



CIMCO NC-Base v7 User Guide

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Software: NC-Base v7

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CIMCO NC-Base is production centric, designed to be used by people in the programming department and on the shop floor. With NC-Base, CNC programmers and production staff can assemble virtual folders containing all the necessary data used by machinists, operators, quality staff, and others who are responsible for finished parts.

Why just send CNC programs to the shop floor when you can also provide setup sheets, tool lists, images, and other vital information required to manufacture parts? This information may be accessed from PCs running the NC-Base Client or printed out for manual distribution. Either way, NC-Base helps ensure the right part gets made right every time.

CNC operators can access and update the database directly from the CNC control, or any PC on the shop floor.

Installation

To install NC-Base v7 follow the instructions below.

1. Locate installation files

If you received NC-Base v7 on a CR-ROM, open the NC-Base v7 directory on the CD. If you received NC-Base via e-mail, save the NC-Base v7 file in a temporary directory.

2. Run installation program

Start the installation program by clicking on the CIMCO Software setup program:



CIMCO Software setup program.

3. Select components

Now follow the instructions on the screen.

When prompted for selecting components, select *CIMCO Database Server* for installing NC-Base Server and select *CIMCO Edit* for installing NC-Base Client (CIMCO Edit is needed in order to run NC-Base Client).

If you have purchased a license for CIMCO DNC-Max, or wish to install an evaluation version of CIMCO DNC-Max, you should also select *DNC-Max* from the list.

4. Copying your key file

If you do not have a key file and wish to install an evaluation version, just proceed to the next step.

If you have received a key file from CIMCO, it should be copied to the `NCBase7` directory after the installation is completed.

If you have installed both NC-Base Server and Client, the key file must be copied to the `CIMCOEdit7` directory too.

5. Starting the server

When the installation is completed, and you have copied your key file, you are ready to start NC-Base for the first time.

Go to the NC-Base installation directory (typically `C:/CIMCO/NCBase7`) and run `NCBaseServer.exe`, this will bring up the database server console. Click the "Start" button to start the server.

Verify that your company name is shown at the top of the window. If not, you forgot to copy the key file to the NC-Base directory. If you are running an evaluation version, the license name is *Demo version*.



In Windows 8, Windows 7 and Vista you need to right-click and select "Run as administrator".

6. Starting the client

Start CIMCO Edit v7 and verify that the *Database* tab is available in the ribbon. If not, open the Editor configuration by clicking the  Global Setup icon in the *Editor* tab. Go to the Plugins section in the left tree of the configuration window, and ensure that the option Disable NC-Base is unchecked. Now restart the program to activate the Database tab.

Database Tab

In this section, the functions under the Database tab are described.

The functions in NC-Base v7 are activated using the appropriate icons on the Ribbon. The commands are organized into different menus under the *Database* tab.

If the function can be activated through the Ribbon bar or a keyboard shortcut, the icon or the shortcut is displayed next to the command name.



The database is optional and will be present in the Editor only if you also purchased it.



If the *Database* tab is not available, please refer to *Installation* to read about how to start the NC-Base Client.



- Database
- Search
- Program
- Status
- Transfer
- Backup
- Customer
- Administration

Database

This section describes the functions in the Database menu. You can access the database configuration using the icon .

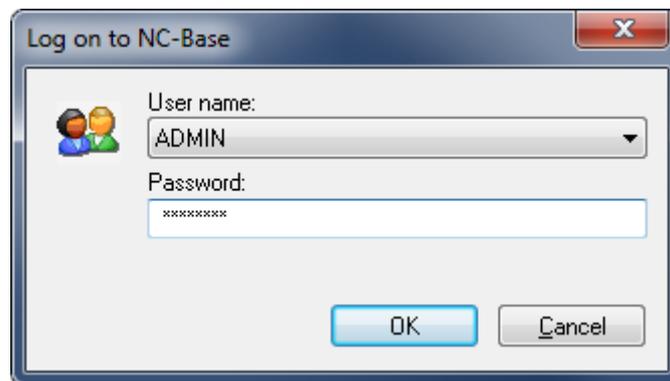


The Database menu.

 Explorer / *Ctrl+E*

Opens the database window.

The following dialog appears to let you log into the database.



Database Login.

Enter your *User name* and *Password* in the corresponding fields and click the OK button.

Further information on User Rights is found under [User Groups](#).

 Logoff

Logs you out from the database.

The NC-Base Explorer closes when you log off from the database.



By default, NC-Base Explorer auto logs you off after 5 minutes. You can specify the auto logout time in the [Client Settings](#) dialog.

 Database Setup

Use this dialog to configure the database.

Click on this icon , or select the  Setup icon in the *Administration* menu to open the database configuration dialog.

Please refer to the section [NC-Base Settings](#) for details.

Search

This section is concerned with the Database Search function. This menu contains the functions described below for file searching.

For more details about the Search settings, please refer to [NC-Base Settings / Search Settings](#).



The Search menu.

Queue

Click on this icon to display a list of all programs on the import queue.



Queued programs are marked with a red cross on the corresponding icon. Programs on the import queue can be accepted or rejected, and only approved programs can be edited. The queue function can only be used with DNC-Max enabled. Programs received by using DNC-Max auto receive or auto import options can be placed on the queue.

Find programs received from CNC's

Click on this icon to display a list of received programs from CNC's that are placed on the queue.



Programs that have been placed on the queue by the CNC machine are designated in the program log with DNCMAX as user.

Find auto imported programs

Click on this icon for a list of auto imported programs that are placed on the queue.



The auto import function can only be used with DNC-Max enabled.

Last 24 Hours

Click on this icon to display a list of programs that have been modified within the last 24 hours.

Find Modified Last 7 Days

Click on this icon for a list of programs that have been modified within the last 7 days.

Locked

Click this option to display a list of all locked programs.



To search for locked programs, the option Use locking system must be activated in the NC-Base Configuration dialog under [Server Settings / Advanced](#).

Find All Unlocked

Click this option for a list of all unlocked programs.



To search for unlocked programs, the option Use locking system must be activated in the NC-Base Configuration dialog under [Server Settings / Advanced](#).

Read/Write

Click on this icon for a list of all read/write programs.



To search for Read/Write programs, the option Use read-only system must be activated in the NC-Base Configuration dialog under [Server Settings / Advanced](#).

Find All Read-only

Click this option to display a list of all read-only programs.



To search for Read-only programs, the option Use read-only system must be activated in the NC-Base Configuration dialog under [Server Settings / Advanced](#).

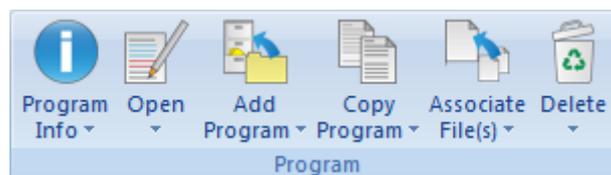
Find Deleted

Click this icon to display a list of all deleted programs.

Program

This section describes the Program menu on the Database tab. The Program menu contains the functions described below for file handling.

For more details about Program settings, please refer to [NC-Base Settings](#).



The Program menu.

Program Info

Shows program info for the selected program(s).



Program Info can be specified for the fields defined in the [Database Settings](#).

You can find additional settings for the automatic reading of the database fields under [Program Format](#).

Copy Program Info

Click this option to copy the program info from the selected program.

Paste Program Info

Click this option to paste the copied program info to the selected program.

Open

Opens the selected file.

Click this icon to open the selected file with the associated file extension application (e.g. *.pdf will open with Acrobat Reader, *.doc with Microsoft Word, etc.).

Open with CIMCO Edit

Opens the selected file in CIMCO Edit.

Click this icon to open the selected files for viewing or editing in CIMCO Edit.

Compare

Compares the selected programs.

Click this option to open the selected files in CIMCO Edit File Compare. When you select two programs and compare them, the corresponding NC programs are usually also compared.

If you want to compare associated files, you must select them. You can compare associated files for different programs.

View Version Report

Views a version report for the selected file.



To view version reports, the option Use versioning system must be activated in the NC-Base Configuration dialog under [Server Settings / Advanced](#).

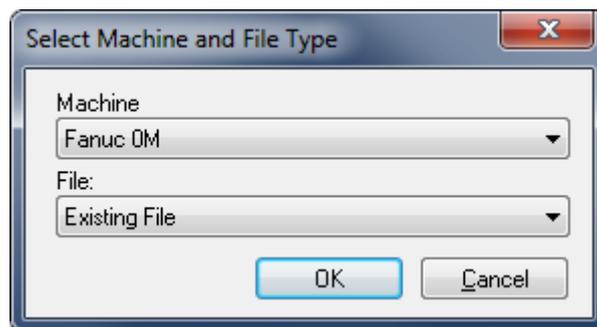
Show File Notes

Shows the file notes.

Add Program

Adds a new program to the database.

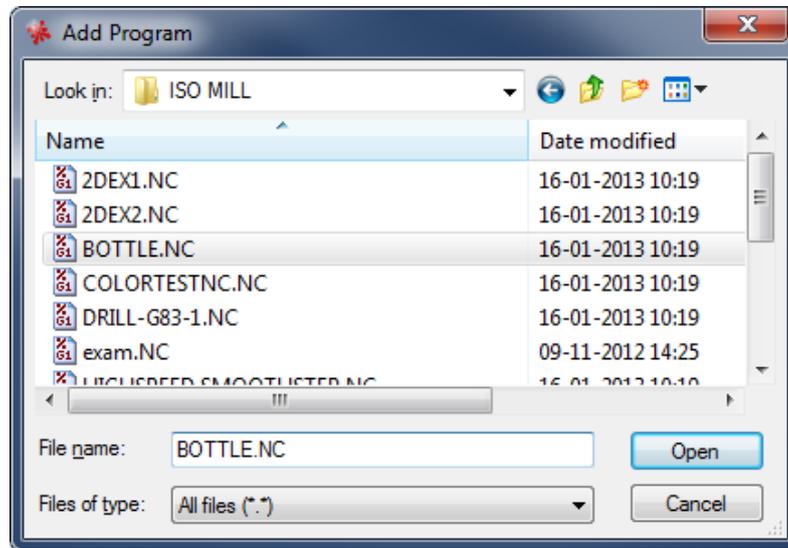
When you click on this icon, the following dialog appears:



The dialog for adding a new program.

- Machine: Select a machine to add to the new program.
- File: Files can be added as follows:

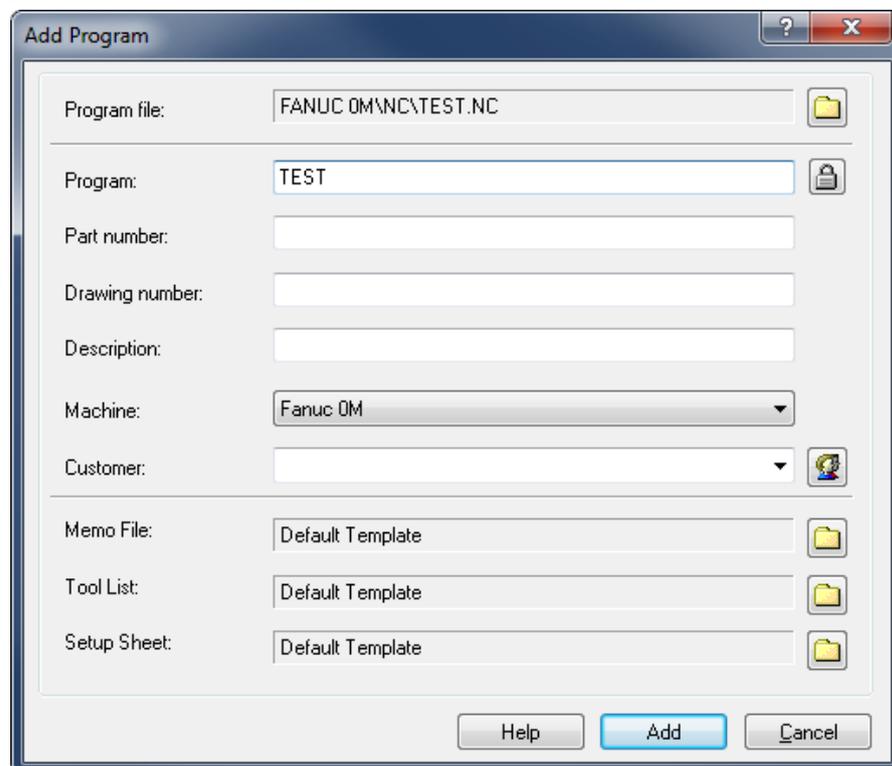
- o Existing File: Adds an existing file to the selected machine group. Select a program and click Open.



Add existing file.

- o New File: Creates an empty file and adds it to the selected machine.

Enter a descriptive name in the input field *Program* and click on Add. If necessary, you can add the file before entering any other information about the file (e.g. customer, status, etc.). Click Cancel to exit the dialog without entering data.



Add new file.

- Empty Mazatrol File: Creates an empty Mazatrol file and adds it to the selected machine. Proceed as described under New File to add the file.



The editor must be licensed for Mazatrol Viewer to use this option.



Add Current Program

Adds program in current window to the database.

Proceed as described under New File to add the file.



Copy Program

Copies the selected program.

Proceed as described under New File to add the file.



Associate File(s)

Associates file(s) to a program.

You can associate any file to the program (e.g. digital pictures in jpeg-format, drawings in pdf-format, etc.).



The preview is active for supported formats such as jpeg, bmp, and pdf, but not for unsupported formats.



Add/Update Memo File

Add/Update new memo file.



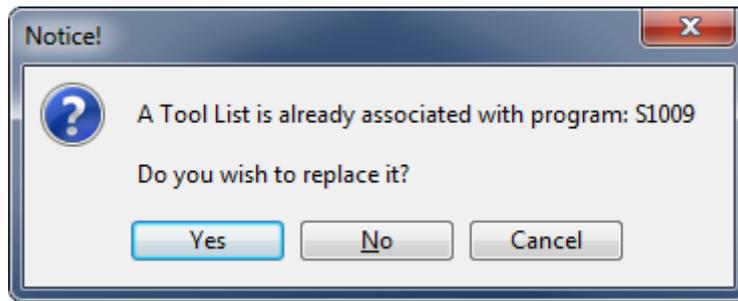
Add/Update Tool List

Add/Update new tool list.



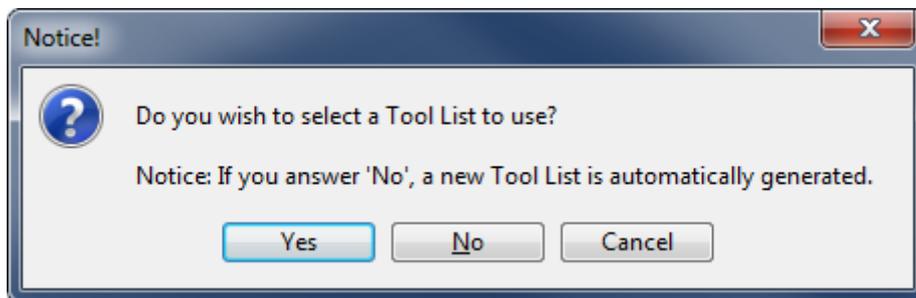
By default, a tool list is automatically generated when adding new programs (can be deactivated by checking the box Disable Tool List in [Server Settings](#) / [Associated Files](#)).

If you want to add a tool list, the following message appears:



Click Yes to replace the existing tool list with a new one. Click No to abort the operation.

If you click Yes, the following message appears:



Click Yes to add an existing tool list. Click No to generate a new tool list automatically. Click on Cancel to exit without any changes taking effect.

Add/Update Setup Sheet

Add/Update new setup sheet.

Please proceed as described above under Add Tool List.

Delete

Deletes selected program(s).



Deleted programs can be restored (please refer to *Restore Deleted Programs* for details).

Purge

Purges selected file(s).



Purged programs can NOT be restored.

 Undelete

Undeletes selected program(s).

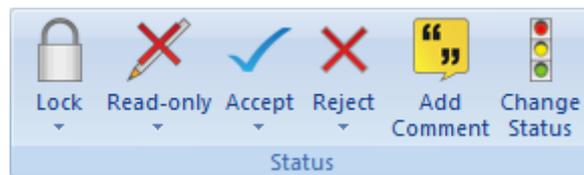


Permanently deleted programs can NOT be restored.

Status

This section describes the Status function. The Status menu contains the functions described below for file processing.

Please refer to section [NC-Base Settings / Server Settings](#) for further information.



The Status menu.

Lock

Locks the selected program(s).



Locked programs cannot be transferred to CNC machines. To lock a program, go to [Server Settings / Advanced](#), and check the field Use locking system.

Unlock

Unlocks selected program(s).

Read-only

Marks selected program(s) as read-only.



When a program is marked as read-only, it can be simulated (in Backplot) but not edited. To use this option, check the field Use read-only system under [Server Settings / Advanced](#).

Read/Write

Sets selected program(s) read/write.

Accept

Accept imported file.

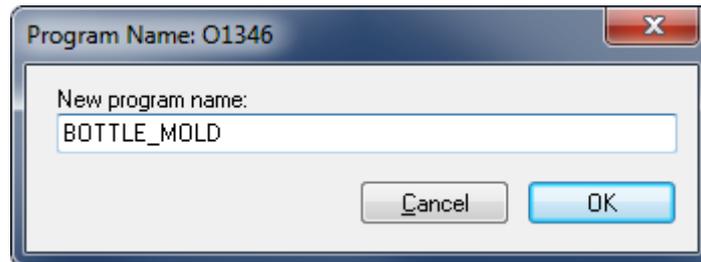
Click this option to accept the imported file under the name defined in DNC-Max auto receive or auto import.



Programs on the import queue can be accepted or rejected. The queue function can only be used with DNC-Max enabled (see also [Search / Queue](#)).

Accept Imported File As

Accept imported file under a different name. The following dialog appears:



Enter a new program name and click OK. Click on Cancel to exit without entering a new filename.

View Imported File

Shows a preview of the imported program. This function allows you to view the file before accepting or rejecting it.

Compare with Imported File

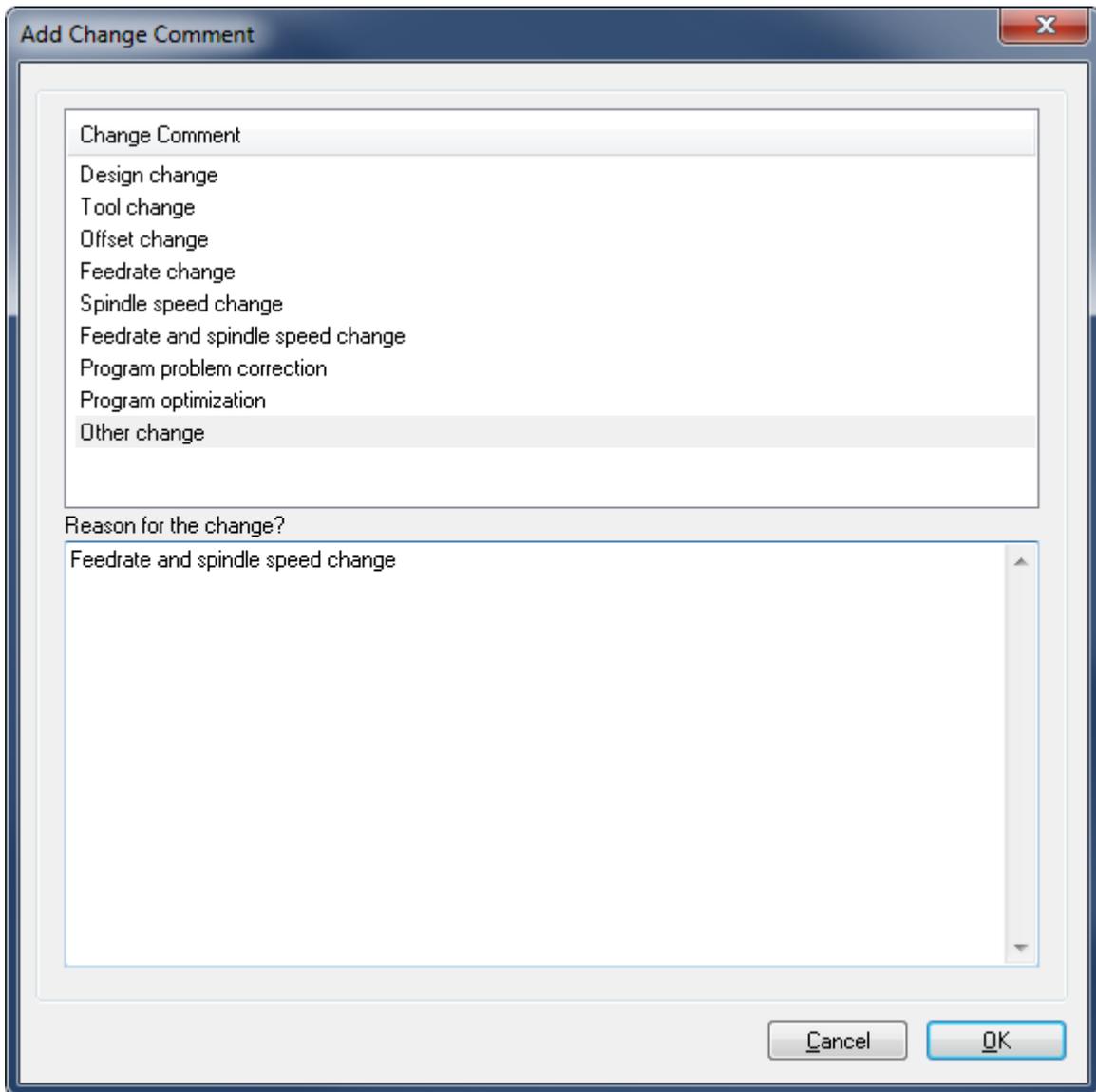
Compares the imported file with a program on the queue. This allows you to view the file before accepting or rejecting it.

Reject

Reject imported file.

Add Comment

Add change comment to the selected program. The following dialog appears:



Add change comment.

In the field *Change Comment*, select a comment and click OK to insert it. To add your own comment, select *Other change*, enter your comment in the field *Reason for the change?* and click OK. To cancel the operation, click Cancel.

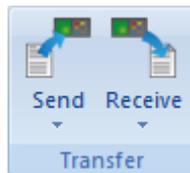
Change Status

Click this option if you wish to change the program status.

Transfer

In this section, the Database Transfer command is described. The Transfer menu contains the functions described below for file transfer.

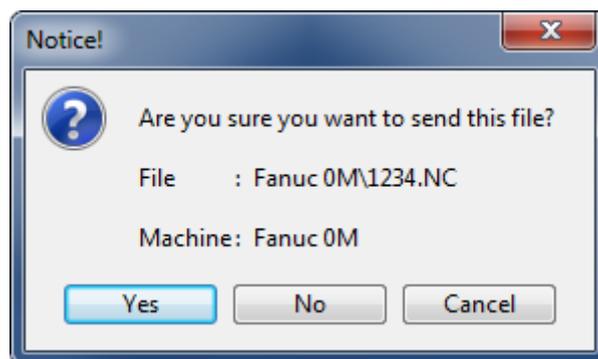
Information on the Transfer settings is found under [NC-Base Settings](#).



The Transfer menu.

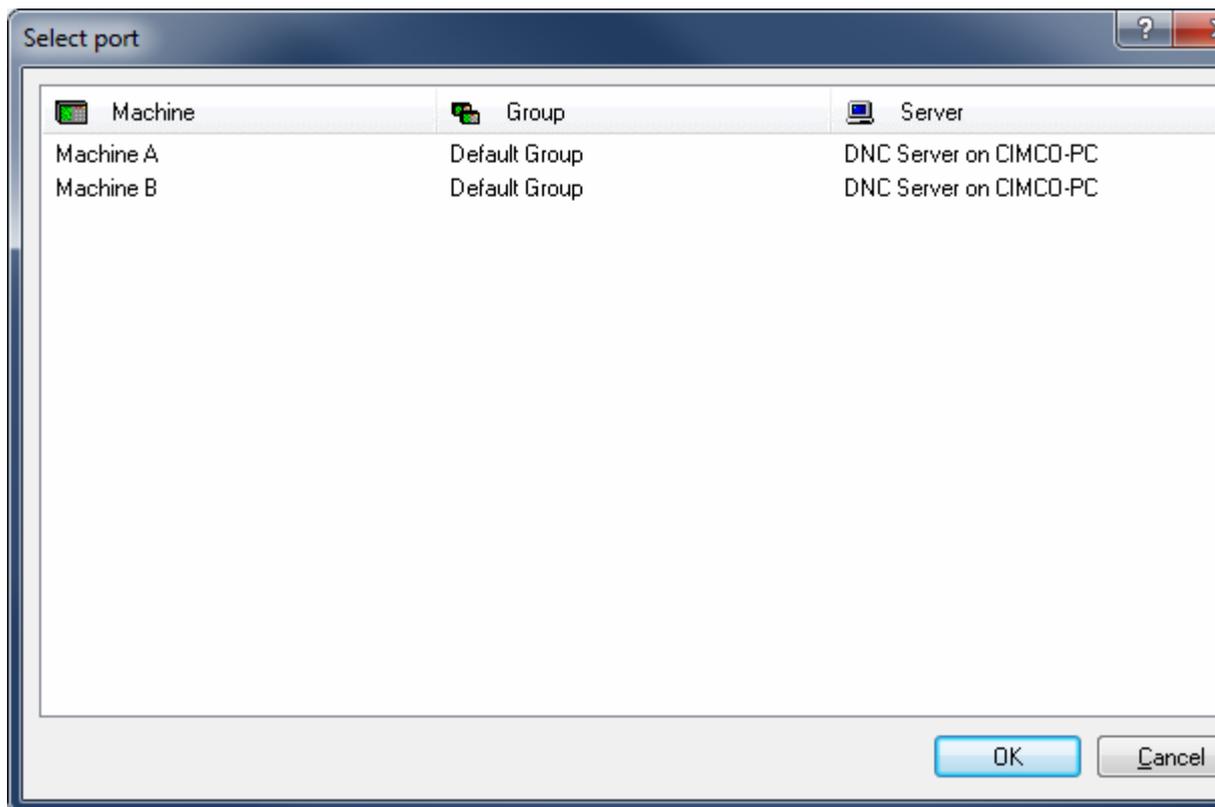
Send

Sends the selected program(s). When you click on this icon, the following message appears:



Click Yes to send the file. If you want to cancel the operation, click No.

If multiple CNC machines are associated with an NC-Base machine group, you must first select a machine in the *Select Port* dialog below:



Select a machine for the transmit operation.

Click finally on OK in the dialog *Info, file set on the transmit queue*.



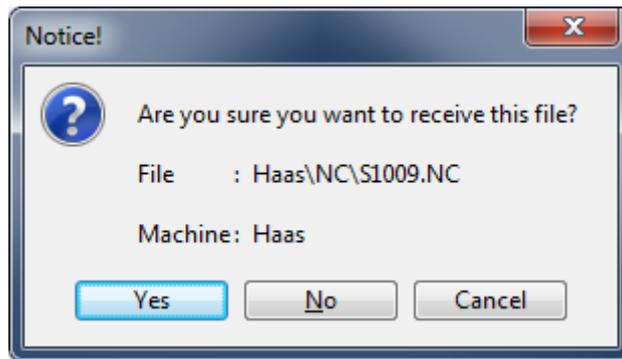
You need DNC-Max to send NC programs, and DNC-Max must be configured for this operation. It is also possible to send programs from NC-Base using the DNC module of the Editor (optional). Please contact your local dealer for information about the required DNC settings.

Stop current DNC Transfer

Stops the current DNC transfer (only when using the Editor DNC Option).

Receive

Receives the selected program(s) in the database. Existing files are overwritten. When you click on the Receive icon, the following message appears:



Click Yes to receive the file. To cancel the receiving process, click No.

If multiple CNC machines are associated with an NC-Base machine group, you must first select a machine in the *Select Port* dialog.

Click finally OK in the dialog *Info, file set on the receive queue*.



You need DNC-Max to receive NC programs, and DNC-Max must be configured for this operation. If DNC-Max is in use, the NC programs are normally received automatically. It is also possible to receive programs in NC-Base using the DNC module of the Editor (optional). Please contact your local dealer for information about the required DNC settings.

Receive New Program

Receives a program in a new window.

Backup

This section is concerned with the Database Backup function. This menu contains the functions described below for database backup and restore.

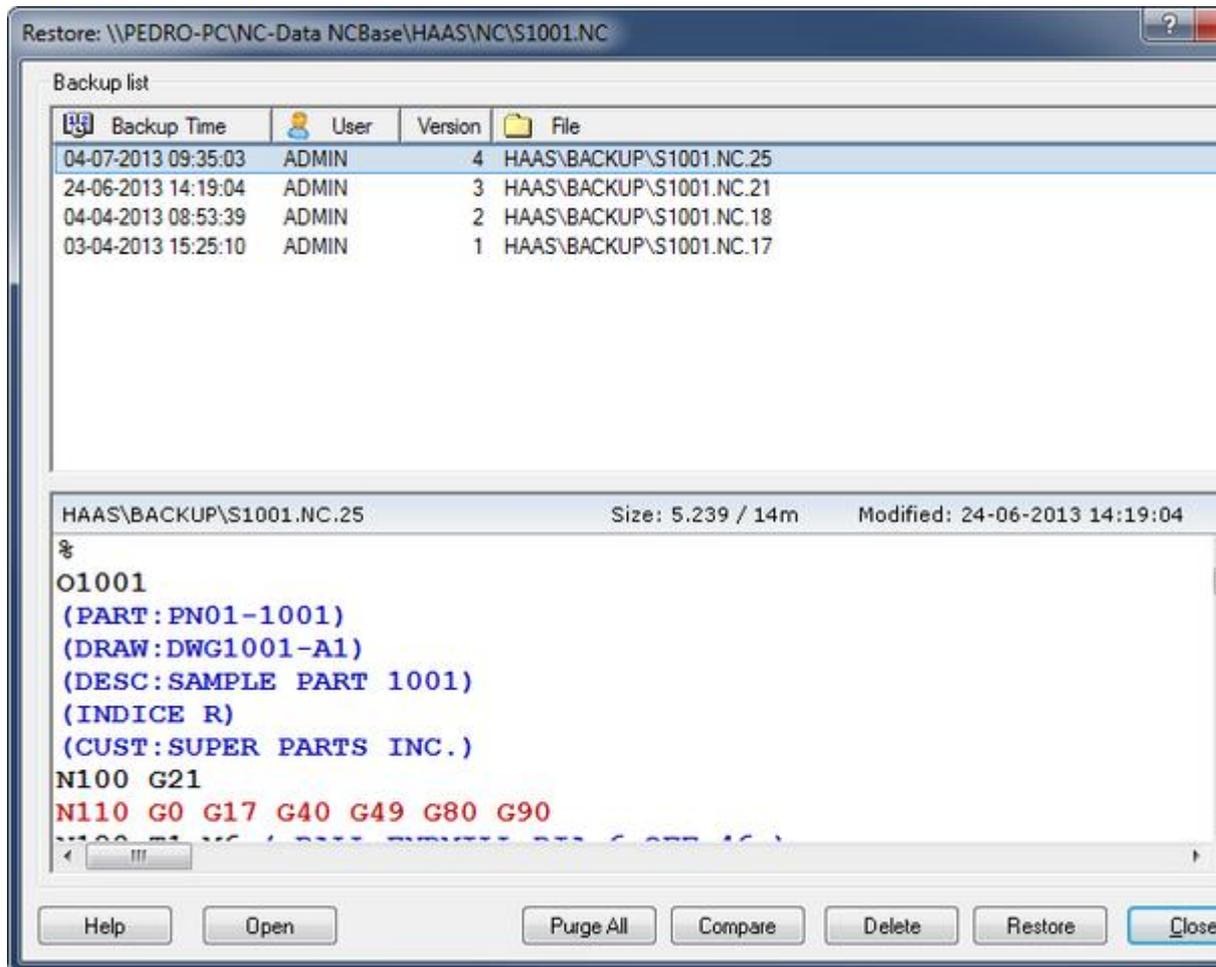
Please refer to [NC-Base Settings / Backup](#) for further information.



