

**ShopFloorManager Tech Notes**  
**"Managing DNC Files": The Right Document & File at the Right Time** [PDF Version](#)  
**Managing, Controlling & Approving all of your DNC Files, Machine Tools, File Cabinets...**  
**Supports Windows 7, Windows XP & Windows XP including Support for Terminal Server 2003/2005/2008**

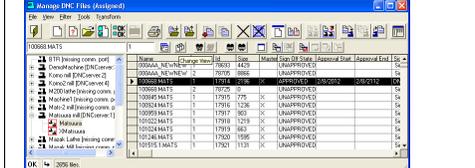
ShopDNC is part of ShopFloorManager's Enterprise Management System's Suite of Secure Integrated Manufacturing Software Applications built upon CAD/CAM Integrator's Standard and Optional Modules. These Modules include EventAware Technologies which Continually Listen & Capture all Events for processing so Manufacturing Users and Applications can be kept in Sync!

ShopDNC provides a full DNC Management User Interface: machine tool configuration, a complete protocol generator, serial, UNC & FTP communications, remote issuer generator, simple ISO/ISO00 Document Control, simple user custom reports, intelligent charts, visualization, management tools, Database Management, Virtual File Cabinets, File & History Archiving and any number of upgrade options.

**Manage DNC Files: Using Manage DNC File for Managing all of your Manufacturing DNC Files**



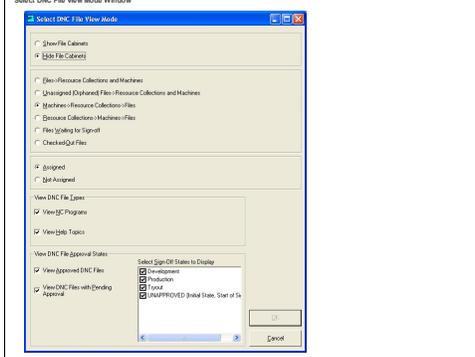
**Note:** Click on the "Manage DNC Files" button to bring the Window that is used to Manage your DNC File for Assigning to Resource Collections, Machine Tools, Approving Files for Production, Editing Files, Copying, etc. This Window is used for 90% of the dealings you will have with DNC Files.



**Note:** The Above Window is but one of many Data Relationship Views that exist between Resource Collections, Machine Tools, File Cabinets, DNC Files, etc. These Views allow you to establish the Data Relationships that best aid you in performing your DNC Management Functions.

You will notice that several of the icons in the above View are grayed out indicating that the Resources selected along with present System "State" will not logically allow you access the Functions associated with these icons. The conditions for activating these will be explained in this Guide.  
 We will be discussing what Function/Failure is activated for each of the icons on the "Manage DNC Files" Window in the order that they are displayed as we go through this Guide. This is an important Feature that we will briefly cover before continuing and that is how we chose the View with which we are working.

Click on the "Change View" icon and the Following Window will be displayed.



**Note:** The above View Window is used to select the particular Data Relationship Views that best aid you in doing your particular Function.

**Important!** In the following Guide we have displayed the "Viewing Options" that are used for each View Displayed. Please feel free to change these to fit your particular requirements.

**Standard:**

**SubFactory Runtime - Close**

**Viewing Options:**

- Show File Cabinet
- Machine-Resource Collections+File
- Assigned
- View File
- View File Programs
- View File Topics
- View DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files**

**Close Icon**

**SubFactory Runtime - New File Cabinet**

**Viewing Options:**

- Show File Cabinet
- Machine-Resource Collections+File
- Assigned
- View File
- View File Programs
- View File Topics
- View DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files**

**New File Cabinet Icon**

Select where you want the New File Cabinet appear as a Sub-File Cabinet and Click on the "New File Cabinet" icon and the Following window is displayed:

**"New File Cabinet" Window**

**Note:** Choose a File Cabinet Name to reflect on the DNC Files or other documents you will be storing in this File Cabinet of "NC Files".

Whenever File Cabinet you have highlighted when you create a New File Cabinet it will become a Sub-File Cabinet to the Highlighted File Cabinet. You can drag it from File Cabinet to it to stay more than amount.

