

SmartComm Import And Export File Specification

(last revised 25,OCT2006)

General

This document describes details for files used to import and export data with SmartComm.

File Format

The import and export files are Comma-Separated Variable (CSV) files. For documentation purposes, each line of the files will be referred to as a record. More specifically, a record begins on a new line, data following ASCII carriage returns (0x0D) or ASCII carriage return/line feed (0x0D/0x0A) combos. The same record ends at the next new line.

Additionally, blank lines are ignored and lines beginning with the pound symbol, #, are ignored. This mechanism may be used to add comments to the import file.

Import Files

There are two types of import files required, the import header and data files.

Import Data File Arbitration

The mechanism for import data file arbitration will be handled as follows:

◆At time of creation of import data, the import device will search the import data file. If not found, import device creates this file and adds the desired import records. Otherwise, the import device must either attempt to append the existing file with the new import records or wait until the import data file is removed by SmartComm.

◆Upon an import event at SmartComm, SmartComm will attempt to rename the import data file. Upon success, SmartComm reads and processes the renamed import data file, then deletes it. Upon failure, due to the possibility of the import device having the file opened or the file is nonexistent, SmartComm will not process file and wait for the next import event to try again.

Import Data File Contents

The import data file contains the specific data records to import. The first field of an import record is the import command, followed by the data fields specific to the command. The following table describes all the possible import commands and their syntax:

<i>Command/Description</i>	<i>Syntax</i>
Import Job: Instructs SmartComm to import a Job. ¹	J, (field), (field), (field), ...
Import Batch: Instructs SmartComm to import a Batch to be included into the last imported Job. ¹	B, (field), (field), (field), ...
Import Part: Instructs SmartComm to import a Part. ¹	P, (field), (field), (field), ...
Import Operation: Instructs SmartComm to import an Operation to be included into the last imported Part. ¹	O, (field), (field), (field), ...
Import Coil: Instructs SmartComm to import a Coil. ¹	C, (field), (field), (field), ...
Import Machine: Instructs SmartComm to import a Machine definition. ¹	M, (field), (field), (field), ...
Import Material: Instructs SmartComm to import a Material definition. ¹	L, (field), (field), (field), ...
Import Profile: Instructs SmartComm to import a Profile definition. ^{1,5}	F, (field), (field), (field), ..., (machine), (machine), (machine), ...
Delete Job: Instructs SmartComm to remove specified Job from memory. ^{2,3}	DELETE JOB, (job name)
Purge Coils: Instructs SmartComm to purge all coils from	PURGE COILS

<i>Command/Description</i>	<i>Syntax</i>
memory. ^{2,4}	

¹Note: This command has a variable number of fields to follow the import command. Use of this command requires a corresponding record entry in the import header file. This header entry instructs SmartComm of which, and the order of, fields to expect in the import data entry.

²Note: These commands produce IMPORT COMMAND RESULT production records in the export file when exporting is enabled in SmartComm.

³Note: This command requires a job name in the field following the command.

⁴Note: This command has no fields to follow the import command.

⁵Note: The Machines to assign to this Profile must follow the last field defined in the Profile header record.

Job/Batch and Part/Operation Record Correlations

Since Jobs and Batches are correlated, more specifically, every Batch is tied to a Job; the way the correlation is specified is by the order of the Job/Batch records. Each Job record must be followed by all of the Batch records corresponding to that Job. Similarly, each Part record must be followed by all of the Operation records corresponding to that Part.

Temporary Parts

Temporary Parts provides a mechanism in which an import may generate custom parts on-the-fly for Batches. These parts are referred to as Temporary Parts. The process for defining a Temporary Part is the same as regular Parts, which is using the Part and Operation import records, with one exception. The PART field of the Temporary Part import record must be named "#".

In order for a Batch to use a Temporary Part, the import entries for the Temporary Part, and its Operations, must immediately precede the import entry for the Batch. Furthermore, the Part specified in the Batch import entry must be named "#".

Upon importation of a Temporary Part, SmartComm will uniquely rename the Temporary Part. Further SmartComm will change the Part in which the following Batch uses to that name as well.

Upon deletion of the Job or Batch, in SmartComm, that uses the Temporary Part, the temporary Part will be removed from memory as well.

