

MTConnect® Standard

Part 2 – Components and Data Items  
Version 1.1.0 – Draft G

Prepared for: MTConnect Institute

Prepared by: William Sobel

Prepared on: April 17, 2010

MTConnect® Specification

AMT - The Association For Manufacturing Technology (“AMT”) owns the copyright in this MTConnect® Specification. AMT grants to you a non-exclusive, non- transferable, revocable, non-sublicensable, fully-paid-up copyright license to reproduce, copy and redistribute the MTConnect® Specification, provided that you may only copy or redistribute the MTConnect® Specification in the form in which you received it, without modifications, and with all copyright notices and other notices and disclaimers contained in the MTConnect® Specification.

If you intend to adopt or implement this MTConnect® Specification in a product, whether hardware, software or firmware, which complies with the MTConnect® Specification, you must agree to the MTConnect® Specification Implementer License Agreement (“Implementer License”) or to the MTConnect® Intellectual Property Policy and Agreement (“IP Policy”). The Implementer License and IP Policy each sets forth the license terms and other terms of use for MTConnect® Implementers to adopt or implement the MTConnect® Specifications, including certain license rights covering necessary patent claims for that purpose. These materials can be found at www.MTConnect.org, or by contacting Paul Warndorf at <mailto:pwarndorf@mtconnect.hyperoffice.com>.

MTConnect® Institute and AMT have no responsibility to identify patents, patent claims or patent applications which may relate to or be required to implement a Specification, or to determine the legal validity or scope of any such patent claims brought to their attention. Each MTConnect® Implementer is responsible for securing its own licenses or rights to any patent or other intellectual property rights that may be necessary for such use, and neither AMT nor MTConnect® Institute have any obligation to secure any such rights.

The MTConnect® Specification is provided “as is” and MTConnect® Institute and AMT, and each of their respective members, officers, affiliates, sponsors and agents, make no representation or warranty of any kind relating to these materials or to any implementation of the MTConnect® Specification in any product, including, without limitation, any express or implied warranty of noninfringement, merchantability, or fitness for particular purpose, or of the accuracy, reliability, or completeness of information contained herein. In no event shall MTConnect® Institute or AMT be liable to any user or implementer of the MTConnect® Specification for the cost of procuring substitute goods or services, lost profits, loss of use, loss of data or any incidental, consequential, indirect, special or punitive damages or other direct damages, whether under contract, tort, warranty or otherwise, arising in any way out of access, use or inability to use the MTConnect® Specification or other MTConnect® Materials, whether or not they had advance notice of the possibility of such damage.

Table of Contents

1 Overview 1

1.1 MTConnect® Document Structure 1

2 Purpose of This Document 2

2.1 Terminology 2

2.2 Terminology and Conventions 4

3 Devices and Components 5

3.1 Devices 6

3.1.1 Device 6

3.1.1.1 Device Attributes 6

3.1.1.2 Device Structure 9

3.2 Component 9

3.3 Component Schema 10

3.3.1 Common Component Attributes 10

3.3.2 Component Elements 11

3.3.2.1 Description 11

3.3.2.2 Components 11

3.3.2.3 DataItems 12

3.4 Types of Components 12

3.4.1 Axes 12

3.4.2 Controller 14

3.4.2.1 Path 14

3.4.3 ~~Power~~  DEPRECATED 14

3.4.4 Door 14

3.4.5 Actuator 14

3.4.6 Sensors 15

3.4.6.1 Pressure 15

3.4.6.2 Thermostat 15

3.4.6.3 Vibration 15

3.4.7 Systems 15

3.4.7.1 Hydraulic 15

3.4.7.2 Pneumatic 15

3.4.7.3 Coolant 15

3.4.7.4 Lubrication 15

3.4.7.5 Electric 15

4 Data Items 16

4.1 DataItem Element 17

4.1.1 Data Item Attributes 17

4.1.2 Data Item Elements 18

4.1.2.1 Constraints Elements 18

4.1.3 Data Item attribute: category 19

4.1.4 Data Item attribute: coordinateSystem 19

4.1.5 Data Item attribute: units 20

4.1.6 Data Item attribute: nativeUnits 21

4.2 Types and Subtypes of Data Items 22

4.2.1 Data Item Types for SAMPLE Category 24

4.2.2 Data Item Types for EVENT Category 26

4.2.3 Data Item Types for CONDITION Category 27

5 Component and Data Item Relationships 28

5.1 Overview 28

5.2 Device 28

5.2.1 DataItem types 28

5.2.2 Sub-components of Device 28

5.3 Common Components and Data Items 28

5.3.1 Axes 28

5.3.1.1 DataItem types 28

5.3.1.2 Sub-components of Axes 29

5.3.2 Linear 29

5.3.2.1 DataItem types 29

5.3.2.2 Condition types 29

5.3.3 Rotary 29

5.3.3.1 DataItem types 29

5.3.3.2 Condition types 29

5.3.4 Controller 30

5.3.4.1 Sub-components of Controller 30

5.3.4.2 DataItem types 30

5.3.4.3 Condition types 30

5.3.5 Path 30

DataItem types 30

5.3.5.1 Condition types 31

~~5.3.6~~ ~~Power~~ DEPRECATED 31

~~5.3.6.1~~ ~~DataItem types~~ 31

~~5.3.6.2~~ ~~Condition types~~ 31

5.3.7 Thermostat 31

5.3.7.1 DataItem types 32

5.3.7.2 Condition types 32

5.3.8 Vibration 32

5.3.8.1 DataItem types 32

5.3.8.2 Condition types 32

5.3.9 Pressure 32

5.3.9.1 DataItem types 32

5.3.9.2 Condition types 32

5.3.10 Door 32

5.3.10.1 DataItem types 32

5.3.11 Actuator 32

5.3.11.1 DataItem types 32

5.3.11.2 Condition types 33

5.3.12 Systems 33

5.3.12.1 Sub-components of Systems 33

5.3.13 Hydraulic 33

5.3.13.1 DataItem types 33

5.3.13.2 Condition types 33

5.3.14 Coolant 33

5.3.14.1 DataItem types 33

5.3.14.2 Condition types 33

5.3.15 Lubrication 34

5.3.15.1 DataItem types 34

5.3.15.2 Condition types 34

5.3.16 Electric 34

5.3.16.1 DataItem types 34

5.3.16.2 Condition types 34

~~5.4~~ ~~Cutting Machine Tool Components and Data Items~~ 34

5.4.1 Spindle - DEPRECATED 34

~~5.4.1.1~~ ~~DataItem types~~ 34

6 Annotated XML Examples 35

6.1 Simplest Device 35

6.2 More Complex Example of probe 36

Appendices 39

A. Bibliography 39

B. Machine Tool Modeling 41

B.1. Vertical Three Axis Mill 41

B.2. Two Axis Lathe 43

B.3. HyperQuadrex 45

Table of Figures

Figure 1: Example Devices Structure 5

Figure 2: Device Schema Diagram 9

Figure 3: Component Schema 10

Figure 4: Axes Example With Three Linear Axes and one Rotary Axis 12

Figure 5: Right Hand Rule Coordinate Planes 13

Figure 6: Rotational Right Hand Rule 13

Figure 7: DataItem Schema Diagram 16

Figure 8: Constraints Schema 18

Figure 9: Three Axis Mill 41

Figure 10: Two Axis Lathe 43

# Overview

MTConnect® is a standard based on an open protocol for data integration. MTConnect® is not intended to replace the functionality of existing products, but it strives to enhance the data acquisition capabilities of devices and applications and move toward a plug-and-play environment to reduce the cost of integration.

MTConnect® is built upon the most prevalent standards in the manufacturing and software industry, maximizing the number of tools available for its implementation and providing the highest level of interoperability with other standards and tools in these industries.

To facilitate this level of interoperability, a number of objectives are being met. Foremost is the ability to transfer data via a standard protocol which includes:

* + A device identity (i.e. model number, serial number, calibration data, etc.).
  + The identity of all the independent components of the device.
  + Possibly a device’s design characteristics (i.e. axis length, maximum speeds, device thresholds, etc.).
  + Most importantly, data captured in real or near-real-time (i.e. current speed, position data, temperature data, program block, etc.) by a device that can be utilized by other devices or applications (e.g. utilized by maintenance diagnostic systems, management production information systems, CAM products, etc.).

The types of data that may need to be addressed in MTConnect® could include:

* + Physical and actual device design data
  + Measurement or calibration data
  + Near-real-time data from the device

To accommodate the vast amount of different types of devices and information that may come into play, MTConnect® will provide a common high-level vocabulary and structure.

The first version of MTConnect® will focus on a limited set of the characteristics mentioned above that were selected based on the fact that they can have an immediate affect on the efficiency of operations.

## MTConnect® Document Structure

The MTConnect® specification is subdivided using the following scheme:

Part 1: Overview and Protocol – Version 1.1.0, Draft G

Part 2: Components and Data Items – Version 1.1.0, Draft G

Part 3: Streams, Events, Samples, and Condition – Version 1.1.0, Draft G

Extensions to the standard will be made according to this scheme and new sections will be added as new areas are addressed. Documents will be named as follows: MTC\_Part\_<Number>\_<Description>.doc. All documents will be developed in Microsoft® Word format and released in Adobe® PDF format. For example, this document is MTC\_Part\_1\_Overview.doc.

# Purpose of This Document

The three MTConnect® documents are intended to:

* define the MTConnect® standard;
* specify the requirements for compliance with the MTConnect® standard;
* provide engineers with sufficient information to implement Agents for their devices;
* provide developers with the necessary guidelines to use the standard to develop applications.

Part 2 of the MTConnect® standard focuses on structure and description of what information is available from the device. The actual device state is not provided in this section, but is covered in Part 3 covering streams, samples, and events. The descriptive data is similar to the schema of the data, it describes the components available in a device and what data items are provided by each component.

This part also covers instructions on how a piece of equipment should be modeled, the structure of the component hierarchy, the names for each component (if restricted), and allowable data items for each of the component. Some components, like Linear axis, use the naming conventions as laid out in this document. This allows for a consistent meaning across devices.

