



QMSOFT® Manual - Upgrade to Version 8

Release 8.1

**L&W Gesellschaft für Fertigungsmesstechnik
und Qualitätssicherung mbH**

Jun 12, 2025

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CHAPTER 1

Introduction

This manual should help you to upgrade an existing installation of the QMSOFT® gauge management software (version 3 up to version 7) to the actual version 8 of QMSOFT®. If you have to upgrade an older version than version 3 please contact the developer team of the L&W GmbH in the case, that you want to take over database contents from the Paradox databases (DOS, 16-bit-Windows) into the actual SQL database of QMSOFT®.

Note

Coming from version 6 or 7, the steps described in section *Import of local settings (version 5 and older)* are obsolete.

Please read this document carefully to avoid errors and additional effort!

Warning

Be sure while the whole QMSOFT® upgrade process, that no other user is logged in into a QMSOFT®-instance, which is using the same QMSOFT® database!

The QMSOFT® upgrade process is separated into the following steps:

- Refresh of the license data;
- Update - if required - the Firebird SQL server and of the binary format of the database files (not necessary when using Microsoft SQL database)
- Update-Installation of QMSOFT®
- Refresh of the database content (internal database structure, Import of local settings of the computer)

The following chapters describe these steps in more detail. If you need further assistance, you will find a prepared form for faxing a support request in the QMSOFT®/GaugeMan program under the menu item *Help → Support Sheet*. Please use the following contact information:

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01217 Dresden
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Website: www.lw-gmbh.com

Please also consider submitting your own contact information, so we can reach you quickly, and please try to understand, that we can not respond immediately to any inquiry in exceptional cases, we always try to hold our response times as short as possible.

QMSOFT® - How to add additional licenses

2.1 License Update on Client

In the QMSOFT® version 4 (and later) the activation of additional software licenses will be done by an import of a new “CodeMeter® license file”. “CodeMeter® stick” is the product name of the used dongle for the software protection.

The license file to update an existing license is called “Remote license update file”. Such a file will have the file extension .LwRemUpd. The file name itself is the serial number of the existing CodeMeter® stick.

Note

To initiate a license update for an existing CodeMeter® stick, you should make sure that this CodeMeter® stick is plugged into the local computer on which you will perform the next actions. It is not possible to update the license if the CodeMeter® stick is placed somewhere else in the network.

To execute a remote license update please do the following:

- 1) Open the QMSOFT® registration centre as shown in the figure [Fig. 2.1.1]

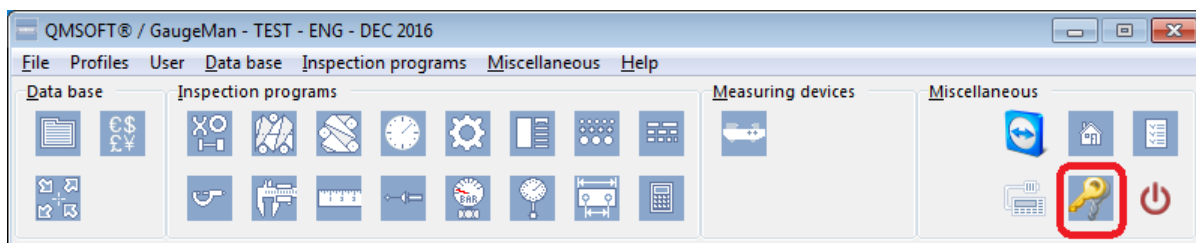


Fig. 2.1.1: QMSOFT® startup window (GaugeMan) - Opening “Registration of QMSOFT® modules”.

- 2) Load the “Remote update file”

You will now get a screen showing your existing licenses.

Click the button “Load remote update file..” (see “Step 1”) in the figure and “Open” the file in the next dialogue (see “Step 2”) [Fig. 2.1.2]

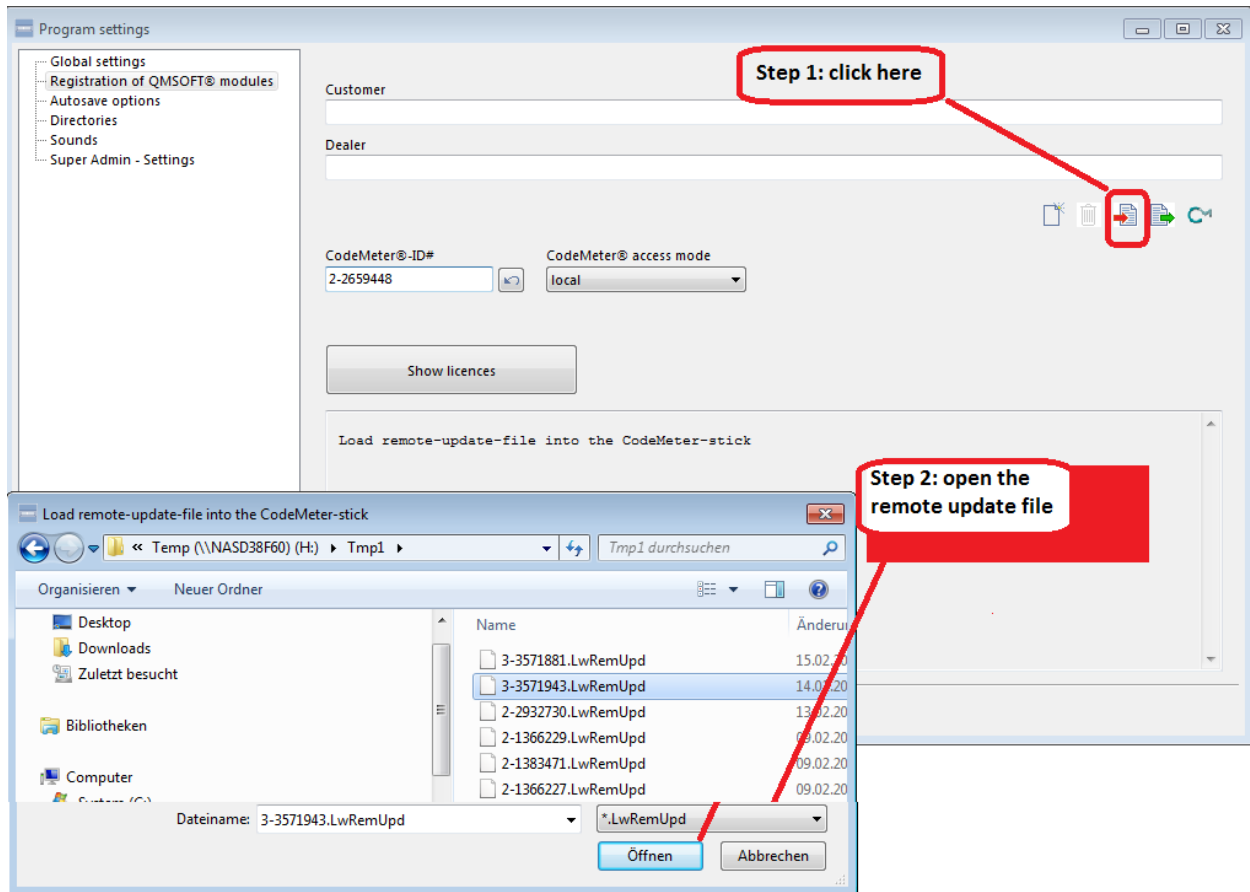


Fig. 2.1.2: Programsettings → Module registration → Import.

After loading the “Remote Update File” close the license dialogue by clicking the “OK”-button. From this point of time the changed license volume can be used.

2.2 License Update on Server

Requirement:

CodeMeter® is installed on a server without QMSOFT® installation.

Implementation:

In this case, you can use the so-called QMSOFT®-QMLicenseUpdater. This program can be run without installation directly on the computer that has access to the CodeMeter® stick.

The program can be downloaded directly from the L&W GmbH website:

Download:

<https://download.lw-gmbh.com/tools/QMLicenseUpdater/QMLicenseUpdater.exe>

After starting the program you will see the following screen [Fig. 2.2.1].

