SECS/GEM 200mm Manual

For the

NT300 & CVP600

Version

1.13

Released

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Index

| Index | |
|--|----|
| Introduction | 1 |
| | |
| SECS Information | 2 |
| Communication Parameters | 2 |
| GEM Compliance | 2 |
| SEMI Standard Compliance | 4 |
| GEM and Equipment State Model | 5 |
| Control State Model | 5 |
| Process State Model | 6 |
| Data Dictionary | 7 |
| Data Format | 7 |
| Data Item List | 7 |
| Collected event (CEID) | 11 |
| Report (RPTID) | |
| Variables ID (EC, SV and DV) | 13 |
| Alarm (ALID) | 20 |
| SECS Message Support | 30 |
| Stream 1 Equipment State | 30 |
| Stream 2 Equipment Control and Diagnostics | 33 |
| Stream 5 Exception Handling | 38 |
| Stream 6 Data Collection | 40 |
| Stream 7 Process Program Management | 43 |
| Stream 9 Terminal Services | 45 |
| Stream 10 Terminal Services | 46 |
| CCode (S7F23 & S7F26 Format Example) | 47 |

Amendments

| Date | Comments |
|------------|---|
| 2022/02/13 | File created. |
| | 1. Add RCMD PAUSE, RESUME |
| 2022/03/02 | 2. Modify RCMD GOREMOTE/GOLOCAL to GO-REMOTE/GO-LOCAL |
| | 3. Update ALID and ALTX |
| 2022/3/10 | 1. Update VID 307, 607 description |
| 2022/3/23 | 1. Modify VID 9 description |
| 2022/3/23 | 2. Add CCode definition |
| | Add Data Format and Data Item List |
| 2022/4/17 | 2. Modify RPTID |
| | 3. Add SVID 28 and 29 |
| 2022/5/5 | 1. Edit VID List |
| 2022/5/6 | 1. Edit VID List |
| 2022/3/0 | 2. Edit Report List |
| 2022/5/6 | 1. Modify VID 345 \ 346 \ 375 \ 376 |
| | 1. Delete VID:663 \ 662 \ 665 \ 667 \ 664 \ 666 \ 671 |
| 2022/5/23 | 2. Modify RCMD: PPSELECT => PP-SELECT |
| | |
| 2022/5/27 | 1. Modify VID Process Status 、Control Status 、NT_Status 、CVP_Status |
| 2022/3/27 | 2. Modify LotProcessCount Descript |
| 2022/06/13 | 1. Delete VID 632 - VID 632 = VID654 |
| 2022/08/11 | 1. ADD SV 678 CVP_ProcessCount |
| 2022/06/11 | 2. Normal Flow Chart Edit |
| 2022/10/17 | 1. Add CEID 254(CVP_1Step_Start) \ 255(CVP_2Step_Start) |

| 1. Add New VID 679 CVP_ExecPPID |
|---------------------------------|
| 1. |

Introduction

For the goal of SECS Automation, Device NT300 and CVP600/CVP1500SP/CVP1700SP associates with SECS GEM with Equipment(ArisPLC as follows) software. Following the protocol specify in SECS/GEM standards that developed by the SEMI organization, and it has the capability to communicate with a computer which implement the same standards.

Term Definition:

Equipment >Device(NT300 & CVP600/CVP1500SP/CVP1700SP) with ArisPLC

Host > which send SECS message to Equipment in the fab factory(like EAP).

SECS Information

Communication Parameters

The Equipment provides the following HSMS installation parameters with default value:

| Parameter | Default | Description |
|-------------------|-------------|--|
| ConnectionMode | Passive | This will be used during HSMS connection |
| | | establishment. |
| Local IP address | xxx.xxx.xxx | Equipment IP address |
| | x | |
| Local TCP port | 5000 | Equipment TCP port |
| Remote IP address | xxx.xxx.xxx | Host IP address |
| | x | |
| Remote TCP port | 5000 | Host TCP port |
| Т3 | 45 seconds | Reply timeout (1-120 seconds) |
| T5 | 10 seconds | Connect separation timeout(1-240 seconds) |
| Т6 | 5 seconds | Control transaction timeout(1-240 seconds) |
| Т7 | 10 seconds | Not selected timeout(1-240 seconds) |
| Т8 | 5 seconds | Inter-character timeout(1-120 seconds) |

GEM Compliance

◎ : Provide by SECS driver

○ : Provide by ArisPLC

 $X \ : \text{Not support}$

| Fundamental GEM Requirements | |
|-----------------------------------|---|
| Equipment Processing State | 0 |
| Host Initiated S1F13/F14 Scenario | 0 |
| Event Notification | © |
| On-Line Identification | 0 |

| Error Message | 0 |
|------------------------------------|---------|
| Control Operator Initiated | |
| Additional Capabilities | |
| Establish Communication | \circ |
| Dynamic Event Report Configuration | 0 |
| Variable Data Collection | 0 |
| Trace Data Collection | 0 |
| Status Data Collection | 0 |
| Alarm Management | 0 |
| Remote Control | \circ |
| Equipment Constants | 0 |
| Process Program Management | \circ |
| Material Movement | 0 |
| Equipment Terminal Services | |
| Clock | 0 |
| Limits Monitoring | X |
| Spooling | X |
| Control Host Initiated | 0 |

SEMI Standard Compliance

| SEMI Standards Versions Supported by ArisPLC | | | |
|--|--|--|--|
| Standard | Description | | |
| E4 | SECS-I | | |
| E5 | SECS-II ArisPLC provides only subset of E5 required by E30and E39. | | |
| E30 | GEM | | |
| E37 | HSMS | | |
| E37.1 | HSMS-SS | | |
| E39 | Object Services | | |
| E39.1 | | | |

GEM and Equipment State Model

The State Model describes the GEM and Equipment behavior from Host side. All state model as following:

- 1. Control State Model
- 2. Process State Model

Control State Model

| Value | State |
|-------|---------------|
| 3 | Offline |
| 4 | Online/Local |
| 5 | Online/Remote |

The variable GEM_CONTROL_STATE(SVID: 8) represents current control state and previous control state, and each state will be one of the following values:

Offline

In this state, it means only operators can operate this equipment, and it maybe also means disconnect between Device and ArisPLC, so Host can't get the newest information from Equipment. Any Host primary message will be replied with SnFO Abort message unless the connect between Deviceand ArisPLC.

Online

While ArisPLC connect to Device, it will change to Online state, it means Equipment can accept primary message with S1F13 (Establish Communication Request) and change to Online state.

When in Online state, Host can send S1F15 (Request OFF-LINE) to Equipment and change the state to Offline/Host Offline, and any Host primary message will be replied with SnF0 Abort message unless Host change state to Online by send S1F17 (Request ON-LINE).

Online/Local

Operation of the equipment is implemented by direct action of an operator. All operation commands shall be available for input at the local operator console of the Equipment.

Online/Remote

Equipment accept S1F13 message from Host in Offline state. Operator usually can't operate Equipment in this state unless the permission.

Process State Model

| Value | State |
|-------|-------|
| 1 | Down |
| 2 | Run |
| 4 | Idle |

The variable Equipment and represents current process state and previous process state, and each state will be one of the following values:

Idle

When Equipment is ready to accept Host message, it will change to this state.

Run

Run is the state in which the equipment is executing a process program automatically and can continue to do so without external intervention.

Done

In this state processing is suspended and the equipment is awaiting a command.

Data Dictionary

Data Format

| Format | Standard(Octal) | Нех | SML |
|-------------------------|-----------------|-----|---------|
| List | 00 | 00 | L |
| Binary | 10 | 08 | В |
| Boolean | 11 | 09 | BOOLEAN |
| ASCII | 20 | 10 | А |
| JIS-8 | 21 | 11 | J |
| 8-byte Singed Integer | 30 | 18 | 18 |
| 1-byte Singed Integer | 31 | 19 | I1 |
| 2-byte Singed Integer | 32 | 1A | 12 |
| 4-byte Singed Integer | 34 | 1C | 14 |
| 8-byte Floating Point | 40 | 20 | F8 |
| 4-byte Floating Point | 44 | 24 | F4 |
| 8-byte Unsinged Integer | 50 | 28 | U8 |
| 1-byte Unsinged Integer | 51 | 29 | U1 |
| 2-byte Unsinged Integer | 52 | 2A | U2 |
| 4-byte Unsinged Integer | 54 | 2C | U4 |

Data Item List

| Data Item | Description | Format | Length |
|-----------|----------------------------|--------|--------|
| ACKC5 | Acknowledge code | Binary | 1 |
| | 0 = Accepted | | |
| | >0 = Error, not accepted | | |
| | 1-63 Reserved | | |
| ACKC6 | Acknowledge code | Binary | 1 |
| | 0 = Accepted | | |
| | >0 = Error, not accepted | | |
| | 1-63 Reserved | | |
| ACKC7 | Acknowledge code | Binary | 1 |
| | 0 = Accepted | | |
| | 1 = Permission not granted | | |

| | 2 = Length error | | |
|---------|---|-----------|----|
| | 3 = Matrix overflow | | |
| | 4 = PPID not found | | |
| | 5 = Mode unsupported | | |
| | 6 = Command will be performed | | |
| | with completion signaled later | | |
| | >6 = Other error | | |
| | 7-63 Reserved | | |
| ACKC10 | Acknowledge code | Binary | 1 |
| | 0 = Accepted for display | | |
| | 1 = Message will not be | | |
| | displayed | | |
| | 2 = Terminal not available | | |
| | 3-63 Reserved | | |
| ALCD | Alarm code with set/clear | Binary | 1 |
| | bit 8 = 1 means alarm set | | |
| | bit 8 = 0 means alarm cleared | | |
| | bit 7-1 is alarm category | | |
| | 0 = Not used | | |
| | 1 = Personal safety | | |
| | 2 = Equipment safety | | |
| | 3 = Parameter control warning | | |
| | 4 = Parameter control error | | |
| | 5 = Irrecoverable error | | |
| | 6 = Equipment status warning | | |
| | 7 = Attention flags | | |
| | 8 = Data integrity | | |
| | >8 = Other categories | | |
| | 9-63 Reserved | | |
| ALED | Alarm enable/disable | Binary | 1 |
| | bit 8 = 1 means enable alarm | | |
| | bit 8 = 0 means disable alarm | | |
| ALID | Alarm ID | U-Integer | 4 |
| ALTX | Alarm text message | ASCII | 80 |
| CEED | Collection event enable/disable code | Boolean | 1 |
| | FALSE = Disable | | |
| | TRUE = Enable | | |
| CEID | Collection event ID | U-Integer | 4 |
| СОММАСК | Communications establish acknowledgement code | Binary | 1 |
| | 0 = Accepted | | |
| | 1 = Denied, Try Again | | |
| | 2-63 Reserved | | |
| | | | |

| CPNAME | Command parameter name | ACSII | m |
|--------------------|---|---------------------|-------------|
| CPACK | Command acknowledgement | Integer | 1 |
| CPVAL | Command parameter value | All | m |
| DATAID | Data ID | U-Integer | 2 |
| DATALENGTH | Data length | U-Integer | 4 |
| DRACK | Define report acknowledgement code | Binary | 1 |
| | 0 = Accept | | |
| | 1 = Denied. Insufficient space | | |
| | 2 = Denied. Invalid format | | |
| | 3 = Denied. At least one RPTID | | |
| | already defined | | |
| | 4 = Denied. At least VID does | | |
| | not exist | | |
| | 5 = Denied. At least RPTID not exist while delete | | |
| | >5 = Other errors | | |
| | 6-63 Reserved | | |
| EAC | Equipment acknowledgement code | Binary | 1 |
| | 0 = Acknowledge | | |
| | 1 = Denied. At least one | | |
| | constant does not exist | | |
| | 2 = Denied. Busy | | |
| | 3 = Denied. At least one | | |
| | constant out of range | | |
| | 4 = Denied. Length zero or SECS format error | | |
| | >4 = Other equipment-specific | | |
| | error | | |
| | 5-63 Reserved | | |
| ECID | Equipment constant ID | U-Integer | 2 |
| ECV | Equipment constant value | All | m |
| ECDEF | | | |
| LCDLI | Equipment constant default value | All | m |
| ECMAX | Equipment constant default value Equipment constant maximum | All | m m |
| | | | |
| ECMAX | Equipment constant maximum | All | m |
| ECMAX ECMIN | Equipment constant maximum Equipment constant minimum | All | m m |
| ECMAX ECMIN ECNAME | Equipment constant maximum Equipment constant minimum Equipment constant name | AII AII ASCII | m m m |
| ECMAX ECMIN ECNAME | Equipment constant maximum Equipment constant minimum Equipment constant name Enable/Disable event report | AII AII ASCII | m m m |
| ECMAX ECMIN ECNAME | Equipment constant maximum Equipment constant minimum Equipment constant name Enable/Disable event report 0 = Accepted | AII AII ASCII | m m m |
| ECMAX ECMIN ECNAME | Equipment constant maximum Equipment constant minimum Equipment constant name Enable/Disable event report 0 = Accepted 1 = Denied. At least one CEID | AII AII ASCII | m m m |
| ECMAX ECMIN ECNAME | Equipment constant maximum Equipment constant minimum Equipment constant name Enable/Disable event report 0 = Accepted 1 = Denied. At least one CEID does not exist | AII AII ASCII | m m m |

| LENGTH | Length of the service program or process program | U-Integer | 1 |
|--------|--|-----------|----|
| LRACK | Link report acknowledgement code | Binary | 1 |
| | 0 = Accepted | | |
| | 1 = Denied. Insufficient space | | |
| | 2 = Denied. Invalid format | | |
| | 3 = Denied. At least one CEID | | |
| | link already defined | | |
| | 4 = Denied. At least one CEID | | |
| | does not exist | | |
| | 5 = Denied. At least one RPTID | | |
| | does not exist | | |
| | >5 = Other errors | | |
| | 6-63 Reserved | | |
| LVACK | Variable Limit definition acknowledgement code | Binary | 1 |
| | 1 = Variable does not exist | | |
| | 2 = Variable has no limits | | |
| | capability | | |
| | 3 = Variable repeated in | | |
| | message | | |
| | 4 = Limit value error as | | |
| | described in LIMITACK | | |
| | 5-63 Reserved | | |
| MDLN | Equipment model type | ACSII | 6 |
| | Same data as returned by S1,F2 | | |
| MHEAD | SECS message block header associated with message block in error | Binary | 10 |
| OFLACK | Acknowledgement code for off-line request | Binary | 1 |
| | 0 = OFF-LINE Acknowledge | | |
| | 1-63 Reserved | | |
| ONLACK | Acknowledgement code for on-line request | Binary | 1 |
| | 0 = ON-LINE Accepted | , | |
| | 1 = ON-LINE Not Allowed | | |
| | 2 = Equipment Already ON-LINE | | |
| | 3-63 Reserved | | |
| PPBODY | Process program body | Binary | М |
| | The process program describes to | | |
| | the equipment, in its own | | |
| | language, the actions to be | | |
| | taken in processing the material | | |
| | it receives. | | |
| PPGNT | Process program grant status | Binary | 1 |
| | 0 = OK | | _ |

| SHEAD | Message header of sent block | Binary | 10 |
|-------|----------------------------------|-----------|--------|
| RPTID | Report ID | U-Integer | 2 |
| RCMD | Remote command | ASCII | m |
| | hexadecimal form. | | |
| | the display should be in | | |
| | display the transmitted code, | | |
| | equipment is not prepared to | | |
| | binary pattern. If the local | | |
| | can be treated as a unique | | |
| | use of the equipment, the PPID | | |
| | be host-dependent. For internal | | |
| | The format used in the PPID will | | |
| | bytes. | | |
| | Limited to a maximum of 80 | | |
| PPID | Process program ID | ASCII | Max 80 |
| | 6-63 Reserved | | |
| | >5 = Other error | | |
| | 5 = Will not accept | | |
| | 4 = Busy, try later | | |
| | 3 = Invalid PPID | | |
| | 2 = No space | | |
| | 1 = Already have | | |