## Terminology

**Adapter** An optional software component that connects the Agent to the Device.

**Agent** A process that implements the MTConnect® HTTP protocol, XML generation, and MTConnect protocol.

**Alarm** An alarm indicates an event that requires attention and indicates a deviation from normal operation.

**Application** A process or set of processes that access the MTConnect® Agent to perform some task.

**Attribute** A part of an element that provides additional information about that element. For example, the name element of the Device is given as <Device **name=“mill-1”**>...</Device>

**CDATA** The text in a simple content element. For example, *This is some text*, in <mt:Alarm ...>This is some text</mt:Alarm>.

**Component** A part of a device that can have sub-components and data items. A component is a basic building block of a device.

**Controlled Vocabulary** The value of an element or attribute is limited to a restricted set of possibilities. Examples of controlled vocabularies are country codes: US, JP, CA, FR, DE, etc…

**Current** A snapshot request to the Agent to retrieve the current values of all the data items specified in the path parameter. If no path parameter is given, then the values for all components are provided.

**Data Item** A data item provides the descriptive information regarding something that can be collected by the Agent.

**Device** A piece of equipment capable of performing an operation. A device is composed of a set of components that provide data to the application. The device is a separate entity with at least one Controller managing its operation.

**Discovery** Discovery is a service that allows the application to locate Agents for devices in the manufacturing environment. The discovery service is also referred to as the *Name Service.*

**Element** An XML element is the central building block of any XML Document. For example, in MTConnect® the Device element is specified as <**Device** >...</**Device**>

**Event** An event represents a change in state that occurs at a point in time. Note: An event does not occur at predefined frequencies.

**HTTP** Hyper-Text Transport Protocol. The protocol used by all web browsers and web applications.

**Instance** When used in software engineering, the word *instance* is used to define a single physical example of that type. In object-oriented models, there is the class that describes the thing and the instance that is an example of that thing.

**LDAP** Lightweight Directory Access Protocol, better known as Active Directory in Microsoft Windows. This protocol provides resource location and contact information in a hierarchal structure.

**MIME** Multipurpose Internet Mail Extensions. A format used for encoding multipart mail and http content with separate sections separated by a fixed boundary.

**Probe** A request to determine the configuration and reporting capabilities of the device.

**REST** REpresentational State Transfer. A software architecture where the client and server move through a series of state transitions based solely on the request from the client and the response from the server.

**Results** A general term for the Samples, Events, and Condition contained in a ComponentStream as a response from a sample or current request.

**Sample** A sample is a data point from within a continuous series of data points. An example of a Sample is the position of an axis.

**Socket** When used concerning interprocess communication, it refers to a connection between two end-points (usually processes). Socket communication most often uses TCP/IP as the underlying protocol.

**Stream** A collection of events and samples organized by devices and components.

**Service** An application that provides necessary functionality.

**Tag** Used to reference an instance of an XML element.

**TCP/IP** TCP/IP is the most prevalent stream-based protocol for interprocess communication. It is based on the IP stack (Internet Protocol) and provides the flow-control and reliable transmission layer on top of the IP routing infrastructure.

**URI** Universal Resource Identifier. This is the official name for a web address as seen in the address bar of a browser.

**UUID** Universally unique identifier.

**XPath** XPath is a language for addressing parts of an XML Document. See the XPath specification for more information. <http://www.w3.org/TR/xpath>

**XML** Extensible Markup Language. <http://www.w3.org/XML/>

**XML Schema** The definition of the XML structure and vocabularies used in the XML Document.

**XML Document** An instance of an XML Schema which has a single root element and conforms to the XML specification and schema.

**XML NMTOKEN** The data type for XML identifiers. It must start with a letter, an underscore “\_” or a colon “:” and then it **MUST** be followed by a letter, a number, or one of the following “.”, ”-“, ”\_”, “:”. An NMTOKEN cannot have any spaces or special characters.

## Terminology and Conventions

Please refer to Part 1 “Overview and Protocol” Section 2 for XML Terminology and Documentation conventions.

# Devices and Components

A device can be thought of as a group of components. For example, Figure 1 illustrates a mill Device. The mill has the following components: every device in MTConnect® **MUST** have an Availability data item; availability represents the devices ability to provide information about itself. The mill also has sub-components of the Axes component; there are the three Linear axes and one Rotary axis representing the spindle. The Controller component controls the axes and runs the program using a single Path component.

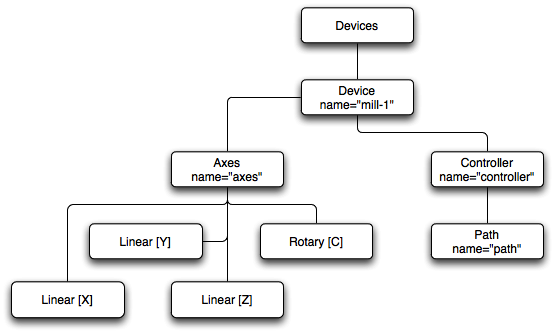


Figure : Example Devices Structure

Multiple devices may be represented in a top level container element called Devices. These container elements have no additional attributes and are only used to group sub-elements together. There are three containers used in the MTConnectDevices document. The first is the Devices container holding all Device elements. The next container is Components that groups all the subcomponents together, like the Linear and Rotary axes. The last container is DataItems that groups all data items for a component together.

In the following document structure:  
 MTConnectDevices  
 Devices  
 Device  
 Components  
 Axes  
 Components  
 Rotary [C]

Values SPINDLE  
 Linear [X]  
 DataItems  
 DataItem [Xpos]  
 Linear [Y]  
 DataItems  
 DataItem [Ypos]  
 Linear [Z]  
 DataItems  
 DataItem [Zpos]  
  
 Controller

Components

Path  
 DataItems  
 DataItem [mode]  
 DataItem [execution]

These containers make it easier to address individual parts of the XML document. For example, if one wanted to retrieve just the DataItems for the Controller you can express this using the following XPath: //Controller/DataItems/\*. If you were interested in retrieving only the subcomponets of the Axes component, you would write the following XPath: //Axes/Components/\*.

All Devices, Components, and DataItems require an id attribute. The id attribute must adhere to the w3c standard ID-type and must be unique within the entire XML document. The id attributes **MUST** start with a :, \_, or letter (A-Z, a-z) and then may be followed with numbers, letters, -, or a period (.). For more information see: http://www.w3.org/TR/REC-xml/#NT-Name.

## Devices

The Devices element is a top level container for every Device returned from a probe request. Devices is a similar container to Components except it may only contain elements of type Device.

| **Elements** | **Description** | **Occurrence** |
| --- | --- | --- |
| Device | The root of each device. The Device is contained within the top level Devices container. There can be multiple Device elements. | 1..INF |

### Device

A Device is a component that holds all the components associated with this piece of equipment. The Device **MUST** have an Availablity data item that indicates if this device is available to provide information.

#### Device Attributes

**DEPRECATION WARNING:** The ISO 841 classification is being deprecated in the next release to be replaced with a more current ontology of machine types.

| **Attribute** | **Description** | **Occurrence** |
| --- | --- | --- |
| iso841Class | **DEPRECATION WARNING**: The ISO 841 classification for the device. | 0..1 |
| uuid | A unique identifier that will only refer to this component. For example, this can be the manufacturer code and the serial number. The uuid should be alphanumeric and not exceeding 255 characters. An NMTOKEN XML type. | 0..1\* |
| name | The name of the component. This name should be unique within the machine to allow for easier data integration. An NMTOKEN XML type. | 1 |
| nativeName | The name the device manufacturer assigned to the component. If the native name is not provided it **MUST** be the name. | 0..1 |
| id | The unique identifier for this component in the document. An id must be unique across all the id attributes in the document. An XML ID-type. | 1 |
| sampleRate | The rate in seconds that data is obtained from the component. This is the number of milliseconds between data captures. If the sample rate is smaller than one millisecond, the number can be represented as a floating point number. For example, for one 100 microsecond sample rate would be 0.1. | 0..1\*\* |
| name |  |  |

A device **MAY** be classified using one of the following identifiers from the ISO 841 specification (this will be deprecated in the next version of the specification). The following classification is taken from the appendix of the ISO 841 specification, please use the diagram that best matches the figures in the appendix of ISO 841. If there is no diagram that matches the device, use iso841Class=”1”. Please provide us with a diagram of your device and its respective components and we will attempt to create a new classification for the device.

| **MTC ISO 841 Classification** | **Description** | **Figure** |
| --- | --- | --- |
| 1 | Other (Device not included in list) |  |
| 2 | Parallel lathe (engine lathe) | A.2 |
| 3 | Twin turret lathe with programmable tailstock | A.3 |
| 4 | Vertical turning and boring lathe | A.4 |
| 5 | Milling machine with horizontal spindle | A.5 |
| 6 | Milling machine with vertical spindle (with W axis) | A.6 |
| 7 | Boring and milling machine with horizontal spindle | A.7 |
| 8 | Milling machine with vertical spindle | A.8 |
| 9 | Portal-type milling machine | A.9 |
| 10 | Gantry-type milling machine | A.10 |
| 11 | Planer-type horizontal boring machine | A.11 |
| 12 | Profile and contouring milling machine with movable table | A.12 |
| 13 | Profile and contour milling machine with horizontal spindle | A.13 |
| 14 | Profile and contour milling machine with tilting head | A.14 |
| 15 | Profile and contour milling machine with tilting table | A.15 |
| 16 | External cylindrical grinding machine | A.16 |
| 17 | Tool and cutter grinding machine | A.17 |
| 18 | Openside planer | A.18 |
| 19 | Vertical filament winding machine | A.19 |
| 20 | Horizontal filament winding machine | A.20 |
| 21 | Flame cutting machine | A.21 |
| 22 | Punch press | A.22 |
| 23 | Drafting machine | A.23 |
| 24 | Right-hand tube bender | A.24 |
| 25 | Surface grinding machine with vertical grinding wheel | A.25 |
| 26 | Cavity sinking EDM machine | A.26 |
| 27 | Surface grinding machine | A.27 |
| 28 | Coordinate measuring machine | A.28 |
| 29 | Press brake | A.29 |
| 30 | Wire electrical discharge machine | A.30 |
| 31 | Laser cutting machine | A.31 |
| 32… | Reserved for future use. |  |

#### Device Structure



Figure : Device Schema Diagram

## Component

The Agent needs to be capable of delivering data associated with each component to an application. The description of these pieces of information is referred to as DataItems and will be discussed in the section 4 of this document. The actual values for those data items are delivered in Streams and will be discussed in Part 3 of the standard on *Streams, Samples, and Events*.