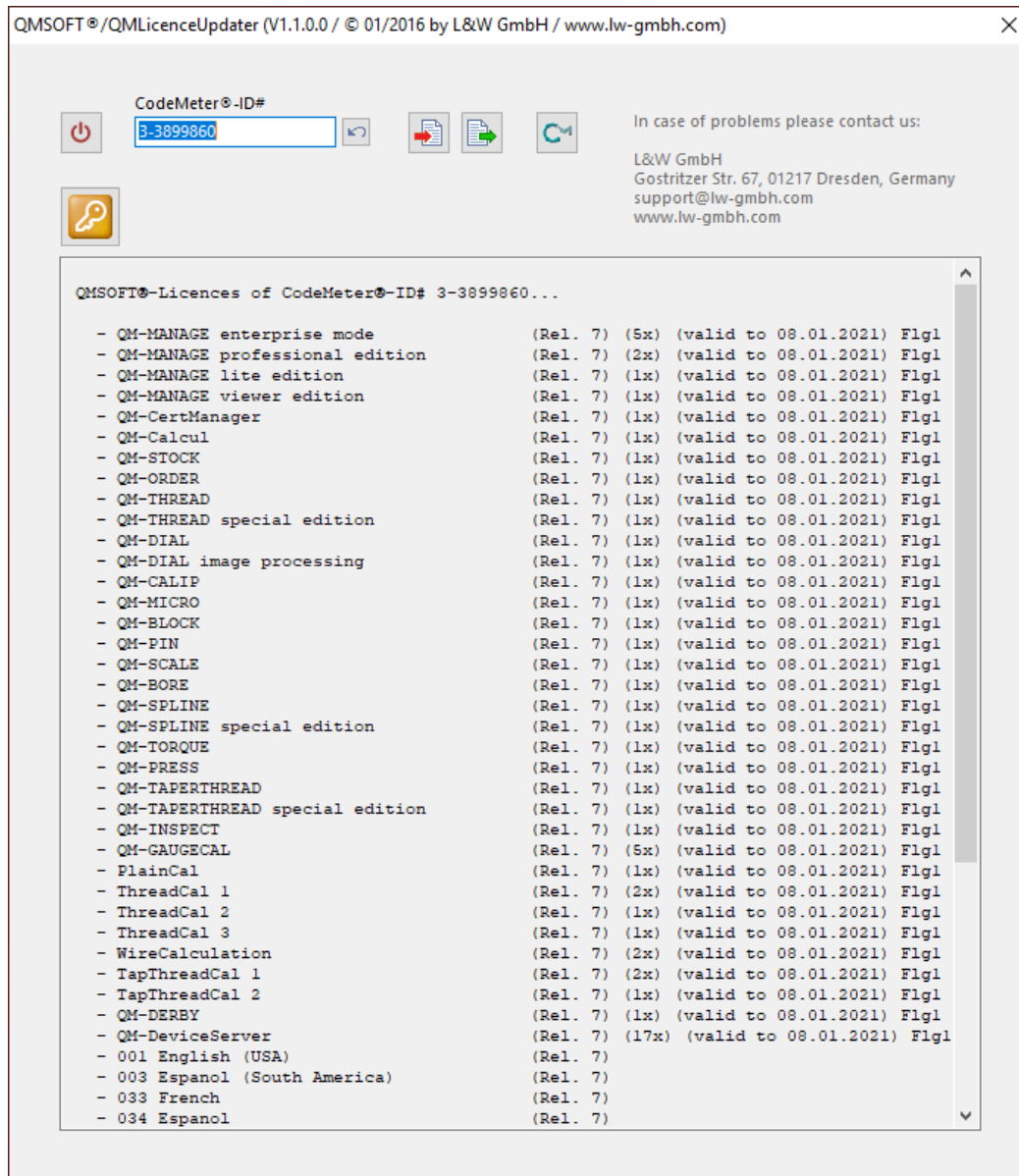


Fig. 2.2.1: QMSOFT®-QMLicenseUpdater.

The file can then be read as described under “*License Update on Client*”.

Updating the Firebird SQL Server

This step is necessary if the old QMSOFT® installation used an “older” Firebird SQL Server (QMSOFT® versions 3 to 6). To work with QMSOFT® version 8, the Firebird SQL Server must be at least version 2.5 (version 3.0 or 4.0 can also be used).

Note

If you are using an MS SQL database server OR your Firebird SQL Server is already version 2.5, you can skip this step!

Note

When using an MS SQL database, it is necessary to install a current ODBC driver on the local computer. We recommend using the ODBC driver 17 (here is the download link: <https://go.microsoft.com/fwlink/?linkid=2223304>).

If you are not sure which database server is actually connected (SQL server type, server computer), you can find out this information using the QMSOFT® database configuration tool “Configurator32”. You can find this under the menu item *Settings* → *Configure database connection*.

You can find out the Firebird version number using the MS Windows Control Panel: To do this, start the “Firebird Server Manager”, which will show you the version number.

Warning

Even if you are not working with the QMSOFT®/QM-MANAGE program, please check whether an older Firebird installation is available. Please remove it if you don’t need it for other applications. Make sure that the Firebird SQL Server is used exclusively with QMSOFT®, otherwise the update may affect other software outside the QMSOFT® system. If in doubt, please contact the manufacturer of this software to clarify compatibility issues in advance!

Warning

Please make a backup of all existing database files before updating the database server; see next chapter *Backup of databases!*

Here is a quick summary of the steps to upgrade the Firebird database server (please read this chapter to the end before you start):

- please first perform a “backup” of all existing QMSOFT® database files (system database, measuring device databases) with the existing Firebird instance (use either the menu functions of the previous QMSOFT® installation or the “old” Firebird backup tool gbak or the BackupRestore tool from L&W GmbH),
- now uninstall the old Firebird version and remove all “Firebird” directories from the program directory of your computer,
- install the current Firebird version 2.5 or later
- restore all your previously backed-up database files while running the new Firebird version (gbak or BackupRestore tool).

The following sections explain these steps in more detail.

3.1 Backup of databases

Please make a backup of all existing database files before updating the database server. As an alternative to the menu functions of the old QMSOFT® installation for backup or to Firebird’s own gbak program with its rather complicated parameter syntax, you can perform the backup (and restore) operations with the BackupRestore tool provided by L&W GmbH.

Note

This tool can be found on the QMSOFT® DVD-ROM in the folder Additional/BackupRestore.

Copy the program file “BackupRestore.exe” from the QMSOFT® DVD-ROM to a folder on the computer running Firebird SQL Server. This program file can be executed directly without any installation. You will get the following form [Fig. 3.1.1]:

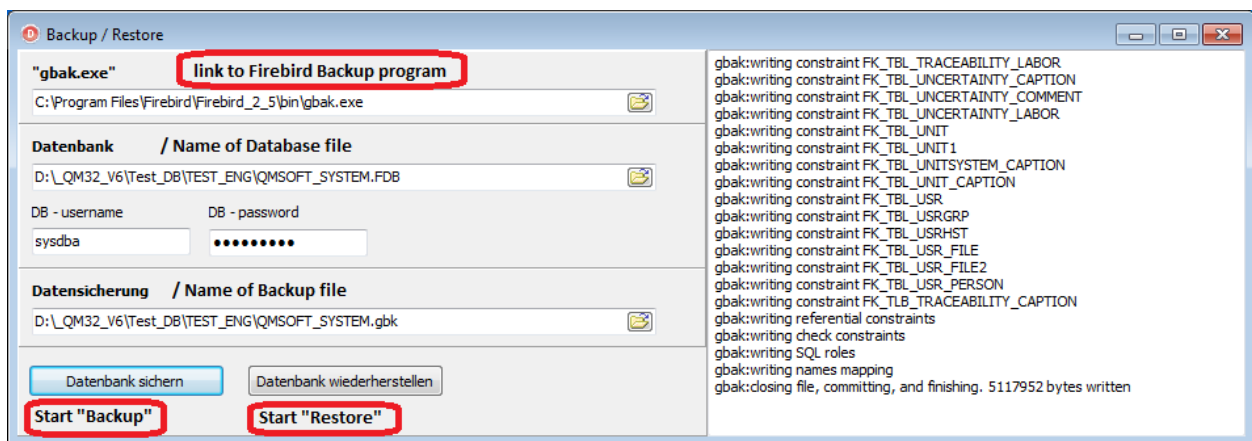


Fig. 3.1.1: “BackupRestore” tool, see QMSOFT® DVD-ROM.

Please enter the full name and path of the Firebird backup tool “gbak” before starting the backup. Enter the name of the database file and the backup file and perform the backup. Repeat this process for all existing database files (be sure to change both file names!).

3.1.1 Alternative Backup instructions when updating from QMSOFT® version 4 or version 5

In many cases, updating these versions requires changing the PC. In this case, you can use the QMSOFT® internal functions.

The steps to do are:

- 1) Launch the database configuration tool and verify that the settings for the Firebird backup tool gbak are correct [Fig. 3.1.2].



Fig. 3.1.2: QMSOFT® database configuration tool.

Go to *Settings* → *Program Settings* and configure the Firebird backup tool gbak [Fig. 3.1.3].

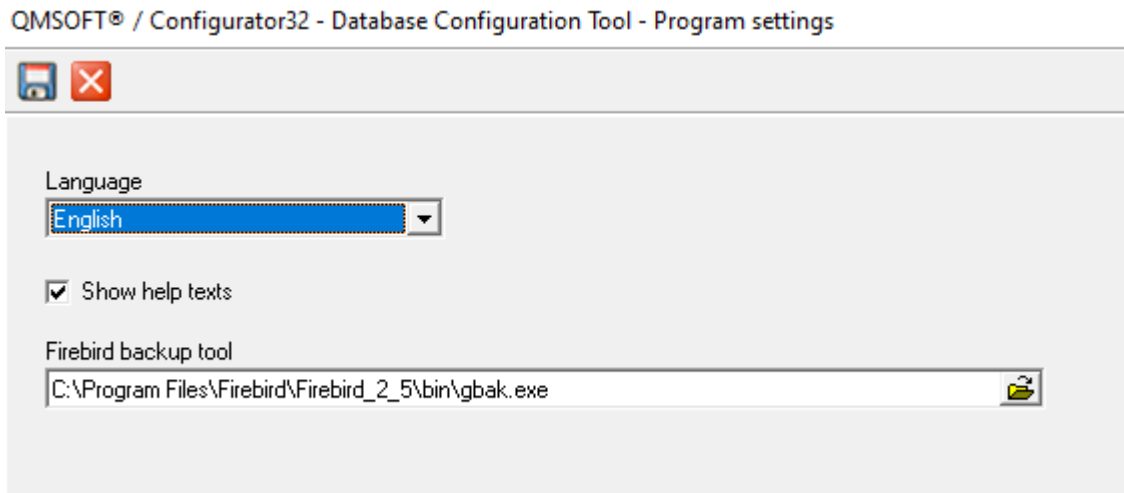


Fig. 3.1.3: QMSOFT® database configuration tool.

- 2) Go to the *Database Management* menu and start the *Backup SYSTEM database* function [Fig. 3.1.4].

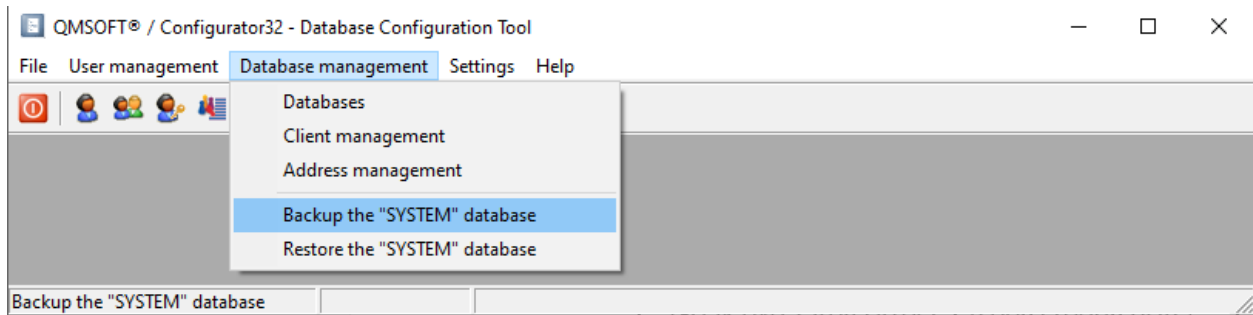


Fig. 3.1.4: Database management → Backup the “SYSTEM” database.