The Backup menu.

Restore

Restores the selected program. Clicking on this icon will open the following dialog (example).



The Restore dialog.

Help Button

Opens the NC-Base help file.

Open Button

Opens the selected backup file in the editor.

Purge All Button

Deletes all listed backups.

Compare Button

Compares the selected backup with the current version.

Delete Button

Deletes the selected backup.

Restore Button

Restores the selected backup.

Close Button

Closes the backup dialog.

Restore Latest

Restores latest backup of the selected program(s).



The latest created backup is restored.

Compare With Latest Backup

Compares the selected file with the latest backup.

Backup

Makes a backup of the selected program(s).

Customer

This section describes the Database command Customer. The Customer menu contains functions described below for customer managing.

Information on Customer settings is found under [NC-Base Settings](#).



The Customer menu.

Add Customer

Click this icon to add a new customer to the database. The following dialog appears:

The image shows a software dialog box titled "Add customer". It features a standard Windows-style title bar with a help icon and a close button. The dialog is organized into two main sections: "Customer Info" and "Contact Info".

The "Customer Info" section includes the following fields:

- Customer: (text input)
- Address: (two stacked text input lines)
- City: (text input) and St/Prv: (text input)
- Zip/Postal code: (text input) and Country: (text input)
- Telephone: (text input) and Fax: (text input)
- Homepage: (text input) with a home icon to its right.

The "Contact Info" section includes the following fields:

- Name: (text input)
- Telephone: (text input)
- Email: (text input) with an email icon to its right.

At the bottom of the dialog, there are three buttons: "Help", "Add", and "Cancel". The "Add" button is highlighted with a blue border.

Add customer.

Enter the customer data in the corresponding fields and close the dialog by clicking on Add. If you want to exit without entering data, click on Cancel.

Modify Customer

Click this option to modify the data of the selected customer. A dialog which is similar to the *Add customer* dialog appears, although with the title *Modify customer*. Select the customer you want to modify from the drop-down list and click Modify to enter new customer data. Click OK to apply the changes, or click Cancel to abort the operation.

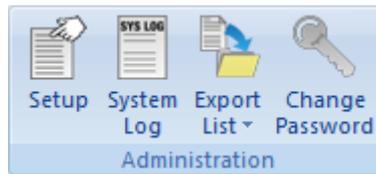
Delete Customer

Click this option to delete a customer from the database.

Administration

In this section, the Database Administration command is described. The below mentioned functions are used for system administration.

Information on how to configure this function is found under [NC-Base Settings](#).



The Administration menu.

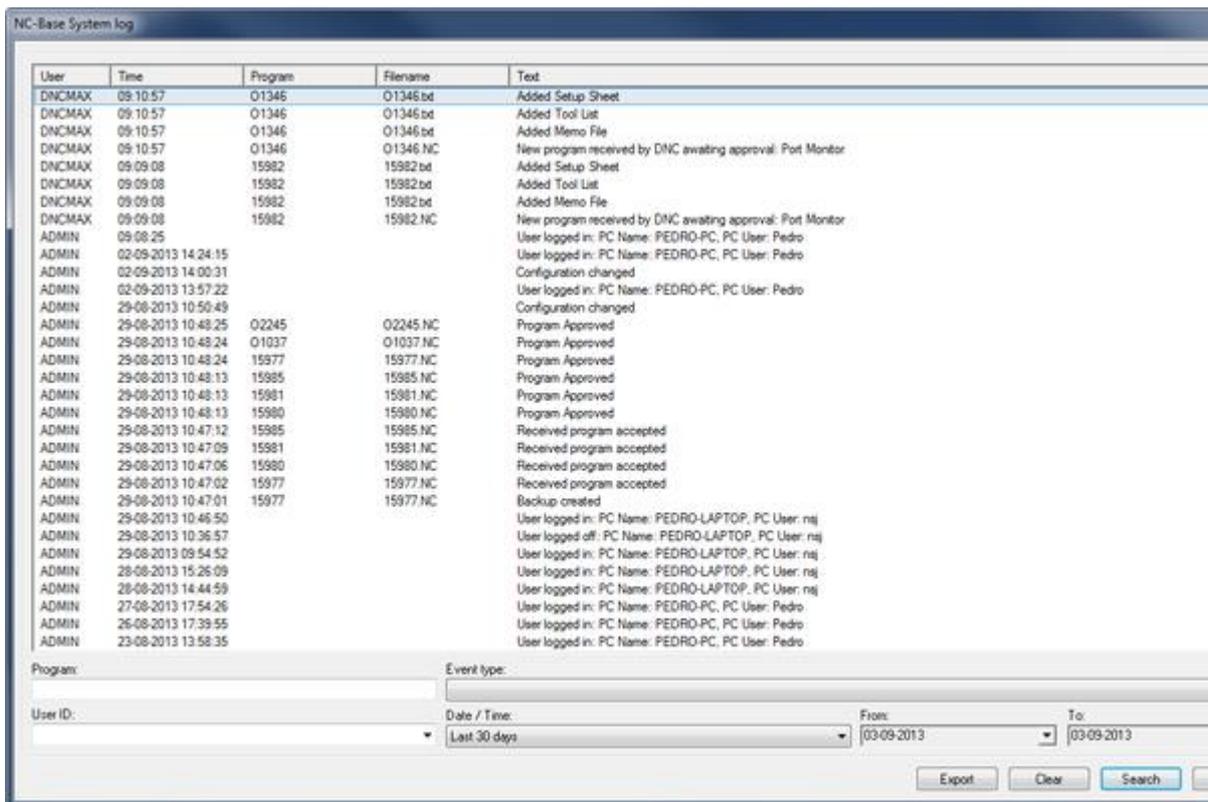
Setup

Click this icon to configure the database.

Please refer to the section [NC-Base Settings](#) for more information on how to configure the database.

System Log

Opens the system log browser.



System Log.

abc

Program

Use this field to specify a program name.

Example: To find all events for the program MOULD1, specify MOULD1 in this field. To find all events for programs containing MOULD in the program name, specify *MOULD*.



Wildcards are allowed.

abc ▾

User ID

Specify the user info in this field.



Wildcards are allowed.

Event type

Use this field to specify the type of event. Select the blank field to display all types of events.

Date / Time

Use this field to specify dates that should be searched.

From

Use this field to specify the date that should be searched.

To

Use this field to specify the date that should be searched.

Export

Click this button to export the log file.

Clear

Clears all search fields.

Search

Click this button to show the NC-Base system log.

Exit

Closes the log window.

 Export List

Click this option to export current search to a file.

 Print Program List

Prints the result of current search.

 Change Password

Click this icon to change your password.

NC-Base Database

In this section you will find general information about the functions and settings of the NC-Base interface, as well as information on setting up search criteria to find programs in the database.

With NC-Base v7, a system for information storing and transferring is at your disposal, which makes it possible for you to search for programs without necessarily knowing all details about them. An example of such a database could be the search system of a common library: The books in the shelves are sorted by the names of the authors. If you know only the title of the book, it may result in a long search through the bookshelves. A database allows you to search for certain book using the title as search key, the result in this case being the name of the author, or you could enter the name of the author as search key and the result would be all titles by this author to date.



- [The NC-Base Explorer](#)
- [Search for Programs](#)

The NC-Base Explorer

NC-Base v7 consists of two applications: The NC-Base Server (no user interface, runs in the background as a service) and the NC-Base Client (NC-Base Explorer).

The function of the NC-Base Server is primarily the data storage and the actual data processing, e.g. the search for specific programs.

The NC-Base Explorer serves as user interface for the service provided by the NC-Base Server, thus enabling the entering of search criteria, as well as the (graphical) presentation of the results, the further processing of programs, and the possibility of program data modification.

Using the Explorer, you can perform operations like *Program search*, *Add program*, *Associate file(s)*, *Lock program*, *make Backup*, *Add customer*, *Send program*, etc.

Edit program files

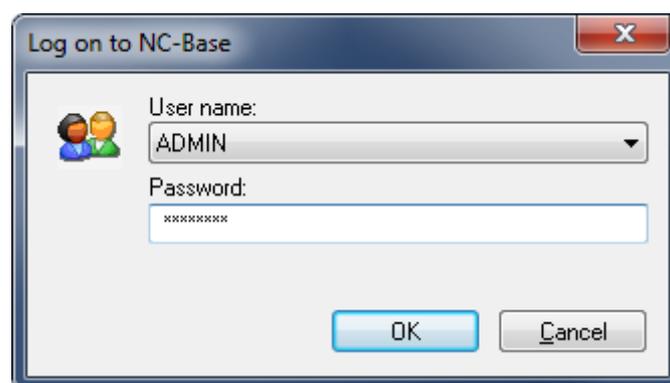
The NC-Base Explorer allows the editing of NC programs in the CIMCO Editor, as well as the modification of associated files by means of applications outside NC-Base, normally used when opening these files. Depending on the configuration of your PC, only a double-click on the file is needed to start the corresponding application. From there, you edit your file as you normally would and click Save, and all changes will be assumed by the database.



Do not save the file clicking *Save As...* If the file is saved in another directory, the modified data will not be stored in the database.

Start NC-Base Explorer

To start NC-Base Explorer, click on the  Explorer icon in the *Database* menu. The following window will appear:



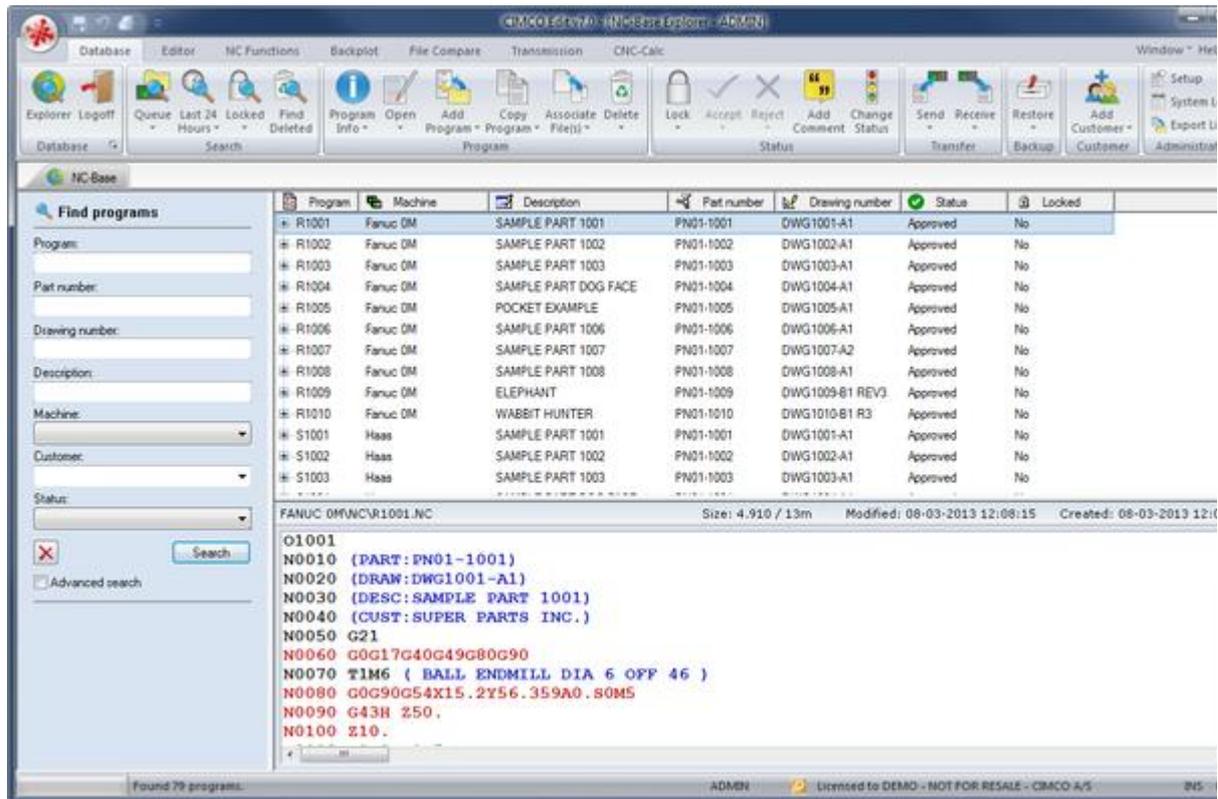
Login window.

Enter your *User name* and *Password* in the corresponding fields and click OK.



Further information on the assignment of user permissions is found under [User Groups](#).

The following window appears:



NC-Base Explorer.

Common information

The NC-Base Explorer consists of two parts: On the right a preview field and a tree structured presentation of all programs for showing table contents, and on the left fields for entering search criteria.

Program search

The fields *Program*, *Machine*, *Customer*, and *Status* are predefined (see following picture).

NC-Base

Find programs

Program:
[Text Input Field]

Machine:
[Dropdown Menu]

Customer:
[Dropdown Menu]

Status:
[Dropdown Menu]

[Red X Icon] [Search Button]

Advanced search

Program Search.

Program search with customised search fields

If you have defined *Text field 1*, *Text field 2*, *Text field 3*, etc. in [Database Settings](#), these fields will be recognised as search fields (see following picture).

NC-Base

Find programs

Program:
[Text field]

Text field 1:
[Text field]

Text field 2:
[Text field]

Text field 3:
[Text field]

Text field 4:
[Text field]

Machine:
[Dropdown menu]

Customer:
[Dropdown menu]

Status:
[Dropdown menu]

[Search button]

Advanced search

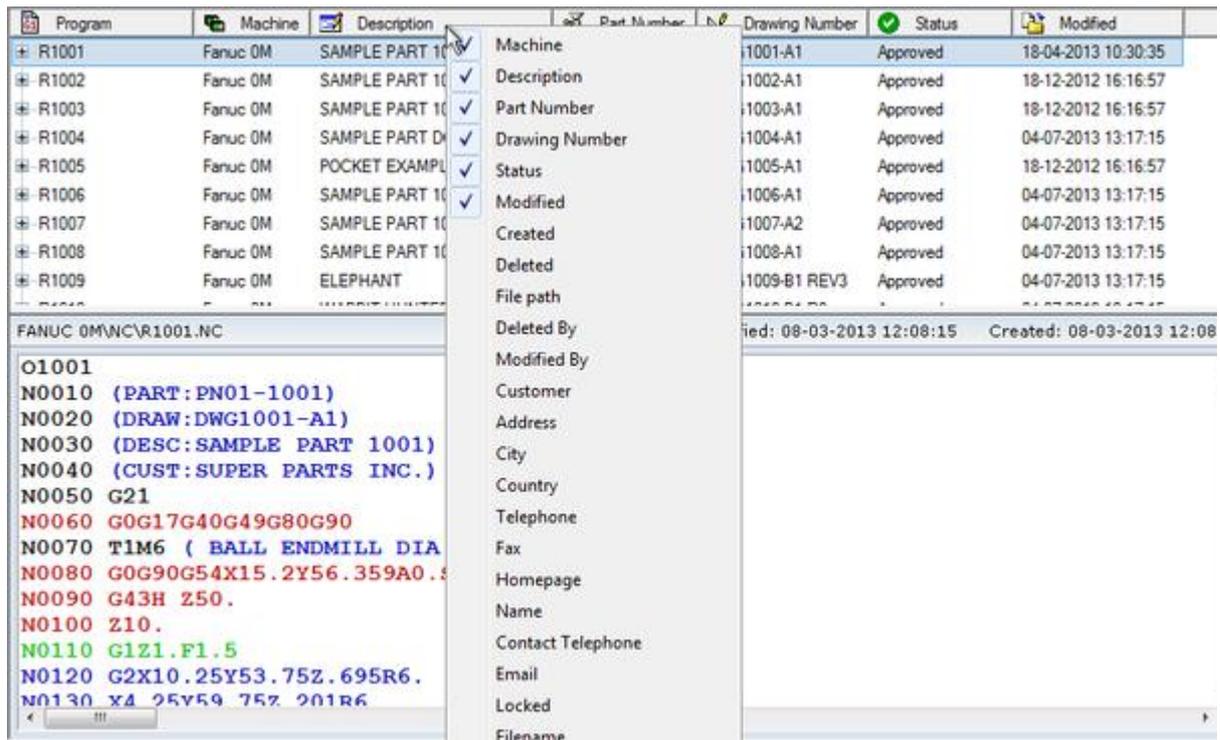
Program search with customised search fields.



You can specify up to 9 customised search fields.

Preview

If you highlight an NC program or an associated file in the NC-Base search result window to the right, the contents will be displayed in a separate window below the search result window (see the following picture).



Add/remove columns.

In the context menu, which appears when right-clicking the title bar, you can check and uncheck a column title to make it appear in or disappear from the Explorer search result window.

Column order

You can easily change the column order by clicking a column title and dragging it to a new position.



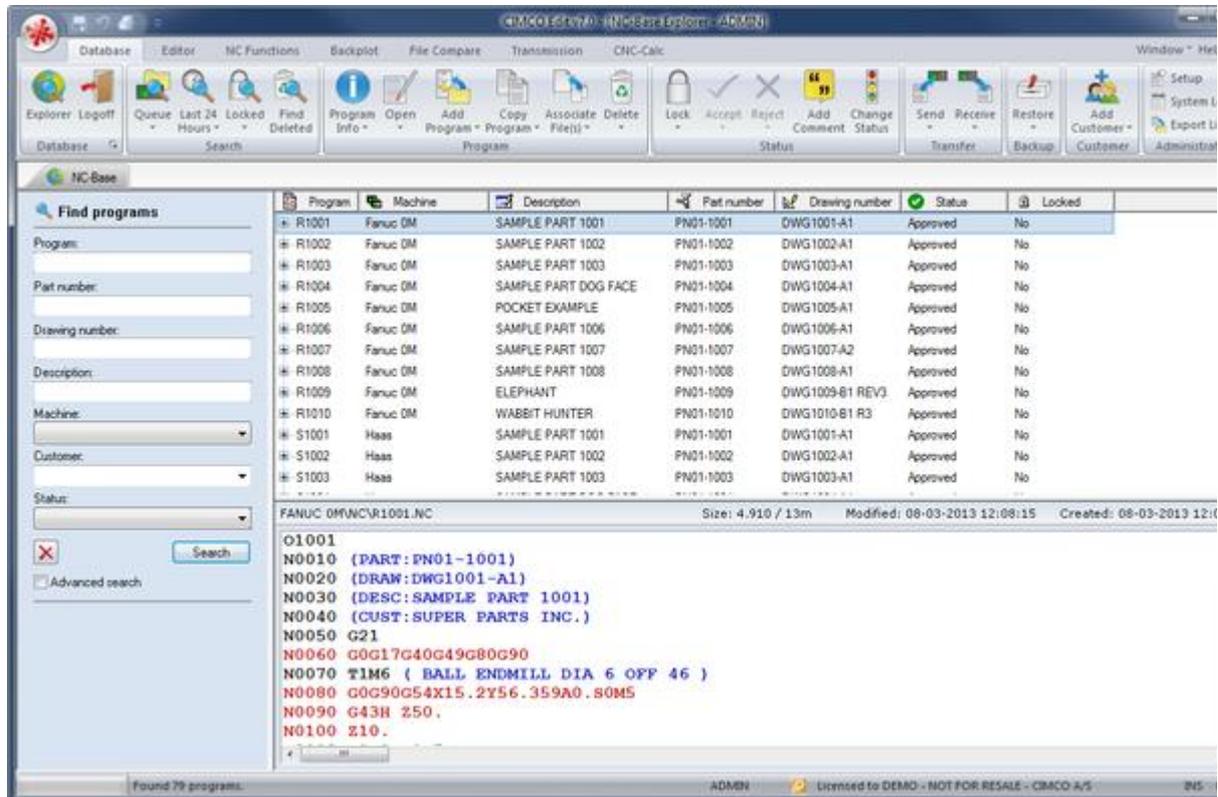
You can click and drag between column titles to adjust the width of the nearest column to the left.

Search for Programs

In this section, you will find information on how to enter search criteria to find programs in the database.

By entering search criteria in the fields *Program*, *Machine*, *Customer*, etc., you can make a search for specified programs. Using wildcards like ? (for any unspecified character) and * (for a string of unspecified characters) you can limit the search to come up with programs having certain character strings in common.

You must be logged on to search for a program in NC-Base. To do this, select Explorer in the Database menu to start the NC-Base Explorer. In the Logon dialog, enter your User name and Password and click OK. The following window appears:



NC-Base Explorer.

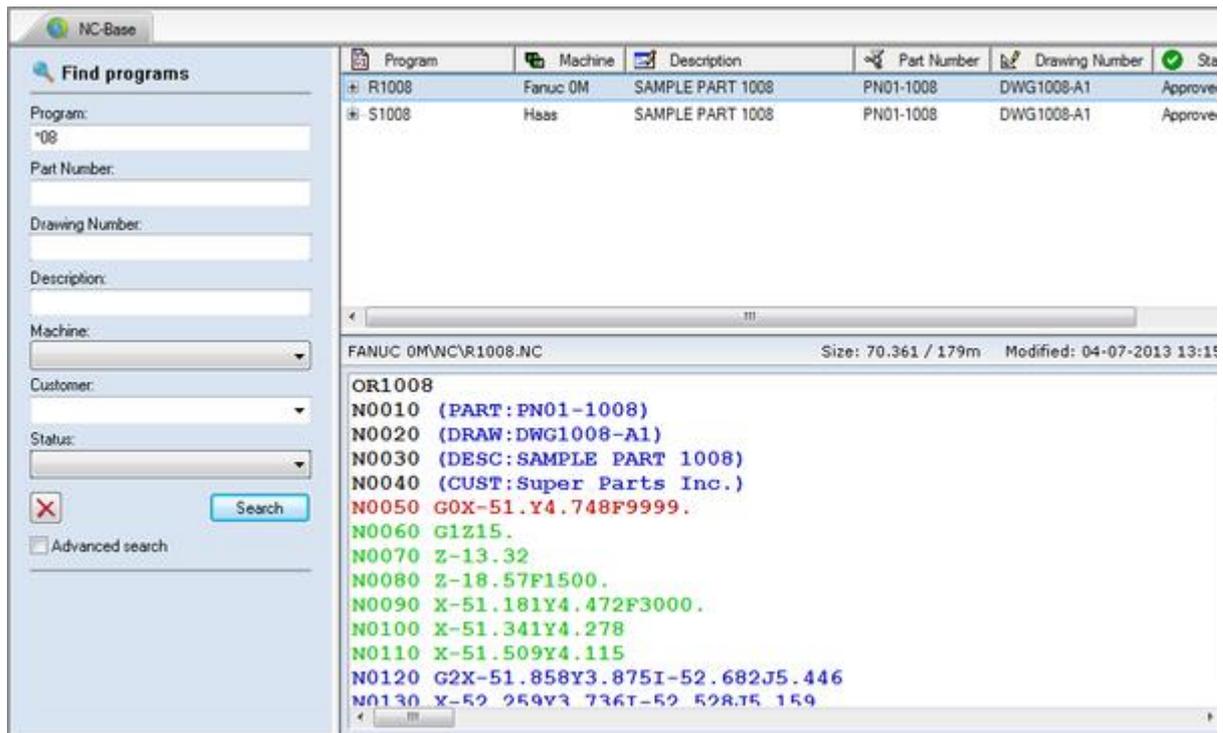
Search for programs

A search can be simple or complicated, narrow or broad. A "successful" search (user finds all information needed) should be simple and broad.

In the Program Search window, you can enter part or all of the search term. If a field is left empty, it will not be included in the search criteria. You can thus enter search terms into one, some, or all of the fields, as well as select machine group, customer, and status from the drop-down lists.

When the desired search terms have been entered, click Search.

All programs matching the search criteria will be shown in the search result window, as shown in the following example:



Click on Clear  if you wish to clear the search fields.

Advanced search

In NC-Base v7 you can extend the search to include groups of data not defined by field names. Check the field Advanced search to activate the extended search options. The following window will appear:

The screenshot shows the 'Find programs' search results in the NC-Base software. The search criteria are: Program: R1005, Part Number: PN01-1005, Drawing Number: DWG1005-A1, Description: POCKET EXAMPLE, Machine: Fanuc 0M. The search results are displayed in a table with columns for Program, Machine, Description, Part Number, Drawing Number, and Status. Below the table, the content of the program file 'R1005.NC' is shown, including a list of G-code lines such as 'O1015', 'N0010 (PART:PN01-1005)', 'N0020 (DRAW:DWG1005-A1)', and various G0, G1, G2, G3 lines with coordinates and tool numbers.

All Fields

Use this field to specify a search string that should match any of the fields.

Program filename / description / memo

Use this field to specify a search string that should be matched. All programs with a program file that matches the specified name are found.



All filenames that contain the specified string are matched.

All filenames / descriptions / memos

Use this field to specify a search string that should be matched. All programs with a program or associated file that matches the specified name are found.



All filenames that contain the specified string are matched.

Content of program files

Use this field to specify a search string that should be matched inside program files.

Content of all files

Use this field to specify a search string that should be matched inside files.

Date

Performs a search for files that are created and/or modified within the time period specified below.

- *Do not search by date:* A search for programs without considering the dates of their modification or creation (the options Between and and are disabled).
- *Created and Modified time:* A search for programs created and modified within the dates specified in the Between and and fields.
- *Created time:* A search for programs created within the dates specified in the Between and and fields.
- *Modified time:* A search for programs modified within the dates specified in the Between and and fields.

Locked

Use this field to search for either locked or unlocked programs.

- *All:* A search for locked and unlocked programs.
- *Yes:* A search for locked programs.
- *No:* A search for unlocked programs.
- *Imported on queue:* A search for locked or unlocked programs on the import queue.

Read-only

Use this field to search for programs that are either read-only or read/write.

- *Both*: A search for read-only and read/write programs.
- *Yes*: A search for read-only programs.
- *No*: A search for read/write programs.

Deleted

- *Both*: A search for deleted and not deleted programs.
- *Yes*: A search for deleted programs.
- *No*: A search for not deleted programs.
- *Deleted on date*: A search for programs deleted within the dates specified in the Between and and fields below.

Programs without a machine

Check this box to search for programs that are not linked to a machine group.

Programs without a customer

Check this field to search for programs that are not linked to a customer.

NC-Base Settings

This section describes in details the configuration of the NC-Base database, including Client Settings, Server Settings, User Permissions, Passwords, Machine Groups, etc. The configuration of the database depends on which machine is to be connected to it, where programs and associated files should be stored, which user should have access and with which permissions, etc.



In order for you to be able to configure the database, you must be permitted access as system administrator and have access to the PC where the NC-Base Client is installed.

When you start to configure the database, you will be prompted to enter your password.



- [Client Settings](#)
- [Server Settings](#)
- [Machines](#)
- [User Groups](#)
- [Database Settings](#)
- [Maintenance](#)
- [Backup](#)
- [Predefined Fields](#)

Client Settings

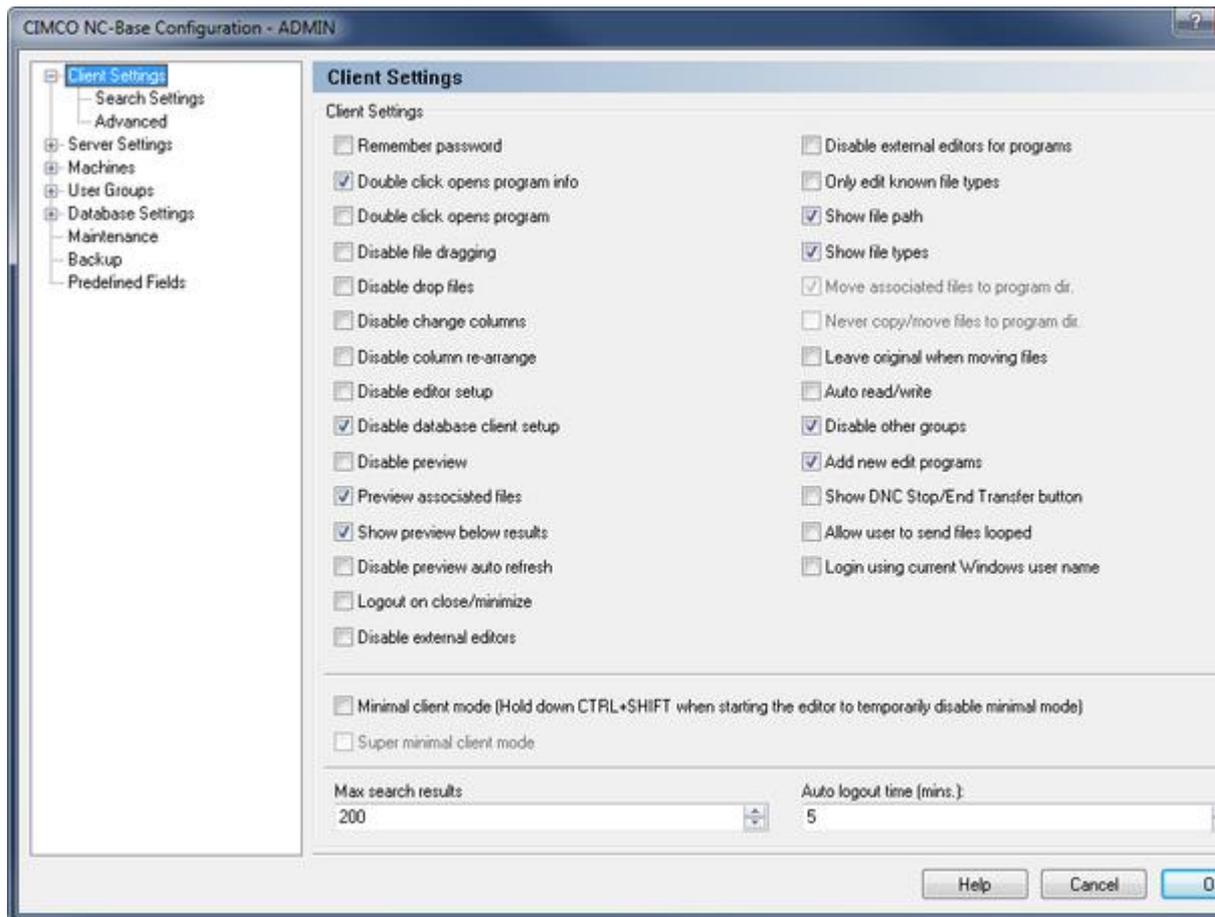
In this section, it is described how to set up and use the NC-Base Client (NC-Base Explorer) functions.



- [Search Settings](#)
- [Advanced](#)

The NC-Base Client is the user interface of the NC-Base Server.

To configure the Client, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. This will open the CIMCO NC-Base Configuration window. Select Client Settings from the left hand list. The following dialog appears:



Client Settings configuration dialog.

- Remember password

Check this field to log in automatically.



Selecting this option will render the properties of the *Auto logout* function inactive.

- Double-click opens program info

With this field checked, the dialog *Program Info* will start when a program is double-clicked.

- Double-click opens program

With this field checked, you can open and edit the program file with a double-click.

- Disable file dragging

Check this field to disable file dragging. With this option selected, the user cannot copy or move associated files between programs by Drag'n'Drop.

Disable drop files

Check this field to disable drop files. With this option selected, the user cannot copy or move program files or to-be associated files into the database by using Drag'n'Drop.