## Component Schema



Figure : Component Schema

### Common Component Attributes

Every component has the following composition:

| **Attribute** | **Description** | **Occurrence** |
| --- | --- | --- |
| uuid | A unique identifier that will only refer to this component. For example, this can be the manufacturer code and the serial number. The uuid should be alphanumeric and not exceeding 255 characters. An NMTOKEN XML type. | 0..1\* |
| name | The name of the component. This name should be unique within the machine to allow for easier data integration. An NMTOKEN XML type. | 1 |
| nativeName | The name the device manufacturer assigned to the component. If the native name is not provided it **MUST** be the name. | 0..1 |
| id | The unique identifier for this component in the document. An id must be unique across all the id attributes in the document. An XML ID-type. | 1 |
| sampleRate | The rate in seconds that data is obtained from the component. This is the number of milliseconds between data captures. If the sample rate is smaller than one millisecond, the number can be represented as a floating point number. For example, for one 100 microsecond sample rate would be 0.1. | 0..1\*\* |

Notes: \* The uuid **MUST** be provided for the Device, it is optional for all other components. \*\* The sampleRate is used to aid the application in interpolating values. This is the desired sample rate and may vary depending on the capabilities of the device.

### Component Elements

| **Element** | **Description** | **Occurrence** |
| --- | --- | --- |
| Description | An element that can contain any descriptive content. This can contain configuration information and manufacturer specific details. | 0..1 |
| Components | Sub-components of this component. | 0..1\* |
| DataItems | The data items this component provides. The data items are descriptions of the data events for reporting. | 0..1\* |

Notes: \*At least one of Components or DataItems **MUST** be provided.

#### Description

| **Attribute** | **Description** | **Occurrence** |
| --- | --- | --- |
| manufacturer | The name of the manufacturer of the component | 0..1 |
| serialNumber | The device’s serial number | 0..1 |
| station | The station the device is located at. When a device is part of a manufacturing unit or cell with multiple stations that share the same physical controller. | 0..1 |

The CDATA of the Description is any additional descriptive information the implementor chooses to include regarding the component. An example of a description is as follows:

<Description manufacturer="SystemInsights" serialNumber="A124FFF" station="2">

System Insights Simulated Verticle 3 Axis Machining center.

</Description>

The information can be provided for any component, for example a electrical power sensor can be defined as follows:

<Description manufacturer="Continental Control Systems LLC"   
 serialNumber="WNB-3Y-208-P-XXXX">

Advanced Pulse WattNode® RMS AC watt-hour transducer with pulse output.

</Description>

#### Components

| **Element** | **Description** | **Occurrence** |
| --- | --- | --- |
| Component | One or more components. This can also include the subtypes of Component like Axes, Linear, Thermostat, etc... | 1..INF |

#### DataItems

| **Element** | **Description** | **Occurrence** |
| --- | --- | --- |
| DataItem | Only elements of types DataItem can be specified | 1..INF |

## Types of Components

A component is an abstract type that allows for extensibility. As the specification progresses more component types will be added to support new devices and parts of new devices. Some examples of components are Axes, Controller, and Path. Any of these components can have data items and sub-components. Appendix B contains reference models for common equipment to guide developers in implementing MTConnect on their devices.

### Axes

Axes is the root of all device components that have linear or rotational motion; currently there are only Linear and Rotary axes supported and the Axes component **MUST** contain at least one Linear or Rotary axis. The Linear axes **MUST** be named X, Y, Z with numbers appended for additional axes in the same plane, for example X2, Y2, and Z2 are the secondary axes to X, Y, and Z. Rotary axes **MUST** be named A, B, and C and rotate around the X, Y, and Z axes respectively. As with the Linear axes, a number **MUST** be appended for additional axes in the same plane.

The Axes represent the physical data for the axis components and positions **MUST** be given in MACHINE coordinates. The WORK coordinates will now be represented in the Path component of the Controller.

DEPRECATION WARNING: In version 1.1 of the MTConnect® standard, the Spindle component is no longer supported. The Spindle will now be represented by a rotary axis that has a RotaryMode of SPINDLE. The S(n) axis nomenclature **SHOULD** be removed and replaced with A, B, or C to clearly identify which primary plane the spindle is rotating around. All data items **SHOULD** now be named accordingly.

*Note:* The convention for multiple linear and rotary axes having the same designation is to index the axes letter with a number. For this standard, the secondary axis number starts at 2 (i.e. X, X2, X3, … or C, C2, C3, C4, …). This is in compliance with the ISO-841-2001. Please refer to that specification for more details.



Figure : Axes Example With Three Linear Axes and one Rotary Axis

**Linear** A linear axis represents the movement of a physical device, or a portion of a device, in a straight line. Movement may be in either a positive or negative direction.

**Rotary** An axis whose function is to provide rotary motion either for the purpose of continuous rotation (i.e. spindle mode), for continuous-path contour cutting in a rotary direction or for repositioning (i.e. indexing) different faces of the part, for example, the purpose of metal removal. A rotary axis can operate in one of the three following modes: SPINDLE, INDEX, or CONTOUR.

MTConnect utilizes the right hand rule for all coordinate systems representing physical space and orientation within a machine. The positive movement is given by extending the first three fingers on the right hand and labeling the axes in order of the digits, X, Y, and Z. The fingers will point in the positive direction. All Linear axes **MUST** represent a space within a machine that is defined by coordinates according to the right hand rule.



Figure : Right Hand Rule Coordinate Planes

For Rotary axes, the thumb points in the direction of the output of the rotary motion. All rotational angles and movement **MUST** be given according to the right hand rule for Rotary axes.

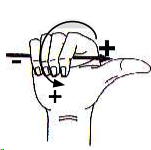


Figure : Rotational Right Hand Rule

### Controller

The Controller component represents an intelligent device, a CNC (Computer Numerical Control) or PAC (Programmable Automation Control) which has been referred to as a *Motion Control* or *General Purpose Motion Control*. The Control provides information regarding the execution of a control program and the execution state of the device. There are no required sub-components of the Controller.

Note: Version 1.1.0 implementations **SHOULD** use a Path sub-component to represent an individual tool path and execution state. (see Path). When the machine is capable of executing more than one simultaneous program, the implementation **MUST** use the Path components.

#### Path

For more complex devices and controllers, each path will be represented by a Path component. A Path represents the motion of a control point as it moves through space as controlled by a set of control instructions (i.e. vector move). The Path will encapsulate the position, feedrate, and rotation of the control point as presented by the controller. The control point is the positioning of a tool at a point in space.

If the controller is capable of running more than one task simultaneously, a Path component **MUST** be given for each task under the Controller component.

### ~~Power~~ DEPRECATED

**NOTE:** Power as an indication of availability will be changed to the data item AVAILABILITY and electrical current and power consumption will be represented by the Electric system, see *Electric* below.

~~The Power component is provided to report on the power status and possibly the voltage associated with its parent component. The device~~ **~~MUST~~** ~~contain a Power component and the Power component~~ **~~MUST~~** ~~contain the POWER\_STATE data item. Any other data items~~ **~~MAY~~** ~~be added. Any other component, such as a Rotary, that can be switched on or off separately from the Device~~ **~~SHOULD~~** ~~have a Power component if this information is available.~~

~~Power~~ **~~MUST~~** ~~have a value of ON if the device is reachable and its power indicator is ON. A status of OFF means the power supply to the device has been disconnected. The one exception to this rule is if the Computer controller on the device is powered on but the rest of the device is powered off. In this case the device power status will still be considered OFF.~~

### Door

This component represents a door closure that can be opened or closed. It **MUST** have a data item DoorState to indicate if it is opened or closed.

### Actuator

An actuator is a mechanical device for moving or controlling a mechanism or system. It takes energy, usually transported by air, electric current, or liquid, and converts it into some kind of motion. (Wikipedia).

### Sensors

Sensors are components that may or may not be integral to a parent component or device. They can be external to the device and can be moved from one device to another. They **MAY** have their own uuid so they can be tracked throughout their lifetime.

#### Pressure

A sensor or instrument used to measure the force exerted by a liquid or gas.

#### Thermostat

A sensor or instrument used to measure temperature.

#### Vibration

A sensor or instrument used to measure the amount and/or frequency of vibration within a system.

### Systems

A component similar to axes that groups sub-components that comprise complex parts that are not easily deconstructed. The systems will be used to represent general information about the health and viability of all the parts.

#### Hydraulic

A hydraulic system comprises all the parts involved in moving and distributing pressurized liquid for the purpose of a delivering a source of power to specific types of actuators.

#### Pneumatic

A pneumatic system comprises all the parts involved in moving and distributing pressurized gas regardless of purpose or activity.

#### Coolant

The coolant system comprises all the parts involved in distribution and management of coolants.

#### Lubrication

The lubrication system comprises all the parts involved in distribution and management of the lubricants.

#### Electric

The electric system represents the main power supply or generator for the device. The electric system will provide all the data with regard to current, voltage, and frequency.

# Data Items

A DataItem describes a piece of information that can be collected from a component. The data item **MUST** specify the type of data being collected, the id of the data item, and the category of the item. There will only be one category for each type, but it **MUST** be included to aid the application in determining the location for the data stream. The data item **MAY** specify a Source sub-element to provide the native name for the data feed.



Figure : DataItem Schema Diagram

A DataItem **MAY** also specify the subType, to further qualify the type of data being requested. Subtypes are required for certain data items. For example, the POSITION has two subtypes: ACTUAL and COMMANDED. These are two separate data items that can be reported independently. See section 4.2.1 for a complete list of type/subtype relations.

The units **MUST** be specified for any data item with category Sample. The nativeUnits **MAY** be specified if they apply to the type of data and if they differ from the units. The Agent is responsible for converting the nativeUnits to the units before sending them to the applications. In addition, nativeUnits **MAY** be scaled using the nativeScale attribute; for example, if the device measures velocity in 100 ft/min, MTConnect® would represent it with the following attributes: nativeUnits=“FEET/MINUTE” and nativeScale=“100”.

