Software Manual

MatchPoint® BLADE™ Reports

MiTek Machinery Division
301 Fountain Lakes Industrial Drive
St. Charles, MO 63301
Phone:800-523-3380
Fax: 636-328-9218
www.mitek-us.com

Revision Date	
Revised By	
Approved By	M. Kanjee
Print Date	21 September 2017
Date Created	6 September 2017
Created By	G. Gaia

Overview

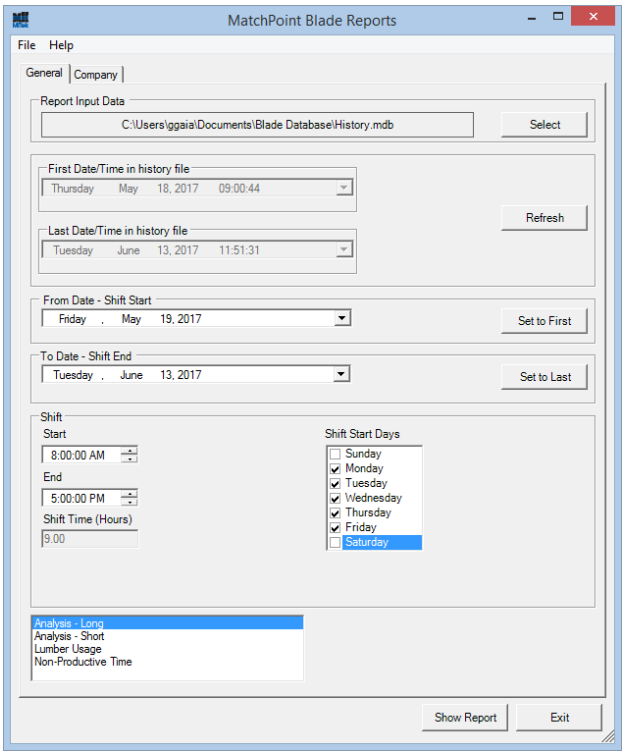
As the *MatchPoint® BLADE™* wood processing system operates, it stores production data locally in a database file. Managers may use *MatchPoint® BLADE™* Reports software to review and evaluate production data from the database file.

Note: the PC that you use to run the *BLADE* Reports software must have access to the *BLADE* saw PC through your network.

Main Menu

Using the General Tab

The General tab in *MatchPoint® BLADE™* Reports software allows managers to select the database file containing the production data from the saw and to set parameters for it.



To open the file containing production data, either click *File* > *Open* or click *Select* under the Report Input Data section.

Navigate to the saw PC. Then click *C:* > *Program Files (x86)* > *Mitek* > *Blade* > *Config*, and select either History or MachineryDB (only one is available).

Review the dates displayed in the First Date/Time and Last Date/Time to make sure that you have current data. Use the Refresh button to check for recent updates. These dropdowns are not selectable.

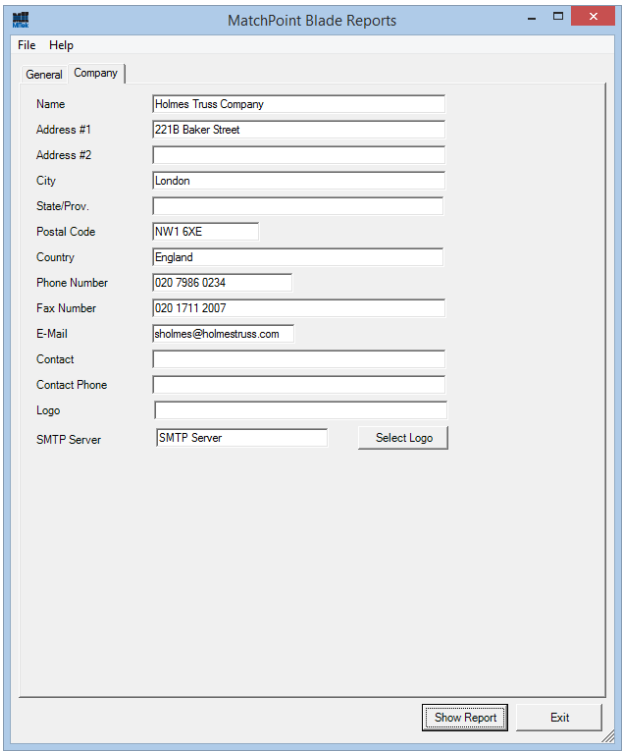
Select the dates and times from which you want to review data. Use the From Date – Shift Start dropdown to set the beginning of your date range. Use the To Date – Shift End dropdown to set the end of the date range.