Collected event (CEID)

| CEID | NAME | RPTID | TID Description | | | | |
|------|-------------------------------|-------|--|--|--|--|--|
| | Equipment Control State Event | | | | | | |
| 24 | GEM_OFF_LINE | 1 | Notify Host of control state change to Offline | | | | |
| 25 | GEM_CONTROL_STATE_LOCAL | 1 | Notify Host of control state change to Online-Local | | | | |
| 26 | GEM_CONTROL_STATE_REMOTE | 1 | Notify Host of control state change to Online-Remote | | | | |
| | Recipe Event | | | | | | |
| 103 | PPSelectOK | | Setup fail while Film Barcode NG | | | | |
| 104 | PPSelectNG | 4 | A recipe of NT300 & CVPSet Complete | | | | |
| | | | Panel Event | | | | |
| 201 | Panelin_NT300 | 99 | NT300 operator request Panel start. | | | | |
| 203 | PanelOut_NT300 | 99 | NT300 operator request Panel end. | | | | |
| 251 | Panelin_CVP | 99 | CVP operator request Panel start. | | | | |

| 253 | PanelOut_CVP | 99 | CVP operator request Panel end. | | | | | |
|-----|---------------------|----|---|--|--|--|--|--|
| | Ready Event | | | | | | | |
| 111 | EQPAIIDeviceReady | 3 | NT300 and CVP Ready to Load and Film Barcode OK | | | | | |
| 112 | WaitForStart | 3 | Wait for Start | | | | | |
| | Process Event | | | | | | | |
| 105 | LotStart | 5 | LotStart | | | | | |
| 106 | LotEnd | 5 | LotEnd while all panel count = 0 | | | | | |
| | | 1 | Report Event | | | | | |
| 113 | AbnormalEvnet_NT300 | 99 | AbnormalEvnet_NT300 | | | | | |
| 114 | AbnormalEvnet_CVP | 99 | AbnormalEvnet_CVP | | | | | |
| 254 | CVP_1Step_Start | 99 | CVP_1Step_Start | | | | | |
| 255 | CVP_2Step_Start | 99 | CVP_2Step_Start | | | | | |
| | | | | | | | | |

Report (RPTID)

| RPTID | VID | Туре | Description |
|---------------------|-----|------|-----------------------|
| 1 | 8 | U1 | GEM_CONTROL_STATE |
| 3 | 201 | U1 | EQPReadyStatus |
| 4 | 202 | Α | PPID |
| | 325 | U4 | NT_ExecPPID |
| | 203 | U4 | LotProcessCount |
| 5 | 204 | U4 | LotTotalCount |
| | 206 | Α | LotID |
| 6 | 612 | U4 | CVP_Warm-up_Operation |
| | 619 | U4 | CVP_Number_shots |
| 7 | 628 | F4 | CVP_Tact_time |
| 634 U4 CVP_RecipeNo | | U4 | CVP_RecipeNo |
| 99 PPID | | Α | PPID |
| | 203 | U4 | LotProcessCount |

| 204 | U4 | LotTotalCount |
|-----|----|---------------|
| 206 | Α | LotID |

Variables ID (EC, SV and DV)

| VID | Туре | NAME | Format | Description |
|-----|------|------------------------|------------|--|
| | | Equipmen | t Constar | nt ID |
| 21 | EC | GEM_TIME_FORMAT | U1 | DetermineGemTime and S2F17 format length: |
| | | | | 0: 12 |
| | | | | 1: 16 |
| | | | | default = <u2 0=""></u2> |
| 22 | EC | GEM_WBIT_S5 | U1 | S5F1 |
| | | | | 0: No Reply |
| | | | | 1: Reply |
| 23 | EC | GEM_WBIT_S6 | U1 | S6F1 and S6F11 Reply |
| | | | | 0: No Reply |
| | | | | 1: Reply |
| 27 | EC | GEM_INIT_CONTROL_STATE | U1 | Determine when connect establish whether |
| | | | | controlstate is Online/Local or Online /Remote |
| | | | | 0: Online/Local |
| | | | | 1: Online/Remote |
| | | | | default = <u2 0=""></u2> |
| | | Status \ | /ariable I | D |
| 8 | SV | GEM_CONTROL_STATE | U1 | Current control state value: |
| | | | | 1: Offline/Equipment offline |
| | | | | 2: Offline/Attempt online |
| | | | | 3: Offline/Host offline |

| | | | | 4: Online/Local |
|-----|----|----------------------|----|---|
| | | | | 5: Online/Remote |
| 9 | SV | GEM_PROCESS_STATE | U1 | Current process state value: |
| | | | | 1: Done |
| | | | | 2: Run |
| | | | | 4: Idle |
| 28 | SV | GEM_MDLN | Α | Equipment Model |
| 29 | SV | GEM_SOFTREV | Α | Software Version |
| 201 | SV | EQPReadyStatus | U1 | 0: Not Ready |
| | | | | 1: NT300 Ready |
| | | | | 2: CVP Ready |
| | | | | 3: All Device Ready |
| 202 | SV | PPID | Α | PPID(from Host PP-Select Parameter) |
| 203 | SV | LotProcessCount | U4 | Lot Panel Count for Lot End event trigger |
| | | | | (While Count = LotTotalCount trigger Lot End) |
| 204 | SV | LotTotalCount | U4 | Lot Panel Total Count |
| | | | | (from Host PP-Select Parameter) |
| 205 | SV | ParNo | Α | ParNo |
| 206 | SV | LotID | Α | LotID(from Host PP-Select Parameter) |
| 207 | SV | OpID | Α | OpiD |
| 300 | DV | NT_ProcessReportTime | U4 | NT_ProcessReportTime |
| 301 | SV | NT_PR_Year | U4 | NT_PR_Year |
| 302 | SV | NT_PR_Month | U4 | NT_PR_Month |
| 303 | SV | NT_PR_Day | U4 | NT_PR_Day |
| 304 | SV | NT_PR_Hour | U4 | NT_PR_Hour |
| 305 | SV | NT_PR_Minute | U4 | NT_PR_Minute |
| 306 | SV | NT_PR_Second | U4 | NT_PR_Second |
| 307 | SV | NT_Status | U4 | NT_Status |

| | | | | 1: Down |
|-----|----|----------------------|----|----------------------|
| | | | | 2: Running |
| | | | | 4: Idle |
| 308 | SV | NT_TackF | F4 | NT_TackF |
| 309 | SV | NT_TackR | F4 | NT_TackR |
| 310 | SV | NT_TackingTime | F4 | NT_TackingTime |
| 311 | SV | NT_Tact | F4 | NT_Tact |
| 312 | SV | NT_UpperDiameler | F4 | NT_UpperDiameler |
| 313 | SV | NT_LowerDiameler | F4 | NT_LowerDiameler |
| 314 | SV | NT_Coolingtime | F4 | NT_Coolingtime |
| 315 | DV | NT_NormalRepotTime | U4 | NT_NormalRepotTime |
| 316 | SV | NT_NR_Year | U4 | NT_NR_Year |
| 317 | SV | NT_NR_Month | U4 | NT_NR_Month |
| 318 | SV | NT_NR_Day | U4 | NT_NR_Day |
| 319 | SV | NT_NR_Hour | U4 | NT_NR_Hour |
| 320 | SV | NT_NR_Minute | U4 | NT_NR_Minute |
| 321 | SV | NT_NR_Second | U4 | NT_NR_Second |
| 322 | SV | NT_JobNo | U4 | NT_JobNo |
| 323 | SV | NT_UpperFeedSpeed | F4 | NT_UpperFeedSpeed |
| 324 | SV | NT_LowerFeedSpeed | U4 | NT_LowerFeedSpeed |
| 325 | SV | NT_ExecPPID | U4 | NT_ExecPPID |
| 326 | SV | NT_TackingPointF | F4 | NT_TackingPointF |
| 327 | SV | NT_TackingPointR | F4 | NT_TackingPointR |
| 328 | SV | NT_TackingTime_SV | F4 | NT_TackingTime_SV |
| 329 | SV | NT_UpperTackOn | U4 | NT_UpperTackOn |
| 330 | SV | NT_UpPetModeOn | U4 | NT_UpPetModeOn |
| 331 | SV | NT_LowerTackon | U4 | NT_LowerTackon |
| 332 | SV | NT_LoPetModeOn | U4 | NT_LoPetModeOn |
| 333 | SV | NT_UpTemperature_1PV | F4 | NT_UpTemperature_1PV |

| 334 | SV | NT_UpTemperature_2PV | F4 | NT_UpTemperature_2PV |
|-----|----|----------------------------|----|----------------------------|
| 335 | SV | NT_UpTemperature_3PV | F4 | NT_UpTemperature_3PV |
| 336 | SV | NT_UpTemperature_4PV | F4 | NT_UpTemperature_4PV |
| 337 | SV | NT_UpTemperature_5PV | F4 | NT_UpTemperature_5PV |
| 338 | SV | NT_UpTemperatureKeeper_PV | F4 | NT_UpTemperatureKeeper_PV |
| 339 | SV | NT_LoTemperature_1PV | F4 | NT_LoTemperature_1PV |
| 340 | SV | NT_LoTemperature_2PV | F4 | NT_LoTemperature_2PV |
| 341 | SV | NT_LoTemperature_3PV | F4 | NT_LoTemperature_3PV |
| 342 | SV | NT_LoTemperature_4PV | F4 | NT_LoTemperature_4PV |
| 343 | SV | NT_LoTemperature_5PV | F4 | NT_LoTemperature_5PV |
| 344 | SV | NT_LoTemperatureKeeper_PV | F4 | NT_LoTemperatureKeeper_PV |
| 345 | SV | NT_CutterSpeed | F4 | NT_CutterSpeed_PV |
| 346 | SV | NT_CurrterRevolution | U4 | NT_CurrterRevolution |
| 347 | SV | NT_UpTemperature_1SV | F4 | NT_UpTemperature_1SV |
| 348 | SV | NT_UpTemperature_2SV | F4 | NT_UpTemperature_2SV |
| 349 | SV | NT_UpTemperature_3SV | F4 | NT_UpTemperature_3SV |
| 350 | SV | NT_UpTemperature_4SV | F4 | NT_UpTemperature_4SV |
| 351 | SV | NT_UpTemperature_5SV | F4 | NT_UpTemperature_5SV |
| 352 | SV | NT_UpTemperatureKeeper_SV | F4 | NT_UpTemperatureKeeper_SV |
| 353 | SV | NT_LoTemperature_1SV | F4 | NT_LoTemperature_1SV |
| 354 | SV | NT_LoTemperature_2SV | F4 | NT_LoTemperature_2SV |
| 355 | SV | NT_LoTemperature_3SV | F4 | NT_LoTemperature_3SV |
| 356 | SV | NT_LoTemperature_4SV | F4 | NT_LoTemperature_4SV |
| 357 | SV | NT_LoTemperature_5SV | F4 | NT_LoTemperature_5SV |
| 358 | SV | NT_LoTemperatureKeeper_SV | F4 | NT_LoTemperatureKeeper_SV |
| 359 | SV | NT_Input_work_cooling_time | F4 | NT_Input_work_cooling_time |
| 360 | SV | NT_Film Thickness | U4 | NT_Film Thickness |
| 361 | SV | NT_Panel_X | U4 | NT_Panel_X |
| 362 | SV | NT_Panel_Y | U4 | NT_Panel_Y |
| | | | • | |

| 363 | SV | NT_Clamp | U4 | NT_Clamp |
|-----|----|---------------------------|----|-------------------------------|
| 364 | SV | NT_UP_Niproll_Delay | U4 | NT_UP_Niproll_Delay |
| 365 | SV | NT_UP_Quick_Stop_Distance | U4 | NT_UP_Quick_Stop_Distance |
| 366 | SV | NT_UP_Speed | U4 | NT_UP_Speed_SV |
| 367 | SV | NT_LO_Niproll_Delay | U4 | NT_LO_Niproll_Delay |
| 368 | SV | NT_LO_Quick_Stop_Distance | U4 | NT_LO_Quick_Stop_Distance |
| 369 | SV | NT_LO_Speed | U4 | NT_LO_Speed_SV |
| 370 | SV | NT_UP_ClampTorq | U4 | NT_UP_ClampTorq |
| 371 | SV | NT_UP_Plate_Close_Torque | U4 | NT_UP_Plate_Close_Torque |
| 372 | SV | NT_LO_ClampTorq | U4 | NT_LO_ClampTorq |
| 373 | SV | NT_LO_Plate_Close_Torque | U4 | NT_LO_Plate_Close_Torque |
| 374 | SV | NT_Tacking_Offset_Rear | U4 | NT_Tacking_Offset_Rear |
| 375 | SV | NT_Speed | U4 | NT_Speed_SV |
| 376 | SV | NT_Revolution | U4 | NT_Revolution_SV |
| 373 | 0. | | 0 | The Same as 346 NT_Revolution |
| 377 | SV | NT_Vacuum_UP_1 | U4 | NT_Vacuum_UP_1 |
| 378 | SV | NT_Vacuum_UP_2 | U4 | NT_Vacuum_UP_2 |
| 379 | SV | NT_Vacuum_UP_3 | U4 | NT_Vacuum_UP_3 |
| 380 | SV | NT_Vacuum_LO_1 | U4 | NT_Vacuum_LO_1 |
| 381 | SV | NT_Vacuum_LO_2 | U4 | NT_Vacuum_LO_2 |
| 382 | SV | NT_Vacuum_LO_3 | U4 | NT_Vacuum_LO_3 |
| 600 | DV | CVP_ProcessReportTime | U4 | CVP_ProcessReportTime |
| 601 | SV | CVP_PRC_Year | U4 | CVP_PRC_Year |
| 602 | SV | CVP_PRC_Month | U4 | CVP_PRC_Month |
| 603 | SV | CVP_PRC_Day | U4 | CVP_PRC_Day |
| 604 | SV | CVP_PRC_Hour | U4 | CVP_PRC_Hour |
| 605 | SV | CVP_PRC_Minute | U4 | CVP_PRC_Minute |
| 606 | SV | CVP_PRC_Second | U4 | CVP_PRC_Second |
| 607 | SV | CVP_Status | U4 | CVP600_Status |

