

PMS.Cliptest - Manual - Leoni - LEPS 4

Version 25.3.2.2



MAR Rostock GmbH - 10.10.2025

© 2025 PMS.Cliptest is a registered Trademark of MAR Rostock GmbH. Microsoft, SQL Server and Windows 10 are registered trademarks of the Microsoft Corporation. All other trademarks are in legal ownership of their registered proprietors.

Document version management

Version	Date	Status	Range of Validity	Creator	Document
1.0.0.0	05.07.2022	Release	MAR / Global	Seidel	Publishing of Document V1.0.0.0
24.4.1.0	08.11.2024	Release	MAR / Global	Seidel	Updated to latest software version
24.4.2.0	06.12.2024	Release	MAR / Global	Seidel	Updated to latest software version
24.4.2.1	11.12.2024	Release	MAR / Global	Seidel	New option "Enforce Unique Clip Addresses" in File Backend, Fixed obfuscation issue
25.1.1.0	08.02.2025	Release	MAR / Global	Schuster / Seidel	Optimized performance of the service and clip receivment
25.1.1.1	22.02.2025	Release	MAR / Global	Schuster / Seidel	Fixed clip-exchange PinStatus.csv file modification to check on led additional to boardname and address
25.1.1.2	08.03.2025	Release	MAR / Global	Schuster / Seidel	Customer specific small changes

25.2.1.0	23.04.2025	Release	MAR / Global	Schuster / Seidel	Tests can be started without board scan if there is only one board in masterdata, Eventing improvements
25.2.2.0	08.05.2025	Release	MAR / Global	Schuster / Seidel	Added new option "Allow anybody to login by scan" to allow login by scan without the operator being configured in the system
25.3.1.0	02.07.2025	Release	MAR / Global	Schuster / Seidel	Fixed Web-Login with empty password, several fixes and improvements
25.3.1.1	25.07.2025	Release	MAR / Global	Schuster / Seidel	Customer specific changes
25.3.2.0	19.08.2025	Release	MAR / Global	Schuster / Seidel	Improved Board-Teaching UI and added clip validation, Statistic data fixed
25.3.2.1	06.09.2025	Release	MAR / Global	Schuster / Seidel	Fixed empty Test-Mode in ViewClient after reconnect
25.3.2.2	05.10.2025	Release	MAR / Global	Schuster / Seidel	Printing bugfix in case of option Combined Test Result

Referenced Documents

ID	Document
1	PMS.Cliptest.Documentation.v25.3.2.2.pdf

Table of Content

- [PMS.Cliptest - Manual - Leoni - LEPS 4](#)
 - [Document version management](#)
 - [Referenced Documents](#)
 - [Table of Content](#)
 - [1 General Information](#)
 - [2 Workflow](#)
 - [3 Configuration](#)
 - [3.1 OPC UA Connection](#)
 - [3.2 Quality Confirmation Text File Configuration](#)
 - [3.3 Unconfigured Clips Detection](#)
 - [3.3.1 Workflow](#)
 - [3.3.2 Available Bookmarks](#)

1 General Information

PMS.Cliptest uses OPC UA technology to communicate to the LEPS 4 facility service. The facility service is a windows service which hosts an OPC UA Server to which PMS.Cliptest connects as an OPC UA Client. There is no permanent connection to LEPS, instead the connection is established and closed on each request.

2 Workflow

The communication is in any case initiated by PMS.Cliptest and all communication is done by simple requests from PMS.Cliptest and (immediate, synchron) responses by LEPS. Usually the operators perform a number of scans in PMS.Cliptest. After all required scans are done, PMS.Cliptest sends a request to LEPS 4 to retrieve the test information. The received test information contains at least the cliplist, the ordernumber, the board and the test type (Cliptest or Emptytest) for the corresponding workplace.

3 Configuration

3.1 OPC UA Connection

OPC UA CONNECTION

Host

FacilityService

Port

50101

Username

opc

Password

.....

Test

Setting	Description
Host	Name or IP of the Server where the LEPS4 Facility Service is running
Port	The configured Port of the LEPS4 Facility Service
Username	The optional username which is configured in LEPS4 Facility Service
Password	The password of the user

Finally, use the "Test" button to verify that the configuration is correct and the connection to the LEPS4 Facility Service can be established.

3.2 Quality Confirmation Text File Configuration

QUALITY CONFIRMATION TEXT FILE CONFIGURATION

☐ Create Quality Confirmation Text File

Max Files

5000

File Path

C:\Temp

>>

File Name

[Order_] [Board_] [CtYear] [CtMonth] [CtDay] [CtHour] [CtMinute] [CtSecond].csv

Line Pattern

[Order_] [CriticalEventClipLED] [CriticalEventClipX] [CriticalEventClipY] [CriticalEventComment] [CriticalEventTimestamp] [CriticalEventIsAcknowledged] [CriticalEventAckTimestamp] [CriticalEventOperator]

Important: To use this option it is required that the option "Enable Quality Confirmation" in PMS.Cliptest.ViewClient is enabled

This section allows the configuration for the creation of text files related to the occurrence of quality issues during tests. A quality issue is considered as a clip change from state NeedlessPressed to NeedlessNotPressed. That means a cilp was pressed and released although it was not part of the test list.