In the Shift section, adjust the Start and End times to include only specific times of day in the data.

In the Shift section, double-click the boxes under Shift Start Days to include or exclude them from the data.

Using the Company Tab

If you want company information to appear in the header of the report, complete the fields in the Company tab. These are not required to generate a report.



Selecting a Report Type

After setting parameters for the data and inputting company data, return to the General tab and select the specific report type that you want to generate. Then click *Show Report*. Descriptions of the four report types appear below, starting on page 6.

Terminology

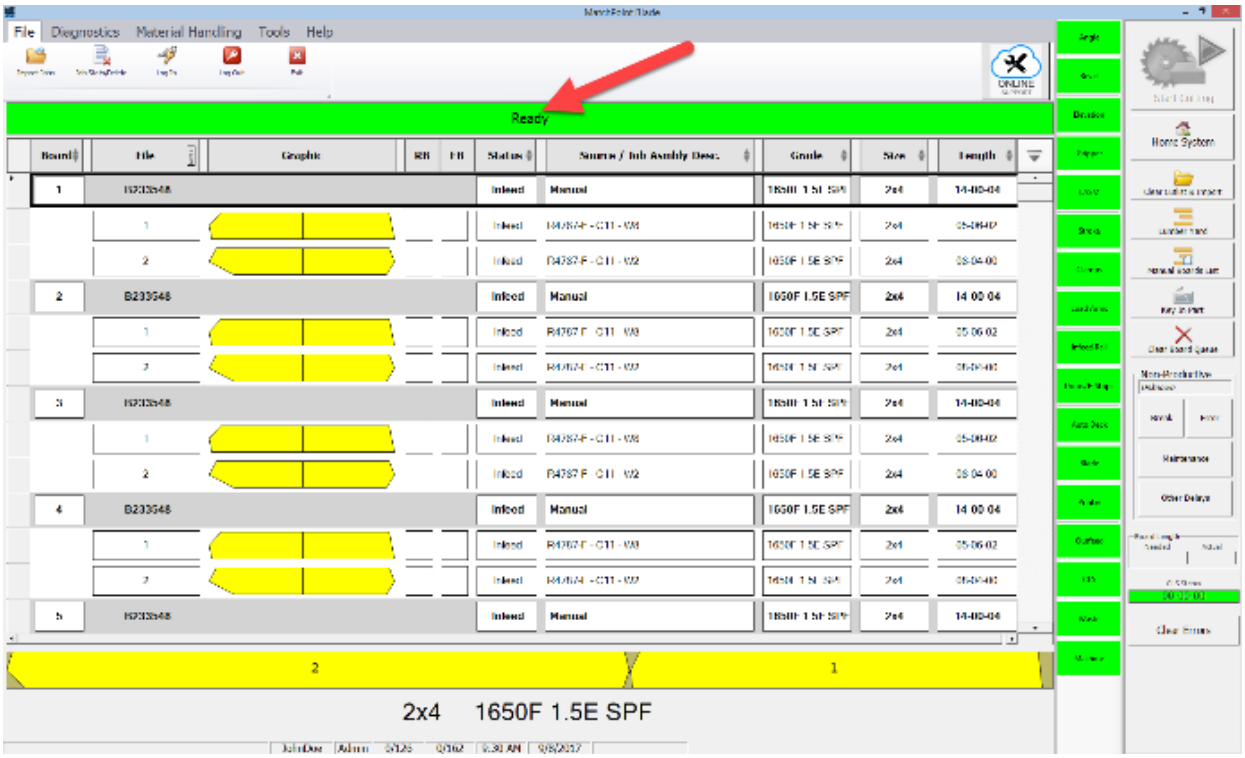
Three of the four reports categorize time as either Productive Time or Non-Productive Time. The *BLADE* saw generates this data; the *BLADE* Reports software simply accesses and reviews the data that the saw collects.

