

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