	
	Cancel

• Enter the required note in the area identified as 'New Note' as in the example below:-

Note Pad	
Existing Note	~
	2
New Note Example of a note added to a m	neasurement
	Canal OK

• When satisfied, click the 'OK' button. A confirmation box appears.

Microseam Inspection Software	
Save new text?	
<u>Y</u> es <u>N</u> o	Cancel

- Click 'Yes' to save the note. ('Cancel' will return to adding the note text and 'No' will quit the note altogether.)
- The 'Display Measurements' screen will re-appear. There will now be a 'Yes' in the 'Note' column.
- Check the note by clicking 'Note' again. See the example below:-

Note Pad	×
Existing Note	
Edited at time 16:33 date 18/02/2008 by operator Administrator. Example of a note added to a measurement	~
	×
New Note	1
Cancel	ок

• Click the 'Cancel' button.

#### 15.7.2 Reading a Note

To read a note, proceed as shown above for adding a note but do not add any information. When finished click the 'Cancel' button to exit the 'Note Pad'.

#### **15.8 Deleting Measurements**

From time to time it may be necessary to delete a measurement. This is achieved as follows and is restricted to Administrator/Supervisor.

- Select the measurement line it is required to delete.
- Click the 'Delete' button. The following confirmation box appears.

Microseam Inspection Software	
1 measurement has been selected from the list and will now be deleted Do you wish to proceed with this operation?           Yes         No	

 Click 'Yes' button to complete the deletion or 'No' button to abort the process.

#### **15.9 Printing Measurement Data**

It is possible for any operator to print measurement data by following the procedure below:-

From the Display Measurements screen:-

- Select the lines to be printed. If no selection is made all lines will be printed and the 'Select Measurements to be Printed' box will not be displayed.
- Click the 'Print' button.
- The 'Select Measurements to be Printed' box appears with the following buttons:-

'Cancel' will abort the process, 'Selected' will print only the selected measurement lines and 'All' will print all lines irrespective of what was selected.

Select Measurements to be Printed
One or more measurements have been selected from the list. Use the All button to print all the measurements in the list or use the Selected button to print just the selected measurements.
Cancel All Selected
- Click the 'All' or 'Selected' button.
- The 'Select Dimensions' box appears. This has a list of individual dimensions which can be selected to appear on the print.

Select Dimensions	Select Dimensions
Seam Length Body Hook Lth End Hook Lth Seam Thickness Body Vall Thick Operator Batch No.	Seam Length Body Hook Lth End Hook Lth Seam Thickness Body Wall Thick Operator Batch No.
Cancel	Cancel OK

- Select one or more dimensions from the list and click the 'OK' button.
- A screen appears showing a table of the selected dimensions together with other information concerning the Datafile parameters. See example below. Note that for this example only one page is required to display the data as indicated by the "Page 1 of 1" text. If more than one page is required then the pages can be scrolled using the Page Up and Page Down keys on the computer keyboard.

🗟 Mie	croseam	n Inspe	ectio	n Sof	twar	e									8	<
Eile	Measure	ement	For	mat	Imag	e <u>H</u> e	lp <u>P</u> ri	int	Administrator	is logged on						
Prin	t Measu	remer	nts													
Aru	ndle Optie	cs Rep	ort o	n Data	ifile 0	000001	9.DAT	[					Pag	e 1 of 1		
Gene	erated at t file descr	time 16 ription	:35 o	n date G PUL	18/0 L 3, 1	2/2008 nachin	, select e=E67,	ted head=All, nu product=COLA	mber of measureme , units=Metric.	ents=4.						
Date		Time	Cat	n Head	1 Cut	t <u>Tol.</u>	App.	Seam Length	Body Hook Lth	End Hook Lth	Seam Thickness	Body Wall Thick				
18/0	2/2008	16:24	1	1	1	OK	NO	0.89750	0.44470	0.50950	2.36720	0.80000				
18/0	2/2008	16:25	1	1	2	OK	NO	0.89750	0.44470	0.50950	2.36720	0.80000				
18/0	2/2008	16:29	2	2	1	Out	NO	0.89/50	0.44470	0.50950	2.36720	0.87000				
18/0.	2/2008	10:50	2	2	4	UK	NU	0.89730	0.44470	0.00900	2.30720	0.81000				
						Ave	rage	0.89750	0.44470	0.50950	2.36720	0.82000				
						Std.	Dev.	0.00000	0.00000	0.00000	0.00000	0.02915				
																1
<										(UU)					>	

• From the main menu select the 'Print' option and from the drop down list select 'Print'. The Windows print box appears as shown below.