Disable change columns

Check this field to disable the function *Change columns*. With this option selected, the user cannot change which columns are displayed in the search window.

Disable column re-arrange

Check this field to disable the function *Column re-arrange*. With this option selected, the user cannot change the order of the columns in the NC-Base search window.

Disable editor setup

Check this field to disable the editor configuration dialogs. This limitation should not be imposed on users with Administrator access.

Disable database client setup

Check this field to disable the NC-Base client configuration dialogs, unless the user has Administrator access.

Disable preview

Check this field to disable the preview window.

Preview associated files

Check this field to enable the preview of associated files.

Show preview below results

Check this field to show the preview below the search results.

Disable preview auto refresh

Check this field to disable auto refresh of the preview windows. You should check this field if other programs have problems accessing files when they are opened from NC-Base.

Logout on close/minimize

Check this field to logout from the database when minimizing the editor.

Disable external editors

Check this field to disable external editors. All files are then viewed or edited using CIMCO Edit.

Disable external editors for programs

Check this field to disable external editors for all program files. When this option is selected, program files will always be edited/viewed with CIMCO Edit.

Only edit known file types

Check this field if users should only be allowed to edit known file types.



To add new file types to the editor, go to the *File types* setup sheet in the editor configuration window.

Show file path

Check this field to show the file paths of associated files in the search window.

Show file types

Check this field to show the file types of associated files in the search window.

Move associated files to program directory

Check this field if files should automatically be moved to the machine directory, when they are associated with an existing program.

Never copy/move files to program directory

Check this field if files should never be copied/moved to the program directory, when they are associated with an existing program.

Leave original when moving files

Check this field if you wish to copy files to the program directory, leaving the original.

Auto read/write

Check this field if programs should automatically be set to read/write mode when opening the program file or an associated file for editing.

Disable other groups

Check this field if machine boxes should show only allowed machines.

Add new edit programs

Check this field if all new programs created in the editor should be added to the database.

Show DNC Stop/End Transfer button

Check this field to show the *DNC Stop/End Transfer* button on the NC-Base toolbar.

Allow user to send files looped

Check this field to allow users to send files looped. When a file is sent in a loop operation, DNC-Max will repeat the file transfer until the transfer is stopped by the operator.

Login using current Windows user name

Check this field to use the current Windows user name as login when NC-Base is first started. When this option is checked, the user does not have to specify a password.

Minimal client mode

Check this field to enable the Minimal client mode. In Minimal client mode, the setup menu etc. is not available so you have to hold down *Ctrl+Shift* when starting the editor to temporarily disable minimal mode.



You must restart the editor to activate this function.

Super minimal client mode

Check this field to enable the Super minimal client mode. In this mode no editing functions are available.



You must restart the editor to activate this function.

Max search results

Enter the maximum search results.

Auto logout time (mins)

Enter the time in minutes before automatic logout. To deactivate the automatic logout, specify 0 in this field.

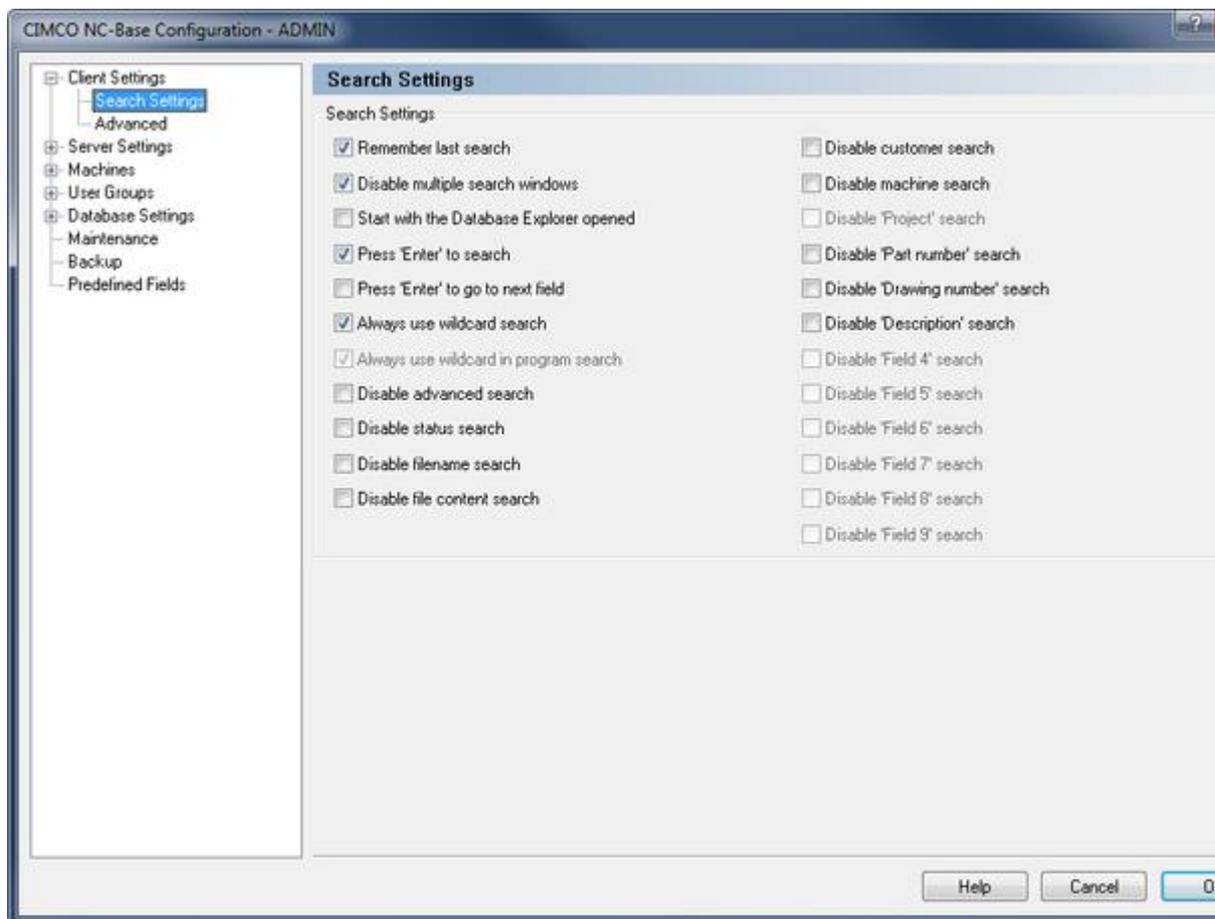


This option is not available when the option *Remember password* is enabled.

Search Settings

This section describes how to configure and use the Search Settings functions.

To configure Search Settings, select Setup in the *Administration* menu, or click the Setup dialog launch icon in the *Database* menu. The CIMCO NC-Base Configuration window appears. Click on Client Settings in the left hand list and select Search Settings. The following dialog appears:



The Search Settings dialog.

Remember last search

Check this field to store the latest search made.

Disable multiple search window

Check this field to deactivate the function Multiple Search Windows. With this option selected, the user can open only one search window at a time.

Start with the Database Explorer opened

Check this field if the Database Explorer should be opened automatically when the editor is started.

Press 'Enter' to search

Check this field if you wish to start the search when you hit Enter in the search window.

Press 'Enter' to go to next field

Check this field if you wish to move to the next field in the search window when you hit Enter.

Always use wildcard search

Check this field to always use wildcard searches. When this option is selected, a search will match any field that contains the specified string, instead of any field that matches the specified string.

Always use wildcard in program search

Check this field to always use wild card when searching program names.

When this option is selected, a search will match any program that starts with the specified string, instead of any program that matches the specified string.

Disable advanced search

Check this field to disable the advanced search options.

Disable status search

Check this field if you do not wish to search for programs with a specific status.

Disable filename search

Check this field if you do not wish to perform searches using filenames.

Disable file content search

Check this field if you do not wish to search for file contents.

Disable customer search

Check this field if you do not wish to search using customer names.

Disable machine search

Check this field if you do not wish to search after programs for specific machines.

Disable 'Project' search

Check this field if you do not wish to make searches using the 'Project' field.

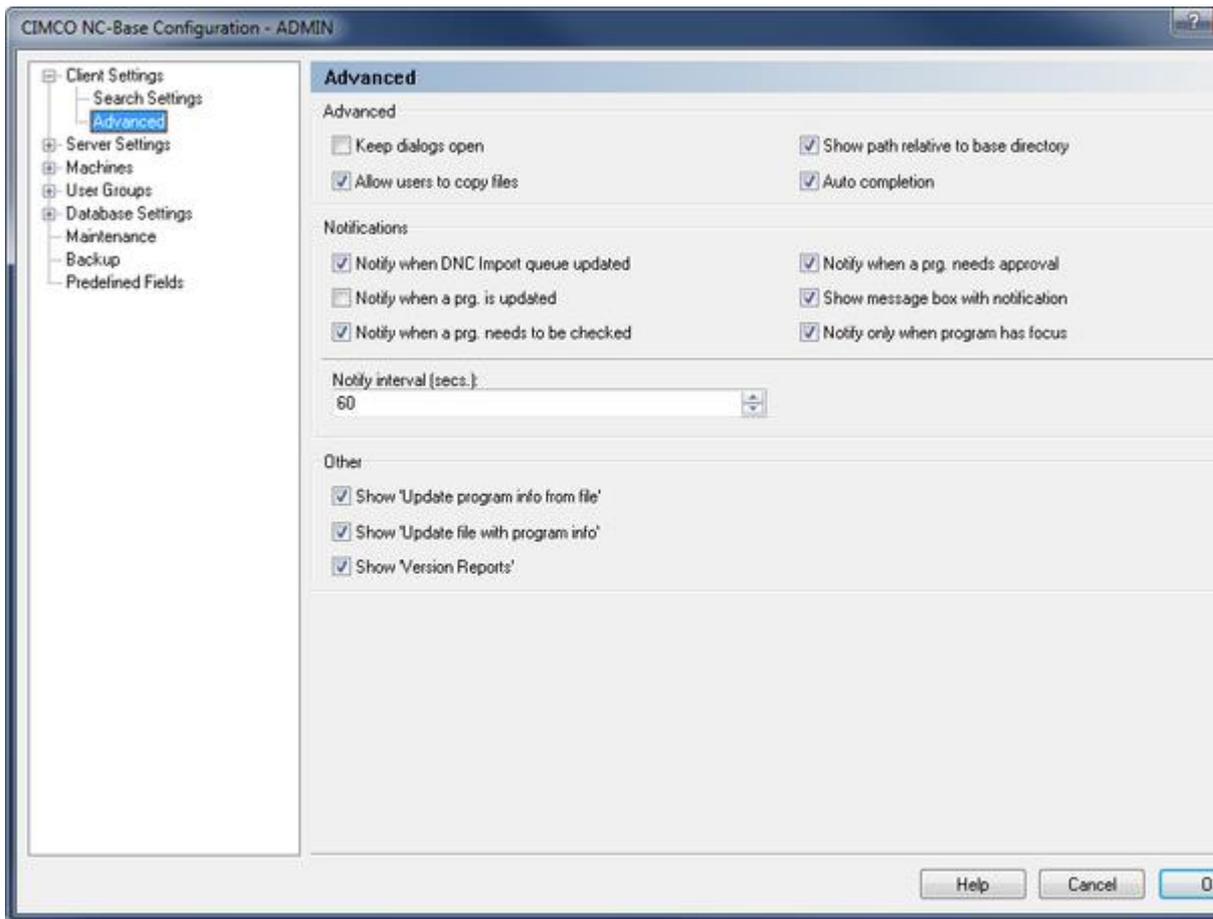
Disable 'Field 1, 2, 3...' search

Check this field if you do not wish to perform searches using the database custom fields.

Advanced

This section describes how to set up and use the Advanced functions.

To configure the Advanced settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. The CIMCO NC-Base Configuration window appears. Click on Client Settings in the left hand list and select Advanced. The following dialog appears:



The Advanced dialog.

Keep dialogs open

Check this field to keep dialogs open. When this option is selected, the customer and program dialogs will stay opened after adding a new entry. This makes it easier to add multiple programs/customers.

Allow users to copy files

Check this field to allow the user to copy files to another location, like a floppy or other drive.

Show path relative to base directory

Check this field if filenames should be displayed relative to the base directory.

Example: If the base directory is N:\NCBASE, then the file N:\NCBASE\FANUC3\MOULD.NC is shown as FANUC3\MOULD.NC.

Auto completion

Check this field to enable the function *Auto completion*.



If you have a slow network/computer, you should disable this option.

Notify when DNC Import queue updated

Check this field if a notification sound should be played, when one or more programs have been imported.

Notify when a program is updated

Check this field if a notification sound should be played, when one or more programs have been updated.

Notify when a program needs to be checked

Check this field if a notification sound should be played, when one or more programs need to be checked.

Notify when a program needs approval

Check this field if a notification sound should be played, when one or more programs need approval.

Show message box with notification

Check this field if a notification message box should be shown, when one or more programs need to be accepted/checked/approved/etc. by the user currently logged in.

Notify only when program has focus

Check this field if notifications should be shown only when CIMCO Edit has focus.

Notify interval (secs.)

Use this field to specify how often the database should be checked for updates, so the user can be notified of any changes.



Specifying a low value here will load the server, and can also slow down the client.

Show 'Update program info from file'

Check this field to show *Update program info from file* in the program list popup menu.

Show 'Update file with program info'

Check this field to show *Update file with program info* in the program list popup menu.

Show 'Version Reports'

Check this field to show *Version Reports* in the program list popup menu.

Server Settings

This section describes the setup and use of the NC-Base Server functions.

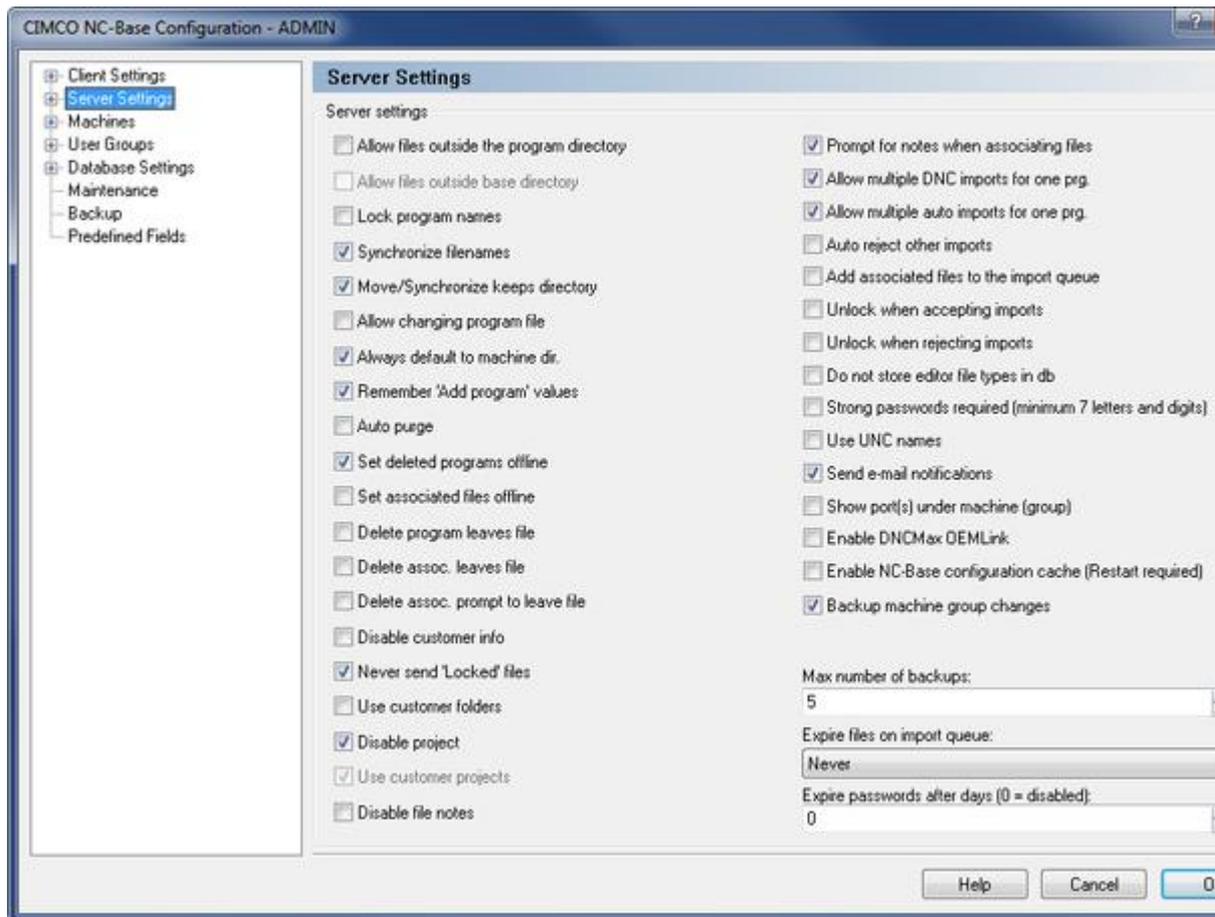


- [Advanced](#)
- [Other](#)
- [Associated Files](#)
- [Logging](#)
- [Required Fields](#)
- [Printing](#)
- [List Export](#)

The function of the NC-Base Server (no user interface, runs in the background as a service) is primarily the data storage and data processing, such as searching for individual programs.

The server offers functions like *Use CIMCO DNC-Max*, *Disable memo files*, *Use versioning system*, *Max number of backups*, *Allow multiple auto imports for one program*, *Only backup if changed*, etc. In this dialog, the optional search fields are also defined.

To open the Server Settings dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



The Server Settings dialog.

Server Settings

- Allow files outside the program directory

Check this field to allow programs to be placed outside the program directory.

- Allow files outside base directory

Check this field to allow programs to be placed outside the base directory.



The main directory is specified in [Database Settings](#).

- Lock program names

Check this field to lock program names. When this option is selected, the program name cannot be changed.

- Synchronize filenames

Check this field to synchronize filenames. When this option is selected, the filename is always synchronized with the program name. So if the program name is changed, the filename is also updated.



When this option is used, the database will not allow two programs for the same machine to have the same program name, and program files cannot be stored outside the base directory.

Move/Synchronize keeps directory

Check this field to leave the program in the same directory, and only update the filename when *Synchronize filenames* is selected, or move the program to the same sub-directory name when moving program between program groups.

If this option is not selected, the program is moved to the machine base directory when the program name is changed.

Allow changing program file

Check this field if the user should be allowed to change the program file associated with a program.

Always default to machine directory

Check this field if the *Add program* dialog should always default to the machine directory.

Remember 'Add program' values

Check this field if values from the previous program added should be remembered when adding a new program.

Auto purge

Check this field to delete programs permanently.



When this option is enabled, deleted programs cannot be undeleted.

Set deleted programs offline

Check this field to move deleted program files to the machine's *Deleted Folder*. This will prevent deleted programs from showing up in directory listings on the CNC control.

Set associated files offline

Check this field to move deleted associated files to the machine's *Deleted Folder*. This will prevent deleted files from showing up in directory listings on the CNC control.

Delete program leaves file

Check this field to leave all files when deleting a program.



If this option is not checked, deleted files are moved to the *Deleted* directory.

Delete associated leaves file

Check this field to leave the file when deleting an associated file.



If this option is not checked, deleted files are moved to the *Deleted* directory.

Delete associated prompt to leave file

Check this field to prompt the user to leave the file when deleting an associated file.



If this option is not checked, deleted files are moved to the *Deleted* directory.

Disable customer info

Check this field to disable all customer info.

Never send 'Locked' files

Check this field if users should not be allowed to send locked files, even if they have permissions to lock/unlock files.

Use customer folders

Check this field to move programs into a sub-folder named after the customer when adding new programs.

Disable project

Check this field to disable the project field.

Use customer projects

Check this field if projects should be locked to customers.

Disable file notes

Check this field to disable file notes.

Prompt for notes when associating files

Check this field if the user should be prompted to add a file note when associating files to a program.

Allow multiple DNC imports for one program

Check this field to allow multiple DNC imports for the same program.

Allow multiple auto imports for one program

Check this field to allow multiple auto imports for the same program.

Auto reject other imports

Check this field to automatically reject other imports for the same program, when an import is accepted.

Add associated files to the import queue

Check this field if associated files should be placed on the import queue when auto imported or auto received.

Un-lock when accepting imports

Check this field to unlock the program when accepting a program on the import queue.

Un-lock when rejecting imports

Check this field to unlock the program when rejecting a program on the import queue.

Do not store editor file types in db

Check this field to prevent the editor file types (ISO/Heidenhain/Text etc.) from being stored in the database.

Strong passwords required (minimum 7 letters and digits)

Check this field to require strong passwords. A strong password must be at least 7 characters long and it must contain both letters and digits.

Use UNC names

Check this field to use UNC names.

Send e-mail notifications

Check this field to send e-mail notifications when programs are locked/unlocked etc.



E-mail server settings must be configured in the DNC-Max server to use this feature.

Show port(s) under machine (group)

Check this field to show the port name(s) for each machine in the NC-Base Explorer.

Enable DNCMax OEMLink

Check this field to enable OEM-Link.

Enable NC-Base configuration cache (Restart required)

Check this field to enable the NC-Base configuration cache, and create a local configuration file. The NC-Base configuration will be loaded from this file and not from the database.

Backup machine group changes

Check this field to enable backup of association between machine groups and DNC-Max ports. The log is saved in the Editor's log directory.

When NC-Base is connected to DNC-Max ports, it may occur that you lose the association between NC-Base machines and DNC-Max ports when upgrading DNC-Max or migrating to a new server. By enabling *Backup machine group changes* a record is made of the association between NC-Base machines and DNC-Max ports after each change. This backup can then be used to restore the association.



The machine port association is only backed up after each change. No initial backup is performed when enabling "Backup machine group changes".

Max number of backups

Use this field to specify how many backups should be kept in the database.



To disable backups, specify a value of 0 in this field.

Expire files on import queue

Use this field to specify how long imported programs should be waiting on the import queue, before they are automatically rejected.

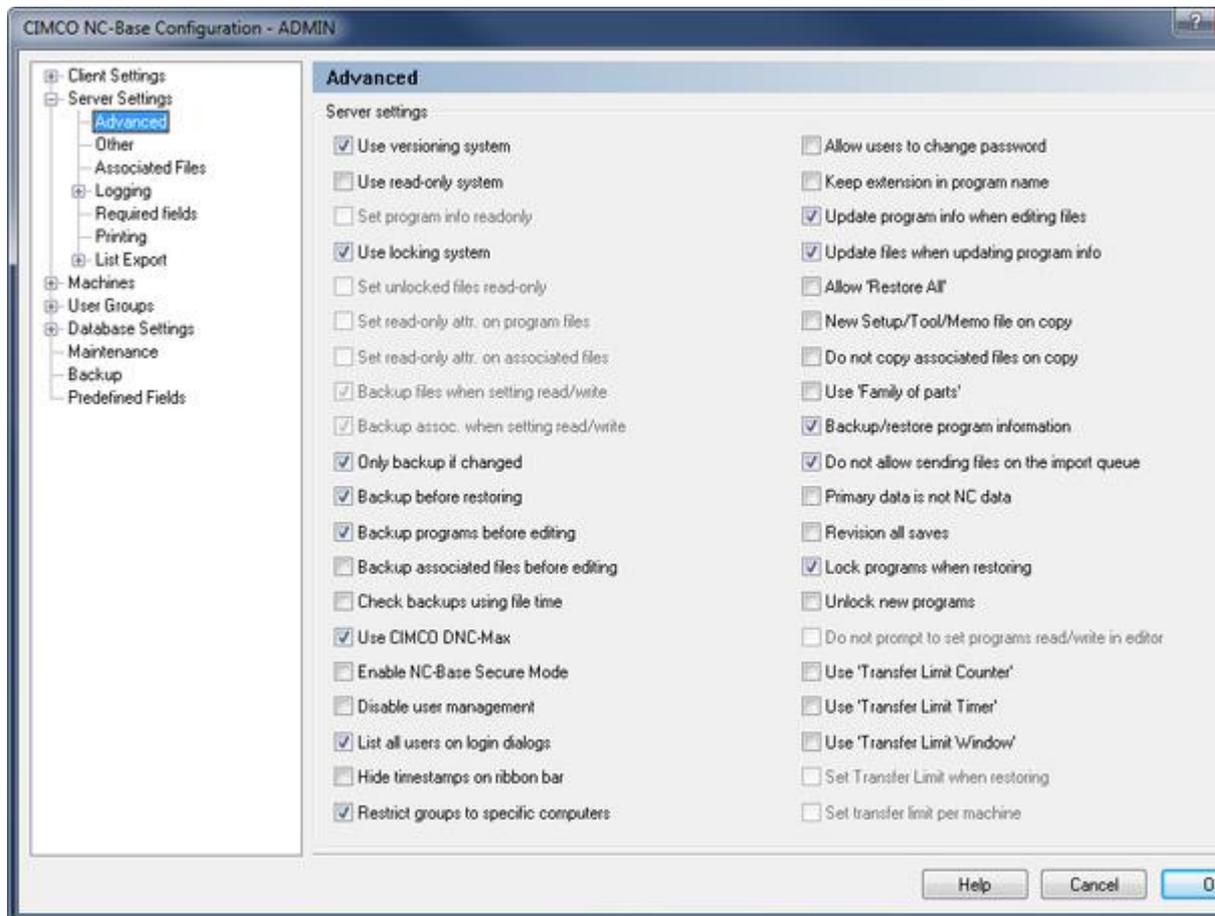
Expire passwords after days (0 = disabled)

Use this field to specify how often users must change their password.

Advanced

This section describes the setup and use of the NC-Base Server's Advanced features.

To open the Advanced dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. This will open the CIMCO NC-Base Configuration window. Click on Server Settings in the left hand list and select Advanced. The following dialog appears:



Advanced Server Settings.

Server Settings



Use versioning system

Check this field to enable the versioning system. When the versioning system is enabled, NC-Base will automatically create a backup when updating a file. The *Maximum number of backups* setting controls how many old versions should be retained. If you have one or more machines that use large 3D files, you can disable the versioning system for these machines in the machine setup. When using versioning, it will take a little longer to open and/or close a file because NC-Base needs to create a backup file.

Use read-only system

Check this field to enable the read-only system. When this system is enabled, users cannot edit files marked as read-only.

Set program info read-only

Check this field if program info should be read-only when the program is set to read-only.

Use locking system

Check this field to enable the locking system. When this system is enabled, users are only allowed to send unlocked programs.

Set unlocked files read-only

Check this field if all unlocked files should be marked as read-only. This prevents unauthorized changes to unlocked files.

Set read-only attr. on program files

Check this field if the read-only file system attribute should be set on program files, when the program is marked as read-only.



When the read-only attribute is set, external programs cannot modify/delete the file.

Set read-only attr. on associated files

Check this field if the read-only file system attribute should be set on associated files, when the program is marked as read-only.



When the read-only attribute is set, external programs cannot modify/delete the file.

Backup files when setting read/write

Check this field if program files should be backed up when a program is changed from read-only to read/write.

Backup associated when setting read/write

Check this field if associated files should be backed up when a program is changed from read-only to read/write.

Only backup if changed

Check this field if backups should only be generated, if the file is different from the latest backup.

Backup before restoring

Check this field if a backup should be created before restoring a file.

Backup programs before editing

Check this field to automatically backup program files before editing them.

Backup associated files before editing

Check this field to automatically backup associated files before editing them.

Check backups using file time

Check this field if NC-Base should only use the time stamp of a file to check if it is changed.



The time stamp might fail to identify changed files on some network drives and operating systems. If NC-Base does not generate backups correctly, remove the check from this field.

Use CIMCO DNC-Max

Check this field if CIMCO DNC-Max should be used as DNC link.

Enable NC-Base Secure Mode

Check this field to enable the secure mode. When NC-Base is running in secure mode, users do not need write access to the NC-Base base directory.

Disable user management

Check this field to disable user management.

- List all users on login dialogs

Check this field if the login dialog should show a list of all users.

- Hide timestamps on ribbon bar

Check this field to hide the file created/modified time shown on the ribbon bar above the preview window.

- Restrict groups to specific computers

Check this field if individual user groups should be restricted to specific computers.



When this field is selected, the *User group* setup will have a check box next to each group. Check these to specify which groups can login to NC-Base from this computer.

- Allow users to change password

Check this field to allow users to change their passwords.

- Keep extension in program name

Check this field to keep the file extension as part of the program name.

- Update program info when editing files

Check this field to update the database information when editing the NC file.



You must configure the Program Format Triggers to use this option.

- Update files when updating program info

Check this field to update the database information specified in the NC file when updating the database info.



You must configure the Program Format Triggers to use this option.

- Allow 'Restore All'

Check this field to allow user to restore programs and associated files from the Restore dialog.



When this option is selected, a backup is created for associated files even if they are not changed since the last backup.

New Setup/Tool/Memo file on copy

Check this field if a new Memo/Setup/Tool file should be created when a program is copied.



If this option is not selected, the user will be prompted if the file should be copied. When the file is not copied, a link to the existing file is created.

Do not copy associated files on copy

Check this field if associated files should not be copied/linked to the new program when copying an existing program.

Use 'Family of parts'

Check this field to allow specifying multiple part numbers for one program.

Backup/restore program information

Check this field to restore the program fields when restoring a program.

Do not allow sending files on the import queue

Check this field if operators are not allowed to send files waiting on the import queue.



Remote request is normally not possible unless the DNC-Max port is configured to look for files on the import queue.

Primary data is not NC data

Check this field to change NC-Base mode. When checked, NC-Base assumes that the primary program file is not an NC program but a CAM file or similar.

Revision all saves

Check this field to revise all saves from the editor. If this option is not checked, the file is only revised the first time it is saved, and will not be revised again until the file is closed and opened again.

Lock programs when restoring

Check this field to lock programs when restoring the program file from a backup.

Unlock new programs

Check this field to set new programs unlocked when added by a user that does not have permission to unlock programs.

- Do not prompt to set programs read/write in editor

Check this field to disable the *Set program read/write* message when editing read-only programs.

- Use 'Transfer Limit Counter'

Check this field to use the *Transfer Limit Counter* option.



When this option is enabled, the number of times a file can be transferred is specified on the program info dialog. When this counter reaches 0, the program can no longer be transferred.

- Use 'Transfer Limit Timer'

Check this field to use the *Transfer Limit Timer* option.



When this option is enabled, a file can only be transferred until the transfer time expires. When the timer reaches 0, the program can no longer be transferred.

- Use 'Transfer Limit Window'

Check this field to use the *Transfer Limit Window* option.



When this option is enabled, a timer is started when a file is transferred. When the timer reaches 0, the program can no longer be transferred.

- Set Transfer Limit when restoring

Check this field if the Transfer Count Limit should be set to the default value (specified under Server Settings, Other) when restoring a program.

