## **Software Manual**

# MatchPoint<sup>®</sup> BLADE<sup>™</sup> 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*<sup>®</sup> *BLADE*<sup>TM</sup> wood processing system operates, it stores production data locally in a database file. Managers may use *MatchPoint*<sup>®</sup> *BLADE*<sup>TM</sup> 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<sup>®</sup> BLADE<sup>TM</sup>* Reports software allows managers to select the database file containing the production data from the saw and to set parameters for it.

			MatchPoi	nt Blade Reports			>
e Help							
General Compa	nv						
Report Input [	)						
Report input t			- Diala	Detekse all Colores and		Colori	1
	C:\Us	ers\ggala\Do	cuments\Blade	Database(History.mdb		Select	
First Date/T	ime in hi	story file					
Thursday	May	18, 2017	09:00:44	~			
						Refresh	1
Last Date/Ti	me in his	story file					_
Tuesday	June	13, 2017	11:51:31	<b>~</b>			
From Date -	Shift Star	t					-
Friday .	May	19, 2017		•		Set to First	
- To Date - Shit	End -						
Tuesday	June	13 2017		<b>•</b>		Sat to Last	1
						00110 2001	_
Shift							
Start				Shift Start Days	_		
8:00:00 AM	÷			Sunday			
End				✓ Monday ✓ Tuesday			
5:00:00 PM	÷			✓ Wednesday			
Shift Time (H	ours)			✓ Friday			
19:00				Saturday			
Analysis - Long							
Analysis - Short							
Lumber Usage Non-Productive	Time						
						1	-
					Show Report	Exit	

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.

MI	MatchPoint Blade Reports	- 🗆 🗙
File Help		
General Company		
Name	Holmes Truss Company	
Address #1	221B Baker Street	
Address #2		
City	London	
State/Prov.		
Postal Code	NW1 6XE	
Country	England	
Phone Number	020 7986 0234	
Fax Number	020 1711 2007	
E-Mail	sholmes@holmestruss.com	
Contact		
Contact Phone		
Logo		
SMTP Server	SMTP Server Select Logo	
		3
	Show Report	Exit

#### 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.

¥		MatchPoint Blade					- 7 - 8
File Diegnostics Material Handling Tools Help					UNLINE UNIVER	ingt ann	Stel Orling
	Read	lγ				Druden	1
Bount Hile 1	Status 🎙	Source / Jub Asobly Desc. 🕴	Goule 🍦	Size 0	tength 🕴 🐺	( Anger	Home System
1 15212548	Inlead	Manual	16501-151-504	264	14-00-04	LNV	desculars over
	Interest	1002874F - CT1 - W8	1650F 1 5F 50 F	264	05-06402	984	Lunder hard
2	Infeed	R4787-F - C 11 - W2	1050F 1.5E SINF	2x4	08-04-00	Cores.	Hernauel la son de La et
2 B233548	Infeed	Manual	1050F 1.5E SPF	204	14 00 04	Land/and	Erry in Part
	Inlocd	R4767 F C11 W8	1600F 1.5E SPF	204	05 06 02	Hered Bell	X
	Inlesd	R42074F - C11 - W2	1650° 1.5° SPT	261	05-04-00		Non-Productive
3 15212548	Inlead	Manual	1850F15F5P	264	14-00-04		Brok From
	Interest	R4787-F - C 11 - W8	1650F 1 SE SPF	2.04	05-08-02	Auto Deck	
2	Infeed	R4787 F - C 11 - W2	1050F 1.5E SPF	264	08 04 00	<b>e.</b> *	Kaintenance
4 B233548	Infeed	Manual	1650F 1.5E SPF	204	14 00 04	1 de 1	Other Delaya
	Inleed	R4787-F - C11 - W8	1650F 1.5E SPF	2x1	05-06-02	0.msc	-Rand Logik Needed Adval
	Intered	R05/4 -C11-02	1650 1 N SPI	264	06406400	an -	0.53.cm
5 15732548	Intend	Menuel	1850F 1 5F SPF	214	14-00-04	N.S.S.	Class Frans
×							
2		X	1				
2x4	1650F	1.5E SPF					

JohnDoe Admin 0/126 0/162 9:30 AM 9/8/2017



#### 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.

Delay Threshold Exceeded		Time (hrs.)	Percent (%)
Select a reason for the current delay in production	Productive Time	65.11	44.0%
Break	Unreported Non-Productive Time	34.49	23.3%
	Other Non-Productive Time	33.66	22.8%
Error	Maintenance Time	0.00	0.0%
Maintenance	Error Time	10.54	7.1%
	Break Time	4.07	2.8%
Other Delays	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.

