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General Improvements for Version 8.0.0

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New Dynamic Reports module

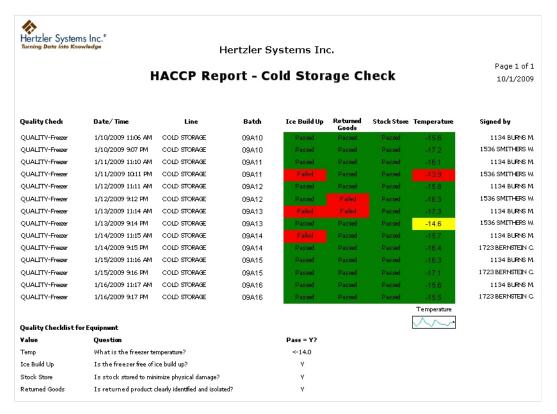
The new **Dynamic Reports module** allows you to create highly customized reports. It is similar to Crystal Reports®.

Like the Report Writer in the SPC Charts and Reports and DMS Charts and Reports modules, the Dynamic Reports module lets you combine raw data, statistics, and/or images in a single report. This is useful for generating common reports such as a Certificate of Analysis.

However, the Dynamic Reports module also gives you many additional capabilities for customizing reports, such as:

- $_{\ensuremath{\epsilon}}$ including data from a custom query on the current database connection
- ϵ including data retrieved from other data sources
- ϵ performing mathematical functions
- ε user interaction with finished reports
- ε executing Visual Basic code
- ε complete control over layout, colors and fonts
- ¿ and many other options

Hertzler Systems can provide training classes and other services to help you use these advanced capabilities to your advantage.



Server Edition now extended beyond Enterprise Dashboard

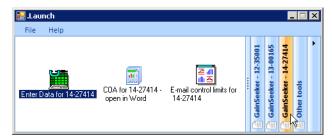
In previous versions of GainSeeker, it was possible to purchase a Server Edition of the Enterprise Dashboard module to easily share dashboards with people who may not have access to GainSeeker.

This functionality is now extended to the new Dynamic Reports module, and this additional license is now known as the Server Edition of GainSeeker.

For information on Server Edition options for the Dynamic Reports module, see <u>Parameters to print or export a dynamic report</u>. For information on Server Edition options for Enterprise Dashboards, see <u>Server Edition options for Dashboards</u>.

New .Launch module

The new .Launch module allows you to launch multiple GainSeeker modules from a single login.



If you have purchased a license for this module, you can easily set up shortcuts to perform automatic functions in GainSeeker modules.



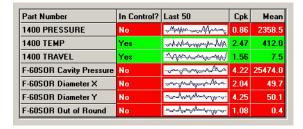
You can also include shortcuts to other programs, files and web addresses, and you can organize these shortcuts in groups.

For details, see Launching GainSeeker modules from the .Launch module.

Enterprise Dashboard enhancements

Sparklines and Control Charts now available on Dashboards

Real-time failure dashboards and Statistical Filter dashboards for variable data can now include sparkline charts (run charts) and control charts. This makes it easy to visualize how your process is performing over time.



KPI gage dashboards can now display pictures, documents and web pages

In addition to Dial gages, Bar gages, Dynamic text and Static text, you can now add File or URL items to KPI gage dashboards.

This new type of item allows you to display pictures, documents, and web pages on KPI gage dashboards. It also makes it possible to display any type of GainSeeker chart - including Pareto charts, Box and Whisker charts, etc. - on a KPI gage dashboard.

For more information, see Specifying a File or URL.

New ability to automatically run a template before opening a Dashboard

In previous versions, the Server Edition of GainSeeker allowed you to perform one or more functions after a dashboard was opened or refreshed.

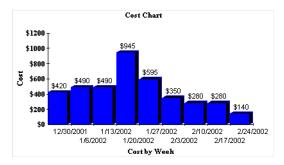
With this release of GainSeeker, the Server Edition also allows you to run a template before a dashboard opens or refreshes. This new functionality makes it possible to enter the most recent data into GainSeeker just before the dashboard is displayed. You could also use this feature to calculate one component of the dashboard from the value of another component of the dashboard. For more information, see Run a template before dashboard opens or refreshes.