**Important!** For more details on File Cabinets see "Creating File Cabinets" in another Guide.

**SubFactory Runtime - Delete File Cabinet**

**Viewing Options:**

- Show File Cabinet
- Machine-Resource Collections+File
- Assigned
- View File
- View File Programs
- View File Topics
- View DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files**

**Delete File Cabinet Icon**



**Create Help Topic**

To create a new Help Topic, select a Topic Type, select the target Machine Tool Connection, type the Topic Name, and click OK.

Topic Type

- Specific Topic for a Selected Machine (Explains the Generic Topic, but has the same Topic Name)
- Default Topic for Selected Machine
- Generic Topic for Any Machine

Target Machine:  Topic Name:

OK Cancel

**Types of Help Files:**

- Specific Help Topic for Specific Machine Tool (from the CNC web for Specific Help Topics and it will be sent)
- Default Help Topic for Specific Machine Tool (from the CNC web for Help and the Default Help Topic will be sent)
- Generic Help Topic for Any Machine Tool (from the CNC web for Any Help Topic and it will be sent)

**Note:** ShopFloorManager allows you to create "Help Files" that can be remotely requested from any Modern Machine Tool that supports Connections in DNC Files. After selecting the publication option from above, CCA Editor will be opened where you type the "Help File" or copy it from existing Documents!

**Definition:** A "Help File" is a text based document that can be used for example, describe how to Use a Fixture, OSHA regulations, Probe Controls for drill etc. It is optional to use PC and needs registration on a particular Subject ShopFloorManager's "Help File" can be requested from the CNC at anytime of day or night. See the Description!

**ShopFloor Runtime - Edit Existing DNC File**

Viewing Options:

- Hide File Details
- Machine-Resource Collections=Files
- Assigned
- View CNC File
- View Help Files
- View Agreement DNC File
- View CNC Files with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files (As/Updated)**

File Name	Version	Created	Modified	Status	Approved Date
100000.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100001.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100002.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100003.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100004.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100005.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100006.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100007.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100008.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100009.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100010.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100011.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100012.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100013.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100014.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100015.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100016.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100017.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100018.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100019.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100020.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	

