ATS Inspect 6.0

What’s New?
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New Features in ATS Inspect 6.0

For program fixes see [here](#).

For implemented feature requests see [here](#).

Data Collect

3D Data Collection

ATS Inspect now allows you to enter defects directly onto 3D CAD models.

The name and ID of each and every component within the model can also be imported into the database which will greatly reduce your setup time.

When you need to add a defect you can smoothly rotate the model, using a mouse or touch-screen, zoom in to the required area and assign the defect.

By bookmarking key positions the operator can jump to preset perspectives with cut-throughs and with various components removed so that they can place defects inside the product without the need for multiple views and photos to be taken.

Layered Views

You can now create multi-layer views. This allows the operator to strip away information to see inside the object being inspected.
For example, if you were inspecting the interior of a car door you could have layers that represent the door panel, wiring harness behind the door panel and finally the shell of the door. You can add and remove parts of your products on the image itself to get a real-life feel when carrying out inspections.

This layered approach mimics real-world inspections and speeds up data collection which reduces costs and means no defect can remain hidden for long.

**Create Part/Concern Associations at Runtime**

A new method of relating concerns to components has been introduced that will greatly reduce your configuration time.

When an operator first tries to highlight a defect they'll be presented with all available concerns. Once they've selected the concern and created the defect that concern is associated to the component.

Once enough data is collected an administrator can create the final list of concerns for each component based on the associations that have already been made on the production line. In effect we have created a self-learning configuration ability.

**Event Driven Logic**

You now have the ability to add event-driven logic to your end-user interfaces giving you all the power you need to customize the application behavior.
Instead of asking ATS for additional functionality when the user presses a button, you can add this functionality yourself. In-house configuration reduces costs and increases customization flexibility as well as reducing the time from concept to use on the plant floor.

**Search and Filter Defects**

Search and filter capabilities have now been incorporated into the defect entry workflows.

**Add Comments to Checklist Answers**

To give further information about an answer the operator can add comments.

**Image Capture in Checklist**

Operators can now take photos or upload images to support answers given in checklists.

**Images in Multiple Choice Questions**

The answers in multiple choice questions can now include images.

**Automatically Resizing to Screen Size**

Instead of having to make a different screen for every screen size you can now have a single screen that adjusts to all screen sizes.

**Full Screen View**

Data Collect allows you to expand the view itself to fill the whole screen. This gives you a much larger area to work with.
Include Extra Info in Tabs

You can use tabs to provide extra information in the same screen. Presenting everything the operator requires in tabs gives Data Collect a more intuitive feel.

View Reports Directly in DC

Microsoft SSRS reports can also be viewed directly in the Data Collect interface giving operators the latest data while carrying out inspections.

These reports, presented at the point-of-origin, will allow operators to see trends emerging in real time. For example, if a machine is slowly moving out of alignment, causing increasing numbers of defects, then the operator at the machine can see it happening and fix the problem before it gets any worse.

View Context Sensitive Documents

Documents can be shown related to the currently viewed product, characteristic, part, concern or repair. Any document can be made available so long as the client machine has an application that can open it.

View Web Pages in DC

Web pages can be accessed directly in Data Collect for quicker access to reference information stored online or on a local network.

Unlimited Unit Colors

A new Color Types capability has been added that allows an unlimited number of colors to be specified instead of just four.

Improved Touch Support

Many controls now support swiping.

Streamlined Workflows

All of the workflows within Data Collect have been revisited and, wherever possible, they’ve been streamlined and standardized to make defect entry as quick and intuitive as possible.

View Composer (New Application)

The vital step of configuring the inspection images has now been separated out into its own module.

Separating it from the other setup procedures has allowed us to create a clean environment where you can concentrate on creating your multi-layered 2D views and 3D CAD views quickly and effectively.
Improved Thumbnail Creation

Thumbnails can now be created for all images that have been imported at the click of a button. The thumbnails are created and stored in multiple sizes so that Data Collect can import the most appropriate size which has greatly improved image upload speed.

Image Editing

Some basic modifications can be carried out on images imported into View Composer. You are able to adjust the brightness and contrast as well as rotate and flip the image.

Improved Raster Workflows

The methods used for creating Raster views has been greatly advanced to produce modern tools and workflows that can be easily learnt and put into action.

Form Composer

Create User Interfaces for Data Collect

Form Composer now creates the user interfaces for Data Collect as well as Variable Data Collect.

Format Painter

The Format Painter allows you to copy the formatting of one control to another.

Smart Tags

Smart Tags are now available on each control you add to the form. Selecting a smart tag gives you access to a drop-down list of the most common properties of the control.
Expert Mode

By switching to expert mode you can view all of the available properties of a control. This gives more advanced users full control over how a user interface looks and runs.

Theme Support

The look of a set of user interfaces can be changed and standardised quickly by applying themes.

Variable Data Collect

WECO Rules

As well as Nelson rules you can now apply Western Electric (WECO) rules giving you more flexibility in your SPC control.

Boolean Characteristics

Variable Data Collect has also had several enhancements. You can now use Boolean characteristics presenting you with an additional method of recording and analysing your variable data.

Setup Information Displayed

Setup information (selected Process, Product, Setup and Labels) can now be displayed in the majority of the forms so that the operator can be sure that they're recording the correct information.

Automatic Return to Setup Screen when Subgroup Batch Completed

When a preset number of subgroups have been completed the operator is automatically returned to the Setup screen. This functionality is optional and can be set for each individual setup.
**Date/Time of Variable Datasets**

The Date/Time of variable datasets is now stored in UTC in the database and is converted to the correct time zone on the client machine so that the operator sees the correct time.

**Increased Subgroup Size**

The number of values that can be recorded for each characteristic in a single subgroup has been increased to 999. This number is set when assigning a characteristic to a setup.