- Set transfer limit per machine

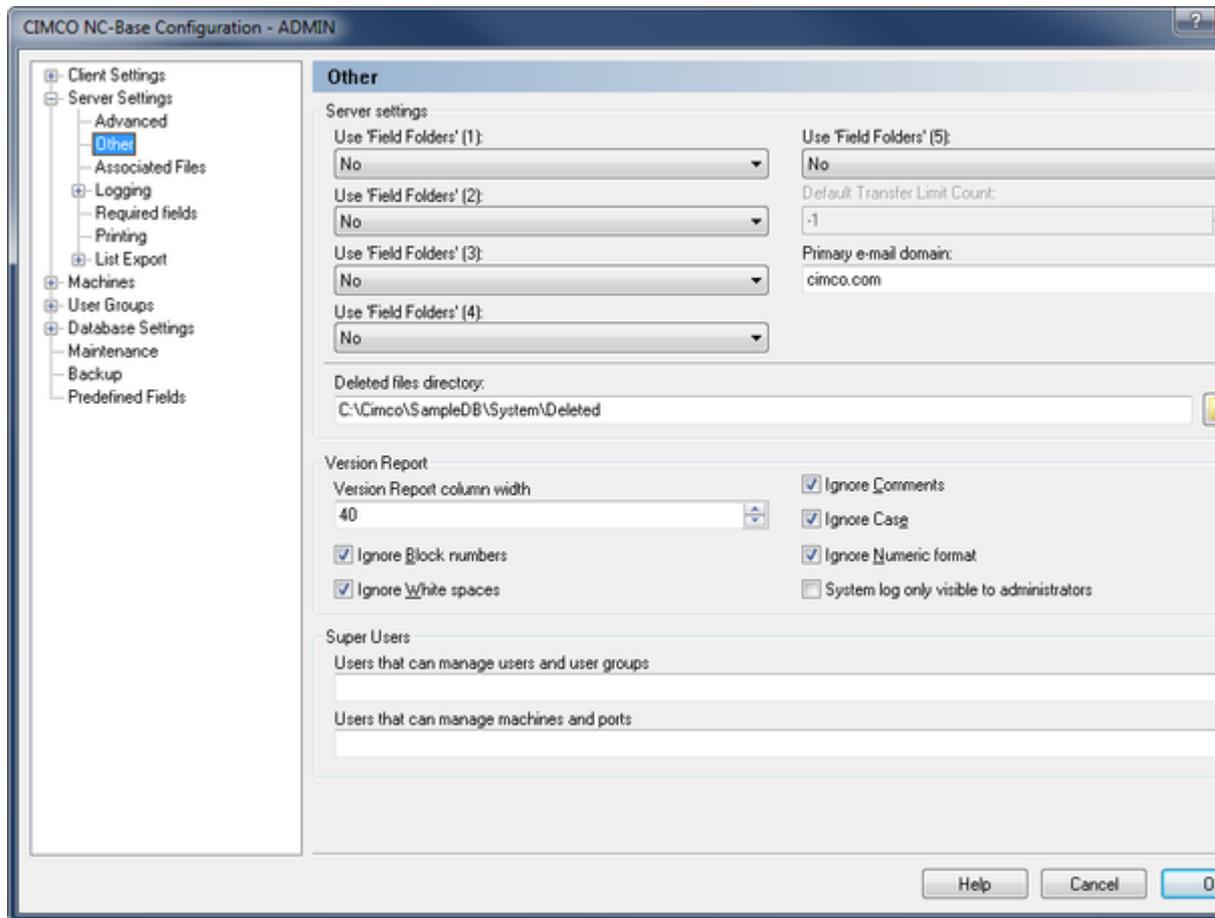
Check this field to set individual default transfer limits for each machine.

Other

This section describes how to configure and use the Other functions in the NC-Base Servers setup.

To configure Other settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. This will open the CIMCO NC-Base

Configuration window. Then click on Server Settings in the left hand list and select Other. The following dialog appears:



The 'Other' dialog.

Server Settings

Use 'Field folders' (1-5)

Use this field to move programs into a sub-folder named after the selected field when adding new programs.

Default Transfer Limit Count

Use this field to specify the default transfer limit count for new/auto imported programs.



Specify -1 in this field to disable transfer limit by default for the selected machine.

Primary e-mail domain

Use this field to specify the primary e-mail domain.



When you specify the e-mail address of a user, you do not need to specify @yourdomain.com, if you have specified yourdomain.com in this field.

Deleted files directory

Use this field to specify the directory where deleted files should be stored.

Version Report

Version Report column width

Use this field to specify the width of the version report column.

Ignore Block numbers

Select this option to ignore block numbers.

Ignore White spaces

Select this option to ignore tabs (ASCII 9) and space (ASCII 32).

Ignore Comments

Select this option to ignore any changes within comments.

Ignore Case

Select this option to ignore the case of the compared files, i.e. a matches A.

Ignore Numeric format

Select this option to ignore leading/trailing zeros, and optional '+' character, i.e. X+14.10 matches X14.1.

System log only visible to administrators

Check this field if the system log should be visible to administrators only.

Super Users

Users that can manage users and user groups

Use this field to specify users not in the Administrators group that can manage users/groups.

Example: ALICE, BOB.

Users that can manage machines and ports

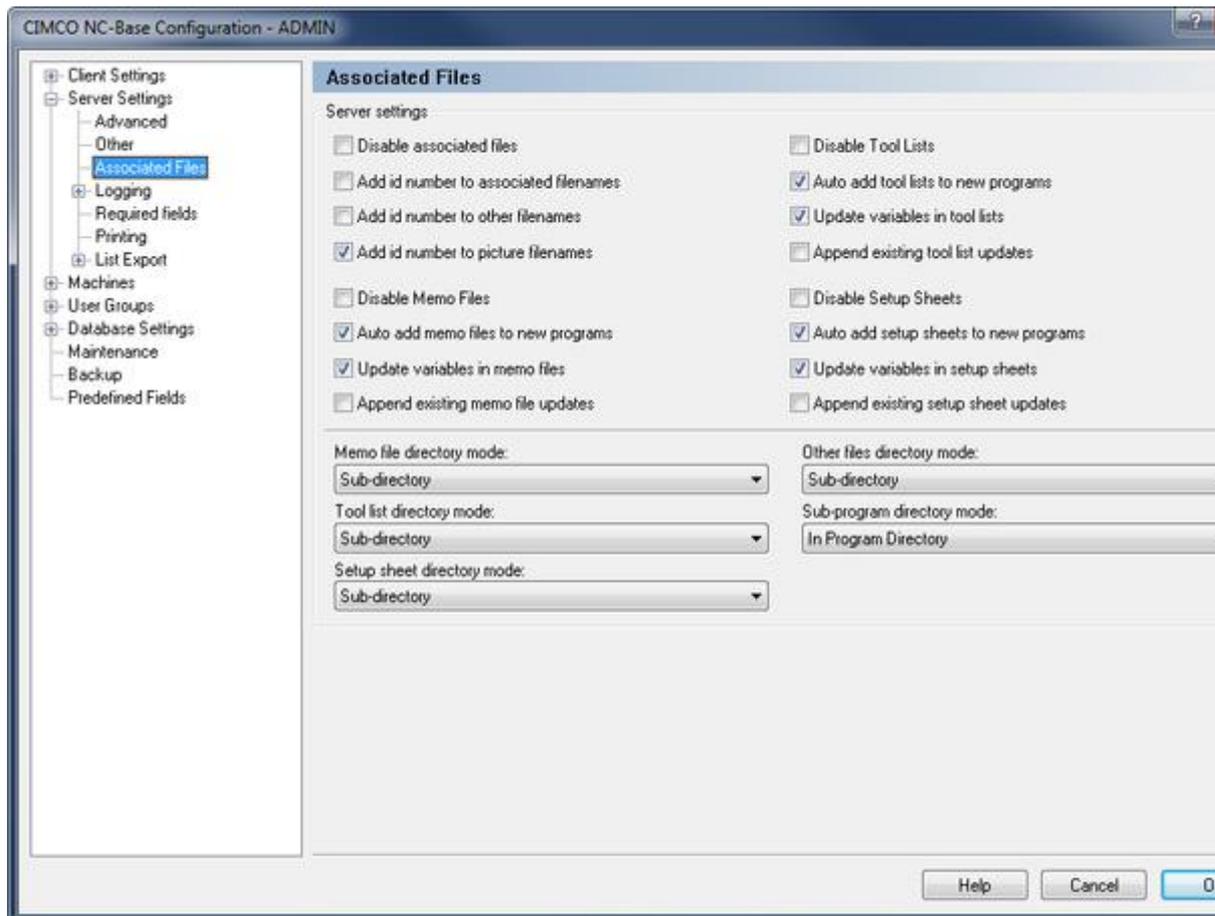
Use this field to specify users not in the Administrators group that can manage machines.

Example: ALICE, BOB.

Associated Files

This section describes how to configure and use the Associated Files settings.

To open the Associated Files dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Associated Files. The following window appears:



Associated Files dialog.

Server Settings

Disable associated files

Check this field to disable associated files.

Add id number to associated filenames

Check this field to append a unique id number to all associated filenames (memo files/setup sheets/tool lists).



Adding a unique id to filenames avoids potential filename conflicts.

Add id number to other filenames

Check this field to append a unique id number to all other files (not memo files/setup sheets/tool lists).



Adding a unique id to filenames avoids potential filename conflicts.

Add id number to picture filenames

Check this field to append a unique id number to all picture filenames.



Adding a unique id to filenames avoids potential filename conflicts.

Disable Memo Files

Check this field to disable memo files.

Auto add memo files to new programs

Check this field to automatically add a memo file to new programs.

Update variables in memo files

Check this field to insert variables in memo files.

Append existing memo file updates

Check this field to copy any additional text added to the end of the existing file when generating a new file.

Disable Tool Lists

Check this field to disable tool lists.

Auto add tool lists to new programs

Check this field to automatically add a tool list to new programs.

Update variables in tool lists

Check this field to insert variables in tool lists.

Append existing tool list updates

Check this field to copy any additional text added to the end of the existing file when generating a new file.

Disable Setup Sheets

Check this field to disable setup sheets.

Auto add setup sheets to new programs

Check this field to automatically add a setup sheet to new programs.

Update variables in setup sheets

Check this field to insert variables in setup sheets.

Append existing setup sheet updates

Check this field to copy any additional text added to the end of the existing file when generating a new file.

Memo file directory mode

Use this field to override where memo files should be stored.

- *Sub-directory*: The associated files are stored in a sub-directory of the NC program directory if the *Store in sub-directory* or *Store in specified directory* is specified on the [Machines\Directories](#) page.
- *Specified Directory*: Files are always stored in the directory specified on the [Machines\Directories](#) page.
- *Any Directory*: Files are not left in their original location.
- *In Program Directory*: Files are stored in the same directory as the program.

Tool list directory mode

Use this field to override where tool lists should be stored.

See *Memo file directory mode* description above for information about the different options.

Setup sheet directory mode

Use this field to override where setup sheet files should be stored.

See *Memo file directory mode* description above for information about the different options.

Other files directory mode

Use this field to override where other associated files should be stored.

See *Memo file directory mode* description above for information about the different options.

Sub-program directory mode

Use this field to override where sub-program files should be stored.

See *Memo file directory mode* description above for information about the different options.

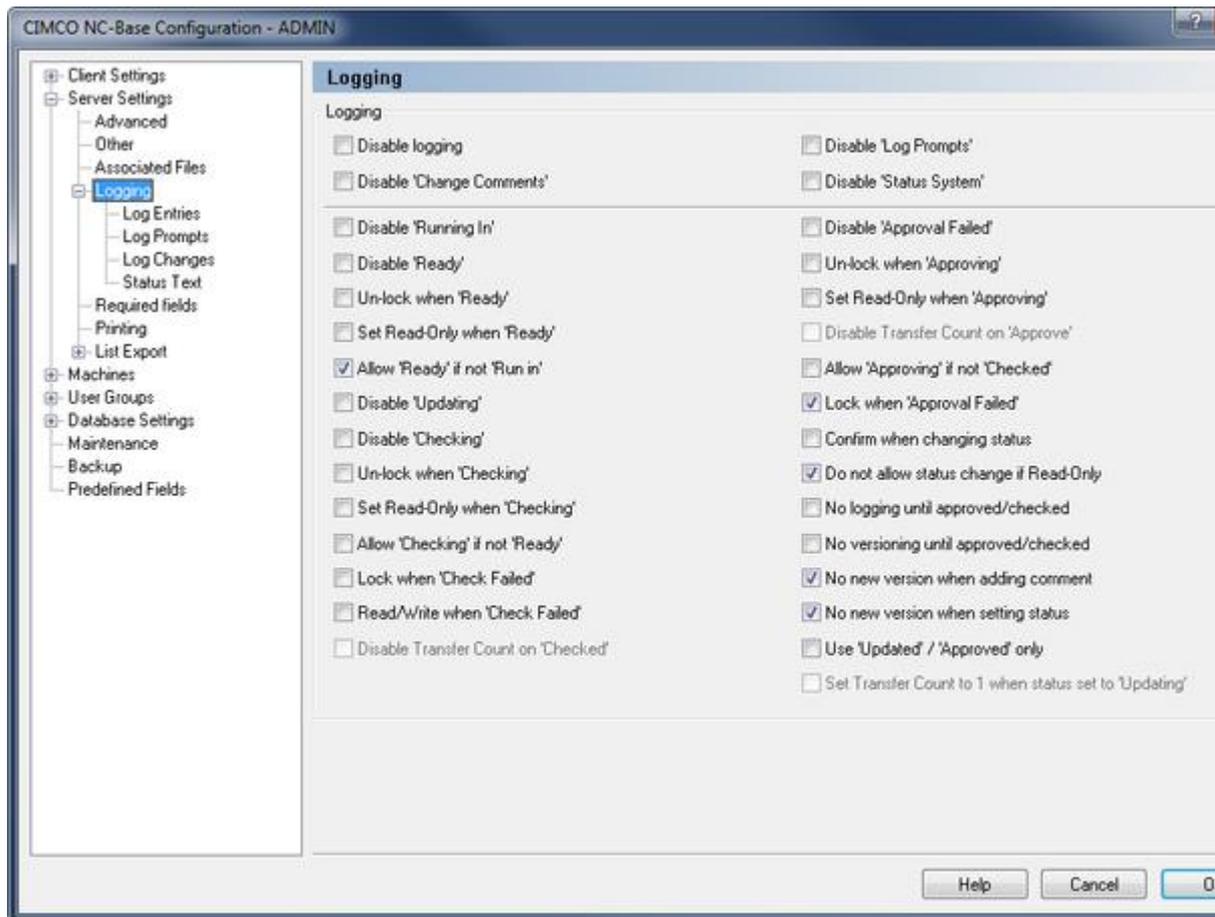
Logging

This section describes the setup and use of the Logging parameters.



- [Log Entries](#)
- [Log Prompts](#)
- [Log Changes](#)
- [Status Text](#)

To configure Logging settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Logging. The following window appears:



The Logging dialog.

Logging

- Disable logging

Check this field to disable the log facility.

- Disable 'Change Comments'

Check this field to disable Change Comments. Change Comments allows users to manually add comments to the log.

- Disable 'Log Prompts'

Check this field to disable the *Log Prompts*. When *Log Prompts* are enabled, the operator is prompted to specify the reason why an operation was performed.

Example: If a program file backup is restored, the operator must specify why he restored the backup.

Disable 'Status System'

Check this field to disable the *Status System*.



The *Status System* allows operators to set the status of a program/file to: *Running In*, *Ready*, *Checked* or *Approved*.

Disable 'Running In'

Check this field to disable the *Running In* status.

Disable 'Ready'

Check this field to disable the *Ready* status.

Un-lock when 'Ready'

Check this field if programs should be unlocked when the status is changed to *Ready*.

Set Read-Only when 'Ready'

Check this field if programs should be marked as *Read-Only* when the status is changed to *Ready*.

Allow 'Ready' if not 'Run in'

Check this field if it should be allowed to mark programs as *Ready* if they are not marked *Running In*.

Disable 'Updating'

Check this field to disable the *Updating* status.

Disable 'Checking'

Check this field to disable the *Checking* state.



When *Checking* is disabled, parts marked as *Ready* cannot be marked as *Checked* before they are approved.

Un-lock when 'Checking'

Check this field if programs should be unlocked when the status is changed to *Checked*.

Set Read-Only when 'Checking'

Check this field if programs should be marked as *Read-Only* when the status is changed to *Checked*.

Allow 'Checking' if not 'Ready'

Check this field if it should be allowed to mark programs as *Checked* if they are not marked *Ready*.

Lock when 'Check Failed'

Check this field to lock programs when setting status *Check Failed*.

Read/Write when 'Check Failed'

Check this field to set the program *Read/Write* when marked *Check Failed*.

Disable Transfer Count on 'Checked'

Check this field to disable the transfer limit count when the status is changed to *Checked*.

Disable 'Approval Failed'

Check this field to disable the *Approval Failed* status.

Un-lock when 'Approving'

Check this field if programs should be un-locked when the status is changed to *Approved*.

Set Read-Only when 'Approving'

Check this field if programs should be marked as *Read-Only* when the status is changed to *Approved*.

Disable Transfer Count on 'Approve'

Check this field to disable the transfer limit count when the status is changed to *Approved*.

Allow 'Approving' if not 'Checked'

Check this field if it should be allowed to mark programs as *Approved* if they are not marked *Checked* and/or *Ready*.

Lock when 'Approval Failed'

Check this field to lock programs when setting status *Approval Failed*.

Confirm when changing status

Check this field to confirm status changes.

Do not allow status change if Read-Only

Check this field if the operator should not be allowed to change the program status, if the program is marked as *Read-Only*.



If the operator has permission to mark a program as *Read/Write*, this field is ignored.

No logging until approved/checked

Check this field if log information should not be added until the program has been *Checked* or *Approved* once.

No versioning until approved/checked

Check this field if version information/backups should not be created until the program has been *Checked* or *Approved* once.

No new version when adding comment

Check this field if a new version should not be created when adding a change comment.

No new version when setting status

Check this field if a new version should not be created when changing the program status.

Use 'Updated' / 'Approved' only

Check this field to use only *Updated/Imported/Approved* status states.

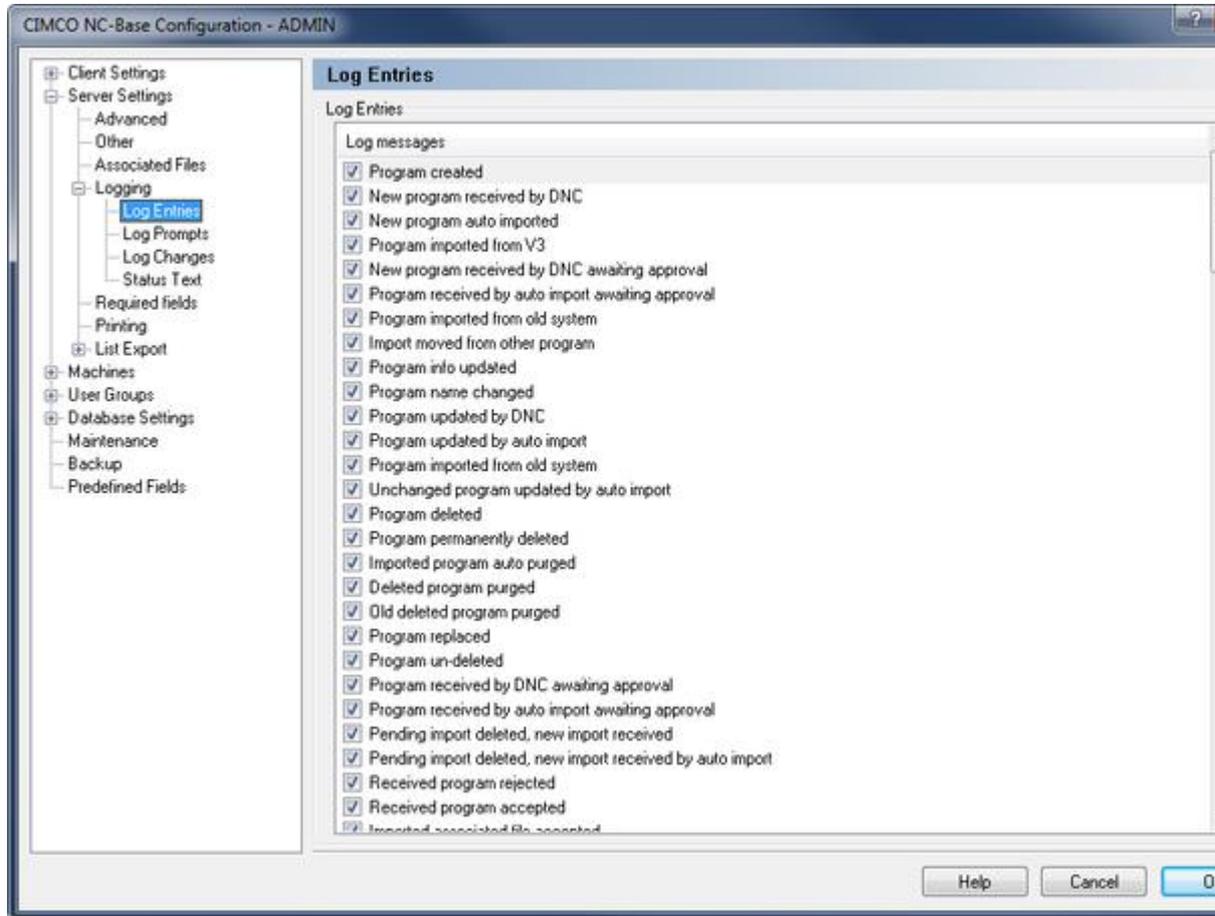
Set Transfer Count to 1 when status set to 'Updating'

Check this field to set the transfer limit count to 1 when status is changed to *Updating*.

Log Entries

This section is concerned with Log Entries settings. In the dialog, you can enable/disable individual log entries.

To open the Log Entries dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Logging / Log Entries. The following window appears:



Log Entries configuration dialog.

Log Entries

- Log messages

This field contains a list of log messages you can select from. Click in the field next to a message to enable/disable individual log entries.

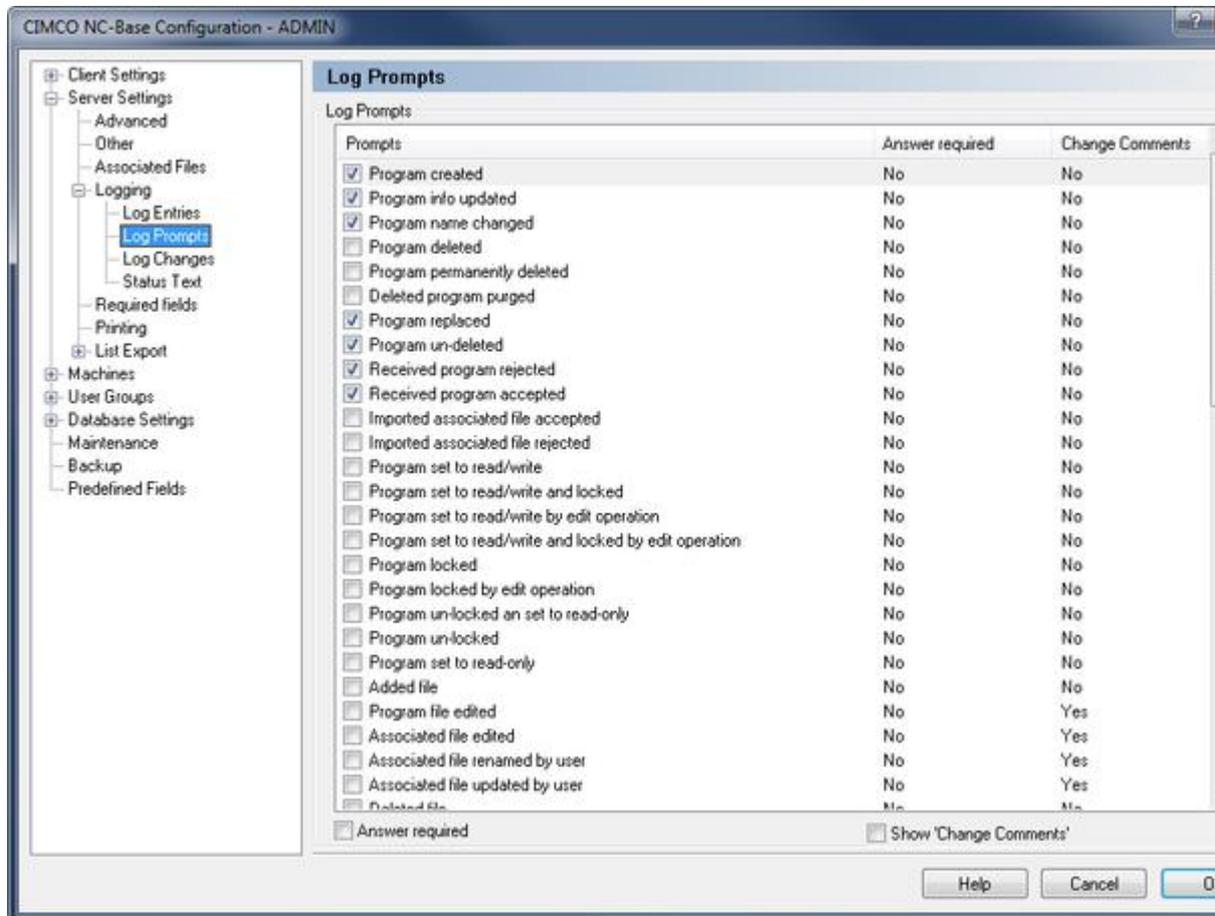


If an entry is not checked, it will never be added to the log.

Log Prompts

This section provides a list of Log Prompts. You can enable/disable individual Log Prompts in the dialog.

To open the Log Prompts dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Logging / Log Prompts. The following window appears:



Log Prompts configuration dialog.

Log Prompts

Prompts

This field contains a list of prompts you can select from. Click in the field next to a message to enable/disable individual log prompts.



If an entry is checked, the user will be prompted to specify a reason for the update.

Answer required

This field shows whether or not an answer is required from the user.

Change Comments

This field indicates if *Change Comments* should be shown.

Answer required

Check this field if the user is required to fill in a comment when prompted with this entry.

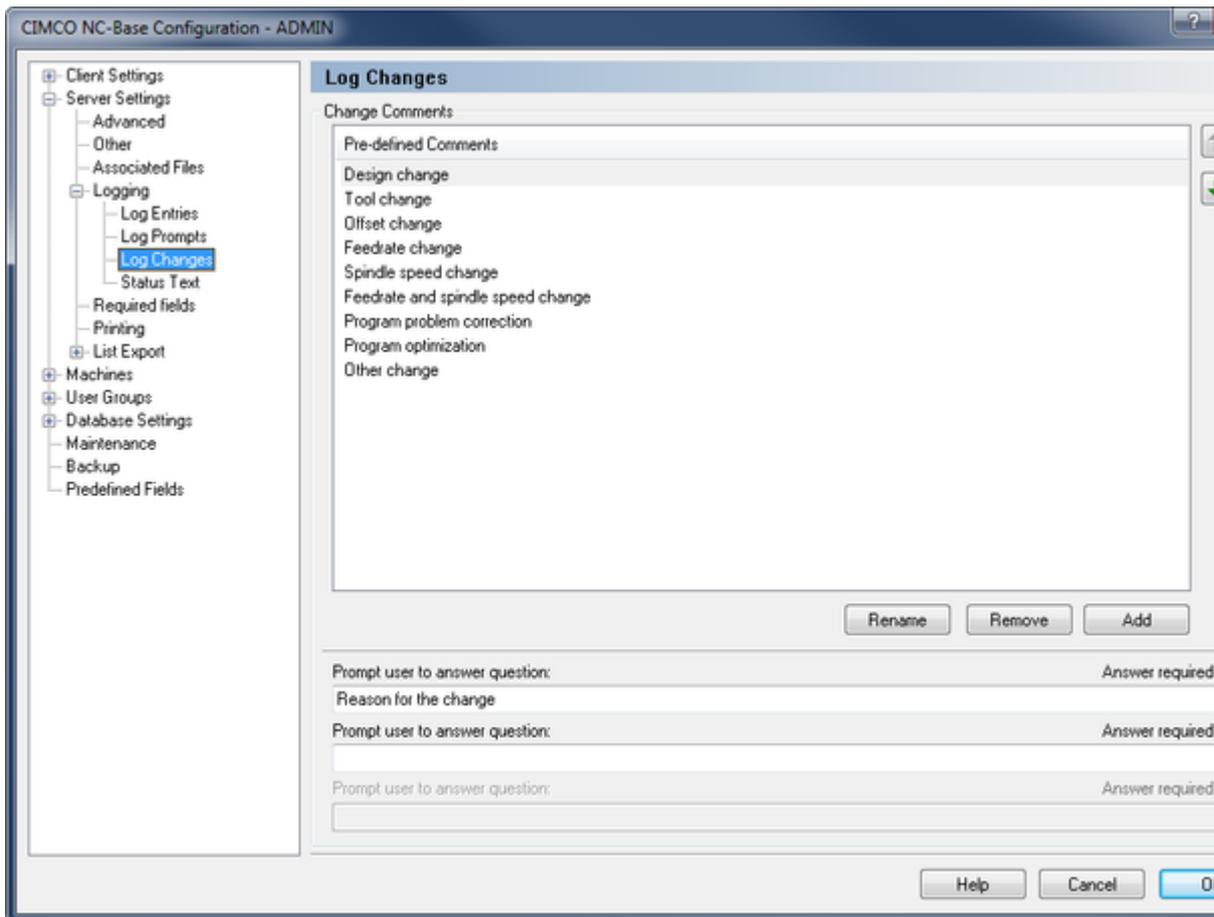
Show 'Change Comments'

Check this field if the *Change Comments* field should be shown for the selected entry.

Log Changes

Use this dialog to define Change Comments. Change Comments are manually added to the log by the operator to indicate changes made to a program or file.

To open the Log Changes dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Logging / Log Changes. The following window appears:



Log Changes configuration dialog.

Change Comments

Pre-defined Comments

This field shows a list of all defined *Change Comments*.

Rename

Use this button to rename the selected *Change Comment*.

Remove

Click this button to delete the selected *Change Comment*.

Add

Use this button to add a new *Change Comment*.

Prompt user to answer question

Use this field to specify a question that the operator should answer when adding a *Change Comment*.

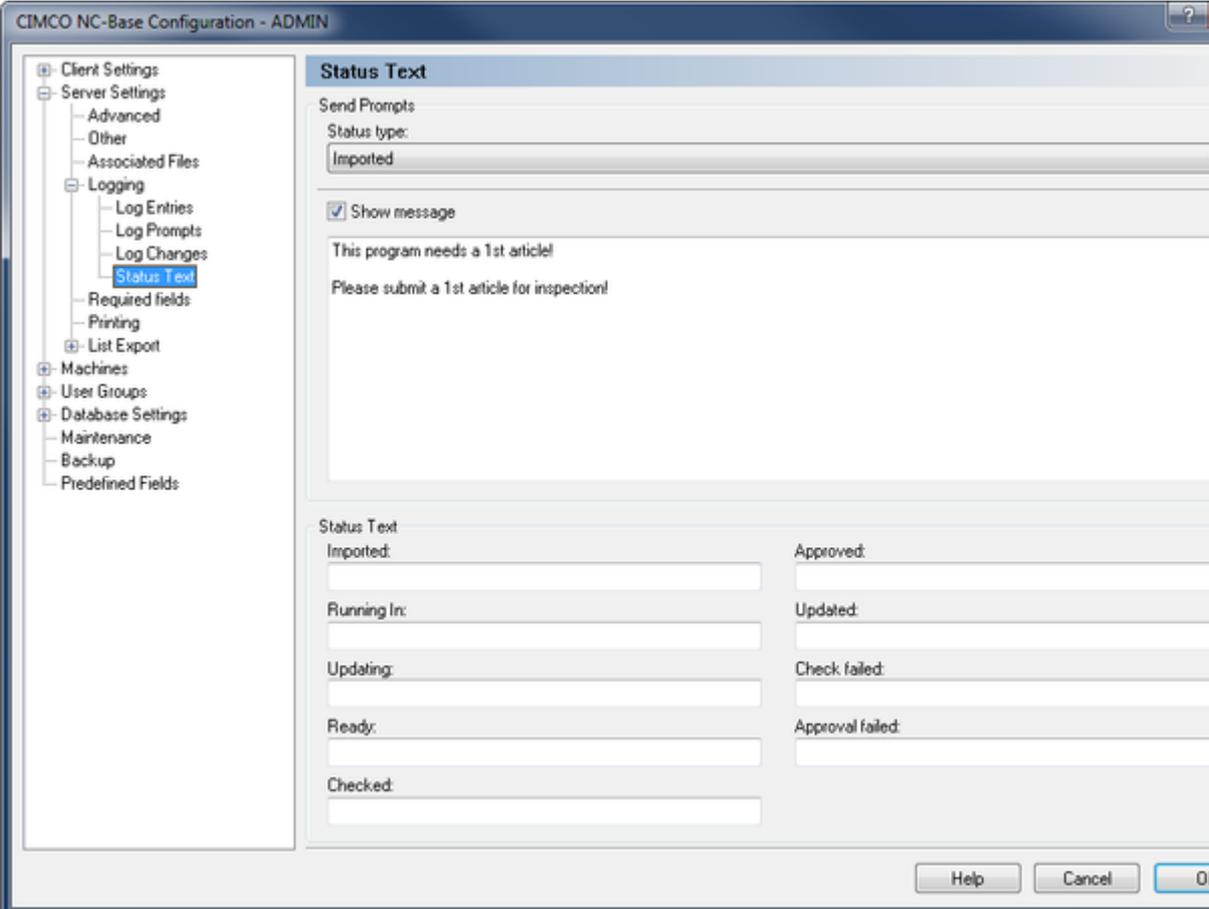
Answer required

Check this field if it is required that the operator answers the specified question.