OK Cancel

**Edit Existing DNC File Window**

**ShopFloor M: Editor**

```

G01 X100 Y100 Z100 F1000
G02 X150 Y150 Z150 R50 F1000
G03 X200 Y200 Z200 R75 F1000
G04 X250 Y250 Z250 P1000
G05 X300 Y300 Z300 P1500
G06 X350 Y350 Z350 P2000
G07 X400 Y400 Z400 P2500
G08 X450 Y450 Z450 P3000
G09 X500 Y500 Z500 P3500
G10 X550 Y550 Z550 P4000
G11 X600 Y600 Z600 P4500
G12 X650 Y650 Z650 P5000
G13 X700 Y700 Z700 P5500
G14 X750 Y750 Z750 P6000
G15 X800 Y800 Z800 P6500
G16 X850 Y850 Z850 P7000
G17 X900 Y900 Z900 P7500
G18 X950 Y950 Z950 P8000
G19 X1000 Y1000 Z1000 P8500
G20 X1050 Y1050 Z1050 P9000
G21 X1100 Y1100 Z1100 P9500
G22 X1150 Y1150 Z1150 P10000
G23 X1200 Y1200 Z1200 P10500
G24 X1250 Y1250 Z1250 P11000
G25 X1300 Y1300 Z1300 P11500
G26 X1350 Y1350 Z1350 P12000
G27 X1400 Y1400 Z1400 P12500
G28 X1450 Y1450 Z1450 P13000
G29 X1500 Y1500 Z1500 P13500
G30 X1550 Y1550 Z1550 P14000
G31 X1600 Y1600 Z1600 P14500
G32 X1650 Y1650 Z1650 P15000
G33 X1700 Y1700 Z1700 P15500
G34 X1750 Y1750 Z1750 P16000
G35 X1800 Y1800 Z1800 P16500
G36 X1850 Y1850 Z1850 P17000
G37 X1900 Y1900 Z1900 P17500
G38 X1950 Y1950 Z1950 P18000
G39 X2000 Y2000 Z2000 P18500
G40 X2050 Y2050 Z2050 P19000
G41 X2100 Y2100 Z2100 P19500
G42 X2150 Y2150 Z2150 P20000
G43 X2200 Y2200 Z2200 P20500
G44 X2250 Y2250 Z2250 P21000
G45 X2300 Y2300 Z2300 P21500
G46 X2350 Y2350 Z2350 P22000
G47 X2400 Y2400 Z2400 P22500
G48 X2450 Y2450 Z2450 P23000
G49 X2500 Y2500 Z2500 P23500
G50 X2550 Y2550 Z2550 P24000
G51 X2600 Y2600 Z2600 P24500
G52 X2650 Y2650 Z2650 P25000
G53 X2700 Y2700 Z2700 P25500
G54 X2750 Y2750 Z2750 P26000
G55 X2800 Y2800 Z2800 P26500
G56 X2850 Y2850 Z2850 P27000
G57 X2900 Y2900 Z2900 P27500
G58 X2950 Y2950 Z2950 P28000
G59 X3000 Y3000 Z3000 P28500
G60 X3050 Y3050 Z3050 P29000
G61 X3100 Y3100 Z3100 P29500
G62 X3150 Y3150 Z3150 P30000
G63 X3200 Y3200 Z3200 P30500
G64 X3250 Y3250 Z3250 P31000
G65 X3300 Y3300 Z3300 P31500
G66 X3350 Y3350 Z3350 P32000
G67 X3400 Y3400 Z3400 P32500
G68 X3450 Y3450 Z3450 P33000
G69 X3500 Y3500 Z3500 P33500
G70 X3550 Y3550 Z3550 P34000
G71 X3600 Y3600 Z3600 P34500
G72 X3650 Y3650 Z3650 P35000
G73 X3700 Y3700 Z3700 P35500
G74 X3750 Y3750 Z3750 P36000
G75 X3800 Y3800 Z3800 P36500
G76 X3850 Y3850 Z3850 P37000
G77 X3900 Y3900 Z3900 P37500
G78 X3950 Y3950 Z3950 P38000
G79 X4000 Y4000 Z4000 P38500
G80 X4050 Y4050 Z4050 P39000
G81 X4100 Y4100 Z4100 P39500
G82 X4150 Y4150 Z4150 P40000
G83 X4200 Y4200 Z4200 P40500
G84 X4250 Y4250 Z4250 P41000
G85 X4300 Y4300 Z4300 P41500
G86 X4350 Y4350 Z4350 P42000
G87 X4400 Y4400 Z4400 P42500
G88 X4450 Y4450 Z4450 P43000
G89 X4500 Y4500 Z4500 P43500
G90 X4550 Y4550 Z4550 P44000
G91 X4600 Y4600 Z4600 P44500
G92 X4650 Y4650 Z4650 P45000
G93 X4700 Y4700 Z4700 P45500
G94 X4750 Y4750 Z4750 P46000
G95 X4800 Y4800 Z4800 P46500
G96 X4850 Y4850 Z4850 P47000
G97 X4900 Y4900 Z4900 P47500
G98 X4950 Y4950 Z4950 P48000
G99 X5000 Y5000 Z5000 P48500
M02

```

DNC Name: 2/2/2012 12:48 PM

OK Cancel

**ShopFloor Editor Features:**

- Requires Machine Files being Downloaded at the Same Time while still supporting 020000 Controls for each File
- Printing of File Content with Multiple Options
- Cut, Copy, Paste
- The sequencing of Line Numbers with complete control of Line number Size on sequencing
- Mirroring of any number Axis
- Scaling of any number Axis
- Translation of any number of Axis
- Mirror Capability

**Note:** For more information on using ShopFloorManager's ShopFloor Editor visit our Website: <http://www.shopfloormanager.com> and go to the "Downloads" Menu and click on the "Tooling Guide"!