Import Header File Arbitration

The mechanism for file arbitration will be handled as follows:

◆ At time of creation of import data, this file should be created or updated only after the previous import data file has been deleted and before the import device creates the next import data file. If this is the first importation, then the import data file should not exist and the import devices is free to create or update the import header file any time before creating the first import data file.

◆ SmartComm will only read this file. Therefore, no arbitration is necessary.

Import Header File Contents

The import header file contains records that describe which, and the order of, data fields that are contained in certain import data file records. The import header file will be typically defined once throughout the life of SmartComm. Exceptions would be if that the importing device needs to change the order of or the data fields that it imports.

The syntax for a header entry is similar to a data entry in the import data file. The first field is the import command, followed by the names of the data fields that will be used in the import data files. The following tables describe the fields available for each import command:

Available Import Job Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
JOB	Job name	Alphanumeric, up to 16 characters
PROFILE	Profile name	Alphanumeric, up to 24 characters

MATERIAL	Material name	Alphanumeric, up to 24 characters
MACHINE	Machine name	Alphanumeric, up to 24 characters
USER 1	User defined field 1	Alphanumeric, up to 36 characters
USER 2	User defined field 2	Alphanumeric, up to 36 characters
USER 3	User defined field 3	Alphanumeric, up to 36 characters
USER 4	User defined field 4	Alphanumeric, up to 36 characters
USER 5	User defined field 5	Alphanumeric, up to 36 characters
USER 6	User defined field 6	Alphanumeric, up to 36 characters
USER 7	User defined field 7	Alphanumeric, up to 36 characters
USER 8	User defined field 8	Alphanumeric, up to 36 characters
USER 9	User defined field 9	Alphanumeric, up to 36 characters
USER 10	User defined field 10	Alphanumeric, up to 36 characters
SCHEDULE	Automatic download schedule time	MM/DD/YYYY hh:mm:ss ¹

Available Import Batch Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
BATCH	Batch name	Alphanumeric, up to 4 characters, typically numeric text
QUANTITY	Number of pieces to produce	Numeric, unsigned integer, 0 – 9999
LENGTH	Length of pieces to produce	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
PART	Part name to use	Alphanumeric, up to 6 characters. Leave empty or set to "0" if not using Parts.
USER 1	User defined field 1	Alphanumeric, up to 36 characters
USER 2	User defined field 2	Alphanumeric, up to 36 characters
USER 3	User defined field 3	Alphanumeric, up to 36 characters
USER 4	User defined field 4	Alphanumeric, up to 36 characters
USER 5	User defined field 5	Alphanumeric, up to 36 characters

Available Import Part Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
PART	Part name	Alphanumeric, up to 6 characters. Part names beginning with the symbol '#' are not allowed. Those names are reserved for Temporary Parts.
DESCRIPTION	Part description	Alphanumeric, up to 40 characters

Available Import Operation Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
OPERATION	Operation name (Tool Definition)	Alphanumeric, up to 4 characters
POSITION	Operation location on Part	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
REFERENCE	Where POSITION is referenced from	Enumerated text strings, the following choices are available: LEADING EDGE TRAILING EDGE LEADING CENTER TRAILING CENTER

		SPACING START EVEN SPACING SPACING END CONTINUOUS CONTINUOUS REF NESTED RIGHT LEADING EDGE NESTED RIGHT TRAILING EDGE NESTED RIGHT LEADING CENTER NESTED RIGHT TRAILING CENTER NESTED LEFT LEADING EDGE NESTED LEFT TRAILING EDGE NESTED LEFT LEADING CENTER NESTED LEFT TRAILING CENTER NESTED ALTERNATING
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Available Import Coil Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
COIL	Coil name	Alphanumeric, up to 24 characters
MATERIAL	Material name	Alphanumeric, up to 24 characters
RECEIVED	Date coil received	MM/DD/YYYY ¹
STATUS	Status of coil	Enumerated text strings, the following choices are available: AVAILABLE DEPLETED HOLD
VENDOR	Where coil was purchased from	Alphanumeric, up to 255 characters
WEIGHT	Entire weight of coil	Numeric, unsigned floating point pounds
LENGTH	Length of coil	Numeric, unsigned floating point feet
GRADE	Quality grade of coil	Enumerated text strings, the following choices are available: PREMIUM SECONDS
NOTES		Alphanumeric, up to 255 characters