Setting	Description
---------	-------------

Create Quality Confirmation Text File	Enable the creation of text files
File Path	The path in that the text files will be created
File Name	The pattern of the resulting file name. Use bookmarks to create files with a unique file name. Refer to the general PMS.ClipTest documentation to get detailed information about the meaning and usage of bookmarks. Select available bookmarks using the down arrow button to the right.
Line Pattern	Defines the content of each line in the text file. Combine static text alongside with bookmarks. Select available bookmarks using the down arrow button to the right. For each quality issue which happened a new line will be added to the text file.
Max Files	The maximum number of text files in the configured "File Path". If limit is reached the oldest file will be deleted. Set to 0 to never delete any files.

3.3 Unconfigured Clips Detection

Unconfigured Clips Detection

☒ Enable Detection of Unconfigured Clips

☒ Create Unconfigured Clips File

Max Files 5000

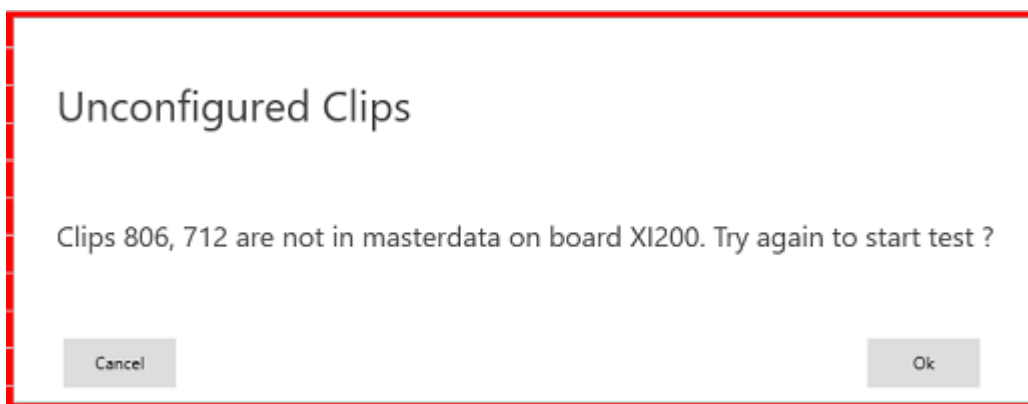
File Path C:\Temp >>

File Name [Order][Board][Canceled][CtYear][CtMonth][CtDay][CtHour][CtMinute][CtSecond].csv

Line Pattern [Order][Board][ClipLed][Operator][NOW]

Important: LEPS4 Option "Job Data Generation" needs to be active in LEPS4 ClipTest Job properties. This option enables that the clip-list is re-generated on demand with every request and not only once. Otherwise unconfigured clips list remains the same regardless of changed masterdata.

The detection of Unconfigured Clips can be activated on demand. If this option is enabled PMS.ClipTest opens a popup dialog which shows the list of unconfigured clips. A clip is unconfigured if it is requested to be tested but not defined on the board in masterdata. After the dialog opened the operator can decide to retry to start the test or to cancel the test-start request and no test will be started. The time while the dialog is open operators can use the chance to fix the unconfigured clips in PMS.ClipTest Masterdata and try again to start the test.



3.3.1 Workflow

A test is requested after all scans are done. PMS.ClipTest sends all clips from masterdata for this board in the test request to LEPS. LEPS processes the request and replies with the list of clips where each clip contains information if it is unconfigured or not. If there are unconfigured clips the test is not started and a dialog appears in PMS.ClipTest.ViewClient. The retry option of the dialog sends the same request to LEPS and waits for the response again. If the dialog is canceled operators can scan again.

Setting	Description
Enable Detection of Unconfigured Clips	Enables the check for unconfigured clips
Create Unconfigured Clips File	If Unconfigured Clips were detected a text file can be created optionally
File Path	The path in that the text files will be created
File Name	The pattern of the resulting file name. Use bookmarks to create files with a unique file name. Refer to the general PMS.ClipTest documentation to get detailed information about the meaning and usage of bookmarks. Available Bookmarks are listed below.
Line Pattern	Defines the content of each line in the text file. Available Bookmarks are listed below.
Max Files	The maximum number of text files in the configured "File Path". If limit is reached the oldest file will be deleted. Set to 0 to never delete any files.

3.3.2 Available Bookmarks

All Bookmarks related to Scans and Timestamps ([CtYear], [CtMinute]...) can be used for the filename alongside with others listed below.

Bookmark	Description
[Order]	Scanned Order Number
[Board]	Scanned Board
[Canceled]	"Canceled", if operator closed dialog with Cancel button, otherwise "Retry" in case of Retry button
[Operator]	The name of the operator who closed the dialog
[ClipLed]	Can be used for the line pattern only, contains the led number of each unconfigured led