Explanation for BD of the machines

Índice

Machine Details

Name	**BRAÑOSERA**	**TAMESA**
Number	670123	670074
DataBase ID	2207	1245
Control	Heidenhain	Heidenhain
Heads	UAD 37kW	UAD 37kV E5E 35kW
Vibration Control	X	X
Draining	3	2
ATC	Cadena 60	Pluma 40
Gauge H	S-RENISHAW NC4S	X
Gauge P	RENISHAW RMP60-Q	RPM-60 Renishaw
X	5000 mm 15.1kW	4000 mm 15.1kW
Y	1750 mm 15.1kW	1500 mm 15.1kW
Z	3750 mm 15.71kW	3000 mm 15.71kW

BD information

In the Vixion database there are several tables.

We will only use “variable”, “variable_log_float”, and “variable_log_string”.

The rest of the tables are required for Vixion’s operation, but they do not contain raw data controlled by Correa, so only the necessary tables will be described.

It is possible that some variables did not exist during certain periods of time, as they may have been added later. Therefore, the first time they appear should be taken as the reference point.

After reviewing the tables, we have detected that some data are likely to be corrupted, and we cannot guarantee their validity, since some foreign keys in certain tables refer to variables that are not of the indicated type. Consequently, the raw data from these machines are being recovered to regenerate them, and once they are ready, I will send you the new dumps so that you can reload them in phpPGAdmin.

TABLES

They are all within the ***public*** schema.

Variable

This table contains the variable names and their types. For each variable name, a description will be provided explaining its meaning and the units in which it is stored.

id: identification number used to link the recorded data.
name: variable name, which will be used to cross-reference and obtain its description and units.
datatype: type of variable as it was stored in the cloud.

variable_log_float

This table stores the raw values of numeric types. A new record is stored at the moment the value changes. As long as the variable's value remains the same, no new record is added. When the machine is turned off, the record becomes NaN.

id_var: foreign key that references the "variable" table.
date: the date is given in UTC format.
value: value taken by the variable at that moment.

variable_log_string

This table stores the raw values of string types. A new record is stored at the moment the value changes. As long as the variable's value remains the same, no new record is added. When the machine is turned off, the record becomes NaN.

id_var: foreign key that references the "variable" table.
date: the date is given in UTC format.
value: value taken by the variable at that moment.

Variables from machines

TAMESA

id	**prettyName**	**units**
SERIAL_NUMBER	Serial Number	Number
MACHINE_TYPE	Machine Type	Number
OPERATING_MODE	Operating mode	Enumeral
OP_MODE_STANDBY	Machine in standby	true:activated false:deactivated
TELESERVICE	Teleservice flag	true:activated false:deactivated
OP_MODE_OPERATIONAL_CONTROL	Working Mode operational control	true:activated false:deactivated
SPINDLE_OVERRIDE	Spindle override	1/100%
RAPIDTRAVERSE_OVERRIDE	Rapid Feed override	1/100%
FEEDRATE_OVERRIDE	Feed override	1/100%
MACHINE_EMERGENCY	Machine emergency pulsed	true:activated false:deactivated
MACHINE_STOP_ACTIVE	NC STOP active	true:activated false:deactivated

MACHINE_IN_OPERATION	Machine executing a program	true:activated false:deactivated
OP_MODE_EXCLUSIVE_AXES_M888	Working Mode Exclusive Axes M888	true:activated false:deactivated
HEAD_MENU_MAINTENANCE	Maintenance Head Menu	true:activated false:deactivated
TEMPERATURA_MOTOR_X	Axis X, engine temperature	degrees
EJE_X_UTILIZACION_MOTOR	Axis X, motor utilization	%
EJE_X_POSICION_ACTUAL_REFERENCIA	Axis X, actual reference position	micrometers
X	X encoder position	micrometers
TEMPERATURA_MOTOR_Y	Axis Y, engine temperature	degrees
EJE_Y_UTILIZACION_MOTOR	Axis Y, motor utilization	%
EJE_Y_POSICION_ACTUAL_REFERENCIA	Axis Y, actual reference position	micrometers
TEMPERATURA_MOTOR_Z	Axis Z, engine temperature	degrees
EJE_Z_POSICION_ACTUAL_REFERENCIA	Axis Z, actual reference position	micrometers
EJE_Z_UTILIZACION_MOTOR	Axis Z, motor utilization	%
Y	Y encoder position	micrometers
Z	Z encoder position	micrometers
C1	Z encoder position	micrometers
C2	Z encoder position	micrometers