**Message and Severity Displayed when Rule Violated**

When adding Characteristics to a Setup it's possible to specify the severity of each Nelson rule being broken. The severity will be displayed by the background colour and text colour in the Violation Message control in the Violation popup.

**Rename Rules and Chart Types**

Control rules and chart types can now be renamed.
Cockpit

All Admin Functionality Now Included in Cockpit

The Admin application has been removed and all of its functionality can now be found in Cockpit. This is also true for all functionality that was previously found in the Admin tab of Classic Reporting which has also been removed.

Import Data Using Spreadsheet

Many items, such as parts and concerns, can be imported from an Excel spreadsheet directly into the database. This is much quicker than specifying each item individually.

Import Multiple Images and Documents

It is possible to import multiple images and documents in one go instead of having to upload each one individually.

Product Groups

Product groups are now available in Variable Data Collect. Product groups are used in reporting to group product data. For example, if your facility produces washing machines and dryers, the quality data can be reported separately for each product. However, by creating a product group containing both, reports can be generated for the two items together.

Assign Multiple Products to a Single Variable Setup

Multiple products can be assigned to a single setup.

Assign Processes to Variable Setups

Rather than being completely independent, processes now need to be associated to a setup.

Assign Labels to Variable Subgroups

Labels can now be assigned to individual subgroups as well as to datasets.
Sync Code to Description

When adding a new item that requires both a Description and a Code you can enable the Sync Code to Description check box. This will automatically populate the Code field with whatever you enter in the Description field.

Hints for Missing Data

The configuration module, Cockpit, will now tell you if you are missing data required to create the item you’ve selected. When you select an item to create a warning will open in the bottom-right corner. You can then click on it to see what needs to be created before you can add the selected item.

Advanced Reporting Services

The entire collection of ATS Inspect reports are now available through ATS Advanced Reporting Services (ARS).

Using ATS ARS you’ll be able to run multiple reports simultaneously, save multiple report configurations, export to many different formats, schedule automatic report generation and much more.
Superseded Applications

Sometimes the requirements of our customers move beyond the capabilities of the existing software. When this happens we have to look to different technologies that can take us where we need to go. For this reason we have replaced three of our existing applications:

<table>
<thead>
<tr>
<th>Old Application</th>
<th>New Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Admin</td>
<td>Cockpit</td>
</tr>
<tr>
<td>Layout Manager</td>
<td>Form Composer</td>
</tr>
<tr>
<td>Classic Reporting</td>
<td>ATS ARS</td>
</tr>
</tbody>
</table>

All of our applications are now built on the .NET platform and web services. This provides a more robust and scalable environment.

Meanwhile, report generation has been completely migrated to the ATS Advanced Reporting Services (ARS) platform, leveraging the strengths of Microsoft SSRS technology.

General

Work on Multiple Monitors

In the configuration modules (Cockpit, Form Composer, View Composer) it's possible to work across multiple monitors. The separate windows and panels can be dragged outside of the application increasing your working area.

Improved Event Service

Creating Events has been simplified by allowing you to drag and drop data tags into the script. There is also only one service used now instead of the multiple services used in previous versions.
New Features in ATS Inspect 5.5

Data Collect

Filter Checklist Questions

The questions displayed to an operator can now be filtered by adjusting the properties of the station. The available options are:

- Show all questions
- Show unanswered questions
- Show wrongly answered questions

Checklist Control Document

The maximum size of the document displayed in the Checklist control of the Main page can now be set to take up to 80% of the control. The reference document component can also be disabled altogether.

Reset Questions after Repairs

It is possible for checklist questions to be reset automatically when a repair is carried out. This means that when a specified repair is carried out the answers to associated checklist questions are cleared and the operator must check those items again.

Checklist Service Associated to Station

Checklist Service is now associated directly to each Data Collect, Mobile Repair and Mobile Checklist station. It is associated in the Properties tab of the station settings in Admin.
Checklist Service Split in Two

Checklist Service has now been split into two with the following tasks:

- ATS Inspect Checklist Generation Service: Handles requests to create checklists.
- ATS Inspect WCF Checklist Service: Handles requests to perform tasks related to checklist questions.

Variable Data Collect

Custom Event Scripting in VDC

Custom event scripting allows you to add custom functionality to the forms. This functionality could be used at any point such as when opening a form, clicking a button or entering a value. It will allow you to add whatever functionality you need. For example:

- Show extra information in a popup when clicking a button.
- Send an email whenever someone logs in.
- Launch and interact with other applications while entering data.
- Call and utilise data from other databases.

Database

Support for Languages with Double Byte Characters

It is now possible to add items to the database using languages with double-byte characters. This means that the data collection user interface can now be displayed in languages such as Chinese, Japanese and Korean.

An existing database can be updated to support double-byte characters using the new Data Transfer Wizard application.
Oracle Databases

Our customers running Oracle databases will now enjoy all of the latest functionality as described in the following pages, from version 4.1 to version 5.5.

chk_generation_queue Table Updated

The sequence column in the chk_generation_queue table was previously an identity column that was updated with an automatically assigned number. For Oracle compatibility it must now be filled with the next available number. This will affect existing custom_create_new_unit scripts that will need to be updated.

Form Composer

More Descriptive Errors in Form Composer

Error messages in Form Composer now contain more information. These can be viewed in the following ways:

- View the errors in the Error List panel.
- Save a form - any errors (e.g., missing components) will be listed.
- Hover over the Usable column when opening a form to see why a form isn't usable.

Cockpit

Reference Documents

The method for adding reference documents has been modified so that documents can be associated to parts, concerns and repairs in one screen.
Search Checklist Questions

The Checklist Questions list can now be filtered by entering text in a Search field. The list will return questions that match the text in either the Description or Code column.