| | | | | 1: Down |
|-----|----|---------------------------------|----|---|
| | | | | 2: Running |
| | | | | 4: Idle |
| 608 | SV | CVP_Pre_processing_waiting_time | F4 | CVP_Pre_processing_waiting_time |
| 609 | SV | CVP_Waiting_time_limit | F4 | CVP_Waiting_time_limit |
| 610 | SV | CVP_Film_Crimping_step | F4 | CVP_Film_Crimping_step |
| 611 | SV | CVP_Film_mm | F4 | CVP_Film_mm |
| 612 | SV | CVP_Warm-up_Operation | U4 | CVP_Warm-up_Operation |
| 613 | SV | CVP_Monitoring | U4 | CVP_Monitoring |
| 614 | SV | CVP_Vacuum_Reaching_Time | F4 | CVP_Vacuum_Reaching_Time |
| 615 | SV | CVP_Vacuuming | F4 | CVP_Vacuuming CVP_1st_Vaccum_Time_PV |
| 616 | SV | CVP_Vacuum_PV | F4 | CVP_Vacuum_PV CVP_1st_Vaccum_PV |
| 617 | SV | CVP_1step_press | F4 | CVP_1step_press CVP_1st_1step_Press_Time_PV |
| 618 | SV | CVP_2step_press | F4 | CVP_2step_press CVP_1st_2step_Press_Time_PV |
| 619 | SV | CVP_Number_shots | U4 | CVP_Number_shots |
| 620 | SV | CVP_Presssure | F4 | CVP_Presssure CVP_1st_1step_Press_PV CVP_1st_2step_Press_PV |
| 621 | SV | CVP_Press | F4 | CVP_Press CVP_2nd_Press_Time_PV |
| 622 | SV | CVP_Panel_transfer_pause_time | F4 | CVP_Panel_transfer_pause_time |
| 623 | SV | CVP_Out_cooling_time | F4 | CVP_Out_cooling_time |
| 624 | SV | CVP_Forward_up | F4 | CVP_Forward_up |
| 625 | SV | CVP_Forward_lo | F4 | CVP_Forward_lo |
| 626 | SV | CVP_Rewind_Up | F4 | CVP_Rewind_Up |
| 627 | SV | CVP_Rewind_Lo | F4 | CVP_Rewind_Lo |
| 628 | SV | CVP_Tact_time | F4 | CVP_Tact_time |

| 629 | SV | CVP_Film_Feed | F4 | CVP_Film_Feed |
|-----|----|---|----|---|
| 630 | SV | CVP_JobNo | U4 | CVP_JobNo |
| 631 | SV | CVP_Conveyor_Stop_Timing | F4 | CVP_Conveyor_Stop_Timing |
| 633 | SV | CVP_1st_Vaccum_SV | F4 | CVP_1st_Vaccum_SV |
| 634 | SV | CVP_RecipeNo | U4 | CVP_RecipeNo |
| 635 | SV | CVP_Vacumming_Time_SV | F4 | CVP_Vacumming_Time_SV |
| 636 | SV | CVP_Size_X | U4 | CVP_Size_X |
| 637 | SV | CVP_Size_Y | U4 | CVP_Size_Y |
| 638 | SV | CVP_Film_Thickness | U4 | CVP_Film_Thickness |
| 639 | SV | CVP_1st_1step_Press_SV | U4 | CVP_1st_1step_Press_SV |
| 640 | SV | CVP_1st_1step_Press_Time_SV | U4 | CVP_1st_1step_Press_Time_SV |
| 641 | SV | CVP_1st_2step_Press_SV | U4 | CVP_1st_2step_Press_SV |
| 642 | SV | CVP_1st_2step_Press_Time_SV | U4 | CVP_1st_2step_Press_Time_SV |
| 643 | SV | CVP_1st_Upper_Temp_SV | U4 | CVP_1st_Upper_Temp_SV |
| 644 | SV | CVP_1st_Lower_Temp_SV | U4 | CVP_1st_Lower_Temp_SV |
| 645 | SV | CVP_2nd_Press_SV | U4 | CVP_2nd_Press_SV |
| 646 | SV | CVP_2nd_Press_Time_SV | U4 | CVP_2nd_Press_Time_SV |
| 647 | SV | CVP_2ndStage_Up _Temperature_3_SV | U4 | CVP_2ndStage_Up _Temperature_3_SV |
| 648 | SV | CVP_2ndStage_Up_Temperature_2_S V | U4 | CVP_2ndStage_Up_Temperature_2_SV |
| 649 | SV | CVP_2ndStage_Up_Temperature_1_S V | U4 | CVP_2ndStage_Up_Temperature_1_SV |
| 650 | SV | CVP_2ndStage_Lo_Temperature_3_S V | U4 | CVP_2ndStage_Lo_Temperature_3_SV |
| 651 | SV | CVP_2ndStage_Lo_Temperature_2_S V | U4 | CVP_2ndStage_Lo_Temperature_2_SV |
| 652 | SV | CVP_2ndStage_Lo_Temperature_1_S V | U4 | CVP_2ndStage_Lo_Temperature_1_SV |
| 653 | SV | CVP_Input_Conveyor_Pre- Process_Waiting_Time | U4 | CVP_Input_Conveyor_Pre- Process_Waiting_Time |

| 654 | SV | CVP_Input_Timing_Timer | U4 | CVP_Input_Timing_Timer |
|------------------|----|---|----|---|
| 655 | SV | CVP_Input_Start_timing_Film_Feed_a rmount | U4 | CVP_Input_Start_timing_Film_Feed_armount |
| 656 | SV | CVP_1Step_Crimp_First_Position_Fil m_Feed_Amount | U4 | CVP_1Step_Crimp_First_Position_Film_Feed_ Amount |
| 657 | SV | CVP_2Step_Second_Crimp_Increment _Position | U4 | CVP_2Step_Second_Crimp_Increment_Position |
| 658 | SV | CVP_Film_Feed_Speed | U4 | CVP_Film_Feed_Speed |
| 659 | SV | CVP_UP_Tension | U4 | CVP_UP_Tension |
| 660 | SV | CVP_LO_Tension | U4 | CVP_LO_Tension |
| 661 | SV | CVP_OutPut_Cooling_Time | U4 | CVP_OutPut_Cooling_Time |
| 668 | SV | CVP_1st_Upper_Temp_PV | U4 | CVP_1st_Upper_Temp_PV |
| 669 | SV | CVP_1st_Lower_Temp_PV | U4 | CVP_1st_Lower_Temp_PV |
| 670 | SV | CVP_2nd_Press_PV | U4 | CVP_2nd_Press_PV |
| 672 | SV | CVP_2ndStage_Up _Temperature_3_PV | U4 | CVP_2ndStage_Up _Temperature_3_PV |
| 673 | SV | CVP_2ndStage_Up_Temperature_2_P V | U4 | CVP_2ndStage_Up_Temperature_2_PV |
| 674 | SV | CVP_2ndStage_Up_Temperature_1_P V | U4 | CVP_2ndStage_Up_Temperature_1_PV |
| 675 | SV | CVP_2ndStage_Lo_Temperature_3_P V | U4 | CVP_2ndStage_Lo_Temperature_3_PV |
| 676 | SV | CVP_2ndStage_Lo_Temperature_2_P V | U4 | CVP_2ndStage_Lo_Temperature_2_PV |
| 677 | SV | CVP_2ndStage_Lo_Temperature_1_P V | U4 | CVP_2ndStage_Lo_Temperature_1_PV |
| 678 | SV | CVP_ProcessCount | U4 | CVP_ProcessCount |
| <mark>679</mark> | SV | CVP_ExecPPID | A | CVP Current PPID |

Alarm (ALID)

| ALID | ALTX |
|-------|------|
| NT300 | |

| 2001 | M4: INPUT CONVEYOR ERR. |
|------|-------------------------------------|
| 2002 | M5: ME2 CENTERING ERR. |
| 2003 | M6: ME3 FEED ROLLER ERR. |
| 2004 | M7: MT1 UP. FILM FEEDER ERR. |
| 2005 | M8: MT2 LO. FILM FEEDER ERR. |
| 2006 | M9: MT3 UP. CUTTER ROTATING ERR. |
| 2007 | M10: MT4 LO.CUTTER ROTATING ERR. |
| 2008 | M11: MT5 UP. CUTTER DRIVE ERR. |
| 2009 | M12: MT6 LO. CUTTER DRIVE ERR. |
| 2010 | M13: MT7 UP. REAR-END SUC. BAR ERR. |
| 2011 | M14: MT8 LO. REAR-END SUC. BAR ERR. |
| 2012 | M15: MD1 PANEL CLAMP ERR. |
| 2013 | M16: CPU UNIT LOW BATTERY |
| 2014 | M17: EMERGENCY STOP SW. ON |
| 2015 | M18: INPUT CONVEYOR DOOR OPEN |
| 2016 | M19: EJECT CONVEYOR DOOR OPEN |
| 2017 | M20: LOW PRESSURE ALARM |
| 2018 | M21: UP. FILM HEATER 1 WIRE DISCON. |
| 2019 | M22: UP. FILM HEATER 2 WIRE DISCON. |
| 2020 | M23: UP. FILM HEATER 3 WIRE DISCON. |
| 2021 | M24: UP. FILM HEATER 4 WIRE DISCON. |
| 2022 | M25: UP. FILM HEATER 5 WIRE DISCON. |
| 2023 | M26: UP. FILM KEEPER WIRE DISCON. |
| 2024 | M27: LO. FILM HEATER 1 WIRE DISCON. |
| 2025 | M28: LO. FILM HEATER 2 WIRE DISCON. |
| 2026 | M29: LO. FILM HEATER 3 WIRE DISCON. |
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| 2027 | M30: LO. FILM HEATER 4 WIRE DISCON. |
|------|---------------------------------------|
| 2028 | M31: LO. FILM HEATER 5 WIRE DISCON. |
| 2029 | M32: LO. FILM KEEPER WIRE DISCON. |
| 2030 | M33: UP. FILM HEATER 1 TEMP. TOO HIGH |
| 2031 | M34: UP. FILM HEATER 2 TEMP. TOO HIGH |
| 2032 | M35: UP. FILM HEATER 3 TEMP. TOO HIGH |
| 2033 | M36: UP. FILM HEATER 4 TEMP. TOO HIGH |
| 2034 | M37: UP. FILM HEATER 5 TEMP. TOO HIGH |
| 2035 | M38: UP. FILM KEEPER TEMP. TOO HIGH |
| 2036 | M39: LO. FILM HEATER 1 TEMP. TOO HIGH |
| 2037 | M40: LO. FILM HEATER 2 TEMP. TOO HIGH |
| 2038 | M41: LO. FILM HEATER 3 TEMP. TOO HIGH |
| 2039 | M42: LO. FILM HEATER 4 TEMP. TOO HIGH |
| 2040 | M43: LO. FILM HEATER 5 TEMP. TOO HIGH |
| 2041 | M44: LO. FILM KEEPER TEMP. TOO HIGH |
| 2042 | M45: THERMAL VACUUM BLO. MOTOR |
| 2043 | M46: INVERTER ERR. AT EJECT CON. |
| 2044 | M47: UP. FILM FEEDER TQ. MOTOR ALARM |
| 2045 | M48: LO. FILM FEEDER TQ. MOTOR ALARM |
| 2046 | M49:Up Cutter Rotation Motor Alarm |
| 2047 | M50:Lo Cutter Rotation Motor Alarm |
| 2048 | M51: ANALOG OUTPUT UNIT ERR. |
| 2049 | M53: MAIN BODY DOOR IS OPEN |
| 2050 | M54: UP. VACUUM PRESSURE IS LOW |
| 2051 | M55: LO. VACUUM PRESSURE IS LOW |
| 2052 | M56: PANEL CLAMP FAILED |
| | |

| 2053 | M57: PANEL FEED FAILED |
|------|--------------------------------------|
| 2054 | M58:PANEL CENTERING FAILED |
| 2055 | M59: PANEL EJECT FAILED |
| 2056 | M60:IN-CON.CLAMP CYCLE OVER |
| 2057 | M61:IN-CON. UNCLAMP CYCLE OVER |
| 2058 | M65:Upper Film error |
| 2059 | M66:Lower Film error |
| 2060 | M67:Upper Film error(DancerRoll) |
| 2061 | M68:Lower Film error(DancerRoll) |
| 2062 | M73: UP. FILM DIAMETER SET VALUE |
| 2063 | M74: LO. FILM DIAMETER SET VALUE |
| 2064 | M75: UP. FILM FEED AMOUNT SET VALUE |
| 2065 | M76: LO. FILM FEED AMOUNT SET VALUE |
| 2066 | M77: UP. FILM DIAMETER SET VALUE |
| 2067 | M78: LO. FILM DIAMETER SET VALUE |
| 2068 | M81: PANEL FEED ROLLER UP TIME UP |
| 2069 | M82: PANEL FEED ROLLER DOWN TIME UP |
| 2070 | M83: UP. FILM FEED ROLLER F. TIME UP |
| 2071 | M84: UP. FILM FEED ROLLER B. TIME UP |
| 2072 | M85: LO. FILM FEED ROLLER F. TIME UP |
| 2073 | M86: LO. FILM FEED ROLLER B. TIME UP |
| 2074 | M87: UP. SUCTION PLATE UP TIME UP |
| 2075 | M88: UP. SUCTION PLATE DOWN TIME UP |
| 2076 | M89: LO. SUCTION PLATE UP TIME UP |
| 2077 | M90: LO. SUCTION PLATE DOWN TIME UP |
| 2078 | M91: UP. FILM KEEPER FORWARD TIME UP |
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| 2079 | M92: UP. FILM KEEPER B. TIME UP |
|------|--|
| 2080 | M93: LO. FILM KEEPER FORWARD TIME UP |
| 2081 | M94: LO. FILM KEEPER B. TIME UP |
| 2082 | M95: UP. GUIDE ROLLER UP TIME UP |
| 2083 | M96: UP. GUIDE ROLLER DOWN TIME UP |
| 2084 | M97: LO. GUIDE ROLLER UP TIME UP |
| 2085 | M98: LO. GUIDE ROLLER DOWN TIME UP |
| 2086 | M99: GUIDE ROLLER & EJECT CV F. TIME UP |
| 2087 | M100: GUIDE ROLLER & EJECT CV B. TIME UP |
| 2088 | M101: EJECT CONVEYOR UP TIME UP |
| 2089 | M102: EJECT CONVEYOR DOWN TIME UP |
| 2090 | M103: CLAMP OPEN TIME UP |
| 2091 | M104: CLAMP CLOSE TIME UP |
| 2092 | M105: CLAMP UP TIME UP |
| 2093 | M106: CLAMP DOWN TIME UP |
| 2094 | M108: AIRCON.ERR. |
| 2095 | M109:AIRCON. TEMP ERR. |
| 2096 | M110:AIRCON.LEAK WATER |
| 2097 | M111:IN-CONVEA LO CYCLE ERR. |
| 2098 | M112:IN-CONVEA UP CYCLE ERR. |
| 2099 | M113: UP. FILM TQ. MOTOR FAN ERR. |
| 2100 | M114: LO. FILMTQ. MOTOR FAN ERR. |
| 2101 | M115:Dust collector clogging alarm |
| 2102 | M116: POST PROCESS READY SIGNAL OFF |
| 2103 | M120:In·Film Temperature Err. |
| 2104 | M121:Upper Film count UP |
| - | |