TEMPERATURA_MANDRINO_1	Spindle temperature 1	degrees
MANDRINO_CONSUMO_VISUALIZADO	Spindle consumption viewed	%
MANDRINO_CONSUMO_1	Spindle 1, motor utilization	%
MANDRINO_CONSUMO_2	Spindle 2, motor utilization	%
ALARMA_ACTIVA	Alarm active	true:activated false:deactivated
MANDRINO_CAMBIO_DE_GAMA_ACTIVO	Spindle gear change active	true:activated false:deactivated
MANDRINO_GAMA_ALTA_ACTIVA	Spindle high range active	true:activated false:deactivated
MANDRINO_GAMA_BAJA_ACTIVA	Spindle high range active	true:activated false:deactivated
EJES_EN_MOVIMIENTO	Axes in motion	true:activated false:deactivated
PROG_RUN	Program Run	true:activated false:deactivated
PROG_STOPPED	Program stopped	true:activated false:deactivated
PROG_INTERRUPTED	Program interrupted	true:activated false:deactivated

PROG_FINISHED	Program finished	true:activated false:deactivated
PROG_NAME	Program selected	string
PROG_LINE	Program Block Number	Number
PROG_SUB	Program active	String
HEAD_INDEX_MOUNTED	Head index mounted	Number
TOOL_SPINDLE_NUMBER	Tool placed in the Spindle(Number)	Tool Number
TOOL_CALL	Tool Call request	true:activated false:deactivated
TOOL_DEF	Tool Def request	true:activated false:deactivated
CURRENT_TIME	Time	TIME
TOUCH_PROBE_IN_SPINDLE2	Status of touch probe in spindle 2	true:activated false:deactivated
TOOL_SPINDLE_INDEX	Tool placed in the Spindle(Index)	Tool Index
TOOL_SPINDLE_STORAGE	Tool placed in the Spindle(Pocket Number in ATC)	Tool Pocket
TOOL_SPINDLE_ATC	ATC of the Tool placed in the Spindle	ATC
TOOL_GRIPPER_MAGAZINE_NUMBER_CAD1	Tool number in gripper(magazine side, Cad1)	ATC
TOOL_GRIPPER_SPINDLE_NUMBER_CAD1	Tool number in gripper(spindle side, Cad1)	ATC
TOOL_UNLOCK_ORDER_MANUAL	Order to unlock tool manually	true:activated

		false:deactivated
TOOL_UNLOCK_ORDER_ATC	Order to unlock tool in ATC	true:activated false:deactivated
ACTIVE_TOOL	Tool name placed in spindle	String
ATC_STAGE	Atc Stage	number
ATC_MANUAL_STAGE	Atc manual Stage	number
ATC_STAGE_CAD1	Atc Stage Cad1	number
ATC_STAGE_CAD2	Atc Stage Cad2	number
ATC_STAGE_AES	Atc Stage AES	number
ATC_ACTUAL_POSITION_CAD1	Atc actual position cad1	number
ATC_REQUESTED_POSITION_CAD1	Atc requested position cad1	number
PROG_BLOCKSCAN	Program in Block Scan	true:activated false:deactivated
PROG_CANCELLED	Program canceled	true:activated false:deactivated
PROG_NAME_CORREA	Program Name	true:activated false:deactivated
FEED_PROGRAMMED_THREAD	Programed thread feed rate	mm/rev x 1.000
FEED_THREAD_ACTIVE	Status of Feed thread	true:activated false:deactivated

FEED_RAPID_ACTIVE	Status of Rapid Feeds	true:activated false:deactivated
FEED_PROGRAMMED_MINUTE	Feeds programmed per minute.	mm/min/ 1.000
FEED_CONTOUR	Actual Contour Feeds per minute	mm/min/ 1.000
HEAD_C2_TURN_ORDER	C2 body turn order	true:activated false:deactivated
HEAD_C1_TURN_ORDER	C1 body turn order	true:activated false:deactivated
HEAD_C1_POSITION_REQUESTED	Head C1 position requested	Degrees
HEAD_C2_POSITION_REQUESTED	Head C2 position requested	Degrees
ENCLOSURE_CLOSED	Enclosure closed and bloqued	true:activated false:deactivated
PRESURE_GROUP_HIGH	High Pressure Group Enabled	true:activated false:deactivated
PRESURE_GROUP_LOW	Low Pressure Group Enabled	true:activated false:deactivated
COOLANT_INTERNAL	Internal coolant activated	true:activated false:deactivated
COOLANT_EXTERNAL	External coolant activated	true:activated false:deactivated
TEMPERATURA	Temperature 1	Celsius /1.000