Print	
Printer <u>N</u> ame: HP Of Status: Ready Type: HP Offi Where: USB00 Comment:	icejet 7300 series Properties cejet 7300 series 1 Print to file
Print range          • All       • Pages from:       • Selection       • Election	Copies Number of <u>copies</u> : 1 $(1)$ 1 $(2)$ 1 $(2)$ 1 $(2)$ 1 $(2)$
	OK Cancel

- Click the 'OK' button and the print should be produced.
- The print can be previewed by selecting 'Print' from the main menu and selecting 'Print Preview' from the drop down list.
- The page can be copied to the Windows Clipboard by selecting 'Print' from the main menu and selecting 'Copy to Clipboard' from the drop down list. This allows the page to be pasted into other applications running on the computer.

### **15.10 Producing Graphs of Measurement Data**

It is possible for any operator to print graphs of measurement data.

From the Display Measurements screen:-

- Select the lines to be displayed graphically. If no selection is made all lines will be plotted and the 'Select Measurements to be Viewed Graphically' box will not appear.
- Click the 'Graph' button.
- The 'Select Measurements to be Viewed Graphically' box appears:-

Select Measurem	ents to be Viev	wed Graphic 🔀
One or more measure Use the All button to the Selected button t	ments have been view all the measu o view just the sele	selected from the list. rements in the list or use acted measurements.
Cancel		Selected

'Cancel' will abort the process, 'Selected' will graph only the selected measurement lines and 'All' will graph all lines irrespective of what was selected.

• Click the 'All' or 'Selected' button. The 'Select Dimensions' box appears. This has a list of individual dimensions which can be selected to appear in each graph.

Select Dimensions	Select Dimensions
Seam Length Body Hook Lth End Hook Lth Seam Thickness Body Wall Thick	Seam Length Body Hook Lth End Hook Lth Seam Thickness Body Wall Thick
Cancel OK	Cancel OK

• Select one or more dimensions from the list and click the 'OK' button.

 A screen appears showing a series of graphs for the selected dimensions containing points representing the actual measurements together with other information concerning the Datafile parameters. See example below. Note that for this example only one page is required to display the data as indicated by the "Page 1 of 1" text. If more than one page is required then the pages can be scrolled using the Page Up and Page Down keys on the computer keyboard.



Points that are within tolerance are shown in green and points outside tolerance are shown as red. The high and low tolerance dimensions are shown on the 'Y' axis and dashed lines from these dimensions across the graph shows the tolerance band.

The 'X' axis is designated with the range of times and dates displayed.

If there is a large amount of data on a graph such that it is not possible to see the detail, a Zoom facility is available as follows:-

- Place the mouse cursor on the left of the area of interest on the graph and click the left mouse button. A vertical cursor is drawn.
- Place the mouse cursor on the right of the area of interest and click the left mouse button. A vertical cursor is drawn. See example below:-



• Press the 'Zoom In' button. The graph is expanded so that the area of interest fills the x-axis. The axis legend displays the new time period represented on the graph.



- The graph can be expanded further if required. Pressing 'Zoom Out' progressively returns through the zoomed stages until the full period is displayed.
- To print the graphs, at the top of the screen click on 'Print' and from the drop down list select 'Print'. The Windows print box appears as shown below.

rint Printer		
<u>N</u> ame: Status: Type: Where: Comment:	HP Officejet 7300 series Ready HP Officejet 7300 series USB001	Properties
Print range ② <u>A</u> I ③ Pages ③ <u>S</u> electi	from: 1to: 1	Copies Number of <u>c</u> opies: 1 $\Rightarrow$ 123 123
		OK Cancel

- Click the 'OK' button and the print should be produced.
- The print can be previewed by selecting 'Print' from the main menu and selecting 'Print Preview' from the drop down list.
- The page can be copied to the Windows Clipboard by selecting 'Print' from the main menu and selecting 'Copy to Clipboard' from the drop down list. This allows the page to be pasted into other applications running on the computer.

## **15.11 Exporting Measurement Data to Other Applications**

It is possible for any operator to export selected measurement data for use by other spreadsheet, database, or word processing applications.