Productive Time

The sawyer does not take action to classify Productive Time. The saw automatically classifies any of the following states as Productive Time.

- Active Cutting (occurs when the saw is processing wood)
- Pausing (occurs when the saw is finishing processing shortly before reaching Paused state)
- Stopping at Board End (occurs when the saw is still processing wood before reaching Ready state)
- Clearing Saw (occurs when the saw is removing any remaining wood before returning to Active Cutting)
- Single Board (occurs when sawyer selects *Cut* from a board's dropdown menu)
- Blade Velocity Recover (occurs when the software is waiting for the blade to regain cutting speed)

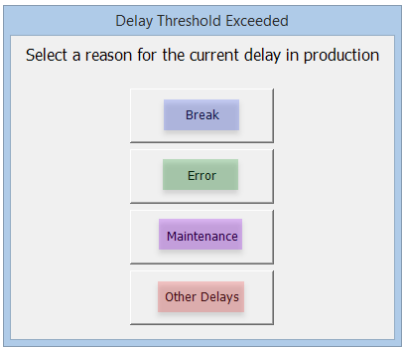
The saw displays these states—in addition to other information—in the status bar.



Non-Productive Time

When the saw has been inactive for a set period of time, a Delay Threshold Exceeded window appears on the *BLADE* operator interface, prompting the sawyer to select one of four types of inactivity: *Break*, *Error*, *Maintenance*, or *Other Delays*.

These types of inactivity are all classified as Non-Productive Time. They appear on several reports.



	Time (hrs.)	Percent (%)
Productive Time	65.11	44.0%
Unreported Non-Productive Time	34.49	23.3%
Other Non-Productive Time	33.66	22.8%
Maintenance Time	0.00	0.0%
Error Time	10.54	7.1%
Break Time	4.07	2.8%
Shift Time	147.87	

There are two instances, however, when the sawyer does not have the opportunity to select a reason from the Delay Threshold Exceeded window. In both instances, the saw classifies the time involved as Unreported Non-Productive Time (shown along with the four types of Non-Productive Time above).

- If a sawyer is, for example, waiting for wood for only four minutes, the window does not appear. By default, the Delay Threshold Exceeded window only appears after five minutes of inactivity. The saw automatically classifies that four minutes as Unreported Non-Productive Time.

  To reduce the amount of time that the Delay Threshold Exceeded window takes to appear, access the *BLADE* operator interface. Then go to *Tools* > *Options* > *Production* > *Allowable Idle Time*. Reducing the amount of time that the window takes to appear reduces Unreported Non-Productive Time.

- If the saw or its software is turned off during normal operating hours, the saw classifies that down time as Unreported Non-Productive Time.

Reports

Previewing the Report

The report generates a preview window with a ribbon on the top allowing you to save, print, adjust, navigate, and export the report.

Analysis – Short Report

Provides a breakdown of times and quantities cut.

Displays the total amount of shift time classified by category. (See page 5 for detailed information.)

Displays the average parts per hour and the average time cutting a part. (Productive Time is the amount of time the saw was cutting. Work Time is the total shift time.)

Displays the amount of boards cut and the amount of boards that sawyers loaded manually.

Displays cuts classified by the type of cut.

Displays total part count and total board feet classified by active jobs, remainders, and scrap.

Analysis – Long Report

Provides the same data as the Analysis – Short report but includes additional data (described below).

Cut Type	Saw Strokes	Saw Strokes
Cross Cuts	47,991	97.4%
End Bevel Cuts	0	0.0%
Rip Bevel Cuts	6	0.0%
Scarf Cuts	1,250	2.5%
Total	49,247	100.0%

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/6/2017 2:58:08 PM Page 1 of 2

Holmes Truss Company
2218 Baker Street
London, NW1 6XE

MatchPoint Blade Analysis

Phone: 020 7986 0234
Fax: 020 1711 2007
Email: sholmes@holmestruss.com

Saw: Blade
Now: 9/6/2017 2:58:08 PM
Name: ggaia

Start: Fri, May 19 '17
Finish: Tue, Jun 13 '17
Shifts: 16
Shift Start: 8:00:00 AM
Work Hrs / Shift: 9