Open	Save	Print	Quick Print	Cotors	2 Parameters	Header /Hooter	scale	Margins	Crientation	Size	66 Find	tsokrata	THEL Page	Prévious Page	Next Page	Last Page	× 0 d	Many Pages	Q Zoom Out	Q Zoom	Q Zoom In	Page Color	Watermark	Export To *	E-Mail As •	Close Print Preview
Dec	ament			Print			Fac	se Setup		2			Naviga	ituri:					Zouth			Page Ba	ckground		Expo	rt -

#### Analysis – Short Report

Provides a breakdown of times and quantities cut.

Holmes Truss Company 2218 BakerStreet London: NW1 6XE	MatchPo Ana	oint Blade Ilysis			category. (See page 5 for detailed information.)
Phane: 020 7965 0234 Fax: 020 1711 2007 Emeit: sholmes@holmestuss.com	Sew Blade Now 9(6/2017 Name ggaie	1 29 12 PM	Stan Finalt Shift Shift Stant Work Hts / Shift	Fn, May 19:17 Tue, Jun 13:17 15 8:00:00 AM 9	
Productive Time Unreported Non-Productive Time Other Non-Productive Time Naimsenance Time Bealant Bealant Bealant Bealant Bealant Bealant	Time (hes.) 65 11 34 49 33,65 0,00 10,54 4 07 147,87	Persent (%) 44 0% 23.3% 22.8% 0.0% 7.1% 2.8%			Displays the average parts per hour and the average tir cutting a part. (Productive Time is the amount of time the saw was cutting. Work Time is the total shift time.
Aug. Parts Per Hour Aug Time Per Part (sex.)	Productive Time 324.59 11.09	Work Time 142.92 25.19			Displays the amount of boards cut and the amount of boards that sawyers loaded manually
Board Quantity Manual Load Quantity Earl Revel Dates (%)	10.320				
Rip Sevel Parts (%) Saw Stolias Par Angle (%)	0.0%				
Assigned to Jobs Remaindem Screp	Part Cours 10.592 2.541 NA	Count 15 88.0% 12.0% NA	8eard Feet 95.533 1.977 4.339	80ant Feat % 93.8% 1.9% 4.3%	Displays cuts classified by the type of cut.
Treat	21,133	1	101,848		
					Displays total part count and total board feet classified by active jobs, remainders, and scrap.
i lauri e cale Oco - mantel Bie de Database i titra	Idhm voi				



