

# SuiteFactory™ DNC Administrator's Guide For V7.1.125 - up

**This document is a guide for setting up SuiteDNC. It shows all the various parameters and settings that are included. It does not give detailed descriptions of each setting but shows what is possible and where it is found. For details, refer to CCI's full manual on CD or online at [www.suitefactory.com](http://www.suitefactory.com).**

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## Preface

(Note! \*\* indicates that the feature optional).

This document applies to the SuiteDNC™ part of SuiteFactory™. Other SuiteFactory applications include SuiteDOCS™ for document and records control, storage and retrieval and SuitePACS™ for creating electronic shop floor job packets (folders) containing all the information required to perform an operation or any other set of related documents. When installing SuiteFactory for the very first time there are a number of steps to follow to ensure the application is set up to:

- follow your shop's standards, methods and rules
- provide security for your DNC files
- machine tool communications

It would be helpful to sketch out a layout of your shop DNC configuration. Show all workstations that will be running SuiteFactory, and assign them DNC system names. These names do not have to be the same as the computer's network name though they can be. These names should be familiar to the programmers and the operators on the shop floor. If you have multiple shop floor workstations and/or multiple RS-232 devices, show where they are, what COM ports they are assigned and what machines are to be attached to them.

## Install multi-port wired or wireless RS-232 serial devices

Before configuring and setting up SuiteFactory, the RS-232 communications devices should be in place and device drivers loaded.

## Setup SuiteFactory

**Setup requires administrative rights to do so. Therefore, to start the setup, login as administrator.**

The following table lists the various tasks for configuring SuiteFactory. They do not necessarily have to be done in the order shown. Nor do they necessarily have to be done in the order described in the rest of this guide. Of course, logically, some things have to be done before others. The context should clarify this along the way. For example, you need a database folder before you can select a database path, before you can register your workstation which is required before you can do anything else. **Note - some features of SuiteDNC are optional and depend upon the license you purchased. This is indicated by an \*\* next to the item.**

Database Configuration
Workstation Registration
General System Configuration
Workstations
Machines
Resource Collections
Users
User Groups
3 <sup>rd</sup> Party Tools **
Manage Language

Figure 1 - SuiteFactory Configuration Tasks

## **Configure SuiteFactory Database**

Create a Windows folder for your database. Name it something like SuiteFactoryDB. This folder must be located on a computer on your Local Area Network (LAN) that all SuiteFactory users can share. All SuiteFactory users need read/write/modify rights to this folder from the sharing and security points of view. Inside that folder create another and name is something like SFDB71125. If your database will be Microsoft Access, all the database information will be located in this folder. It is not necessary or desirable to map a drive letter to this share. SuiteFactory uses the Universal Naming Convention (UNC) to locate shared networked folders.

If your database will be SQL Server\*\* all of your DNC files and text or XML configuration and semaphore files will be located in this folder. The database tables will be located somewhere determined by the SQL server application. The latter can be configured using the Microsoft Enterprise Manager utility.

**Note! For proper operation the SuiteFactory database files must be located in a sub-folder of the shared folder. For example, as suggested, above, C:\SuiteFactoryDB\SFDB71125 where the SuiteFactoryDB folder is setup as shared with read/write/modify rights for all Windows users that need access to Suitefactory.**

**Note! For best performance the database should be located on the same computer that serves the RS-232 serial communication ports. This is not a necessity, however. On a typical, moderately busy 100 base-T Ethernet LAN with Ethernet switches used rather than old-fashioned hub, performance should be more than adequate. Having the database automatically backed up in a timely fashion usually outweighs performance considerations.**

*If this is a new installation you will be prompted to configure the database. To start the process click OK.*

### **Select SuiteFactory Database**

Select a Database Provider: *Microsoft Jet 4.0 (Access) or SQL Server\*\*.*

#### **Microsoft Jet 4.0 Choice**

Browse to the folder created, above, or create a new one if you did not create one earlier. We recommend using the Universal Naming Convention (UNC) method of naming the networked path rather than mapping a network drive. Click OK.

#### **\*\* SQL Server Choice**

Select the SQL server computer that will host your database. If this is the first time you are setting up SuiteDNC on this SQL Server computer you will have to create a new database. Click Create. Enter the name you want to call the Catalog Set and then browse to the folder you created above or create a new one if you did not create one earlier. You can use the same name for the Catalog Set as the name of the folder if you wish. We recommend using the Universal Naming Convention (UNC) method of naming the networked path rather than mapping a network drive. Click OK.