TEMPERATURA_PT100	Temperatura pt100 0	Celsius / 100
TEMPERATURA_ANALOGICAS_0	Temperatura analogica 0	Celsius /100
TEMPERATURA_CARNERO	Ram temperature	true:activated false:deactivated
TEMPERATURA_CARNERO_2	Ram temperature 2	true:activated false:deactivated
TEMPERATURA_BASE	Base temperature	true:activated false:deactivated
TEMPERATURA_CABEZAL	Head temperature	true:activated false:deactivated
DILATACIONES_CORRECCION_AXIAL	Dilatation axial correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL	Dilatation transversal correction	mm / 10.000
DILATACIONES_CORRECCION_AXIAL_CABEZAL_1	Dilatation head 1 axial correction	mm / 10.000
DILATACIONES_CORRECCION_AXIAL_CABEZAL	Dilatation head axial correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL_CABEZAL_1	Dilatation head 1 transversal correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL_CABEZAL_2	Dilatation head 1 transversal correction	mm / 10.000
THERMAL_COMPENSATION_ON	Thermal compensation active	true:activated false:deactivated
FUNCION_M128	Funcion M128	true:activated

		false:deactivated
FUNCION_M144	Funcion M144	true:activated false:deactivated
FUNCION_M575	Funcion M575	true:activated false:deactivated
FUNCION_M591	Funcion M591	true:activated false:deactivated
FUNCION_M592	Funcion M592	true:activated false:deactivated
EJE_Y_DISTANCIA_A_COTA	Axis Y, distance to go	mm / 1.000
EJE_X_DISTANCIA_A_COTA	Axis X, distance to go	mm / 1.000
EJE_Z__DISTANCIA_A_COTA	Axis Z, distance to go	mm / 1.000
EJE_X_AVANCES_PERMITIDOS	Axis X, feeds allowed	true:activated false:deactivated
EJE_Y_AVANCES_PERMITIDOS	Axis Y, feeds allowed	true:activated false:deactivated
EJE_Z_AVANCES_PERMITIDOS	Axis Z, feeds allowed	true:activated false:deactivated
EJE_X_EN_MOVIMIENTO	Axis X in motion	true:activated false:deactivated
EJE_Y_EN_MOVIMIENTO	Axis Y in motion	true:activated

		false:deactivated
EJE_Z_EN_MOVIMIENTO	Axis Z in motion	true:activated false:deactivated
EJE_X_EN_POSICION	Axis X in position	true:activated false:deactivated
EJE_Y_EN_POSICION	Axis Y in position	true:activated false:deactivated
EJE_Z_EN_POSICION	Axis Z in position	true:activated false:deactivated
SPINDLE_RPM	Spindle nominal RPM	rpm x 1000
MANDRINO_N_SELECIONADO	Spindle number selected	number
SPINDLE_LOAD	Spindle utilization	%
SPINDLE_TEMP	Spindle temperature	Degrees Celsius
MANDRINO_POSICION_ACTUAL	Spindle actual position	Degrees / 10.000
MANDRINO_M4_ACTIVA	Spindle in M4	true:activated false:deactivated
MANDRINO_M3_ACTIVA	Spindle in M3	true:activated false:deactivated
CONFIG_NUMERO_EJES	Config, axes number	Number
CONFIG_NUMERO_MANDRINOS	Config, spindle umber	Number
PARAMETROS_MECANIZADO	Parameters of machining	Number

EJE_4_UTILIZACION_MOTOR	Axis 4, motor utilization	%
EJE_4_POSICION_ACTUAL_REFERENCIA	Axis 4, actual reference position	micrometers
TEMPERATURA_MOTOR_4	Axis 4, engine temperature	degrees
TEMPERATURA_MOTOR_5	Axis 5, engine temperature	Degrees
EJE_5_UTILIZACION_MOTOR	Axis 5, motor utilization	%
TEMPERATURA_MOTOR_6	Axis 6, engine temperature	Degrees
EJE_5_POSICION_ACTUAL_REFERENCIA	Axis 5, actual reference position	micrometers
EJE_6_UTILIZACION_MOTOR	Axis 6, motor utilization	%
EJE_6_POSICION_ACTUAL_REFERENCIA	Axis 6, actual reference position	micrometers
TEMPERATURA_MOTOR_7	Axis 7, engine temperature	Degrees
EJE_7_UTILIZACION_MOTOR	Axis 7, motor utilization	%
EJE_7_POSICION_ACTUAL_REFERENCIA	Axis 7, actual reference position	micrometers
TEMPERATURA_MOTOR_8	Axis 8, engine temperature	Degrees
EJE_8_UTILIZACION_MOTOR	Axis 8, motor utilization	%
EJE_8_POSICION_ACTUAL_REFERENCIA	Axis 8, actual reference position	micrometers
TEMPERATURA_MOTOR_9	Axis 9, engine temperature	Degrees
EJE_9_POSICION_ACTUAL_REFERENCIA	Axis 9, actual reference position	micrometers