**ShopFloor Runtime - Properties**

Viewing Options:

- Hide File Details
- Machine-Resource Collections=Files
- Assigned
- View CNC File
- View Help Files
- View Agreement DNC File
- View CNC Files with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files (As/Updated)**

File Name	Version	Created	Modified	Status	Approved Date
100000.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100001.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100002.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100003.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100004.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100005.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100006.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100007.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100008.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100009.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100010.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100011.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100012.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100013.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100014.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100015.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100016.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100017.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100018.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100019.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	
100020.MAT5	1	2008/01/15	2008/01/15	UNAPPROVED	

OK Cancel

**Properties Window**

**Properties**

100000.MAT5  
Version: 1

Master File

File Type:

- G-Program
- Help File

Status:

- Available for Sending to a Machine Tool
- Not Available for Sending to a Machine Tool

File Name:

OK Cancel

**Note:** ShopFloorManager allows you to change an individual File's Properties which affects how Third-Party Applications deals with them.

**Important:** Different DNC File Types will be handled differently by Third-Party Applications regarding Windows Associated File Extensions and ShopFloorManager's Search Engine just to mention a Few!

**Properties:**

- Master File - Check this Check-box if you want this File to have Master Status. (Requires More Rights to Modify)
- File Type -
  - G-Program - Needs to be the type for Downloading to a Machine Tool in DNC Format
  - Help File - See Above for more details on Help Files
- Status -
  - Available for Sending to a Machine Tool
  - Not Available for Sending to a Machine Tool (Requires More Rights to Download & Upload - This would restrict an Operator's income)
- Enter "File Type" Used on Windows can associate a Particular File Extension with Third-Party Applications.

**ShopFloor Runtime - Edit Approval & Sign-off**

Viewing Options:

- Hide File Details
- Machine-Resource Collections=Files
- Assigned
- View CNC File
- View Help Files
- View Agreement DNC File
- View CNC Files with Pending Approval

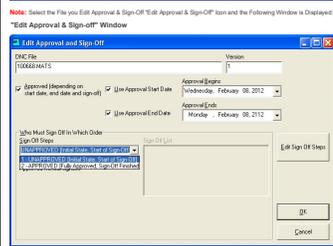
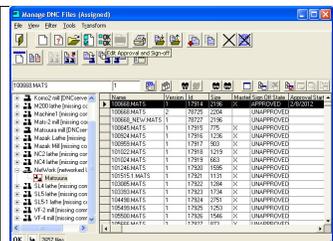
**Note:** Click to Change View!

**Manage DNC Files**

**Edit Approval**

**and**

**Sign-off Icon**



Note: Select the File you Edit Approval & Sign-Off. The Approval & Sign-Off icon and the Following Window is Displayed.

The Following Shows the Lower Left Corner of This "Manage DNC File" Window

Viewing Options:

- Hide File Cabinets
- Machine-Resource Collections+Files
- Assigned
- View DNC Files
- View Approved DNC Files
- View DNC Files with Pending Approval

Note: Click to Change View

Note: ShopToolManager provides an ISO6000 Module for creating your own Sign-Off and Approval Forms and Flow Charts for securely managing & controlling all of your Files, Documents & Packets. For details please look for Creating Sign-Off Approvals on our Website: <http://www.shopmanager.com>

Note: ShopToolManager supports Approval & Sign-Off for all of its DNC Files, Documents & Packets. If configured, ShopToolManager supports two States: Approved & Unapproved. You can setup a simple Sign-Off & Approval and chosen from ShopToolManager Users which will establish an ISO6000 File Control System. If you need a more sophisticated infrastructure you can create your own Sign-Off & Approval Lists with Sign-Off Flow Charts to meet any Manufacturer's needs.

Click on the "OK Button" icon and the Following Window is Displayed:

Note: This Window displays the DNC Files, Documents & Packets that This User has waiting to be Signed-Off for Approval. Clicking on a particular Category(DNC File Above) will Automatically Change the View to Files Waiting For Sign-Off.

See "Select DNC File View Model" Above for Details.

Click on the "Sign-Off DNC File" icon and the Following Window is Displayed:

Viewing Options:

- Hide File Cabinets
- Files Waiting for Sign-Off
- Assigned
- View DNC Files
- View Approved DNC Files
- View DNC Files with Pending Approval

Note: Click to Change View

Note: Clicking on the "OK" Button will Sign-Off & Approve This File so it can move to the next Approval Step. If you have created your own Sign-Off & Approval Forms & Flow Charts. If you are using the default Sign-Off & Approval list File has Final Approval State which allows it for Production.