| 2105 | M122:Lower Film count UP |
|------|--|
| 2106 | M123:PC Connection Alarm |
| 2107 | Upper Cutter Motor slip Alarm |
| 2108 | Lower Cutter Motor slip Alarm |
| 2109 | Upper Heater 1 SSR Short Circuit Err. |
| 2110 | Upper Heater 2 SSR Short Circuit Err. |
| 2111 | Upper Heater 3 SSR Short Circuit Err. |
| 2112 | Upper Heater 4 SSR Short Circuit Err. |
| 2113 | Upper Heater 5 SSR Short Circuit Err. |
| 2114 | Upper Keeper Heater SSR Short Circuit Err. |
| 2115 | Lower Heater 1 SSR Short Circuit Err. |
| 2116 | Lower Heater 2 SSR Short Circuit Err. |
| 2117 | Lower Heater 3 SSR Short Circuit Err. |
| 2118 | Lower Heater 4 SSR Short Circuit Err. |
| 2119 | Lower Heater 5 SSR Short Circuit Err. |
| 2120 | Lower Keeper Heater SSR Short Circuit Err. |
| 2121 | Upper Heater 1 Over Current |
| 2122 | Upper Heater 2 Over Current |
| 2123 | Upper Heater 3 Over Current |
| 2124 | Upper Heater 4 Over Current |
| 2125 | Upper Heater 5 Over Current |
| 2126 | Upper Keeper Heater Over Current |
| 2127 | Lower Heater 1 Over Current |
| 2128 | Lower Heater 2 Over Current |
| 2129 | Lower Heater 3 Over Current |
| 2130 | Lower Heater 4 Over Current |
| 1 | |

| 2131 | Lower Heater 5 Over Current |
|------|---|
| 2132 | Lower Keeper Heater Over Current |
| 2133 | NX Temperature Err. |
| | CVP |
| 3001 | NIPROLL SERVO AXIS ERROR |
| 3002 | FORWARDER UPPER ROLLER SERVO AXIS ERROR |
| 3003 | REWINDER UPPER ROLLER SERVO AXIS ERROR |
| 3004 | 1STAGE UP HEATER SRR Err. |
| 3005 | 1STAGE LO HEATER SRR Err. |
| 3006 | 2nd UP HEATER SRR Err. |
| 3007 | 2nd LO HEATER SRR Err. |
| 3008 | 1st Output Board Shift Error |
| 3009 | PLC BATTERY IS LOW. |
| 3010 | EMS BUTTON PRESSED. |
| 3011 | FORWARDER DOOR OPEN |
| 3012 | 1st STAGE DOOR OPEN |
| 3013 | 2nd STAGE DOOR OPEN |
| 3014 | REWINDER DOOR OPEN |
| 3015 | CONTROL PANEL DOOR OPEN |
| 3016 | 3-STAGE DOOR OPEN |
| 3017 | CDA PRESSURE IS LOW |
| 3018 | 1st STAGE UP.HEATER DISCONNECTION |
| 3019 | 1st STAGE LO.HEATER DISCONNECTION |
| 3020 | 2nd STAGE UP.HEATER DISCONNECTION |
| 3021 | 2nd STAGE LO.HEATER DISCONNECTION |
| 3022 | 1st STAGE UP.HEATER OVERHEAT |

| 3023 | 1st STAGE LO.HEATER OVERHEAT |
|----------|---|
| 3024 | 2nd STAGE UP.HEATER OVERHEAT |
| 3025 | 2nd STAGE LO.HEATER OVERHEAT |
| 3026 | 1ST upper sensor is ON VACUUM |
| 3027 | 1st STAGE DRY PUMP ERROR. |
| 3028 | INPUT CONVEYOR INVERTER ERROR |
| 3029 | REWINDER UP.ROLLER MOTOR ALARM |
| 3030 | REWINDER LO.ROLLER MOTOR ALARM |
| 3031 | UPPER FILM IS CUT/NO UPPER FILM |
| 3032 | LOWER FILM IS CUT/NO LOWER FILM |
| 3033 | ANALOG MODULE READY SIGNAL OFF |
| 3034 | Crimping open alarm |
| 3035 | Crimping Close alarm |
| 3036 | Vacuum pump water leak alaram |
| 3037 | PANEL BARRIER DOWN SENSOR TIME OVER |
| 3038 | PANEL BARRIER UP SENSOR TIME OVER |
| 3039 | FORWARDER DOOR OPEN:CYCLE STOP SOON |
| 3040 | FORWARDER UPPER ROLLER IS NOT SET |
| 3041 | FORWARDER LOWER ROLLER IS NOT SET |
| 3042 | FORWARDER UPPER FILM IS LOW (SENSOR ALARM) |
| 3043 | FORWARDER LOWER FILM IS LOW (SENSOR ALARM) |
| 3044 | FORWARDER UP. FILM DIAMETER IS LOW(CAL.ALARM) |
| 3045 | FORWARDER LO. FILM DIAMETER IS LOW(CAL.ALARM) |
| 3046 | PANEL STUCK AT INPUT CONVEYOR |
| 3047 | FORWARDER UPPER FILM IS LOW (SENSOR ERROR) |
| 3048 | FORWARDER UPPER FILM IS LOW (SENSOR ERROR) |
| <u> </u> | |

| 3049 | FORWARDER UP. FILM DIAMETER IS LOW(CAL.ERROR) |
|------|---|
| 3050 | FORWARDER LO. FILM DIAMETER IS LOW(CAL.ERROR) |
| 3051 | INPUT CONVEYOR WAITING TIME OVER(EJECTED) |
| 3052 | PANEL STUCK AT INPUT CONVEYOR |
| 3053 | 1st STAGE UPPER POSITION SENSOR TIME OVER |
| 3054 | 1st STAGE TRANSFER POSITION SENSOR TIME OVER |
| 3055 | 1st STAGE LOWER POSITION SENSOR TIME OVER |
| 3056 | 1st STAGE VACUUM POSITION SENSOR TIME OVER |
| 3057 | 1st STAGE UPPER TEMP. IS LOW |
| 3058 | 1st STAGE LOWER TEMP. IS LOW |
| 3059 | Clean roller count up |
| 3060 | PC Connection Alarm |
| 3061 | 2nd⇔Rewinder upper ionizer alarm |
| 3062 | 2nd⇔Rewinder lower ionizer alarm |
| 3063 | Rewinder upper nip ionizer alarm |
| 3064 | Rewinder lower nip ionizer alarm |
| 3065 | 1st STAGE DOOR OPEN |
| 3066 | 1st STAGE VACUUM SENSOR DISCONNECTION ERROR |
| 3067 | OUTPUT CONVEYOR UPPER FAN ERROR |
| 3068 | OUTPUT CONVEYOR LOWER FAN ERROR |
| 3069 | 1st STAGE UPPER FAN STOPPED |
| 3070 | 1st STAGE LOWER FAN STOPPED |
| 3071 | 2nd STAGE UPPER TEMP. IS LOW |
| 3072 | 2nd STAGE LOWER TEMP. IS LOW |
| 3073 | 1->2 STAGE PANEL PASS SENSOR FAILED |
| 3074 | PANEL PASS SENSOR IS ON WHILE SHUTDOWN |
| | |

| 3075 | 2nd STAGE UPPER FAN STOPPED |
|------|---|
| 3076 | 2nd STAGE LOWER FAN STOPPED |
| 3077 | 2nd STAGE UPPER POSITION SENSOR TIME OVER |
| 3078 | 2nd STAGE TRANSFER POSITION SENSOR TIME OVER |
| 3079 | 2nd STAGE LOWER POSITION SENSOR TIME OVER |
| 3080 | 2nd STAGE DOOR OPEN |
| 3081 | FILM MISALIGNMENT DETECTED IN AUTO.OPERATION |
| 3082 | UPPER NIPROLL OPEN SENSOR TIME OVER |
| 3083 | LOWER NIPROLL OPEN SENSOR TIME OVER |
| 3084 | UPPER NIPROLL CLOSE SENSOR TIME OVER |
| 3085 | LOWER NIPROLL CLOSE SENSOR TIME OVER |
| 3086 | REWINDER UPPER FILM IS FULL (SENSOR ALARM) |
| 3087 | REWINDER LOWER FILM IS FULL (SENSOR ALARM) |
| 3088 | SERVO MOTOR STARTING CONDITION ERROR |
| 3089 | REWINDER UP.FILM DIAMETER IS FULL(CAL.ALARM) |
| 3090 | REWINDER LO.FILM DIAMETER IS FULL(CAL.ALARM) |
| 3091 | FILM FEED LENGTH ALARM (REACHED MAXIMU VALUE) |
| 3092 | REWINDER UPPER FILM IS FULL (SENSOR ALARM) |
| 3093 | REWINDER LOWER FILM IS FULL (SENSOR ALARM) |
| 3094 | REWINDER UP.FILM DIAMETER IS FULL(CAL.ALARM) |
| 3095 | REWINDER LO.FILM DIAMETER IS FULL(CAL.ALARM) |
| 3096 | FILM FEED LENGTH ALARM(REACHED MAXIMUM VALUE) |
| 3097 | REWINDER UPPER TORQUE MOTOR FAN BREAKDOWN |
| 3098 | REWINDER LOWER TORQUE MOTOR FAN BREAKDOWN |
| 3099 | NEXT PROCESS READY SIGNAL OFF |
| 3100 | SHUTTER OPEN SENSOR TIME OVER |
| | |

| 3101 | SHUTTER CLOSE SENSOR TIME OVER |
|------|---|
| 3102 | REWINDER DOOR OPEN |
| 3103 | CONTOROL BOX DOOR OPEN |
| 3104 | SENSOR DETECTED NG PANEL AT OUTPUT CONVEYOR |
| 3105 | PANEL STUCK BETWEEN 2nd STAGE & OUT-CONVEYOR |
| 3106 | PANEL STUCK AT OUTPUT CONVEYOR |
| 3107 | PANEL STUCK AT 2nd STAGE |
| 3108 | 1st STAGE VACUUM VALUE ERROR |
| 3109 | 1st STAGE VACUUM ERROR PANEL IS EJECTED |
| 3110 | 1st STAGE PRESS PRESSURIZING ERROR |
| 3111 | 1st STAGE PRESSURIZING ERROR PANEL IS EJECTED |
| 3112 | 2nd STAGE PRESS PRESSURIZING ERROR |
| 3113 | 2nd STAGE PRESSURIZING ERROR PANEL IS EJECTED |
| 3114 | 2nd STAGE VACUUM VALUE ERROR |
| 3115 | 2nd STAGE VACUUM ERROR PANEL IS EJECTED |
| 3116 | 1st Input Board Shift Error |
| 3117 | 2nd-Out panel shift alarm |

SECS Message Support

Stream 1 Equipment State

| Stream Function | Description | Direction |
|-----------------|-------------------------------------|-------------------|
| S1F0 | Abort Transaction Header only. | H <e< td=""></e<> |
| S1F1 | Are You There Request Header only. | H<>E |

| | On Line Data | |
|-------|--|-------------------|
| S1F2 | L, 2 1. <mdln> 2. <softrev></softrev></mdln> | H<>E |
| S1F3 | Selected Equipment Status Request L, n 1. <svid<sub>1> . n. <svid<sub>n></svid<sub></svid<sub> | H>E |
| S1F4 | Selected Equipment Status Data L, n 1. <sv data<sub="">1> . n. <svdata<sub>n></svdata<sub></sv> | H <e< td=""></e<> |
| S1F11 | Status Variable Namelist Request L, n 1. <svid<sub>1> . n. <svid<sub>n></svid<sub></svid<sub> | H>E |
| S1F12 | Status Variable Namelist Request Reply L,n 1. L, 3 1. <svid<sub>1> 2. <svname<sub>1></svname<sub></svid<sub> | H <e< td=""></e<> |

| | 3. <units<sub>1></units<sub> | |
|-------|------------------------------------|-------------------|
| | 2. L, 3 | |
| | | |
| | | |
| | n. L, 3 | |
| | | |
| | 1. <svid<sub>n></svid<sub> | |
| | 2. <svname<sub>n></svname<sub> | |
| | 3. <units<sub>n></units<sub> | |
| | | |
| | Communication Request | |
| | | |
| C1F12 | L, 2 | H>E |
| S1F13 | 1. <mdln></mdln> | П>Е |
| | 2. <softrev></softrev> | |
| | | |
| | Communications Request Acknowledge | |
| | | |
| | L, 2 | |
| | 1. <commack></commack> | |
| S1F14 | | H <e< td=""></e<> |
| | 2. L, 2 | |
| | 1. <mdln></mdln> | |
| | 2. <softrev></softrev> | |
| | | |
| | Request OFFLINE | |
| S1F15 | | H>E |
| | Header only. | |
| | | |
| | OFFLINE Acknowledge | |
| C1F1C | | H <e< td=""></e<> |
| S1F16 | <oflack></oflack> | H <e< td=""></e<> |
| | | |
| | Request ONLINE | |
| | | |
| S1F17 | Header only. | H>E |
| | | |
| S1F18 | ONLINE Acknowledge | H <e< td=""></e<> |
| 21110 | ONLINE Acknowledge | ПХС |

| <onlack></onlack> | |
|-------------------|--|
| | |

Stream 2 Equipment Control and Diagnostics

| Stream Function | Description | Direction |
|-----------------|--|-------------------|
| S2F0 | Abort Transaction Header only. | H <e< td=""></e<> |
| S2F13 | Equipment Constant Request L, n 1. <ecid<sub>1> . . n. <ecid<sub>n></ecid<sub></ecid<sub> | H>E |
| S2F14 | Equipment Constant Data L, n 1. <ecv<sub>1> . n. <ecv<sub>n></ecv<sub></ecv<sub> | H <e< td=""></e<> |
| S2F15 | New Equipment Constant Send L, n 1. L, 2 1. <ecid<sub>1> 2. <ecv<sub>1> 1. L, 2 n. L, 2</ecv<sub></ecid<sub> | H>E |

| | 1. <ecid<sub>n></ecid<sub> | |
|-------|-------------------------------------|-------------------|
| | 2. <ecv<sub>n></ecv<sub> | |
| | | |
| | New Equipment Constant Acknowledge | |
| S2F16 | | H <e< td=""></e<> |
| | <eac></eac> | |
| | | |
| | Date and Time Request | |
| S2F17 | | H>E |
| | Header only. | |
| | Date and Time Data | |
| | | |
| S2F18 | <time></time> | H <e< td=""></e<> |
| | | |
| | Trace Initialize Send | |
| | | |
| | L, 5 | |
| | 1. <trid></trid> | |
| | 2. <dsper></dsper> | |
| | 3. <totsmp></totsmp> | |
| S2F23 | 4. <repgsz></repgsz> | H>E |
| | 5. L, n | |
| | 1. <svid<sub>1></svid<sub> | |
| | · | |
| | | |
| | n. <svid<sub>n></svid<sub> | |
| | Trace Initialize Acknowledge | |
| | Trade initialize / teknowicage | |
| S2F24 | <tiaack></tiaack> | H <e< td=""></e<> |
| | | |
| | Equipment Constant Namelist Request | |
| S2F29 | | H>E |
| 32123 | L, n | 11/2 |
| | 1. <ecid<sub>1></ecid<sub> | |

| | n. <ecid<sub>n></ecid<sub> | |
|-------|---------------------------------------|-------------------|
| | | |
| | Equipment Constant Namelist | |
| | | |
| | L, n | |
| | 1. L, 6 | |
| | 1. < ECID ₁ > | |
| | 2. < ECNAME ₁ > | |
| | 3. < ECMIN ₁ > | |
| | 4. < ECMAX ₁ > | |
| | 5. < ECDEF ₁ > | |
| | 6. < UNITS ₁ > | |
| S2F30 | 2. L, 6 | H <e< td=""></e<> |
| | | |
| | | |
| | n. L, 6 | |
| | 1. <ecid<sub>n></ecid<sub> | |
| | 2. <ecname<sub>n></ecname<sub> | |
| | 3. <ecmin<sub>n></ecmin<sub> | |
| | 4. <ecmax<sub>n></ecmax<sub> | |
| | 5. <ecdef<sub>n></ecdef<sub> | |
| | 6. <units<sub>n></units<sub> | |
| | | |
| | Date and Time Set | |
| S2F31 | | H>E |
| 32F31 | <time></time> | П>С |
| | | |
| | Date and Time Acknowledge | |
| S2F32 | | H <e< td=""></e<> |
| 32132 | <tiack></tiack> | IINL |
| | | |
| | Define Report | |
| S2F33 | | H>E |
| | L, 2 | |
| | · · · · · · · · · · · · · · · · · · · | • |