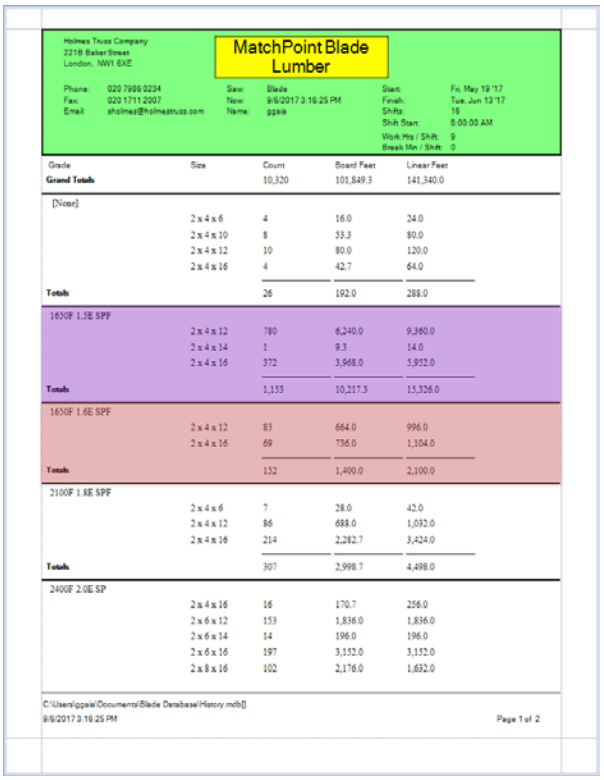
Part Type	Length 0' - 3' Qty	0' - 3' Time (sec)	3' - 6' Qty	3' - 6' Time (sec)	6' - 9' Qty	6' - 9' Time (sec)	9' - Qty	9' - Time (sec)
Rip Bevel	0	0.0	1	18.0	0	0.0	5	52.8
2 Angle	4,561	8.9	1,938	7.6	1,749	7.5	3,819	9.8
3 Angle	1,052	10.4	1,618	9.9	557	12.7	1,710	13.7
4 Angle	471	12.6	1,190	11.8	1,852	12.4	577	15.1
5+ Angle	0	0.0	2	15.5	8	16.5	18	20.4

Displays total saw strokes classified into cross, end bevel, rip bevel, and scarf cuts.

Displays part types sorted by number of cuts and classified by cut part length and time.

Lumber Usage Report

Provides data about board count, board feet, and linear feet classified by lumber grade.



Holmes Truss Company
2218 Baker Street
London, NW1 6XE

MatchPoint Blade Lumber

Phone: 020 7986 0234
Fax: 020 1711 2007
Email: sholmes@holmestruss.com

Saw: Blade
Now: 9/6/2017 3:16:25 PM
Name: ggaia

Start: Fri, May 19 '17
Finish: Tue, Jun 13 '17
Shifts: 16
Shift Start: 8:00:00 AM
Work Hrs / Shift: 9
Break Min / Shift: 0

Grade	Size	Count	Board Feet	Linear Feet
Grand Totals		10,320	101,849.3	141,340.0
[None]				
	2 x 4 x 6	4	16.0	24.0
	2 x 4 x 10	8	53.3	80.0
	2 x 4 x 12	10	80.0	120.0
	2 x 4 x 16	4	42.7	64.0
Totals		26	192.0	288.0
1650F 1.5E SPF				
	2 x 4 x 12	780	6,240.0	9,360.0
	2 x 4 x 14	1	9.3	14.0
	2 x 4 x 16	372	3,968.0	5,952.0
Totals		1,153	10,217.3	15,326.0
1650F 1.6E SPF				
	2 x 4 x 12	83	664.0	996.0
	2 x 4 x 16	69	736.0	1,104.0
Totals		152	1,400.0	2,100.0
2100F 1.8E SPF				
	2 x 4 x 6	7	28.0	42.0
	2 x 4 x 12	86	688.0	1,032.0
	2 x 4 x 16	214	2,282.7	3,424.0
Totals		307	2,998.7	4,498.0
2400F 2.0E SP				
	2 x 4 x 16	16	170.7	256.0
	2 x 6 x 12	153	1,836.0	1,836.0
	2 x 6 x 14	14	196.0	196.0
	2 x 6 x 16	197	3,152.0	3,152.0
	2 x 8 x 16	102	2,176.0	1,632.0

