

SECS/GEM 200mm Manual

For the

NT300 & CVP600

Version

1.13

Released

2024/08/22

Index

Index	II
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)	12
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.
2022/03/02	<ol style="list-style-type: none"> 1. Add RCMD PAUSE, RESUME 2. Modify RCMD GOREMOTE/GOLOCAL to GO-REMOTE/GO-LOCAL 3. Update ALID and ALTX
2022/3/10	<ol style="list-style-type: none"> 1. Update VID 307, 607 description
2022/3/23	<ol style="list-style-type: none"> 1. Modify VID 9 description 2. Add CCode definition
2022/4/17	<ol style="list-style-type: none"> 1. Add Data Format and Data Item List 2. Modify RPTID 3. Add SVID 28 and 29
2022/5/5	<ol style="list-style-type: none"> 1. Edit VID List
2022/5/6	<ol style="list-style-type: none"> 1. Edit VID List 2. Edit Report List
2022/5/6	<ol style="list-style-type: none"> 1. Modify VID 345 、 346 、 375 、 376
2022/5/23	<ol style="list-style-type: none"> 1. Delete VID:663 、 662 、 665 、 667 、 664 、 666 、 671 2. Modify RCMD: PPSELECT => PP-SELECT
2022/5/27	<ol style="list-style-type: none"> 1. Modify VID Process Status 、 Control Status 、 NT_Status 、 CVP_Status 2. Modify LotProcessCount Descript
2022/06/13	<ol style="list-style-type: none"> 1. Delete VID 632 , VID 632 = VID654
2022/08/11	<ol style="list-style-type: none"> 1. ADD SV 678 CVP_ProcessCount 2. Normal Flow Chart Edit
2022/10/17	<ol style="list-style-type: none"> 1. Add CEID 254(CVP_1Step_Start) 、 255(CVP_2Step_Start)

2024/08/22	1. Add New VID 679 CVP_ExecPPID
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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.xx x	Equipment IP address
Local TCP port	5000	Equipment TCP port
Remote IP address	xxx.xxx.xxx.xx x	Host IP address
Remote TCP port	5000	Host TCP port
T3	45 seconds	Reply timeout (1-120 seconds)
T5	10 seconds	Connect separation timeout(1-240 seconds)
T6	5 seconds	Control transaction timeout(1-240 seconds)
T7	10 seconds	Not selected timeout(1-240 seconds)
T8	5 seconds	Inter-character timeout(1-120 seconds)

GEM Compliance

◎ : Provide by SECS driver

○ : Provide by ArisPLC

X : Not support

Fundamental GEM Requirements	
Equipment Processing State	○
Host Initiated S1F13/F14 Scenario	○
Event Notification	◎
On-Line Identification	○

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

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 E39.1	Object Services

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 Device and 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 SnFO 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)	Hex	SML
List	00	00	L
Binary	10	08	B
Boolean	11	09	BOOLEAN
ASCII	20	10	A
JIS-8	21	11	J
8-byte Singed Integer	30	18	I8
1-byte Singed Integer	31	19	I1
2-byte Singed Integer	32	1A	I2
4-byte Singed Integer	34	1C	I4
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 0 = Accepted >0 = Error, not accepted 1-63 Reserved	Binary	1
ACKC6	Acknowledge code 0 = Accepted >0 = Error, not accepted 1-63 Reserved	Binary	1
ACKC7	Acknowledge code 0 = Accepted 1 = Permission not granted	Binary	1

	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 0 = Accepted for display 1 = Message will not be displayed 2 = Terminal not available 3-63 Reserved	Binary	1
ALCD	Alarm code with set/clear 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	Binary	1
ALED	Alarm enable/disable bit 8 = 1 means enable alarm bit 8 = 0 means disable alarm	Binary	1
ALID	Alarm ID	U-Integer	4
ALTX	Alarm text message	ASCII	80
CEED	Collection event enable/disable code FALSE = Disable TRUE = Enable	Boolean	1
CEID	Collection event ID	U-Integer	4
COMMACK	Communications establish acknowledgement code 0 = Accepted 1 = Denied, Try Again 2-63 Reserved	Binary	1

