SIEMENS DATA ITEMS

DataXchange Machine Monitoring Data Items

Scytec DataXchange utilizes Siemens OPC UA connectivity to acquire data items 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 the **Siemens 840D Solution Line** with **SINUMERIK Operate** and **SINUMERIK ONE** 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	Returns the tool position of the active tool
Alarm Code	Returns the alarm code without the description
Alarm Status	Whether or not an alarm is active
Axis Feed Rate	Feed rate information for the specified path and axis number
Capture Alarms	Captures all alarms including those that go off simultaneously
Connect Time	The connect time for the most recent poll
Connected Time	Returns time in seconds since a successful connection
Coolant	Whether or not coolant is enabled
Current Executing Block	The currently active program block, with/without line number
Cycle Status	Whether or not machine is 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
Mode Selection	The currently selected controller mode
Rapid Override	The current rapid override as a percentage
Part Count	Returns the current part count from the Siemens part counter
Program File Name	Returns the actual file name of the program
Program Stop (M0)	Returns true if the program has stopped due to an M0 code
Options Stop (M1)	Returns true if the program has stopped due to an M1 code
Rapid Override	Returns the percentage of the rapid traverse override
Single Block Status	Whether single block mode is currently on or off
Spindle Load Meter Percent	Spindle load as a percent for the specified spindle
Spindle Override	The active spindle override as a percentage
Spindle Speed	Returns the speed of the specified spindle

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