3) Open the menu *Database management* → *Databases* and start the *Backup* function [Fig. 3.1.5].

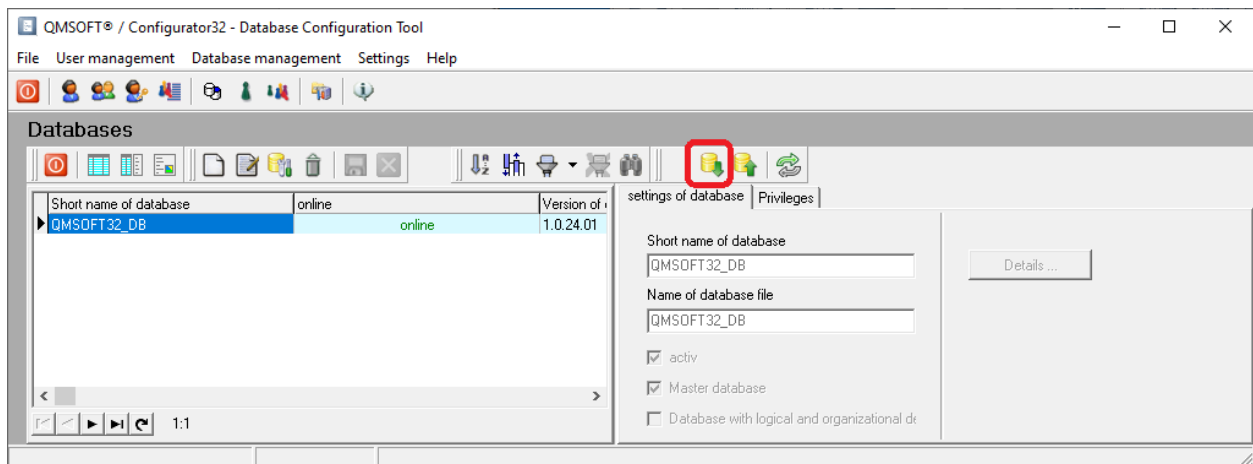


Fig. 3.1.5: Database management → Databases → Backup.

4) As a final step, the local settings, layout files, tolerance tables or test positions can be saved. To do this, we recommend copying the entire folder `C:\Users\Public\Documents\QMSOFT32\` to an external drive.

3.2 Stop the Firebird SQL Server

To update the Firebird SQL Server, it must first be “stopped”. Please follow these steps:

- Open the MS Windows Control Panel on the computer and go to *System & Security* → *Administrative Tools* → *Services*. You will now see a list of services running on your computer.
- Locate the “Firebird Server” and click the “Stop Service” button to stop the SQL Server process, then stop the “Firebird Guardian” as well.

3.3 Uninstall the old Firebird SQL Server

To remove the old Firebird SQL Server (from the local computer or from the server) you must use the MS Windows Control Panel. Navigate to the “Software” or “Programs” or “Apps” page, look for Firebird in the list of installed programs and “uninstall” it. After the uninstallation process is complete, you should use MS Windows Explorer to remove any remaining files from the Firebird program folder (you can delete the Firebird folder entirely).

3.4 Install the new Firebird SQL Server

The installation of the Firebird SQL Server starts automatically as soon as you install QMSOFT® using the autostart procedure “StartQmsoftCD.exe” from the root directory of the supplied QMSOFT® DVD-ROM and select one of the functions “QMSOFT® Desktop Installation” or “SQL Server (Firebird)”.

You can find the Firebird installation kit, which fits your MS Windows version (32-bit or 64-bit), in the folder Additional/Firebird of the QMSOFT® DVD-ROM.

3.5 Restore of databases

Because Firebird SQL Server 2.5 (or later) uses a new binary file format for database files, all existing QMSOFT® database files must be converted to this new format. This can be done by restoring the database backup files you created previously. For this purpose, you can use the “BackupRestore” tool from the QMSOFT® DVD-ROM (see Chapter *Backup of databases* for a description).

Note

The restore should be done in the original database folder where the QMSOFT® database files were previously located!

After restoring all QMSOFT® database files, you can install the new QMSOFT® version.

CHAPTER 4

QMSOFT® update installation

Please install the QMSOFT® software as described in the manual. Use as far as possible all the default settings! Please note that QMSOFT® ALWAYS uses a SQL database server (unlike the old versions of the program), either on the local computer or on a server.

Upon successful completion of the program installation starts automatically a QMSOFT® configuration Wizard. After setting the dialogue language and requesting/checking the QMSOFT® license data this configuration wizard expects the entry of connection parameters for QMSOFT® system database. You will get the following screen [Fig. 4.1]:



Fig. 4.1: QMSOFT® configuration wizzard.

Because of updating QMSOFT® there is already an existing database, please select the option *Connect to an existing database!*

In the next step you have to enter the parameters for your database connection. Make sure to select the correct version when using the Firebird SQL server. If the database is running on your local machine, you can use "localhost" as server

name [Fig. 4.2].

The screenshot shows a Windows-style dialog box titled "QMSOFT® - Konfigurieren ...". The main heading inside is "Configuration parameters to existing database ...". The form contains the following fields:

- Type of SQL database:** A dropdown menu with "Firebird" selected.
- Server version:** A dropdown menu with "2.5" selected.
- Name of database server:** A text input field containing "localhost".
- User (SQL-Server):** A text input field containing "sysdba".
- Password (SQL-Server):** A password input field with 10 dots.
- Firebird Alias or name of Firebird database incl. folder on the database server:** A text input field containing "C:\ProgramData\QMSOFT\V8_Databases\QMSOFT_DB.fdb".

At the bottom, there are three buttons: "Abort" (with a red X icon), "Back" (with a green left arrow icon), and "Continue" (with a green right arrow icon).

Fig. 4.2: Database connection.

Perform with the Continue button. If the QMSOFT® configuration wizzard is able to connect to this database, you will now be prompted to enter your login name and password for the QMSOFT® database application. Please use a login with "Administrator" rights for this.

Refreshing and updating data

After an update of the QMSOFT® program files the internal structures of the QMSOFT® databases have to be refreshed. This is executed automatically while accessing the database for the first time after the program update. After this you can import all of this settings and documents, which was saved outside of the database by the old QMSOFT® version in a last step. Please read all of the following chapters and note all of the hints!

5.1 Updating the QMSOFT® database structure

Note

If you have upgraded from QMSOFT® version 6 the refresh of the database structure has to be executed in every case, for older QMSOFT® versions it is necessary only in the case, that you have used QMSOFT® database programs (QM-MANAGE, QM-BLOCK, QM-PIN).

If the system detects an older version of the QMSOFT® system database, QMSOFT® requires an authorized user-login at the level of a QMSOFT® “administrator” to define the gauge stock for the management of “reference standards, ...”

Note

Since QMSOFT® version 6 there is a central laboratory management function to handle the reference standards and gauges. As a rule, the Update Wizard will automatically detect the correct client to synchronize this data or edit. If the Update Wizard does not appropriate these clients can determine for synchronization, you need to define in which data structure this client is to be generated.

Warning

(upgrading Version 6 and previous): In the new version of QMSOFT® all data from all of the gauge databases are copied into the “system” database. This process may take some time, please be sure to wait, until the process is complete! The previous QMSOFT® gauge database files now no longer are needed, they can be deleted (and removed from the backup regime), because all the information is stored in the QMSOFT® system database.

Note

Following the database update, it is recommended to execute a backup/restore-process of the QMSOFT® system database again. This possibly is eliminating “wholes” and reducing the database file size.

5.2 Import of local settings (version 5 and older)

Please note that this function is exclusively designed to import data and files, which are not a part of the gauge database (e.g. factory tolerances, inspection positions, certificate layouts templates, database report templates). It is only necessary when you upgrade from a version 3, 4 or 5!

One of the main differences between the QMSOFT® version 6 and all previous versions is the fact, that all formerly “file based” information (which was spread to a number of directories) are now completely saved in the central QMSOFT® database.

Please check careful, which information you really need to take over from an older version! In case that there are a number of new opportunities in the software it may be sometimes useful to use the new created data and add your data you need to customise the system manually, especially if you are updating from an older 3.xx version.

Start now the assistant to import the old files and data by opening the menu *File* → *Import data from older version*.

The following screen will now offer you the selection of the different data you may import. At first select the number of your QMSOFT® program version, which you have used before updating to the new version. For versions older than version 4 please select also the “Directory of previous installation”. This will be used to set the default values for the directories to be selected.

5.2.1 Import of “global” data

The import of “Global data” [Fig. 5.2.1] does include

- the probe data file (TASTER.XML, was used by the former version of the “Probes and Masters Management” program to save the external and internal reference standards, the wires and probes for the thread measurement and probes and balls for internal measurements),
- frame layout templates (only existing in version 5) and
- standards and traceability (only existing in version 5).