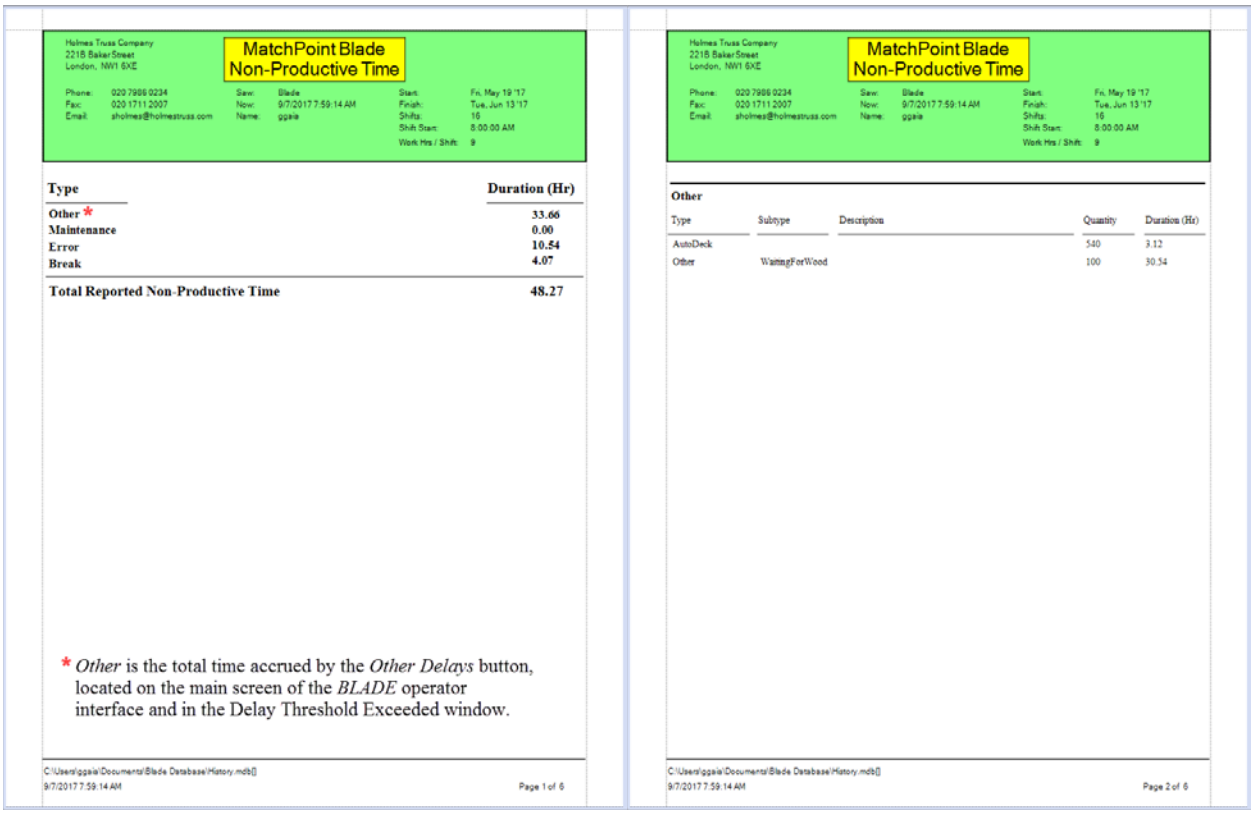
C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/6/2017 3:16:25 PM Page 1 of 2

Sample data for three dimensions of 1650F 1.5E spruce pine fir boards.

Sample data for two dimensions of 1650F 1.6E spruce pine fir boards.

Non-Productive Time Report

Provides data on both types of Non-Productive Time due to maintenance, errors, breaks, and other stoppages. The first page is an overview, while the following pages provide more detailed data. See the note on page 5 for more information on types of Non-Productive Time.