EJE_9_UTILIZACION_MOTOR	Axis 9, motor utilization	%
HEAD_NUMBER_MODEL_INDEX1	Head number model for index 1	Number
HEAD_NUMBER_MODEL_INDEX2	Head number model for index 2	number
CAC_INITIALIZED	Head change has been initialized	Boolean
CAC_HEAD_REQUESTED	Head requested for the change	Number
CAC_STATUS	Phase of the CAC	Number
CONVETOR_ALARM	Conveyor alarmed	true:activated false:deactivated
CONVEYOR_1_START	Conveyor 1 started	true:activated false:deactivated
CONVEYOR_2_START	Conveyor 2 started	true:activated false:deactivated
CONVEYOR_1_INVERTER	Conveyor 1 inverter started	true:activated false:deactivated
TOUCH_PROBE_MONITOR	Monitoring of the Touch Probe	true:activated false:deactivated
CONVEYOR_2_INVERTER	Conveyor 2 inverter started	true:activated false:deactivated
TOUCH_PROBE_MEASUREMENT_CICLE_ACTIVE	Status of Probe cycle	true:activated false:deactivated
TOUCH_PROBE_IN_SPINDLE1	Status of touch probe in spindle 1	true:activated

		false:deactivated
PROG_STATUS	Program status	enumeral

BRAÑOSERA

id	prettyName	units
SERIAL_NUMBER	Serial Number	Number
MACHINE_TYPE	Machine Type	Number
TELESERVICE	Teleservice flag	true:activated false:deactivated
OP_MODE_STANDBY	Machine in standby	true:activated false:deactivated
OPERATING_MODE	Operating mode	Enumeral
OP_MODE_OPERATIONAL_CONTROL	Working Mode operational control	true:activated false:deactivated
PROG_STATUS	Program status	Enumeral
OVERRIDE_SPINDLE	Spindle override	%
OVERRIDE_FEEDRATE	Feed override	%
OVERRIDE_RAPIDTRAVERSE	Rapid Feed override	%
MACHINE_EMERGENCY	Machine emergency pulsed	true:activated false:deactivated
MACHINE_STOP_ACTIVE	NC STOP active	true:activated false:deactivated
MACHINE_IN_OPERATION	Machine executing a program	true:activated

		false:deactivated
TEMPERATURE_MOTOR_X	Axis X, engine temperature	degrees
AXIS_X_MOTOR_UTILIZACION	Axis X, motor utilization	%
AXIS_X_ACTUAL_POSITION_REFERENCE	Axis X, actual reference position	micrometers
X	X encoder position	micrometers
TEMPERATURE_MOTOR_Y	Axis Y, engine temperature	Degrees
AXIS_Y_MOTOR_UTILIZATION	Axis Y, motor utilization	%
EJE_Y_ACTUAL_POSITION_REFERENCE	Axis Y, actual reference position	micrometers
Y	Y encoder position	micrometers
TEMPERATURE_MOTOR_Z	Axis Z, engine temperature	Degrees
AXIS_Z_MOTOR_UTILIZACION	Axis Z, motor utilization	%
EJE_Z_POSICION_ACTUAL_REFERENCE	Axis Z, actual reference position	micrometers
Z	Z encoder position	micrometers
C1	C1 encoder position	micrometers
C2	C2 encoder position	micrometers
TEMPERATURE_SPINDLE_1	Spindle temperature 1	Degrees
SPINDLE_LOAD_1	Spindle 1, motor utilization	%
ALARM_ACTIVE	Alarm active	true:activated

		false:deactivated
EMERGENCY_PULSED	Emergency push button active. Pilz entry.	true:activated false:deactivated
SPINDLE_GEAR_CHANGE_ACTIVE	Spindle gear change active	true:activated false:deactivated
SPINDLE_HIGH_RANGE	Spindle high range active	true:activated false:deactivated
SPINDLE_LOW_RANGE	Spindle low range active	true:activated false:deactivated
AXES_IN_MOTION	Axes in motion	true:activated false:deactivated
PROG_STOPPED	Program stopped	true:activated false:deactivated
PROG_RUN	Program Run	true:activated false:deactivated
PROG_INTERRUPTED	Program interrupted	true:activated false:deactivated
PROG_FINISHED	Program finished	true:activated false:deactivated
PROG_NAME	Program selected	String
PROG_SUB	Program active	String
PROG_LINE	Program Block Number	Number