Status Text

Use this dialog to define messages that should be shown when the operator tries to send a program with the selected status from the NC-Base Client.

To open the Status Text dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click then on Server Settings in the left window of the CIMCO NC-Base Configuration dialog and select Logging / Status Text. The following window appears:



The screenshot shows the 'CIMCO NC-Base Configuration - ADMIN' dialog box. On the left is a tree view with 'Status Text' selected under 'Logging'. The main area is titled 'Status Text' and contains the following fields:

- Send Prompts:
- Status type:
- Show message
- Message text: "This program needs a 1st article!
Please submit a 1st article for inspection!"
- Status Text section with two columns of text input fields:
 - Imported:
 - Running In:
 - Updating:
 - Ready:
 - Checked:
 - Approved:
 - Updated:
 - Check failed:
 - Approval failed:

Buttons for 'Help', 'Cancel', and 'OK' are at the bottom right.

Status Text configuration dialog.

Send Prompts

Status type

Select the prompts status from the drop-down list.

Show message

Check this field to specify a message that should be shown when the operator tries to send a program with the selected status from the NC-Base Client.

Use the text field below this check box to specify the message to show.

Status Text

Imported

Use this field to specify the name used for the status *Imported*.

Running In

Use this field to specify the name used for the status *Running In*.

Updating

Use this field to specify the name used for the status *Updating*.

Ready

Use this field to specify the name used for the status *Ready*.

Checked

Use this field to specify the name used for the status *Checked*.

Approved

Use this field to specify the name used for the status *Approved*.

Updated

Use this field to specify the name used for the status *Updated*.

Check failed

Use this field to specify the name used for the status *Check failed*.

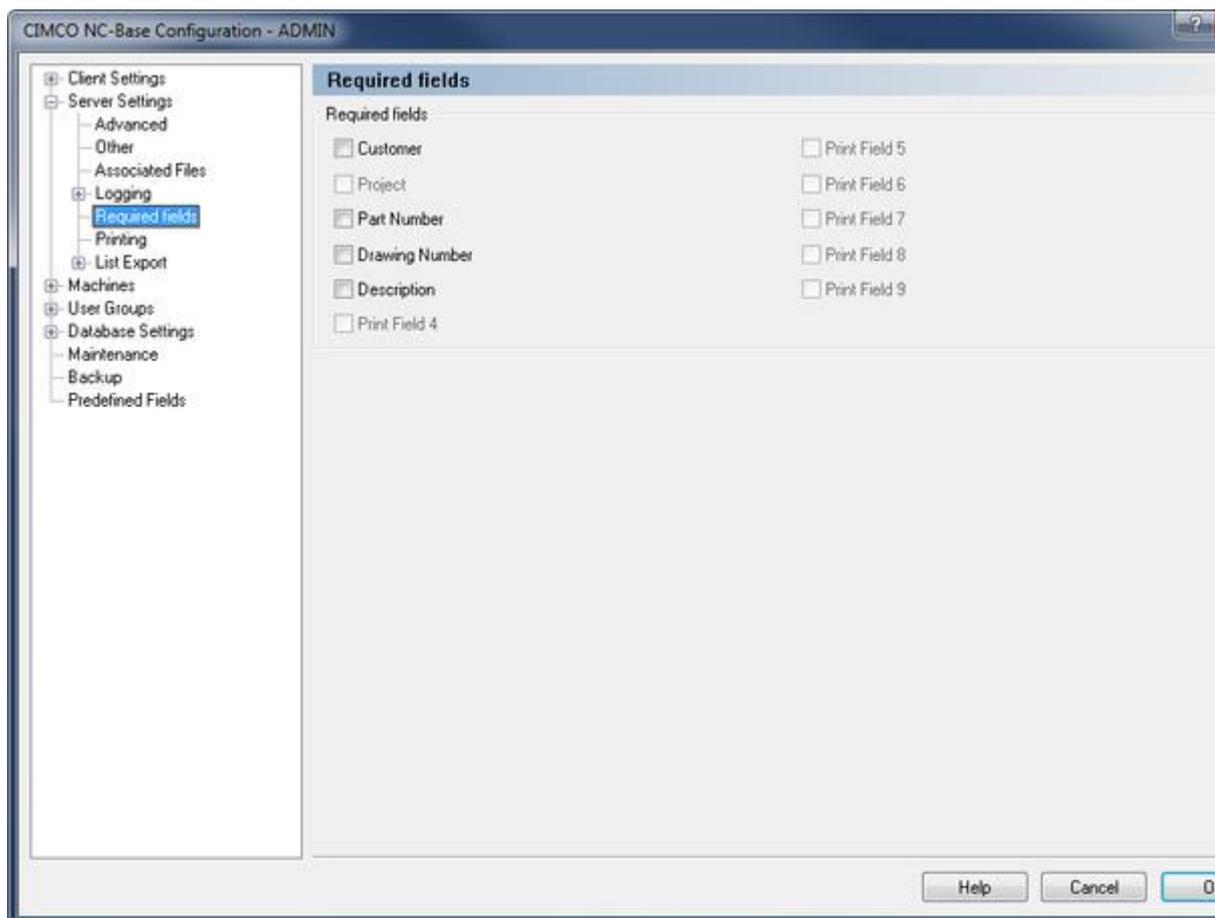
Approval failed

Use this field to specify the name used for the status *Approval failed*.

Required Fields

This section describes how to set up the Required fields.

To configure Required Fields, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. The CIMCO NC-Base Configuration window appears. Click on Server Settings in the left hand list and select Required fields. The following dialog appears:



Required fields dialog.

Required fields

Check these fields if a value is required.

Required fields are search criteria / search fields that have been activated during the installation and start-up. When adding an NC program, you can specify additional information such as search criteria next to the program name. Additional information is by default optional and can be omitted.



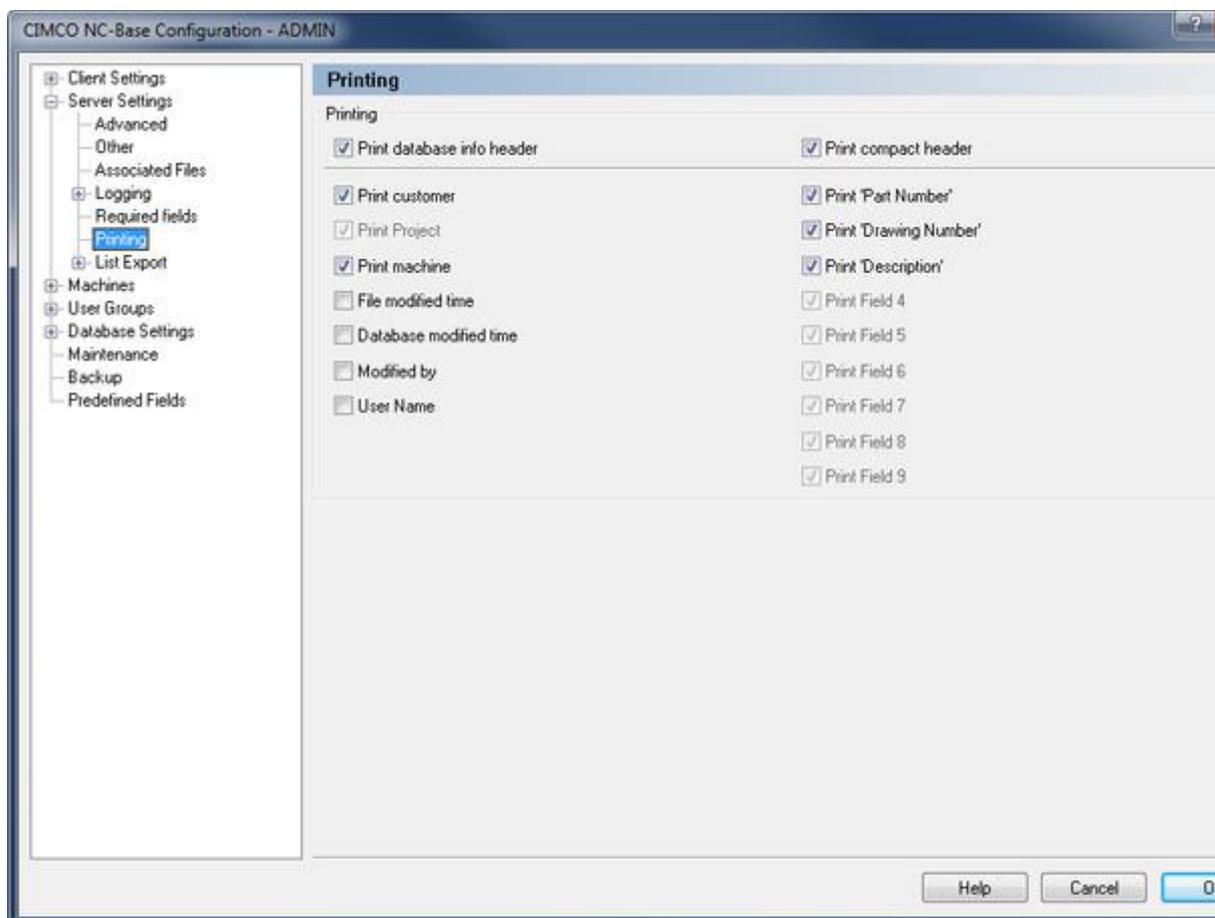
When a field is checked, a new program cannot be added without the operator specifying

the corresponding field.

Printing

This section describes the setup of printing settings.

To configure the printing functions, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Choose Printing from the Server Settings menu in the left window of the CIMCO NC-Base Configuration dialog. The printing configuration dialog is shown below:



The Printing dialog.

Printing

Print database info header

Check this field to add database info (machine group, customer, text field 1, etc.) to the print header.

Print compact header

Check this field to print database info in compact mode (2 columns).

Print customer

Check this field to include the customer name in the print header.

Print Project

Check this field to include the project name in the print header.

Print machine

Check this field to include the machine name in the print header.

File modified time

Check this field to include the file modified time in the print header.

Database modified time

Check this field to include the database modified time in the print header.

Modified by

Check this to include the field Modified by in the print header.

User Name

Check this field to include the user name in the print header.

Print Field 1-9

Check this to include the specified field(s) (*Text field 1 to Text field 9*) in the print header.

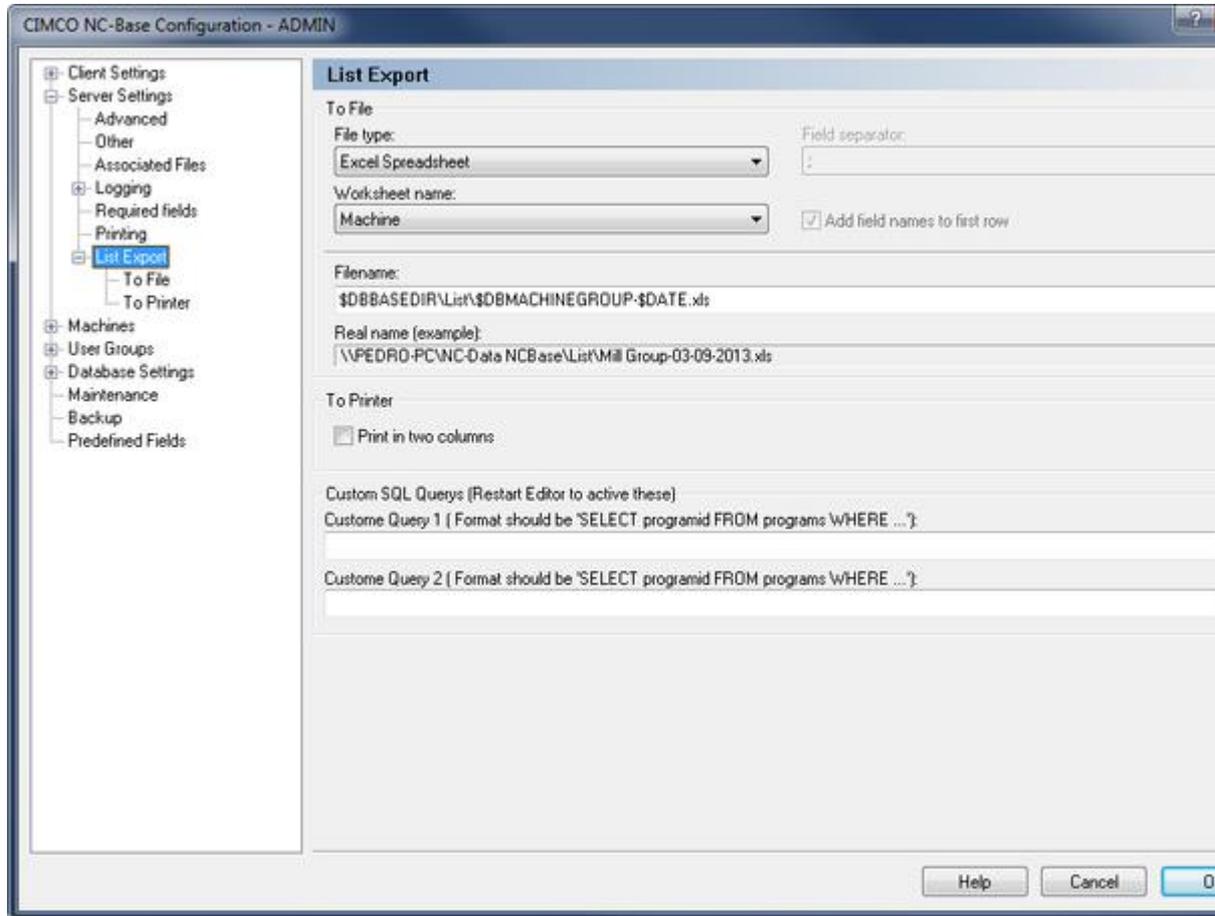
List Export

This section describes how to configure program listing export. Program listing can be stored as a text file or Excel file, and exported to a file or a printer.



- [To File](#)
- [To Printer](#)

To configure List Export settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Select List Export from the Server Settings menu in the left window of the CIMCO NC-Base Configuration dialog. The List Export dialog is shown below:



List Export configuration dialog.

To File

File type 

Select the file type used for exporting program lists from the drop-down list.

Field separator 

Use this field to specify the field separator (only active if text file is selected as file type).

Worksheet name 

Select the Excel worksheet name from the drop-down list (only active if Excel Spreadsheet is selected as file type).

Add field names to first row

Check this field if the field names should be inserted as the first row in the exported file.

Filename

Use this field to specify the default filename used when exporting program lists.

You can use the normal environment variables for date and time, and 3 additional variables:

- \$DBBASEDIR : Database base directory.
- \$DBCUSTOMER : If all programs in the list are associated with the same customer, the variable \$DBCUSTOMER contains the customer name.
- \$DBMACHINEGROUP : If all programs in the list belong to the same machine, the variable \$DBMACHINEGROUP contains the machine name.

Real name (example)

This field shows the result of the file name specified above, when the environment variables are replaced with their values.

To Printer

Print in two columns

Check this field to print program info in two columns.

Custom SQL Queries

You must restart the Editor to activate these functions.

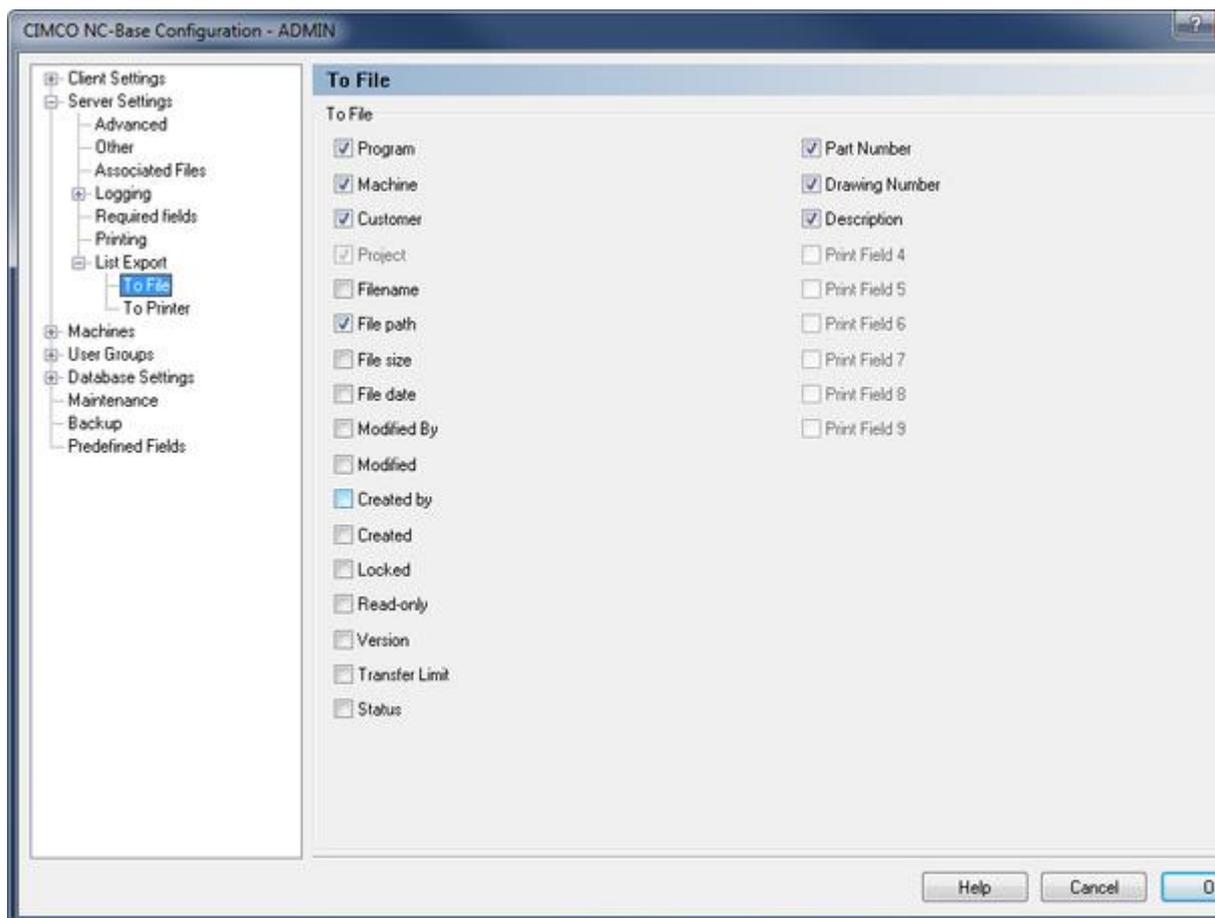
Custom Query 1-2

Custom database query. The format should be *SELECT programid FROM programs WHERE*

To File

Use this dialog to define the settings for the text file listing export.

To open the dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Choose List Export / To File from the menu Server Settings in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



To File dialog.

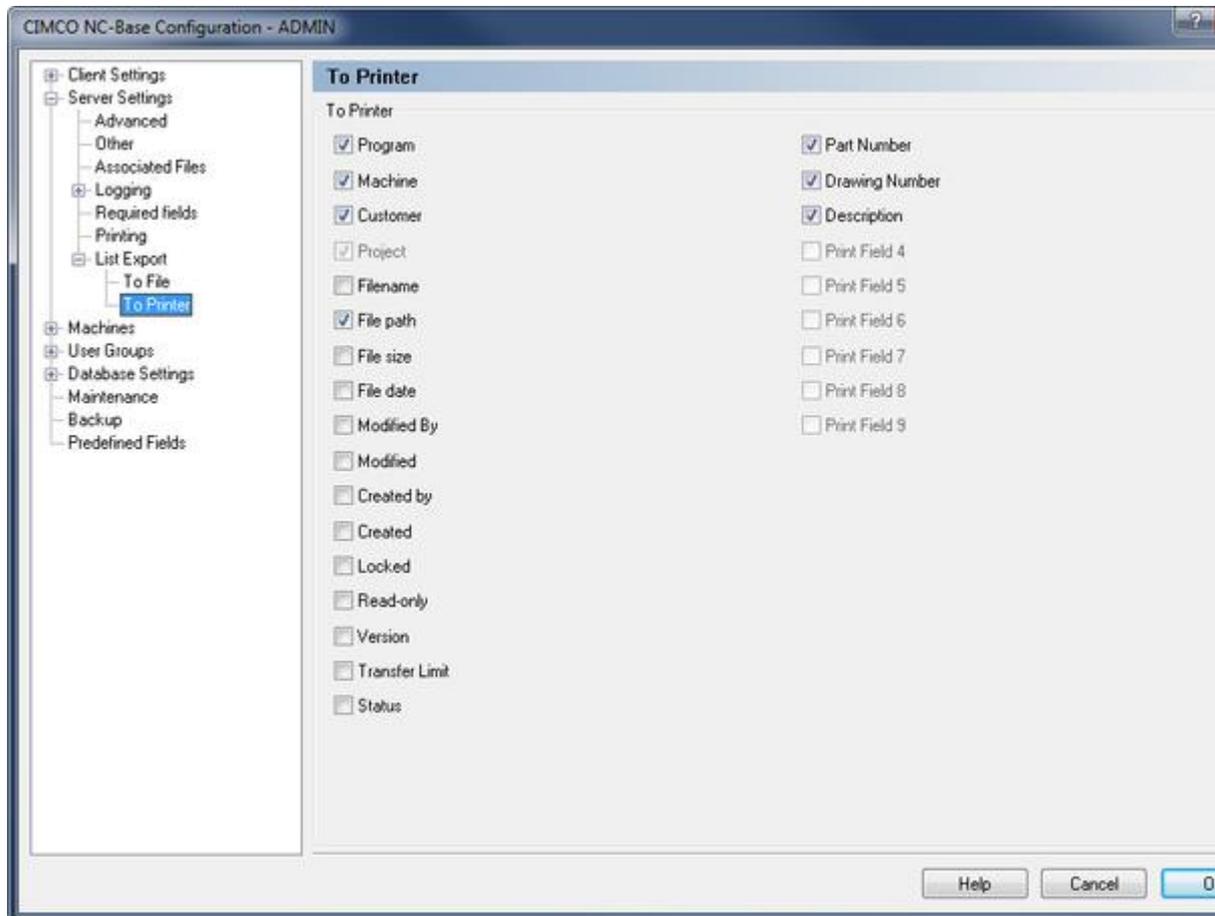
To File

- Check these boxes to export the specified fields.

To Printer

Use this dialog to define the settings for listing printing.

To open the dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Select List Export / To Printer from the menu Server Settings in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



To Printer dialog.

To Printer

- Check these boxes to export the specified fields.

Machines

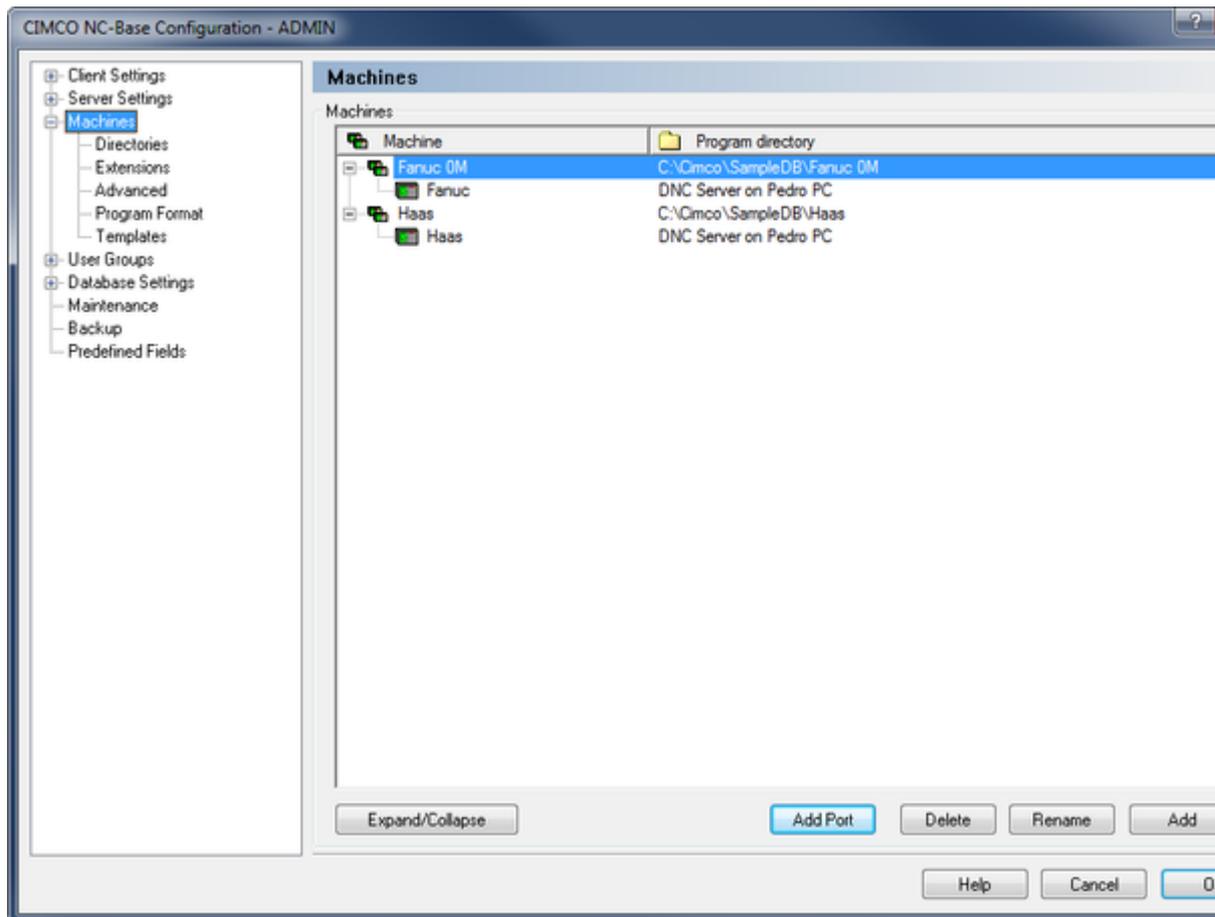


- [Directories](#)
- [Extensions](#)
- [Advanced](#)
- [Program Format](#)
- [Templates](#)

The Machines dialog provides functions that make it possible to attach a defined machine group to a DNC port. Whether the machine groups are defined in the Editor or in DNC-Max depends on the *Use CIMCO DNC-Max* setting made in the Advanced server configuration dialog.

In NC-Base it is possible to associate programs with a machine group, which in turn is connected to a DNC port. In this way, NC programs that are imported to the database can be accessed or sent directly from the machine control (this method utilizes the functions *Remote Request* and *Auto Receive* from optional DNC-Max).

To open the Machine Groups dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on Machines in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



Machine Groups.

Machines

Machines

This field shows a list of all defined machine groups.

Program directory

Shows the program directory where each machine group is stored.

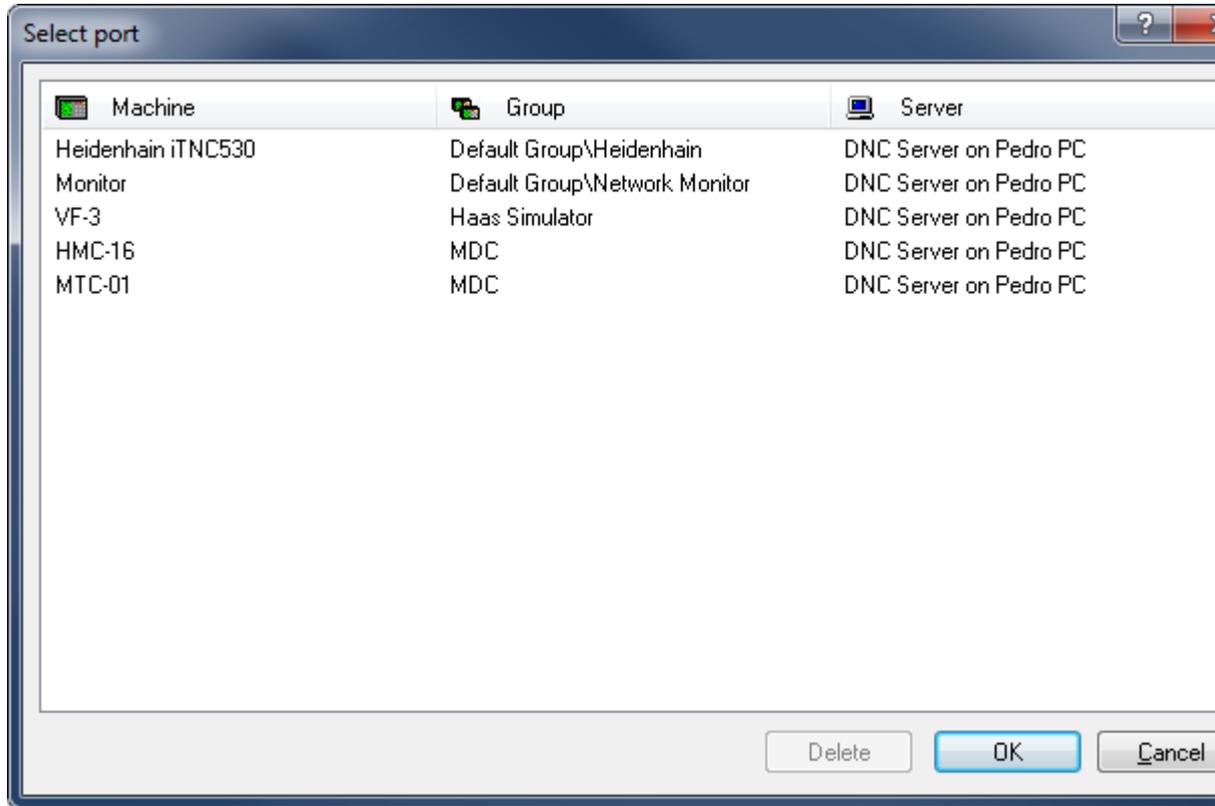
Expand/Collapse Button

Click this button to expand the machine groups and view the ports assigned to each group, or collapse the machine groups.

Add Port Button

Click this button to add a DNC port to the selected machine group. DNC Ports are either defined in the Editor DNC configuration or in DNC-Max, depending on the *Use CIMCO DNC-Max* setting in the Advanced server configuration dialog.

Click Add port to add a DNC port to the selected machine group. The following dialog appears:



Add port.