View Questions Associated to Static Answers

The checklist questions that are using specific static answers can now be viewed in the Static Answers dialog box in Admin.
Tracking Point Groups in Triggers

Tracking Point groups can now be selected, as well as individual tracking points, when creating Quantity per Time and Quantity per Unit triggers. Units that go by any of the tracking points in the group and satisfy the other variables will cause the trigger to go off and a notification to be sent.

Replaceable Parameter for Step

A replaceable parameter has been added to identify the current step when using stored procedures.

\[ \text{[current\_step\_id]} \]

Mobile Apps

Mobile Vocabulary

Mobile apps are now multi-lingual and have their own set of vocabulary.

![Mobile Apps](image1)

Mobile Settings

The following settings are now available in Mobile Checklist and Mobile Repair:

- **Show Close Button**: Display a close button in the application (1=yes, 0=no).
- **Allow User Code Login**: Allows user to toggle between login screen with username/password and one with user code only. Using the code option allows a user to quickly login via a single step scan.

Mobile Checklist also contains the following setting:

- **Default Identity Type**: Sets the default identity type on the unit screen.
General

Single Login Method

Login for all applications requiring a standard login has been simplified. They will now only accept an *Inspect* username and password (an *SQL* and *Windows* login were previously available).

![Connect to Inspect](image)

Multiple Service Instances

It is now possible to run multiple instances of some services on the application server. Each service can then connect to a different database. This can be done with the following services:

- ATS Inspect WCF Checklist Service
- ATS Inspect WCF Communication Service
- ATS Inspect WCF Data Service
- ATS Inspect WCF Traffic Service
- ATS Inspect WCF Travel Service
The graphic below demonstrates how the connections could work:

Functionality Moved from Admin to Cockpit

The following functionality has been moved from Admin to Cockpit:

- Part Categories
- View Categories
- Products
- Product Groups
- Model Years
- Build Groups
- Plants

View Checklist Answer History

The history of the answers given to a question on a particular unit can be viewed in the Single Unit History report.

<table>
<thead>
<tr>
<th>Actual Date</th>
<th>Station</th>
<th>Recording User</th>
<th>Value</th>
<th>OK</th>
</tr>
</thead>
<tbody>
<tr>
<td>19/10/2012 13:55</td>
<td>Final Inspection</td>
<td>Inspect</td>
<td>14.0</td>
<td>No</td>
</tr>
<tr>
<td>19/10/2012 13:59</td>
<td>Final Inspection</td>
<td>Inspect</td>
<td>18.0</td>
<td>No</td>
</tr>
<tr>
<td>19/10/2012 14:00</td>
<td>Final Inspection</td>
<td>Inspect</td>
<td>25.0</td>
<td>Yes</td>
</tr>
</tbody>
</table>
New Features in ATS Inspect 5.4.3

There are no new features in 5.4.3. This release is purely to correct an issue.

See [here](#) for more information.
New Features in ATS Inspect 5.4.2

Reference Documents for Questions

Reference documents such as text files, PDFs and images can be associated to a question in Cockpit. These can then be viewed by the operator answering the questions in the Checklist control in Data Collect.

The files that can be displayed are limited only by the available viewers installed on the client machine. For example, if Adobe Reader is installed, PDF files can be opened.
New Features in ATS Inspect 5.4.1

Custom Unit Information

Data collection has now been enhanced by the use of custom unit information. For example, you can add a variable to the units named Inspection Stage which would relate to the current location of the unit within the inspection process. The variable can then be used in the following ways:

Unit Lists

Display custom unit information in the unit lists when using Data Collect and Auditor. The unit lists allow the operator to select a unit to be inspected. The operator can sort the list using the custom field to quickly locate and select the required unit. This modification affects the Unit List and Unit List - Audit screens, as well as the Unit List control in the Main and Main - Audit screens.
Custom Info Field

This control (available in the Main and Main - Audit screens) will display custom data related to the unit.

Brewery ID

Import and Export Forms

Form Composer forms can now be exported and imported individually as files, allowing them to be copied and transferred between systems.
New Features in ATS Inspect 5.4

Data Collect

Mandatory Inspection Sequence

System administrators now have the ability to create inspection steps. Inspection steps are assigned to each station in the desired sequence using Cockpit. Each step may include checklist questions, views, view categories and part categories and can have an image associated to it to highlight where the operator is working.

In Data Collect the operator must begin with the first inspection step assigned to the station, and cannot proceed to the next step until the current step has been completed. Completion will be accomplished by answering all checklist questions assigned to the step.

To help visualize where the user is in the overall inspection process, a new Filmstrip control has been introduced. It allows the user, at a glance, to know exactly where they are. If the Inspection step contains an image, it will be displayed in the control.

Inspectors may logout at any point during the inspection process and the current inspection step will be saved. Any inspector will be able to login, pull up the same unit and continue the inspection at the point where the previous inspector left off.
In order to simplify the setup procedure Cockpit now contains the functionality to associate the Views, View Categories and Part Categories to a Data Collect station. This functionality was previously in Admin.

**Checklist control**

A new Checklist Control has been introduced in the main screen to make it easier to answer checklist questions. It is very similar to the control available on the Mobile Checklist application, which has been welcomed by our customers. The control will cycle through the questions tied to an Inspection Step, one question at a time. If the answer is correct, it automatically moves on to the next question. If not, it indicates the wrong answer and requests confirmation.
Reference documents

On the Defect and Repair screens, the operator can now view images and documents that describe the acceptable/non-acceptable conditions on the selected part. These could be documents such as operator instructions, process sheets, drawings or visual aids. They can be associated to the following items:

- Part
- Part + Concern
- Part + Concern + Repair

The files that can be displayed are limited only by the available viewers installed on the client machine. For example, if Adobe Reader is installed, PDF files can be opened.