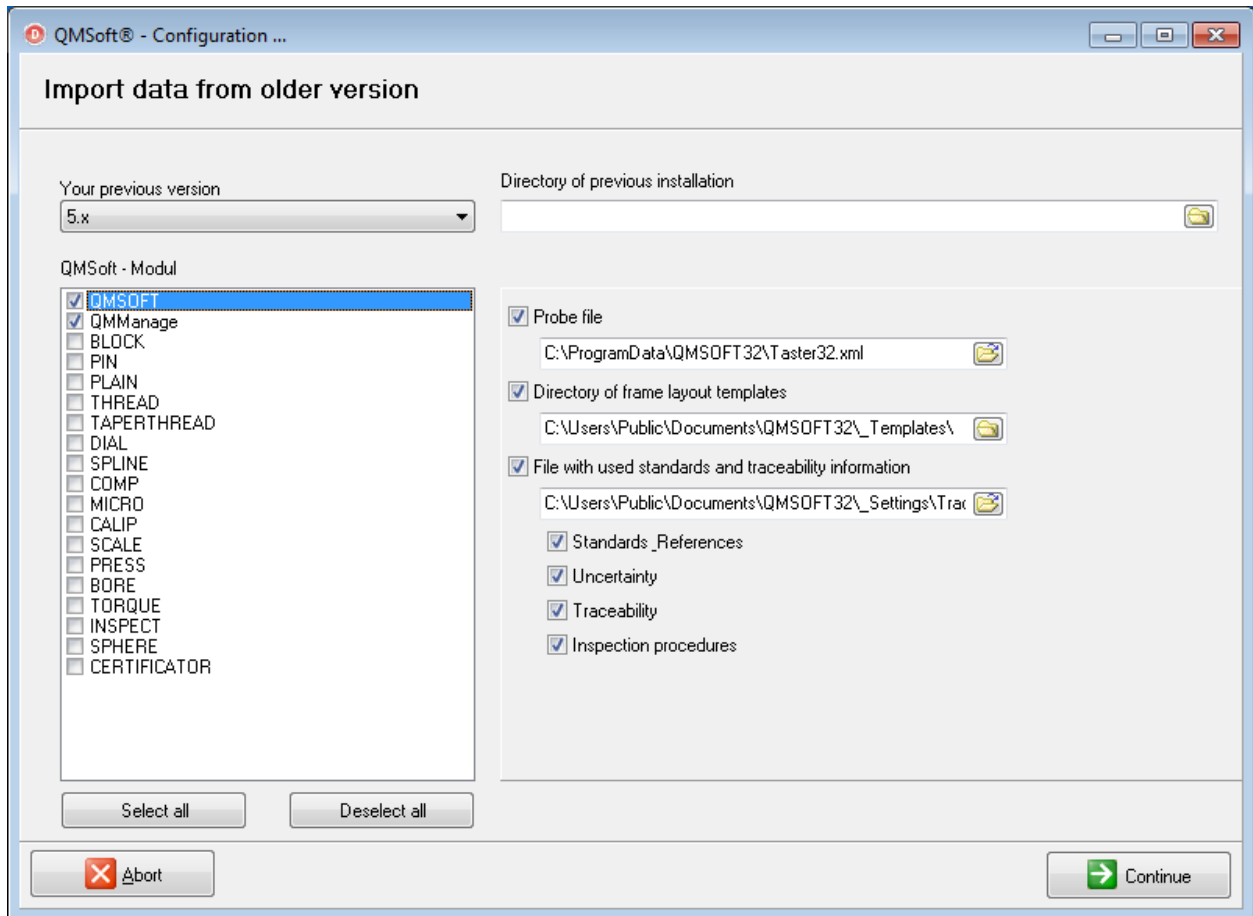


Fig. 5.2.1: Import of global data.

5.2.1.1 Import of probe data (probe file “TASTER.XML”)

This option will import the data of the probes, wires and used standards. You should do this import only if you have entered customised wire or probe data for the thread measurement.

The data will be imported to the new database for the “Management of standards and instruments”. Please check the data after the import. In case that the import procedure does not assign a useful name for the probe or wire set(s) it does make sense to rename it.

Note

If you are working with different working places for measure threads, it may be necessary to import the local “TASTER.XML” file from each working place!

5.2.1.2 Import of uncertainty information (QMSOFT®-Version 5 only)

The import of the uncertainty information is saving this data into the central “QMSOFT® laboratory management”, category “Measuring uncertainties”. Please check the entered formula whether it can be evaluated by the formula parser, and please use “plain text” names to identify your saved uncertainty items easy!

5.2.1.3 Import of inspection procedures (QMSOFT®-Version 5 only)

This feature does import the names of “Inspection procedures” which you has defined in QMSOFT®-Version 5. Please note that the assignment to the related types of gauges will not be set: to do thos you can use the QMSOFT® laboratory management.

5.2.2 Import of inspection program data

These files and data do (at maximum) include [Fig. 5.2.2]:

- “old” certificate layout files,
- “tolerance files” containing the data of “user-created” factory tolerances,
- “inspection position files” containing the data of inspection positions (these files are mainly used for the inspection programs QMSOFT®/QM-MICRO and QMSOFT®/QM-CALIP defining the inspection positions for micrometer and caliper inspections)

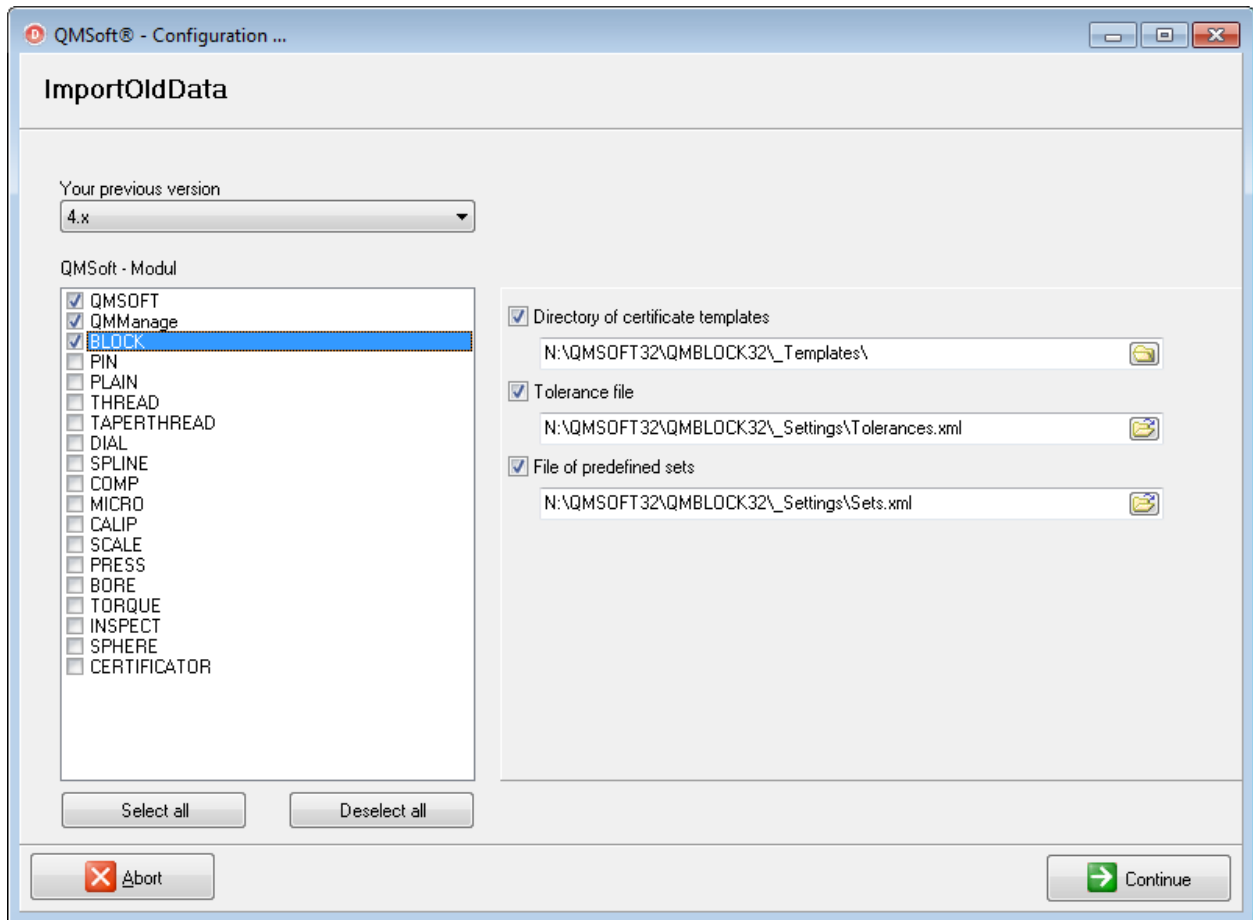


Fig. 5.2.2: inspection program data.

5.2.2.1 Import of certificate layout template files

If you are upgrading from a QMSOFT® version older than version 5 in the most cases it is recommended to use the new original templates, which are delivered with the new version. In case that new functions (see the options “Frame Layout”) was established it will be easier to modify.

5.2.2.2 Import of factory tolerances

In older QMSOFT® versions customised factory tolerance are stored in files with the name “Tolerances.XML”. Activate the option if you need to import such tolerance information.

Warning

The structure of the tolerance tables for Calipers and Cylindrical Pins has changed. Therefore, it is not possible to import this tolerance information.

5.3 Update of gauge type definitions

Caused by internal changes and extensions of the QMSOFT® modules as well as changes in the related standards and inspection procedures it may be necessary to adapt the existing gauge type definitions in the database. Even the new function in the QMSOFT® V8 which does enable the automatic matching between your defined tolerance tables in the laboratory management and the list in the type definition, does require an update of the type information.

Note

The most convenient and safest way to do this is the usage of the function *Import original type definition(s)*. You will find this function in the program QMSOFT®/QM-MANAGE in the menu *Settings* → *Types* [Fig. 5.3.1].

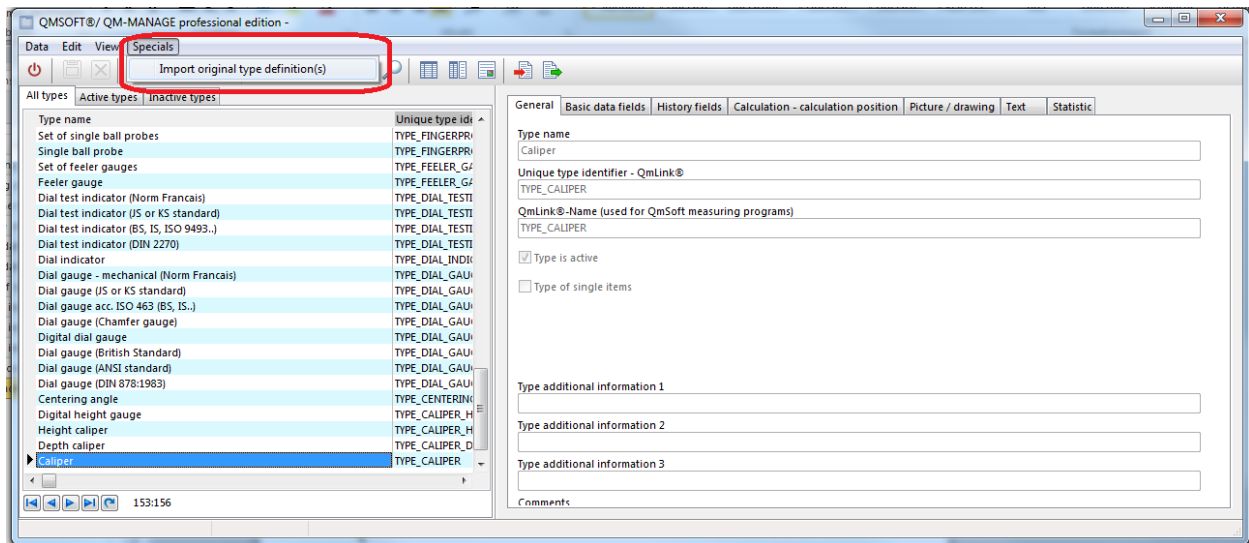


Fig. 5.3.1: Import original type definition(s).