Highlight the machine you want to connect to the port and click OK.

Delete Button

Click this button to remove the selected port/machine group.

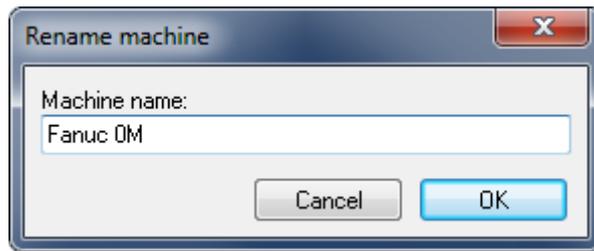


During the deletion process, you can add programs to another machine.

Rename Button

Press this button to rename the selected port/machine group.

To rename a machine group, highlight it and click on the button Rename. The following dialog will appear:



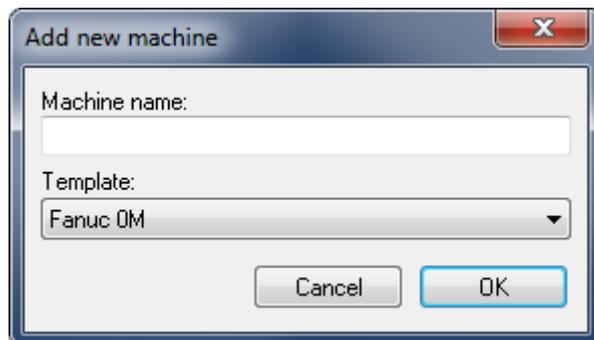
Rename machine group.

Assign a new name to the machine group and click OK.

Add 

Click this button to add a new machine group.

To add a DNC port to a machine group, you must first create the machine. Click Add to add a new machine group to the list. The following dialog will appear:



Add a new machine group.

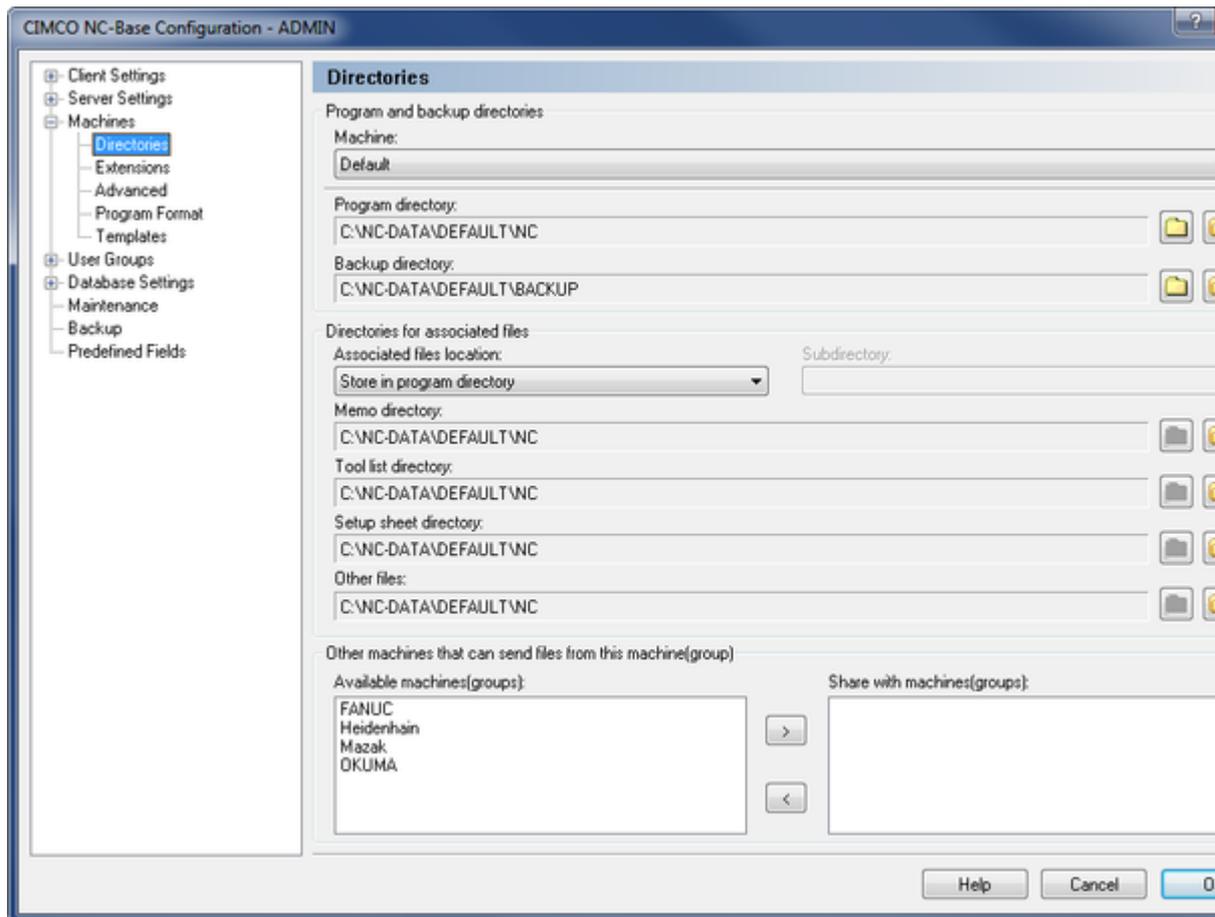
Assign an indicative name to the machine group and click OK.

Directories

This section describes how to configure the directories of the database machine groups. In the Directories dialog the structure of the directories can be changed, based on the previously defined main directory.

The fields below the directory name show the contents of the folder icons to the right.

To configure the Directories settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click on Machines in the left window of the CIMCO NC-Base Configuration dialog and select Directories. The following dialog appears:



Directories configuration dialog.

Program and backup directories

Machine

This list shows all the defined machines. Select a machine from the list to configure its directories.

Program directory

Use this field to specify the program directory.

Press the icon with the red check mark  to move the file to the specified directory.

When you click this icon, a window opens, asking if all program files should be moved to the specified directory. Click Yes to move the files, or click No to abort the operation.

You can also click the folder icon  if you want to change the location of the selected machine. Here, you will be prompted to select a new directory for the program. Select a directory from the list and click OK, or click Cancel if you do not want to select a directory.

Backup directory

Use this field to specify the backup directory.

Please refer to the description above for more information on how to use the folder icons.

Directories for associated files

Apart from storing program files, CIMCO NC-Base also assumes management of associated files. All formats accepted by Windows can be stored, e.g. Word files (*.doc), PDF files (*.pdf), images (*.jpg, *.gif and others), etc.

Below is described in details, where you can store all your associated files and which templates you can use for *Memo file*, *Tool list*, *Setup sheet*, and *Other files*.



If these files are to be used, they must NOT be disabled in the *Associated Files* dialog. Further information on the settings for associated files is found in the section [Server Settings / Associated Files](#).

Associated files location

Specify here where the memo files, tool lists, and setup sheets should be stored.

- *Store in program directory*: Files are stored in the same directory as the program files (see following picture).



Associated files are stored in the same directory as the program files.

- *Store in subdirectory*: Files are stored in a directory subordinate to the program directory (see following picture). This is the sub-directory you specify in the field Subdirectory.

Directories for associated files

Associated files location: Store in subdirectory Subdirectory: Files

Memo directory: C:\Cimco\SampleDB\Haas\Files

Tool list directory: C:\Cimco\SampleDB\Haas\Files

Setup sheet directory: C:\Cimco\SampleDB\Haas\Files

Other files: C:\Cimco\SampleDB\Haas\Files

Associated files are stored in a sub-directory of the program file directory.

- *Store in specified directory*: Files are stored in the directories specified below (see following picture).

Directories for associated files

Associated files location: Store in specified directory Subdirectory:

Memo directory: C:\Cimco\SampleDB\Haas\Memo

Tool list directory: C:\Cimco\SampleDB\Haas\Tool

Setup sheet directory: C:\Cimco\SampleDB\Haas\Setup

Other files: C:\Cimco\SampleDB\Haas\Other

Associated files are stored in the specified 'Memo directory', 'Tool list directory', 'Setup sheet directory', and 'Other files directory'.

Memo directory

Use this field to specify the directory where memo files should be stored.

Please refer to the description under *Program directory* for more information on how to use the folder icons.

Tool list directory

Use this field to specify the directory where tool lists should be stored.

Please refer to the description under *Program directory* for more information on how to use the folder icons.

Setup sheet directory

Use this field to specify the directory where setup sheets should be stored.

Please refer to the description under *Program directory* for more information on how to use the folder icons.

Other files

Use this field to specify the directory where other associated files should be stored.

Please refer to the description under *Program directory* for more information on how to use the folder icons.

Other machines that can send files from this machine(group)

Available machines(groups)

Use this field to specify another machine(group) that can send files belonging to this machine(group).

Share with machines(groups)

Use this field to specify another machine(group) that can send files belonging to this machine(group).

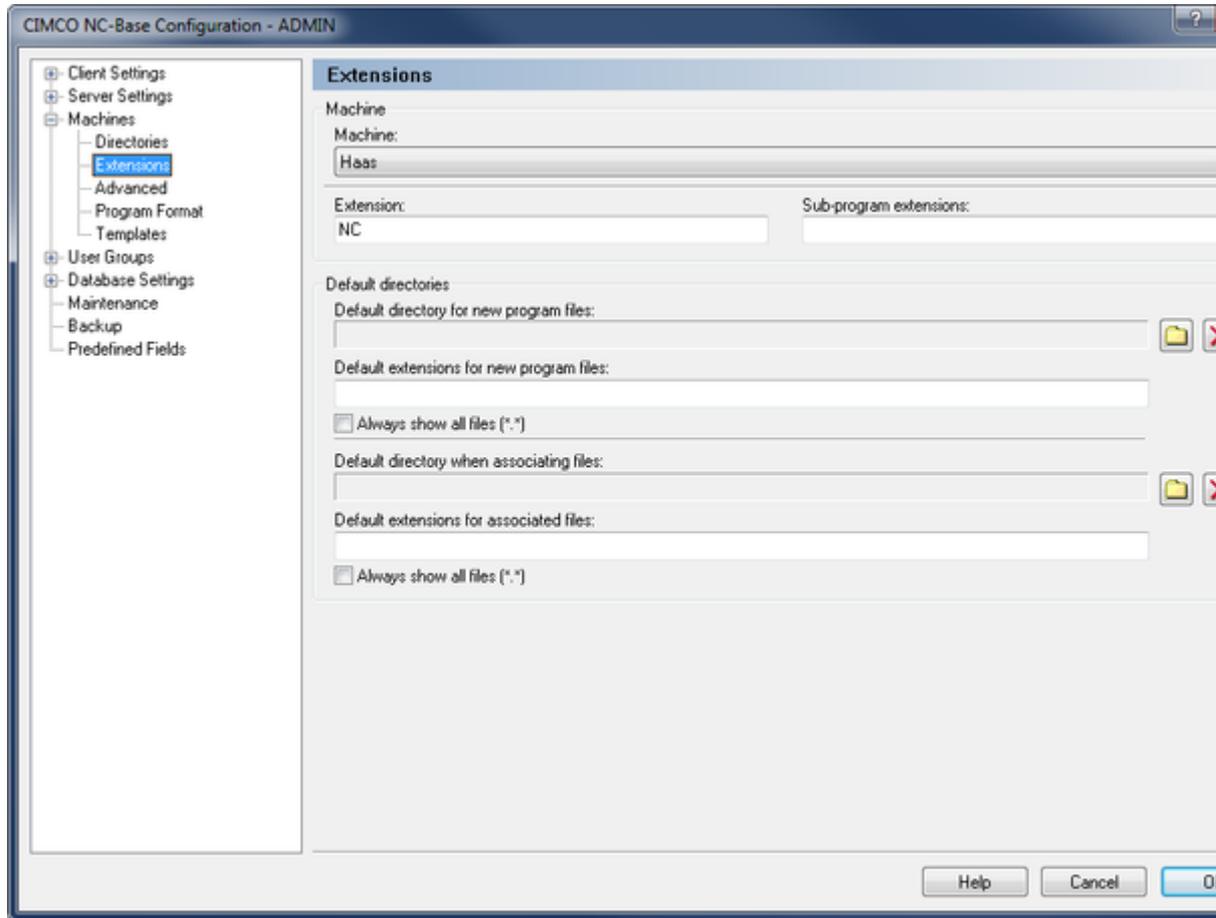
Use the arrows to move machine/group to the appropriate field.

Extensions

In the Extensions dialog, you can specify the file extensions of NC programs and associated files for each machine/machine group. You can also specify the default directories to be used when adding new programs or associated files.

To open the Extensions dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then select Extensions from the

Machines menu in the left window of the CIMCO NC-Base Configuration dialog. The Extensions dialog is shown below:



Extensions dialog.

Machine

Machine

This field shows a list of all defined machine groups.

Extension

Use this field to specify the default extension for NC programs.

Sub-program extensions

Use this field to specify extensions for sub-programs. When associating a file with one of the specified sub-program extensions, the file will automatically be marked as a sub-program.



Only the program file and associated files marked as sub-programs can be sent/received by the DNC system.

You can specify multiple extensions by separating them with commas.

Example: To mark NC and ISO files as sub-programs, specify: ISO,NC.

Default directories

Default directory for new program files

Specify the default directory used when adding new programs in this field. New programs are temporary stored in this directory. When you select Add Program, the file dialog will open at this location.

Click on the folder icon with the red mark  to delete the default directory.



If this field is empty, the file dialog will open in the last used directory.

Default extensions for new program files

Specify the default extensions used when adding new programs in this field. When you click on Add Program, the file dialog will show files with these extensions by default.



If this field is empty, the file dialog will show all files by default.

You can specify multiple extensions by separating them with commas.

Example: To show NC and ISO files, specify: ISO,NC.

Always show all files (*.*)

Check this field if the file dialog should always show all files.

Default directory when associating files

Use this field to specify the default directory used when associating files. New associated files are temporary stored in this directory. When you click on Associate File(s), the file dialog will open at this location.

Click on the folder icon with the red mark  to delete the default directory.



If this field is empty, the file dialog will open in the last used directory.

Default extensions for associated files

Use this field to specify the default extensions used associating files to a program. When you select Associate File(s), the file dialog shows files with these extensions by default.



If this field is empty, the file dialog will show all files by default.

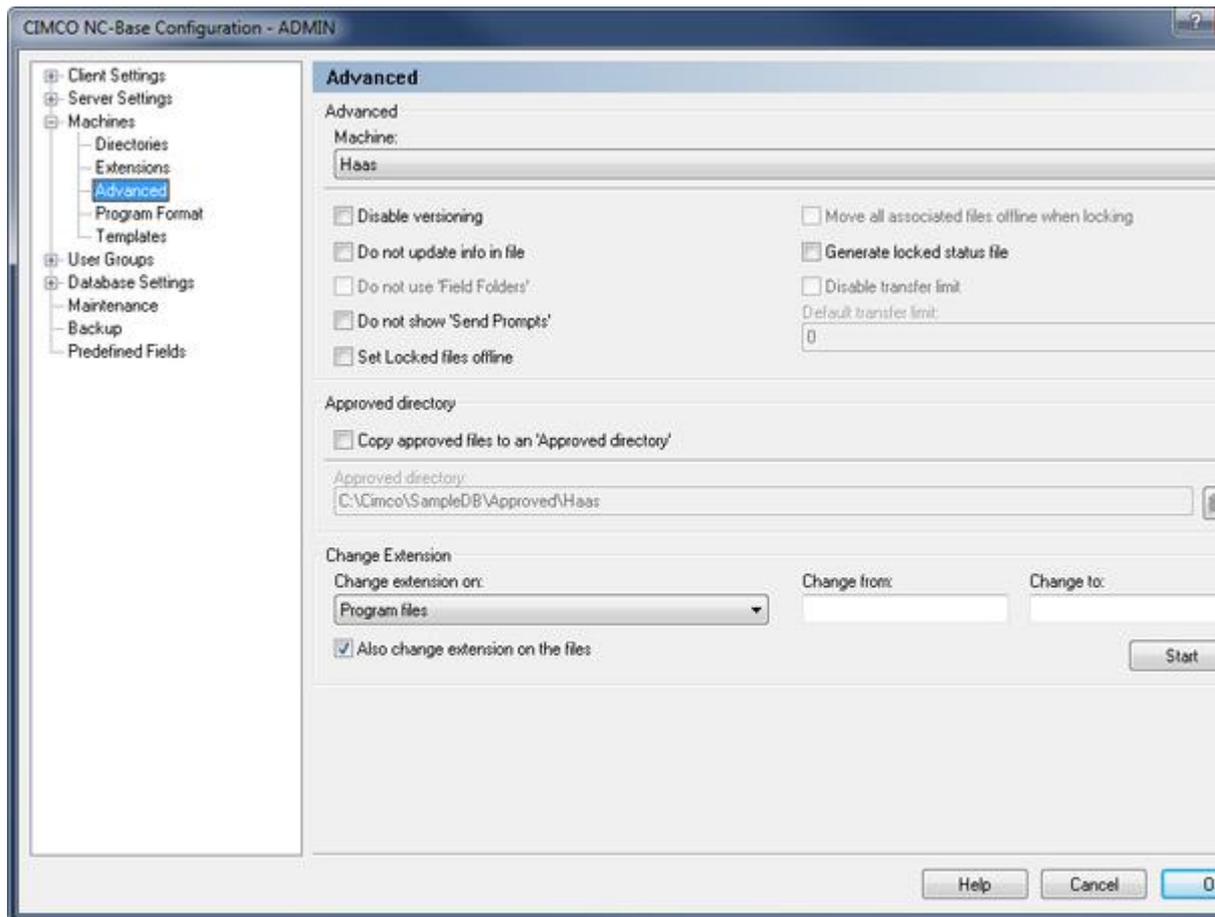
You can specify multiple extensions by separating them with commas.

Example: To show Word and JPG files, specify: DOC,JPG,JPEG.

Advanced

This section describes how to configure and use Advanced machine settings.

To open the Advanced dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Choose Advanced from the Machines menu in the left window of the CIMCO NC-Base Configuration dialog. The following window appears:



Advanced machine settings.

Advanced

Machine abc

List of all defined machines.

Disable versioning

Check this field to disable versioning for the selected machine. When versioning is enabled, a backup is created every time the program is updated. For machines using large 3D programs, this can use large amount of disk space, so you might want to disable versioning for such machines.

Do not update info in file

Check this field if the machine uses a binary program format. When this option is checked, NC-Base will not update the database information specified in the NC file.



This option is only active if you have checked the *Update files when updating program info* on the [Advanced Server Settings](#) page.

Do not use 'Field Folders'

Check this field if 'Field Folders' should not be used for this machine.



This option is only active if you have selected *Use 'Field Folders'* on the [Other Server Settings](#) page.

Do not show 'Send Prompts'

Check this field to disable 'Send Prompts' messages for this machine when the operator sends a program.

Set Locked files offline

Check this field to move locked files to a separate directory (BaseDirectory\Locked).

Move all associated files offline when locking

Check this field to move all files associated with a program to a separate directory (BaseDirectory\Locked) when a program is locked.

Generate locked status file

Check this field to generate a status text file with the locked status of the program in the send directory of directory monitor ports.

Disable transfer limit

Check this field to disable transfer limits for the selected machine.

Default Transfer Limit

Use this field to specify the default transfer limit for this machine.



To disable transfer limits by default for the selected machine, specify -1 in this field.

Approved Directory

Copy approved files to an 'Approved directory'

Check this field to copy approved program files to the specified *Approved directory*.



When a program is marked as Approved, a copy of the program file is placed in the *Approved directory*.

Approved directory

Use this field to specify the 'Approved directory'.

Change Extensions

Change extension on

Select from the drop-down list the type of files that you wish to change the extension for.

Change from

Use this field to specify the extension of files that should be changed.

To change extension on all files, specify *. To specify multiple extensions, separate them with a comma. The use of the wildcards * and ? is supported. To allow files without extensions, specify a comma at the beginning.

Example: To rename only files with the extensions .ISO and .NC, specify: ISO,NC.

Example: To rename only files where the first letter of the extension is N, specify: N*.

Example: To rename only files without an extension or with the extension NC, specify: ,NC.

Change to

Use this field to specify the new extension.

Also change extension on the files

Check this field if the file should also be renamed to use the new extension.



It is recommended that you check this option.

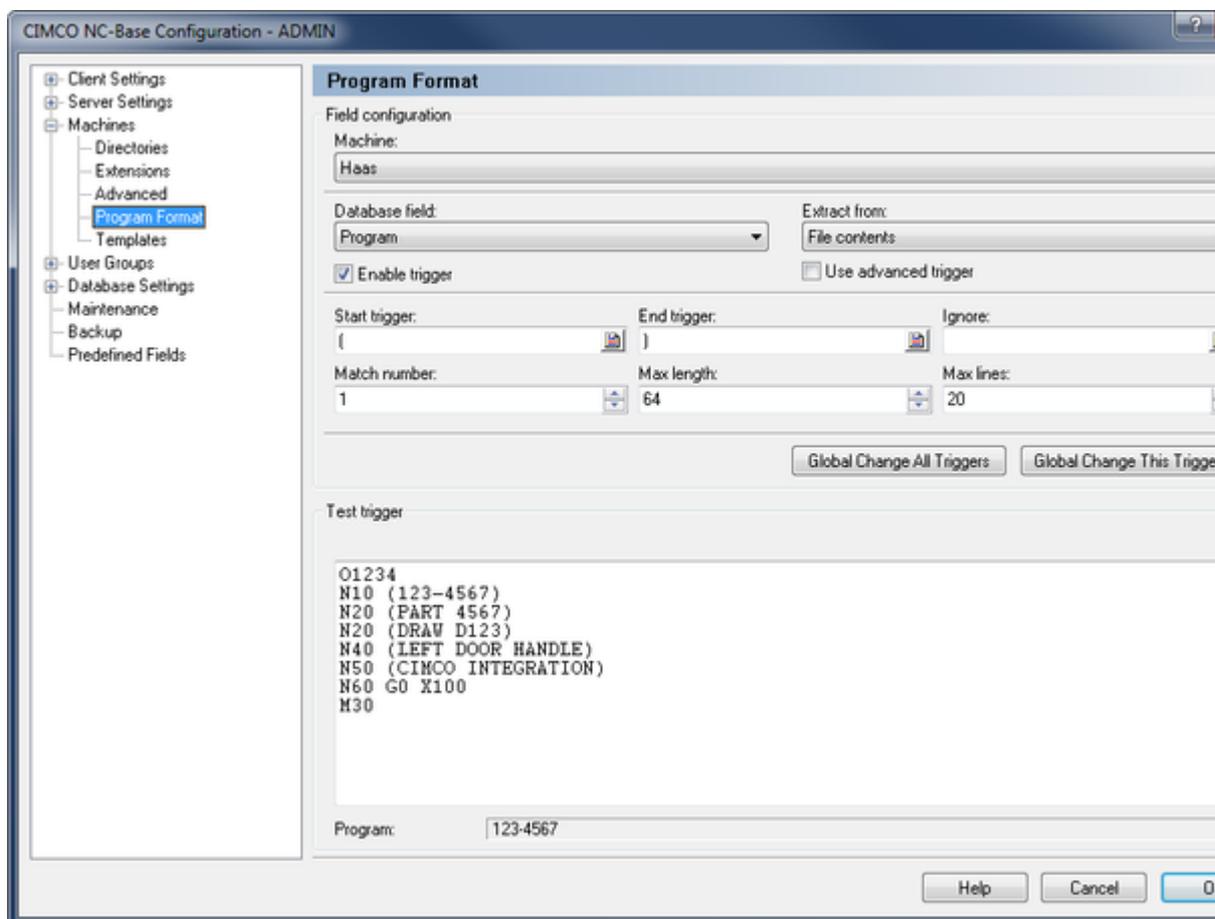
Start

Click this button to change the extensions as specified.

Program Format

This section describes how to use the Program Format functions to automatically extract NC programs comments, and depending on the configuration, fill them in the appropriate database fields. This function is active when adding programs manually or using the DNC Auto import option.

To configure Program Format, select  Setup in the *Administration* menu, or click on the Setup dialog launch icon  in the *Database* menu. Choose Program Format from the Machines menu in the left window of the NC-Base Configuration dialog. The following dialog appears:



The Program Format dialog.

Field Configuration

Machine 

Select the machine group you wish to configure a program format for.

Database field

Select the database field you wish to configure from this list.

The following database fields can be selected: *Program*, *Customer* and *Text field 1-9* (custom fields in [Database Settings](#)).

Extract from

Use this field to specify where the program information should be extracted from.

Enable trigger

Check this field to enable a trigger for the selected database field.

Please refer to [Using Triggers](#) for detailed information about triggers.

Use advanced trigger

Check this field to specify a trigger using the advanced trigger format.

Please refer to [Using Advanced Triggers](#) for detailed information about advanced triggers.

Start trigger

Use this field to specify the start trigger.

The server will look for the start trigger in the file, and when found, match all characters between the start trigger and end trigger.

End trigger

Use this field to specify the end trigger.

The server will look for the end trigger in the file, and when found, match all characters between the start trigger and end trigger.

Ignore

Use this field to specify any characters/strings/triggers that should be removed from the extracted value.

Example: If you specify '-' in this field, and the extracted value is *MOULD-3*, then the string MOULD3 will be inserted into the database.

Match number

Use this field to specify how many times the trigger should be matched, before the value is extracted.



If the trigger occurs only once in the file (i.e. each database field contains a trigger), specify 1.

Max length

Use this field to specify the maximum length of the value extracted.

Example: If you specify 4 in this field, and the extracted value is *MOULD*, only MOUL will be used.

Max lines

Use this field to specify how many lines should be scanned (starting from the top of the program).

Example: If you specify 10, and the trigger is not within the 10 first lines of the program, the value will not be found.

Global Change All Triggers

Click this button to change all triggers for the selected machine(s).

Global Change This Trigger

Click this button to change the current trigger for the selected machine(s).

Test trigger

Use this field to test your triggers. Copy the header of the corresponding NC program in the test field and test the above values to see if the correct content will be extracted.

Example: You can see in the Program Format dialog that the Start and End triggers are defined for the database field Program. We will test the following NC program, where the comment (P-ID 1234) should match the program name:

```
%  
O1234  
(P-ID 1234)  
(PART 123-4567)  
(JOB 123-4567)
```

The string '(P-ID' is used as start trigger for the program name, and ')' is used as end trigger. The extracted program name 1234 is displayed in the field below the test field.

You can proceed in the same way to test more triggers.

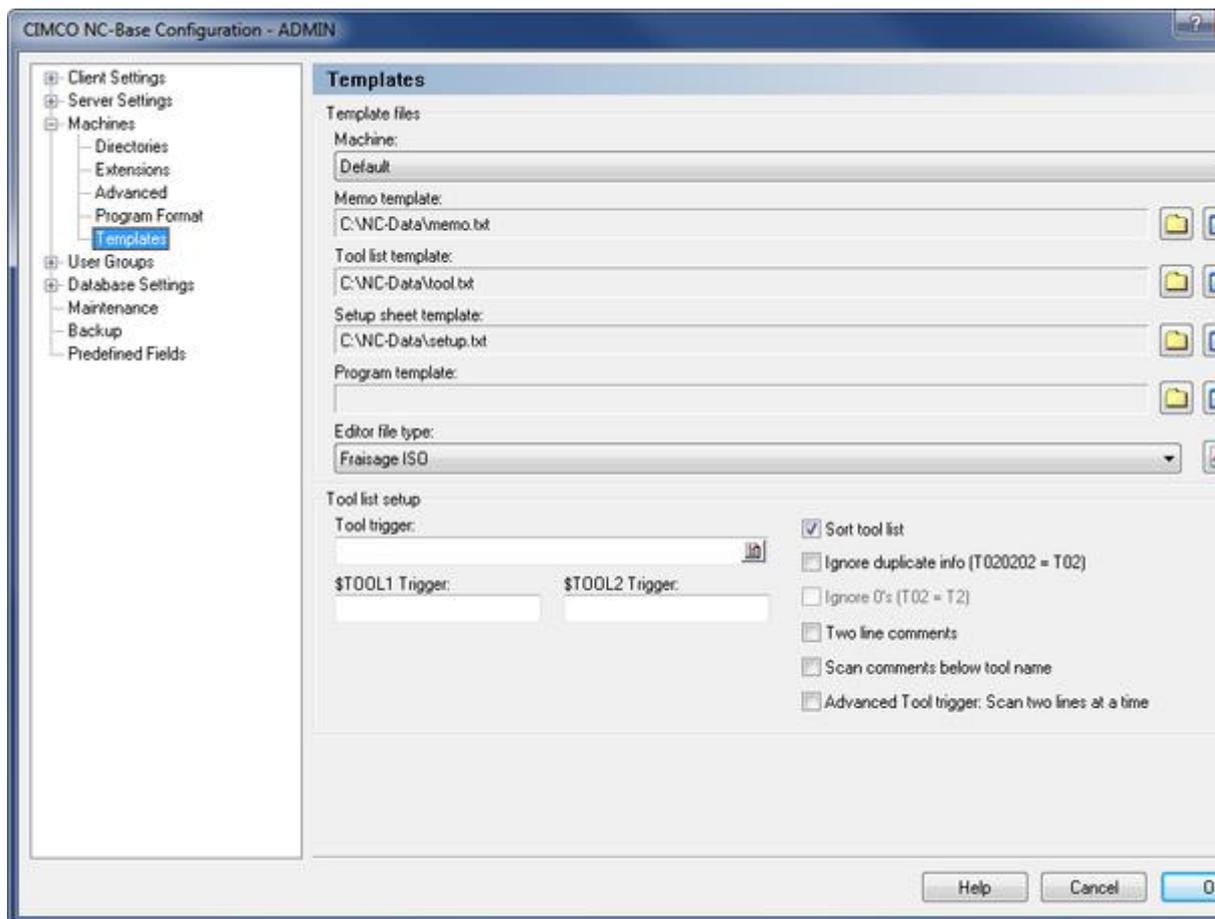
Program

This field shows the result of the test program based on the parameters specified above.

Templates

Use this dialog to configure program and associated files templates.

To open this dialog, select  Setup in the *Administration* menu, or click on the Setup dialog launch icon  in the *Database* menu. Select Templates from the Machines menu in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



Templates dialog.

Template files

The directory structure of the templates can be modified on the basis of the defined base directory. If you already use a predefined template for e.g. Setup sheet, you can select it from here.

Machine

This field displays a list of all defined machines.

Memo template

This field shows the location of the memo template. Click on the folder icon  to the right to change the memo file template.

If you wish to edit the specified memo template, click the icon  next to the folder icon.

Tool list template

This field shows the location of the tool list template. Click the folder icon  to the right to change the tool list template.

If you wish to edit the specified tool list template, click the icon  next to the folder icon.

Setup sheet template

This field shows the location of the setup sheet template. Click the folder icon  to the right to change the setup sheet template.

If you wish to edit the specified setup sheet template, click the icon  next to the folder icon.

Program template

This field shows the location of the program template. Click on the folder icon  to the right to select a template program file.

If you wish to edit the specified program template, click the icon  next to the folder icon.

Editor file type

Select a file type for this machine from the drop-down list.



Click the icon  on the right side of this field if you wish to create a new editor file type for the selected machine.

Tool list setup

Tool trigger

Use this field to specify the tool trigger.

Example: If the machine uses T01 for tool 01, specify T in this field.

\$TOOL1 Trigger

Use this field to specify the advanced trigger that should be used to generate the \$TOOL1 variable.

Example: To include the value specified after R into the following line: (T1 5MM DRILL R33), specify the trigger <R[0-9]+>. This will assign the value R33 to \$TOOL1.