#### Analysis – Long Report

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

	Carly	be 2:	aw addance	Saw:	MONES				
	Cross Cu	158	47.991		97.4%				
Enc	t Bevel Ci	ha .	0		0.0%				
Re	Bevel Ca	da .			0.0%				
	Sear C.	AR .	1,250		2.5%				
Total		-	49.247	1	00.0%				
CiUsersiggsialOccumentsiBlade Dats NR:2017 2:58:08 PM	sbase Ha	tory.mdb[]							Page 1 of 2
Holmes Truss Company 2218 Baker Street Lender, WY1 BXE		M	atchP An	oint B alysis	lade				
Holmes Truss Company 2218 Balar Sweet Lendon, NVI 6X8 Phone: 020 7866 0234		Mi Saw	atchP An	oint B alysis	ilade	Start	Fi	n. May 19 1	7
Holmes Truss Company 2218 Balar Steet Lendon, NVI SXE Phone: 020 7986 0234 Fair: 020 1711 2007		Mi Saw Now	atchP An Bide 9820	oint B alysis	Blade	Start Frish	Fi	n. May 19 '1 Ve, Jun 13 '	7
Huhmer Truise Company 2218 Bater Street Lendon, WVT 8XE Phone: 020 79880234 Fac: 020 7713027 Emeit: shohmes∰hohmestru	55.00M	M: Saw Now: Name	atchP An Blade 98920 9999	oint B alysis	Blade	Stant Finah Shifts Shift Star Work Hig	Fi Ti 18 / Shift: 9	n. May 19-1 Lus, Jun 13-1 6 100:00 AM	7
Holmes Truss Company 2218 Balar Stream Lendon, WIN 632 Phone: 020 73980 0234 Parc: 020 7371 2007 Email: shokes@holmestic	ss.com	M: Saw Now Name	atchP An Biede 9999	oint E alysis	Blade M	Stant Finish Shith Stan Work His	Fi Ti Shitt 9	n. May 19 1 Vet, Jun 13 1 8 30:00 AM	7
Holmes Tusis Conçany 2218 Batar Swan Landan, Witt BKB Phana 020 2886 0234 Para 70 2013 2007 Email: etnolmac@holmesmu	ss.com icgði -(3)	Saw Now Name	atchP An Blade staco ggain	oint B alysis	Blade	Stant Finah Shifts Shift Star Work His	Гі т. / Shift: 9 [9'-	n, May 19 1 Vie, Jun 13 1 8 100:00 AM	7
Holmes Tusis Company 2218 Batar Swaet London, XVII SKE Phane, 020 7966 0234 Fac: 0.00 713 3007 Email: eholmest@holmest Plant Type: 2 2	ss.com ingth i -3' 9'	Saw Now Name Time (Soc)	atchP An Blade setioo ggain 27-5	Torne (tec)	Blade MA Er-9' Dite	Stant Finish Shifts Shift Star Work His Usik His	Гі т. 8 / Shift: 9 / Shift: 9 / Эніт: 9 / Эніт: 9	n. May 19-1 List, Jun 13-5 8 -00-00 AM Time (sec)	7
Holmes Tuss. Company.           218 Baker Street           London, WW1 SKE           Plane.         620 6234           Face.         020 171 3202           Brail         sholmes@bakerstr           Plant.         700           Plant.         700           Plant.         700           Plant.         700           Plant.         700	as com right -3" 9	Mi Saw Now Name Time (soc)	atchP An Blade setioo ggain 27-6 Oty	Time (sec) 180	Blade MA Er-P Dry 0	Stan Pinah Shifte Shift Star Work Ha Time (3ec)	Fi 11 5 - 0 0ty 5	n. May 19-1 us, Jun 13 * 6 :00:00 AM [sec] 52.5	7
Нойнев Тиша Солрану 2218 Шака-Sheet Londan, W01 5K2 Ринан 020 7969 6224 Ринан 020 7969 6224 Рина 020 7969 6224 Рина 1071 2007 Елия Туре с С По Биле! 2 Арари	ss com ingth -37 97 0 4.551	Saw Now Now Name (sec) 0.0 8.9	27-6 01y 1.308	Time (sec) 18.0 7.8	Blade Ma 67 - 97 Oty 0 1,749	Stant Finah Shifts Shift Start Work Ha Vork Ha (sec)	Fi 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	n, May 19 1 se, Jun 13 5 6 :00:00 AM Time (occ) 5 2 5 9 9 5	7
Holmes Tours Conçany 2218 Balar Street London, Wr1 6x8 Phane 020 2989 0224 Pare 020 2173 2007 Email shalmas@halmestv Plant Type 24 Reg Street Reg Street 24 agin	sx.com -3' V 0 4.561 1.059	Sam Now Name Teme (sec) 0.0 8.9 20.4	27-6 27-6 27-6 27-7 27-7 27-7 27-7 27-7	Coint B alysis 172 58 08 F (sec) 18.0 7.6 9.9	Blade M (F-9 (Tr) (Tr) (Tr) (Tr) (Tr) (Tr) (Tr) (Tr)	Start Finish Shifts Shifts Shift Star Work His Use() 0.0 7.5 5 12.7	Fi 15kHz 9 97- Qby 5513 1,210	n, May 19 'T se, Jun 13 8 :00:00 AM [sec] 3 52.6 9 .0 5 1 .5 1 .5 2	7

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.

