|  |  |  |
| --- | --- | --- |
| cure \_ position \_: 경화 좌표 | end, standby, start  끝, 대기, 시작 | x, z, Θ |
| DISCHARGED SPEED OF RESIN: 레진 토출 속도 |  |  |
| DISCHARGED TIME OF RESIN()  : 레진 토출 시간 | stage1, stage2, stage3  CID, Seg, Cluster | 로그 |
| Dispense Volume()  : 레진 토출량 | stage1, stage2, stage3 | 로그 |
| HEAD NORMAL COORDINATE \_ AXIS(): 토출 좌표 | x, y, z | stage1, stage2, stage3 |
| HEAD \_ Position \_  토출대기좌표, 노즐클린 좌표, Resin Drain 좌표, Zero 좌표 | standby, clean, purge, zero | x, y, z |
| Machine Tact time  DAM공정소요시간 |  |  |
| PalletID |  | 로그 |
| Production Qty  : 생성된 제품 수량 |  | 로그 |
| Receip No |  | 로그 |
| \_ \_ Distance Speed | stage1, stage2, stage3 | circle1, 2, 3, 4: R 수치  line1, 2, 3, 4: 토출 스피드 |
| thickness \_ | 1, 2, 3 |  |
| workmode |  | 로그 |
| \_ Pressure \_  : 압력 | 1st, 2nd, 3rd | Collect Result, unit time, judge value 로그 |
| Chamber Temp. \_  : 온도 | Collect Result, unit time, judge value |  |

fill1 이 없는것: 빨강

fill1, fill2 둘다 없는것: 파랑

둘다 있는것: 검정

autoclave는 아래쪽

중요변수:

Workorder

Model.Suffix

Receip No

Chamber Temp

Pressure

HEAD NORMAL COORDINATE

PalletID

Production Qty

Stage1 Circle1 Distance Speed

Stage2 Line4 Distance Speed

DISCHARGED TIME OF RESIN(Stage2)

3rd Pressure Unit Time

3rd Pressure Collect Result

HEAD NORMAL COORDINATE Z AXIS(Stage1)

Stage3 Circle1 Distance Speed

DISCHARGED TIME OF RESIN(Stage1)

Stage2 Line2 Distance Speed

Stage3 Line2 Distance Speed

Stage3 Circle3 Distance Speed

HEAD NORMAL COORDINATE X AXIS(Stage1)

WorkMode

Head Zero Position Z

Dispense Volume(Stage3)

Stage2 Circle4 Distance Speed

Stage2 Line3 Distance Speed

Stage1 Line3 Distance Speed

Stage2 Line1 Distance Speed

Stage1 Line2 Distance Speed

Stage3 Line1 Distance Speed

Machine Tact time

Dispense Volume(Stage2)

Stage1 Circle3 Distance Speed

Stage1 Line4 Distance Speed

Dispense Volume(Stage1)

HEAD Standby Position X

Stage2 Circle3 Distance Speed

Stage1 Line1 Distance Speed

Chamber Temp. Judge Value\_AutoClave 0.549962

Stage3 Circle4 Distance Speed Collect Result\_Dam 0.544544

HEAD NORMAL COORDINATE Z AXIS(Stage3) Collect Result\_Dam 0.527942

HEAD NORMAL COORDINATE Z AXIS(Stage2) Collect Result\_Dam 0.499095

THICKNESS 3 Collect Result\_Dam 0.435370

Stage3 Line3 Distance Speed Collect Result\_Dam 0.432396

DISCHARGED SPEED OF RESIN Collect Result\_Dam 0.405066

Stage3 Circle2 Distance Speed Collect Result\_Dam 0.382816

THICKNESS 1 Collect Result\_Dam 0.379998

Stage2 Circle1 Distance Speed Collect Result\_Dam 0.379406

Stage2 Circle2 Distance Speed Collect Result\_Dam 0.371639

THICKNESS 2 Collect Result\_Dam 0.315354

Stage3 Line4 Distance Speed Collect Result\_Dam 0.310498

Stage1 Circle4 Distance Speed Collect Result\_Dam 0.306262

Equipment\_Dam 0.304644

DISCHARGED TIME OF RESIN(Stage3) Collect Result\_Dam 0.285048

CURE SPEED Collect Result\_Dam 0.283887

CURE START POSITION Θ Collect Result\_Dam 0.269560

Head Zero Position Y Collect Result\_Dam 0.263595

Stage1 Circle2 Distance Speed Collect Result\_Dam 0.262155

Head Purge Position X Collect Result\_Dam 0.258175

2nd Pressure Unit Time\_AutoClave 0.248835

Head Clean Position X Collect Result\_Dam 0.234304

Head Purge Position Z Collect Result\_Dam 0.222792

CURE END POSITION Z Collect Result\_Dam 0.207552

CURE START POSITION X Collect Result\_Dam 0.201704

Head Purge Position Y Collect Result\_Dam 0.174093

CURE END POSITION Θ Collect Result\_Dam 0.149504

Head Clean Position Z Collect Result\_Dam 0.131430

Head Clean Position Y Collect Result\_Dam 0.110621

Head Zero Position X Collect Result\_Dam 0.098465

CURE END POSITION X Collect Result\_Dam 0.040256

HEAD Standby Position Z Collect Result\_Dam 0.028927

HEAD Standby Position Y Collect Result\_Dam 0.011448