![Reference Documents Associated to Part](image)

Figure 1 – Reference Documents Associated to Part
Figure 2 – Reference Documents Associated to Part + Concern

Figure 3 – Reference Documents Associated to Part + Concern + Repair
Replaceable Parameters

New replaceable parameters have been created:

- current_part_id
- current_part_code
- current_concern_id
- current_concern_code
- current_repair_type_id
- current_repair_type_code

Loading Layouts

All layouts are now loaded on demand which means that the initial startup time of the program is much faster.

New Repair Controls

Two new controls have been added to the Repair screen to speed up the repair process. The Last Repair Comments control displays a list of most recent comments associated to the selected Component/Concern/Repair combination. The Top Repair Types control displays the most common repairs for the selected component.

Admin

Clone Station

Station cloning now copies across all station settings automatically.

Serial Port Handlers

The Serial Port Handler functionality has now been moved to Cockpit.

Event Service

Repair Triggers

It is now possible to create Repair Triggers. A Repair Trigger is very similar to a Defect Trigger. Repair Triggers send notifications when individual repairs are entered into the Inspect system. Administrators can customize these triggers so that notifications will be sent when a specific type of repair is carried out on a specific component used in one product. Repair triggers can also be set up to send notifications when any repair is carried out on any component used in any product assembled in the plant.

Security Manager

SQL Server login

It is no longer possible to modify the password of an SQL Server login using Security Manager. The modification must now be carried out in SQL Server Management Studio.
Services

Travel Service
Travel Service has been rewritten in .NET and the image caching function has been made optional.

XML Comm Service
The XML Comm Service has been removed.

Database

Password Encryption
ATS Inspect now encrypts its passwords in the database. This provides you with a much higher level of security.
New Features in ATS Inspect 5.3

Cockpit (New Application)

System administrators and other IT/technical resources use this application to configure, manage and monitor communication processes and services for external systems that send information to and from Inspect. It manages the configuration of the new .NET version of Inspect Communication Services.

It also manages the configuration of the information required for Variable Data Collection.

Data Archiver (New Application)

This new data management tool allows you to remove your historical data from the Inspect database and store it on a separate file. This will free up online resources and increase the analytical speed of your production systems by reducing the amount of data in the system.

Form Composer (New Application)

The Form Composer application is a design and layout program for customizing the appearance of screens used at the Inspect Variable Data Collect stations. The system administrator can create
templates, comprised of forms, to control the colors, sizes, fonts and placements of every Variable Data Collect screen.

Variable Data Collect (New Application)

Inspect has long been the preferred data analysis tool for Six Sigma Black Belts in the attribute data world; we have now crossed the threshold into the variable data world.

Variable Data Collect allows operators to record Critical To Quality characteristics such as lengths, diameters, temperatures, voltage or weight. Statistical process control charts are also now available.
for real-time data analysis. Our customers asked to have all data, attribute and variable, in one portal; and we listened.

Admin

Keyboard entry to find part in checklist

When creating or editing a question, the associated part/location can be found faster by selecting the dropdown list and pressing the first letter of the part/location you are looking for. The list will then jump to part/locations starting with that letter.

Part/Concern extended properties

The matching options for a part/concern repair relationship can include a dynamic lookup and location.
Selected Parts and Views in categories

When looking at the View Categories popup, highlighted views remain selected when you switch between products. This saves the user from having to find and re-select views when the same views are required in several products. The same also happens in the Part Categories popup.

Defect selection radius

The radius at which a defect can be selected in Data Collect and Auditor can be modified in the station options. Enlarging the radius at which a defect can be selected will make them easier to select.

On the other hand the radius can be reduced if the defects are generally close together.
Optional detail selection

Detail entry in Data Collect and Auditor can be made either optional or mandatory in the station options. When detail entry is mandatory, and there are details available for the selected concern, the OK button won’t be activated until a detail has been selected.

Turn on/off validation sounds

Validation sounds for checklist questions in Data Collect and Auditor can be turned on or off in the station options.

Question can appear in more than one category in a checklist

A question can be cloned and modified so that it appears in more than one category of the same checklist.
Question can be included in a Product Group

The inclusion tab in question properties allows a question to be included in an entire product group as well as in individual products.

Load views on demand

In order to speed up the start-up process for Data Collect and Auditor, instead of loading all views when logging in, there is an option in Station properties that will allow them to only be loaded when they’re required.

Resize original size of views

The original size of views in Data Collect and Auditor can be changed in the station options.

List of screens shown for selected template

When looking at layouts associated to stations the screens of the layout are also visible.
Make non-essential languages inactive

Languages can be hidden from the drop-down list in the task bar by setting them as inactive.

![Languages](image)

Instant update of checklist questions

When an existing checklist question has been modified, or a new one has been added, it can be made available on the production line instantly by pressing the new **Add to Units...** button. This ability is limited to questions that are assigned to categories.

Data Collect

Auto-select Detail

If only one Detail is available when a defect is being entered, it is automatically selected.

Defect Filter Mode button renamed

The Defect Filter Mode button has been renamed on the Main screen and the Overview screen as follows:

- **Main screen**: Defect Source Filter Mode.
- **Overview screen**: Defect Status Filter Mode.

Layout Manager

Transfer layouts between databases

It's possible to transfer a layout from one database to another. The layouts are exported from the first database as .xml files and can then be imported by the second database in the same format.
View layout, template and station relationships

When opening a layout it is now possible to see which templates they belong to by selecting them.

It is also possible to see a list of stations that a template is related to when viewing templates.