Available Import Machine Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
MACHINE	Machine name	Alphanumeric, up to 24 characters
SHIFT1	Shift 1 starting time	hh:mm:ss ¹
SHIFT2	Shift 2 starting time	hh:mm:ss ¹
SHIFT3	Shift 3 starting time	hh:mm:ss ¹

Available Import Material Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
MATERIAL	Material name	Alphanumeric, up to 24 characters
GAUGE	Material's gauge/thickness	Numeric, unsigned integer, 0 - 255
THICKNESS	Material's gauge/thickness	Numeric, unsigned floating point inches
WIDTH	Material's width	Numeric, unsigned floating point inches
COLOR	Material's color	Alphanumeric, up to 24 characters

DENSITY	Material's lineal density	Numeric, unsigned floating point pounds per feet
DESCRIPTION	Description for material	Alphanumeric, up to 36 characters

Available Import Profile Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
PROFILE	Profile name	Alphanumeric, up to 24 characters
COVERAGE	Profile's coverage	Numeric, unsigned floating point inches
PACKAGE CAPACITY	Profile's package capacity	Numeric, unsigned integer, 0 – 9999
DESCRIPTION	Description for material	Alphanumeric, up to 36 characters
MACHINE(S)	Name(s) of machine(s) using this profile	Alphanumeric, up to 24 characters

¹Note: Date time format where:

MM = month of year, 01 - 12

DD = day of month, 01 - 31

YYYY = year

hh = hour, 00 - 23

mm =minutes, 00 - 59

ss = seconds, 00 – 59

Import File Examples

Simple Example

```
J, JOB, PROFILE, MATERIAL  
B, BATCH, QUANTITY, LENGTH
```

Import Header File Contents:

```
J, XYZ Construction, 3-1/2" Stud, 20GA  
B, 1, 500, 96.000  
B, 1, 27, 108.125  
B, 1, 500, 120.500  
J, 110-22-222, 5" Track, 16GA  
B, 1, 500, 96.000
```

Import Data File Contents:

Full Featured Example

```
# Import Machine Record Header  
M, MACHINE, SHIFT1, SHIFT2, SHIFT3  
  
# Import Material Record Header  
L, MATERIAL, GAUGE, THICKNESS, WIDTH, COLOR, DENSITY, DESCRIPTION  
  
# Import Profile Record Header  
F, PROFILE, COVERAGE, PACKAGE CAPACITY, DESCRIPTION  
  
# Import Coil Record Header  
C, COIL, MATERIAL, RECEIVED, STATUS, VENDOR, WEIGHT, LENGTH, GRADE, NOTES  
  
# Import Part/Operation Record Headers  
P, PART, DESCRIPTION  
O, OPERATION, POSITION, REFERENCE  
  
# Import Job/Batch Record Headers  
J, JOB, MACHINE, SCHEDULE, MATERIAL, PROFILE, USER 1, USER 2, USER 3  
B, BATCH, QUANTITY, LENGTH, PART
```

