Data Items Available Listed by Functionality Group

June 1, 2015

Machine Make:	Mazak Corporation
Machine Model:	QTN-xxxx
Controller Model:	Matrix
MTConnect Version:	1.2
Adapter Version:	1.2.0.8
Adapter Type:	Native

Functional Group: Motion

Data Item	Description	Included
Axis Feed Rate	The feed rate of a linear axis.	✅
Feed Rate Override	Feed Rate Override expressed as a percentage of the calculated feed rate.	✅
Path Feed Rate	The feed rate of the tool path.	✅
Rotary Velocity	The rotational speed of a rotary axis. Spindle Speed of the C Axis.	✅
Rotary Velocity Override	Rotary Velocity Override expressed as a percentage of the rotary velocity. Spindle Speed Override of the C Axis.	✅

Functional Group: State

Data Item	Description	Included
Execution Ready	An Execution State of the Controller identifying the machine is ready to run	✅
Execution Active	An Execution State of the Controller identifying the machine is actively running	✅
Execution Interrupted	An Execution State of the Controller identifying the machine has been interrupted	✅
Execution Feed Hold	An Execution State of the Controller identifying motion has been stopped due to Feed Hold	✅
Execution Stopped	An Execution State of the Controller identifying the controller has been stopped	✅
Execution Optional Stop	An Execution State of the Controller identifying motion has been stopped due to an Optional Stop	⛔
Execution Program Stopped	An Execution State of the Controller identifying motion has been stopped due to a Program Stop	✅
Execution Program Completed	An Execution State of the Controller identifying motion has been stopped due to the program completing execution	⛔
Controller Mode Automatic	The current mode of the Controller.	✅
Controller Mode Manual	The current mode of the Controller.	✅
Controller Mode Manual Data Input	The current mode of the Controller.	✅

Controller Mode Semi Automatic	The current mode of the Controller.	✅
Controller Mode Single Block	The current mode of the Controller.	⛔
Controller Mode Edit	The current mode of the Controller.	⛔
Emergency Stop Armed	The current state of the emergency stop signal indicating that emergency stop is not currently active	✅
Emergency Stop Triggered	The current state of the emergency stop signal indicating that emergency stop is currently active	✅
Chuck State Open	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is open.	⛔
Chuck State Closed	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is closed.	⛔
Chuck State Unlatched	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is unlatched.	⛔
Door State Open	The state of the door is currently open.	⛔
Door State Closed	The state of the door is currently closed.	⛔
Door State Unlatched	The state of the door is currently unlatched.	⛔
Functional Mode Production	The current intended production status of the device or component is production.	⛔
Functional Mode Teardown	The current intended production status of the device or component is teardown.	⛔
Functional Mode Maintenance	The current intended production status of the device or component is maintenance.	⛔
Functional Mode Process Development	The current intended production status of the device or component is process development.	⛔

Functional Group: Error

Data Item	Description	Included
Logic Program	An error occurred in the logic program or PLC (programmable logic controller).	✅
System	A CONDITION representing something that is not the operator, program, or hardware.	✅

Functional Group: Program / Parts

Data Item	Description	Included
Part Count	The current count of parts produced as represented by the Controller.	✅
Program	The name of the program being executed by the Controller component.	✅

Functional Group: Tooling

Data Item	Description	Included
Tool Number	The identifier of a tool provided by the device controller.	✅

Functional Group: Other

Data Item	Description	Included