

## 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 iTNC 530, TNC 640 and TNC 7** controllers. Data can then be visualized into useful manufacturing dashboards and charts, used with DXIQ, or by Vericut CNC Machine Connect.

#### Data Items Collected

**Active Tool**  
**Alarm Code/Description**  
**Alarm Status**  
**Capture Alarms**  
**Connect Time**  
**Connected Time**  
**Controller Mode**  
**Current Executing Line Number**  
**Cycle Status**  
**Emergency Status**  
**Feed Rate Override**  
**Path Feed Rate**  
**Program File**  
**Program Stop (M0)**  
**Rapid Override**  
**Spindle Override**  
**Spindle Speed**

#### Data Items Description

The current Active Tool number  
Alarm information including code and description  
Returns status of machine alarm  
Returns all captured Heidenhain alarms  
The connect time for the most recent poll  
Returns the amount of time since a connection to the source  
The current Mode Selection value  
Returns the line number of the code currently executing  
The current status of a machine  
Returns if a machine is currently in a E-Stop  
The current Feed Rate Override as a percentage  
The Feed Rate value of the current path  
Returns the file name of the program running on the control  
Returns true if the program has stopped due to an M0 code  
Returns the percentage of the Rapid Traverse Override  
The active Spindle Override as a percentage  
Returns the speed of the specified spindle

## **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**