| | 1. <dataid></dataid> | | |
|-------|---------------------------------|---------------------|-------------------|
| | 2. L, a | # reports | |
| | 1.L, 2 | report 1 | |
| | 1. <rptid<sub>1></rptid<sub> | | |
| | 2. L, b | # VIDs this report | |
| | 1. <vid<sub>1></vid<sub> | | |
| | | | |
| | | | |
| | b. <vid<sub>b></vid<sub> | | |
| | 2. L, 2 | report 2 | |
| | | | |
| | | | |
| | a. L, 2 | report a | |
| | 1. <rptid<sub>a></rptid<sub> | | |
| | 2. L, c | # VIDs this report | |
| | 1. <vid<sub>1></vid<sub> | | |
| | | | |
| | | | |
| | b. <vid<sub>c></vid<sub> | | |
| | | | |
| | Define Report Acknowledge | | |
| S2F34 | | | H <e< td=""></e<> |
| | <drack></drack> | | |
| | | | |
| | Link Event Report | | |
| | | | |
| | L, 2 | | |
| | 1. <dataid></dataid> | | |
| | 2. L, a | # events | |
| S2F35 | 1. L, 2 | event 1 | H>E |
| | 1. <ceid<sub>1></ceid<sub> | # DDTIDe this super | |
| | | # RPTIDs this event | |
| | 1. <rptid<sub>1></rptid<sub> | | |
| | · | | |
| | h >DDTID > | | |
| | b. <rptid<sub>b></rptid<sub> | | |

| a. L, 2 event a | |
|---|-------------------|
| | |
| | |
| 1. <ceid<sub>a></ceid<sub> | |
| _ ~ | |
| 2. L, c # RPTIDs this event | |
| 1. <rptid₁></rptid₁> | |
| | |
| | |
| b. <rptid<sub>c></rptid<sub> | |
| | |
| Link Event Report Acknowledge | |
| S2F36 | H <e< td=""></e<> |
| <lrack></lrack> | IINE |
| | |
| Enable/Disable Event Report | |
| | |
| L, 5 | |
| 1. <ceed> enable/disable</ceed> | |
| 2. L, n S2F37 | H>E |
| 1. <ceid<sub>1></ceid<sub> | 117 2 |
| · | |
| · | |
| n. <ceid<sub>n></ceid<sub> | |
| | |
| Enable Event Report Acknowledge | |
| S2F38 | H <e< td=""></e<> |
| <erack></erack> | |
| | |
| Host Command Send | |
| Remote Command(RCMD) supports: | |
| PP-SELECT: Select a PPID for processing. Reply NAK, if the PPID does not exist in the matching Device(NT300 and CVP). | II. F |
| S2F41 START: Start the lot processing. Reply NAK, if the equipment is unable to start processing. | H>E |
| STOP: Stop the lot processing. Reply NAK, if the equipment is unable to stop processing. | |

| | PAUSE: The lot pause, if equipment able to pause. | |
|-------|--|-------------------|
| | RESUME: Resume the pause. | |
| | GO-REMOTE: Set EQ CIM Status is Remote. | |
| | GO-LOCAL: Set EQ CIM Status is Local. | |
| | | |
| | L, 2 | |
| | 1. | |
| | 2. L, 1 | |
| | 1. L, n | |
| | 1. <cpname<sub>n></cpname<sub> | |
| | 2. <cpval<sub>n></cpval<sub> | |
| | < n = 3 > | |
| | PP-SELECT | |
| | <a>CPNAME₁: PPID | |
| | <a>CPVAL₁: | |
| | <a>CPNAME₂: LotID | |
| | <a>CPVAL₂: | |
| | <a>CPNAME₃: QTY | |
| | <a>CPVAL₃: | |
| | | |
| | < others n = 0 > | |
| | Host Command Acknowledge | |
| | | |
| | L, 2 | |
| | 1. <hcack></hcack> | |
| | | |
| S2F42 | 0: Acknowledge, command has been performed. | H <e< td=""></e<> |
| | 1: Command does not exist. | |
| | 2: Cannot perform now. | |
| | 3: At least one parameter is invalid. | |
| | 4: Acknowledge,command will be performed with completion signaled later. | |

Stream 5 Exception Handling

| Stream Function | Description | Direction |
|-----------------|-------------|-----------|
|-----------------|-------------|-----------|

| Ab | ort Transaction | |
|--|---|-------------------|
| S5F0 He | ader only. | H <e< td=""></e<> |
| Ala | arm Report Send | |
| L, 3 | 1. <alcd> 2. <alid> 3. <altx></altx></alid></alcd> | H <e< td=""></e<> |
| Ala | arm Report Acknowledge | |
| S5F2 <a< td=""><td>CKC5></td><td>H>E</td></a<> | CKC5> | H>E |
| Ena | able/Disable Alarm Send | |
| S5F3 L, 2 | 1. <aled> 2. <alid></alid></aled> | H>E |
| Ena | able/Disable Alarm Acknowledge | |
| S5F4 <a< td=""><td>CKC5></td><td>H<e< td=""></e<></td></a<> | CKC5> | H <e< td=""></e<> |
| List | t Alarm Request | |
| \$5F5 <a< td=""><td>LID₁, , ALID_n></td><td>H>E</td></a<> | LID ₁ , , ALID _n > | H>E |
| List | t Alarm Data | |
| L, r S5F6 | 1. L, 3 1. <alcd<sub>1> 2. <alid<sub>1></alid<sub></alcd<sub> | H <e< td=""></e<> |
| | 1. L, 3 1. <alcd<sub>1></alcd<sub> | |

| | 2. L, 3 | |
|--------|-------------------------------|-------------------|
| | | |
| | | |
| | m. L, 3 | |
| | 1. <alcd<sub>m></alcd<sub> | |
| | 2. <alid<sub>m></alid<sub> | |
| | 3. <altx<sub>m></altx<sub> | |
| | | |
| | List Enabled Alarm Request | |
| CE E 7 | | USE |
| S5F7 | Header only. | H>E |
| | | |
| | List Enabled Alarm Data | |
| | | |
| | L, m | |
| | 1. L, 3 | |
| | 1. <alcd<sub>1></alcd<sub> | |
| | 2. <alid<sub>1></alid<sub> | |
| | 3. <altx<sub>1></altx<sub> | |
| S5F8 | 2. L, 3 | H <e< td=""></e<> |
| | | |
| | | |
| | m. L, 3 | |
| | 1. <alcd<sub>m></alcd<sub> | |
| | 2. <alid<sub>m></alid<sub> | |
| | 3. <altx<sub>m></altx<sub> | |
| | | |

Stream 6 Data Collection

| Stream Function | Description | Direction |
|-----------------|---|-------------------|
| | Trace Data Send L, 4 1. <trid></trid> | H <e< td=""></e<> |
| | 2. <smpln> 3. <stime></stime></smpln> | |

| | 4. L, n | |
|-------|-----------------------------------|-------------------|
| | 1. <sv<sub>1></sv<sub> | |
| | | |
| | n. <sv<sub>n></sv<sub> | |
| | | |
| | Trace Data Acknowledge | |
| | | |
| S6F2 | <ackc6></ackc6> | H>E |
| | | |
| | Event Report Send | |
| | | |
| | L, 3 | |
| | 1. <dataid></dataid> | |
| | 2. <ceid></ceid> | |
| | 3. L, n | |
| | 1. L,2 | |
| | 1. <dsid<sub>1></dsid<sub> | |
| | 2. L, m | |
| | 1. L, 2 | |
| | 1. <dvname<sub>1></dvname<sub> | |
| | 2. <dvval<sub>1></dvval<sub> | |
| S6F11 | 2. L, 2 | H <e< td=""></e<> |
| | · | |
| | | |
| | m. L, 2 | |
| | 1. <dvname<sub>m></dvname<sub> | |
| | 2. <dvval<sub>m></dvval<sub> | |
| | 2. L, 2 | |
| | | |
| | | |
| | n. L, 2 | |
| | 1. <dsid<sub>n></dsid<sub> | |
| | 2. etc. | |
| | | |
| | Event Report Acknowledge | |
| S6F12 | | H>E |
| | | |

| | <ackc6></ackc6> | |
|----------|---|-------------------|
| | Event Report Request | |
| S6F15 | <ceid></ceid> | H <e< td=""></e<> |
| | Event Report Data | |
| | L, 3 | |
| | 1. <dataid></dataid> | |
| | 2. <ceid></ceid> | |
| | 3. L, n | |
| | 1. L,2 | |
| | 1. <rptid></rptid> | |
| | 2. L, m | |
| S6F16 | 1. L, 2 | H>E |
| 30/10 | 1. <dvname<sub>1></dvname<sub> | 11/2 |
| | 2. <dvval<sub>1></dvval<sub> | |
| | 2. L, 2 | |
| | | |
| | | |
| | m. L, 2 | |
| | 1. <dvname<sub>m></dvname<sub> | |
| | 2. <dvval<sub>m></dvval<sub> | |
| | Individual Report Request ,RPTID is Value ,No Name. | |
| 66540 | | 11.45 |
| S6F19 | <rptid></rptid> | H <e< td=""></e<> |
| | Individual Report Data | |
| | L, m | |
| | 1. L, 2 | |
| | 1. <dvname<sub>1></dvname<sub> | |
| S6F20 | 2. <dvval<sub>1></dvval<sub> | H>E |
| | 2. L, 2 | |
| | · | |
| | | |
| <u> </u> | 1 | 1 |

| m. L, 2 | |
|-----------------------------------|--|
| 1. <dvname<sub>m></dvname<sub> | |
| 2. <dvval<sub>m></dvval<sub> | |
| | |

Stream 7 Process Program Management

| Stream Function | Description | Direction |
|-----------------|---|-------------------|
| | Abort Transaction | |
| S7F0 | Header only. | H <e< td=""></e<> |
| | Delete Process Program Send | |
| S7F17 | L, n 1. <a>Process Program ID | H>E |
| | 2. | |
| | Delete Process Program Acknowledge | |
| | Acknowledge code | |
| | 0 - Accepted | |
| | 1 - Permission not granted | H <e< td=""></e<> |
| | 2 - length error | |
| S7F18 | 3 - matrix overflow | |
| | 4 - PPID not found | |
| | 5 - unsupported mode | |
| | 6 - initiated for asynchronous completion | |
| | 7 - storage limit error | |
| | | |
| | Current PPList Request | |
| \$7F19 | Header only. | H>E |
| | Current PPList Data | |
| S7F20 | L, n 1. <ppid<sub>1> .</ppid<sub> | H <e< td=""></e<> |

| | n. <ppid<sub>n></ppid<sub> | | | | | |
|--------|--|-------------------|--|--|--|--|
| | | | | | | |
| | Process Program Send | | | | | |
| | | | | | | |
| | L, 4 | | | | | |
| | 1. <ppid></ppid> | | | | | |
| | 2. <mdln></mdln> | | | | | |
| | 3. <softrev></softrev> | | | | | |
| | 4. L, c c = number of process commands | | | | | |
| | 1. L, 2 | | | | | |
| | 1. <ccode></ccode> | | | | | |
| S7F23 | 2. L, p p = number of parameters | H>E | | | | |
| 077.20 | 1. <pparm<sub>1></pparm<sub> | | | | | |
| | 27.3.77.4.4.12 | | | | | |
| | · | | | | | |
| | p. <pparm<sub>p></pparm<sub> | | | | | |
| | 2. L, 2 | | | | | |
| | 2. 2, 2 | | | | | |
| | · | | | | | |
| | c. L, 2 | | | | | |
| | 0. 1, 2 | | | | | |
| | Process Program Acknowledge | | | | | |
| | riocess riogiam Acknowledge | | | | | |
| S7F24 | Acknowledge code | H <e< td=""></e<> | | | | |
| | CB-Acknowledge code | | | | | |
| | Current PPBody Request | | | | | |
| | Current it body nequest | | | | | |
| S7F25 | <ppid></ppid> | H>E | | | | |
| | CFFID? | | | | | |
| | Current PPBody Data | | | | | |
| | Carretter Body Bata | | | | | |
| | L, 4 | | | | | |
| S7F26 | 1. <ppid></ppid> | H <e< td=""></e<> | | | | |
| | 2. <mdln></mdln> | | | | | |
| | 3. <softrev></softrev> | | | | | |
| | J. NOOI TINEVA | | | | | |

| 4. L, c c = number of process commands | |
|--|--|
| 1. L, 2 | |
| 1. <ccode></ccode> | |
| 2. L, p p = number of parameters | |
| 1. <pparm<sub>1></pparm<sub> | |
| | |
| | |
| p. <pparm<sub>p></pparm<sub> | |
| 2. L, 2 | |
| | |
| | |
| c. L, 2 | |
| | |
| | |

Stream 9 Terminal Services

| Stream Function | Description | Direction |
|-----------------|---|-------------------|
| S9F1 | Unrecognized Device ID <mhead></mhead> | H <e< td=""></e<> |
| S9F3 | Unrecognized Stream Type <mhead></mhead> | H <e< td=""></e<> |
| | Unrecognized Function Type | H <e< td=""></e<> |
| S9F5 | <mhead></mhead> | |
| S9F7 | Illegal Data <mhead></mhead> | H <e< td=""></e<> |
| S9F9 | Transaction Timer Timeout <shead></shead> | H <e< td=""></e<> |

Stream 10 Terminal Services

| Stream Function | Description | Direction |
|-----------------|---|-------------------|
| S10F0 | Abort Transaction Header only. | H <e< td=""></e<> |
| S10F1 | L,2 1. <tid> 2. <text></text></tid> | H <e< td=""></e<> |
| S10F2 | Terminal Request Acknowledge <ackc10></ackc10> | H>E |
| S10F3 | Terminal Display, Single L, 2 1. <tid> 2. <text></text></tid> | H>E |
| S10F4 | Terminal Display, Single Acknowledge <ackc10></ackc10> | H <e< td=""></e<> |