HEAD_INDEX_MOUNTED	Head index mounted	Number
TOOL_SPINDLE_NUMBER	Tool placed in the Spindle(Number)	Tool Number
TOOL_CALL	Tool Call request	true:activated false:deactivated
TOOL_DEF	Tool Def request	true:activated false:deactivated
CURRENT_TIME	Time	TIME
HOURS_MACHINE_ON	Amount of time with the machine ON, for comparison purposes	Hours
RESTART_COUNTER	Number of times that the machine has been turn on-off	Number
POWER_OFF_FAIL_COUNTER	Number of possible power off failures	Number
EASY_LOG_NUMBER	Number for easy log message	string
EASY_LOG_MESSAGE	Register for easy log message	Text
EMERGENCY	Machine program stopped, emergency	true:activated false:deactivated
TOOL_SPINDLE_INDEX	Tool placed in the Spindle(Index)	Tool Index
TOOL_SPINDLE_STORAGE	Tool placed in the Spindle(Pocket Number in ATC)	Tool Pocket
TOOL_SPINDLE_ATC	ATC of the Tool placed in the Spindle	ATC
TOOL_GRIPPER_MAGAZINE_NUMBER_CAD1	Tool number in gripper(magazine side, Cad1)	ATC
TOOL_GRIPPER_SPINDLE_NUMBER_CAD1	Tool number in gripper(spindle side, Cad1)	ATC

TOOL_UNLOCK_ORDER_MANUAL	Order to unlock tool manually	true:activated false:deactivated
ACTIVE_TOOL	Tool name placed in spindle	String
TOOL_UNLOCK_ORDER_ATC	Order to unlock tool in ATC	true:activated false:deactivated
ATC_STAGE	Atc Stage	Number
ATC_MANUAL_STAGE	Atc manual Stage	Number
ATC_STAGE_CAD1	Atc Stage Cad1	Number
ATC_REQUESTED_POSITION_CAD1	Atc requested position cad1	Number
ATC_STAGE_AES	Atc Stage AES	Number
ATC_ACTUAL_POSITION_CAD1	Atc actual position cad1	Number
ATC_ERRORS	Number of errors related to tool changes	Number
AUTOMATIC_TOOL_CHANGES	Number of automatic tool changes	Number
MANUAL_TOOL_CHANGES	Number of manual tool changes	Number
TOOL_DEF_COUNTER	Number of TOOL DEF	Number
VERTICAL_AUTO_TOOL_CHANGES	Number of automatic tool changes with head in vertical position	Number
HORIZONTAL_AUTO_TOOL_CHANGES	Number of automatic tool changes with head in horizontal position	Number
LAST_TOOL_CHANGE_TIME	The amount of time which took the last automatic tool change	Seconds

ERROR_827_COUNTER	Number of counting errors in ATC	Number
PROG_CANCELLED	Program canceled	true:activated false:deactivated
ERROR_930_COUNTER	Number of error caused by an excess in tool change time	Number
PROG_NAME_CORREA	Program Name	true:activated false:deactivated
FEED_PROGRAMMED_THREAD	Programed thread feed rate	mm/rev / 1.000
FEED_THREAD_ACTIVE	Status of Feed thread	true:activated false:deactivated
FEED_RAPID_ACTIVE	Status of Rapid Feeds	true:activated false:deactivated
FEED_PROGRAMMED_MINUTE	Feeds programmed per minute.	mm/min / 1.000
FEED_CONTOUR	Actual Contour Feeds per minute	mm/min / 1.000
HEAD_C1_TURN_ORDER	C1 body turn order	true:activated false:deactivated
HEAD_C2_TURN_ORDER	C2 body turn order	true:activated false:deactivated
HEAD_C1_POSITION_REQUESTED	Head C1 position requested	Degrees
HEAD_C2_POSITION_REQUESTED	Head C2 position requested	Degrees
ACTIVE_NC_MACRO	Number of the active NC macro	
CYCLE_305_COUNTER	Number of times that the cycle 305 has been executed	Number