## DataItem Element

### Data Item Attributes

| **Attribute** | **Description** | **Occurrence** |
| --- | --- | --- |
| id | The unique identifier for this data item. The id attribute must be unique across the entire document including the ids for components. An XML ID-type. | 1 |
| name | The name of the data item. A name is provided as an additional human readable identifier for this data item in addition to the id. It is not required and will be implementation dependent. The identity of this data item is the type and sub-type. An NMTOKEN XML type. | 0..1 |
| type | The type of data being measured. Examples of types are POSITION, VELOCITY, ANGLE, CODE, BLOCK, SPINDLE\_SPEED, etc. | 1 |
| subType | A sub-categorization of the data item type. For example, the subtypes of POSITION are ACTUAL and COMMANDED. Not all types have subtypes and this can be left off. | 0..1 |
| category | This is how the data item will be sampled. The available options are SAMPLE, EVENT, or CONDITION. | 1 |
| nativeUnits | The native units used by the component. These units will be converted before they are delivered to the application. | 0..1 |
| units | The units delivered to the application. These will always be the same for this data item type. This **MUST** be specified for all numeric values. | 0..1 |
| nativeScale | The multiplier for the native units. The received data **MAY** be divided by this value before conversion. If provided the value **MUST** be numeric. | 0..1 |
| significantDigits | The number of significant digits in the reported value. This is used by applications to determine accuracy of values. This **SHOULD** be specified for all numeric values. | 0..1 |
| coordinateSystem | The coordinate system being used. | 0..1 |

### Data Item Elements

| **Element** | **Description** | **Occurrence** |
| --- | --- | --- |
| Source | Source is an optional element that contains the long name of the data item if it is too complex for the name attribute. For example, if we want to name the data item Xact, but the axis position is delivered from the device as Axis.channel.0.position, Source is used to provide the mapping. If the source is not specified, it will be assumed to be the same as the name. | 0..1 |
| Constraints | The set of possible values this data item can be assigned. This provides a way to specify the capabilities for this component by limiting the choices. For example, for ROTARY\_MODE the axis can be limited to SPINDLE for an axis that can only spin. | 0..1 |

#### Constraints Elements



Figure : Constraints Schema

| **Element** | **Description** | **Occurrence** |
| --- | --- | --- |
| Value | A constraint on the possible values for this data item. If there is only one value listed here, the value data item will be constant. In the case of a constant data item, the value is not required to be supplied in the streams document. | 0..INF |
| Maximum | The maximum value for this data item. This will be the bounded upper range. This will only be relevant when the data item has a numeric type. | 0..1 |
| Minimum | The minimum value for this data item. This will be the bounded lower range. This will only be relevant when the data item has a numeric type. | 0..1 |

### Data Item attribute: category

MTConnect® provides three different categories of data items, SAMPLE, EVENT, and CONDITION. The category will indicate where the results will be reported in the XML Document as a response to a sample or current request. See Part 3 section 3 on *Streams, Samples, and Events* for more information.

**SAMPLE** A Sample is the reading of the value of a continuously variable or analog data item. A continuous value can be sampled at any point-in-time and will always product a result. An example of a continuous data item is the Rotary C axis spindle speed. Sample data items that are continuous are always scalar floating point or integers that can have an infinite number of possible values. This is different from state or discrete data items that have a limited number of possible values. Samples **MUST** have units.

**EVENT** An Event comprises discrete information from the device. There are two types of events: those representing state, with two or more discrete values, and those representing messages that contain plain text data. An example of a state event is a DoorStatus that can be either OPEN or CLOSED. An example of a message is a PROGRAM that can be any valid string of numbers. Events do not have intermediate values that vary over time, as do Samples. Events can be thought of as streaming information that if taken at any point in time represents the current state of the device.

**CONDITION** A data item that communicates the device’s health and ability to function. A condition can be one of Unavailable, Normal, Warning, or Fault and there can be multiple active condition at one time whereas a sample or event can only have a single value at one point in time.

### Data Item attribute: coordinateSystem

A data item can specify an optional coordinate system that is being used. If not specified, the Axes coordinates **MUST** be MACHINE and the Path coordinates **MUST** be WORK. The possible values of coordinates are:

**MACHINE** An unchangeable coordinate system that has machine zero as its origin.

**WORK** The coordinate system that represents the working area for a particular workpiece whose origin is shifted within the MACHINE coordinate system. If the WORK coordinates are not currently defined in the device, the MACHINE coordinates will be used.

### Data Item attribute: units

| **Unit** | **Description** |
| --- | --- |
| AMPERE | Amps |
| CELCIUS | Degrees Celsius |
| COUNT | A counted event |
| DEGREE | Angle in degrees |
| DEGREE/SECOND | Degrees per second |
| DEGREE/SECOND^2 | Acceleration in degrees per second squared |
| HERTZ | Frequency measured in cycles per second |
| JOULE | A measurement of energy. |
| KILOGRAM | Kilograms |
| LITER | Liters |
| LITER/SECOND | Liters per second |
| MILLIMETER | Millimeters |
| MILLIMETER/SECOND | Millimeters per second |
| MILLIMETER/SECOND^2 | Acceleration in millimeters per second squared |
| MILLIMETER\_3D | A point in space identified by X, Y, and Z positions and represented by a space delimited set of numbers each expressed in millimeters. |
| NEWTON | Force in Newtons |
| NEWTON\_METER | Torque, a unit for force times distance. The SI units will be used. |
| PASCAL | Pressure in Newtons per square meter |
| PERCENT | Percent |
| PH | pH is a measure of hydrogen ion concentration; a measure of the acidity or alkalinity of a solution. |
| REVOLUTION/MINUTE | Revolutions per minute |
| SECOND | A measurement of time. |
| VOLT | Volts |
| WATT | Watts |

### Data Item attribute: nativeUnits

The nativeUnits attribute adds additional values to the units values. This is the list currently supported by MTConnect® and the MTConnect® schema.

| **Unit** | **Description** |
| --- | --- |
| DEGREE/MINUTE | Rotational velocity in degrees per minute |
| FAHRENHEIT | Temperature in Fahrenheit |
| FOOT | Feet |
| FOOT/MINUTE | Feet per minute |
| FOOT/SECOND | Feet per second |
| FOOT/SECOND^2 | Acceleration in feet per second squared |
| FOOT\_3D | A point in space identified by X, Y, and Z positions and represented by a space delimited set of numbers each expressed in feet. |
| GALLON/MINUTE | Gallons per minute. |
| INCH | Inches |
| INCH/MINUTE | Inches per minute |
| INCH/SECOND | Inches per second |
| INCH/SECOND^2 | Acceleration in inches per second squared |
| INCH\_3D | A point in space identified by X, Y, and Z positions and represented by a space delimited set of numbers each expressed in inches. |
| INCH\_POUND | A measure of torque in inch pounds. |
| KILOWATT | A measurement in kilowatt. |
| KILOWATT\_HOUR | Kilowatt hours which is 3.6 mega joules. |
| MILLIMETER/MINUTE | Velocity in millimeters per minute |
| POUND | US pounds |
| POUND/INCH^2 | Pressure in pounds per square inch (PSI). |
| RADIAN | Angle in radians |
| RADIAN/SECOND | Velocity in radians per second |
| RADIAN/SECOND^2 | Rotational acceleration in radian per second squared |
| RADIAN/MINUTE | Velocity in radians per second. |
| REVOLUTION/SECOND | Rotational velocity in revolution per second |
| OTHER | Unsupported units |

## Types and Subtypes of Data Items

What follows is the association between the various types and subtypes of data items. Each data item type **MUST** be translated into a Sample or Event with the following rules: The type name will be all in capitals with an underscore (\_) between words. The element of the event or sample will be the transformation of the data item type by capitalizing the first character of each word and then removing the underscore. For example, the data item type DOOR\_STATE is DoorState, POSITION is Position, and SPINDLE\_SPEED is SpindleSpeed.

An example of this transformation between the DataItem name and the Stream element is as follows:

<Path name="path" id="p1">

<DataItems>

<DataItem type="**LINE**" category="EVENT" id="p2" subType="**ACTUAL**" name="line" />

<DataItem type="**CONTROLLER\_MODE**" category="EVENT" id="p3" name="mode" />

<DataItem type="PROGRAM" category="EVENT" id="p4" name="program" />

<DataItem type="EXECUTION" category="EVENT" id="p5" name="execution" />

<DataItem type="BLOCK" category="EVENT" id="p6" name="block" />

</DataItems>

</Path>

The transformation from the probe *(as defined in Part 1 of the standard)* to the current or sample will occur as follows. This also illustrates how the subType is also placed in the ComponentStream as well. The probe will provide the category meaning the sub-element of the ComponentStream the items will appear in. Also note how the CONTROLLER\_MODE was changed to ControllerMode in the current request below.