CCode (S7F23 & S7F26 Format Example)

| Name | Туре | Value | Direction |
|--------------------------------|------|------------------|----------------------------|
| L,4 | | | |
| 1. <ppid></ppid> | А | "UVVWXX" | Recipe Name |
| 2. <gem_mdln></gem_mdln> | А | "NT300" | Name |
| 3. <gem_softrev></gem_softrev> | A | "1.0.0.1" | GEM Revision |
| 4.L,80 | | | |
| 1.L,2 | | | |
| 1. <ccode></ccode> | U2 | 101 | Film Thickness,膜厚 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Film Thickness" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "0.543" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "9.999" | MaxiMum Value |
| 2.L,2 | | | |
| 1. <ccode></ccode> | A | 102 | Panel X,基板 X |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "Panel X" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "404" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9" | MaxiMum Value |
| 3.L,2 | | | |
| 1. <ccode></ccode> | А | 103 | Panel Y,基板 Y |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Panel Y" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "523" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9" | MaxiMum Value |
| 4.L,2 | | | |
| 1. <ccode></ccode> | А | 104 | Clamp, 夾取量 |

| 2.L,7 | | | |
|--------------------------|---|--------------------|----------------------------|
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Clamp" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "6" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| 5.L,2 | | | |
| 1. <ccode></ccode> | А | 105 | Thacking Point F,預貼位置前 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Thacking Point F" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| 6.L,2 | | | |
| 1. <ccode></ccode> | А | 106 | Thacking Point R,預貼位置後 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Thacking Point R" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| 7.L,2 | | | |
| 1. <ccode></ccode> | А | 107 | Tacking Time,預貼時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Tacking Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| 8.L,2 | | | |
| | | | |

| 2.L,7 | | | |
|--------------------------|---|--------------------|----------------------------|
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Temperature 5" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 9.L,2 | | | |
| 1. <ccode></ccode> | А | 109 | UP Temperature 4,溫度上 4 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Temperature 4" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 10.L,2 | | | |
| 1. <ccode></ccode> | А | 110 | UP Temperature 3,溫度上 3 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Temperature 3" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 11.L,2 | | | |
| 1. <ccode></ccode> | А | 111 | UP Temperature 2,溫度上 2 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 12.L,2 | | | |
| | | | |

| 2.L,7 | | | |
|--------------------------|---|--------------------|----------------------------|
| 1. <pparm1-1></pparm1-1> | Α | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Temperature 1" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 13.L,2 | | | |
| 1. <ccode></ccode> | А | 113 | UP Keeper, UP Keeper |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Keeper" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "40" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "80.0" | MaxiMum Value |
| 14.L,2 | | | |
| 1. <ccode></ccode> | А | 114 | LO Temperature 5,溫度下 5 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "LO Temperature 5" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "140.0" | MaxiMum Value |
| 15.L,2 | | | |
| 1. <ccode></ccode> | А | 115 | LO Temperature 4,溫度下 4 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | Α | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | Α | "LO Temperature 4" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | Α | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | Α | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | Α | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | Α | "140.0" | MaxiMum Value |
| 16.L,2 | | | |
| 1. <ccode></ccode> | А | 116 | LO Temperature 3,溫度下 3 |
| | | | |

| 2.L,7 | | | |
|--------------------------|---|--------------------|----------------------------|
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "LO Temperature 3" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | Α | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | Α | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "140.0" | MaxiMum Value |
| 17.L,2 | | | |
| 1. <ccode></ccode> | A | 117 | LO Temperature 2,溫度下 2 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "140.0" | MaxiMum Value |
| 18.L,2 | | | |
| 1. <ccode></ccode> | A | 118 | LO Temperature 1, 溫度下 1 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO Temperature 1" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "50" | SetValue |
| 6. <pparm2-6></pparm2-6> | Α | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "140.0" | MaxiMum Value |
| 19.L,2 | | | |
| 1. <ccode></ccode> | A | 119 | LO Keeper, LO Keeper |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO Keeper" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "40" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "140.0" | MaxiMum Value |
| 20.L,2 | | | |
| 20.1,2 | I | | |

| 1. <pre>1. <pre>PARMI-1></pre></pre> | 2.L,7 | | | |
|---|--------------------------|---|--------------------|----------------------------------|
| 3. <pparm2-3> A "sec" Unit 4.<pparm2-4> A "f4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 1.<ccode> A 121 UP Quick Stop Distance, 上到達位置停止程槽 2.L,7 1.<pparm1-1> A "True" ProcessParameter EnableFlag 7.<pparm2-2> A "10 Quick Stop Distance" ProcessParameter SetValue 6.<pparm2-3> A "mm" Unit 6.<pparm2-5> A "1" SetValue 7.<pparm2-5> A "1.75" MaxiMum Value 2.L,7 1.<pparm1-1> A "f4" Type 7.<pparm2-7> A "1.75" MaxiMum Value 2.L,7 1.<pparm1-1> A "True" ProcessParameter EnableFlag 7.<pparm2-7> A "1.75" MaxiMum Value 7.<pparm2-8> A "1" SetValue 6.<pparm2-8> A "1" Frue" ProcessParameter SetValue 7.<pparm2-8> A "1.75" MaxiMum Value 7.<pparm2-8> A "True" ProcessParameter SetValue 7.<pparm2-8> A "Mmin" Unit 7.<pparm2-8> A "Mmin" Unit 7.<pparm2-8> A "1.97" SetValue 7.<pparm2-8> A "1.97" ProcessParameter SetUalue 7.<pparm2-8> A "1.97" SetValue 7.<pparm2-8> A "1.97" MaxiMum Value 7.<pparm2-8> A "1.97" MaxiMum Value 7.<pparm2-8> A "0" Minimum Value 7.<pparm2-8> A "9.99" MaxiMum Value 7.<pparm< td=""><td>1.<pparm1-1></pparm1-1></td><td>А</td><td>"True"</td><td>ProcessParameterEnableFlag</td></pparm<></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-8></pparm2-7></pparm1-1></pparm2-7></pparm1-1></pparm2-5></pparm2-5></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| A 《PF4》 Type S. Type S. Type S. Type S. Type S. Type S. Type S. Type SetValue SetValue S. Type SetValue SetValue S. Type SetValue SetValue S. Type SetValue Se | 2. <pparm2-2></pparm2-2> | A | "UP Niproll Delay" | ProcessParameter |
| 5 < PPARM2-5> A "0" SetValue 6 < PPARM2-6> A "0" Minimum Value 7 < PPARM2-7> A "9.99" MaxiMum Value 7 < PPARM2-7> A "9.99" MaxiMum Value 7 < PPARM2-7> A "9.99" MaxiMum Value 7 < PPARM2-7> A "121 UP Quick Stop Distance, 上列達位世停止程率 7 < PPARM1-1> A "True" ProcessParameterEnableFlag 7 < PPARM2-2> A "UP Quick Stop Distance" 7 < PPARM2-2> A "Mm" Unit 7 < PPARM2-3> A "mm" Unit 7 < PPARM2-3> A "14" SetValue 7 < PPARM2-5> A "1.75" MaxiMum Value 7 < PPARM2-7> A "1.75" ProcessParameterEnableFlag 7 < PPARM2-7> A "1.75" MaxiMum Value 7 < PPARM2-7> A "1.75" MaxiMum Value 7 < PPARM2-7> A "1.75" ProcessParameterEnableFlag 7 < PPARM2-7> A "1.75" MaxiMum Value 7 < PPARM2-7> A "1.75" MaxiMum V | 3. <pparm2-3></pparm2-3> | A | "sec" | Unit |
| 6 < PPARM2-6> A "0" Minimum Value 7 < PPARM2-7> A "9.99" MaxiMum Value 21.L,2 1. < CCODE> A 121 UP Quick Stop Distance, 上到達位管停止距離 2.L,7 ProcessParameterEnableFlag 2.4-PARM1-1> A "True" ProcessParameter 3. < PPARM2-2> A "UP Quick Stop Distance" ProcessParameter 3. < PPARM2-3> A "mm" Unit 4. < PPARM2-4> A "f-4" Type 5. < PPARM2-5> A "1" SetValue 6. < PPARM2-6> A "0" Minimum Value 7. < PPARM2-7> A "1.75" MaxiMum Value 22.L,2 1. < CCODE> A 122 UP Speed, 上速度 2.L,7 ProcessParameterEnableFlag 3. < PPARM1-1> A "True" ProcessParameterEnableFlag 2. < PPARM2-3> A "UP Speed" ProcessParameter 3. < PPARM2-3> A "My ProcessParameter 4. < PPARM2-3> A "197" SetValue 5. < PPARM2-5> A "197" SetValue 1. < PPARM2-5> A "197" SetValue 1. < PPARM2-6> A "99.999" MaxiMum Value 23.L,2 UP Speed ProcessParameter National ProcessParameter Na | 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 7. <pparm2-7> A "9.99" MaxiMum Value </pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 1. | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 1. 1.1 | 7. <pparm2-7></pparm2-7> | А | "9.99" | MaxiMum Value |
| 2.L,7 1.ePPARM1-1> A "True" ProcessParameterEnableFlag 2.ePPARM2-2> A "UP Quick Stop Distance" ProcessParameter 3.ePPARM2-3> A "mm" Unit 4.ePPARM2-6> A "f4" Type 5.ePPARM2-5> A "1" SetValue 6.ePPARM2-6> A "0" Minimum Value 7.ePPARM2-7> A "1.75" MaxiMum Value 22.L,2 1. Lexeg 1.cCCODE> A 122 UP Speed, 上速度 2.L,7 1.ePPARM1-1> A "True" ProcessParameterEnableFlag 2.ePPARM2-2> A "UP Speed" ProcessParameter 3.ePPARM2-3> A "f4" Type 5.ePPARM2-4> A "f4" Type 5.ePPARM2-5> A "1.97" SetValue 6.ePPARM2-6> A "0" Minimum Value 23.L,2 1.cCCODE> A 123 LO Niproll Delay, 下送出豫範數經歷 2.L,7 1.ePPARM1-1> A "True" ProcessParameter 3.ePPARM2-2> A "123 LO Niproll Delay, 下送出豫範疇 3.ePPARM2-3> A "CO N | 21.L,2 | | | |
| 1. <pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "UP Quick Stop Distance" 3.<pparm2-3> A "mm" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" Minimum Value 7.<pparm2-6> A "0" MaxiMum Value 1.<ccode> A 122 UP Speed, 上速度 2.L,7 1.<pparm1-1> A "True" ProcessParameter 3.<pparm2-2> A "DY Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "64" Type 5.<pparm2-5> A "19" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下遊出蓬輪散動延遲 2.L,7 1PPARM1-1> A "True" ProcessParameter 3PPARM2-7> A "9.999" MaxiMum Value 3PPARM2-7> A "123 LO Niproll Delay, 下遊出蓬輪散動延遲 2.L,7 1PPARM1-1> A "True" ProcessParameter 3PPARM2-8> A "10 Niproll Delay, 下遊出蓬輪散動延遲 2.L,7 1PPARM1-1> A "True" ProcessParameter 3PPARM2-8> A "LO Niproll Delay" ProcessParameter 3PPARM2-8> A "CO Niproll Delay" ProcessParameter 3PPARM2-8> A "Go" Unit 4PPARM2-8> A "Go" Unit 4PPARM2-8> A "Go" Unit 4PPARM2-8> A "Go" Unit 4PPARM2-8> A "Go" SetValue 5PPARM2-8> A "Go" SetValue 6PPARM2-8> A "Go" Minimum Value 7PPARM2-8> A "Go" Minimum Value 7PPARM2-8> A "Go" SetValue 6PPARM2-8> A "Go" Minimum Value 7PPARM2-8> A "Go" Minimum Value</ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 1. <ccode></ccode> | А | 121 | UP Quick Stop Distance,上到達位置停止距離 |
| A | 2.L,7 | | | |
| Distance" Processivarameter Processivarameter | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 4. 4. (*F4***) Type 5. 5. (*PARM2-5>) A "1" SetValue 6. 4. "0" Minimum Value 7. 4. "1.75" MaxiMum Value 22.L,2 1. MaxiMum Value 2.L,7 1. ProcessParameterEnableFlag 2.L,7 1. ProcessParameterEnableFlag 2. ProcessParameter ProcessParameter 3. | 2. <pparm2-2></pparm2-2> | А | | ProcessParameter |
| 5. <pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1.75" MaxiMum Value 22.L,2 1.<ccode> A 122 UP Speed, 上速度 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "UP Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" Minimum Value 7.<pparm2-7> A "99.99" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滚輪散動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-5> A 123 LO Niproll Delay, 下送出滚輪散動延遲 3.L,2 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameterEnableFlag 3.<pparm2-3> A "sec" Unit 4.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue</pparm2-5></pparm2-4></pparm2-3></pparm2-3></pparm2-2></pparm1-1></pparm2-5></pparm1-1></ccode></pparm2-7></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5> | 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| A | 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 7. <pparm2-7> A "1.75" MaxiMum Value 22.L,2 1.<ccode> A 122 UP Speed, 上速度 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "UP Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪酸動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "Sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "O" SetValue 6.<pparm2-5> A "Sec" Unit 4.<pparm2-5> A "Sec" Unit 4.<pparm2-5> A "F4" Type 5.<pparm2-6> A "O" SetValue 6.<pparm2-6> A "O" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-7></pparm2-7></pparm2-7></pparm2-6></pparm2-6></pparm2-5></pparm2-5></pparm2-5></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "1" | SetValue |
| 22.L,7 | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 1. <ccode> A 122 UP Speed, 上速度 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "UP Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輸啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameter 3.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-6> A "0" SetValue 6.<pparm2-6> A "0" SetValue 6.<pparm2-6> A "Sec" Unit 4.<pparm2-6> A "6" SetValue 6.<pparm2-6> A "6" Minimum Value 7.<pparm2-6> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-6></pparm2-6></pparm2-6></pparm2-6></pparm2-6></pparm2-6></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode> | 7. <pparm2-7></pparm2-7> | А | "1.75" | MaxiMum Value |
| 2.L,7 1. ProcessParameterEnableFlag 2. <pparm1-1> A "True" ProcessParameter 3.<pparm2-3> A "Mmin" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1. LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 ProcessParameterEnableFlag 2.<pparm1-1> A "True" ProcessParameter 3.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm1-1> | 22.L,2 | | | |
| 1. <pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "UP Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 1. <ccode></ccode> | А | 122 | UP Speed,上速度 |
| 2. <pparm2-2> A "UP Speed" ProcessParameter 3.<pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出液輸啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 4.4,2PARM2-7> A "9.99" MaxiMum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-7></pparm2-6></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3> A "m/min" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 4. <pparm2-4> A "F4" Type 5.<pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 ProcessParameterEnableFlag 2. A "True" ProcessParameter 3.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm2-7></pparm2-6></pparm2-5></pparm2-4> | 2. <pparm2-2></pparm2-2> | А | "UP Speed" | ProcessParameter |
| 5. <pparm2-5> A "1.97" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5> | 3. <pparm2-3></pparm2-3> | А | "m/min" | Unit |
| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 7. <pparm2-7> A "99.999" MaxiMum Value 23.L,2 1.<ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "1.97" | SetValue |
| 23.L,2LO Niproll Delay, 下送出滾輪啟動延遲2.L,7I.1. <pparm1-1>A "True" ProcessParameterEnableFlag2.<pparm2-2>A "LO Niproll Delay" ProcessParameter3.<pparm2-3>A "sec" Unit4.<pparm2-4>A "F4" Type5.<pparm2-5>A "0" SetValue6.<pparm2-6>A "0" Minimum Value7.<pparm2-7>A "9.99" MaxiMum Value24.L,2"MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 1. <ccode> A 123 LO Niproll Delay, 下送出滾輪啟動延遲 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode> | 7. <pparm2-7></pparm2-7> | А | "99.999" | MaxiMum Value |
| 2.L,7 1. ProcessParameterEnableFlag 2. A "True" ProcessParameterEnableFlag 2. A "LO Niproll Delay" ProcessParameter 3. PPARM2-3> A "sec" Unit 4. Type Type 5. A "0" SetValue 6. A "0" Minimum Value 7. PPARM2-7> A "9.99" MaxiMum Value | 23.L,2 | | | |
| 1. <pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 1. <ccode></ccode> | А | 123 | LO Niproll Delay, 下送出滾輪啟動延遲 |
| 2. <pparm2-2> A "LO Niproll Delay" ProcessParameter 3.<pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3> A "sec" Unit 4.<pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 4. <pparm2-4> A "F4" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2 — —</pparm2-7></pparm2-6></pparm2-5></pparm2-4> | 2. <pparm2-2></pparm2-2> | А | "LO Niproll Delay" | ProcessParameter |
| 5. <pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6></pparm2-5> | 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 7. <pparm2-7> A "9.99" MaxiMum Value 24.L,2</pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 24.L,2 | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| | 7. <pparm2-7></pparm2-7> | А | "9.99" | MaxiMum Value |
| 1. <ccode> A 124 LO Quick Stop Distance,下到達位置停止距離</ccode> | 24.L,2 | | | |
| | 1. <ccode></ccode> | А | 124 | LO Quick Stop Distance,下到達位置停止距離 |