After this, you can select what type definitions you want to refresh [Fig. 5.3.2].

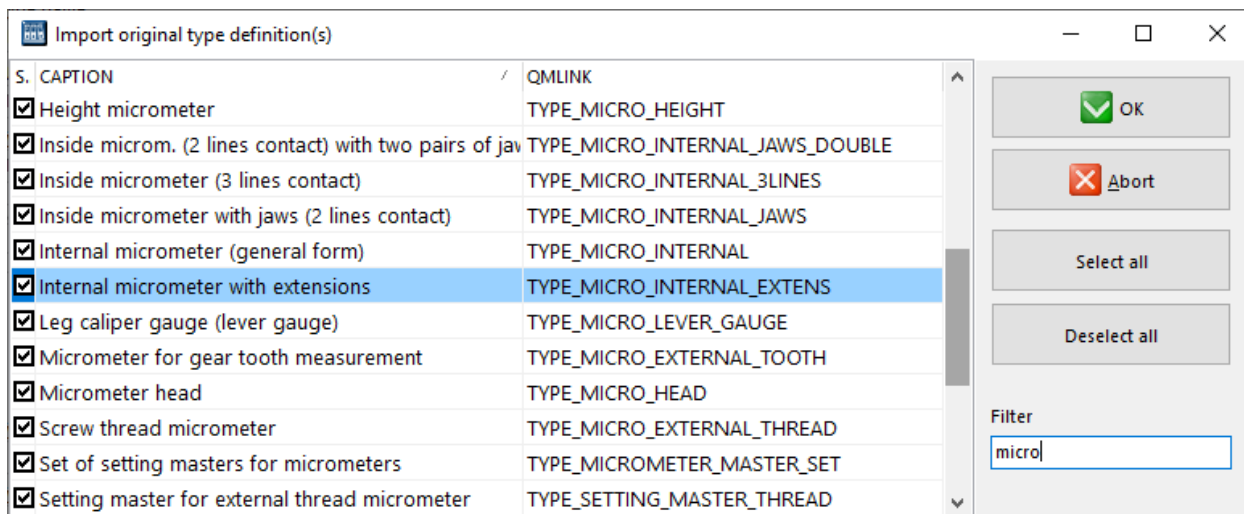


Fig. 5.3.2: Select gauge types for the type definition upgrade.

Note

If you have not changed the existing “standard” types, you can easily “select all” to update all existing types.

Warning

Be careful if you have made changes to type definitions yourself! Then do not overwrite these types and if necessary coordinate the procedure with L&W!

Please also note that test equipment types that you have created yourself are of course not updated. You may have to intervene manually here.

The link to the tolerance structure in order to update automatically the list of standards for the gauge type can also be set manually in the type definition. To do this, activate the option *Select tolerance tables by structure or module*, as shown in the figure [Fig. 5.3.3], and set the required specifications.

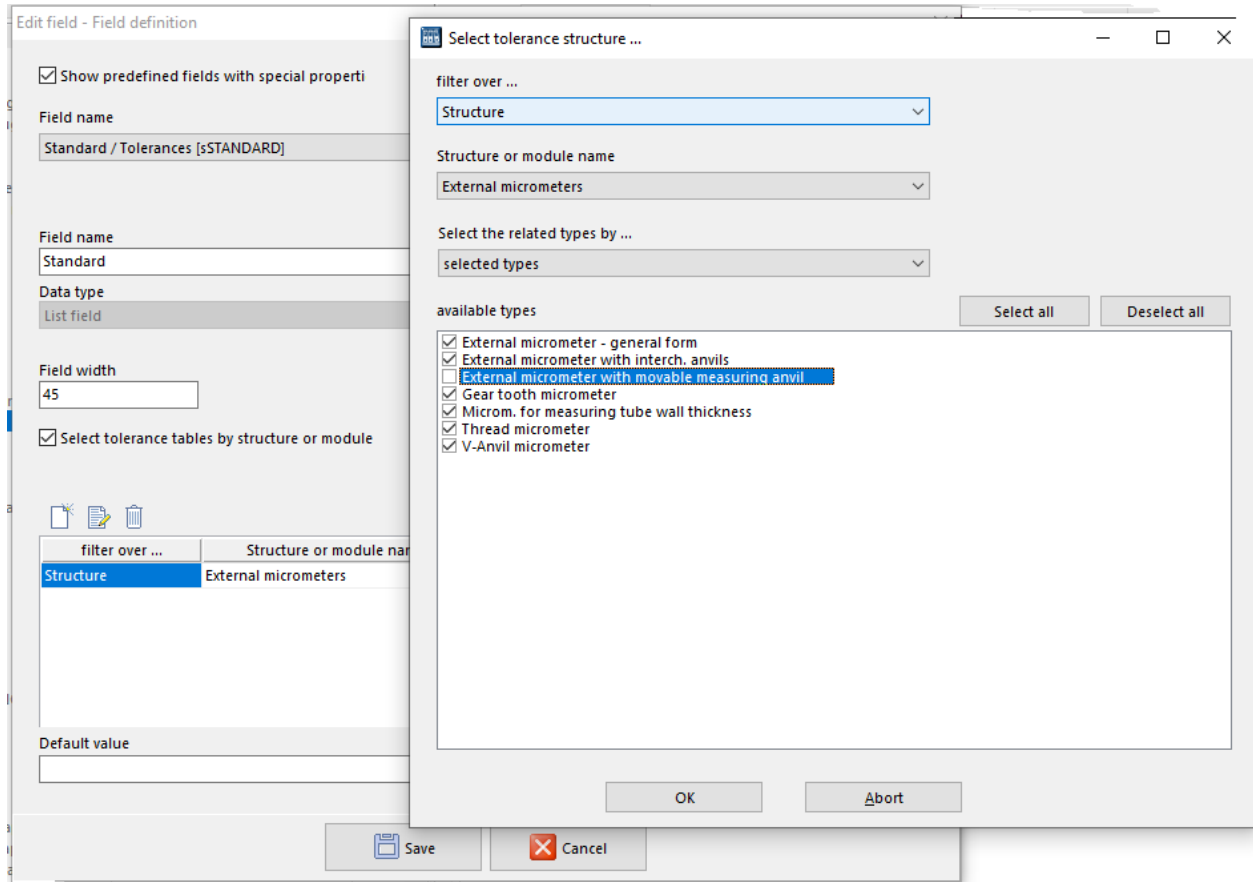


Fig. 5.3.3: Setting a link between the gauge type and the tolerance structure (tolerance tables).

5.4 Settings for “overdue” checks

If you have previously used the “Overdue check” option in the QMSOFT®/QM-MANAGE test equipment management to automatically display due test equipment when opening the database, you will have to completely reconfigure this.

Overdue checks can be used very flexibly and can be started both manually and automatically. If an automatic start is desired, a corresponding task must always be created in the QMSOFT® Task scheduler (call via “House” icon / General administration) [Fig. 5.4.1]

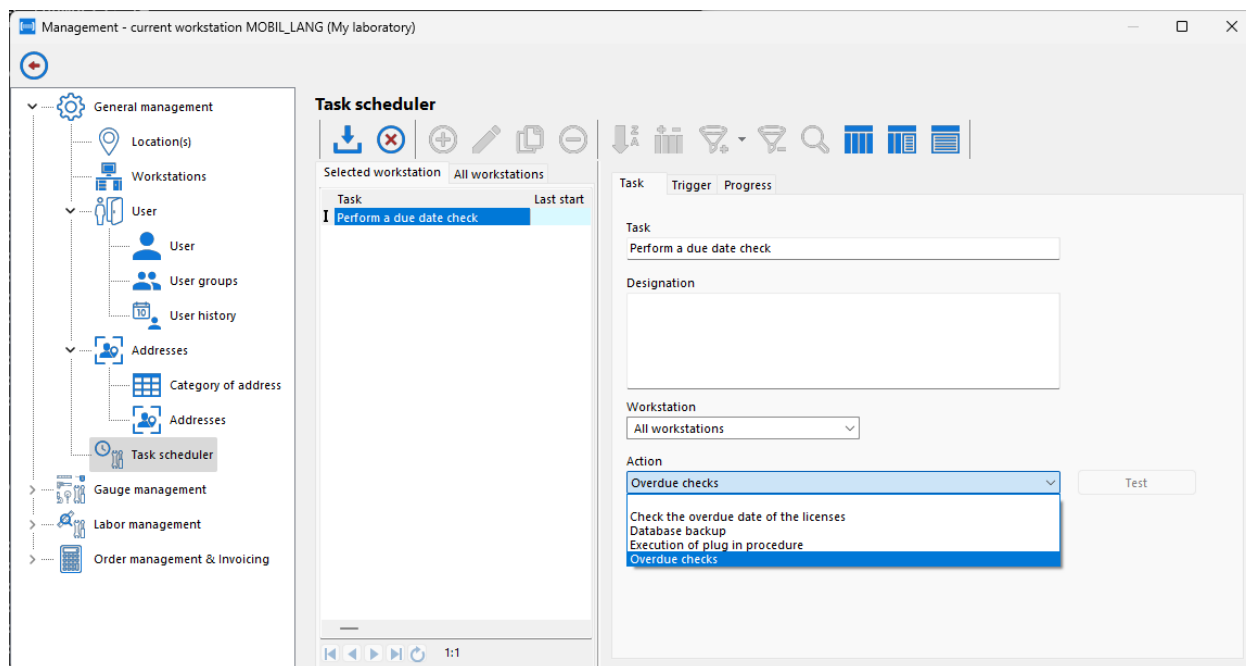


Fig. 5.4.1: QMSOFT® Task scheduler.