<ComponentStream componentId="p1" component="Path" name="path">

<Events>

<**Line** dataItemId="p2" timestamp="2009-03-04T19:45:50.458305" subType="**ACTUAL**" name="line" sequence="150651130">702</Line>

<Block dataItemId="p6" timestamp="2009-03-04T19:45:50.458305" name="block" sequence="150651134">x0.371524 y-0.483808</Block>

<**ControllerMode** dataItemId="p3" timestamp="2009-02-26T02:02:35.716224" name="mode" sequence="182">AUTOMATIC</ControllerMode>

</Events>

</ComponentStream>

### Data Item Types for SAMPLE Category

The types are given in **bold** and the subtypes are indented and in plain text.

| **Data Item type/subtype** | **Description** | **Units** |
| --- | --- | --- |
| **ACCELERATION** | Rate of change of velocity | MILLIMETER/SECOND^2 |
| **ANGULAR\_ACCELERATION** | Rate of change of angular velocity. | DEGREE/SECOND^2 |
| **ANGULAR\_VELOCITY** | Rate of change of angular position. | DEGREE/SECOND |
| **AMPERAGE** | The line current | AMPERE |
| **ANGLE** | The angular position of a component relative to the parent. | DEGREE |
| * + ACTUAL | The angular position as read from the physical component. | DEGREE |
| * + COMMANDED | The angular position computed by the controller. | DEGREE |
| **AXIS\_FEEDRATE** | The feedrate of a linear axis. | MILLIMETER/SECOND |
| * + ACTUAL | The actual federate of a linear axis. | MILLIMETER/SECOND |
| * + COMMANDED | The feedrate as specified in the program. | MILLIMETER/SECOND |
| * + OVERRIDE | The operator’s overridden value. Percent of commanded. | PERCENT |
| **DISPLACEMENT** | The displacement as measured from zero to peak | MILLIMETER |
| **FREQUENCY** | The frequency as measure in cycles per second | HERTZ |
| **~~GLOBAL\_POSITION~~**  **(DEPRECATED)** | ~~The position in three-dimensional space. The X, Y, and Z positions will be provided.~~ | ~~MILLIMETER~~ |
| * + ~~ACTUAL~~ | ~~The position of the component as read from the device.~~ | ~~MILLIMETER~~ |
| * + ~~COMMANDED~~ | ~~The position computed by the controller.~~ | ~~MILLIMETER~~ |
| **LOAD** | The load on the component. | NEWTON |
| **PATH\_FEEDRATE** | The feedrate of the tool path. | MILLIMETER/SECOND |
| * + ACTUAL | The three-dimensional feedrate derived from all components. | MILLIMETER/SECOND |
| * + COMMANDED | The feedrate as specified in the program | MILLIMETER/SECOND |
| * + OVERRIDE | The operator’s overridden value. Percent of commanded. | PERCENT |
| **PATH\_POSITION** | The current program control point or program coordinate in WORK coordinates. The coordinate system will revert to MACHINE coordinates if WORK coordinates are not available. | MILLIMETER\_3D |
| * + ACTUAL | The position of the component as read from the device. | MILLIMETER\_3D |
| * + COMMANDED | The position computed by the controller. | MILLIMETER\_3D |
| * + TARGET | The target position for the movement. | MILLIMETER\_3D |
| * + PROBE | The position provided by a probe | MILLIMETER\_3D |
| **PH** | Th measure of hydrogen ion concentration; a measure of the acidity or alkalinity of a solution. | PH |
| **PRESSURE** | The pressure on the component | PASCAL |
| **POSITION** | The position of the component. Defaults to MACHINE coordinates. | MILLIMETER |
| * + ACTUAL | The position of the component as read from the device. | MILLIMETER |
| * + COMMANDED | The position as given by the Controller. | MILLIMETER |
| * + TARGET | The target position for the movement. | MILLIMETER |
| **SPINDLE\_SPEED** | The rotational speed of the rotary axis. | REVOLUTION/MINUTE |
| * + ACTUAL | The rotational speed the rotary axis is spinning at. ROTARY\_MODE must be SPINDLE. | REVOLUTION/MINUTE |
| * + COMMANDED | The rotational speed the as specified in the program. | REVOLUTION/MINUTE |
| * + OVERRIDE | The operator’s overridden value. Percent of commanded. | PERCENT |
| **TEMPERATURE** | The temperature | CELSIUS |
| **TORQUE** | The torque | NEWTON\_METER |
| **VELOCITY** | The rate of change of position. | MILLIMETER/SECOND |
| **VOLTAGE** | The voltage | VOLT |
| **WATTAGE** | The wattage | WATT |

### Data Item Types for EVENT Category

Note: The Event does not have any units since these values are not scalars.

| **Data Item type/subtype** | **Description** |
| --- | --- |
| **~~ALARM~~** | ~~An alarm is a special data item that will report any alarm for this component. An alarm~~ **~~MUST~~** ~~be included as a DataItem for the Device~~ DEPRECATED: Replaced with CONDITION category. |
| **ACTIVE\_AXES** | The set of axes associated with a path and the controller is controlling. If this data item is not provided, it will be assumed the controller is controlling all axes. |
| **AVAILABILITY** | Represents the components ability to communicate its availability. This **MUST** be provided for the device and **MAY** be provided for all other components |
| **AXIS\_COUPLING** | Describes the way the axes will be associated to each other. This is used in conjunction with COUPLED\_AXES to indicate the way the are interacting. The possible values are: TANDEM, SYNCHRONOUS, MASTER, and SLAVE. The coupling **MUST** be view from the perspective of the axis, therefore a MASTER coupling indicates that this axis is the master of the COUPLED\_AXES. |
| **BLOCK** | The block of code being executed. The block contains the entire expression of the step in the program. |
| **~~CODE~~** | ~~The programmatic code being executed~~. DEPRECATED |
| **CONTROLLER\_MODE** | The current controller’s mode. AUTOMATIC, MANUAL, or  MANUAL\_DATA\_INPUT, or SEMI\_AUTOMATIC. |
| **COUPLED\_AXES** | Refers to the set of associated axes. The value will be a space delimited set of axes names. |
| **DIRECTION** | The rotational direction of the Axis. CLOCKWISE or COUNTER\_CLOCKWISE |
| **DOOR\_STATE** | The opened or closed state of the door. OPEN or CLOSED. |
| **EMERGENCY\_STOP** | The current state of the emergency stop actuator. RESET (the circuit is complete and the device is operating) or ENGAGED (the circuit is open and the device must cease operation). |
| **EXECUTION** | The execution status of the Controller. READY, ACTIVE, INTERRUPTED, or STOPPED |
| **LINE** | The current line of code being executed |
| MAXIMUM | The maximum line number of the code being executed. |
| MINIMUM | The minimum line number of the code being executed. |
| **MESSAGE** | An uninterpreted textual notification. |
| **PART\_COUNT** | The current count of parts produced as represented by the controller. Must be an integer value. |
| ALL | The count of all the parts produced. If the subtype is not given, this is the default. |
| GOOD | Indicates the count of correct parts made. |
| BAD | Indicates the count of incorrect parts produced. |
| **PART\_ID** | An identifier of the current part in the device |
| **PATH\_MODE** | The operational mode for this path. SYNCHRONOUS, MIRROR, or INDEPENDENT. Default value is INDEPENDENT if not specified. |
| **~~POWER\_STATUS~~** | ~~The ON or OFF status of the component.~~ DEPRECATED |
| **PROGRAM** | The name of the program being executed |
| **ROTARY\_MODE** | The mode for the Rotary axis. SPINDLE, INDEX, or CONTOUR. |
| **TOOL\_ID** | The identifier of the tool currently in use for a given path |
| **WORKHOLDING\_ID** | The identifier for the workholding currently in use for a given path |

### Data Item Types for CONDITION Category

These are items that indicate the devices' health and ability to operate. They are reported differently than Samples or Events: they **MUST** be reported as Normal, Warning, and Fault. Unlike the other two categories, a Component or Device **MAY** have values for a Condition type DataItem that has multiple concurrently active values at any point in time.

| **Data Item type/ qualifier** | **Description** |
| --- | --- |
| **ACTUATOR** | A motion servo or actuator related condition. |
| **AMPERAGE** | A high or low condition for the electrical current. |
| **COMMUNICATIONS** | A communications failure indicator. |
| **HARDWARE** | The hardware subsystem of the component operation condition. |
| **LEVEL** | Represents the level of a resource. |
| **LOAD** | Indicates the load of a component is within operating limits. |
| **LOGIC\_PROGRAM** | An error occurred in the logic program or PLC (programmable logic controller). |
| **MOTION\_PROGRAM** | An error occurred in the motion program. |
| **POSITION** | The component’s position is within operational limits. |
| **PRESSURE** | Indicates the pressure of a component is within operating limits. |
| **SYSTEM** | A condition representing something that is not the operator, program, or hardware. This is often used for operating system issues. |
| **TEMPERATURE** | Indicates the temperature of a component is within operating limits. |
| **VOLTAGE** | A high or low voltage condition. |
| **VELOCITY** | A fault or warning with regard to the velocity of the component. |

# Component and Data Item Relationships

This section will discuss the association between Component, DataItems, and Events, Condition, and Samples. For each component, there are a limited set of allowable sub-components and a limited set of data items. For example, an Axes component may not have a Device or a Controller as a child, and it may not have Block as a DataItem type, since it is incapable of running a program.

## Overview

At the top level, a device **MUST** always contain an Availability data item that represents this device is available to do work. Any component **MAY** also include an arbitrary set of sensors as sub-components. The sensor is currently a placeholder for extensible data collection devices and is not modeled in this version of the specification. A sensor will be an external device that will collect data and report it to the Agent. The sensor **MUST** be correctly associated with its most relevant component. The rules governing this association will be covered in a later version of this specification.

## Device

The Device is the only top level element in the component tree. Since an MTConnect® Agent can manage multiple devices, the schema provides a top level container Devices to hold the Device elements.

### DataItem types

* EMERGENCY\_STOP - The emergency stop state of the machine.
* AVAILABILITY - **Required**

### Sub-components of Device

* Axes
* Controller
* Systems
* Door

## Common Components and Data Items

A common set of DataItems have been created to provide the flexibility to define a wide variety of information about a machine or process. Any DataItem can be used with and Device or Component providing that the standard naming conventions are implemented.

### Axes

The Axes component is a container for the actual axes of which there are currently two: Linear and Rotary.

#### DataItem types

* ~~GLOBAL\_POSITION~~ - DEPRECATED
* ~~PATH\_FEEDRATE~~ – Moved to Path
* ~~ACCELERATION~~ – Moved to Path
* ~~VELOCITY~~ – Moved to Path

#### Sub-components of Axes

* Linear
* Rotary
* ~~Spindle~~ - DEPRECATED

### Linear

A linear axis represents travel along a straight line. The name of the linear axis **SHOULD** follow the conventions of the industry.

#### DataItem types

* ACCELERATION
* AXIS\_FEEDRATE
* LOAD
* POSITION
* SLAVE\_OF\_AXIS
* VELOCITY

#### Condition types

* AMPERAGE
* LOAD
* POSITION
* TEMPERATURE
* VOLTAGE

### Rotary

A rotary axis revolves around a point.

#### DataItem types

* ANGLE
* ANGULAR\_ACCELERATION
* ANGULAR\_VELOCITY
* AXIS\_FEEDRATE
* DIRECTION
* LOAD
* ROTARY\_MODE
* SLAVE\_OF\_AXIS
* SPINDLE\_SPEED
* TORQUE

#### Condition types

* ANGLE
* AMPERAGE
* LOAD
* TEMPERATURE
* VOLTAGE
* VELOCITY

### Controller

The controller component is the component that controls a device, executes a program, and sends instructions to the other components of the machine. It is the brains of the machine and can be asked for its current execution state and program name.