Import Header File Contents:

```
# Import Machines
M,R-Panel,07:00:00,15:00:00,23:00:00
M,Purlin Line,07:00:00,15:00:00,23:00:00
M,Drywall Stud,07:00:00,15:00:00,23:00:00
M,Structural Stud,08:30:00,15:00:00,23:00:00
```

```
# Import Materials
L,Red 42-030,30,,42,Red,1.988,"Red 42 IN wide, 30 GA"
L,White 42-030,30,,42,White,1.988,"White 42 IN wide, 30 GA"
L,White 42-026,26,,42,White,2.125,"White 42 IN wide, 26 GA"
L,Red Iron 16-016,16,,16,Red,2.375,"Red Iron 16 IN wide, 16 GA"
L,Red Iron 16-014,14,,16,Red,2.55,"Red Iron 16 IN wide, 14 GA"
L,CRS 25-625,25,,6.25,Grey,0.604,"CRS 25 GA 6-1/4 IN, 3-1/2 IN stud"
L,CRS 25-550,25,,5.5,Grey,0.531,"CRS 25 GA 5-1/2 IN, 3-1/2 IN track"
L,CRS 20-625,20,,6.25,Grey,0.637,"CRS 20 GA 6-1/4 IN, 3-1/2 IN stud"
L,CRS 20-900,20,,9,Grey,0.956,"CRS 20 GA 9 IN, 6 IN stud"
L,CRS 20-800,20,,8,Grey,0.85,"CRS 20 GA 8 IN, 6 IN track"
```

```
# Import Profiles
F,R-Panel,24,36,,R-Panel
F,Flat Sheets,36,48,,R-Panel
F,Cee Purlin,12,24,,Purlin Line
F,Zee Purlin,12,24,,Purlin Line
F,3-1/2" Stud,3.5,36,,Drywall Stud,Purlin Line,Structural Stud
F,3-1/2" Track,3.5,36,,Drywall Stud
F,6" Stud,6,48,,Structural Stud
F,6" Track,6,36,,Structural Stud
```

```
# Import Coil Record Data
C,112-W,White 42-030,11/04/2002,AVAILABLE,Coils-Are-Us,725,500,PREMIUM,New coil
C,113-R,Red Iron 16-014,11/04/2002,AVAILABLE,Coils-Are-Us,1000,750,SECONDS,New coil
```

```
# Import Part/Operation Record Data
P,24,24" Centered Studs
O,2,24.000,SPACING START
O,2,24.000,EVEN SPACING
O,2,24.000,SPACING END
P,12C,12" Continuous
O,2,12.000,CONTINUOUS
P,505,Standard Lap
O,2,2.000,LEADING EDGE
O,3,4.000,LEADING EDGE
O,4,6.000,LEADING EDGE
O,5,8.000,LEADING EDGE
O,6,10.000,LEADING EDGE
O,8,0.000,LEADING CENTER
O,2,10.000,TRAILING EDGE
O,3,8.000,TRAILING EDGE
O,4,6.000,TRAILING EDGE
O,5,4.000,TRAILING EDGE
O,6,2.000,TRAILING EDGE
```

```
# Import Job/Batch Record Data.
# Note: This Job is not scheduled for downloading since that field is left blank.
J,PO 12345,R-Panel,,White 42-030,R-Panel,ABC Construction,12345 First St, "Anywhere, AK 76654"
B,1,1000,96.000,24
B,1,1000,48.000,0
B,1,1000,24.000,0
B,2,500,120.000,24
B,2,250,36.000,0
B,2,250,72.000,12C
J,PO 12346,Purlin Line,,CRS 20-900,Cee Purlin,Bldgs-R-Us,203 Maple Dr, "Anywhere, AZ 49624"
B,1,1000,12.500,0
B,1,1000,18.125,505
B,1,1000,24.000,505
```

```
# Import Job/Batch Record Data, that uses a Temporary Parts
# Note: This Job is will be scheduled for downloading immediately since that field is dated in the past.
J,PO 12357,Purlin Line,01/01/2001 00:00:00,Red Iron 16-014,Zee Purlin,Fab Buildings,38345 Long St, "Nowhere, ND 74889"
P,#,First Temporary Part
O,2,16.000,SPACING START
O,2,16.000,EVEN SPACING
O,2,16.000,SPACING END
B,1,25,120.000,#
P,#,Second Temporary Part
O,2,22.000,SPACING START
O,2,22.000,EVEN SPACING
O,2,22.000,SPACING END
B,1,10,144.000,#
```

```
# Import Job/Batch Record Data
J,PO 12349,Purlin Line,06/01/2005 13:00:00,Red Iron 16-014,Zee Purlin,Bldgs-R-Us,4507 Maple Dr, "Anywhere, AL 39651"
B,1,1000,16.000,0
B,1,1000,48.000,0
B,2,500,24.000,12C
B,2,500,120.000,24
B,3,250,36.000,0
B,4,750,72.000,505
```

Import Data File Contents:

Export Files

There are two types of export files required, the export header and data files.

