

FANUC 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 **Fanuc I series** 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 Information
Auto Status
Axis Feed Rate
Current Block
Cycle Status
Emergency Status
Feed Hold Status
Feed Rate Override
Mode Selection
Optional Stop or Program Stop
P Code Macro Variable
Part Count
Part Number
Path Feed Rate
Program Comment
Main Program Number
Active Program Number
Rapid Override
Read PMC Address
Single Block Status
Spindle Load Percent
Spindle Override
Spindle Speed
Macro Variable

Data Items Description

The current active tool number
Alarm information including code and description
Whether a machine is in a RUN, PAUSED, or RESET state
The axis feed rate of the controlled axis
The currently active program block, with/without line number
Whether a machine is idle or cycling
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 currently selected controller mode
Determine if a program has stopped due to an M1 or M0 code
The value of the specified p-code macro variable
The current part count from the part counter
The part number from a comment in the header of the NC program
The current path feed rate
Search for a specific comment in the active program
The current main program loaded
The current executing program
The rapid override setting as a percentage
The content of a PMC address range or bit value
Whether single block mode is on or off
The load on the specified spindle as a value or percentage
The active spindle override as a percentage
The current spindle speed as a value or a percentage
The current value held by a specific macro or system variable