Give the test a name and select **Overdue checks** in the *Action* field. Then define a starting point for the execution of the test on the *Trigger* tab page. For a simple test - analogous to version 7 - select *When opening a database* [Fig. 5.4.2].

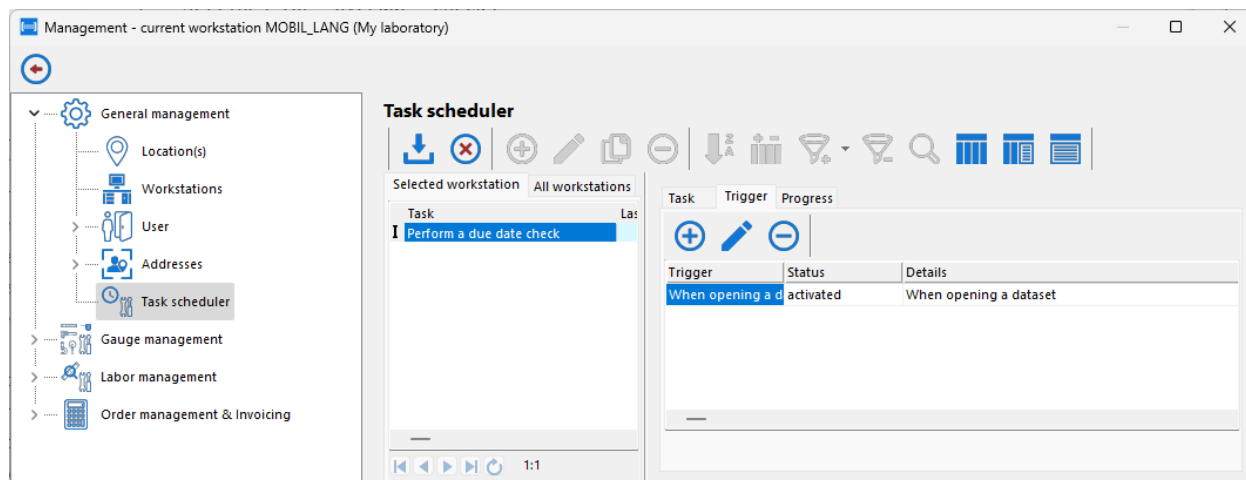


Fig. 5.4.2: QMSOFT® Task scheduler - edit trigger (event).

All other settings for the execution of a due date test, which call up test equipment for calibration (or other measures), has to be done in the QMSOFT®/QM-MANAGE program after opening the associated dataset (client).

Due to the various setting options of an overdue check, some other system configurations must also be considered in connection with these.

Note

You can configure the overdue check directly in the gauge management program QMSOFT®/QM-MANAGE under the menu *Settings* → *Overdue checks*. But before, please define at first the “filter” and the action(s) to be performed as described below.

Here you will find a short overview what settings are needed for an overdue check and should therefore be configured in advance:

- **“FILTER” - Select the gauges / test equipment which are affected by the test**
the selection of gauges which are affected is basically done by using a “Filter”; the following screen [Fig. 5.4.3] is showing an example of a typical filter;

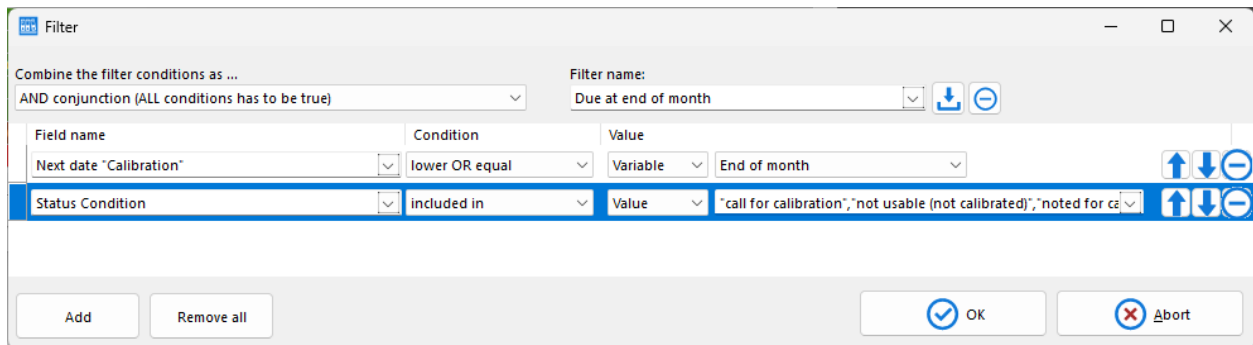


Fig. 5.4.3: Filter definiton.

this filter will select all gauges which will be due at the end of the month and fulfill the selected characteristics for the status (exclusion of scrapped test equipment and similar things). Please save the filter as a “System filter” [Fig. 5.4.4] under a meaningful name!

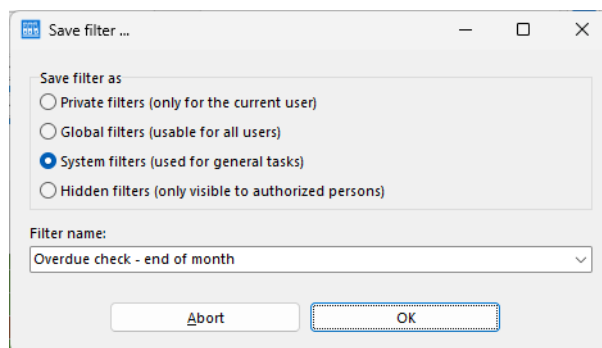


Fig. 5.4.4: Save filter definiton as “System filter”.

- **what should be done?**

Here you will find the options: “Show message “, “Execute a gauge action”, “Send e-mail” Here it is also important to ensure that all required information is available in the system and correctly configured. Should an “action” be carried out when the test will be done, e.g. to change the status of the test equipment, the corresponding action must of course be defined before. When sending e-mails, please note that both the e-mail addresses of the recipients and your sender address are entered. The e-mail sender address is configured in the user administration for the user selected as “Person for auto-mail function” in the laboratory administration.

- **when is the test carried out?**

Here you can choose between “Manual start” (“default” setting) and tasks defined in the Task scheduler. With “manual start” you start the test by calling the function after opening the database. The automatic execution depends on the “trigger” which you have defined in the Task scheduler.

Here, you can now see an example for defining an “overdue check” [Fig. 5.4.5]:

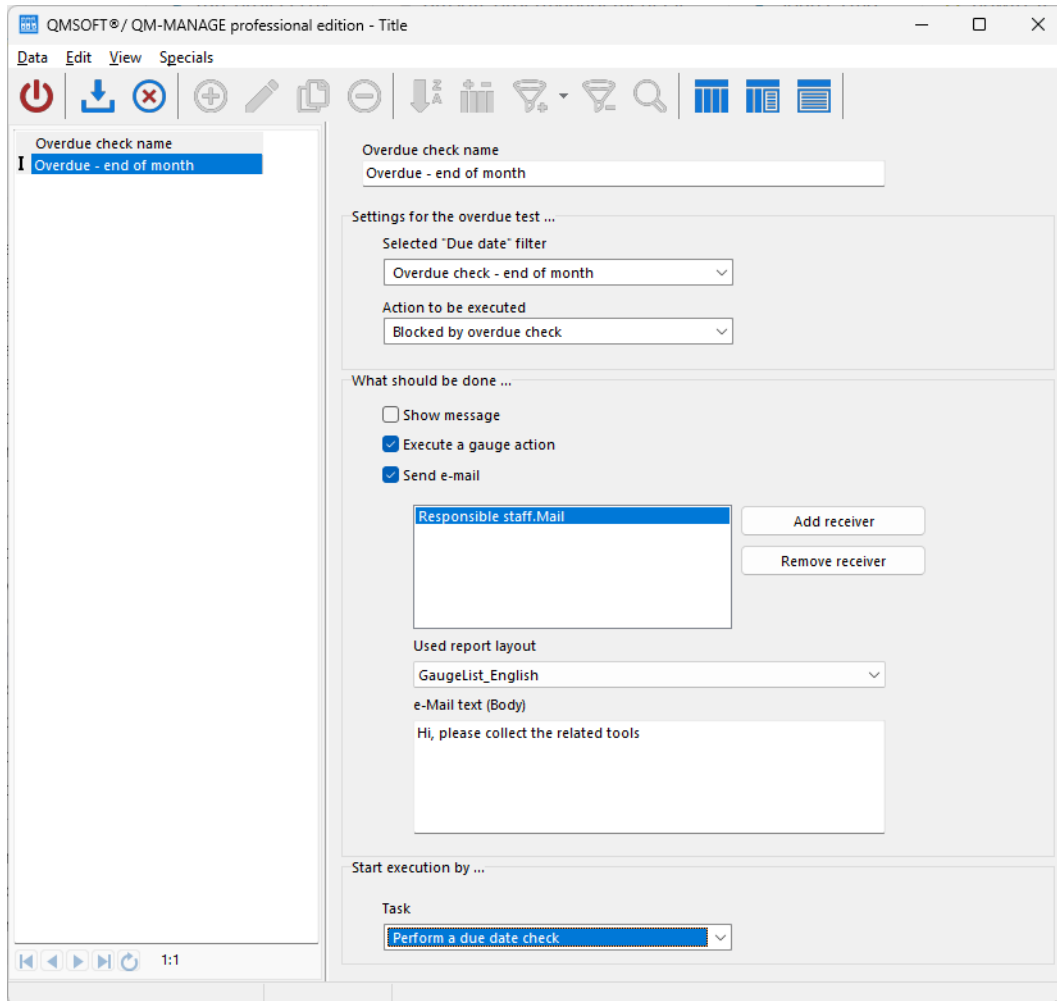


Fig. 5.4.5: Definition of an overdue check.