## LOGIN as Administrator

Regardless of the database type you selected you will now be prompted to login as administrator. There is no default password. We recommend you add a password to this account before deploying the system.

### ***Register your workstation***

Click Configure/Register Workstation. Create a new workstation name for the computer that you are presently running and setting up SuiteFactory. You will have to perform this step for each computer or terminal session that will be running SuiteDNC.

### ***Install License and Activation Key***

You should have received a license file either by e-mail or on a separate floppy disk. Install it by clicking on File/Install License File. Depending upon the type of license you received, you either will have been supplied with an Activation Key file or when you install the license you will be prompted to send some information to CCI in order to get an Activation Key. If you have the activation key file, click File/Enter Activation Key. Without the activation key you generally have 30 days of full operation before SuiteFactory goes into Demo Mode.

If you move your database to another hard drive then you have to request a new activation key. You generally have a 7-14 day grace period before SuiteFactory goes into Demo Mode.

### ***Default Database***

For installations on a Windows network with several Windows users. This feature sets what database folder a new user defaults to when first running SuiteFactory.

## General System Configuration

**Note! General System Configuration requires exclusive access to the database when saving information. Therefore, all instances of SuiteFactory must be shut down except for the one where setup is being performed.**

To get there: On main tool bar click Configure/General System Configuration. Read message then click OK. Select and set the following tabbed items:

- General
  - General
    - Database size warning setting
    - \*\* Enable Approval and Signoff setting
    - \*\* Enable Activity Logging (DNC file history)
  - Autoview™ is for documents only – skip.
  - History Reasons \*\*
    - Edit Reasons Picklist – this allows you to create your own list of reasons that certain actions were taken. For example, why was a DNC file edited or deleted?
    - Select Operations on DNC Files that require supplying a reason.
  - Machine Events \*\* Configure Machine Events
    - Data Items
    - Session Lists

- State Lists
- DNC Files
  - General
    - DNC File Version Rules – Require a single version or allow multiple versions. If you select single version then go to the Import tab and then the Maintenance Engine Import tab to setup the action to take when files names match.
    - DNC File Naming to Uppercase or not.
    - Select whether of not to use Automatic DNC File Name Generation and if so select the width of the name. If you chose to allow multiple DNC file versions then configure what happens when a user enters and DNC file name by clicking on the ‘New’ button:  
Create the next version of the selected file; Generate a brand new file name; or Ask the user to choose whether to create the Next Version or a Brand New Name.
    - Select whether or not to limit User rights granted by User Groups that have access to Resource Collections that contain the selected DNC file. – if you select this it means that if a User belongs to more than one User Group the User’s DNC file rights are no longer simply the combination of rights of all those groups but are limited to only those DNC file rights granted to the User Group assigned to the Resource Collection(s) to which the selected DNC file is assigned.
  - Communications Engine
    - Select whether or not to shut down the Communications Engine when shutting down the runtime program.
    - Check File Transfer Queue Interval setting (do not change).
    - Check Communications Status Interval setting (do not change)
    - Select whether or not to allow editing parameters of a machine that has items on the file transfer queue.
    - Select Serial Port Control Type – CommStudio (newest) or SaxComm8.
  - \*\* Search Columns
    - Define DNC file filter criteria (if never done before)
    - Edit if you have already defined some DNC file filter criteria
    - Edit Pick Lists if any
  - Import
    - Maintenance Engine Import settings
      - Select how often to check for DNC files to import.
      - If you required Single versions of DNC filenames on the DNC Files/General tab, then select the action to be taken when the file you are importing matches an existing DNC file name. Do you want it to replace the contents and increment the version number or keep the current version?
    - Manual Import settings
      - Select whether or not to have an automatically generated DNC file name when a file is manually imported. (If Automatic DNC File Name Generation was selected on the DNC Files/General tab)