Holmes Truss Company
2218 Baker Street
London, NW1 6XE

MatchPoint Blade
Non-Productive Time

Phone: 020 7986 0234
Fax: 020 1711 2007
Email: sholmes@holmestruss.com

Saw: Blade
Now: 9/7/2017 7:59:14 AM
Name: ggaia

Start: Fri, May 19 '17
Finish: Tue, Jun 13 '17
Shifts: 16
Shift Start: 8:00:00 AM
Work Hrs / Shift: 9

Type	Duration (Hr)
Other *	33.66
Maintenance	0.00
Error	10.54
Break	4.07
Total Reported Non-Productive Time	**48.27**

* *Other* is the total time accrued by the *Other Delays* button, located on the main screen of the *BLADE* operator interface and in the Delay Threshold Exceeded window.

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/7/2017 7:59:14 AM Page 1 of 6

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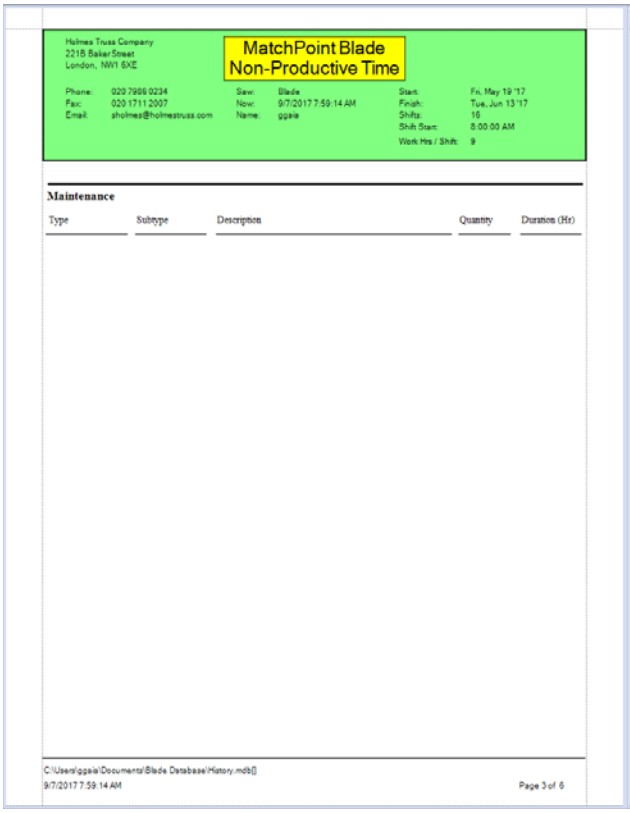
Other

Type	Subtype	Description	Quantity	Duration (Hr)
AutoDeck			540	3.12
Other	WaitingForWood		100	30.54

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/7/2017 7:59:14 AM Page 2 of 6



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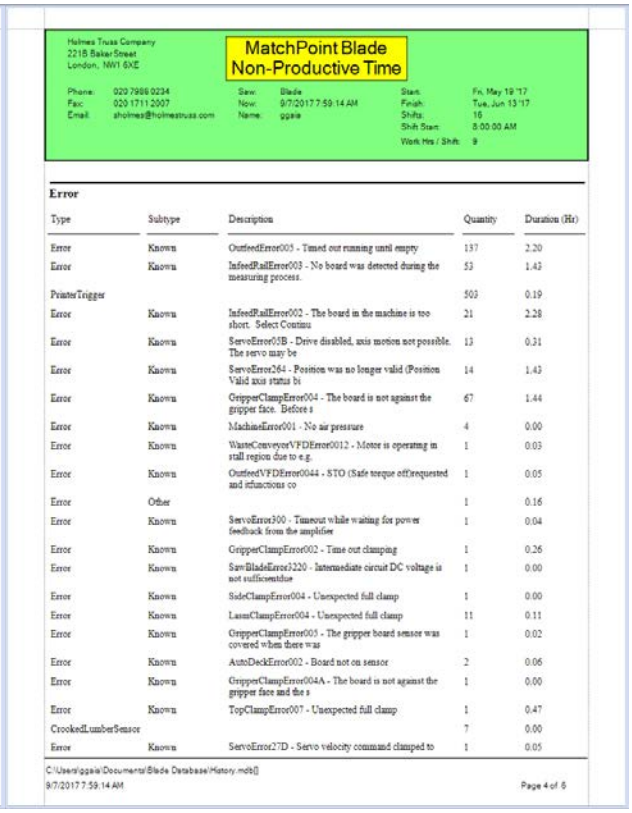
Maintenance