#### Sub-components of Controller

* Path

#### DataItem types

* BLOCK
* CODE
* CONTROLLER\_MODE
* EXECUTION
* EMERGENCY\_STOP
* LINE
* MESSAGE
* PART\_COUNT
* PART\_ID
* PATH\_FEEDRATE
* PATH\_POSITION
* PROGRAM
* TOOL\_ID
* WORKHOLDING\_ID

#### Condition types

* COMMUNICATIONS
* HARDWARE
* LOGIC\_PROGRAM
* MOTION\_PROGRAM
* SYSTEM

### Path

A Path represents the motion of a control point as it moves through space as controlled by a set of control instructions (i.e. vector move).

#### DataItem types

* ACTIVE\_AXES
* AXES\_COUPLING
* ACCELERATION
* BLOCK
* CODE
* CONTROLLED\_AXES
* COUPLED\_AXES
* CONTROLLER\_MODE
* EXECUTION
* LINE
* MESSAGE
* PART\_COUNT
* PART\_ID
* PATH\_FEEDRATE
* PATH\_POSITION
* PROGRAM
* TOOL\_ID
* VELOCITY
* WORKHOLDING\_ID

#### Condition types

* MOTION\_PROGRAM

### ~~Power~~ DEPRECATED

~~The power component represents the electrical activation of the component. The data items the power component can collect are a simple status (on/off) and three power related measurements, voltage, amperage and watts. There are no sub-components of Power. The reason for making this a separate component is the need to support legacy equipment.~~

~~For the top-level Device Power component, the PowerStatus represents the power to all components of the device except the computer controller, since the controller may be hosting the MTConnect~~~~®~~*~~Agent~~*~~, it would be impossible to report Power ON or OFF if the controller is off. Therefore, if network or physical connectivity to the device is interrupted, the Power~~ **~~MUST~~** ~~be considered OFF.~~

~~For all other components, the definition of OFF is the component is not connected to the power source.~~

#### ~~DataItem types~~

* ~~POWER\_STATUS DEPRECATED.~~
* ~~VOLTAGE~~
* ~~AMPERAGE~~
* ~~WATTS~~

#### ~~Condition types~~

* ~~VOLTAGE~~
* ~~AMPERAGE~~

### Thermostat

A sensor capable of measuring the temperature of a component. The temperature is always given in Celsius.

#### DataItem types

* TEMPERATURE

#### Condition types

* TEMPERATURE

### Vibration

A sensor capable of measuring the vibration of a component.

#### DataItem types

* ACCELERATION
* DISPLACEMENT
* FREQUENCY
* VELOCITY

#### Condition types

* DISPLACEMENT
* VIBRATION

### Pressure

A sensor capable of measuring the pressure.

#### DataItem types

* PRESSURE

#### Condition types

* PRESSURE

### Door

A opening that can be closed.

#### DataItem types

* DOOR\_STATE

### Actuator

A mechanical device for moving or controlling a mechanism or system.

#### DataItem types

* ACCELERATION
* ANGLE
* ANGULAR\_ACCELATION
* ANGULAR\_VELOCITY
* LOAD
* POSITION
* PRESSURE
* VELOCITY
* TEMPERATURE
* TORQUE

#### Condition types

* AMPERAGE
* LOAD
* POSITION
* PRESSURE
* TEMPERATURE
* VOLTAGE

### Systems

The systems component is a place holder for all the system types.

#### Sub-components of Systems

* Hydraulic
* Pneumatic
* Coolant
* Lubrication

### Hydraulic

A component representing the hydraulics of a device.

#### DataItem types

* PRESSURE
* TEMPERATURE

#### Condition types

* PRESSURE
* TEMPERATURE
* LEVEL

### Coolant

A component representing the coolant of a device.

#### DataItem types

* PRESSURE
* TEMPERATURE

#### Condition types

* LEVEL
* PH
* PRESSURE
* TEMPERATURE

### Lubrication

A component representing the lubricant of a device.

#### DataItem types

* PRESSURE
* TEMPERATURE

#### Condition types

* PRESSURE
* TEMPERATURE
* LEVEL

### Electric

#### DataItem types

* VOLTAGE
* AMPERAGE
* WATTS

#### Condition types

* VOLTAGE
* AMPERAGE

## ~~Cutting Machine Tool Components and Data Items~~

### Spindle - DEPRECATED

~~The spindle is a rotational axis that revolves at high speed and has its speed expressed in REVOLUTION/MINUTE. The spindle can also have additional data items. Spindle speed has been specified as a separate data item since it receives special treatment in many applications. Velocity is used for linear axes other than spindle.~~

#### ~~DataItem types~~

* ~~SPINDLE\_SPEED~~
* ~~LOAD~~
* ~~DIRECTION~~
* ~~TORQUE~~

# Annotated XML Examples

## Simplest Device

For the simplest possible device we are modeling a saw that has only an Availability (the minimal set of data items). To retrieve this information we send the following request to the Agent:

[http://10.1.23.10/ LinuxCNC/probe](http://10.1.23.10/%20LinuxCNC/probe)

The Agent responds as follows:

1. <?xml version="1.0" encoding="UTF-8"?>
2. <MTConnectDevices xmlns:m="urn:mtconnect.com:MTConnectDevices:0.9" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance" xmlns="urn:mtconnect.com:MTConnectDevices:0.9" xsi:schemaLocation="urn:mtconnect.com:MTConnectDevices:0.9 /schemas/MTConnectDevices.xsd">
3. <Header sender="10.1.23.10" bufferSize="100000" creationTime="2008-07-07T23:07:50-07:00" version="0.9" instanceId="1214527986"/>

Line 3 provides the instanceId as a unique number for this run. For this example, the Agent does not persist the samples, events, and condition therefore, this number will change every time. The bufferSize indicates that this Agent is capable of storing 100,000 samples, events, and condition.

1. <Devices>
2. <Device iso841Class="6" uuid="linux-01" name="LinuxCNC" sampleRate="100.0" id="d">
3. <Description manufacturer="NIST" serialNumber="01"/>

The above device description includes the unique id and a sample rate of ten times per second. Since there are no telemetry data being collected, once a second is adequate.

1. <DataItems>
2. <DataItem type="AVAILABILITY" name="avail" category="EVENT" id="a"/>
3. </DataItems>

As was stated before, the device is only required to have one AVAILABILITY data item which **MUST** report the devices represented availability to communicate. The DataItem on line 13 has an id of a. This will allow events responding to this data item to be easily associated.

1. </Components>
2. </Device>
3. </Devices>
4. </MTConnectDevices>

## More Complex Example of probe

The sample was generated with the following request:

* http://10.1.23.5/LinuxCNC/probe

The following is an example of a 3 axis mill simulation. The mill has three linear axes and one spindle:

1. <?xml version="1.0" encoding="UTF-8"?>
2. <MTConnectDevices xmlns:m="urn:mtconnect.com:MTConnectDevices:0.9" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance" xmlns="urn:mtconnect.com:MTConnectDevices:0.9" xsi:schemaLocation="urn:mtconnect.com:MTConnectDevices:0.9 /schemas/MTConnectDevices.xsd">
3. <Header sender="10.1.23.5" bufferSize="100000" creationTime="2008-07-07T23:07:50-07:00" version="0.9" instanceId="1214527986"/>
4. <Devices>
5. <Device iso841Class="6" uuid="linux-01" name="LinuxCNC" sampleRate="100.0" id="d1">

Here we provide the top level container Devices and the information on the Device.

1. <Description manufacturer="NIST" serialNumber="01"/>
2. <DataItems>
3. <DataItem type="AVAILABILITY" name="avail" category="EVENT" id="a"/>
4. </DataItems>
5. <Components>
6. <Axes name="Axes" id="3">

On line 11 we introduce the collection of Axes. The Axes component is a special component that acts as an abstract component as well as a collection. The Axes component contains various data items that have a global context; they are not associated with any one data item, but they go across all axes.

1. <Components>
2. <Rotary name="C" id="c1">
3. <DataItems>
4. <DataItem type="SPINDLE\_SPEED" name="Cspeed" category="SAMPLE" id="c2" nativeUnits="REVOLUTION/MINUTE" subType="ACTUAL" units="REVOLUTION/MINUTE">
5. <Source>Sspeed</Source>
6. </DataItem>
7. <DataItem type=”ROTARY\_MODE” name”Cmode” category=”EVENT” id=”c3”>
8. <Values><Value>SPINDLE</Value><Values>
9. </DataItem>
10. </DataItems>
11. </Rotary>

The spindle component declared on line 16 is the S axis and has spindle-specific data items.

1. <Linear name="X" id="x1">
2. <DataItems>
3. <DataItem type="POSITION" name="Xact" category="SAMPLE" id="x2" nativeUnits="MILLIMETER" subType="ACTUAL" units="MILLIMETER"/>
4. <DataItem type="POSITION" name="Xcom" category="SAMPLE" id="x3" nativeUnits="MILLIMETER" subType="COMMANDED" units="MILLIMETER"/>
5. </DataItems>
6. </Linear>
7. <Linear name="Y" id="y1">
8. <DataItems>
9. <DataItem type="POSITION" name="Yact" category="SAMPLE" id="y2" nativeUnits="MILLIMETER" subType="ACTUAL" units="MILLIMETER"/>
10. <DataItem type="POSITION" name="Ycom" category="SAMPLE" id="y3" nativeUnits="MILLIMETER" subType="COMMANDED" units="MILLIMETER"/>
11. </DataItems>
12. </Linear>
13. <Linear name="Z" id="z1">
14. <DataItems>
15. <DataItem type="POSITION" name="Zact" category="SAMPLE" id="z2" nativeUnits="MILLIMETER" subType="ACTUAL" units="MILLIMETER"/>
16. <DataItem type="POSITION" name="Zcom" category="SAMPLE" id="z3" nativeUnits="MILLIMETER" subType="COMMANDED" units="MILLIMETER"/>
17. </DataItems>
18. </Linear>

Lines 24, 30, and 36 define the three linear axes X, Y, and Z respectively. In this example device the Agent is only collecting the actual and commanded positions.