- When importing manually, select whether you want to allow setting this separately for every Resource Collection, or always accept the default name automatically, or always display a dialog box where you can edit the name before importing.
    - Select whether a manually imported file should be deleted, moved or left in its original location.
- **\*\* Reports (Automatic DNC file list reports)**
  - **General (*Note: setup File and Fields formats before selecting Enable*)**
    - Enable Automated DNC File List Report Generation
    - Select how often to generate an automatic report.
  - **File Format**
    - Select the type of data you want for the report, text, CSV, XLS etc.
    - Name/Create a file for the report.
  - **Field Format** – depends on what file format you choose for the report.
- **Print Header**
  - Choose/Create custom print header and whether or not to print it on every page.
  - **\*\* Select Search Criteria data to include and whether or not to print them on every page.**
- **Remote Requests**
  - **General**
    - **\*\* Choose whether or not to limit Remote Request transfers from the database to Approved DNC files only**
    - Choose how to handle remote requests for the latest version when you allow multiple versions of DNC files. Select between warning the operator when the latest version of the requested file is not assigned to the machine or simply send the latest version that is assigned to the machine even if it is not the latest version of the DNC file. If the first choice was selected and a warning is received, the operator must resend the remote request and include the specific version required. (See the Remote Request Technotes on how to do this)
  - **E-Mail** – Choose to enable CNC-E-Mail where the operator can use a remote request file to send an e-mail to configured users. There is help on this tab about configuring CNC E-Mail. Note especially the paragraphs about configuring your anti-virus software to allow the CNC email feature to work. For example, with McAfee, start the McAfee console, select Access Protection/Port Blocking. Double click on “Prevent mass mailing worms from sending mail” and add DCOMH701.EXE to the excluded processes.
  - **Default Enabling**
    - Select/de-select which remote request commands will be available.
    - Choose whether or not an operator ID must be supplied with remote requests.
- **Queues and Archive**

- Choose whether or not to allow deleting and purging of archived DNC files from the archive database.
- Select the action to perform on a DNC file after it is successfully sent to a machine tool.
  - The action to take (mark as not available or delete) is defined in each Resource Collection.
  - Mark the DNC file as Not Available for sending (all RC's).
  - Automatically delete the DNC file (all RC's).

## **Workstations**

Shows the configuration of all defined workstations and machines assigned to them. If you have a list of all the workstations that will be running SuiteFactory you can enter them all here now by clicking Configuration/Workstations and clicking New to enter their names. Click on Properties to change the 3<sup>rd</sup> party tool default path for this workstation if necessary. This is where temporary files are stored during 3<sup>rd</sup> party operations. You can unregister a workstation here. To register a workstation you must be running on the computer to which the workstation name is to be registered. You can also delete a workstation from the list.

# Machines

## ***Creating and Setting the Machine Properties***

Click Configure/Machines. Click New to enter a new machine name. Click Properties to set up that machine's parameters. **Note that if you have several machines whose communication parameters are the same or similar then after setting up one them you can highlight it and click on Copy. You will only have to enter its unique name, assign an RS-232 port to it and assign it to a Resource Collection.**

Select and set the following tabbed items:

- General
  - Machine Tool Name
  - Computer where attached – this is the Windows computer name
  - Serial Port
  - Connection Status – use this to temporarily disable a port.
  - Allow Send – enables sending DNC files to the CNC
  - Allow Receive – enables receiving DNC files from the CNC
  - User Must Start – for older CNC's without handshaking, allows you to queue up DNC files to be sent but not sent until the operator clicks on the START button on the DNC Monitor screen.
  - Start Monitoring Automatically – selecting the Monitor screen will show the state of the send/receive queue without having to enable it on the Monitor screens View menu.
  - User Can Assign Files Queued to Receive – this is used when you are receiving many files that are to be assigned to different Resource Collections. For example, if you setup a paper tape reader to read in your tape library for many machines.
- Protocol
  - Send and Receive Protocols such as RS-232, BTR, Mazak, FTP, UNC ...
  - Send and Receive Data Type – ASCII, EIA or Binary
    - Send
      - Send Buffer Size (default is 16384) – don't change unless instructed to
      - Send Timeout – the amount of time to wait in an Xoff state before de-queuing the DNC file.
      - End of Transmission Delay Interval – the amount of time to wait after 100% of the data has been transmitted to the buffer before de-queuing the file. This is useful when using RS-232 devices whose drivers do not report the correct number of characters left in the output buffer that could cause premature de-queuing and loss of data at the end of the file.
      - Various settings for control characters (Pon to Start and Poff at end).
      - Change default mode from memory mode to tape mode when manually queuing up a file for sending. (Tape mode ignores the send timeout). Handshaking must be selected on the Communication tab for this choice to be available.
      - Leader and Trailer if required.