Short Run analysis now available in Enterprise Dashboard module

The Enterprise Dashboard module now performs Short Run analysis of variable data dashboards where rows are sorted by a traceability field instead of the Part Number or Process fields. For KPI gages, Short Run analysis is used when the retrieval is based on a process specification instead of a Part Number (standard). For more information, see <u>Using Dashboards to monitor your processes</u>.

Cost chart now available

A new Cost chart has been added to the DPU chart options in the DMS Charts and Reports module. It can display the cost of defects or defective units over time.



Cumulative Yield now calculated for attribute data

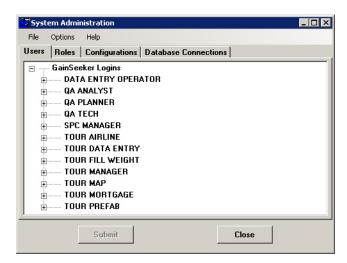
A <u>Cumulative Yield</u> statistic can now be reported for attribute data. This new statistic is calculated as Yield_{process 1} * Yield_{process 2} * ... * Yield_{process 2} and is particularly useful when you retrieve and analyze data from multiple processes.

Administration module redesigned

The Administration module has been redesigned. Some of the new features that were added during the re-design include:

- ¿ Reserving a GainSeeker license for a specific user name
- ¿ Configuring default settings for SPC standards and for DMS standards

For details, see Viewing and changing settings, Submitting or Cancelling changes, Configuring GainSeeker and Checking Data Integrity.



GainSeeker Installation redesigned

The GainSeeker installation program has been completely redesigned.

Previous versions of GainSeeker were typically installed with program files (*.exe) stored on an Application Server. Beginning with GainSeeker version 8.0, these program files are now installed on the local drive of each GainSeeker workstation.

Other changes include the following:

- The GainSeeker installation program now supports the use of file paths expressed in the Universal Naming Convention (UNC) format. Any file path that GainSeeker needs to use, such as those specified in the Administration module, can now be expressed in UNC format.
- $_{\epsilon}$ There is no longer a GainSeeker client installation program or a GainSeeker workstation update program.
- ¿ Because there is no longer a GainSeeker client installation program, the Cms.net file is no longer used by GainSeeker.

Strong encryption for passwords now available

You can now generate a strongly encrypted version of a GainSeeker password or database password, using a 128-bit encryption method. This is useful when you want to specify a password in shortcuts that automate functions, Cms.ini files that connect to a non-default data source, or SPC data entry templates that connect to an external database – without the possibility for users to discover what that password is. For details, see Password Encryption utility.

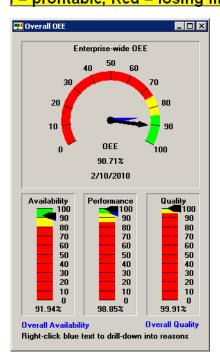
New standards defined for implementing OEE metrics

Overall equipment effectiveness (OEE) is a metric that indicates how effectively a manufacturing operation is utilized. It is generally reported as a percentage and is the product of % Availability * % Performance * % Quality.

With GainSeeker version 8, Hertzler Systems has defined a unified standard for deploying OEE within GainSeeker Suite. The new standards include

- ¿ DMS processes, defect lists and standards
- ¿ SPC standards
- ¿ Standardized data entry processes
- ¿ Standardized dashboards and desktops like the following examples:

Feb 10, 2010 10:27 AM Shift 1		Asset BAGGER01			СН	OCOLATE CHIP 04OZ PACK 1	% OEE 100.0
Hour	SKU	Expected	Actual	% OEE	Qty	Downtime/Scrap Reasons	Time
1	CHOCOLATE CHIP 04OZ	3,800	3,800	100.0	3 8	8 Code Date not Readable	8:00a
2	CHOCOLATE CHIP 04OZ	3,867	3,867	100.0	2 72	72 Code Date not Readable	9:00a
3	CHOCOLATE CHIP 04OZ	3,933	3,933	100.0	1 203	203 Code Date not Readable	10:00a
4							
5							
6							
7							
8							
= profitable. Red = losing money. kaizen continuous improvement in all act							