Once Approved this File will no longer be displayed in this View since it is now Approved. After leaving this Window you will need to hit a View Option other than "Files Waiting for Sign-Off".

Click on the icon to "Select DNC File View Model" Window where you can choose the View Options you want.

ShopFactory Runtime - Print

Viewing Options:

- Hide File Cabinets
- Machine-Resource Collections+Files
- Assigned
- View DNC Files
- View Approved DNC Files
- View DNC Files with Pending Approval

Note: Click to Change View

Note: Select the File you want to Print and Click on the "Print" icon and the Following Window is Displayed:

Options:

- All - Prints the whole File(Be careful that the File isn't very large)
- Select Text - Only active if you have opened the File by clicking on the "View" icon.

File Viewer

Print What:  Show Word  Show Code

Print Range:  All  From:  To:

In the Viewer Window you can Highlight the Lines you want to send to the Printer and click on the Print Button

- **Beginning**
  - Pages - Enter the number of Pages to Print
  - Lines - Enter the number of Lines to Print
- **Reading Only** - This is setup from the Product/Resource Runtime Tool Menu "Tool/Print" and Sub Menu "General System Configuration" - See Configuring the Database Guide for more details

**SelfFactory Runtime - Import DNC Files**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- View NC Files
- View Tool Files
- View Approved DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View!

**Note:** Click on the "Import" icon and the Following Explorer Window is Displayed:

**"Import" Window**

**Note:** Before Browsing to the DNC File you want to Import make sure you have selected/highlighted the correct Resource Collection(s) the Example is (Machines) to which you want to Import the File.

Now browse to the File(s) you want to Import and select one or multiple Files and click on the Open Button and the following Window will be displayed:

**Setting Import Options for Each File:**

**Note:** Chose an Option for all or each of the files and Click OK Button. Continue until complete.

**SelfFactory Runtime - Copy To Folder**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- View NC Files
- View Tool Files
- View Approved DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View!

**Note:** Select the File you want to Export to a Folder and click on the "Copy to a Folder" icon and the Following Window is Displayed:

**"Copy to Folder" Window**

**Note:** After Selecting/Highlighting the File you want to Export you can Browse to the Folder where you want Copy the File or can select from the different Paths displayed above in the various Tables.

Copying the File to an External Folder doesn't delete or change the status of the Exported File

**SelfFactory Runtime - Copy & Assign Window**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- View NC Files
- View Tool Files
- View Approved DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View!

**Note:** Select the File you want to Copy and Assign to Resource Collection(s) and click on the "Copy and Assign" icon and the Following Window will be Displayed:

**"Copy & Assign" Window**

**SelfFactory Runtime - Copy & Assign Window**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- View NC Files
- View Tool Files
- View Approved DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View!

**Note:** Select the File you want to Copy and Assign to Resource Collection(s) and click on the "Copy and Assign" icon and the Following Window will be Displayed:

**"Copy & Assign" Window**

Manage DNC Files

Import Icon

Manage DNC Files

Copy to a Folder Icon

Manage DNC Files

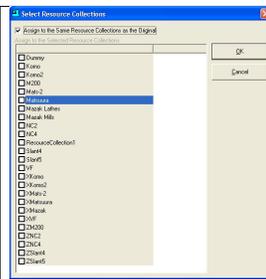
Copy & Assign Icon

Manage DNC Files

Copy & Assign Icon

Manage DNC Files

Copy & Assign Icon



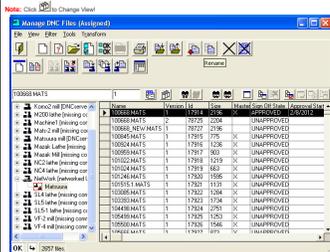
**Note:** You can select which Resource Collections you want the copied File to be assigned to by checking the appropriate Checkboxes.

