

OKUMA 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 **OKUMA OSP-P300, OSP-P300A and OSP-P500** controls. Data can then be visualized into useful manufacturing dashboards and charts, used with analytics, or by Vericut CNC Machine Connect.

Data Items Collected

- Active Tool**
- Alarm Information**
- Coolant**
- Current Block**
- Cycle Status**
- Dry Run**
- Emergency Status**
- Feed Hold Status**
- Feed Rate Override**
- Input/Output Data (Bit, Word, Long Word)**
- Mode Selection**
- Optional Block Skip**
- Optional Stop or Program Stop**
- Part Count**
- Part Number**
- Path Feed Rate**
- Program Comment**
- Program File Name**
- Main Program Number**
- Active Program Number**
- Rapid Override**
- Single Block Status**
- Spindle Load Percent**
- Spindle Override**
- Spindle Speed**
- Common Variable**

Data Items Description

- The current active tool number
- Alarm information including code and description
- Whether coolant is currently active
- The currently active program block, with/without line number
- Whether a machine is idle or cycling
- Whether the dry run setting is on or off
- Whether a machine is in an e-stop
- Whether a machine is in feed hold
- The current feed rate override represented as a percentage
- The current bit value, or 32/64 bit word value of an address
- The currently selected controller mode
- Whether block skip mode is on or off
- Determine if a program has stopped due to an M1 or M0 code
- The current part count from the specified Okuma part counter
- Search the active program header for a part number
- The current path feed rate
- Search for a specific comment in the active program
- The file name of the active program
- The current main program loaded
- The current executing program
- The current rapid override as a percentage
- Whether single block mode is currently on or off
- Spindle load as a percentage for the specified spindle
- The active spindle override as a percentage
- The current spindle speed as a value or a percentage
- The current value held by a specific common variable

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

- Active Alarms**
- Axis Feedrates**
- Axis Positions**
- Block Skip**
- Controller Mode**
- Cycle Status**
- Dry Run**
- E-Stop State**
- Executing Program Name**
- Feed Rate Override**
- Macro Variables**
- Main Program Name**
- Optional Stop or Program Stop**
- Parameters**
- Path Feedrates**
- Program Line**
- Program Stop**
- Rapid Override**
- Running State**
- Single Block**
- Spindle Load**
- Spindle Override**
- Spindle Speed**
- Sub Program Name**
- System Variables**
- Tool ID**
- Tool Offsets**
- Work Offsets**

On Demand Data

- Axis Positions**
- Individual Parameters**
- Machine Configuration**
- Main CNC Program**
- Sub CNC Programs**
- Tool Offsets**
- Common Variables**
- Work Offsets**