 $For information \ on \ using \ Gain Seeker \ for \ OEE \ metrics, \ please \ contact \ the \ \underline{Sales \ department} \ at \ Hertzler \ Systems.$

Other improvements

New tables and files

Some new tables and files are used in GainSeeker version 8:

item in previous version:	replaced by:
database table: CFG	
database table: HSITABLE	
database table: USERPROF	
database table: USER_AUX	

database table: HIL	
file: Table.db	
file: SPC.db	
file: DMS.db	
file: Event.db	new database table: HSICFG
file: Short_s.prf	
file: Short_d.prf	
file: Statlbl.prf	
file: Statlbld.prf	
database tables: UC*	
file: CpOPC.dat	new database table: HSIUC
file: CpDSE.dat	
file: Sngs.dat	new file: Settings.hsi
new in version 8	new database table: HSIRPT
	new file: Redirect.hsi

For a full list of tables and supporting files, see Tables used in GainSeeker 8.

The TABLE command has also been updated with these new table names.



Note: Any templates that access these obsolete tables must be modified to access the new tables. You can use the <u>Syntax Checker</u> to quickly identify which templates (if any) need modification.

UNC file paths now supported

The GainSeeker installation program now supports the use of file paths expressed in the Universal Naming Convention (UNC) format. Any file path that GainSeeker needs to use, such as those specified in the Administration module, can now be expressed in UNC format.

SPC Charts and Reports

A new command line parameter now allows you to create a shortcut which will open a desktop and save it to HTML without launching a web browser. For details, see <u>Parameters to open a desktop and save as HTML</u>.

Statistical changes for SPC and DMS

The default labels for some of the SPC and DMS statistics were updated for consistency and clarity. For a current list all statistics and their default labels, see SPC statistics available and DMS statistics available.

Also, a long list of minor statistical changes for SPC and DMS were implemented in this release of GainSeeker. To view the full list, #click here.

Multiple export and import file types now available for the SPC Standard Utility

Previous versions of GainSeeker only allowed you to export and import standards using the custom .std file format. The SPC Standard Utility now supports two new file formats for exporting and importing standards and Short Run process specifications: tab-delimited format (*.tab files) and XML format (.xml files). The .tab format is easier to use if you need to enter values for new standards with a program like Microsoft Excel which can create or edit files in this format.

SPC Designer - new and updated features

New features:

- Each The new TRACE MR command makes it easier to retrieve all of the traceability values that were most recently entered for a particular machine, line, user, or other traceability field.
- The new DE OPT 29 command allows you to read the contents of a web page that is displayed on the chart window for a row of the template. This command is typically used in conjunction with a timer to read user input and/or button clicks from an HTML file displayed in a data entry chart window.
- The new TEXT_OPT 3 command allows you to change the label on the external applications button or hide the button.
- The new MAV command returns the "Maximum Allowable Variation" (MAV) for the label weight you specify. The MAV value comes from tables in Fourth Edition NIST Handbook 133 (2005), Appendix A.
- The new LOOP and LOOP BREAK commands give you a much faster way to repeatedly execute the formula string you specify.
- The new LIST_OPT 11 and LIST_OPT 12 commands allow you to specify the location of lists generated by the LIST_F, LIST_P, and LIST_Q commands.
- The new RT NOTE command launches the real-time failure note window for the specified template row. It uses the color, message and sound that you

specify, and it uses the DE_OPT 6 setting for forcing the user to choose a corrective action.

- Each The new MISC_INFO 5 MISC_INFO 8 commands will return some of the User-Defined Labels from the current configuration.
- The new OPC OPT command can be used to enable an OPC receive buffer so that each time the value of an OPC channel changes, that channel number and value will be added to the queue in the OPC receive buffer. Then you can use the new OPC RCVBUFFER to read each channel/value pair from the queue.