CYCLE_305_WITHOUT_ROTARY_TABLE	Number of times that the cycle 305 has been executed (without rotary table)	Number
CYCLE_305_WITH_ROTARY_TABLE	Number of times that the cycle 305 has been executed (with rotary table)	Number
CYCLE_305_WITH_VERTICAL_ROTARY_TABLE	Number of times that the cycle 305 has been executed (with vertical rotary table)	Number
CYCLE_310_COUNTER	Number of times that the cycle 310 has been executed	Number
CYCLE_310_WITH_PANEL	Number of times that the cycle 310 has been executed (with a panel)	Number
CONFIGURATION_CHANGES_COUNTER	Number of times that panels and rotary tables configuration is changed	Number
CYCLE_310_WITHOUT_PANEL	Number of times that the cycle 310 has been executed (only for preset)	Number
M629_COUNTER	Number of times that the tool probe position is modified	Number
PANEL_CONFIGURATON	Panel Configuration Meaning: -/-/-/-/-/P3/P2/P1	Number
CONFIGURATION_PT_1_AND_2	Rotary table Configuration (1-2) V2/V/H/M/V2/V/H/M	Number
CONFIGURATION_PT_3_AND_4	Rotary table Configuration (3-4) V2/V/H/M/V2/V/H/M	Number
CYCLE_351_COUNTER	RNumber of times that the cycle 351 have been executed	Number
CYCLE_350_351_COUNTER	RNumber of times that the cycle 350-351 have been executed	Number
CYCLE_381_COUNTER	Number of times that the cycle 381 has been executed	Number

CYCLE_382_COUNTER	Number of times that the cycle 382 has been executed	Number
CYCLE_397_COUNTER	Number of times that the cycle 397 has been executed	Number
CYCLE_398_COUNTER	Number of times that the cycle 398 has been executed	Number
M885_WARMING_COUNTER	Number of times that the warming cycle has been executed (for UDX type)	Number
M320_COUNTER	Number of times that the M320 has been executed	Number
CYCLE_341_WARMING_COUNTER	Number of times that the warming cycle has been executed (for E5E type)	Number
CYCLE_WARMING_LOW_TEMPERATURE	Low temperature warming cycle - Number of times	Number
CYCLE_WARMING_DAILY	Daily warming - Number of times	Number
CYCLE_WARMING_WEEK	Week type warming - Number of times	Number
ENCLOSURE_CLOSED	Enclosure closed and bloqued	true:activated false:deactivated
CYCLE_WARMING_WEEKEND	Weekend type warming - Number of times	Number
PRESURE_GROUP_HIGH	High Pressure Group Enabled	true:activated false:deactivated
PRESURE_GROUP_LOW	Low Pressure Group Enabled	true:activated false:deactivated
COOLANT_EXTERNAL	External coolant activated	true:activated false:deactivated
COOLANT_INTERNAL	Internal coolant activated	true:activated

		false:deactivated
TEMPERATURA_CARNERO	Ram temperature	true:activated false:deactivated
TEMPERATURA_CARNERO_2	Ram temperature 2	true:activated false:deactivated
TEMPERATURA_BASE	Base temperature	true:activated false:deactivated
TEMPERATURA_E5E_rod1	E5E rod1 temperature	Celsius
TEMPERATURA_E5E_rod2	E5E rod2 temperature	Celsius
TEMPERATURA_CABEZAL	Head temperature	true:activated false:deactivated
TEMPERATURA_E5E_rod3	E5E rod3 temperature	Celsius
VACUOSTATO_VACIO_CABEZAL	Vacuostato vacio cabezal	Pressure
NIVEL_TALADRINA_DEP_1	Coolant level storage 1	Pressure
E_DESBLOQUEO_HERRAMIENTA	Tool unlock input	true:activated false:deactivated
E_DESBLOQUEO_C1	C1 unlock input	true:activated false:deactivated
E_DESBLOQUEO_C2	C2 unlock input	true:activated false:deactivated
E_CAUDAL_REF1	Cooling flow input1	true:activated

		false:deactivated
E_CAUDAL_REF2	Cooling flow input2	true:activated false:deactivated
E_CAUDAL_REF1_S1	Cooling flow s1 input1	true:activated false:deactivated
E_CAUDAL_REF2_S1	Cooling flow s1 input2	true:activated false:deactivated
E_RPM_ELAX	RPM ELAX input	true:activated false:deactivated
CONSUMO_ELAX	ELAX Compsuntion	true:activated false:deactivated
SONDA_TEMP_E5E_PLATO	Temperature probe E5E plate	true:activated false:deactivated
S_TALADRINA_INTERNA_VARIABLE	Internal Coolant variable	true:activated false:deactivated
S_TALADRINA_EXTERNA_VARIABLE	External Coolant variable	true:activated false:deactivated
S_EV_CAIDA_CARNERO	Ram drop solenoid valve output	true:activated false:deactivated
S_EV_VUELCO2_CARNERO	Ram dump solenoid valve2 output	true:activated false:deactivated
S_EV_VUELCO1_CARNERO	Ram dump solenoid valve1 output	true:activated