| 2.L,7 | | | |
|--------------------------|---|-----------------------------|-------------------------------|
| · | | // | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO Quick Stop Distance" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "1" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "1.75" | MaxiMum Value |
| 25.L,2 | | | |
| 1. <ccode></ccode> | A | 125 | LO Speed,下速度 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "LO Speed" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "m/min" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "1.99" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0.999" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "99.999" | MaxiMum Value |
| 26.L,2 | | | |
| 1. <ccode></ccode> | А | 126 | UP ClampTorq,上夾板張力 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "UP ClampTorq" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "V" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "1.2" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "1.50" | MaxiMum Value |
| 27.L,2 | | | |
| 1. <ccode></ccode> | А | 127 | UP Plate Close Torque,上吸板卷出張力 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP Plate Close Torque" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "V" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "3.2" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "3.00" | Minimum Value |
| | | i . | 1 |
| 7. <pparm2-7></pparm2-7> | A | "5.00" | MaxiMum Value |

| 1. <ccode></ccode> | А | 128 | LO ClampTorq,下夾板張力 |
|--------------------------|---|----------------------------|-------------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO ClampTorq" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "V" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "1.2" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1.50" | MaxiMum Value |
| 29.L,2 | | | |
| 1. <ccode></ccode> | А | 129 | LO Plate Close Torque,下吸板卷出張力 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "LO Plate Close Torque" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "V" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "3.2" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "3.00" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "5.00" | MaxiMum Value |
| 30.L,2 | | | |
| 1. <ccode></ccode> | А | 130 | Tacking Offset Rear,預貼後位置補正 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Tacking Offset Rear" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "4.5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| 31.L,2 | | | |
| 1. <ccode></ccode> | А | 131 | Speed, 上下切刀驅動速度 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "Speed" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "m/min" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "18.84" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.999" | MaxiMum Value |
| 32.L,2 | | | |
| <u> </u> | | 1 | 1 |

| 2.1、7 1、 | 1. <ccode></ccode> | А | 132 | Revolution,切刀轉速 |
|---|--------------------------|---|------------------|----------------------------|
| 2 < PPARM2-2 > A "Revolution" ProcessParameter 3 < PPARM2-3 > A "Tpm" Unit 4 < PPARM2-3 > A "U4" Type 5 < PPARM2-5 > A "120" SetValue 6 < PPARM2-6 > A "0" Minimum Value 7 < PPARM2-7 > A "9999" MaxiMum Value 33.L,2 | 2.L,7 | | | |
| 3. <pparm2-3> A "rpm" Unit 4.<pparm2-4> A "U4" Type 5.<pparm2-5> A "120" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "9999" MaxiMum Value 33.L2</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 4. ←PPARM2-4> A "U4" Type 5. ←PPARM2-5> A "120" SetValue 6. ←PPARM2-7> A "120" Minimum Value 7. ←PPARM2-7> A "9999" MaxiMum Value 33.L,2 | 2. <pparm2-2></pparm2-2> | A | "Revolution" | ProcessParameter |
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| 6. c.PPARM2-6> A "O" Minimum Value 7. c.PPARM2-7> A "9999" MaxiMum Value 33.L,2 1. <ccode> A 133 Upper Tack ON, 上預期設動 2.L,7 1. c.PPARM1-1> A "True" ProcessParameterEnableFlag 2. c.PPARM2-2> A "Upper Tack ON" ProcessParameter 3. c.PPARM2-3> A "Unit Type 5. c.PPARM2-6> A "O" Minimum Value 6. c.PPARM2-7> A "1" SetValue 6. c.PPARM2-7> A "1" MaxiMum Value 34.L,2 1. <ccode> A 134 Up Pet Mode ON, 上 PET 模式啟動 2.L,7 1. c.PPARM2-2> A "Unit True" ProcessParameter FinableFlag 3. c.PPARM2-2> A "1" SetValue 4. c.PPARM2-3> A "1" MaxiMum Value 3. c.PPARM2-3> A "1" True" ProcessParameter FinableFlag 4. c.PPARM2-3> A "1" ProcessParameter FinableFlag 5. c.PPARM2-3> A "1" True" ProcessParameter FinableFlag 6. c.PPARM2-3> A "1" MaxiMum Value 5. c.PPARM2-3> A "1" MaxiMum Value 6. c.PPARM2-3> A "1" MaxiMum Value 7. c.PPARM2-3> A "True" ProcessParameter FinableFlag 7. c.PPARM2-3> A "" Unit Type 7. c.PPARM2-3> A "" Unit Type 7. c.PPARM2-3> A "" Unit MaxiMum Value 7. c.PPARM2-3> A "" Unit MaxiMum Value 7. c.PPARM2-5> A "1" SetValue 7. c.PPARM2-5> A "1" SetValue 7. c.PPARM2-5> A "1" MaxiMum Value</ccode></ccode> | 4. <pparm2-4></pparm2-4> | A | "U4" | Туре |
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| 7. <pparm2-7> A "1" MaxiMum Value 34.L,2</pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "1" | SetValue |
| 34.L,2 | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
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| 2.L,7 | 34.L,2 | | | |
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| 2. <pparm2-2> A "Up Pet Mode ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 35.L,2 1.<ccode> A 135 Lower Tack ON, 下預貼啟動 2.L,7 1.<pparm1-1> A "True" ProcessParameter EnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-6> A "1" SetValue 6.<pparm2-6> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-7></pparm2-6></pparm2-6></pparm2-6></pparm2-6></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 4. <pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 35.L,2 1.<ccode> A 135 Lower Tack ON, 下預貼啟動 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "U1" Type 5.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4> | 2. <pparm2-2></pparm2-2> | A | "Up Pet Mode ON" | ProcessParameter |
| 5. <pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 35.L,2 Lower Tack ON, 下預貼啟動 2.L,7 PARM1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm2-7></pparm2-6></pparm2-5> | 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 35.L,2 1.<ccode> A 135 Lower Tack ON, 下預貼啟動 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 7. <pparm2-7> A "1" MaxiMum Value 35.L,2 1.<ccode> A 135 Lower Tack ON,下預貼啟動 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 35.L,2 1. <ccode> A 135 Lower Tack ON, 下預貼啟動 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode> | 6. <pparm2-6></pparm2-6> | Α | "0" | Minimum Value |
| 1. <ccode> A 135 Lower Tack ON,下預貼啟動 2.L,7 PPARM1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></ccode> | 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 2.L,7 1. ProcessParameterEnableFlag 1. <pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 35.L,2 | | | |
| 1. <pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1> | 1. <ccode></ccode> | А | 135 | Lower Tack ON,下預貼啟動 |
| 2. <pparm2-2> A "Lower Tack ON" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | Α | "True" | ProcessParameterEnableFlag |
| 4. <pparm2-4> A "U1" Type 5.<pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4> | 2. <pparm2-2></pparm2-2> | A | "Lower Tack ON" | ProcessParameter |
| 5. <pparm2-5> A "1" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5> | 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 7. <pparm2-7> A "1" MaxiMum Value</pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "1" | SetValue |
| | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 36.L,2 | 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| | 36.L,2 | | | |

| 1. <ccode></ccode> | А | 136 | Lo Pet Mode ON,下 PET 模式啟動 |
|--------------------------|-----|------------------|----------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Lo Pet Mode ON" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 37.L,2 | | | |
| 1. <ccode></ccode> | А | 137 | UP 1, 真空吸板上 1 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | Α | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | Α | "UP 1" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "1" | MaxiMum Value |
| 38.L,2 | | | |
| 1. <ccode></ccode> | А | 138 | UP 2, 真空吸板上 2 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "UP 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 39.L,2 | | | |
| 1. <ccode></ccode> | А | 139 | UP 3, 真空吸板上 3 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "UP 3" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | Α | un | Unit |
| 4. <pparm2-4></pparm2-4> | A | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| | l l | | |

| 2.L7 1. | 1. <ccode></ccode> | А | 140 | LO 1, 真空吸板下 1 |
|--|--------------------------|---|--------------------|----------------------------|
| 2. <pparm2-2> A "LO 1" ProcessParameter 3.<pparm2-3> A " Unit 1ype 5.<pparm2-6> A "O" SetValue 6.<pparm2-6> A "O" Minimum Value 7.<pparm2-7> A 14" MaxiMum Value 1. 1.<ccode> A 141 LO 2, 真空吸板下 2 2.L,7 1.<pparm1-1> A "True" ProcessParameter 8. 3.<pparm2-2> A "O" SetValue 6. 4. PPARM2-2> A "LO 2" ProcessParameter 8. 4. PPARM2-3> A "LO 2" ProcessParameter 9. 5. PPARM2-3> A "LO 2" ProcessParameter 9. 5. PPARM2-6> A "O" Minimum Value 7. 4. PPARM2-6> A "O" Minimum Value 7. 4. PPARM2-7> A "L" MaxiMum Value 9. 42. L2 1. CCODE> A 142 LO 3, 真空吸板下 3 1. PPARM2-7> A "L" MaxiMum Value 9. 42. L2 1. CCODE> A 142 LO 3, 真空吸板下 3 1. PPARM2-3> A "L" JUNIT 1. 1. PPARM2-3> A "L" JUNIT 1. 1. PPARM2-3> A "L" MaxiMum Value 9. 42. L2 1. CCODE> A 142 LO 3, 真空吸板下 3 1. PPARM2-3> A "LO 3" ProcessParameter 8. 3. PPARM2-3> A "LO 3" ProcessParameter 9. 3. PPARM2-3> A "LO 3" ProcessParameter 9. 3. PPARM2-3> A "LO 3" ProcessParameter 9. 4. PPARM2-4> A "U1" Type 9. 5. PPARM2-4> A "U1" Type 9. 5. PPARM2-5> A "O" Minimum Value 9. 4. PPARM2-6> A "O" Minimum Value 9. 4. PPARM2-7> A "L" MaxiMum Value 9. 4. PPARM2-7> A "L" ProcessParameter 9. 5. PPARM2-7> A "L" MaxiMum Value 9. 4. PPARM2-7> A "Giass Panel Mode" 9. ProcessParameter 9. 5. PPARM2-8> A "Giass Panel Mode" 9. ProcessParameter 9. 5. PPARM2-8> A "Giass Panel Mode" 9. ProcessParameter 9. 5. PPARM2-8> A "U1" Type 9. 5. PPARM2-8> A "U1" Type 9. 5. PPARM2-8> A "U1" Type 9. 5. PPARM2-8> A "Giass Panel Mode" 9. ProcessParameter 9. 5. PPARM2-8> A "U1" Type 9. 5. PPARM2-8> A "</pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-6></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 41.L2 1.CCODE> A 141 LO 2, 真空吸板下 2 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "10 2" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-3> A "0" Minimum Value 7.<pparm1-1> A "0" MaxiMum Value 42.L2 1.CCODE> A 142 LO 3, 真空吸板下 3 2.L,7 1.<pparm1-1> A "1" MaxiMum Value 42.L2 1.CCODE> A 142 LO 3, 真空吸板下 3 3.<pparm2-3> A "" Unit 1.<pparm1-1> A "True" ProcessParameterEnableFlag 7.<pparm2-3> A "1" MaxiMum Value 42.L2 1.CCODE> A 142 LO 3, 真空吸板下 3 3.<pparm2-3> A "" Unit 1.<pparm1-1> A "True" ProcessParameterEnableFlag 4.<pparm2-3> A "U1" Type 5.<pparm2-3> A "U1" Type 5.<pparm2-3> A "U1" Type 5.<pparm2-3> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-5> A "0" Minimum Value 7.<pparm2-7> A 143 Glass Panel Mode, 股溪珠蛟板ズ 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.L,7 1.<pparm1-1> A "True" ProcessParameter Repairemeter Repai</pparm1-1></pparm1-1></pparm2-7></pparm2-5></pparm2-5></pparm2-3></pparm2-3></pparm2-3></pparm2-3></pparm1-1></pparm2-3></pparm2-3></pparm1-1></pparm2-3></pparm1-1></pparm1-1></pparm2-3></pparm2-3></pparm2-2></pparm1-1></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 4、PPARM2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2-2- | 2. <pparm2-2></pparm2-2> | А | "LO 1" | ProcessParameter |
| S- <pparm2-5> A "O" SetValue </pparm2-5> | 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 6 <pparm2-6> A "0" Minimum Value 7 <pparm2-7> A "1" MaxiMum Value 41.L,2 1.<ccode> A 141</ccode></pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 7. <pparm2-7> A "1" MaxiMum Value </pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 1 | 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 1. 1. LO 2, 真空吸板下 2 2.L,7 1. ProcessParameterEnableFlag 2. ProcessParameter 3. PPARM2-2> A "LO 2" ProcessParameter 3. PPARM2-3> A "U1" Type 5. PPARM2-6> A "O" SetValue 6. PPARM2-6> A "O" Minimum Value 7. PPARM2-7> A "1" MaxiMum Value 42.L,2 LO 3, 真空吸板下 3 2.L,7 ProcessParameterEnableFlag 1. PPARM1-1> A "True" ProcessParameter 2. PPARM2-2> A "LO 3" ProcessParameter 3. PPARM2-3> A "U1" Type 5. PPARM2-3> A "U1" Type 5. PPARM2-4> A "U1" Type 5. PPARM2-5> A "O" Minimum Value 4. PPARM2-7> A "1" MaxiMum Value 3.L,2 Tune ProcessParameterEnableFlag 1. PPARM2-7> A "1" MaxiMum Value 3.L,7 Tune ProcessParameterEnableFlag 2.L,7 Tune ProcessParameterEnableFlag 2.L,7 Tune ProcessParameterEnableFlag 2.L,7 Tune ProcessParameterEnableFlag 2.PPARM2-3> A "Glass Panel Mode" ProcessParameter 3. PPARM | 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 2.L,7 A "True" ProcessParameterEnableFlag 2. <pparm2-2> A "LO 2" ProcessParameter 3.<pparm2-3> A "U Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 42.L,2 1 Interpeach of the company of</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 41.L,2 | | | |
| 1. <pparm1-1-12 "true"="" 2.<pparm2-2-2="" a="" processparameterenableflag=""> A "LO 2" ProcessParameter 3.<pparm2-3-3> A "" Unit 4.<pparm2-4-4> A "U1" Type 5.<pparm2-5-5> A "0" SetValue 6.<pparm2-6-6> A "0" Minimum Value 7.<pparm2-7-7> A "1" MaxiMum Value 42.L,2 1.<ccode> A 142 LO 3, 真空吸板下 3 2.L,7 1.<pparm1-1> A "True" ProcessParameter EnableFlag 2.<pparm2-2> A "0" Unit 4.<pparm2-3> A "" Unit 4.<pparm2-3> A "" Unit 4.<pparm2-4> A "0" SetValue 6.<pparm2-5> A "0" SetValue 7.<pparm2-7> A "1" MaxiMum Value 1.<pparm2-1> A "True" ProcessParameter EnableFlag 7. 4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.6.4. 4.7. 4.4. 4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4. 4.4.<</pparm2-1></pparm2-7></pparm2-5></pparm2-4></pparm2-3></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7-7></pparm2-6-6></pparm2-5-5></pparm2-4-4></pparm2-3-3></pparm1-1-12> | 1. <ccode></ccode> | А | 141 | LO 2, 真空吸板下 2 |
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| 3. <pparm2-3> A """ Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 42.L,2 LO3, 真空吸板下3 2.L,7 ProcessParameterEnableFlag 2.L,7 ProcessParameter 3.<pparm1-1> A "True" ProcessParameter 3.<pparm2-2> A "LO 3" ProcessParameter 3.<pparm2-3> A "U1" Type 5.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "1" MaxiMum Value 43.L,2 I. ProcessParameterEnableFlag 2.L,7 ProcessParameter 1.<pparm1-1> A "True" ProcessParameter 2.<pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-5> A "" Willi</pparm2-5></pparm2-3></pparm2-2></pparm1-1></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
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| 7. <pparm2-7> A "1" MaxiMum Value 42.L,2 1.<ccode> A 142 LO 3,真空吸板下 3 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "LO 3" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-6> A "0" SetValue 6.<pparm2-7> A "1" MaxiMum Value 7.<pparm2-7> A 143 Glass Panel Mode, 玻璃基板模式 2.L,7 1.<pparm1-1> A "True" ProcessParameter 3.<pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 1.<pparm2-3> A "True" ProcessParameterEnableFlag 2.<pparm2-3> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-5> A "0" SetValue 6.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-6></pparm2-5></pparm2-5></pparm2-5></pparm2-4></pparm2-3></pparm2-3></pparm2-3></pparm2-3></pparm2-3></pparm2-2></pparm1-1></pparm2-7></pparm2-7></pparm2-6></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7> | 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 42.L,2 | 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 1. <ccode> A 142 LO 3,真空吸板下 3 2.L,7 </ccode> | 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
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| 3. <pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 43.L,2 1.<ccode> A 143 Glass Panel Mode, 玻璃基板模式 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "U1" Type 5.<pparm2-4> A "U1" Type 5.<pparm2-6> A "0" SetValue 6.<pparm2-6> A "0" SetValue 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-6></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 4. A "U1" Type 5. PPARM2-5> A "0" SetValue 6. A "0" Minimum Value 7. PRAM2-7> A "1" MaxiMum Value 43.L,2 I. Glass Panel Mode, 玻璃基板模式 2.L,7 I. ProcessParameterEnableFlag 2. PPARM1-1> A "True" ProcessParameter 3. PPARM2-2> A "Glass Panel Mode" ProcessParameter 3. PPARM2-3> A "" Unit 4. "PPARM2-4> A "U1" Type 5. PPARM2-5> A "0" SetValue 6. PPARM2-6> A "0" Minimum Value 7. PPARM2-7> A "1" MaxiMum Value | 2. <pparm2-2></pparm2-2> | A | "LO 3" | ProcessParameter |
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| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value 43.L,2 1.<ccode> A 143 Glass Panel Mode,玻璃基板模式 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 7. <pparm2-7> A "1" MaxiMum Value 43.L,2 1.<ccode> A 143 Glass Panel Mode,玻璃基板模式 2.L,7 1.<pparm1-1> A "True" ProcessParameterEnableFlag 2.<pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2></pparm1-1></ccode></pparm2-7> | 5. <pparm2-5></pparm2-5> | A | "0" | SetValue |
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| 2. <pparm2-2> A "Glass Panel Mode" ProcessParameter 3.<pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3></pparm2-2> | 2.L,7 | | | |
| 3. <pparm2-3> A "" Unit 4.<pparm2-4> A "U1" Type 5.<pparm2-5> A "0" SetValue 6.<pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6></pparm2-5></pparm2-4></pparm2-3> | 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
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| 6. <pparm2-6> A "0" Minimum Value 7.<pparm2-7> A "1" MaxiMum Value</pparm2-7></pparm2-6> | 4. <pparm2-4></pparm2-4> | A | "U1" | Туре |
| 7. <pparm2-7> A "1" MaxiMum Value</pparm2-7> | 5. <pparm2-5></pparm2-5> | A | "0" | SetValue |
| | 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 441.2 | 7. <pparm2-7></pparm2-7> | A | "1" | MaxiMum Value |
| • | 44.L,2 | | | |