Type	Subtype	Description	Quantity	Duration (Hr)

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/7/2017 7:59:14 AM Page 3 of 6



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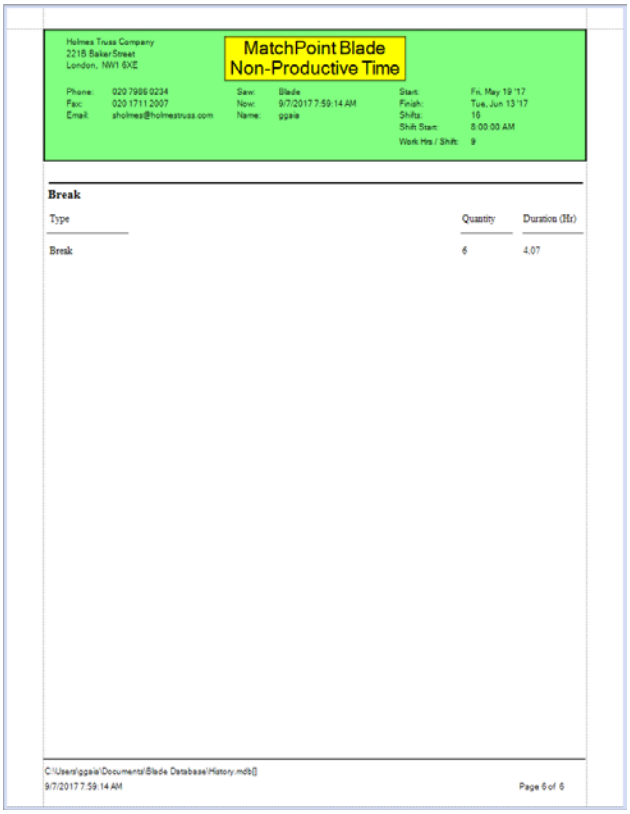
Error

Type	Subtype	Description	Quantity	Duration (Hr)
Error	Known	OutfeedError005 - Timed out running until empty	137	2.20
Error	Known	InfeedRailError003 - No board was detected during the measuring process.	53	1.43
PrinterTrigger			503	0.19
Error	Known	InfeedRailError002 - The board in the machine is too short. Select Continu	21	2.28
Error	Known	ServoError05B - Drive disabled, axis motion not possible. The servo may be	13	0.21
Error	Known	ServoError264 - Position was no longer valid (Position Valid axis status bi	14	1.43
Error	Known	GripperClampError004 - The board is not against the gripper face. Before s	67	1.44
Error	Known	MachineError001 - No air pressure	4	0.00
Error	Known	WasteConveyorVFDError0012 - Motor is operating in stall region due to e.g.	1	0.03
Error	Known	OutfeedVFDError0044 - STO (Safe torque off)requested and infunctions co	1	0.05
Error	Other		1	0.16
Error	Known	ServoError300 - Timeout while waiting for power feedback from the amplifier	1	0.04
Error	Known	GripperClampError002 - Time out clamping	1	0.26
Error	Known	SawBladeError3220 - Intermediate circuit DC voltage is not sufficientdue	1	0.00
Error	Known	SideClampError004 - Unexpected full clamp	1	0.00
Error	Known	LaserClampError004 - Unexpected full clamp	11	0.11
Error	Known	GripperClampError005 - The gripper board sensor was covered when there was	1	0.02
Error	Known	AutoDeckError002 - Board not on sensor	2	0.06
Error	Known	GripperClampError004A - The board is not against the gripper face and the s	1	0.00
Error	Known	TopClampError007 - Unexpected full clamp	1	0.47
CrookedLumberSensor			7	0.00
Error	Known	ServoError27D - Servo velocity command clamped to	1	0.05

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/7/2017 7:59:14 AM Page 4 of 6



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Break

Type	Quantity	Duration (Hr)
Break	6	4.07

C:\Users\ggaia\Documents\Blade Database\History.mdb[]
9/7/2017 7:59:14 AM Page 6 of 6