- Receive
  - Receive Timeout – the amount of time to wait after receiving a file to determine that the data is complete.
  - Send Xon to Start.
  - Send Xoff at End.
  - Select whether or not to enable the receive function to send XON's to prompt for more data before timing out and saving the file data.
- BTR/MIU
  - If you have a CCI Fault Tolerant BTR interface that would have been selected under the protocol tab. If the BTR is a “newer motherboard variety” in a flat aluminum box or with no box at all then this function will be enabled. Select the emulated tape reader's speed and whether to communicate with the serial port of the BTR at 19200 baud (board with EPROM B12) or 4800 baud (all other EPROM's)
- Remote Request Parameters
  - Style – If you are setting up your CNC to be able to request DNC programs to be sent from or saved to the SuiteDNC database from the CNC console then click Enable REMOTE REQUEST Command Language and setup the rest of the choices.
    - Select Remote Request Command Style – Old style XYZ or Customized Commands.
    - Select queuing style – *Standard* where the remote request command listening file is available only if the queue is empty. or *Dynamic* where the remote request command listening file is put at the top of the queue each time a queued item is sent or received so that any received commands can be processed. This feature allows queuing up several jobs for sending, for example. The operator outputs a STARTNEXT command to get the next job on the queue or can send a different command.
  - Analysis – This is available only for XYZ style commands.
    - Select whether or not to strip white space from the DNC file name in the remote command file.
    - Select whether or not to strip comments from the command file before evaluation the command string. If so, define what the comment delimiter will be.
  - Customized commands – This is available only if you selected the Customized Commands option on the Style tab. Click on “Configure Customized Remote Requests” in order to customize the extensive default set of Remote Request commands.
    - Commands
      - Select the individual Remote Commands to be allowed.
      - Edit individual command labels.
    - Delimiters - Select the characters and alternates, if required, to use for Start and End of a command, the character to separate arguments, if any, and the character to be used for disabling a command when there are several commands sent in a single Remote Request file..

Defaults are parentheses to enclose the command, comma between arguments.

- List Parameters – These parameters are for setting up how list data is displayed on a CNC screen. This refers to the list of files and instructions that are sent via the Remote Command Response file to the CNC, in answer to the command, LIST).
  - Format - choose the number of files names to be sent in any one command and the number of character/line; the date format; whether or not to include N numbers; whether or not to repeat the column header and if so, how often; and what character to use to select what DNC file(s) to be queued, if any, from the list received.
  - Filter – Select wild card, escape and disable command characters to be used for filtering the lists. There is on screen help available for these settings.
- CNC Email Parameters – Various settings as to who sends and who receives CNC Email at this machine.
- Machine Events – Define the CNC-specific details for the arguments and text to be included in the Machine Event Remote Command, EVT. (EVT data item/value label/value data/extra data)
  - Machine Event Argument Separator – default is /
  - Select whether or not the CNC's print macro requires representing a space with a substitute character and what that character is (in a FANUC DPRNT macro statement an \* represents a space character).
  - Character to substitute if any arguments contain characters not allowed in a particular CNC's print macro. (for future use).
  - Select whether to save machine event data to the SuiteFactory database.
  - Selected whether to post machine events for pickup by a 3<sup>rd</sup> part program and if so, configure the target path to which this data is to be posted.
- Responses – Define the beginning and ending for DNC programs sent to this model CNC. This is for the file that gets sent to the CNC in the course of the Remote Request command procedure.  
For example, FANUC DNC files start with:  
%  
O2222 (this is a example - it can be any number you choose)  
and end with:  
%
  - Select whether or not to transmit response without trailing New Line. **This only has meaning with the XYZ style commands.**
  - Select whether or not to transmit word descriptions along with the N-number response codes. **This only has meaning with the customized style commands.**