Display and Hide Main View Information

The information displayed below the main view can now be optionally hidden. The available information is:

- Last Point
- Last Physical Point
- Scale
- Component

These options can be changed in the properties of the Master View control as shown below:

Reporting
MFR Part Number in Raw Data Dump report

A column showing the MFR Par Number is now available in the Raw Data Dump report.

Regenerate and delete questions

The administrative tasks tab now allows you to regenerate and delete checklist questions for specific units.

Modified Defect Removal/Correction Filter

In Defect Removal and Defect Correction it is now possible to filter by Recording Area, Group or Station instead of just Recording Station.

Security Manager

Login rights

A user must either have super user rights or rights for logging into Security Manager in order to log in to Security Manager.

Additional security rights

The following possible security rights have been added:

- Admin - Modify Checklist
- Admin - Add Checklist Questions to Unit
- Admin - Modify Costing
- Admin - Modify Variable Setup
- Admin - Modify CAP Setup
- Data Archiver – Login

General

New Services

Two new services have been added:
ATS Inspect WCF Comm Service has been removed.

### Default Service Ports

The Service ports have been re-numbered for .NET services as follows:

<table>
<thead>
<tr>
<th>Service Name</th>
<th>End Point</th>
</tr>
</thead>
<tbody>
<tr>
<td>ATS Inspect WCF Checklist Service</td>
<td>net.tcp://&lt;servername&gt;:8200/WcfChecklistService/</td>
</tr>
<tr>
<td>ATS Inspect WCF Traffic Service</td>
<td>net.tcp://&lt;servername&gt;:8300/WcfTrafficService/</td>
</tr>
<tr>
<td>ATS Inspect WCF Traffic Service</td>
<td>net.tcp://&lt;servername&gt;:8301/WcfTrafficService/Subscriber/</td>
</tr>
<tr>
<td>(subscriber)</td>
<td></td>
</tr>
<tr>
<td>ATS Inspect WCF Traffic Service</td>
<td>net.tcp://&lt;servername&gt;:8302/WcfTrafficService/Publisher/</td>
</tr>
<tr>
<td>(publisher)</td>
<td></td>
</tr>
<tr>
<td>ATS Inspect WCF Comm Service</td>
<td>net.tcp://&lt;servername&gt;:8400/WcfCommService/</td>
</tr>
<tr>
<td>(subscriber)</td>
<td>net.tcp://&lt;servername&gt;:8401/WcfCommService/Subscriber/</td>
</tr>
<tr>
<td>ATS Inspect WCF Data Service</td>
<td>net.tcp://&lt;servername&gt;:8500/WcfDataService/</td>
</tr>
<tr>
<td>ATS Inspect WCF Travel Service</td>
<td>net.tcp://&lt;servername&gt;:8600/WcfTravelService/</td>
</tr>
</tbody>
</table>

### Startup Switches

The majority of the Startup Switches have now been removed as they are now implemented within the various programs.

The only one remaining is `/s` which will work for Data Collect and Auditor. For example, `DataCollect /s FinalCheck` can be used as follows:
Locked units

It is now possible to lock a unit so that it cannot be modified.

Supported platforms

The platforms supported by Inspect has been expanded to contain all of the following:

- Windows XP (32-bit or 64-bit)
- Windows Vista (32-bit or 64-bit)
- Windows 7 (32-bit or 64-bit)
- Windows Mobile 5.0 or higher **
- Windows Server 2003 R2 (32-bit or 64-bit)
- Windows Server 2008 (32-bit or 64-bit)
- Windows Server 2008 R2 64-bit
New Features in ATS Inspect 5.2

Windows Authentication

Windows authentication is now available. Each user can be mapped to a Windows account within the domain; therefore, entering user and password is not necessary, as Inspect recognizes the current Windows user and matches it to the user in the Inspect database.

SQL Server authentication is also supported. These two methods are required for Table Auditing, described next.

Inspect authentication is still supported, but it is not recommended since user-level table audited is not possible.

Table Auditing

Inspect can now detect and record any modifications to any table in the system, such as defects and repairs. All inserts, deletions and updates are logged along with the user who made the change, date and time, application where the change was made from and other parameters.
Security Manager

User configuration and Security Rights management have been removed from Admin and placed into the new Security Manager application. This allows multiple users to make configuration changes in Admin, while still maintaining total control on security privileges in the system.

Improved Licensing

The licensing mechanism has been completely rewritten to improve the response time at startup and friendlier user interface.

Multiple Defect Entry

The automatic selection of a default rank while in Multiple Defect Entry mode has been updated. Now, the user will be required to select the rank before the defect is created.

New Copy Unit Control

The Copy Unit control is used to quickly copy the defects on a single unit to multiple units. In order to use this control, the user simply touches the edit portion of the control and a popup keyboard will
appear. The user should then enter the number of times to copy this unit and its defects. Once the quantity is entered, pressing the Apply button will copy the unit the specified number of times. When the copy process is complete, it will switch to the last unit created.

The Administrator can specify that the copy operation should be confirmed before being performed, if desired. This can be set in Layout Manager by activating the “Confirm before copying unit” property, as shown in the following image.

**Force Rank**

The Force Rank control is used to change the rank of all defects entered during the current inspection to whatever rank the user chooses. The user simply clicks the Force Rank button and all defects will have their rank changed. The caption on the button is fully editable. Only defects entered during the current inspection will be changed – any existing defects will remain at their current rank.

The desired rank is set by changing the Forced Rank property. The Administrator can specify that the rank change should be confirmed before being performed, if desired. This can be set in Layout Manager by activating the “Confirm before changing Rank” property, as shown in the following image.
Station – Top Concerns

The capability to set the order of critical concerns has been added. It appears in the Stations > Data-Collect > Top Concerns menu:

Using this feature, the order of important concerns can be set in any order desired. The concerns associated to the station will be shown in the desired order (provided they are associated to the selected part).
The user can also copy a station's set of concerns (and their order) using the Clone button. If clicked, the following dialog will be displayed:

Please note that this is not a merge operation. Rather, it is a full replacement of the top concerns for a station. Any existing set of concerns for a target station will be removed.