Updated features:

In previous versions, the <u>DB_INSERT</u> command would automatically increment the "DateTime" in the record buffer by one or more seconds if DMS data with the same standard and date/time stamp already existed in the database. This was true even if DMS was configured to display time to seconds or to bundredths of seconds

This command now uses the Show time to configuration setting to determine the unit of time that will be used to increment the "DateTime" – Minutes, Seconds or Hundredths of seconds.

- ² The help topics for CHT OPT SPC and CHT OPT DMS have been updated to indicate which settings will be ignored when retrieving a desktop.
- The CHT_OPT_DASH and CHT_DASH commands have been updated such that when CHT_DASH is used to retrieve a desktop, any CHT_OPT_DASH commands that were used to specify a date period or a filter will be ignored. This makes retrieval of Enterprise Dashboard desktops work the same way that retrieval of SPC desktops and DMS desktops has worked from the beginning.

These commands have also been updated such that when CHT_DASH is used to retrieve a dashboard, the default date period is the date period defined in the dashboard (instead of the date period currently being used for SPC Data Entry) and the default filter is the filter defined in the dashboard (instead of traceability filters set for the current template row by the FILTER command).

Note: If you have templates that were created in GainSeeker 7 to generate dashboards and dashboard desktops, you should review the date periods and filters that will be applied to those dashboards and desktops in GainSeeker 8 now that the default program functionality has changed.

- ¿ The DATE CHK command has been updated to correctly evaluate time stamps that are presented in 12-hour format followed by "AM" or "PM".
- E The help topic for the FREN command was updated to mention that this command can be used to move a file from one folder to another.
- ε On Template Wizard Step 6, the **Document** tab can now support .docx files.

More:

Version 8.0.0 Release Notes

Known Issues

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GainSeeker 8.0.0 Release Notes

This describes the resolution of known issues and corrections to the Online User Guide.

WebSPC

the GainSeeker Administration module can no longer be used to set up users or modify web rights for WebSPC. GainSeeker version 8 uses new tables to store this information, but WebSPC still uses the GainSeeker version 7 tables and files.

Standard Duplicator

Each of the Standard Duplicator module no longer exists as a standalone GainSeeker module. It has been incorporated into the SPC Standard Utility module.

Version Verify

E The Version Verify module is no longer available from the GainSeeker LaunchPad.

Table Creation Utility

E The Table Creation Utility module is no longer available from the GainSeeker LaunchPad.

All Modules

- ¿ Under certain conditions when excluding outliers, the value for "Maximum good subgroup" reported a larger number than the value for "Maximum subgroup". This issue has been resolved.
- ¿ If excluding outliers with multiple data groups, and gates are used for zone violations, the mean used to evaluate outliers could be incorrect and cause outlier evaluation to report incorrect results. This issue has been resolved.
- ¿ Several SPC statistics could be reported incorrectly if excluding outliers for a data set with a subgroup size of one. This issue has been resolved.
- ¿ Users without rights to change notes could still change an existing note if they had the right to add data and notes. Now users with this combination of rights can only append to the existing note. This issue has been resolved.
- ¿ Users were unable to edit DMS data if the data was stored with a higher time precision that is currently being shown. This issue has been resolved.
- When editing a data record and deleting a value from traceability fields 7-48 or SPC data fields 9-72, sometimes the value was not actually deleted. This could happen on a SQL Server 2005 database, or when the <u>Convert.db</u> file contained the setting <u>UseQry=1</u>. This issue has been resolved.
- ¿ On a MySQL database, attempts to change values in a database record (such as an SPC standard) were not always successful. GainSeeker now uses the same method on MySQL that it was already using on SQL Server 2005 and later to perform insert, update and delete operations, and this issue has been resolved.
- End on the Continuous The Continuous End of the Configuration setting for Set nonconforming units = number of defects affects the analysis of DMS data records that are stored with a number of Nonconforming Units that is different from the number of Defects.
- the Online User Guide has been updated to include instructions for calculating color ID numbers that can be used with the DE_OPT 2, DE_OPT 3 and DE_OPT 4 commands.
- ¿ The Online User Guide has been updated to reflect that the Pp and Ppk statistics are now calculated for data sets that exhibit non-normal distributions.
- Each Colline User Guide has been updated to note that the Match case check box will not impact the list of values returned by the search if you are running GainSeeker on a database, table or column where the Collation is case-insensitive.