		false:deactivated
DILATACIONES_CORRECCION_AXIAL	Dilatation axial correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL	Dilatation transversal correction	mm / 10.000
DILATACIONES_CORRECCION_AXIAL_CABEZAL_1	Dilatation head 1 axial correction	mm / 10.000
DILATACIONES_CORRECCION_AXIAL_CABEZAL	Dilatation head axial correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL_CABEZAL_1	Dilatation head 1 transversal correction	mm / 10.000
DILATACIONES_CORRECCION_TRANSVERSAL_CABEZAL_2	Dilatation head 1 transversal correction	mm / 10.000
THERMAL_COMPENSATION_ON	Thermal compensation active	true:activated false:deactivated
FUNCION_M128	Funcion M128	true:activated false:deactivated
FUNCION_M144	Funcion M144	true:activated false:deactivated
FUNCION_M575	Funcion M575	true:activated false:deactivated
FUNCION_M591	Funcion M591	true:activated false:deactivated
FUNCION_M592	Funcion M592	true:activated false:deactivated
EJE_X_DISTANCIA_A_COTA	Axis X, distance to go	mm / 1.000
EJE_Z__DISTANCIA_A_COTA	Axis Z, distance to go	mm / 1.000

EJE_Y_DISTANCIA_A_COTA	Axis Y, distance to go	mm / 1.000
EJE_X_AVANCES_PERMITIDOS	Axis X, feeds allowed	true:activated false:deactivated
EJE_Y_AVANCES_PERMITIDOS	Axis Y, feeds allowed	true:activated false:deactivated
EJE_Z_AVANCES_PERMITIDOS	Axis Z, feeds allowed	true:activated false:deactivated
EJE_X_EN_MOVIMIENTO	Axis X in motion	true:activated false:deactivated
EJE_Z_EN_MOVIMIENTO	Axis Z in motion	true:activated false:deactivated
EJE_Y_EN_MOVIMIENTO	Axis Y in motion	true:activated false:deactivated
EJE_X_EN_POSICION	Axis X in position	true:activated false:deactivated
EJE_Y_EN_POSICION	Axis Y in position	true:activated false:deactivated
EJE_Z_EN_POSICION	Axis Z in position	true:activated false:deactivated
MANDRINO_N_SELECIONADO	Spindle number selected	number
SPINDLE_RPM	Spindle nominal RPM	rpm / 1000

MANDRINO_CONSUMO_VISUALIZADO	Spindle consumption viewed	%
SPINDLE_TEMP	Spindle temperature	Degrees Celsius
MANDRINO_POSICION_ACTUAL	Spindle actual position	Degrees / 10.000
MANDRINO_M3_ACTIVA	Spindle in M3	true:activated false:deactivated
MANDRINO_M4_ACTIVA	Spindle in M4	true:activated false:deactivated
MANDRINO_PARADO_DIFERIDO	Spindle stopped	true:activated false:deactivated
MANDRINO_STATUS_POSICIONAMIENTO	Spindle pos status	true:activated false:deactivated
MANDRINO_EN_MOVIMIENTO	Spindle in motion	true:activated false:deactivated
MANDRINO_EN_TAPPING_MODE	Spindle in tapping mode	true:activated false:deactivated
MANDRINO_ORDEN_DE_PARADA	Spindle stopped order	true:activated false:deactivated
CONFIG_NUMERO_EJES	Config, axes number	Number
CONFIG_NUMERO_MANDRINOS	Config, spindle umber	Number
CAMBIO_GAMA_CONTADOR	Gear change counter	Number