**Dependent SQL Controls**

Since Layout can execute SQL statements to display data on controls, it is now possible to limit the results from a statement depending on the value selected on a different control. In the example below,
the layout shows two controls: Product Group and Product. The goal is to limit the products displayed in the latter, depending on the button selected in the first.

The following SQL statement provides a list of the product groups available, showing them in the top control. Notice that the name of this control is set to 'ProductGroup.'

The following SQL statement to display the data on the second control uses the runtime replaceable parameter name of the top control ([ProductGroup]) to limit the results.
The first example below shows the Product Codes associated to Product Family 'A.' When the selection changes to Product Family 'B,' the List of Product Codes is updated accordingly.
Canvas Size on Layout Manager

Layout Manager now has the concept of the ‘canvas’ – this is the allowable space in the screen where controls can be placed. This was introduced to avoid issues where controls could be left partially out of the layout and would therefore not appear on the screen.

With the canvas, the size of the layout is not actually specifically set. Instead, the size of the layout is defined by the location of controls on it – the size of the layout will be set as the minimum area to include all controls on the canvas.

![Canvas Size on Layout Manager](image)

Thumbnail View in Admin

You can now see a thumbnail preview of a view before opening it.

![Thumbnail View in Admin](image)

New Station Types

Several new station types have been added – these will be used in upcoming applications.
Reference to New Checklist Validation Service

In earlier versions of Inspect, the validation of checklist questions was performed within Data Collect. Now, this logic has been placed on a new service, which allows for future application and external systems to validate the answers to checklist questions.
### Program Fixes

#### ATS Inspect 6.0

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>10517</td>
<td>When details were entered for the next batch, the input screen did not display the details for the new batch but the details previous one.</td>
</tr>
<tr>
<td>10726</td>
<td>It is now possible to use only keyboard when selecting a setup (entering labels, more precisely) and not to have to touch the mouse.</td>
</tr>
<tr>
<td>10853</td>
<td>Defect mode toggle button requires 3 clicks when one of the options is removed. Completely reworked in 6.0.</td>
</tr>
<tr>
<td>10946</td>
<td>Unable to assign repairs when selecting multiple defects on the overview screen.</td>
</tr>
<tr>
<td>11116</td>
<td>&quot;A circular control reference has been made. ...&quot; exception when opening Input form. Receiving the same error 12 times at completely random times within a 1 hour period.</td>
</tr>
<tr>
<td>11295</td>
<td>Unable to scan the bar code labels on the travel ticket. The issue was related to the bar code style on the travel ticket as the scanners will not read code 39.</td>
</tr>
<tr>
<td>11312</td>
<td>Error encountered when trying to delete Inspection Routines.</td>
</tr>
<tr>
<td>11551</td>
<td>When using the Checklist summary report IIS crashed when opening a Histogram chart on a larger data set.</td>
</tr>
<tr>
<td>23544</td>
<td>It was not possible to add a characteristic to an existing setup. The behavior was not entirely consistent.</td>
</tr>
<tr>
<td>23674</td>
<td>When opening Cause/Actions &amp; Chars/Causes an exception is shown. The error was also shown when deleting a characteristic from a Setup and clicking OK.</td>
</tr>
<tr>
<td>24149</td>
<td>fk_var_set_char_rul_vsc_id foreign key creation was missing. This caused DTW to fail when copying var_setup_char_rules table if the source database contained data in var_setup_char_rules referencing var_setup_char_id that does not exist in var_setup_chars table.</td>
</tr>
<tr>
<td>24607</td>
<td>Beg Date and End Date displayed by the Uptake report (813) in US format, but a UK format was required.</td>
</tr>
<tr>
<td>24759</td>
<td>When only labels are changed in a setup, the new labels are not saved.</td>
</tr>
<tr>
<td>24949</td>
<td>When the 6.0.22 database was updated to schema 6.0.26 it was missing VAR_SETUP_SUBGROUP_LABELS and VAR_DATASET_SUBGROUP_LABELS tables.</td>
</tr>
<tr>
<td>25123</td>
<td>In VDC several controls couldn’t be translated.</td>
</tr>
<tr>
<td>25126</td>
<td>Some warnings/confirmations were only shown in English.</td>
</tr>
<tr>
<td>25204</td>
<td>The is_multi_text_unique SP is missing from update scripts. The SP is not contained in any of the update scripts, only in the build script.</td>
</tr>
<tr>
<td>26133</td>
<td>UoM and Reference Documents dropdowns are not showing descriptions.</td>
</tr>
<tr>
<td>26134</td>
<td>Error when importing Setup or Process with numeric process code.</td>
</tr>
<tr>
<td>26135</td>
<td>Error when editing Nelson Rule.</td>
</tr>
<tr>
<td>26136</td>
<td>Exception when clicking on Pie chart.</td>
</tr>
<tr>
<td>26137</td>
<td>Setup import does not allow import of Boolean characteristics.</td>
</tr>
<tr>
<td>26140</td>
<td>Text on View/Edit Data form not translatable.</td>
</tr>
<tr>
<td>TFS</td>
<td>Corrected item</td>
</tr>
<tr>
<td>------</td>
<td>----------------</td>
</tr>
<tr>
<td>7893</td>
<td>When operators entered '&amp;' in defect comments and a trigger was fired, an error message appeared when clicking the script hyperlink in the Event Input Queue.</td>
</tr>
<tr>
<td>9330</td>
<td>Change password functionality had stopped working.</td>
</tr>
<tr>
<td>9437</td>
<td>The only way to log in to Mobile applications was to use a user with Super User rights.</td>
</tr>
</tbody>
</table>
9757 | The maximum size of the document image in the checklist_question control can only be set to 50%.
9758 | Needed to be able to disable the document image part of the checklist control for certain stations.