SPC Data Entry

- ¿ Using the DB SET_VALUE and DB STD SQL "SPC*" commands to create SPC standards would set an incorrect value in the database field for the coding method. This issue has been resolved.
- ¿ If you removed unused columns from the DDAT_AUX table in the current configuration, the DB_DATA_AUX_SQL or DB_INSERT commands were not aware of the missing columns and thus would not generate an SQL string that you could use. These commands will now automatically detect which traceability columns remain in the DDAT_AUX table and will adjust the SQL string accordingly.
- Increasing the subgroup size during a data entry session could generate a Run-time error 9: "Subscript out of Range". This issue has been resolved.
- ε Using the SET_NOTE command to set a note ending with a space could result in a message about not having rights to delete or save a changed note. This issue has been resolved.
- ε When using the DMS_COUNTS command to enter DMS data, the program allowed users to enter data for more than 20 types of defects and then generated a Run-time error 9: "Subscript out of Range". This issue has been resolved.
- ε In previous versions, GainSeeker would round data values to the number of Decimal places in the standard or process specification being used to enter the data before storing these rounded values in the database. GainSeeker now stores the data values as they were entered and will only round the data values when formatting them for display.
- ε In previous versions, template commands such as CHT_DASH could crash if more than 100 .jpg files existed in the destination folder. These commands could also crash if these .jpg files were created and deleted in the same template These issues have been resolved.
- When running a <u>Timed Session</u> with a Display type of Minimized timer dialog, or when running a data entry template with the <u>TIMER DELAY</u> command using a window_state of 1 (Minimized timer window), the default display properties for Windows XP or Vista sometimes makes it impossible to display all of the characters on the countdown timer. When displaying the timer on a minimized dialog, the timer now automatically strips off non-critical characters. For example: a time of 09:30:21 will now display as "9:30:21"; a time of 00:14:29 will now display as "14:29"; a time of 00:3:12 will display as "3:12"; and a time of 00:00:09 will display as "9".

SPC Database Monitor

¿ When using custom dates to display records in the SPC Database Monitor module, charts that were launched from this module sometimes used an incorrect date range. This issue has been resolved.

Enterprise Dashboard

- ¿ When designing a Statistical Filter dashboard: if you choose All Data for your statistical filter, the color settings for this dashboard will now be ignored.
- & When editing a Real-time Failure dashboard, the dialog displayed the high date before the low date. This issue has been resolved.
- When using the Desktop menu to send dashboards to HTML, some image files were placed in the wrong folder if the Cms.ini setting html_location= pointed

to a folder other than the default for this setting. This issue has been resolved.

- On a SQL Server database, opening a Real-time Failure dashboard could sometimes generate a "Cursor not declared" database error when one of the periods on that dashboard was "Last n records". This issue has been resolved.
- When creating a new retrieval for a KPI gage, the default date period was always "Today to default low" even if the default date period for DMS Charts and Reports or SPC Charts and Reports was configured differently. The default date period for a new DMS retrieval now comes from the configuration setting for the default date period for DMS Charts and Reports, and the default date period for a new SPC retrieval now comes from the configuration setting for the default date period for SPC Charts and Reports.
- ¿ Using Prompt for changes for Part Number or Process would not work correctly when more than one part number or process was involved. This issue has been resolved.
- ¿ Statistical Filter dashboards always reported 'NA' for Upper and Lower specification limits when the dashboard rows were defined by one of the Short Run traceability fields. This issue has been resolved.
- Each The help topic on creating a shortcut to <u>automatically open a desktop and save it as XML</u> was updated to mention that the ability to specify the name and location of the resulting XML file is only available when the Server Edition is installed.

DMS Charts and Reports

- ¿ DMS drill-down data table allowed users to edit instead of view notes, and then reported an error. This issue has been resolved.
- ¿ In some cases, the list of DMS standards was automatically filled even though the configuration was set to not automatically fill the list. This issue has been resolved.

