Data Items Available Listed by Functionality Group

April 17, 2015

Machine Make: OKUMA OSP-P Control
Machine Model: P300M, P200M, P100II-M
MTConnect Version: 1.3
Adapter Version: 2.1

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 (Actual)	The feed rate of the tool path.	✅
Rotary Velocity (Actual)	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 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
<Assets> <CuttingTool> <CuttingToolLifeCycle> <CutterStatus/> <ToolLife/> <ProgramToolGroup/> <ProgramToolNumber/> <Location/> <CuttingItems> <CuttingItem> <ItemLife/> <x:ItemCutterStatus/> <x:ItemProgramToolGroup/> </CuttingItem> </CuttingItems> </CuttingToolLifeCycle> </CuttingTool> </Assets>	Assets: CuttingTool: A Cutting Tool can be a single item or an assembly of one or more Adaptive Items, a Tool Item and several Cutting Items on a Tool Item CuttingToolLifeCycle: The tool life cycle CutterStatus: The state of the tool assembly - only for Instance (not archetype) ToolLife: The life of the cutting tool assembly ProgramToolGroup: The tool group this tool is assigned in the part program ProgramToolNumber: The number used to identify this tool in the program. Location: The pocket location CuttingItems: An optional list of edges for this assembly CuttingItem: A cutting item is the portion of the tool that physically removes the material from the workpiece by shear deformation. ItemLife: The life of an edge x:ItemCutterStatus: The state of an edge x:ItemProgramToolGroup The tool group this tool edge is assigned in the part program x:ItemProgramToolNumber: The number used to identify this tool edge in the program	✅

Path Feed Rate (Programmed)	**The feed rate of the tool path.**	✅
Path Feed Rate Override	Path feed rate override (programmed)	✅
Rotary Velocity (Programmed)	The rotational speed of a rotary axis. Spindle Speed of the C Axis.	✅
Load	The measurement of the actual versus the standard rating of a device. Spindle load of the C Axis.	✅
Functional Mode Setup	The current intended production status of the device or component is setup.	✅
Line	The current line of code being executed.	✅
Block	The block of code being executed. Block contains the entire expression for a line of program code	✅