Export Header File

The export header file contains records that describe which, and the order of, data fields to be placed in the export data file records. There must be a single record in the export header file for each record type. The mechanism for file arbitration will be handled as follows:

◆ This file must only be created or updated by the export device when SmartComm is not executing.

Export Data File

The export data file contains the specific data records for exportation. The mechanism for file arbitration will be handled as follows:

◆ Upon an export event at SmartComm, SmartComm will search for the export data file. If not found, SmartComm creates this file and adds the desired export records. Otherwise, SmartComm will either attempt to append the existing file with the new export records or wait until the export data file is removed by the export device.

◆ Upon an export event at the export device, the export device will attempt to rename the export data file. Upon success, the export device reads and processes the renamed export data file, then deletes it. Upon failure, due to the possibility of SmartComm having the file opened or the file is nonexistent, the export device will not process the file and wait for the next export event to try again.

Available Export Record Types

<i>Record Type</i>	<i>Name</i>	<i>Description</i>
1	Enter Run	Generated when the production line is started for any reason.
2	Exit Run	Generated when the production line is stopped for any reason.
3	Item Data	Generated upon completion of production at the production line.
4	Coil Change	Generated when a coil change takes place at the line.
5	Manual Shear	Generated when a manual shear operation takes place at the production line.
6	Quantity Adjust	Generated when an operator overrides production quantities by pressing “1-Extra” “1-Less” buttons on Sierra controller.
7	Import Command Result	Generated upon execution of specific import commands.
8	Message	Generated when SmartComm needs to issue information to the export device not handled by any other export record.

Available Enter Run Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters

Available Exit Run Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters
LENGTH	Length of pieces produced	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
QUANTITY	Number of pieces produced	Numeric, unsigned integer, 0 – 9999
JOB	Job name	Alphanumeric, up to 16 characters
PROFILE	Profile name	Alphanumeric, up to 24 characters
MATERIAL	Material name	Alphanumeric, up to 24 characters
BATCH	Batch name	Alphanumeric, up to 4 characters, typically numeric text
PART	Part name used	Alphanumeric, up to 6 characters. "0" indicates no Part used, shear only.
PROFILE	Profile name	Alphanumeric, up to 24 characters
COIL	Coil name	Alphanumeric, up to 24 characters

Available Item Data Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters
LENGTH	Length of pieces produced	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
QUANTITY	Number of pieces produced	Numeric, unsigned integer, 0 – 9999
JOB	Job name	Alphanumeric, up to 16 characters
PROFILE	Profile name	Alphanumeric, up to 24 characters
MATERIAL	Material name	Alphanumeric, up to 24 characters
BATCH	Batch name	Alphanumeric, up to 4 characters, typically numeric text
PART	Part name used	Alphanumeric, up to 6 characters. "0" indicates no Part used, shear only.
COIL	Coil name	Alphanumeric, up to 24 characters

Available Coil Change Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters
MATERIAL	Material name	Alphanumeric, up to 24 characters
NEW COIL	New coil name	Alphanumeric, up to 24 characters
PREVIOUS COIL	Previous coil name	Alphanumeric, up to 24 characters
DESTINATION	Destination of previous coil	Enumerated text strings, the following selections are possible: DEPLETED INVENTORY

Available Manual Shear Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters
SCRAP	Scrap generated	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
COIL	Coil name	Alphanumeric, up to 24 characters

Available Quantity Adjust Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MACHINE	Name of production line that caused this event.	Alphanumeric, up to 24 characters
LENGTH	Length of pieces produced	Numeric, unsigned fixed point, 0.000 – 2000.000 inches
QUANTITY	Number of pieces produced	Numeric, signed integer, -9999 to 9999

JOB	Job name	Alphanumeric, up to 16 characters
PROFILE	Profile name	Alphanumeric, up to 24 characters
MATERIAL	Material name	Alphanumeric, up to 24 characters
BATCH	Batch name	Alphanumeric, up to 4 characters, typically numeric text
PART	Part name used	Alphanumeric, up to 6 characters. "0" indicates no Part used, shear only.
PROFILE	Profile name	Alphanumeric, up to 24 characters
COIL	Coil name	Alphanumeric, up to 24 characters