SPC Charts and Reports

- ¿ On the dialog that displays statistics list formats, the caption for the "Save as default" check box was incorrect. This issue has been resolved.
- When opening a desktop that did not include a setting for non-symmetrical control limits because the desktop had been created by a previous version of GainSeeker, GainSeeker automatically analyzed the data as if this setting were set to "false" instead of using the default setting from the current configuration. This issue has been resolved.
- ¿ If a user displayed the Control Limit Legend for a control chart where no data groups were present, clicking the Zoom button would generate a Run-time error 5: "Invalid procedure call or argument". This issue has been resolved.
- ¿ On step 3 of the Variation Wizard, selecting multiple items would generate a Run-time error 91: "Object variable or With Block variable not set". This issue has been resolved.
- ¿ When a Short Run chart was displayed, GainSeeker did not correctly search for the relevant process specification when the user clicked the Setup menu and chose Current Value. This issue has been resolved.
- Each of the Store Gates screen would not allow a range gate to be set below 0, even though this is the default lower control limit for Short Run charts using the Standardized coding method. This issue has been resolved.
- When a Short Run control chart was displayed, the user was not able to remove control limits from the range chart. This issue has been resolved.
- ¿ On a Control and Bar chart, double-clicking a point on the X-bar portion of the control chart would not generate the Data Table. This issue has been resolved.

SPC Designer

- ε On Template Wizard Step 5, if the user changed a cell type from Keyboard to Formula and then supersized this dialog, it was possible for this cell to revert back to a Keyboard cell. This issue has been resolved.
- ε On Template Wizard Step 5, clicking Find and then clicking Variables now lists MyNVars, MySVars, MyNArrs and MySArrs in alphabetical order. This makes it much easier to find a specific entry in the list.
- ² The <u>File Import Wizard</u> and <u>Database Integration Wizard</u> have been updated to use the <u>DB_INSERT</u> command to store DMS data, instead of the more complicated template code that was being used in the "DMS Save" column.
- Estep 2 of the Database Integration Wizard has been updated so that a table name that contains (but does not equal) a reserved word will not be erroneously flagged as a reserved word.
- ² The help topics for several commands have been updated to reflect the correct return value (–999 instead of 999) when the requested setting does not exist. These commands include: <a href="https://www.upperschammers.com/upperschammers.co
- ¿ The help topics for the CHT_DASH, CHT_DMS and CHT_SPC commands have been updated to note that if the charting modules used by these commands are already open on the workstation, executing these commands will close the associated charting module.
 - These topics have also been updated to note that if the focus does not returns to the SPC Data Entry module after executing this command, you can use the formula PBUFF: CLOSE PBUFF to return the focus to the SPC Data Entry module.
- Each the help topic for the SETCELL command has been updated to note that if you are setting the value of a cell in the Event, Cause or Action Taken column, your template must visit the cell after SETCELL has made the change.

End to help topic for the Document tab has been updated to note that newer versions of Microsoft Office and document viewers (2003 and later) can no longer display an Office document directly on the document tab of a data entry template, even using the HTML redirect.

Administration

E When setting file paths, previous versions of GainSeeker did not allow you to select a file path that contains a space. Now GainSeeker will try to detect the equivalent "short name" file path (which does not contain spaces) from the file system. If detected, GainSeeker will paste this "short name" file path onto the Edit File Path screen. Otherwise, you will need to enter a different file path which does not contain a space.

Discontinued Cms.ini settings

The following settings from Cms.ini have been moved to Settings.hsi:

¿ data_tablespace=
¿ query_timeout=
¿ audittrl_table

The following settings from Cms.ini have been moved to Redirect.hsi:

ε physid=
ε user_name=
ε user_last=

Also, the html_res= setting has been moved from Cms.ini to the system-wide settings for Chart picture size.

Discontinued Convert.db settings

The computer_name= and requetid= settings from Convert.db have been moved to Settings.hsi.

The following settings from Convert.db have been moved to system-wide settings:

- ¿ audit_uc=
- ¿ notify_days=
- ε notify_date=
- ¿ email_to=
- ¿ email_subject=
- ¿ email_name=
- ¿ email_pw=
- ¿ email_uc=