HEIDENHAIN DATA ITEMS

DataXchange Machine Monitoring Data Items

Scytec DataXchange utilizes direct connectivity to acquire data for DataXchange machine monitoring as well as Scytec DXIQ analytics and Vericut CNC Machine Connect. Below you can find the specific data items that can be collected from **Heidenhain TN640** controllers. Data can then be visualized into useful manufacturing dashboards and charts, used with DXIQ, or by Vericut CNC Machine Connect.

Data Items Collected	Data Items Description
Active Tool	The current Active Tool number
Alarm Code/Description	Alarm information including code and description
Alarm Status	Returns status of machine alarm
Capture Alarms	Returns all captured Heidenhain alarms
Connect Time	The connect time for the most recent poll
Connected Time	Returns the amount of time since a connection to the source
Controller Mode	The current Mode Selection value
Current Executing Line	Returns the line number of the code currently executing
Cycle Status	The current status of a machine
Emergency Status	Returns if a machine is currently in a E-Stop
Feed Rate Override	The current Feed Rate Override as a percentage
Path Feed Rate	The Feed Rate value of the current path
Program File	Returns the file name of the program running on the control
Program Stop (M0)	Returns true if the program has stopped due to an M0 code
Rapid Override	Returns the percentage of the Rapid Traverse Override
Spindle Override	The active Spindle Override as a percentage
Spindle Speed	Returns the speed of the specified spindle

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Scytec DXIQ and Vericut CNC Machine Connect

Specific data points are pulled from your shop floor equipment by DataXchange for use with Scytec DXIQ analytics and **Vericut CNC Machine Connect**. Below you will find the specific continuous data and the on-demand data that can be collected through the Precheck, CNC Machine Monitoring and Postcheck process in Vericut CNC Machine Connect.

Continuous Data

Automatic Mode
Cycling
Handwheel (Jog) Mode
Idle
Manual Mode
MDI Mode
Reference Point
Single Block