Data can be exported as a comma delimited text file (\*.txt) or as an XML file (\*.xml) which can be imported into Spreadsheet and Database applications or it can be exported as an HTML file which can be imported in word processing applications.

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# EXAMPLE OF COMMA DELIMITED TEXT FILE

C:\temp\00000017.xml - Internet Explorer provided by Dell					
			<ul> <li>✓</li> <li>✓</li> <li>✓</li> </ul>	Google	۶ -
😭 🚸 🌈 C:\temp\00000017.xml			<u>~</u>	🔊 🔹 🖶 👻 🄂 Pa	ge 🔻 💮 Tools 👻 🤌
xml version="1.0" ?					* (E)
- <misreport></misreport>					
– <datafileparameters></datafileparameters>					
<description>USC top</description>					
<machine>unknown</machine>					
<product>unknown</product>					
<units>Metric</units>					
<filename>00000017.DAT</filename>					
- <measurement></measurement>					
<listindex>1</listindex>					
<measurementtime>09:31<td>ime&gt;</td><td></td><td></td><td></td><td></td></measurementtime>	ime>				
<measurementdate>22/01/2006<td>ementDate&gt;</td><td></td><td></td><td></td><td></td></measurementdate>	ementDate>				
<operator>Administrator</operator>					
<batchnumber>1</batchnumber>					
<cannumber>1</cannumber>					
<headnumber>1</headnumber>					
<cutnumber>1</cutnumber>					
<seam_length>3.10500</seam_length>					
<end_hook>1.80500</end_hook>					
<body_hook>2.20000</body_hook>					
<seam_thickness>1.40000<td>SS&gt;</td><td></td><td></td><td></td><td></td></seam_thickness>	SS>				
<pre><body_thickness>0.18000</body_thickness></pre> /body_thickness	S>				
<end_unickness>0.32000</end_unickness>					
cfroe coocea 0 68800 c/free coocea					
<pre>ciree_space&gt;0.00000</pre>					
000y_100K_30.83139 000y_100K</td <td></td> <td></td> <td></td> <td></td> <td></td>					
<					
NotePad Time=09:31:14 Date=22/01/2	2006 Operator=Ac	Iministrator The following o	out of tolerance o	imensions were	
measured: 'free space' has value 0.68	800 it should be	00000 to 0 25000 '% bo	dy hook' has valu	le 56 83159 it sh	buld
be 70.00000 to 100.00000.	ood, it should be		ay nook nas van		Juid
<approved>NO</approved>					
<approvednote></approvednote>					
- <measurement></measurement>					
<listindex>2</listindex>					
MassuramentTime 00.32 /MassuramentTi	imes				•
Done		1	Lomputer   Protect	ed Mode: Off	🔍 100% 🔻