- When creating a due date test, first give it a name. Then select a predefined filter that defines the tool selection for the following activities. If an action is to be carried out, specify it here.
- Then select the operations to be selected from the list provided. If e-mail is to be sent, specify the recipient here. For example, if you have saved the e-mail address as additional information on the “current location”, the list of the test equipment concerned is automatically split up for the respective addressee of the current location.
- The report layout for the generated report is selected via the “Used report layout” setting. When sent by e-mail, the generated report is sent as a PDF document in the e-mail attachment
- If you want, you can enter a general e-mail text in the related field;
- At the end of the configuration, set in the “Start execution by” option whether the due date test is started manually or automatically. The execution time for automatic execution is configured in the “Task scheduler” function using the “Trigger” defined there.

Note

The QM-TaskService must be configured and started for an automatic execution of an overdue test outside of QMSOFT®!

Warning

For QMSOFT® versions from November 16, 2021 and later, the right to execute the due date test must also be set in the user administration [Fig. 5.4.6].

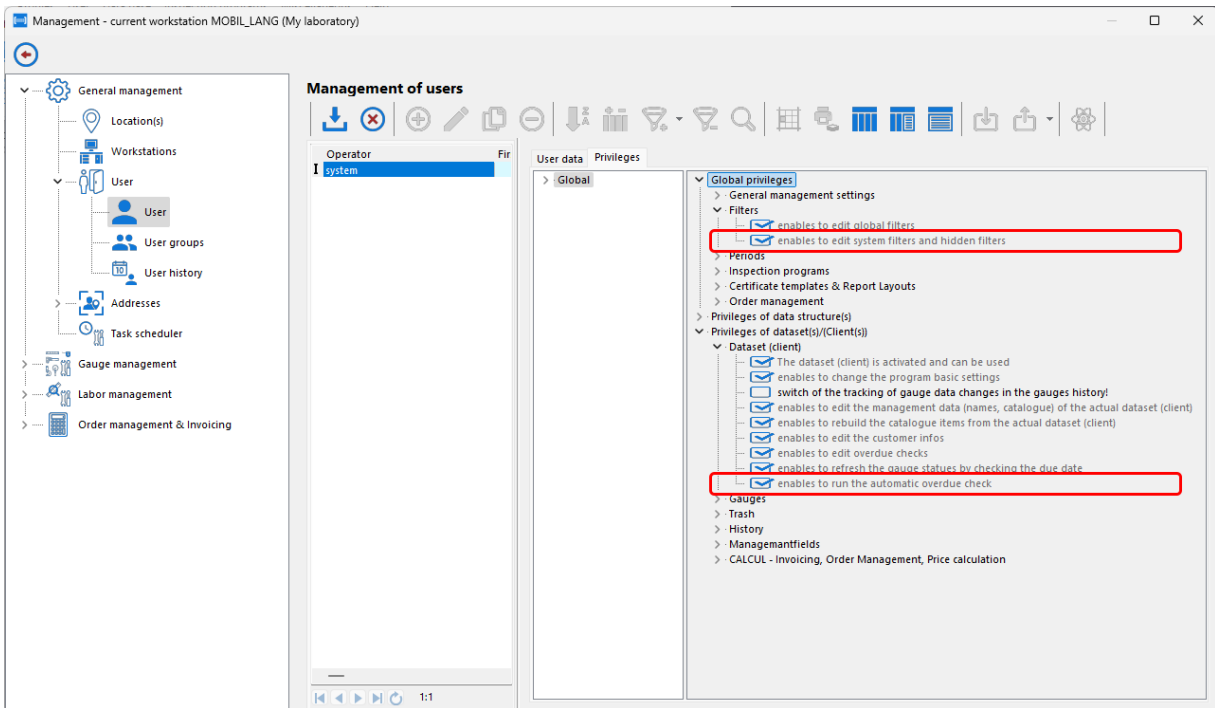


Fig. 5.4.6: General Management → User Management → Privileges.

5.5 Adjustments for the Gauge Management

1. Modification of report templates

Due to internal database changes, the database fields for “last test date”, “next test date”, “test period” must be replaced in the reports used. In the QMSOFT® start window you will find within the menu *Miscellaneous* → *Extras* the function *Convert fields in report report layouts*. This function will automatically replace fields that can now be found under a different name.

2. Corrections for digital dial gauges when using the new ISO standard

when you are using the inspection program for the dial gauges, it's recommended to execute the function *Fix gauge types and tolerance tables for digital dial gauges* [Fig. 5.5.1].

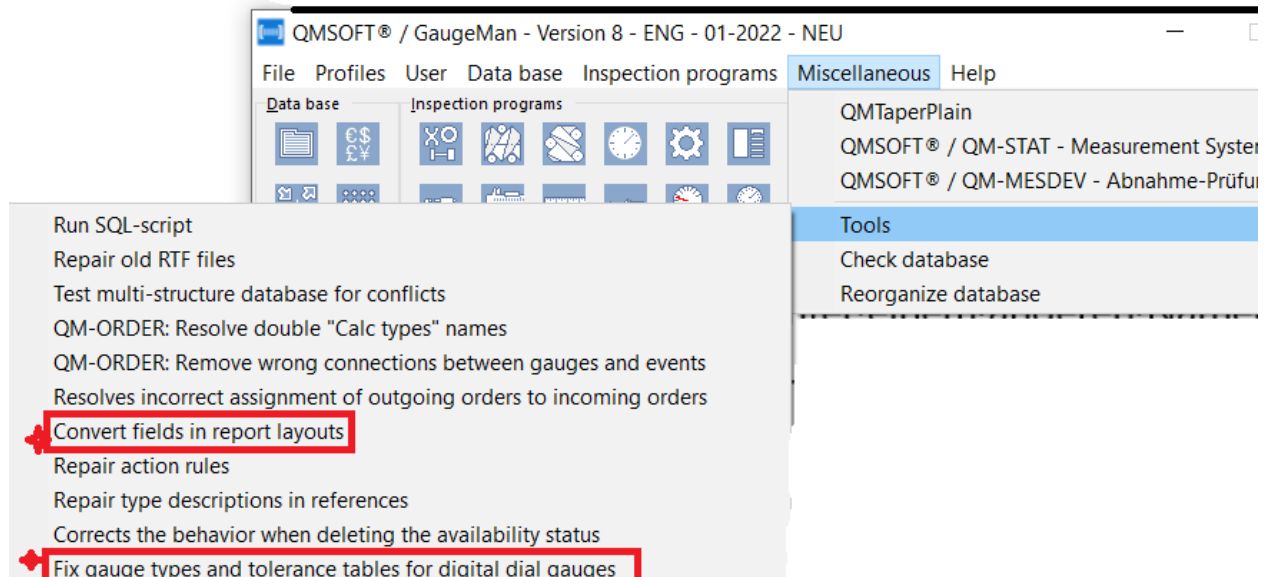


Fig. 5.5.1: Fix gauge types and tolerance tables for digital dial gauges.

3. Review of the “Action rules”

Compared to previous program versions, version 8 allows a much more detailed definition of the changes to the test equipment status and test date (last / next) that should be made by executing an action. Even if the update of the database implements the old rules largely identically, you should do so in the *Settings* → *Actions* again and add or correct them if necessary [Fig. 5.5.2].

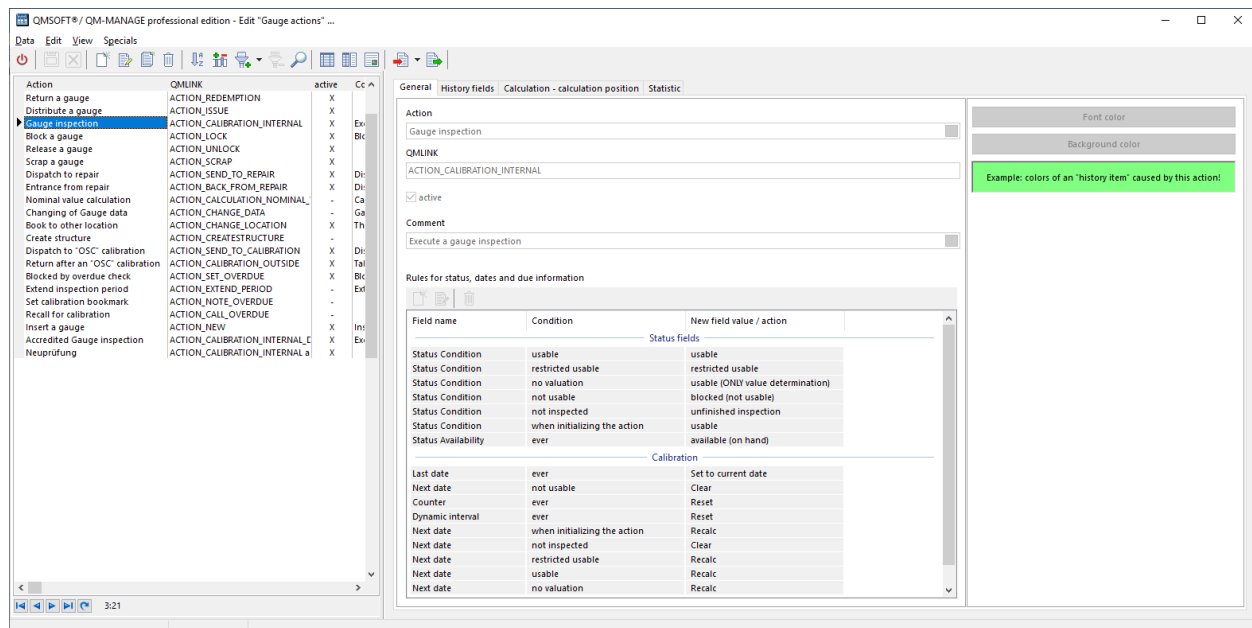


Fig. 5.5.2: Definition of rules for setting the “status” and inspection dates when executing an “action”.