After making the selections click the OK Button and the following Window will be displayed:

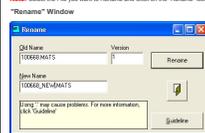


**Note:** Enter a New Name (Click on the Customise button for Help) or leave the same as it is. If you leave the name the same and the System is set for multiple versions a new version number will be generated for this File.

Click the Copy and Assign Button to complete the operation or the Close icon to cancel.

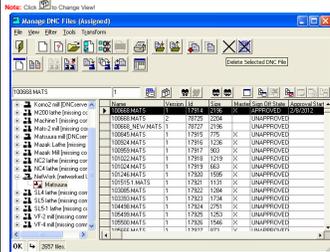
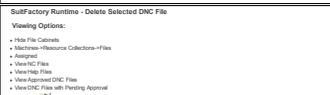


**Note:** Select the File you want to Rename and Click on the "Rename" icon and the Following Window is Displayed:

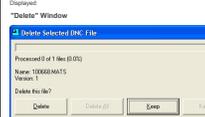


**Note:** Enter a New Name and if you need help with the name click on the Guideline Button.

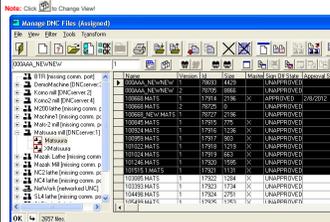
Click the Rename Button to complete the operation or the Close icon to cancel.



**Note:** Select the File you want to Delete and Click on the "Delete Selected DNC File" icon and the Following Window is Displayed:



**Note:** Click the Delete Button to complete the operation or the Keep Button to cancel.



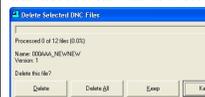
**Note:** Click on the icon to "Select DNC File View Mode" Module for Options to narrow your Search.

Click on the icon to use the Search Engine to narrow your Search.

Hold the Ctrl Key when selecting Specific File(s) after First using File Selection Options 1 & 2 Above)

**Note:** You can combine the Options above to narrow down the File Selection.

Select Files & click the "Delete All Listed Files" icon & the Following Window is Displayed:



**Note:** Caution Make sure you have selected only those Files you want to delete on mass! Once this operation is complete all of the Files will be deleted from ShopFloorManager's main database and placed in the archived database. Trying to restore a large number of Files from the archived database can be Tedious.

To continue using a File by File Mode Click the Delete, Keep or Keep All Button or click the Delete All Button.

Manage DNC Files

Rename Icon

Manage DNC Files

Delete Icon

Manage DNC Files

Delete All Listed Files

Icon

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- Machine File
- Machine File
- View/Apply Files
- View/Assign/DNC File
- View/DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files**

**View Icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- Machine File
- Machine File
- View/Apply Files
- View/Assign/DNC File
- View/DNC File with Pending Approval

**Note:** Click to Change View!

**Select File 1 to Compare:**

**Note:** Choose the First File you want to Compare and click . The selected File is displayed in the Status Line at the Bottom of the Window. You will also notice that the Compare icon is grayed indicating you can't choose this File again!

**Select File 2 to Compare:**

**Note:** Choose the Second File you want to Compare and click and the Compare Application will be displayed!

**The Compare Application:**

**Note:** See the Legend at the Lower Right Corner of the Window for understanding what changed. If you have a Third-Party Application that you would prefer to use you can access that by using ShopFloorManager's Third-Party Tools. See Create Third-Party Tools Guide on our website.

**Select a File & Resource Collection and click on the "Assign" icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- Machine File
- Machine File
- View/Apply Files
- View/Assign/DNC File
- View/DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files Window**

**Assign Icon**

**Note:** Select a File & Resource Collection as shown above and click on the Assign icon. The File is Assigned to the Resource Collection that you highlighted and will be removed from this View since the View you are in now is "Not Assigned". You will need to change the View Option to Assigned. The File has not deleted.