1. </Components>
2. </Axes>

The Controller is capable of providing the program name, block, and the current line being executed:

1. <Controller name="Controller" id="8">
2. <Components>
3. <Path id=”p1” name=”path”>
4. <DataItems>
5. <DataItem type="LINE" name="line" category="EVENT" id="p1"/>
6. <DataItem type="CONTROLLER\_MODE" name="mode" category="EVENT" id="p2"/>
7. <DataItem type="PROGRAM" name="program" category="EVENT" id="p3"/>
8. <DataItem type="EXECUTION" name="execution" category="EVENT" id="p4"/>
9. <DataItem type="PATH\_FEEDRATE" name="feedrate" category="SAMPLE" id="p4" units=”MILLIMETER/SECOND” nativeUnits=”MILLIMETER/SECOND” />
10. <DataItem type="PATH\_POSITION" name="position" category="SAMPLE" id="p4" units=”MILLIMETER\_3D” nativeUnits=”INCH\_3D”/>
11. </DataItems>
12. </Path>
13. </Components>
14. </Controller>
15. </Components>
16. </Device>
17. </Devices>
18. </MTConnectDevices>

Appendices

1. Bibliography
2. Engineering Industries Association. *EIA Standard - EIA-274-D*, Interchangeable Variable, Block Data Format for Positioning, Contouring, and Contouring/Positioning Numerically Controlled Machines. Washington, D.C. 1979.
3. ISO TC 184/SC4/WG3 N1089. *ISO/DIS 10303-238*: Industrial automation systems and integration Product data representation and exchange Part 238: Application Protocols: Application interpreted model for computerized numerical controllers. Geneva, Switzerland, 2004.
4. International Organization for Standardization. *ISO 14649*: Industrial automation systems and integration – Physical device control – Data model for computerized numerical controllers – Part 10: General process data. Geneva, Switzerland, 2004.
5. International Organization for Standardization. *ISO 14649*: Industrial automation systems and integration – Physical device control – Data model for computerized numerical controllers – Part 11: Process data for milling. Geneva, Switzerland, 2000.
6. International Organization for Standardization. *ISO 6983/1* – Numerical Control of machines – Program format and definition of address words – Part 1: Data format for positioning, line and contouring control systems. Geneva, Switzerland, 1982.
7. Electronic Industries Association. *ANSI/EIA-494-B-1992*, 32 Bit Binary CL (BCL) and 7 Bit ASCII CL (ACL) Exchange Input Format for Numerically Controlled Machines. Washington, D.C. 1992.
8. National Aerospace Standard. *Uniform Cutting Tests* - NAS Series: Metal Cutting Equipment Specifications. Washington, D.C. 1969.
9. International Organization for Standardization. *ISO 10303-11*: 1994, Industrial automation systems and integration Product data representation and exchange Part 11: Description methods: The EXPRESS language reference manual. Geneva, Switzerland, 1994.
10. International Organization for Standardization. *ISO 10303-21*: 1996, Industrial automation systems and integration -- Product data representation and exchange -- Part 21: Implementation methods: Clear text encoding of the exchange structure. Geneva, Switzerland, 1996.
11. H.L. Horton, F.D. Jones, and E. Oberg. *Machinery's handbook*. Industrial Press, Inc. New York, 1984.
12. International Organization for Standardization. *ISO 841-2001: Industrial automation systems and integration - Numerical control of machines - Coordinate systems and motion nomenclature.* Geneva, Switzerland, 2001.
13. *ASME B5.59-2 Version 9c: Data Specification for Properties of Machine Tools for Milling and Turning. 2005.*
14. *ASME/ANSI B5.54: Methods for Performance Evaluation of Computer Numerically Controlled Lathes and Turning Centers. 2005.*
15. OPC Foundation. *OPC Unified Architecture Specification, Part 1: Concepts Version 1.00. July 28, 2006.*
16. Machine Tool Modeling

The following section will provide example machine tool configurations and reference MTConnect® implementations.

* 1. Vertical Three Axis Mill

This is a simple machine tool with a vertical spindle and a table that can move in two dimensions. The modeling always starts with the Linear Z axis that **MUST** be aligned with the primary spindle. The X axis is defined as the longest axis perpendicular to the Z axis. The spindle is now defined as a Rotary C axis that rotates around the Z axis.



Figure : Three Axis Mill

The right hand rule applies when naming the axes and defining positive motion and rotation. In this case the Rotary axis only operate as a spindle, so it will have a constant valued RotaryMode data item. This machine is only capable of executing a single program and therefore only capable of a single path. The following XML describes a simple configuration for this machine.

1. <?xml version="1.0" encoding="UTF-8"?>
2. <MTConnectDevices xmlns="urn:mtconnect.com:MTConnectDevices:1.1" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance" xsi:schemaLocation="urn:mtconnect.com:MTConnectDevices:1.1 MTConnectDevices.xsd">
3. <Header bufferSize="130000" instanceId="1" creationTime="2009-11-13T02:31:40" sender="local" version="1.1"/>
4. <Devices>
5. <Device id="d1" uuid="HM1" name="HMC\_3Axis">
6. <Description>3 Axis Mill</Description>
7. <Components>
8. <Axes id="a" name="base">
9. <Components>
10. <Linear id="y" name="Y">
11. <DataItems>
12. <DataItem type="POSITION" subType="ACTUAL" id="yp" category="SAMPLE" name="Yact" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>
13. </DataItems>
14. </Linear>
15. <Linear id="x" name="X">
16. <DataItems>
17. <DataItem type="POSITION" subType="ACTUAL" id="xp" category="SAMPLE" name="Xact" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>
18. </DataItems>
19. </Linear>
20. <Linear id="z" name="Z">
21. <DataItems>
22. <DataItem type="POSITION" id="zp" category="SAMPLE" name="Zact" subType="ACTUAL" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>
23. </DataItems>
24. </Linear>
25. <Rotary id="c" name="C">
26. <DataItems>
27. <DataItem type="SPINDLE\_SPEED" id="cspd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>
28. <DataItem type="SPINDLE\_SPEED" id="cso" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>
29. <DataItem type="ROTARY\_MODE" id="rf" category="EVENT" name="rfunc">
30. <Constraints>
31. <Value>SPINDLE</Value>
32. </Constraints>
33. </DataItem>
34. </DataItems>
35. </Rotary>
36. </Components>
37. </Axes>
38. <Controller id="cont" name="controller">
39. <Components>
40. <Path id="path" name="path">
41. <DataItems>
42. <DataItem type="PROGRAM" id="pgm" category="EVENT" name="program"/>
43. <DataItem type="BLOCK" id="blk" category="EVENT" name="block"/>
44. <DataItem type="LINE" id="ln" category="EVENT" name="line"/>
45. <DataItem type="PATH\_FEEDRATE" id="pf" category="SAMPLE" name="Fact" units="MILLIMETER/SECOND" nativeUnits="FOOT/MINUTE" subType="ACTUAL"/>
46. <DataItem type="PATH\_FEEDRATE" id="pfo" category="SAMPLE" name="Fovr" units="PERCENT" nativeUnits="PERCENT" subType="OVERRIDE"/>
47. <DataItem type="PATH\_POSITION" id="pp" category="SAMPLE" name="Ppos" units="MILLIMETER\_3D" nativeUnits="FOOT\_3D" coordinateSystem="WORK"/>
48. <DataItem type="EXECUTION" id="exec" category="EVENT" name="execution"/>
49. <DataItem type="CONTROLLER\_MODE" id="cm" category="EVENT" name="mode"/>
50. </DataItems>
51. </Path>
52. </Components>
53. </Controller>
54. </Components>
55. </Device>
56. </Devices>
57. </MTConnectDevices>
    1. Two Axis Lathe

The next machine is a simple two axis horizontal lathe with a Z and an X axis where the Linear Z axis which is aligned with the primary spindle Rotary C. The material is now held in the C axis and the tool is fixed.



Figure : Two Axis Lathe

1. <?xml version="1.0" encoding="UTF-8"?>
2. <MTConnectDevices xmlns="urn:mtconnect.com:MTConnectDevices:1.1" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance" xsi:schemaLocation="urn:mtconnect.com:MTConnectDevices:1.1 MTConnectDevices.xsd">
3. <Header bufferSize="130000" instanceId="1" creationTime="2009-11-13T02:31:40" sender="local" version="1.1"/>
4. <Devices>
5. <Device id="d1" uuid="HM1" name="HMC\_3Axis">
6. <Description>3 Axis Mill</Description>
7. <Components>
8. <Axes id="a" name="base">
9. <Components>
10. <Linear id="x" name="X">
11. <DataItems>
12. <DataItem type="POSITION" subType="ACTUAL" id="xp" category="SAMPLE" name="Xact" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>
13. </DataItems>
14. </Linear>
15. <Linear id="z" name="Z">
16. <DataItems>
17. <DataItem type="POSITION" id="zp" category="SAMPLE" name="Zact" subType="ACTUAL" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>
18. </DataItems>
19. </Linear>
20. <Rotary id="c" name="C">
21. <DataItems>
22. <DataItem type="SPINDLE\_SPEED" id="cspd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>
23. <DataItem type="SPINDLE\_SPEED" id="cso" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>
24. <DataItem type="ROTARY\_MODE" id="rf" category="EVENT" name="rfunc">
25. <Constraints>
26. <Value>SPINDLE</Value>
27. <Value>INDEX</Value>
28. </Constraints>
29. </DataItem>
30. </DataItems>
31. </Rotary>
32. </Components>
33. </Axes>
34. <Controller id="cont" name="controller">
35. <Components>
36. <Path id="path" name="path">
37. <DataItems>
38. <DataItem type="PROGRAM" id="pgm" category="EVENT" name="program"/>
39. <DataItem type="BLOCK" id="blk" category="EVENT" name="block"/>
40. <DataItem type="LINE" id="ln" category="EVENT" name="line"/>
41. <DataItem type="PATH\_FEEDRATE" id="pf" category="SAMPLE" name="Fact" units="MILLIMETER/SECOND" nativeUnits="FOOT/MINUTE" subType="ACTUAL"/>
42. <DataItem type="PATH\_FEEDRATE" id="pfo" category="SAMPLE" name="Fovr" units="PERCENT" nativeUnits="PERCENT" subType="OVERRIDE"/>
43. <DataItem type="PATH\_POSITION" id="pp" category="SAMPLE" name="Ppos" units="MILLIMETER\_3D" nativeUnits="FOOT\_3D" coordinateSystem="WORK"/>
44. <DataItem type="EXECUTION" id="exec" category="EVENT" name="execution"/>
45. <DataItem type="CONTROLLER\_MODE" id="cm" category="EVENT" name="mode"/>
46. </DataItems>
47. </Path>
48. </Components>
49. </Controller>
50. </Components>
51. </Device>
52. </Devices>
53. </MTConnectDevices>
    1. HyperQuadrex