5.6 Update of standards (Tables f. Error limits) and inspection procedures

5.6.1 Update of tolerance tables / tables of error limits

When the database is updated, tables for error limits in “Laboratory Management” are updated and supplemented if necessary. All standards associated with an internal calculation DLL (plain gauges, thread gauges) as well as all write-protected standards supplied by L&W are automatically supplemented and updated during a database upgrade.

Note

For users of customized “Factory standards” in the program QM-PLAIN In version 8, some new tolerance tables were created that work in the newly introduced “Mixed Mode”. This means that you can enter individual tolerance values, which will be used by another algorithm to calculate the required limit values when retrieved. These tolerance tables are assigned to the newly introduced table categories [Fig. 5.6.1].

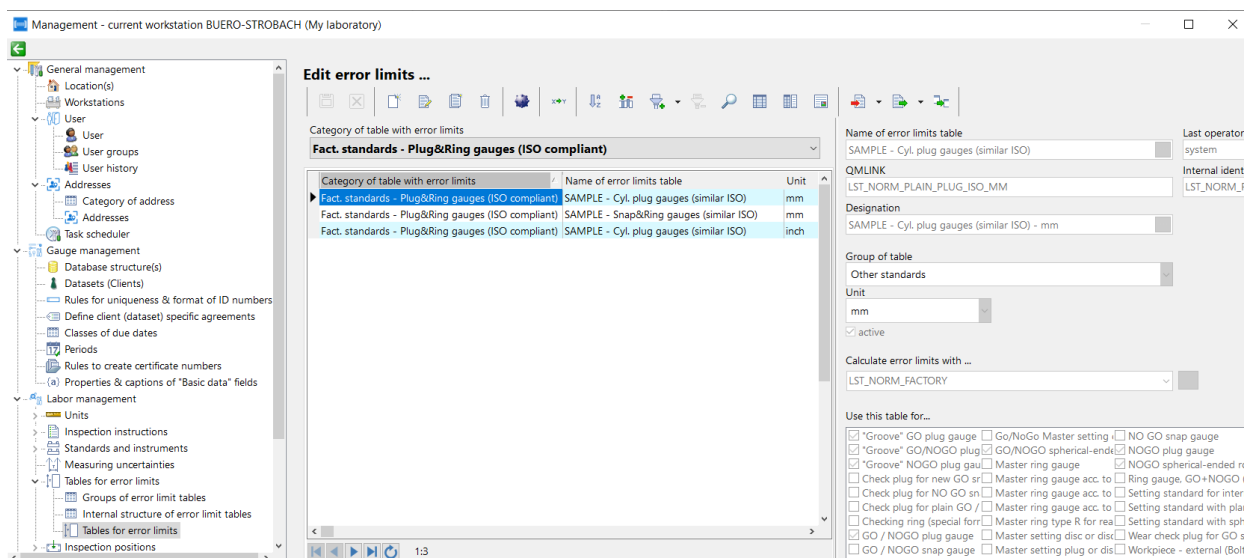


Fig. 5.6.1: Edit Error limits.

In case that you have entered factory tolerance values for plain gauges in the old version there may be conflicts with the new mechanisms. The reason is that tables of the new tolerance structures CANNOT be added automatically as long as tables with the same name already exist, please proceed as follows!

Note

If you are missing tables that you have defined or modified, please contact L&W for assistance with the conversion.

5.6.2 Update of inspection procedures

The new program version does also update and supplement the list of inspection instructions which are stored in the QMSOFT® database. To make sure that the update of this list will be done, execute the function *Import, Refresh the original inspection instructions* as shown in the screen shot [Fig. 5.6.2]!

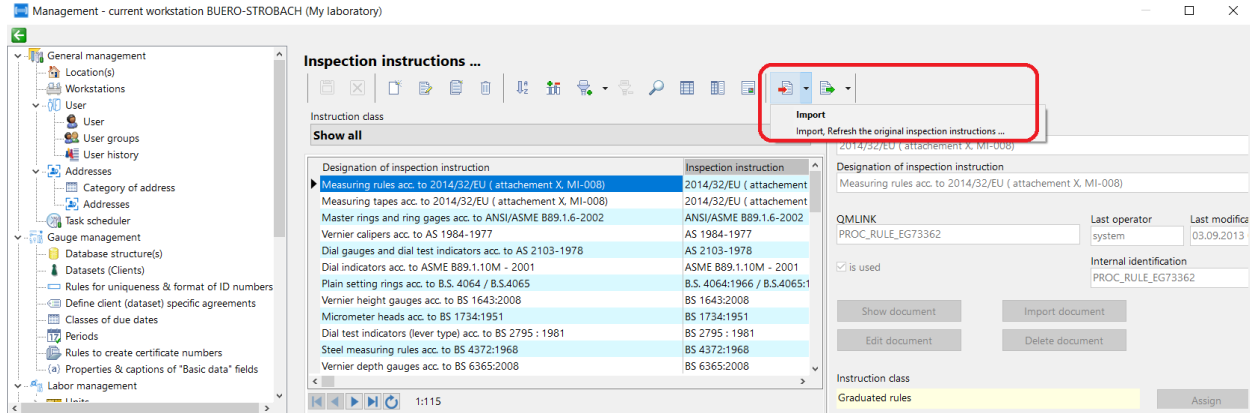


Fig. 5.6.2: Import inspection instructions.

5.7 Configuration of QMSOFT® inspection programs

In all of the QMSOFT® inspection programs the features for handling the program settings and to adjust the inspection conditions have been completely restructured. Unlike previous versions before version 6, all of these settings are stored in the central laboratory database.

Another difference to the previous versions is the replacement of the specification of the number of measuring planes and measuring points with the definition of a position list. (Note: only applies to programs for “fixed gauges” such as plug gauges, threaded mandrels, etc.)

After the upgrade, this means now only once that you check all the settings again. If necessary you should set your desired “standard” settings, use the menu item *Settings* → *Program Settings* inside of all of the licensed QMSOFT® inspection programs to do this.

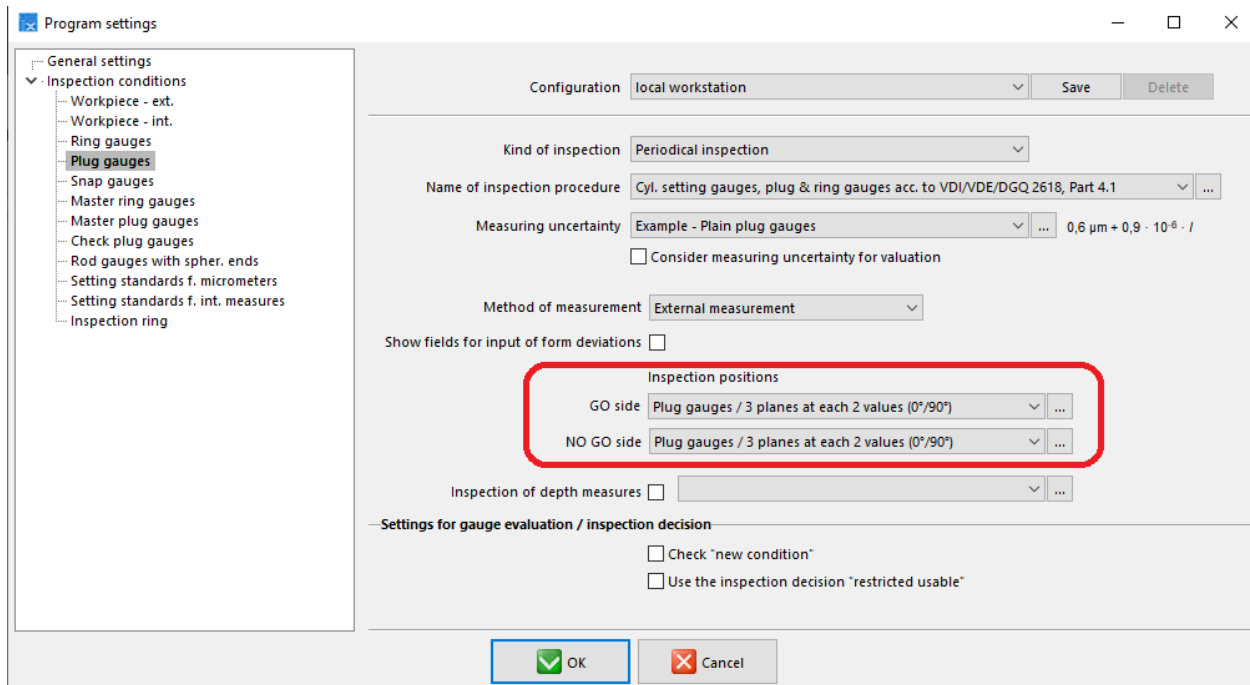


Fig. 5.7.1: General settings and inspection conditions.

The figure [Fig. 5.7.1] shows this as an example for the inspection program QMSOFT®/QM-PLAIN. Check the inspection conditions for all of the gauge types.

5.8 Measuring device configuration (until Version 5)

In case that since Version 6 QMSOFT® does establish a central service “QM-DeviceServer” to manage all measuring instruments, it is necessary to define the connection to the used measuring instrument(s) again as soon as you are coming from QMSOFT® versions older than version 6. Please see the QMSOFT® manual how to do this.

Special notes when changing a computer (workplace related settings)

If an exchange of a computer is necessary, you have to perform several steps to assign the computer-related QMSOFT® settings to the new computer (if the old and the new name of the computer are not the same):

- Integrate the new computer into the network, install QMSOFT® and connect it with the QMSOFT® system database,
- login into QMSOFT® one time, then shut down the computer (or end ALL of the QMSOFT® components including the QMSOFT®/QM-DeviceServer)
- use a third QMSOFT®-computer (not the new computer!) to delete the new computer item from the QMSOFT® workplace management and rename the old computer item into the name of the new computer.

Now all settings are related to the new machine.

Actual values of reference normals, that are calibrated during a gauge measurement (mainly for the calibration of probes), are stored related to the local workstation into the central QMSOFT® database. If such normal is used at several workstations, for the user the workplace-related values are displayed, calibration values of other workplaces are not overwritten.