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	Data Items Description
Active Tool	The current active tool number
Alarm Information	Alarm information including code and description
Coolant	Whether coolant is currently active
Current Block	The currently active program block, with/without line number
Cycle Status	Whether a machine is idle or cycling
Dry Run	Whether the dry run setting is on or off
Emergency Status	Whether a machine is in an e-stop or not
Feed Hold Status	Whether a machine is in feed hold or not
Feed Rate Override	The current feed rate override represented as a percentage
Input/Output Data (Bit, Word, Long Word)	The current bit value, or 32/64 bit word value of an address
Mode Selection	The currently selected controller mode
Optional Block Skip	Whether block skip mode is on or off
Optional Stop or Program Stop	Determine if a program has stopped due to an M1 or M0 code
Part Count	The current part count from the specified Okuma part counter
Part Number	Search the active program header for a part number
Path Feed Rate	The current path feed rate
Program Comment	Search for a specific comment in the active program
Program File Name	The file name of the active program
Main Program Number	The current main program loaded
Active Program Number	The current executing program
Rapid Override	The current rapid override as a percentage
Single Block Status	Whether single block mode is currently on or off
Spindle Load Percent	Spindle load as a percentage for the specified spindle
Spindle Override	The active spindle override as a percentage
Spindle Speed	The current spindle speed as a value or a percentage
Common Variable	The current value held by a specific common variable

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