- Name Rules – These are individual machine settings to establish the DNC file naming conventions to be used when saving a program on a CNC via Remote Command.
  - Default File Type for New DNC Files – This is the underlying Windows style .ext to be used if later want to open this file using a Window native application. If this field is left blank the type will default to “nc”.
  - Machine Label to Add to Name of Saved DNC Files – This is a prefix or suffix to be automatically added by SuiteFactory whether or not it is included in the SAVE command. For example, if the suffix –M1 is configured then the command (SAVE A1234) or command (SAVE A1234-M1) will result in the file being saved as the next version of A1234-M1.
  - Machine Label Position in the New DNC File Name – Select whether the Machine Label, specified above, is a prefix or suffix.
  - How to Generate New DNC File Name and File Type – Given the above specifications of file type, machine label prefix or suffix select one of the following rules:
    - Automatic Assign the Default File Type and the command-specified Name – This means that the machine label will be added to the file name specified in the SAVE command exactly as it is, and the file type will be the type specified in the parameter above. For example, if you specified the default file type as “dnc” and the machine label as “–m101” as a suffix , the command (SAVE A1234) will generate the DNC filename A1234-m101 and the type will be dnc as shown in the type column of the file list display grid. The command (SAVE A1234.L3) will be saved as A1234.L3-m101 and the type will be dnc.
    - Extract and Save: Use the part of the file name that follows the last “.” character as the file type. With this choice the command (SAVE A1234) will be saved as A1234-m101 and type dnc, but (SAVE A1234.L3) will be save as A1234-m101.L3 and type is L3.
    - Truncate and Save: Delete the part of the name that follows the last “.” character and use it as the file type. With this choice the command (SAVE A1234) will be saved as A1234-m101 and type dnc, but (SAVE A1234.L3) will be saved as A1234-m101 and file type L3.
- Networked – if you choose one of the networked protocols the Networked tab appears:
  - Networked UNC
    - Set up the shared send and receive folders for machines that communicate via Windows Ethernet instead of RS-232.
    - If in the General System Configuration, single DNC file version is selected, choose whether or not queuing to send adds a version ID to

the DNC file name. If multiple versions are allowed then SuiteFactory, in order to guarantee unique file names, automatically add a version ID to the file name.

- Networked FTP – For sending to an FTP server only
  - FTP Connection – select an existing FTP server connection
  - FTP Folders – select the path where DNC files will be sent
- Communication – for RS-232 connections (including RS-232 received via a BTR)
  - Send and Receive baud rates, data widths, parity, stop bits, and handshaking
- Conversions
  - End of Block characters – select what the EOB character(s) must be for the machine. None means to accept what happens to be in the operating system file. A Windows file normally has Carriage Return-Line Feed.
  - Comments
    - Setting whether or not to strip sent or received comments. Define what delimits a comment. Usually it is “(“ and “)” but not always.
  - Trim Header and Trailer
    - Strip Internal Header From DNC File Before Sending – Define what character string delimits the header. Select whether or not to include the header delimiter when sending the file. For example, if you configured the “%” to be the delimiter, you probably want to send it to the CNC.
    - Get Header From Previous Version After Receiving. This feature allows you to keep a running commentary about changes to a file, even with CNC’s that don’t make it easy to deal with comments. The operator gets a “clean” file with no leading comments. After running the program he or she adds comments as a header and sends the program back to SuiteFactory. SuiteFactory then automatically gets the header information from the last version of the files and adds it to the top of the program. If adding the new header information is impossible on a particular CNC then the programmer adds new comments in with the SuiteFactory editor after it is received back from the factory floor as a new version. Also choose whether or not you need the system to add the delimiter string after the header that was retrieved from the previous version.
    - Strip Internal Trailer From DNC File Before Sending – Define what character string delimits the trailer. Select whether or not to include the trailer delimiter when sending the file.
    - Copy Send File Locally Before Running. Selecting stripping header or trailer automatically forces local file copy.
  - \*\*Insert Event RRC – Enable Automatic Insert of RUN Event DPRNT Macros in G-Code Programs. This screen allows you to configure the exact syntax and location of DPRNT or equivalent macro statements for the purpose of automatically recording when a part program was started and when it was completed. This information is stored in SuiteFactory’s option Machine Event database. This is used with the Transform feature found on the Manage DNC Files screen of SuiteFactory Runtime.

## Resource Collections

Resource collections are virtual containers used to group machines that are alike; assign those part program DNC files created for those machines and to give permission to users to access those files and machines. Click on Configure/Resource Collections. To setup Resource Collections click Configure/Resource Collections. Click New to create a new Resource Collection. Click on the + sign to assign machines for sending and receiving. Resource Collections can be configured in many ways. For example, you can create a Resource Collection that will contain only files that require testing and another for proven files uploaded from a CNC.