EXAMPLE OF XML FILE

Microseam Report - I	nternet Ex	plorer provi	ided by De	:11												
🔵 💿 🗢 🙋 C:\ter	mp\000000	)17.html										• +	×G	oogle		
🖌 🎲 🌈 Microse	am Repor	i				]						ł	1 - 5	•	🔹 🔂 Page 👻	() Tools
			Arun	dle (	Onti	cs re	enort o	on dat	afile ()	0000	017	DAT	3			
					- pri		Port			0000						
Generation date	18	/02/2008														
eneration time	17	:05														
elected head	Al															
Jumber of measures	ments 17	6	_													
Datafile description	US	SC top	_													
Machine	un	known														
Product	un	known	_													
Units	M	etric														
						M	leasur	ement	ts							
Date Time Can	Head Cut	Tolerance	Approved	seam length	end hook	M body hook	easur seam thickness	emen body thickness	tS end thickness	act. overlap	free space	% body hook	% overlap	% seam thick	Operator	Batch No.
Date         Time         Can           2/01/2006         09:31         1	Head Cut	<b>Tolerance</b> Out	Approved	seam length 3.10500	end hook 1.80500	M body hook 2.20000	seam thickness 1.40000	body thickness	end thickness 0.32000	act. overlap 1.25200	free space 0.68800	% body hook 56.83159	% overlap 56.83159	% seam thick 94.28571	<b>Operator</b> Administrator	Batch No.
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1	Head Cut 1 1 1 2	Tolerance Out Out	Approved NO NO	seam length 3.10500 3.06000	end hook 1.80500 1.76000	M body hook 2.20000 2.15500	seam thickness 1.40000 1.40000	body thickness 0.18000 0.18000	end thickness 0.32000 0.32000	act. overlap 1.25200 1.20700	free space 0.68800 0.68800	% body hook 56.83159 55.93142	% overlap 56.83159 55.93142	% seam thick 94.28571 94.28571	Operator Administrator Administrator	Batch No. 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:34         2	Head Cut 1 1 1 2 2 1	Tolerance Out Out Out	Approved NO NO NO	seam length 3.10500 3.06000 3.01000	end hook 1.80500 1.76000 1.70500	M body hook 2.20000 2.15500 2.04500	easur seam thickness 1.40000 1.40000 1.40000	body thickness 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200	free space 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266	<b>%</b> overlap 56.83159 55.93142 51.80266	% seam           thick           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator	Batch No. 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:34         2           2/01/2006         09:35         2	Head         Cut           1         1           1         2           2         1           2         2	Tolerance Out Out Out Out	Approved NO NO NO NO	seam length 3.10500 3.06000 3.01000 3.10000	end hook 1.80500 1.76000 1.70500 1.69000	M body hook 2.20000 2.15500 2.04500 2.20500	easur seam thickness 1.40000 1.40000 1.40000 1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700	free space 0.68800 0.68800 0.68800 0.68800	% body hook           56.83159           55.93142           51.80266           52.18380	<b>%</b> overlap 56.83159 55.93142 51.80266 52.18380	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:34         2           2/01/2006         09:35         2           2/01/2006         09:45         3	Head         Cut           1         1           1         2           2         1           2         2           1         1	Tolerance Out Out Out Out Out	Approved NO NO NO NO NO	seam length 3.10500 3.06000 3.01000 3.10000 3.10000	end hook 1.80500 1.76000 1.70500 1.69000 1.90000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000	easur seam thickness 1.40000 1.40000 1.40000 1.40000 1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200	free space 0.68800 0.68800 0.68800 0.68800 0.68800	<b>% body</b> hook 56.83159 55.93142 51.80266 52.18380 56.96087	% overlap 56.83159 55.93142 51.80266 52.18380 56.96087	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:34         2           2/01/2006         09:35         2           2/01/2006         09:45         3           2/01/2006         09:46         3	Head         Cut           1         1           1         2           2         1           2         2           1         1           1         2           2         1           2         2           1         1           1         2	Tolerance Out Out Out Out Out Out	Approved NO NO NO NO NO NO	seam length 3.10500 3.06000 3.01000 3.10000 3.10000	end hook 1.80500 1.76500 1.70500 1.69000 1.90000 2.00000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000	easur seam thickness 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook           56.83159           55.93142           51.80266           52.18380           56.96087           66.06005	<b>%</b> overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09-31         1           2/01/2006         09-32         1           2/01/2006         09-34         2           2/01/2006         09-35         2           2/01/2006         09-45         3           2/01/2006         09-46         3           2/01/2006         09-48         4	Head         Cut           1         1           1         2           2         1           2         2           1         1           2         2           1         2           2         1           2         2           1         1           2         2           1         1           2         1	Tolerance Out Out Out Out Out Out Out Out	Approved NO NO NO NO NO NO NO	seam length 3.10500 3.06000 3.01000 3.10000 3.10000 3.10000	end hook 1.80500 1.76000 1.70500 1.69000 1.90000 2.00000 2.20000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000 1.90000	easur seam thickness 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200 1.35200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046	<b>%</b> overlap 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09-31         1           2/01/2006         09-32         1           2/01/2006         09-34         2           2/01/2006         09-34         2           2/01/2006         09-34         3           2/01/2006         09-44         