CPNAME	Command parameter name	ASCII	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 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	Binary	1
EAC	Equipment acknowledgement code 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	Binary	1
ECID	Equipment constant ID	U-Integer	2
ECV	Equipment constant value	All	m
ECDEF	Equipment constant default value	All	m
ECMAX	Equipment constant maximum	All	m
ECMIN	Equipment constant minimum	All	m
ECNAME	Equipment constant name	ASCII	m
ERACK	Enable/Disable event report 0 = Accepted 1 = Denied. At least one CEID does not exist >1 = Other Errors 2-63 Reserved	Binary	1
FCNID	Function ID	U-Integer	1

LENGTH	Length of the service program or process program	U-Integer	1
LRACK	Link report acknowledgement code 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	Binary	1
LVACK	Variable Limit definition acknowledgement code 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	Binary	1
MDLN	Equipment model type Same data as returned by S1,F2	ACSII	6
MHEAD	SECS message block header associated with message block in error	Binary	10
OFLACK	Acknowledgement code for off-line request 0 = OFF-LINE Acknowledge 1-63 Reserved	Binary	1
ONLACK	Acknowledgement code for on-line request 0 = ON-LINE Accepted 1 = ON-LINE Not Allowed 2 = Equipment Already ON-LINE 3-63 Reserved	Binary	1
PPBODY	Process program body The process program describes to the equipment, in its own language, the actions to be taken in processing the material it receives.	Binary	M
PPGNT	Process program grant status 0 = OK	Binary	1

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

Collected event (CEID)

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

	204	U4	LotTotalCount
	206	A	LotID

Variables ID (EC, SV and DV)

VID	Type	NAME	Format	Description
Equipment Constant ID				
21	EC	GEM_TIME_FORMAT	U1	DetermineGemTime and S2F17 format length: 0: 12 1: 16 default = <U2 0>
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>
Status Variable ID				
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	A	Equipment Model
29	SV	GEM_SOFTREV	A	Software Version
201	SV	EQPReadyStatus	U1	0: Not Ready 1: NT300 Ready 2: CVP Ready 3: All Device Ready
202	SV	PPID	A	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	A	ParNo
206	SV	LotID	A	LotID(from Host PP-Select Parameter)
207	SV	OpID	A	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 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_Vacuuming_Time_SV	F4	CVP_Vacuuming_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_amount	U4	CVP_Input_Start_timing_Film_Feed_amount
656	SV	CVP_1Step_Crimp_First_Position_Film_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_PV	U4	CVP_2ndStage_Up_Temperature_2_PV
674	SV	CVP_2ndStage_Up_Temperature_1_PV	U4	CVP_2ndStage_Up_Temperature_1_PV
675	SV	CVP_2ndStage_Lo_Temperature_3_PV	U4	CVP_2ndStage_Lo_Temperature_3_PV
676	SV	CVP_2ndStage_Lo_Temperature_2_PV	U4	CVP_2ndStage_Lo_Temperature_2_PV
677	SV	CVP_2ndStage_Lo_Temperature_1_PV	U4	CVP_2ndStage_Lo_Temperature_1_PV
678	SV	CVP_ProcessCount	U4	CVP_ProcessCount
679	SV	CVP_ExecPPID	A	CVP Current PPID

Alarm (ALID)

ALID	ALT	TX
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.

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

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

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)

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
S1F1	Are You There Request Header only.	H<>E

S1F2	On Line Data L, 2 1. <MDLN> 2. <SOFTREV>	H<>E
S1F3	Selected Equipment Status Request L, n 1. <SVID ₁ > . . n. <SVID _n >	H>E
S1F4	Selected Equipment Status Data L, n 1. <SV Data ₁ > . . n. <SVData _n >	H<E
S1F11	Status Variable Namelist Request L, n 1. <SVID ₁ > . . n. <SVID _n >	H>E
S1F12	Status Variable Namelist Request Reply L,n 1. L, 3 1. <SVID ₁ > 2. <SVNAME ₁ >	H<E

	3. <UNITS ₁ > 2. L, 3 . . n. L, 3 1. <SVID _n > 2. <SVNAME _n > 3. <UNITS _n >	
S1F13	Communication Request L, 2 1. <MDLN> 2. <SOFTREV>	H>E
S1F14	Communications Request Acknowledge L, 2 1. <COMMACK> 2. L, 2 1. <MDLN> 2. <SOFTREV>	H<E
S1F15	Request OFFLINE Header only.	H>E
S1F16	OFFLINE Acknowledge <OFLACK>	H<E
S1F17	Request ONLINE Header only.	H>E
S1F18	ONLINE Acknowledge	H<E

	<ONLACK>	
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Stream 2 Equipment Control and Diagnostics