- Import Name Rules – Similar the naming rules as defined for saving a file using the Remote Command, SAVE, this is to configure how a file will be named when automatically imported into a Resource Collection as a Master File, using the Maintenance Engine; manually imported using by drag and drop, copy and paste; or the Import button in the Manage DNC Files screen of SuiteFactory Runtime.
  - Import ID – in order to make the DNC file names unique, define what the import ID should be for this Resource Collection. Each Resource Collection has it’s own ID. You cannot specify the same ID for more than one Resource Collection. Select whether the ID is a prefix or suffix.
  - Default File Type - for new DNC Files imported into the database and assigned to a particular Resource Collection, this is the underlying Windows style .ext to be used if later want to open this file using a Window native application. If this field is left blank the type will default to “nc”.
    - How to Convert Import Source File Name to New DNC File Name and File Type – Given the above specifications of file type, machine label prefix or suffix select one of the following rules:
      - Automatic Assign the Default File Type and the command-specified Name – This means that the machine label will be added to the file name specified in the SAVE command exactly as it is, and the file type will be the type specified in the parameter above. For example, if you specified the default file type as “dnc” and the machine label as “-m101” as a suffix , the command (SAVE A1234) will generate the DNC filename A1234-m101 and the type will be dnc as shown in the type column of the file list display grid. The command (SAVE A1234.L3) will be saved as A1234.L3-m101 and the type will be dnc.
      - Extract and Save: Use the part of the file name that follows the last “.” character as the file type. With this choice the command (SAVE A1234) will be saved as A1234-m101 and type dnc, but (SAVE A1234.L3) will be save as A1234-m101.L3 and type is L3.
      - Truncate and Save: Delete the part of the name that follows the last “.” character and use it as the file type. With this choice the command (SAVE A1234) will be saved as A1234-m101 and type dnc, but (SAVE A1234.L3) will be saved as A1234-m101 and file type L3.
- Import Behavior

- Select what action to take after a file is imported: whether to delete it or move it the sub-folder of the autoimport folder.
- Select how you want to normalize the end-of-line blocks: Leave them as they are, make them CR-LF and leave in all blank lines, or make them CR-LF and remove all blank lines.
- How to Import Manually – Select whether to accept the default name automatically or to display a user dialog to that you can edit the file name. These setting might not be available because there is a system wide parameter in the DNC File/Import/Manual Import tab that controls whether or not to allow you to set this at individual Resource Collections or to force manually importing the same way for all Resource Collections. I.e, accept the default name or display a user dialog box to edit the name.
- Import Path
  - If using the autoimport feature of the Maintenance Engine, select the path to the autoimport folder for this Resource Collection. Each Resource Collection containing files to be queued to send to a CNC must have a unique autoimport folder.
- Queues – If in the General System Configuration DNC Files/Queues and Archive tab, you chose to have the “Action to Perform on a DNC file after it is successfully downloaded to a CNC” to be set for each Resource Collection, individually, this is where it is configured. Choose to leave it in the database unchanged, mark it “Unavailable” for downloading or delete it from the database. (It will be saved in the Archive.)

## User Groups

User groups are where the various rights to the features of SuiteFactory are configured. Decide how many classes of users you will need. The user group called “Trusted Users” is the administrators group and cannot be deleted. Users assigned to this group have all rights to use all the functions of SuiteFactory. The user group called “Everyone” (as its name suggests) contains all the users defined for SuiteFactory. You can use this group to assign those rights you want everyone to have all the time. You might want to create an Operator group with minimal rights for Sending and Receiving DNC files and a Programmer’s group who have rights to do most everything to DNC files, but have no database configuration rights. Perhaps a Supervisor’s group that has rights in-between the operator and programmer.

**Note! A user can be assigned to more than one User Group. The rights which that user has are the sum of the rights assigned to each user group.**

To setup user groups click Configure/User Groups. Click New to create a new group. Click a + sign and highlight rights to assign the Rights, Resource Collections and later to assign the individual Users.

## Users

Click Configure/Users to create and assign Users to User Groups. **Note! You can assign a User to more than one User Group. The Rights will be the sum of the Rights of all the User Groups to which that User is assigned.**

## **\*\*3<sup>rd</sup> Party Tools**

Third Party Tools are applications that you want to run from within SuiteFactory interactively with the SuiteFactory Database. For example, if you have a favorite text editor you would rather use than SuiteFactory's NC Editor, you can set it up as a 3<sup>rd</sup> Party Tool. Another example, if you have save Mazatrol programs that you would like to be able to view, print out or edit you can setup a 3<sup>rd</sup> Party Application, such as, Solutionware's Mazacam software to do this.

## Manage Language

For configuring SuiteFactory for use with languages other than English in other language locales. CCI has translations to Chinese, Japanese and Spanish.

## Setup Printing

On the mail toolbar, click File/Print Setup. Decide whether you want to use SuiteFactory's native printing or use a Windows native application for printing such as Word Pad if you want to format the data differently than SuiteFactory allows.

Setup the font and size.