### ATS Inspect 5.4.3

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>9341</td>
<td>When trying to open the chars/cause window the CPU load went to 100% for WCFDataService and the memory went up to 600mb.</td>
</tr>
</tbody>
</table>

### ATS Inspect 5.4.2

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>9233</td>
<td>Error in Security manager and no security groups available. On opening &quot;Manage security groups and rights&quot; two errors were shown.</td>
</tr>
</tbody>
</table>

### ATS Inspect 5.4.1

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>8755</td>
<td>When performing repair for the faults entered into DC from the test equipment the &quot;OK&quot; was not active.</td>
</tr>
</tbody>
</table>

### ATS Inspect 5.4

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>7401</td>
<td>View with part/location associated to checklist would not appear in the checklist views.</td>
</tr>
<tr>
<td>8286</td>
<td>Only the first view from the view picker control was functional on the MDE screen.</td>
</tr>
<tr>
<td>8377</td>
<td>Multi Station/Group Top Five report shows Error on Page. The report wouldn't run, displaying 'Error on Page' in the browser's lower-left corner.</td>
</tr>
<tr>
<td>8575</td>
<td>Comments were actually in the database and also getting loaded into the CRepair instance in the Repair-Details layout but weren't being displayed in the control.</td>
</tr>
<tr>
<td>8723</td>
<td>Exception of type 'AutoMapper.AutoMapperMappingException' was thrown.</td>
</tr>
<tr>
<td>8737</td>
<td>Error Importing data with comm. service. The first number of the VIN was not being inserted. The messages were not starting at the correct position.</td>
</tr>
</tbody>
</table>

### ATS Inspect 5.3

<table>
<thead>
<tr>
<th>TFS</th>
<th>Corrected item</th>
</tr>
</thead>
<tbody>
<tr>
<td>6998</td>
<td>In Data Collect, the color text disappears when the text color is similar to the color itself.</td>
</tr>
<tr>
<td>7778</td>
<td>In Reporting, Single Unit History is slow to generate. The query didn't complete at the bottom of the IE page. The report was visible but the query appeared to still be running in the background.</td>
</tr>
<tr>
<td>7833</td>
<td>An error was shown when attempting to delete a user in Security Manager.</td>
</tr>
<tr>
<td>7840</td>
<td>Was unable to add users due to a duplicate key problem.</td>
</tr>
<tr>
<td>TFS</td>
<td>Corrected item</td>
</tr>
<tr>
<td>--------</td>
<td>-----------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>6546</td>
<td>The new concept of Canvas eliminates the possibility of placing controls off screen.</td>
</tr>
<tr>
<td>6408</td>
<td>Entering defects on views with multiple grids would create one defect record for each grid.</td>
</tr>
<tr>
<td>6716</td>
<td>User was unable to save specific responsible areas/cells; only ALL option was saved.</td>
</tr>
<tr>
<td>6724</td>
<td>Cannot navigate by page with custom filters in Classic Reporting. Problems with the Search capability in custom filters were corrected.</td>
</tr>
<tr>
<td>6629</td>
<td>Selecting Concern/Part/Location would show Detail only. Detail\Detail report does not show the part\location\detail text in the chart.</td>
</tr>
<tr>
<td>6646</td>
<td>An error message appeared when running the Inspection Removal administrative task in Classic Reporting.</td>
</tr>
<tr>
<td>6891</td>
<td>Unable to resize Copy Unit Keyboard control</td>
</tr>
<tr>
<td>6720</td>
<td>The registry key would reset its value after each restart, so it was not possible to use the Debug mode.</td>
</tr>
<tr>
<td>6788</td>
<td>The function that added recurring defects was being called in two places.</td>
</tr>
<tr>
<td>6617</td>
<td>Cannot enter lowercase format characters on Checklist questions.</td>
</tr>
<tr>
<td>6810</td>
<td>In Admin, entering character '{' in part, option code, pocket repair, arrow, station and reference description field causes error message.</td>
</tr>
<tr>
<td>6887, 6950, 6951, 6952, 6953, 6954</td>
<td>The character was not allowed due to the manipulation of the table updates.</td>
</tr>
<tr>
<td>6824</td>
<td>The control would clean up the current answers, but would not delete the previous one.</td>
</tr>
<tr>
<td>6845</td>
<td>Error message when adding/removing recipients to trigger.</td>
</tr>
<tr>
<td>6811</td>
<td>Error message when deleting validation Messages. User would be unable to delete validation messages.</td>
</tr>
<tr>
<td>6743</td>
<td>Checklist validation is disables when adding custom error message. Checkbox should not be updated after adding the message.</td>
</tr>
<tr>
<td>Issue</td>
<td>Description</td>
</tr>
<tr>
<td>--------</td>
<td>-------------</td>
</tr>
<tr>
<td>6755</td>
<td>Cannot delete SMTP Output in Event Service. Error message would prevent deletion.</td>
</tr>
<tr>
<td>6890</td>
<td>A property designed for setting the highlighted color of the selected row on a spreadsheet control had no effect on it. It was corrected, so now the property is functional.</td>
</tr>
<tr>
<td>6904</td>
<td>Concerns auto control does not refresh when selecting different parts in MDE mode.</td>
</tr>
<tr>
<td>6915</td>
<td>Auditor Ranks and Responsible Areas menu items are not active in Admin. After using these options and closing their window, their option in the menu would still be disabled as if the windows were still open.</td>
</tr>
<tr>
<td>6689</td>
<td>Copyrights are now extended until 2009.</td>
</tr>
<tr>
<td>6820</td>
<td>Script to update from 4.1.4 to 4.1.5 had two errors.</td>
</tr>
<tr>
<td>6916</td>
<td>Auto controls not showing on Goto Next Batch screen. Controls would not appear due to a refresh issue.</td>
</tr>
<tr>
<td>6622</td>
<td>Unable to print travel ticket. The error 'CBaseTicket::Print(): Failed to create DC!' would appear when trying to print a travel ticket.</td>
</tr>
<tr>
<td>7000</td>
<td>Column headers on travel ticket do not display proper vocabulary in German. Languages other than English (US) were affected.</td>
</tr>
<tr>
<td>6966</td>
<td>ADO Error when adding a Serial Port Handler with a baud rate of 38400. Removed the 38400 baud setting as it was not supported by the check constraint.</td>
</tr>
<tr>
<td>6967</td>
<td>ADO error editing a Plant Metrics Subgroup. Attempting to edit any existing Plant Metrics Subgroups from the Admin application resulted in an ADO Provider Error message.</td>
</tr>
<tr>
<td>6968</td>
<td>ADO error adding a Audit Report Target. Attempting to add/edit any Audit Report Target from the Admin application resulted in an ADO Provider Error message.</td>
</tr>
<tr>
<td>6969</td>
<td>ADO error deleting a Reference Categories. Attempting to delete any existing Reference categories from the Admin application resulted in an ADO Provider Error message.</td>
</tr>
<tr>
<td>6985</td>
<td>Issue trying to create a dynamic lookup and one of the substrings has a start position greater than 50 and they are receiving an error. Modified dialog to use dropdown's (combo boxes) to limit input to appropriate values.</td>
</tr>
<tr>
<td>6812</td>
<td>Error when deleting script from event service. Corrected issue and now presents warning message when scripts currently have associations.</td>
</tr>
<tr>
<td>7003</td>
<td>Concern Ranking ignoring CUI filter selections. Also affected Details Online/Offline, Concern Grid, Concern Spectrum, Concern Spectrum Video Wall, Repairs by Area/Cell, and Repairs by Category reports.</td>
</tr>
<tr>
<td>6764</td>
<td>DPU Group or DPU Resp Group target won't allow duplicate date. Issue corrected to allow duplicate dates.</td>
</tr>
<tr>
<td>6566</td>
<td>AND operator does not work with Unit Lookup Test for inclusion. The SQL query had to be modified.</td>
</tr>
<tr>
<td>6777</td>
<td>Outdated information on README.TXT. Updated system requirements and company contact information.</td>
</tr>
<tr>
<td>7087</td>
<td>Error message &quot;Cannot start service from the command line or debugger&quot; during installation. Corrected installation routine.</td>
</tr>
<tr>
<td>ID</td>
<td>Description</td>
</tr>
<tr>
<td>-----</td>
<td>---------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>6781</td>
<td>Long delay in Licensing Service. Corrected the Licensing timing at startup.</td>
</tr>
<tr>
<td>6958</td>
<td>Error message when opening view in Admin. Problem appeared when no image was associated to view.</td>
</tr>
<tr>
<td>7101</td>
<td>ADO error deleting Audit station. Delete statement was not checking one table.</td>
</tr>
</tbody>
</table>
### Implemented Feature Requests