Please refer to [Using Triggers](#) for detailed information about triggers.

\$TOOL2 Trigger

Use this field to specify the advanced trigger that should be used to generate the \$TOOL2 variable.

Example: To include the value specified after R into the following line: (T1 5MM DRILL R33), specify the trigger <R[0-9]+>. This will assign the value R33 to \$TOOL2.

Please refer to [Using Triggers](#) for detailed information about triggers.

Sort tool list

Check this field to sort the tool list.



When you check this field, each tool is only listed once.

Ignore duplicate info (T020202 = T02)

Check this field to ignore duplicate/magazine info in the tool number, i.e. T020202 should be listed as T02.

Ignore 0's (T02 = T2)

Check this field to ignore leading zeros in tool numbers, i.e. T02 should be listed as T2.

Two line comments

Check this field if the tool comment consists of two lines.

Scan comments below tool name

Check this field if the tool comment is always located below the tool change line.

Advanced Tool trigger: Scan two lines at a time

Check this field if the Advanced Tool trigger should scan two lines at a time.

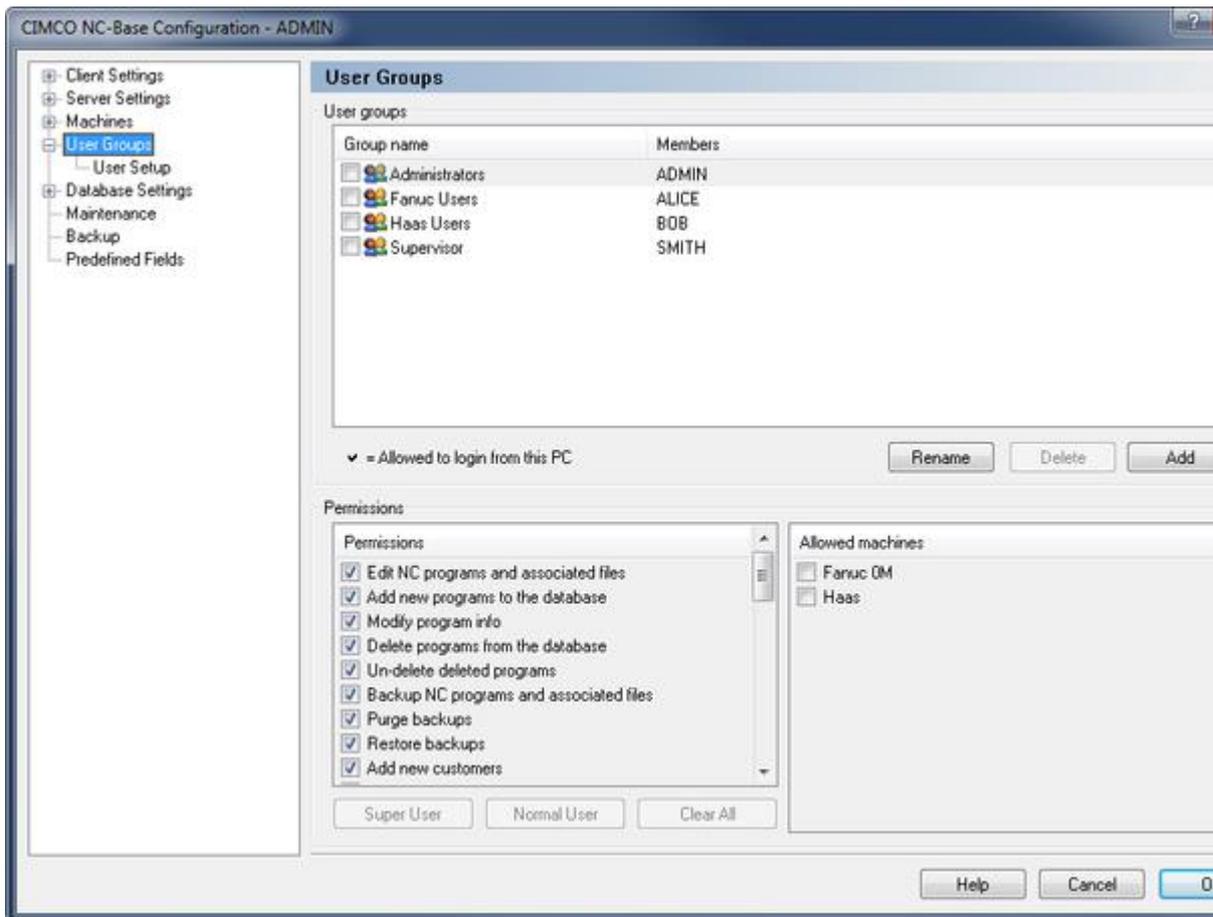
User Groups

This section describes how to configure user groups and user permissions.

Defining different users with different access profiles has some advantages:

- The number of users allowed to alter configurations is limited.
- The normal user cannot accidentally change or delete important configuration setups, nor delete an entire NC program (configuration dependent).
- Possible monitoring of each users program changes.
- Possible conferment of individual user access for each user.

To open the User Groups dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on User Groups in the left window of the CIMCO NC-Base Configuration dialog. The following window appears:



User Groups configuration dialog.

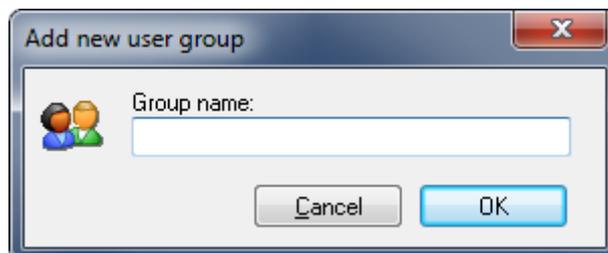
User Groups

Group name / Members

This field shows the list of all defined groups and their members.

Add

Click this button to add a new user group. The following window appears:



Add a new user group.

Enter the name of the group and click OK. If you want to exit the window without any changes, click Cancel.

Delete Button

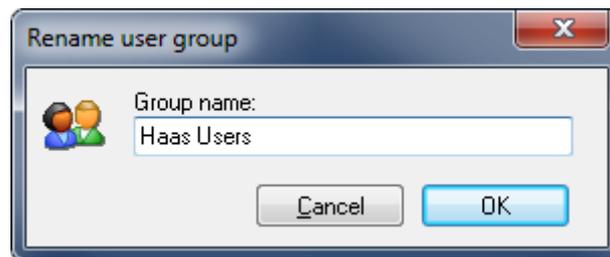
To delete a user group, highlight the user group and click Delete.



The administrator user ADMIN cannot be deleted.

Rename Button

To rename a user group, highlight the user group and click Rename. The following window appears:



Rename user group.

Assign a new name to the user group and click OK, or click Cancel to exit without any changes taking effect.

Permissions

There are two access levels: *Administrator* and *User*. You can permit a new user access on administrator level.

Permissions

This field contains a list of all defined permissions. Check the boxes in this list to allow the highlighted user group access to the corresponding functions.

Super User Button

Click this button to select the super user permissions automatically.

Normal User Button

Click this button to select the normal user permissions automatically.

Clear All Button

Click this button to clear all permissions for the selected user group.

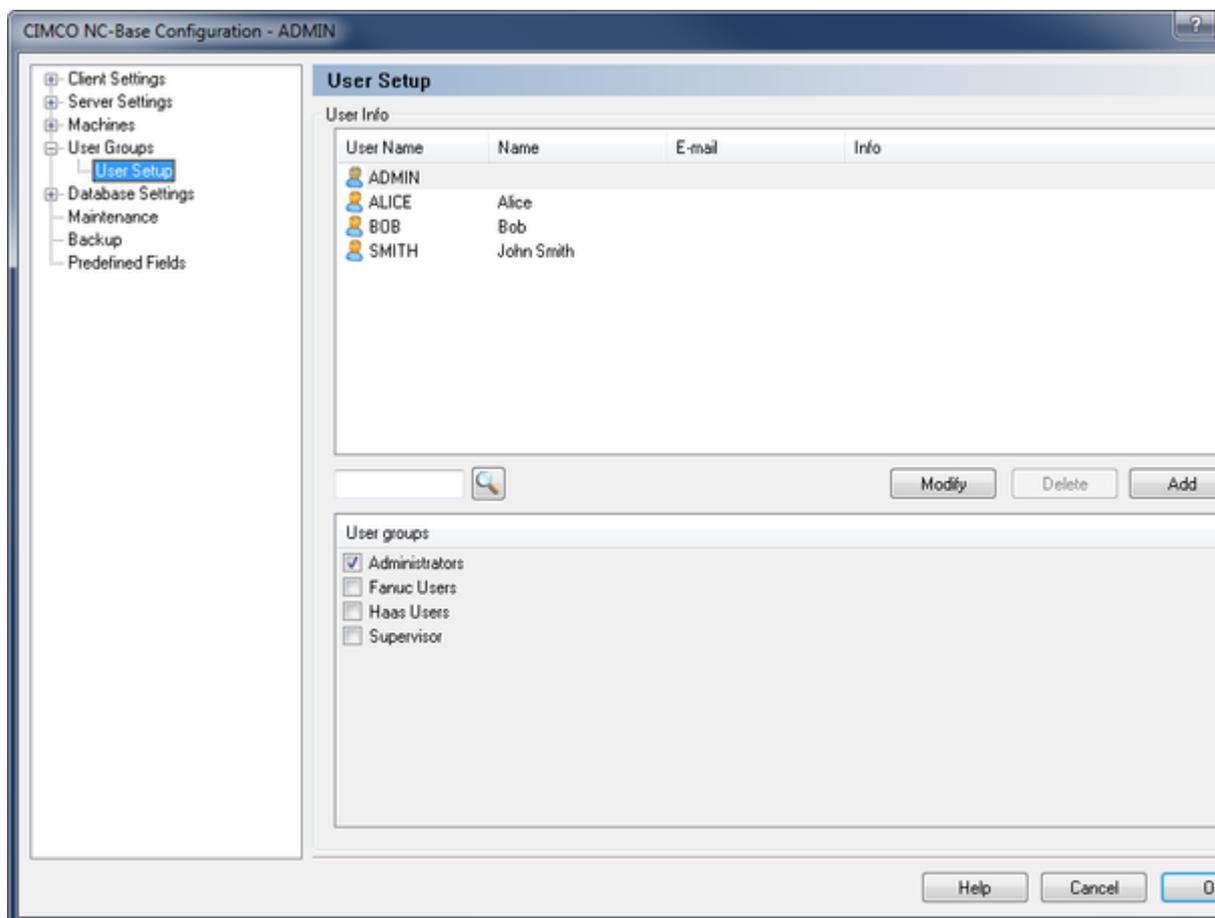
- Allowed machines

This field shows a list of all defined machines. Check the box next to the machine group to allow the selected user group access to the machine.

User Setup

Use this dialog to configure user information.

To configure the User settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. This will open the CIMCO NC-Base Configuration window. Click on User Groups in the left hand list and select User Setup. The following dialog appears:



The User Setup dialog.

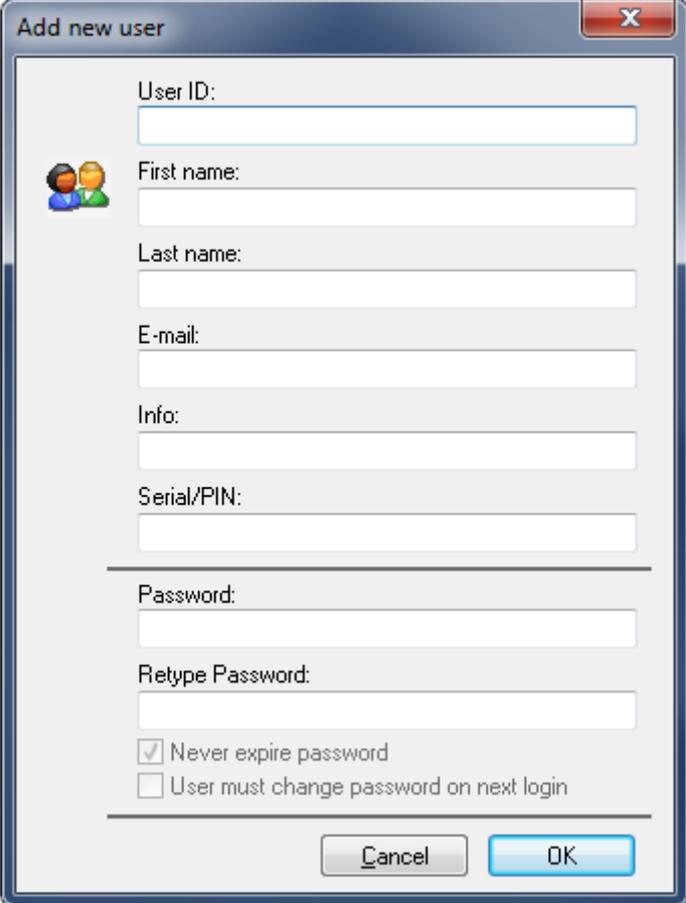
User Info

User Name

This field contains a list of all defined users.

Add Button

To add a new user, click on the button Add. The following dialog appears:



The dialog box is titled "Add new user" and contains the following fields and options:

- User ID: [Text Input]
- First name: [Text Input]
- Last name: [Text Input]
- E-mail: [Text Input]
- Info: [Text Input]
- Serial/PIN: [Text Input]
- Password: [Text Input]
- Retype Password: [Text Input]
- Never expire password
- User must change password on next login

Buttons: Cancel, OK

Add a new user.

Enter a User ID, password, and other information (if necessary) and then click OK. If you want to exit without entering data or changes taking effect, click Cancel.

Delete Button

To delete a user, highlight the user and click Delete.



The administrator ADMIN cannot be deleted.

Modify Button

To modify the information of a user, highlight the user and click Modify. A window that resembles the Add dialog appears, although with the title *Modify user*.

User Groups

List of all defined user groups. Select a user to see which user group the user belongs to.

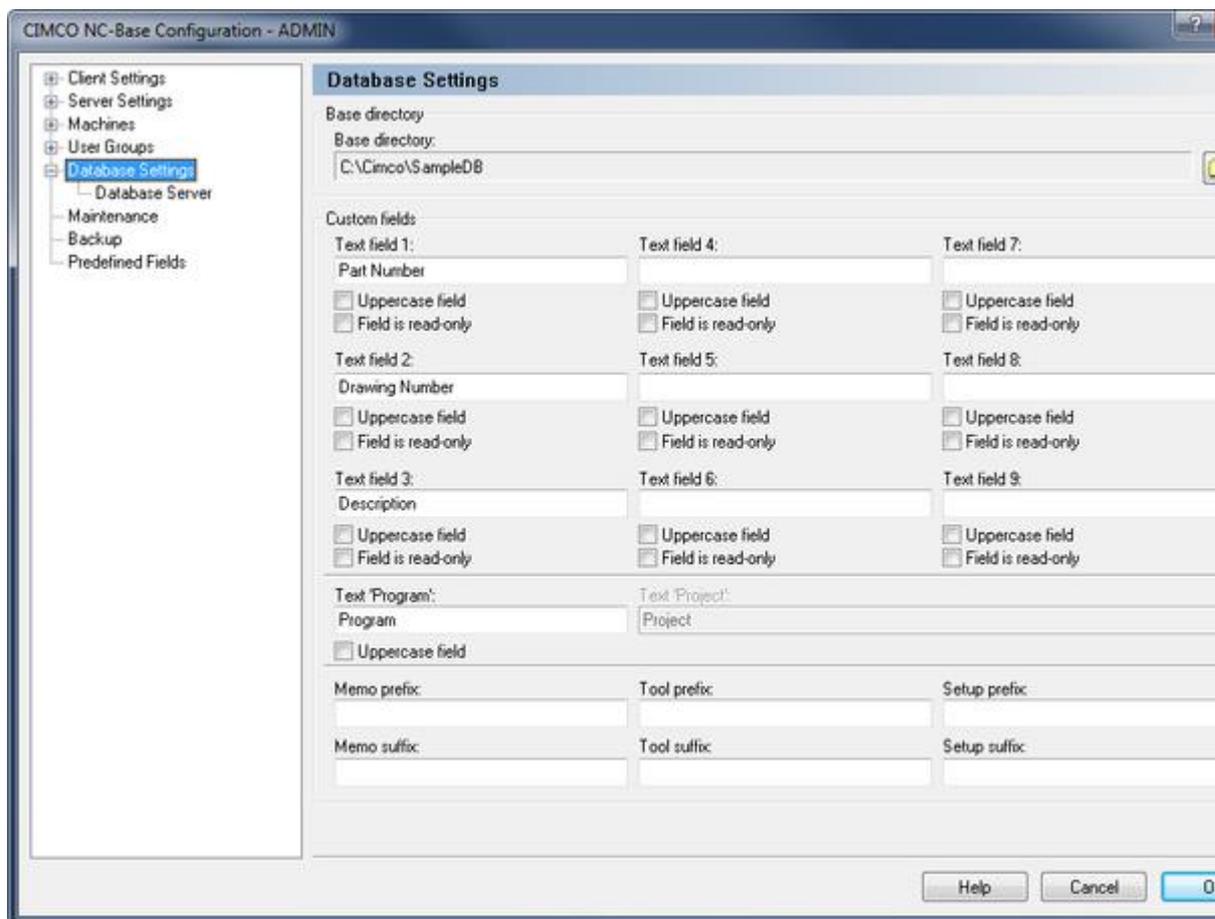


The user groups are set up in the dialog [User Groups](#).

Database Settings

This section describes how to define a Base Directory, declare Custom Fields, and affix prefix/suffix to the Memo, Tool, and Setup files.

To open the Database Settings dialog, select Setup in the *Administration* menu, or click the Setup dialog launch icon in the *Database* menu. Then in the left window of the CIMCO NC-Base Configuration, click on Database Settings. The following dialog appears:



Database Settings dialog.

Base Directory

Base Directory

In this field, the program base directory is defined. Click on the folder icon  to the right to select a base directory.

Custom fields

Text field 1 - 9

Enter into these fields the title of the corresponding custom search field. If you do not want to use this custom search field, leave it empty.

Uppercase field

Check this field to make it uppercase.

Field is read-only

Check this field to make the input field read-only.



When a field is read-only, it can only be modified by importing, receiving, or scanning the program.

Text 'Program'

Use this field to specify the title used for the 'Program' field.

Text 'Project'

Use this field to specify the title used for the 'Project' field.



You can disable this feature by checking the option *Disable project* under [Server Settings](#).

Memo Prefix

Use this field to specify the memo file filename prefix.

Memo Suffix

Use this field to specify the memo file filename suffix.

Tool Prefix

Use this field to specify the tool list filename prefix.

Tool Suffix

Use this field to specify the tool list filename suffix.

Setup Prefix

Use this field to specify the setup sheet filename prefix.

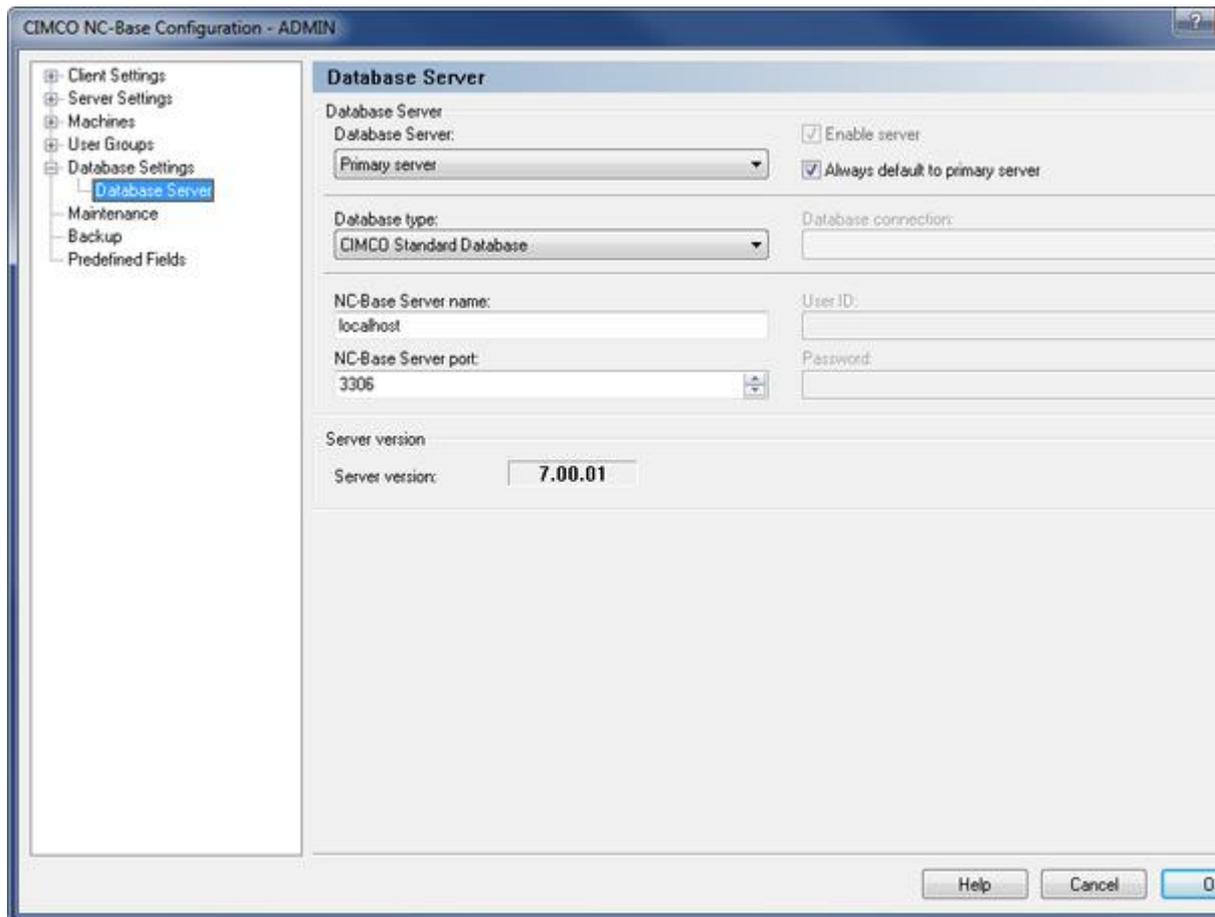
Setup Suffix

Use this field to specify the setup sheet filename suffix.

Database Server

This section describes how to configure the connection to the CIMCO NC-Base Server.

To open the Database Server dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. The CIMCO NC-Base Configuration window appears. Click on Database Settings in the left hand list and select Database Server. The following dialog appears:



Database Server.

Database Server

Database server

Select the server you want to configure from the drop-down list.

Enable server

Check this field to enable additional servers.

Always default to primary server

Check this field to always default to the primary server.

Database type

Select from this list, the type of database that should be used.

Database connection

Select the data source from this list.



You must configure the ODBC data source that should be used by NC-Base through the *Control Panel / Administrative Tools / Data Sources (ODBC)* setup dialog.

NC-Base Server name

Use this field to specify the computer name/address where the CIMCO NC-Base Server is installed. The server name can be either the IP address or the host name of the server.



If the NC-Base Server is running on this computer, you can specify 'localhost' if you are using the CIMCO NC-Base server. If you are using a MS/Oracle SQL server, you must specify the computer name.

NC-Base Server port

Use this field to specify the port number used by the NC-Base Server.



Normally, you do not need to change this value.

User ID

Use this field to specify a user ID. If the selected connection does not require a user ID, leave the field blank.

Password

Use this field to specify a password. If the selected connection does not require a password, leave this field blank.

Server version

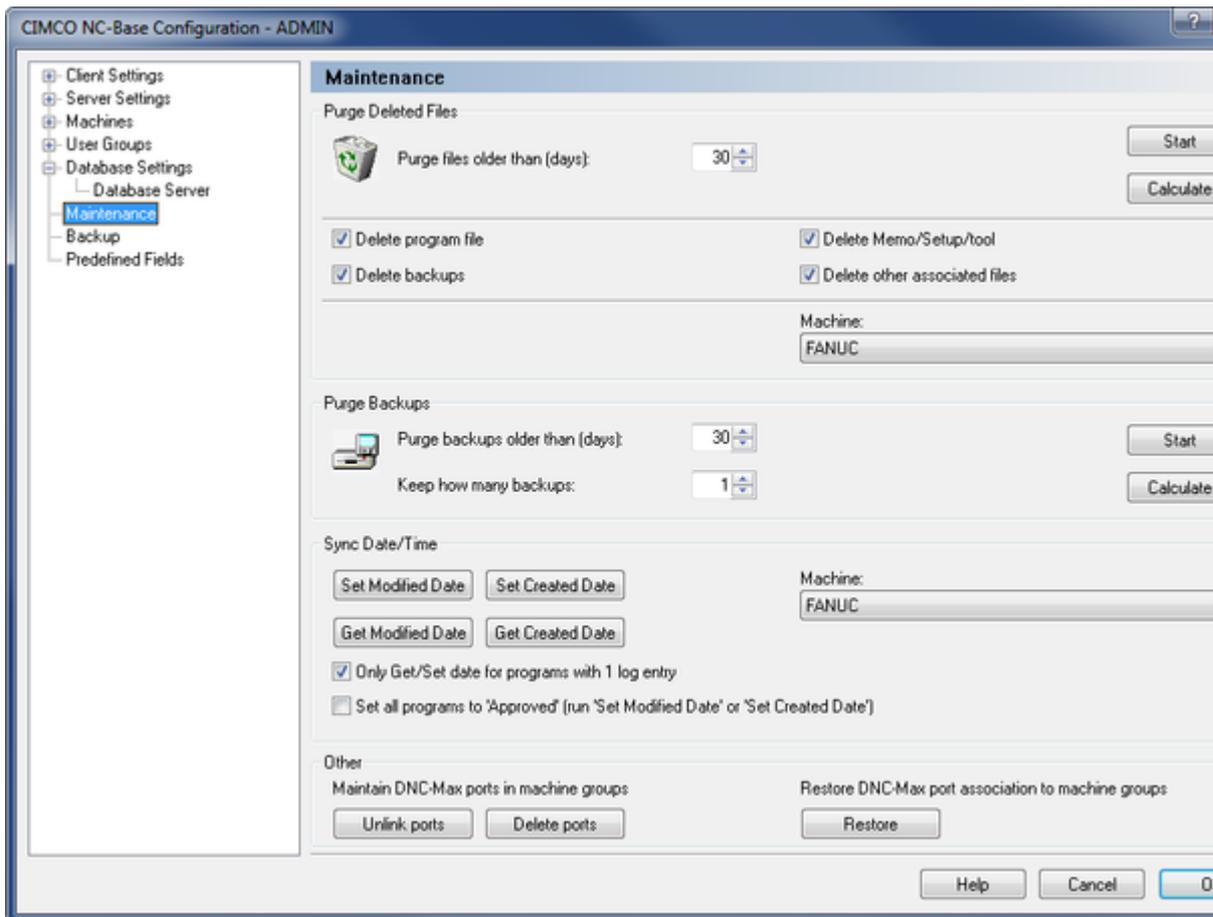
Server version

This field shows the NC-Base server version.

Maintenance

Use this dialog to perform database maintenance functions.

To open the Maintenance dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click on Maintenance in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



Maintenance dialog.

Purge Deleted Files

Purge files older than (days)

Use this field to specify the age of deleted files that should be purged.

Example: If you specify 30 in this field, all programs that were deleted more than 30 days ago will be purged from the database.

Click Start to purge the corresponding files, or click Calculate to calculate the result of running this operation first.

Start

Click this button to purge deleted programs with the specified age.

Calculate

Click this button to show the result of running this operation, without actually updating the database.

Delete program file

Check this field to physically delete program files from the hard drive, when a program is purged.

Delete backups

Check this field to physically delete backup files from the hard drive, when a program is purged.

Delete Memo/Setup/Tool

Check this field to physically delete memo/setup/tool files from the hard drive, when a program is purged.

Delete other associated files

Check this field to physically delete other associated files from the hard drive, when a program is purged.

Machine

Select from the list, the machine for which the purge operation should be performed.



If you do not select a machine, the operation will be performed for all machines.

Purge Backups

Purge backups older than (days)

Use this field to specify the age of backups that should be deleted.

Click Start to purge the corresponding files, or click Calculate to calculate the result of running this operation first.

Keep how many backups

Use this field to specify the number of backups to keep.

Example: If you specify 3 in this field, the 3 latest backups of a file will not be deleted.

Start

Click this button to purge backups with the specified age.

Calculate

Click this button to show the result of running this operation, without actually updating the database.

Sync Date/Time

Set Modified Date

Use this button to set the program modified time to the last modified time of the associated program file.

To change the time for a single machine(group), select the machine(group) from the drop-down list to the right.

Set Created Date

Click this button to set the program created time to the created time of the associated program file.

To change the time for a single machine(group), select the machine(group) from the drop-down list to the right.

Get Modified Date

Click this button to set the last modified time of the associated program file to the program modified time.

To change the time for a single machine(group), select the machine(group) from the drop-down list to the right.

Get Created Date

Use this button to set the create time of the associated program file to the program created time.

To change the time for a single machine(group), select the machine(group) from the drop-down list to the right.

Machine

Select from the list, the machine for which you want to change the date/time.



If you do not select a machine, the date/time will be changed for all machines.

Only Get/Set date for programs with 1 log entry

Check this field if you want to get/set only the date for programs with 1 log entry.

Set all programs to 'Approved' (run 'Set Modified Date' or 'Set Created Date')

Check this field if you want to set all programs to the status *Approved*.

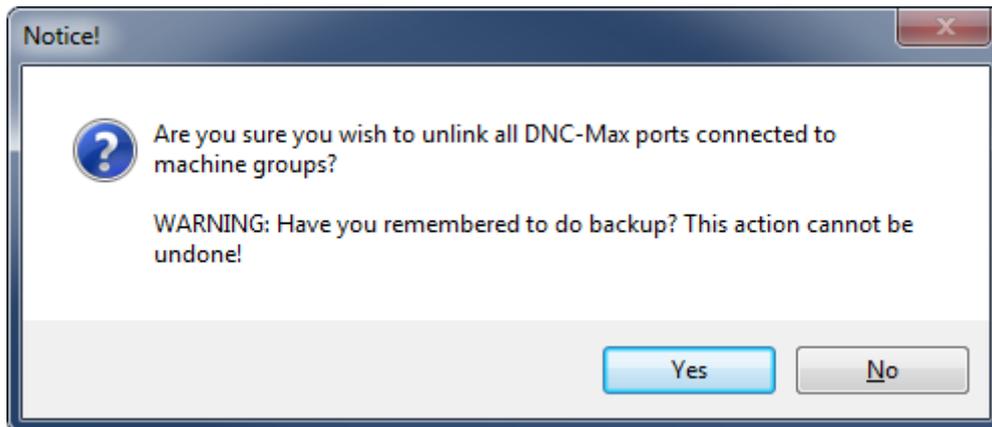
Other

Maintain DNC-Max ports in machine groups

Unlink ports Button

Click this button to unlink all DNC-Max ports connected to machine groups. The association can be restored using the *Restore* button.