**Select a Resource Collection & File and click on the "Clear Assignment" icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections-Files
- Assigned
- Machine File
- Machine File
- View/Apply Files
- View/Assign/DNC File
- View/DNC File with Pending Approval

**Note:** Click to Change View!

**Manage DNC Files Window**

**Clear Assignment Icon**

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

Name	Version	File	Machine	File Size	Assigned
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		

OK [2007] Yes

**Note:** Select a Resource Collection & File as shown above and click on the Clear Assignment Icon. The File Assignment to the Selected Resource Collection that you highlighted is Cleared. You will see that the Selected DNC File has been removed from the View area the User area in the "Assign" and the status of the DNC File is Unassigned regarding the Resource Collection. The File has not deleted.

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

**Select a Machine Tool or Resource Collection and click on the "Send" Icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections of Files
- Assigned
- View CNC Files
- View Map Files
- View Assigned DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View

**Manage DNC Files Window**

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

Name	Version	File	Machine	File Size	Assigned
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		

OK [2007] Yes

**Note:** The effects of choosing a Resource Collection vs. a Machine Tool are as follows. If you choose a Machine Tool all of the Files in it of its associated Resource Collection will be displayed. If you just select a Resource Collection only that Resource Collection's DNC Files will be displayed.

Click on the Send Icon and the Selected File will be downloaded.

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

**Select a Networked CNC or associated Resource Collection & click "Send All Listed..." Icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections of Files
- Assigned
- View CNC Files
- View Map Files
- View Assigned DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View

**Manage DNC Files Window**

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

Name	Version	File	Machine	File Size	Assigned
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		

OK [2007] Yes

**Caution:** Make sure you have selected only those Files you want to send an mass!

**File Selection Options**

- Click on the to "Select DNC File View Mode" Module for Options to narrow your Search
- Click on the to use the Search Engine to narrow your Search
- Hold the Ctrl Key when selecting Specific Function after First using File Selection Options 1 & 2 Above

**Note:** You can combine the Options above to narrow down the File Selection.

**Note:** Click on the Send All Listed DNC File Icon and all of the Listed DNC Files will be downloaded to the Networked CNC (Ethernet or FTP based Controller).

Click on the Send icon to "Select DNC File View Mode" Module for Options to narrow your Search

Hold the Ctrl Key when selecting Specific Function after First using File Selection Options 1 & 2 Above

Note: You can combine the Options above to narrow down the File Selection.

Note: Click on the Send All Listed DNC File Icon and all of the Listed DNC Files will be downloaded to the Networked CNC (Ethernet or FTP based Controller).

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

**Select a Machine Tool or Resource Collection and click the "Receive" Icon**

**Viewing Options:**

- Hide File Cabinets
- Machine-Resource Collections of Files
- Assigned
- View CNC Files
- View Map Files
- View Assigned DNC Files
- View DNC Files with Pending Approval

**Note:** Click to Change View

**Manage DNC Files Window**

**Manage DNC Files (Assigned)**

File View Edit Look (Assign)

100000 MATS

Name	Version	File	Machine	File Size	Assigned
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		
100000_MATS	1	17916	UNAPPROVED		
100000_MATS	2	78702	UNAPPROVED		

OK [2007] Yes

**Note:** You can select an existing DNC File or enter a new DNC File Name in the Text Box. Example Above "NEW\_CNC.DNC". If you select an Existing DNC File and your System has been configured for Multiple Version the next version of the Selected DNC File will be created. If your System has been configured for Single Version the Selected DNC File will be overwritten & Version incremented and the old DNC File will be archived.

The effects of choosing a Resource Collection vs. a Machine Tool are as follows. If you choose a Machine Tool every Resource Collection associated with this Machine Tool will have the Selected DNC File Assigned to it. If you just select a Resource Collection only that Resource Collection will have the DNC File assigned to it.

Note: You can select an existing DNC File or enter a new DNC File Name in the Text Box. Example Above "NEW\_CNC.DNC". If you select an Existing DNC File and your System has been configured for Multiple Version the next version of the Selected DNC File will be created. If your System has been configured for Single Version the Selected DNC File will be overwritten & Version incremented and the old DNC File will be archived.

The effects of choosing a Resource Collection vs. a Machine Tool are as follows. If you choose a Machine Tool every Resource Collection associated with this Machine Tool will have the Selected DNC File Assigned to it. If you just select a Resource Collection only that Resource Collection will have the DNC File assigned to it.