#### ATS Inspect 6.0

<table>
<thead>
<tr>
<th>TFS</th>
<th>Implemented Feature</th>
</tr>
</thead>
<tbody>
<tr>
<td>15878</td>
<td>Add possibility of cloning views</td>
</tr>
<tr>
<td>16243</td>
<td>Add Column for Mandatory Checklist Question or dropdown similar to category</td>
</tr>
<tr>
<td>27056</td>
<td>In Checklist Clone, add option to use new description for new prompt</td>
</tr>
<tr>
<td>30934</td>
<td>Show what folder an item belongs to - Concerns and Parts</td>
</tr>
<tr>
<td>33150</td>
<td>Display multiple reference documents in VDC</td>
</tr>
<tr>
<td>33399</td>
<td>Reload defects option in DC</td>
</tr>
<tr>
<td>33736</td>
<td>Reduce steps when importing setups and characteristics</td>
</tr>
<tr>
<td>34163</td>
<td>Limit number of characters that can be entered in any Collector Comment field</td>
</tr>
<tr>
<td>34373</td>
<td>Create Concern Grid report with &quot;show grid&quot; parameter</td>
</tr>
<tr>
<td>34374</td>
<td>Extend Characteristics code to at least 42 characters</td>
</tr>
<tr>
<td>34420</td>
<td>Add option to import cause/action relationship (like we have for product groups and products)</td>
</tr>
<tr>
<td>34530</td>
<td>Add picture (image) to checklist questions, not to defect or repair</td>
</tr>
<tr>
<td>34549</td>
<td>Link documents to products</td>
</tr>
<tr>
<td>35674</td>
<td>Add &quot;select all&quot; to Violation part of Setup Characteristic</td>
</tr>
<tr>
<td>35777</td>
<td>Enable violations for boolean characteristics</td>
</tr>
<tr>
<td>35778</td>
<td>Violation enhancements</td>
</tr>
<tr>
<td>36107</td>
<td>Allow multiple causes and actions to be chosen sequentially when validation fails</td>
</tr>
<tr>
<td>37620</td>
<td>When loading images from disk not all should be selected by default</td>
</tr>
<tr>
<td>39725</td>
<td>Need new &quot;On Commit&quot; option to end current inspection</td>
</tr>
</tbody>
</table>