CAMBIO_GAMA_CONTADOR_0	Gear change counter 0 fails	Number
CAMBIO_GAMA_CONTADOR_1	Gear change counter 1 fails	Number
CAMBIO_GAMA_CONTADOR_2	Gear change counter 2 fails	Number
CAMBIO_GAMA_CONTADOR_3	Gear change counter 3 fails	Number
CAMBIO_GAMA_CONTADOR_4	Gear change counter 4 fails	Number
CAMBIO_GAMA_SALIDA_EN_FUNCIONAMIENTO_CONTADOR	Gear change has come out, working, counter	Number
CAMBIO_GAMA_NO_RECUPERADA_EN_FUNCIONAMIENTO_CONTADOR	Gear change not recovered, working, counter	Number
ERROR_PN_CAMBIO_GAMA	Gear change has come out, working	Number
MANDRINO_CAMBIO_DE_GAMA_PEDIDO	Spindle gear change requested	Number
CAMBIO_GAMA_TIEMPO_CAMBIO_UD	Gear change change time, per change	Seconds
CAMBIO_GAMA_NUMERO_REINTENTOS_UD	Gear change retries, per change	Number
CAMBIO_GAMA_GAMA_PEDIDA	Gear change retries, per change	Number
PARAMETROS_MECANIZADO	Parameters of machining	Number
CYCLE_360_COUNTER	Number of times that the cycle 360 has been executed	Number
CYCLE_360_COUNTER_Q_11	Number of times that the cycle 360 has been executed (Param 1/1)	Number
CYCLE_360_COUNTER_Q_12	Number of times that the cycle 360 has been executed (Param 1/2)	Number
CYCLE_360_COUNTER_Q_21	Number of times that the cycle 360 has been executed (Param 2/1)	Number

CYCLE_360_COUNTER_Q_22	Number of times that the cycle 360 has been executed (Param 2/2)	Number
SEMAPHORE_RED	Semaphore, red light	Number
SEMAPHORE_GREEN	Semaphore, green light	Number
SEMAPHORE_BLUE	Semaphore, blue light	Number
EJE_W_BRAKE	Axis W, brake	true:activated false:deactivated
SAFETY_WORK_MODE	Working Safety mode active	Number
MARKER_ONE	Marker one	true:activated false:deactivated
MARKER_ZERO	Marker zero	true:activated false:deactivated
SEMAPHORE_LIGHTS	Semaphore lights	1:R, 2:G, 3:B, 4:G+W, 5:B+W
TEMPERATURA_MOTOR_4	Axis 4, engine temperature	degrees
EJE_4_UTILIZACION_MOTOR	Axis 4, motor utilization	%
EJE_4_POSICION_ACTUAL_REFERENCIA	Axis 4, actual reference position	micrometers
TEMPERATURA_MOTOR_5	Axis 5, engine temperature	degrees
EJE_5_UTILIZACION_MOTOR	Axis 5, motor utilization	%
EJE_5_POSICION_ACTUAL_REFERENCIA	Axis 5, actual reference position	micrometers
TEMPERATURA_MOTOR_6	Axis 6, engine temperature	degrees

EJE_6_UTILIZACION_MOTOR	Axis 6, motor utilization	%
EJE_6_POSICION_ACTUAL_REFERENCIA	Axis 6, actual reference position	micrometers
TEMPERATURA_MOTOR_7	Axis 7, engine temperature	degrees
EJE_7_UTILIZACION_MOTOR	Axis 7, motor utilization	%
EJE_7_POSICION_ACTUAL_REFERENCIA	Axis 7, actual reference position	micrometers
TEMPERATURA_MOTOR_8	Axis 8, engine temperature	degrees
EJE_8_UTILIZACION_MOTOR	Axis 8, motor utilization	%
EJE_8_POSICION_ACTUAL_REFERENCIA	Axis 8, actual reference position	micrometers
HEAD_NUMBER_MODEL_INDEX1	Head number model for index 1	number
CONVETOR_ALARM	Conveyor alarmed	true:activated false:deactivated
CONVEYOR_1_START	Conveyor 1 started	true:activated false:deactivated
CONVEYOR_1_INVERTER	Conveyor 1 inverter started	true:activated false:deactivated
CONVEYOR_2_START	Conveyor 2 started	true:activated false:deactivated
CONVEYOR_2_INVERTER	Conveyor 2 inverter started	true:activated false:deactivated

TOUCH_PROBE_MONITOR	Monitoring of the Touch Probe	true:activated false:deactivated
PART_MEASURING_CYCLE_ACTIVE	Status of Probe cycle	true:activated false:deactivated
TOUCH_PROBE_IN_SPINDLE1	Status of touch probe in spindle 1	true:activated false:deactivated
TOUCH_PROBE_IN_SPINDLE2	Status of touch probe in spindle 2	true:activated false:deactivated
MANDRINO_TOUCH_PROBE_NUMBER	Spindle touch probe number active	Number
MANDRINO_TOUCH_PROBE_TYPE	Spindle touch probe type active	Number
TOOL_MEASURING_CYCLE_ACTIVE	Status of Probe cycle	true:activated false:deactivated
HOURS_UAD	Hours with UAD running	Hours