Available Import Command Result Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
COMMAND	Import command that caused this event.	Alphanumeric
ARGUMENT	Argument of import command that caused this event.	Alphanumeric
RESULT	Result of import command that caused this event.	Enumerated text strings, the following selections are possible: SUCCESS FAIL

Available Message Fields

<i>Field Name</i>	<i>Description</i>	<i>Field Data Type</i>
TIMESTAMP	Date and time of action that caused this event.	MM/DD/YYYY hh:mm:ss ¹
TIMESTAMP DATE	Same as TIMESTAMP field except only reports the date.	MM/DD/YYYY ¹
TIMESTAMP TIME	Same as TIMESTAMP field except only reports the time of day.	hh:mm:ss ¹
MESSAGE	Message contents.	Alphanumeric

¹Note: Date time format where:

MM = month of year, 01 - 12

DD = day of month, 01 - 31

YYYY = year

hh = hour, 00 - 23

mm = minute, 00 - 59

ss = seconds, 00 - 59

Message Export Record

The message export record is a facility for SmartComm to report events not covered by the other more specific export records. The following table describes the message records SmartComm issues during exporting:

<i>Message</i>	<i>Message Syntax</i>	<i>Description</i>
Job Completion	Job Completion; Job: (job name); Machine: (machine); Profile: (profile); Material: (material)	This message is issued when SmartComm has determined that a Job, either authored in or imported into SmartComm, has been downloaded, produced and completed by a particular machine.

Export File Example

1,MACHINE,TIMESTAMP

2,MACHINE,TIMESTAMP,LENGTH,QUANTITY,JOB,PROFILE,MATERIAL,BATCH,PART,COIL

3,MACHINE,TIMESTAMP,LENGTH,QUANTITY,JOB,PROFILE,MATERIAL,BATCH,PART,COIL

4,MACHINE,TIMESTAMP,MATERIAL,NEW COIL,PREVIOUS COIL,DESTINATION

5,MACHINE,TIMESTAMP,SCRAP,COIL

6,MACHINE,TIMESTAMP,LENGTH,QUANTITY,JOB,PROFILE,MATERIAL,BATCH,PART,COIL

7,TIMESTAMP,COMMAND,ARGUMENT,RESULT

8,TIMESTAMP,MESSAGE

Export Header File Contents:

Export Data File Contents:

5,R-Panel,01/09/2003 15:13:02,31.125,112-W

1,R-Panel,01/09/2003 15:13:05

3,R-Panel,01/09/2003 15:47:25,96.000,1000,PO 12345,R-Panel,White 42-030,1,24,112-W

2,R-Panel,01/09/2003 16:10:22,48.000,357,PO 12345,R-Panel,White 42-030,1,0,112-W

6,R-Panel,01/09/2003 16:10:25,48.000,-1,PO 12345,R-Panel,White 42-030,1,0,112-W

1,R-Panel,01/09/2003 16:10:45

3,R-Panel,01/09/2003 16:10:25,48.000,644,PO 12345,R-Panel,White 42-030,1,0,112-W

3,R-Panel,01/09/2003 16:15:13,24.000,1000,PO 12345,R-Panel,White 42-030,1,0,112-W

3,R-Panel,01/09/2003 16:33:58,120.000,500,PO 12345,R-Panel,White 42-030,2,24,112-W

3,R-Panel,01/09/2003 16:46:14,36.000,250,PO 12345,R-Panel,White 42-030,2,0,112-W

3,R-Panel,01/09/2003 16:57:09,72.000,250,PO 12345,R-Panel,White 42-030,2,12C,112-W

2,R-Panel,01/09/2003 16:57:09,0.000,0,,,,,

4,R-Panel,01/09/2003 17:05:48,Red Iron 16-014,113-R,112-W,INVENTORY

5,R-Panel,01/09/2003 17:08:02,26.000,112-R

1,R-Panel,01/09/2003 17:08:05

2,R-Panel,01/09/2003 17:25:25,24.000,100,PO 12347,R-Panel,Red Iron 16-014,1,0,113-R

7,04/01/2003 16:23:35,DELETE JOB,Job123,SUCCESS

8,12/14/2003 14:23:47,Job Completion; Job: PO 12349; Machine: R-Panel; Profile: ; Material: Red Iron 16-014