3           2/01/2006         09-48         4           2/01/2006         09-48         4	Head         Cut           1         1           1         2           2         1           2         1           1         2           2         1           1         2           2         1           2         1           2         2           1         2           2         1           2         2	Tolerance Out Out Out Out Out Out Out Out Out Out	Approved NO NO NO NO NO NO NO	seam length 3.10500 3.01000 3.10000 3.10000 3.10000 2.90500	end hook 1.80500 1.76000 1.70500 1.69000 1.90000 2.00000 2.20000 1.80500	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000 1.90000 1.80000	seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200 1.35200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	%6 body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122	<b>%</b> overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09-31         1           2/01/2006         09-32         1           2/01/2006         09-34         2           2/01/2006         09-35         2           2/01/2006         09-45         3           2/01/2006         09-46         3           2/01/2006         09-45         4           2/01/2006         09-46         4           2/01/2006         09-45         3           2/01/2006         09-45         4           2/01/2006         09-45         4	Head         Cut           1         1           1         2           2         1           2         1           1         2           1         1           2         1           1         2           1         1           2         1           2         2           1         1	Tolerance Out Out Out Out Out Out Out Out	Approved NO NO NO NO NO NO NO NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 3.10000 3.00000 3.00000	end hook 1.80500 1.76000 1.69000 1.90000 2.00000 2.20000 1.80500 1.90000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000 1.90000 1.80000 2.19500	seam thickness 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000 1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	ts end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.09200 1.14700 1.25200 1.45200 1.35200 1.05200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045	<b>%</b> overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         2           2/01/2006         09:33         2           2/01/2006         09:33         2           2/01/2006         09:34         3           2/01/2006         09:34         3           2/01/2006         09:44         3           2/01/2006         09:49         4           2/01/2006         09:50         5           2/01/2006         09:50         5           2/01/2006         09:50         5           2/01/2006         09:50         5	Head         Cut           1         1           1         2           2         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         2           2         1           2         2           1         1           2         2           2         2           2         2           2         2           2         2           2         2           2         2           2         2           2         2           3         2	Tolerance Out Out Out Out Out Out Out Out Out	Approved NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 3.10000 2.90500 3.00000 2.90500	end hook 1.80500 1.76000 1.70500 1.90000 2.20000 2.20000 1.80500 1.90000 1.90000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000 1.90000 1.80000 2.19500 2.19500	seam           seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	ts end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200 1.35200 1.05200 1.44700 1.50200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518	<b>%</b> overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518	% seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:33         2           2/01/2006         09:33         2           2/01/2006         09:35         2           2/01/2006         09:45         3           2/01/2006         09:46         3           2/01/2006         09:46         3           2/01/2006         09:49         4           2/01/2006         09:50         5           2/01/2006         09:53         5           2/01/2006         09:50         5           2/01/2006         09:50         5           2/01/2006         09:50         5	Head         Cut           1         1           1         2           2         1           2         2           1         1           1         2           2         1           2         1           2         1           1         2           1         1           2         1           2         2           1         1           2         2           1         2           2         1	Tolerance Out Out Out Out Out Out Out Out Out Out	Approved NO NO NO NO NO NO NO NO NO NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 3.10000 2.90500 3.00000 2.90000 2.90000	end hook 1.80500 1.76000 1.70500 1.90000 2.00000 2.20000 1.80500 1.90000 2.00000 1.90000	M body hook 2.20000 2.15500 2.04500 2.20500 2.205000 1.90000 1.80000 2.19500 2.19500 2.15000 2.05000	seam           seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	ts end thickness 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000 0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.45200 1.45200 1.45200 1.45200 1.44700 1.50200 1.50200	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 75.17518	% overlap 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 75.17518	%6 seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:34         2           2/01/2006         09:35         2           2/01/2006         09:45         3           2/01/2006         09:45         3           2/01/2006         09:45         4           2/01/2006         09:45         5           2/01/2006         09:50         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         