| 1. <ccode></ccode> | А | 144 | GC-Fime Vacuum,真空吸板啟動 |
|--------------------------|---|--------------------------|----------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "GC-Fime Vacuum" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "1" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 45.L,2 | | | |
| 1. <ccode></ccode> | А | 145 | Film Check Front ON,基板進板檢知 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "Film Check Front ON" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 46.L,2 | | | |
| 1. <ccode></ccode> | А | 146 | Film Check Rear ON,排出基板檢知 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Film Check Rear ON" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 47.L,2 | | | |
| 1. <ccode></ccode> | А | 147 | File Check OFF,檔案檢察關閉 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "File Check OFF" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | un | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "1" | MaxiMum Value |
| 48.L,2 | | | |
| L | | - I | 1 |

| | 1 | 148 | Timmer, 計時器 |
|--------------------------|---|------------------|----------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Timmer" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "30" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | un | MaxiMum Value |
| 49.L,2 | | | |
| 1. <ccode></ccode> | А | 201 | Size X,基板寬 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | Α | "Size X" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | Α | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | Α | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | Α | "410" | SetValue |
| 6. <pparm2-6></pparm2-6> | Α | "200.0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | Α | "700.0" | MaxiMum Value |
| 50.L,2 | | | |
| 1. <ccode></ccode> | А | 202 | Size Y,基板長 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Size Y" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "510" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "200.0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "700.0" | MaxiMum Value |
| 51.L,2 | | | |
| 1. <ccode></ccode> | А | 203 | Film Thickness,基板厚 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Film Thickness" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "0.026" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "9.999" | MaxiMum Value |
| 52.L,2 | | | |

| 1. <ccode></ccode> | А | 204 | 1st Vaccum,一段真空值 |
|--------------------------|---|---------------------------|-------------------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st Vaccum" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "hPa" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "1" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.99" | MaxiMum Value |
| 53.L,2 | | | |
| 1. <ccode></ccode> | А | 205 | 1st Vaccum Time,一段抽真空時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st Vaccum Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "30" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "1" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999" | MaxiMum Value |
| 54.L,2 | | | |
| 1. <ccode></ccode> | А | 206 | 1st 1step Press, 一段 1Step 壓合壓力 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st 1step Press" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "kgf/cm2" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "6.5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9" | MaxiMum Value |
| 55.L,2 | | | |
| 1. <ccode></ccode> | А | 207 | 1st 1step Press Time, 一段 1Step 壓合時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st 1step Press Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "30" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "1" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999" | MaxiMum Value |
| 56.L,2 | | | |
| L | 1 | | I |

| 1. <ccode></ccode> | А | 208 | 1st 2step Press, 一段 2Step 壓合壓力 |
|--------------------------|---|---------------------------|-------------------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st 2step Press" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "kgf/cm2" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "8" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9" | MaxiMum Value |
| 57.L,2 | | | |
| 1. <ccode></ccode> | А | 209 | 1st 2step Press Time, 一段 2Step 壓合時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st 2step Press Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "40" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "1" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999" | MaxiMum Value |
| 58.L,2 | | | |
| 1. <ccode></ccode> | А | 210 | 1st Upper Temp,一段上溫度 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st Upper Temp" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "90" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 59.L,2 | | | |
| 1. <ccode></ccode> | А | 211 | 1st Lower Temp,一段下溫度 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "1st Lower Temp" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "90" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 60.L,2 | | | |
| <u> </u> | | ı | I . |

| 1. <ccode></ccode> | Α | 212 | 2nd Press,二段壓力 |
|--------------------------|---|--------------------------------|------------------------------------|
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2nd Press" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "kgf/cm2" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "8" | SetValue |
| 6. <pparm2-6></pparm2-6> | Α | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9" | MaxiMum Value |
| 61.L,2 | | | |
| 1. <ccode></ccode> | А | 213 | 2nd Press Time,二段壓合時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | Α | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2nd Press Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "60" | SetValue |
| 6. <pparm2-6></pparm2-6> | Α | "1" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999" | MaxiMum Value |
| 62.L,2 | | | |
| 1. <ccode></ccode> | А | 214 | 2ndStage Up Temperature 3,二段上溫度 3 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2ndStage Up Temperature 3" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "85" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 63.L,2 | | | |
| 1. <ccode></ccode> | А | 215 | 2ndStage Up Temperature 2, 二段上溫度 2 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2ndStage Up Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "85" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "185.0" | MaxiMum Value |
| | | | |

| 64.L,2 | | | |
|--------------------------|---|--------------------------------|------------------------------------|
| 1. <ccode></ccode> | A | 216 | 2ndStage Up Temperature 1, 二段上溫度 1 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2ndStage Up Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "85" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "185.0" | MaxiMum Value |
| 65.L,2 | | | |
| 1. <ccode></ccode> | A | 217 | 2ndStage Lo Temperature 3, 二段下溫度 3 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2ndStage Lo Temperature 3" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "85" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 66.L,2 | | | |
| 1. <ccode></ccode> | A | 218 | 2ndStage Lo Temperature 2, 二段下温度 2 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "2ndStage Lo Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "85" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 67.L,2 | | | |
| 1. <ccode></ccode> | А | 219 | 2ndStage Lo Temperature 1, 二段下温度 1 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2ndStage Lo Temperature 2" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "Celsius" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "85" | SetValue |

| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
|--------------------------|---|---|--|
| 7. <pparm2-7></pparm2-7> | А | "185.0" | MaxiMum Value |
| 68.L,2 | | | |
| 1. <ccode></ccode> | A | 220 | Input Conveyor Pre-Process Waiting Time,入料傳送帶前工序等 待時間 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "Input Conveyor Pre- Process Waiting Time" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "U4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "10" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999" | MaxiMum Value |
| 69.L,2 | | | |
| 1. <ccode></ccode> | А | 221 | Conveyor Stop Timing Timer,傳送帶停止時間計時器 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "Conveyor Stop Timing Timer" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "2.5" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.99" | MaxiMum Value |
| 70.L,2 | | | |
| 1. <ccode></ccode> | А | 222 | Waiting Time Limit,等待時間限制 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Waiting Time Limit" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "sec" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "0" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "999.0" | MaxiMum Value |
| 71.L,2 | | | |
| 1. <ccode></ccode> | A | 223 | Input Timeing Timer,投入時間計時器 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | Α | "Input Timeing Timer" | ProcessParameter |
| | | | |

| 4. <pparm2-4></pparm2-4> | Α | "F4" | Туре |
|--------------------------|---|---|---|
| 5. <pparm2-5></pparm2-5> | A | "1.25" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| | | _ | |
| 7. <pparm2-7></pparm2-7> | А | "99.99" | MaxiMum Value |
| 72.L,2 | | | |
| 1. <ccode></ccode> | А | 224 | Input Start Timing Fime Feed Amount,投入時傳送帶傳送量 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "Input Start Timing Fime Feed Amount" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "115" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "999.9999" | MaxiMum Value |
| 73.L,2 | | | |
| 1. <ccode></ccode> | А | 225 | 1Step Crimp First Position Film Feed Amount, 1Step 初次咬合位置 距離 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | A | "1Step Crimp First Position Film Feed Amount" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | А | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | А | "30" | SetValue |
| 6. <pparm2-6></pparm2-6> | А | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "150.0000" | MaxiMum Value |
| 74.L,2 | | | |
| 1. <ccode></ccode> | A | 226 | 2Step Second Crimp Increment Position, 1Step 咬合增量距離 |
| 2.L,7 | | | |
| 1. <pparm1-1></pparm1-1> | A | "True" | ProcessParameterEnableFlag |
| 2. <pparm2-2></pparm2-2> | А | "2Step Second Crimp Increment Position" | ProcessParameter |
| 3. <pparm2-3></pparm2-3> | A | "mm" | Unit |
| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "1.9264" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | A | "150.0000" | MaxiMum Value |
| 75.L,2 | | | |
| 1. <ccode></ccode> | A | 227 | Film Feed Speed,傳送膜速度 |
| 2.L,7 | | | אובא און יירודים בייר |
| ۷.۱., ۱ | | | |

| A 「Film Feed Speed" ProcessParameter 3 - *** - ***************************** | 1. <pparm1-1></pparm1-1> | А | "True" | ProcessParameterEnableFlag |
|--|--------------------------|---|-------------------|---|
| 4. <pparm2-4> A "F4" Type 5. <pparm2-5> A "6" SetValue 6. <pparm2-5> A "1" Minimum Value 7. <pparm2-7> A "18.0" MaxiMum Value 76.L.2</pparm2-7></pparm2-5></pparm2-5></pparm2-4> | 2. <pparm2-2></pparm2-2> | A | "Film Feed Speed" | ProcessParameter |
| 5. <pparm2-5> A "6" SetValue</pparm2-5> | 3. <pparm2-3></pparm2-3> | A | "m/min" | Unit |
| 6 < PPARM2-6> A "1" Minimum Value 7 < | 4. <pparm2-4></pparm2-4> | А | "F4" | Туре |
| 7. | 5. <pparm2-5></pparm2-5> | А | "6" | SetValue |
| Total | 6. <pparm2-6></pparm2-6> | А | "1" | Minimum Value |
| 1. 1. 1. CODE> A 228 UP Tension, 上張力 2.L,7 1. ProcessParameterEnableFlag 2. 2. ProcessParameter 3. PPARM2-2> A "UP Tension" ProcessParameter 3. PPARM2-3> A """ Unit 4. PPARM2-4> A "40" SetValue 6. PPARM2-5> A "0.1" Minimum Value 7. PPARM2-7> A "100.0" MaxiMum Value 7. PRAM2-7> A "100.0" MaxiMum Value 1. PROCESSParameterEnableFlag 2. Lo Tension, 下張力 2.L,7 Unit 1. ProcessParameter 3. PPARM2-2> A "Lo Tension" ProcessParameter 3. PPARM2-3> A """ Unit 4. PPARM2-3> A "40" SetValue 6. PPARM2-5> A "100.0" MaxiMum Value 7. PRAM2-7> A "100.0" MaxiMum Value 1. PPARM2-2> A "1 st Vaccuum slow On, 1st 真空低速度有效 2. PPARM2-3> A "1 st Vaccuum slow On, 1st 真空低速度有效 | 7. <pparm2-7></pparm2-7> | А | "18.0" | MaxiMum Value |
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| | 79.L,2 | | | |
| 2.L,7 | 1. <ccode></ccode> | А | 231 | Vaccum postition Lower postition,真空位置下限 |
| | 2.L,7 | | | |

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| 3. <pparm2-3></pparm2-3> | A | un | Unit |
| 4. <pparm2-4></pparm2-4> | A | "U1" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "0" | SetValue |
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| 7. <pparm2-7></pparm2-7> | A | "1" | MaxiMum Value |
| 80.L,2 | | | |
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| 2.L,7 | | | |
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| 4. <pparm2-4></pparm2-4> | A | "F4" | Туре |
| 5. <pparm2-5></pparm2-5> | A | "4" | SetValue |
| 6. <pparm2-6></pparm2-6> | A | "0.1" | Minimum Value |
| 7. <pparm2-7></pparm2-7> | А | "99.9" | MaxiMum Value |
| | | | |

Normal Flow Chart