Phone: 020 3966 0234 Fac: 020 1711 2007 Email: abolma@holma Grade Grand Totals [None]	struss.com Size 2 x 4 x 2 x 4 x	Saw: Now: Name:	Blade 9(6/2017 3.10 998/8 Count 10,320	Board Feet 101,849.3	Start. J Finish: 1 Shifta: 5 Shift Start: 8 Work Hrs / Shift: 6 Break Min / Shift: 6 Linear Feet	in, May 1917 Iue, Jun 1317 6 50500 AM 9
Grade Grand Totals [Neae]	Size 2 x 4 x 2 x 4 x		Count 10,320	Board Feet 101,849.3	Linear Feet	
[None]	2 x 4 x 2 x 4 x				141,340.0	
	2 x 4 x 2 x 4 x					
	2 x 4 x	:6	4	16.0	24.0	
		: 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	10	7 64	28.0	42.0	
	2x4x	- 14	a0 214	033.0	1,092.0	
	2848					
Tetals			307	2,998.7	4,498.0	
2400F 2.0E SP	2 = 4 =	16	16	170.7	256.0	
	2 x 6 x	12	153	1.836.0	1,836.0	
	2x6x	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	
NUsersiggaia/Documenta/Blade 0	Patabase'Hist	ory.mdb[]				01
reizen zialteiza 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 2215 Baker Street London, NVI 6XE Phone: 020 7965 0234 Fax: 020 1711 2007 Email: sholmes@holmestruss.com	MatchPoint Blade           Non-Productive Time           Ser.         Bark           New:         97/2017 59:14 AM           Neme:         ggale           Shrb sac           Shrb sac           Work Hey / Sh	Fic, May 19 17 Tue, Jun 13 17 16 8 00 00 AM ft: 9	Holmes To 2218 Bake London, N Phone: Fac Email	ss Company /Streat 020 7985 0234 020 1711 2007 sholmes@holmestruss.com	MatchPoint Blade Non-Productive Time	n: Fni May1 sh: Tue,Jun 1s: 16 h Stant: 8:00:00 A ht Hns / Shift: 9	9 117 13 117 M
Гуре Other * Maintenance Error		Duration (Hr) 33.66 0.00 10.54	Other Type AutoDeck	Subtype I	Description	Quantity 540	Duration (Hr)
Total Reported Non-Produc	tive Time	48.27		-			
* Other is the total ti located on the main interface and in the	me accrued by the <i>Other Del</i> a screen of the <i>BLADE</i> operat belay Threshold Exceeded w	<i>ays</i> button, or vindow.					



Holmes Tr. 2218 Bakk London, N Phone: Fax: Email	use Company er Soneet W1 6XE 020 7996 0234 020 1711 2007 sholmes@holmestruss.com	MatchPointBlade Non-Productive Time Saw Birks New 972017551444 New 972017551444 New 972017551444 New 972017551444 New 972017551444 New 972017551444 New 972017551444 New 972017551444	Fri. May 1 Tue, Jun 1 16 π 8:00:00 A / Shrh: 9	9 17 3 17 M	Helmes Traas 2218 Baker London, NW Phane: 0 Fac 0 Email: a	Company Sneet 1 6XE 120 7986 0234 220 1711 2007 holmes@holmestruss.com	MatchPoint Blade Non-Productive Time Serve Birk New 972017759.14,44 New 97201759.14,44 New 97201759.14,44 Shift Serve Ven Ne / Shift	Fn. May 11 Tue, Jun 1 16 8-00:00 A 1: 9	9-17 (3-117 М
Iaintenan	ce				Error				
Type	Subtype	Description	Quantity	Duration (Hr)	Type	Subtype	Description	Quantity	Duration (Hr
					Error	Known	OutfeedError003 - Timed out running until empty	137	2.20
					Error	Known	InfeedRalError003 - No board was detected during the	53	1.42
					PrinterTrigger			503	0.19
					Error	Known	InfeedRalError002 - 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	0.31
					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 tengue 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 sufficient/ue	1	0.00
					Error	Known	SideClampError004 - Unexpected full clamp	1	0.00
					Error	Known	LasmClampError004 - 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
					CrookedLumberS	Sensor		7	0.00
					Error	Known	ServoError27D - Servo velocity command clamped to	1	0.05
Users\ggaia\D 7/2017 7:59:14	locuments/Blade Database∖H 4 AM	iatory.mdb[]		Page 3 of 6	C.1Users/ggais/Doc 9/7/2017 7:59:14 A	umenta/Blade Database/Ho M	tory.mdb[]		Page 4 of 6

Holmes Tr 2218 Bak London,	uss Company arStreet NW1 6XE	Ma Non-	tchPoint Blade Productive Ti	e me		
Phone: Fax: Email:	020 7986 0234 020 1711 2007 sholmes@holmestruss.com	Saw: Now: Name:	Blade 9/7/2017 7:59:14 AM ggaia	Stant: Finish: Shifts: Shift Stant: Work Hrs / Shift	Fri, May 1 Tue, Jun 1 16 8:00:00 A 9	9 17 13 17 M
Break						
Type					Quantity	Duration (Ha
Break					6	4.07