When you click this button, the following message appears:



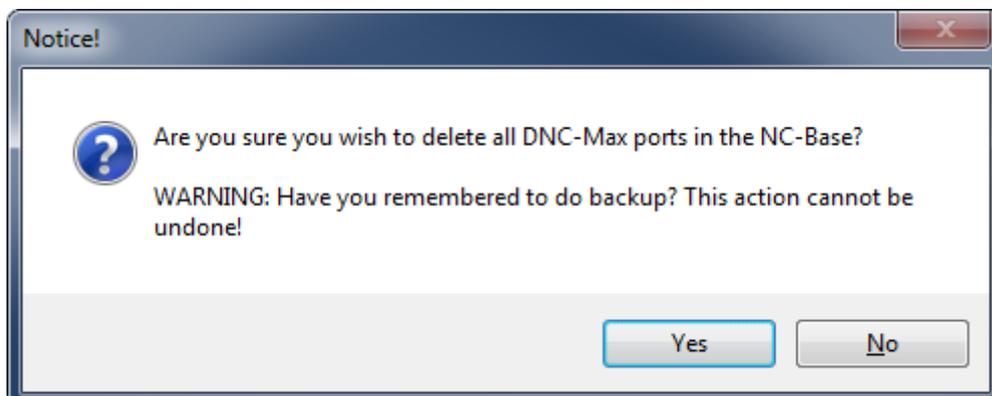
Unlink port message.

Click Yes to unlink the DNC-Max ports, or click No to abort the operation.

Delete ports Button

Click this button to delete all DNC-Max ports in the NC-Base. The ports will be recreated next time DNC-Max is restarted, and the association can then be restored using the *Restore* button.

When you click this button, the following message appears:



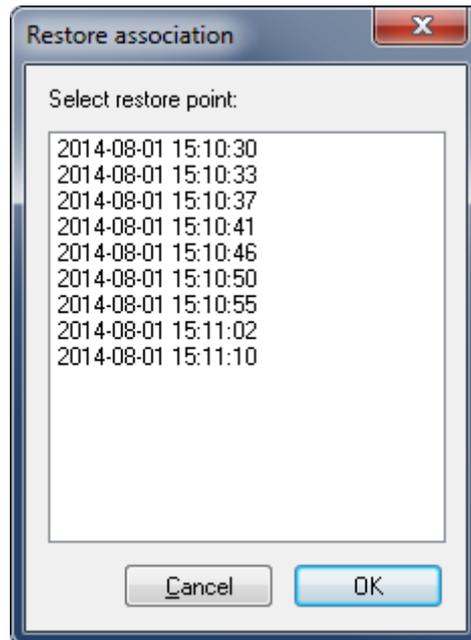
Delete port message.

Click Yes to delete the DNC-Max ports in the database, or click No to abort the operation.

Restore DNC-Max port association to machine groups

Restore 

Click this button to restore association between machine groups and DNC-Max ports, using the log file. The following dialog appears:



The Restore association dialog.

Select a restore point on the list, and click OK to restore the link between machine group and DNC-Max ports. Click Cancel if you do not wish to restore the association.

After a restore has been performed, you can verify the association on the machine group page by clicking on Machines in the left tree of the configuration window. If the restore operation was not successful, you can choose another restore point and try again.

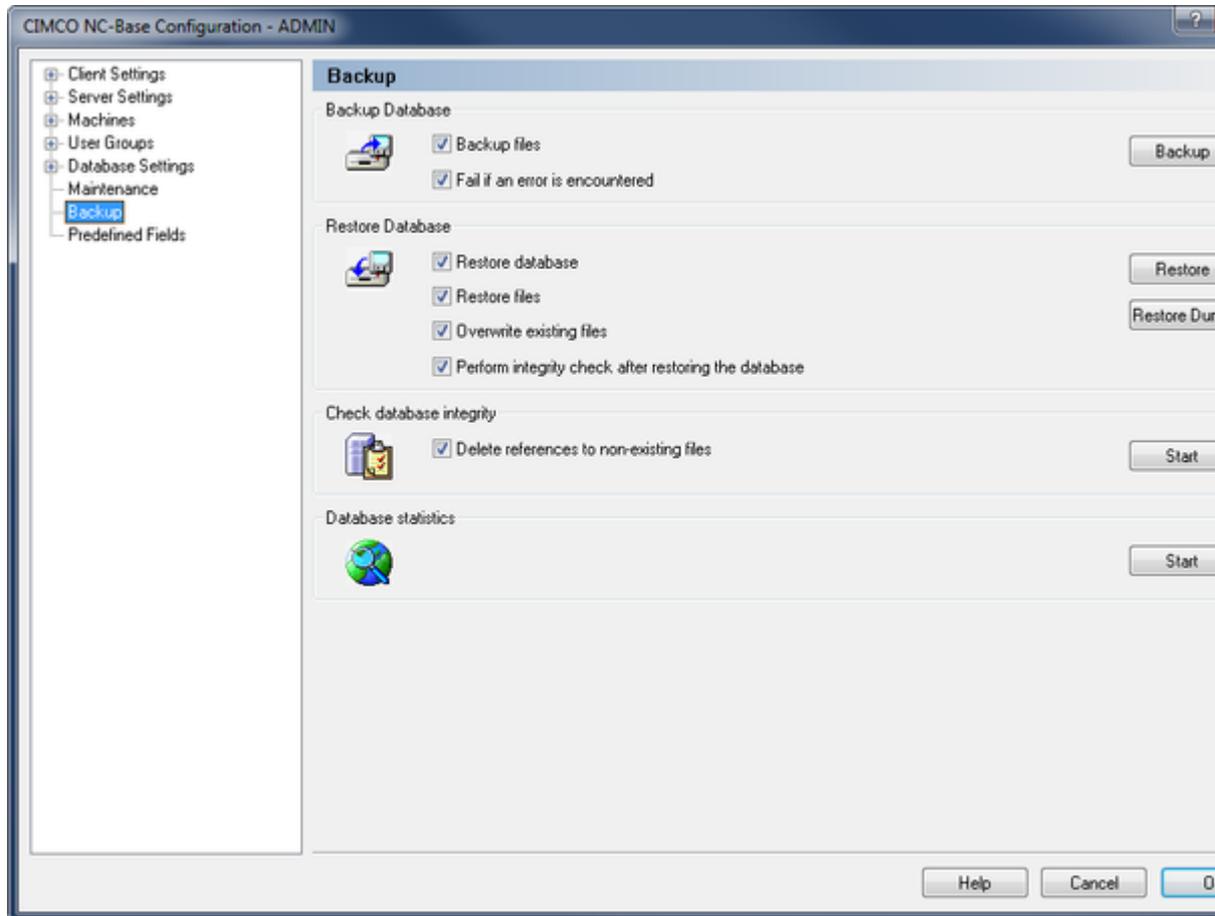


This option is only active if Backup machine group changes has been enabled under *Server Settings*.

Backup

Use this dialog to backup and restore the database.

To configure Backup settings, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Then click on Backup in the left window of the CIMCO NC-Base Configuration dialog. The following window appears:



NC-Base Backup dialog.

Backup Database

Backup files

Check this field to backup all the files in the database.

Fail if an error is encountered

Check this field if the backup should fail if one or more programs files are missing.

Backup 

Click this button to create a database backup.

Restore Database

Restore database

Check this field to restore the database.

Restore files

Check this field to restore all the files stored in the backup.



The backup file must be created with the *Backup Files* option selected.

Overwrite existing files

Check this field to overwrite existing files.

Perform integrity check after restoring the database

Check this field to perform integrity check after restoring the database.

Restore Button

Click this button to restore a database backup file (*.ncb).

Restore Dump Button

Click this button to restore a SQL dump file (*.sql).

Check Database Integrity

Delete references to non-existing files

Check this field if the database integrity check should delete all references to non-existent files.

Click Start to check the database integrity, and to repair the database if a problem arises.



It is recommended that you select this option.

Start Button

Click this button to check the database integrity, and repair the database if any problems are found.

Database Statistics

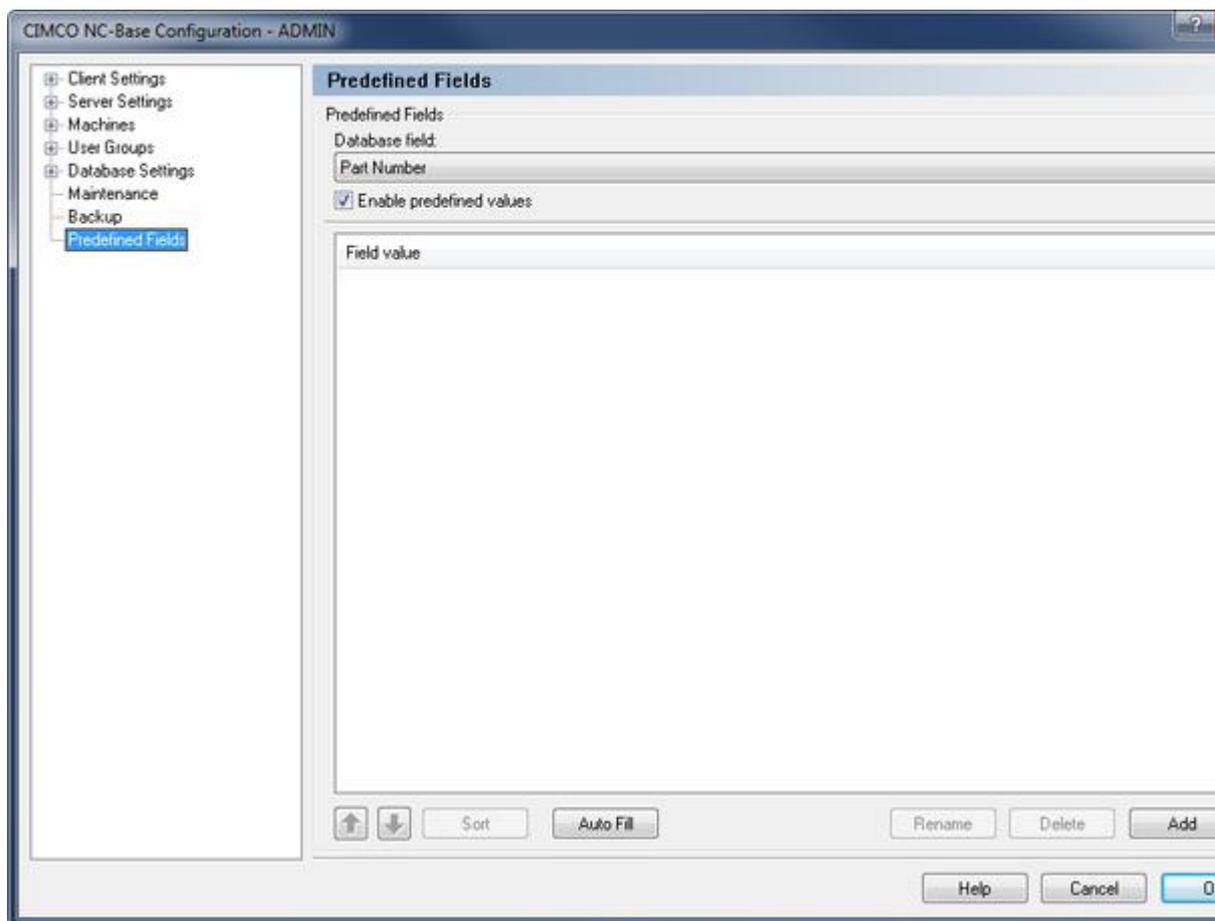
Start 

Click this button to calculate database statistics.

Predefined Fields

Use this dialog to specify predefined values for the database fields.

To open the Predefined Fields dialog, select  Setup in the *Administration* menu, or click the Setup dialog launch icon  in the *Database* menu. Click then on Predefined Fields in the left window of the CIMCO NC-Base Configuration dialog. The following dialog appears:



The Predefined Fields dialog.

Predefined Fields

Database field

Select from the list, the database field for which you wish to set up the predefined field values.

Enable predefined values

Check this field to specify predefined values for the selected database field.

Field value

This field shows a list of all predefined values for the selected database field.

Up/Down arrows

Use these buttons to move the selected value up or down the list.

Sort

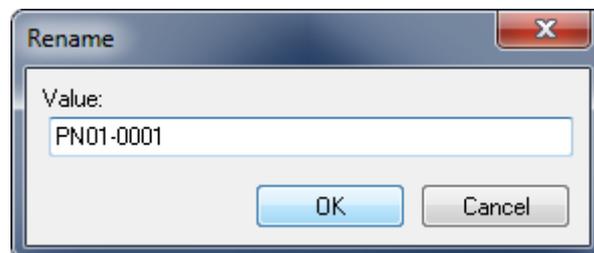
Use this button to sort the predefined values in numerical or alphabetical order.

Auto Fill

Click this button to use all the values currently in the database as predefined values.

Rename

Click this button to rename the selected entry. The following window appears:



Rename field value.

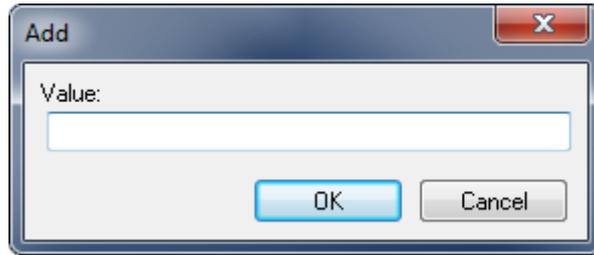
Assign a new name to the field value and click OK. If you want to exit without any changes taking effect, click Cancel.

Delete

Click this button to delete the selected field value.

Add

Use this button to add a new entry to the predefined values. The following window appears:



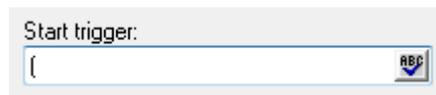
Add a new field value.

Enter the value and click OK, or click Cancel to cancel the operation.

Using Triggers

When specifying a trigger to extract comment from file contents, there are normally three different formats you can use: *Characters*, *String*, and *Advanced*.

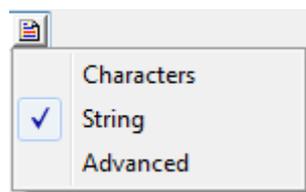
Here is an example where the same trigger is assigned to several database fields. This field is used to specify the start trigger.



Specify start trigger.

The small icon at the right end of the input field indicates the type of trigger selected, in this case *Characters*.

To change the type of trigger, click on the icon, and select the type of trigger from the drop-down list, as shown below:



Select trigger format.

Character Trigger (RBC)

Character triggers are used if you wish to trig on any single character from a list of one or more characters.

Example: To start the feed from the first line that contains % or O, specify %O in the input field, and select *Characters* from the drop-down list.

String Trigger

String triggers are used if you wish to trig on the occurrence of a specific string.

Example: To start the feed from the first line that contains the string "PGM", specify PGM in the input field, and select *String* from the drop-down list.

Advanced Trigger

Advanced triggers can be used when a more complex search is needed.

Example: To speed up the transmission, it is possible to remove comments from the transmitted data. To do this, specify the following advanced trigger `<(.*)>` in the *Omit strings* field, assuming that comments are enclosed in '(' ')'.

When specifying an advanced trigger, a small picture with a red cross  indicates an invalid expression.

For more information on how to specify advanced triggers, please refer to [Using Advanced Triggers](#).

Using Advanced Triggers



The following section provides information on how to use advanced triggers to extract program names in CIMCO DNC-Max. The extraction of comments in NC-Base is done in the same way.

This section contains information only relevant to advanced users. If you do not need to use or understand advanced triggers, you can skip this section.

NC-Base advanced triggers are a modified version of what is known as *Regular Expressions*. Regular expressions are a powerful method for searching text strings.

The following example shows how advanced triggers can be used. Suppose you have an ISO NC program with line numbers in the format N2010 at the beginning of each line, but the post processor used to generate the file has inserted a number of comment lines

at the beginning of the file without block numbers. If you want to make sure that these lines are not sent to the CNC machine, you should specify the following *Start trigger*:

```
^N[0-9]{1,4}
```

This trigger consists of the following elements:

^ The following trigger must be found at the beginning of a line

N Look for the character N

[0-9] Any character in the range from 0 to 9

{1,4} Match 1-4 of the previous character (0 - 9)

This means: *Start transfer from the first line that has N followed by 1 to 4 digits at the beginning of the line.*

A more advanced example is provided at the end of this section.

List of Symbols Recognized by Advanced Triggers

- . Match any single character
- * 0 or more of previous expression
- + 1 or more of previous expression
- Range
- ^ Negate set (inside set delimiters [])
- { Start interval
- } End interval
- [Begin set
-] End set
- ? Previous expression is optional

- | Previous expression OR next expression
- ^ Anchor to beginning of line
- \$ Anchor to end of line
- (Start of sub expression
-) End of sub expression
- < Start extraction
- > End extraction

To use a special symbol as part of the text to be found, precede it with a backslash character '\'.

Example: To find a '\' at the beginning of a line, specify `^\`.

Sets (Bounds)

Sets are specified with the '[' and ']' symbols.

Example: `[abc]` will find an occurrence of any one of the characters 'a', 'b' or 'c'.

You can negate a set by specifying '^' as the first character in the set.

Example: `[^abc]` match any character that is not 'a', 'b' or 'c'.

Ranges

Ranges are specified with the '-' symbol.

Example: `[a-z][0-9]` will find any character from 'a' to 'z' followed by any digit from '0' to '9'.

Example: `[a-zA-Z0-9]` will find any letter or digit.

Interval Expressions

Interval expressions are specified with the symbols '{' and '}'.

Example: `[0-9]{1,4}` will find 1-4 digits.

Example: `[0-9]{3,}` will find 3 or more digits.

Example: `[0-9]{4}` will find exactly 4 digits.

Extracting Sub Expressions

To extract part of the expression, enclose the sub expression in '<' and '>'.

Example: To extract the program number 1234 from the string `PRG=1234`, specify `PRG=<[0-9]{4}>`.

Regular Expressions

A regular expression (RE) is one or more non-empty branches separated by '|'. It matches anything that matches one of the branches.

A branch is one or more pieces concatenated. It matches a match for the first, followed by a match for the second, etc.

A piece is an atom possibly followed by a single '*', '+', '?' or bound. An atom followed by '*' matches a sequence of 0 or more matches of the atom. An atom followed by '+' matches a sequence of 1 or more matches of the atom. An atom followed by '?' matches a sequence of 0 or 1 matches of the atom.

A bound is '{' followed by an unsigned decimal integer, possibly followed by ',' possibly followed by another unsigned decimal integer, always followed by '}'. The integers must lie between 0 and 255 inclusive, and if there are two of them, the first may not exceed the second. An atom followed by a bound containing one integer *i* and no comma matches a sequence of exactly *i* matches of the atom. An atom followed by a bound containing one integer *i* and a comma matches a sequence of *i* or more matches of the atom. An atom followed by a bound containing two integers *i* and *j* matches a sequence of *i* through *j* (inclusive) matches of the atom.

An atom is a regular expression enclosed in '()' (matching a match for the regular expression), an empty set of '()' (matching the null string), a bracket expression (see below), '.' (matching any single character), '^' (matching the null string at the beginning of a line), '\$' (matching the null string at the end of a line), a '\' followed by one of the characters `^.[${}]*+?{\` (matching that character taken as an ordinary character), a '\' followed by any other character (matching that character taken as an ordinary character,

as if the '\ ' had not been present), or a single character with no other significance (matching that character). A '{' followed by a character other than a digit is an ordinary character, not the beginning of a bound. It is illegal to end a regular expression with '\ '.

A bracket expression is a list of characters enclosed in '['']. It normally matches any single character from the list (but see below). If the list begins with '^', it matches any single character (but see below) not from the rest of the list. If two characters in the list are separated by '-', this is shorthand for the full range of characters between those two (inclusive) in the collating sequence, e.g. '[0-9]' in ASCII matches any decimal digit. It is illegal for two ranges to share an endpoint, e.g. 'a-c-e'.

To include a literal ']' in the list, make it the first character (following a possible '^'). To include a literal '-', make it the first or last character, or the second endpoint of a range. To use a literal '-' as the first endpoint of a range, enclose it in '['.' and '.]' to make it a collating element (see below). With the exception of these and some combinations using '[' (see next paragraphs), all other special characters, including '\ ', lose their special significance within a bracket expression.

Within a bracket expression, a collating element (a character, a multi-character sequence that collates as if it were a single character, or a collating sequence name for either) enclosed in '['.' and '.]' stands for the sequence of characters of that collating element. The sequence is a single element of the bracket expression's list. A bracket expression containing a multi-character collating element can thus match more than one character, e.g. if the collating sequence includes a 'ch' collating element, then the regular expression '['[.ch.]]*c' matches the first five characters of 'chchcc'.

Within a bracket expression, a collating element enclosed in '['=' and '=]' is an equivalence class, standing for the sequences of characters of all collating elements equivalent to that one, including itself. (If there are no other equivalent collating elements, the treatment is as if the enclosing delimiters were '['.' and '.]'.) . For example, if o and ^ are the members of an equivalence class, then '['[=o=]]', '['[=^=]]', and '[o^]' are all synonymous. An equivalence class may not be an endpoint of a range.

In the event that a regular expression could match more than one substring of a given string, the RE matches the one starting earliest in the string. If the RE could match more than one substring starting at that point, it matches the longest. Subexpressions also match the longest possible substrings, subject to the constraint that the whole match be as long as possible, with subexpressions starting earlier in the regular expression taking

priority over ones starting later. Note that higher-level subexpressions thus take priority over their lower-level component subexpressions.

Match lengths are measured in characters, not collating elements. A null string is considered longer than no match at all. For example, 'bb*' matches the three middle characters of 'abbbc', '(wee|week)(knights|nights)' matches all ten characters of 'weeknights', when '(.*).*' is matched against 'abc' the parenthesized subexpression matches all three characters, and when '(a*)*' is matched against 'bc' both the whole RE and the parenthesized subexpression match the null string.

Advanced Trigger Example

The advanced triggers can also be used to look for program numbers, path information etc. The following example can be used in the standard protocol auto receive setup to identify the program name for the received file.

Suppose we store the program name in the NC program as O2123 (where 2123 is the program number), but we only want to look for program numbers in a specific line, if the previous line starts with a character %. If this is the case, we should specify:

```
^%.*\LF.*O<[0-9]{4}>([0-9]+|$)
```

This trigger consists of the following elements:

- ^ The following trigger must be found at the beginning of a line
- % Look for the character %
- . Match any character
- * Match zero or more of the previous character, in this case any character
- \LF Match a line feed
- . Match any character
- * Match zero or more of the previous character, in this case any character
- O Look for the character O

< Start of program name

[0-9] Any character in the range from 0 to 9

{4} Match 4 of the previous character, in this case any character in the range from 0 to 9

> End of program name

(Start of sub-expression

[^0-9] Any character outside the range from 0 to 9

+ Match one or more of the previous character, in this case, any character outside the range from 0 to 9

| Match the expression to the left or to the right of the '|'

\$ Must be at end of line

) End of sub-expression

This is translated into something like this:

Look for a line that begins with %, then accept all characters until the end of the line. On the next line, accept all characters until 0 followed by 4 digits. These 4 digits must be followed by either one or more characters that are not digits, or must be at the end of the line.

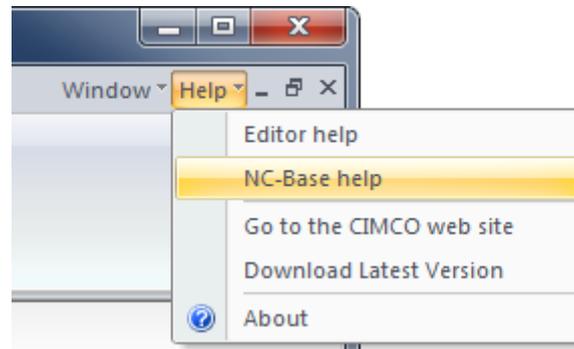
The last part ensures that exactly 4 digits must be specified. Because something like O12345, is 0 followed by 4 digits, followed by something that is a digit (5), and it is therefore not matched.

The '<' and '>' are the delimiters for the part of the expression that should be extracted to get the program number. In this case, 4 digits.

Using NC-Base Help

This section describes how to use the help system in CIMCO products.

A standard Windows Help file is available through the drop-down Help menu by clicking NC-Base help.



Help menu.

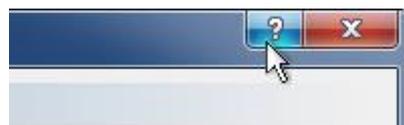


- [Using Help In Dialogs](#)
- [Printing Help Information](#)

Using Help In Dialogs

CIMCO NC-Base v7 contains multiple dialogs that provide drop-down lists, check boxes, text fields and buttons for specific configurations.

To get help for a particular dialog item, click the ? at the top of a dialog box, as shown below.



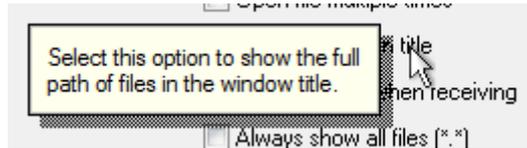
Click the question mark.

This will change the cursor to an arrow and a question mark indicating that you are in *Help Mode*. The new pointer is shown below.



The question cursor.

Now click on the item that you want further information about. If help is available for the selected item, a small window will pop up displaying the help text. If no help is available the general help file is launched. An example of a pop-up help is shown below.

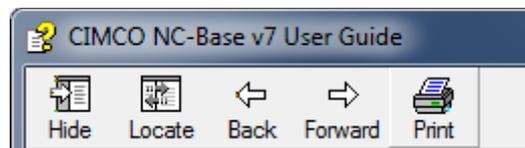


The pop-up information.

You can also display the pop-up help for a dialog item by clicking in the field and then pressing F1.

Printing Help Information

If you wish to print just a single section of this help file, click the Print button on the toolbar (shown below).



Help buttons.

If you wish to print more than a few sections, you should open the PDF version of the documentation. The PDF document produces a much nicer printout.

You can download the PDF version of the user guide from the CIMCO website.



You will need Adobe Reader to open the PDF file.

NC-Base

Find programs

Program:
[Text Input Field]

Machine:
[Dropdown Menu]

Customer:
[Dropdown Menu]

Status:
[Dropdown Menu]

[Red X Icon] [Search Button]

Advanced search

Program Search.

Program search with customised search fields

If you have defined *Text field 1*, *Text field 2*, *Text field 3*, etc. in [Database Settings](#), these fields will be recognised as search fields (see following picture).

NC-Base

Find programs

Program:
[Text Input Field]

Text field 1:
[Text Input Field]

Text field 2:
[Text Input Field]

Text field 3:
[Text Input Field]

Text field 4:
[Text Input Field]

Machine:
[Dropdown Menu]

Customer:
[Dropdown Menu]

Status:
[Dropdown Menu]

[Red X Icon] [Search Button]

Advanced search

Program search with customised search fields.



You can specify up to 9 customised search fields.

Preview

If you highlight an NC program or an associated file in the NC-Base search result window to the right, the contents will be displayed in a separate window below the search result window (see the following picture).

The screenshot shows the NC-Base software interface. On the left is a 'Find programs' sidebar with search filters for Program, Part Number, Drawing Number, Description, Machine, Customer, and Status. The main area displays a search result table with columns for Program, Machine, Description, Part Number, and Drawing Number. The selected file 'R1001.NC' is highlighted. Below the table, a preview window shows the contents of 'FANUC 0M\WC\R1001.NC', displaying G-code lines such as O1001, N0010 (PART:PN01-1001), N0020 (DRAW:DWG1001-A1), N0030 (DESC:SAMPLE PART 1001), N0040 (CUST:SUPER PARTS INC.), N0050 G21, N0060 G0G17G40G49G80G90, N0070 T1M6 (BALL ENDMILL DIA 6 OFF 46), N0080 G0G90G54X15.2Y56.359A0.S0M5, N0090 G43H Z50., N0100 Z10., N0110 G1Z1.F1.5, N0120 G2X10.25Y53.75Z.695R6., and N0130 X4.25Y59.75Z.201R6.

Program	Machine	Description	Part Number	Drawing Number
R1001	Fanuc 0M	SAMPLE PART 1001	PN01-1001	DWG1001-A1
R1001.NC	Program file	FANUC 0M\WC\R1001.NC		
R1001.bt	Tool List	Fanuc 0M\TOOL\R1001.bt		
R1001.bt	Setup Sheet	Fanuc 0M\setup\R1001.bt		
1-601.jpg	JPEG image	FANUC 0M\OTHER\1-601.jpg		
R1002	Fanuc 0M	SAMPLE PART 1002	PN01-1002	DWG1002-A1
R1003	Fanuc 0M	SAMPLE PART 1003	PN01-1003	DWG1003-A1
R1003.NC	Program file	FANUC 0M\WC\R1003.NC		
R1003.bt	Tool List	Fanuc 0M\Tool\R1003.bt		

FANUC 0M\WC\R1001.NC Size: 4.910 / 13m Modified: 08-03-2013 12:04

```
O1001
N0010 (PART:PN01-1001)
N0020 (DRAW:DWG1001-A1)
N0030 (DESC:SAMPLE PART 1001)
N0040 (CUST:SUPER PARTS INC.)
N0050 G21
N0060 G0G17G40G49G80G90
N0070 T1M6 ( BALL ENDMILL DIA 6 OFF 46 )
N0080 G0G90G54X15.2Y56.359A0.S0M5
N0090 G43H Z50.
N0100 Z10.
N0110 G1Z1.F1.5
N0120 G2X10.25Y53.75Z.695R6.
N0130 X4.25Y59.75Z.201R6
```

File preview.



In [Client Settings](#), you can deactivate the preview by checking the *Disable preview* field, or you can specify whether to *Preview associated files*.

Add/remove columns

By right-clicking the title bar of any column in the search window, you can add or remove columns from the Explorer search result window (see following picture).

Program	Machine	Description	Part Number	Drawing Number	Status	Modified
R1001	Fanuc 0M	SAMPLE PART 1001	1001-A1	1001-A1	Approved	18-04-2013 10:30:35
R1002	Fanuc 0M	SAMPLE PART 1002	1002-A1	1002-A1	Approved	18-12-2012 16:16:57
R1003	Fanuc 0M	SAMPLE PART 1003	1003-A1	1003-A1	Approved	18-12-2012 16:16:57
R1004	Fanuc 0M	SAMPLE PART 1004	1004-A1	1004-A1	Approved	04-07-2013 13:17:15
R1005	Fanuc 0M	POCKET EXAMPL	1005-A1	1005-A1	Approved	18-12-2012 16:16:57
R1006	Fanuc 0M	SAMPLE PART 1006	1006-A1	1006-A1	Approved	04-07-2013 13:17:15
R1007	Fanuc 0M	SAMPLE PART 1007	1007-A2	1007-A2	Approved	04-07-2013 13:17:15
R1008	Fanuc 0M	SAMPLE PART 1008	1008-A1	1008-A1	Approved	04-07-2013 13:17:15
R1009	Fanuc 0M	ELEPHANT	1009-B1 REV3	1009-B1 REV3	Approved	04-07-2013 13:17:15

Machine	Description	Part Number	Drawing Number	Status	Modified
Machine	Description	Part Number	Drawing Number	Status	Modified
Created	Deleted	File path	Deleted By	Modified By	Customer
Address	City	Country	Telephone	Fax	Homepage
Name	Contact Telephone	Email	Locked	Filename	


```

FANUC 0M\NC\R1001.NC
O1001
N0010 (PART:PN01-1001)
N0020 (DRAW:DWG1001-A1)
N0030 (DESC:SAMPLE PART 1001)
N0040 (CUST:SUPER PARTS INC.)
N0050 G21
N0060 G0G17G40G49G80G90
N0070 T1M6 ( BALL ENDMILL DIA
N0080 G0G90G54X15.2Y56.359A0.5
N0090 G43H Z50.
N0100 Z10.
N0110 G1Z1.F1.5
N0120 G2X10.25Y53.75Z.695R6.
N0130 X4.25Y59.75Z.201R6

```

Add/remove columns.

In the context menu, which appears when right-clicking the title bar, you can check and uncheck a column title to make it appear in or disappear from the Explorer search result window.

Column order

You can easily change the column order by clicking a column title and dragging it to a new position.



You can click and drag between column titles to adjust the width of the nearest column to the left.