5	Head         Cut           1         1           1         2           2         1           2         1           1         2           2         1           2         1           2         1           2         1           1         2           1         1           2         1           2         1           2         1           2         1           2         1	Tolerance Out Out Out Out Out Out Out Out Out Out	Approved           NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 3.10000 2.90500 3.00000 2.90000 2.90000 2.90000	end hook 1.80500 1.76000 1.70500 1.90000 2.00000 2.200000 1.80500 1.90000 2.90000 1.90000 2.00000	M body hook 2.20000 2.15500 2.04500 2.20500 2.10000 2.20000 1.90000 2.19500 2.15000 2.15000 2.05000 1.99500	seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000           0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200 1.35200 1.45200 1.50200 1.50200 1.39700	free space 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800 0.68800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 69.91992 65.1651	% overlap 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 69.91992 65.1651	%6 seam thick           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           2/01/2006         09:31         1           2/01/2006         09:32         1           2/01/2006         09:32         1           2/01/2006         09:34         2           2/01/2006         09:45         3           2/01/2006         09:45         3           2/01/2006         09:45         4           2/01/2006         09:45         4           2/01/2006         09:53         5           2/01/2006         09:53         5           2/01/2006         09:53         6           2/01/2006         09:57         7           2/01/2006         09:58         6           2/01/2006         09:57         7           2/01/2006         09:57         7           2/01/2006         09:57         7           2/01/2006         09:57         7	Head         Cut           1         1           1         2           2         1           2         1           1         2           2         1           2         1           2         1           2         1           1         2           2         1           1         2           2         1           2         1           2         2           1         1           2         2           1         1	Tolerance Out Out Out Out Out Out Out Out Out Out	Approved           NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 3.10000 2.90500 2.90500 2.90000 2.90000 2.90000 2.90000	end hook 1.80500 1.76000 1.70500 1.90000 2.20000 1.80500 1.90000 2.00000 1.90000 1.95000 1.95000	M body 2.20000 2.15500 2.20500 2.20500 2.20000 1.90000 2.19500 2.19500 2.15000 2.19500 2.15000 1.99500 1.99500	seam           seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	ement body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness           0.32000	act. overlap 1.25200 1.20700 1.09200 1.14700 1.25200 1.45200 1.35200 1.44700 1.50200 1.50200 1.39700 1.30200	free space 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800	%6 body hook           56.83159           55.93142           51.80266           52.18380           56.96087           66.06005           61.51046           52.52122           68.97045           75.17518           75.17518           65.16517           55.4557	9% overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 69.91992 65.16517 52.6526	% seam thick           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Date         Time         Can           12/01/2006         09-31         1           12/01/2006         09-32         1           12/01/2006         09-33         2           12/01/2006         09-34         2           12/01/2006         09-35         3           12/01/2006         09-45         3           12/01/2006         09-46         3           12/01/2006         09-45         4           12/01/2006         09-45         5           12/01/2006         09-57         5           12/01/2006         09-57         6           12/01/2006         09-57         7           12/01/2006         09-57         7           12/01/2006         09-57         7           12/01/2006         09-57         7           12/01/2006         09-57         7           12/01/2006         09-58         6           12/01/2006         10-58         8	Head         Cut           1         1           1         2           2         1           2         2           1         1           2         2           1         2           2         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2           1         1           2         2	Tolerance Out Out Out Out Out Out Out Out Out Out	Approved           NO           NO	seam length 3.10500 3.06000 3.10000 3.10000 3.10000 2.90500 3.00000 2.90000 2.90000 2.90000 2.90000 2.90000	end hook 1.80500 1.76000 1.70500 1.90000 2.20000 1.90000 1.90000 2.00000 1.95000 1.95000 1.95000	M body 2.20000 2.15500 2.20500 2.20500 2.20000 1.90000 2.19500 2.15000 2.19500 2.19500 1.99500 1.99500 1.99000 1.75000	seam           thickness           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000           1.40000	emeni body thickness 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000 0.18000	end thickness           0.32000	act. overlap 1.25200 1.09200 1.14700 1.25200 1.45200 1.35200 1.45200 1.35200 1.44700 1.50200 1.39700 1.39700 1.30200	free space 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800 0.65800	% body hook 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 69.91992 65.16517 57.65766	9% overlap 56.83159 55.93142 51.80266 52.18380 56.96087 66.06005 61.51046 52.52122 68.97045 75.17518 69.91992 65.16517 57.65766 55.16517	%6 seam           thick           94.28571	Operator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator Administrator	Batch No. 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1