<?xml version="1.0" encoding="UTF-8"?>

<MTConnectDevices xmlns="urn:mtconnect.com:MTConnectDevices:1.1" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance" xsi:schemaLocation="urn:mtconnect.com:MTConnectDevices:1.1 ../MTConnectDevices.xsd">

<Header bufferSize="130000" instanceId="1" creationTime="2009-11-13T02:31:40" sender="local" version="1.1"/>

<Devices>

<Device id="d1" uuid="HM1" name="HyperQuadrex">

<Description>Mazak - HyperQuadrex</Description>

<Components>

<Axes id="a" name="base">

<Components>

<Linear id="x" name="X" nativeName="X1">

<DataItems>

<DataItem type="POSITION" subType="ACTUAL" id="xp" category="SAMPLE" name="Xact" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE">

<Source>X1pos</Source>

</DataItem>

<DataItem type="LOAD" id="xl" category="SAMPLE" name="Xload" units="NEWTON">

<Source>X1load</Source>

</DataItem>

</DataItems>

</Linear>

<Linear id="y" name="Y" nativeName="Y1">

<DataItems>

<DataItem type="POSITION" subType="ACTUAL" id="yp" category="SAMPLE" name="Yact" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE">

<Source>Y1pos</Source>

</DataItem>

<DataItem type="LOAD" id="yl" category="SAMPLE" name="Yload" units="NEWTON">

<Source>Y1load</Source>

</DataItem>

</DataItems>

</Linear>

<Linear id="z" name="Z" nativeName="Z1">

<DataItems>

<DataItem type="POSITION" id="zp" category="SAMPLE" name="Zact" subType="ACTUAL" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE">

<Source>Z1pos</Source>

</DataItem>

<DataItem type="LOAD" id="zl" category="SAMPLE" name="Zload" units="NEWTON">

<Source>Z1load</Source>

</DataItem>

</DataItems>

</Linear>

<Linear id="x2" name="X2" >

<DataItems>

<DataItem type="POSITION" subType="ACTUAL" id="x2p" category="SAMPLE" name="X2act" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>

<DataItem type="LOAD" id="x2l" category="SAMPLE" name="X2load" units="NEWTON">

<Source>X2load</Source>

</DataItem>

</DataItems>

</Linear>

<Linear id="y2" name="Y2">

<DataItems>

<DataItem type="POSITION" subType="ACTUAL" id="y2p" category="SAMPLE" name="Y2act" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE"/>

<DataItem type="LOAD" id="y2l" category="SAMPLE" name="Y2load" units="NEWTON"/>

</DataItems>

</Linear>

<Linear id="z2" name="Z2">

<DataItems>

<DataItem type="POSITION" id="z2p" category="SAMPLE" name="Z2act" subType="ACTUAL" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE">

<Source>Z2pos</Source>

</DataItem>

<DataItem type="LOAD" id="z2l" category="SAMPLE" name="Z2load" units="NEWTON"/>

</DataItems>

</Linear>

<Linear id="z3" name="Z3" nativeName="W">

<DataItems>

<DataItem type="POSITION" id="z3p" category="SAMPLE" name="Z3act" subType="ACTUAL" units="MILLIMETER" nativeUnits="MILLIMETER" coordinateSystem="MACHINE">

<Source>Wpos</Source>

</DataItem>

<DataItem type="LOAD" id="z3l" category="SAMPLE" name="Z3load" units="NEWTON">

<Source>Wload</Source>

</DataItem>

</DataItems>

</Linear>

<Rotary id="c" name="C " nativeName="C1">

<DataItems>

<DataItem type="LOAD" id="Cl" category="SAMPLE" name="Cload" units="NEWTON"/>

<DataItem type="SPINDLE\_SPEED" id="cspd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>

<DataItem type="SPINDLE\_SPEED" id="cso" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>

<DataItem type="DIRECTION" id="cdir" category="EVENT" name="Sdir"/>

<DataItem type="ANGLE" id="cpos" category="SAMPLE" name="Cpos" subType="ACTUAL" units="DEGREE" nativeUnits="DEGREE" nativeScale="-1.0"/>

<DataItem type="ROTARY\_MODE" id="rf" category="EVENT" name="rfunc">

<Constraints>

<Value>SPINDLE</Value>

<Value>INDEX</Value>

</Constraints>

</DataItem>

</DataItems>

</Rotary>

<Rotary id="c2" name="C2">

<DataItems>

<DataItem type="LOAD" id="C2l" category="SAMPLE" name="C2load" units="NEWTON"/>

<DataItem type="SPINDLE\_SPEED" id="c2spd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>

<DataItem type="SPINDLE\_SPEED" id="c2so" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>

<DataItem type="DIRECTION" id="c2dir" category="EVENT" name="S2dir"/>

<DataItem type="ROTARY\_MODE" id="rf2" category="EVENT" name="rfunc">

<Constraints>

<Value>SPINDLE</Value>

</Constraints>

</DataItem>

</DataItems>

</Rotary>

<Rotary id="b" name="B" nativeName="S1">

<DataItems>

<DataItem type="LOAD" id="bl" category="SAMPLE" name="Bload" units="NEWTON"/>

<DataItem type="SPINDLE\_SPEED" id="bspd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>

<DataItem type="SPINDLE\_SPEED" id="bso" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>

<DataItem type="DIRECTION" id="bdir" category="EVENT" name="S3dir"/>

<DataItem type="ROTARY\_MODE" id="brf" category="EVENT" name="rfunc">

<Constraints>

<Value>SPINDLE</Value>

</Constraints>

</DataItem>

</DataItems>

</Rotary>

<Rotary id="b2" name="B2" nativeName="S2">

<DataItems>

<DataItem type="LOAD" id="b2l" category="SAMPLE" name="B2load" units="NEWTON"/>

<DataItem type="SPINDLE\_SPEED" id="b2spd" category="SAMPLE" name="Sspeed" subType="ACTUAL" units="REVOLUTION/MINUTE" nativeUnits="REVOLUTION/MINUTE"/>

<DataItem type="SPINDLE\_SPEED" id="b2so" category="SAMPLE" name="Sovr" subType="OVERRIDE" units="PERCENT" nativeUnits="PERCENT"/>

<DataItem type="DIRECTION" id="b2dir" category="EVENT" name="S3dir"/>

<DataItem type="ROTARY\_MODE" id="b2rf" category="EVENT" name="rfunc">

<Constraints>

<Value>SPINDLE</Value>

</Constraints>

</DataItem>

</DataItems>

</Rotary>

</Components>

</Axes>

<Controller id="cont" name="controller">

<Components>

<Path id="path1" name="path1">

<DataItems>

<DataItem type="ACTIVE\_AXES" category="EVENT" name="axes" id="act\_axes1"/>

<DataItem type="PROGRAM" id="pgm1" category="EVENT" name="program"/>

<DataItem type="BLOCK" id="blk1" category="EVENT" name="block"/>

<DataItem type="LINE" id="ln1" category="EVENT" name="line"/>

<DataItem type="PATH\_FEEDRATE" id="pf1" category="SAMPLE" name="Fact" units="MILLIMETER/SECOND" nativeUnits="FOOT/MINUTE" subType="ACTUAL" coordinateSystem="WORK"/>

<DataItem type="PATH\_FEEDRATE" id="pfo1" category="SAMPLE" name="Fovr" units="PERCENT" nativeUnits="PERCENT" subType="OVERRIDE"/>

<DataItem type="PATH\_POSITION" id="pp1" category="SAMPLE" name="Ppos" units="MILLIMETER\_3D" nativeUnits="MILLIMETER\_3D" coordinateSystem="WORK"/>

<DataItem type="TOOL\_ID" id="tid1" category="EVENT" name="Tid"/>

<DataItem type="PART\_ID" id="pid1" category="EVENT" name="Pid"/>

<DataItem type="EXECUTION" id="exec1" category="EVENT" name="execution"/>

<DataItem type="CONTROLLER\_MODE" id="cm1" category="EVENT" name="mode"/>

</DataItems>

</Path>

<Path id="path2" name="path2">

<DataItems>

<DataItem type="ACTIVE\_AXES" category="EVENT" name="axes" id="act\_axes2"/>

<DataItem type="PROGRAM" id="pgm2" category="EVENT" name="program"/>

<DataItem type="BLOCK" id="blk2" category="EVENT" name="block"/>

<DataItem type="LINE" id="ln2" category="EVENT" name="line"/>

<DataItem type="PATH\_FEEDRATE" id="pf2" category="SAMPLE" name="Fact" units="MILLIMETER/SECOND" nativeUnits="FOOT/MINUTE" subType="ACTUAL" coordinateSystem="WORK"/>

<DataItem type="PATH\_FEEDRATE" id="pfo2" category="SAMPLE" name="Fovr" units="PERCENT" nativeUnits="PERCENT" subType="OVERRIDE"/>

<DataItem type="PATH\_POSITION" id="pp2" category="SAMPLE" name="Ppos" units=" MILLIMETER\_3D" nativeUnits=" MILLIMETER\_3D" coordinateSystem="WORK"/>

<DataItem type="TOOL\_ID" id="tid2" category="EVENT" name="Tid"/>

<DataItem type="PART\_ID" id="pid2" category="EVENT" name="Pid"/>

<DataItem type="EXECUTION" id="exec2" category="EVENT" name="execution"/>

<DataItem type="CONTROLLER\_MODE" id="cm2" category="EVENT" name="mode"/>

</DataItems>

</Path>

</Components>

</Controller>

<Door id="d" name="door">

<DataItems>

<DataItem id="ds" category="EVENT" name="door" type="DOOR\_STATE"/>

</DataItems>

</Door>

</Components>

</Device>

</Devices>

</MTConnectDevices>