EXAMPLE OF HTML FILE

From the Display Measurements screen:-

- Select the lines containing data to be exported. If no selection is made all lines will be exported and the 'Select Measurements to be Exported' dialogue box will not be displayed.
- Click the 'Export' button.
- The 'Select Measurements to be Exported' box appears:-

Select Measurem	ents to be Expo	orted	×
One or more measure Use the All button to use the Selected butt measurements.	ments have been s export all the meas on to export just th	selected from the list urements in the list o e selected	r
Cancel	All	Selected	

'Cancel' will abort the process, 'Selected' will export only the selected measurement lines and 'All' will export all lines irrespective of what was selected.

• Click the All or Selected button and the Select Export File Type box is displayed.



• Select one of the file types and the Windows 'Save As' box appears showing files in the last folder used.

Save As						×
Save in:	Je temp	Data and diffed	► Turne	0 Ø 🖻		~
Recent Places Desktop Phil Haynes Computer	ams_3v0v3 backup bitmap bitmap bounce chart com_samp download enhmeta GenradF33 GenradF33 GenradTK3 HScr2Clp_ Icom prog	ovace modified Sv2 oles G 8160 src ramming software	туре	JIZE		
Network	File <u>n</u> ame: Save as <u>t</u> ype:	00000017.txt txt Files (*.txt)		*	<u>S</u> ave Cancel	

- Use the 'Save in' area to navigate to a folder to store the exported data. Use the create new folder icon if required to make a new folder.
- In the 'File name' area provide a meaningful filename for the exported data.
- Click 'Save' to save the file. The data is exported and the 'Save As' box disappears.

### 16 ADMINISTRATOR PROCEDURES

The System Administrator will have access to all functions within Microseam and can create new users or modify/delete existing users and allocate the security level at which they can operate.

The Administrator should be logged on in order to perform the following tasks.

#### 16.1 Create a New User/Supervisor

Each User/Supervisor of the system should be allocated an ID and Password.

- From the main menu select 'File'.
- From the drop down list select 'Operators'.
- The 'Operator Setup' box will appear.

Operator ID	Security Level	
Administrator Haynes Smith	Administrator Administrator User	Add
		Password

- Click 'Add'.
- A blank 'Operator Edit' box will appear.

Operator ID	
Security Level	· ·
Password	
Password (Repeat)	

• Enter an 'Operator ID', which can be alpha numeric with a maximum length of between 7 and 12 characters depending on the characters used i.e. upper or lower case. If an attempt is made to enter more than 12 characters, an error message will appear after selecting 'OK' below.

- Enter a 'Security Level' from the drop down list. Choices are Administrator, Supervisor and User.
- Enter a 'Password' in the 'Password' field.
   'Password' can be alpha numeric up to 16 characters and is not case sensitive i.e. PASSWORD, password or Password are all the same. The password appears as a series of asterisks \*.
- Enter the password again in the 'Password (Repeat)' field.
- The completed box should look something like that below.

Operator Edit	×
Operator ID	Trevor M
Security Level	User 💌
Password	••••
Password (Repeat)	••••
Cano	el OK

- Click the 'OK' button.
- The 'Operator Setup' box re-appears with the new entry shown.

Operator ID	Security Level	
Administrator Haynes Smith Trevor M	Administrator Administrator User User	Add Delete Password

### 17 USER PROCEDURES

All operators will have an 'Operator ID' and 'Password' initially allocated by the Administrator. The password can be changed later as described in paragraph 17.2 below.

An 'Operator' defined as a 'User', may only take measurements.

#### 17.1 User Logon

Authorised operators will logon as follows:-

- Run Microseam.
- From the main menu select 'File'.
- From the drop down list select 'Logon'.
- The 'Operator Logon' box will appear.

perator Logon	
Select Your Operator ID	•
Enter Your Password	
Cano	

- Select the 'Operator ID' from the drop down list.
- Enter the password then click the 'OK' button.

#### 17.2 User Password Change

A user may change his/her password at any time. Clicking 'Cancel' at any time in the following procedure will abort the procedure and retain the old password:-

- From the main menu select the 'File' option.
- From the drop down list select 'Change Password'.
- The 'Enter a New Password' box will appear.

Enter a New Password	×
Enter the password	
	Cancel OK

- Enter an new password of up to 16 characters and click the 'OK' button. The password can be alpha numeric up to 16 characters and is not case sensitive i.e. PASSWORD, password or Password are all the same.
- The 'Re-type the New Password' box will appear and the password should be entered again.



If the password was re-typed incorrectly then an error message will appear to that effect and the procedure will have to be repeated from scratch.

- Click the 'OK' button.
- A password changed success box will appear similar to that below:-

mis	
<u> </u>	The password for operator 'Frank G' has been changed successfully.
	ОК

• Click the 'OK' button.

## 18 MICROSEAM DOUBLE SEAM DIMENSIONS

This section contains figures showing the typical dimensions used for a double can seam.

# Microseam double seam dimensions.



# Rotary Microseam double seam dimensions.