Stream Function	Description	Direction
S2F0	Abort Transaction Header only.	H<E
S2F13	Equipment Constant Request L, n 1. <ECID ₁ > . . n. <ECID _n >	H>E
S2F14	Equipment Constant Data L, n 1. <ECV ₁ > . . n. <ECV _n >	H<E
S2F15	New Equipment Constant Send L, n 1. L, 2 1. <ECID ₁ > 2. <ECV ₁ > 2. L, 2 . . n. L, 2	H>E

	1. <ECID _n > 2. <ECV _n >	
S2F16	New Equipment Constant Acknowledge <EAC>	H<E
S2F17	Date and Time Request Header only.	H>E
S2F18	Date and Time Data <TIME>	H<E
S2F23	Trace Initialize Send L, 5 1. <TRID> 2. <DSPER> 3. <TOTSMP> 4. <REPGSZ> 5. L, n 1. <SVID ₁ > . . n. <SVID _n >	H>E
S2F24	Trace Initialize Acknowledge <TIAACK>	H<E
S2F29	Equipment Constant Namelist Request L, n 1. <ECID ₁ >	H>E

	<p>.</p> <p>.</p> <p>n. <ECID_n></p>	
S2F30	<p>Equipment Constant Namelist</p> <p>L, n</p> <p>1. L, 6</p> <p>1. < ECID₁></p> <p>2. < ECNAME₁></p> <p>3. < ECMIN₁></p> <p>4. < ECMAX₁></p> <p>5. < ECDEF₁></p> <p>6. < UNITS₁></p> <p>2. L, 6</p> <p>.</p> <p>.</p> <p>n. L, 6</p> <p>1. <ECID_n></p> <p>2. <ECNAME_n></p> <p>3. <ECMIN_n></p> <p>4. <ECMAX_n></p> <p>5. <ECDEF_n></p> <p>6. <UNITS_n></p>	H<E
S2F31	<p>Date and Time Set</p> <p><TIME></p>	H>E
S2F32	<p>Date and Time Acknowledge</p> <p><TIACK></p>	H<E
S2F33	<p>Define Report</p> <p>L, 2</p>	H>E

	<p>PAUSE: The lot pause, if equipment able to pause.</p> <p>RESUME: Resume the pause.</p> <p>GO-REMOTE: Set EQ CIM Status is Remote.</p> <p>GO-LOCAL: Set EQ CIM Status is Local.</p> <p>L, 2</p> <ol style="list-style-type: none"> 1. <A RCMD> 2. L, 1 <ol style="list-style-type: none"> 1. L, n <ol style="list-style-type: none"> 1. <CPNAME_n> 2. <CPVAL_n> <p>< n = 3 ></p> <p>PP-SELECT</p> <p><A>CPNAME₁: PPID</p> <p><A>CPVAL₁:</p> <p><A>CPNAME₂: LotID</p> <p><A>CPVAL₂:</p> <p><A>CPNAME₃: QTY</p> <p><A>CPVAL₃:</p> <p>< others n = 0 ></p>	
S2F42	<p>Host Command Acknowledge</p> <p>L, 2</p> <ol style="list-style-type: none"> 1. <HCACK> <p>0: Acknowledge, command has been performed.</p> <p>1: Command does not exist.</p> <p>2: Cannot perform now.</p> <p>3: At least one parameter is invalid.</p> <p>4: Acknowledge, command will be performed with completion signaled later.</p>	H<E

Stream 5 Exception Handling

Stream Function	Description	Direction
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S5F0	<p>Abort Transaction</p> <p>Header only.</p>	H<E
S5F1	<p>Alarm Report Send</p> <p>L, 3</p> <ol style="list-style-type: none"> 1. <ALCD> 2. <ALID> 3. <ALTX> 	H<E
S5F2	<p>Alarm Report Acknowledge</p> <p><ACKC5></p>	H>E
S5F3	<p>Enable/Disable Alarm Send</p> <p>L, 2</p> <ol style="list-style-type: none"> 1. <ALED> 2. <ALID> 	H>E
S5F4	<p>Enable/Disable Alarm Acknowledge</p> <p><ACKC5></p>	H<E
S5F5	<p>List Alarm Request</p> <p><ALID₁, ... , ALID_n></p>	H>E
S5F6	<p>List Alarm Data</p> <p>L, m</p> <ol style="list-style-type: none"> 1. L, 3 <ol style="list-style-type: none"> 1. <ALCD₁> 2. <ALID₁> 3. <ALTX₁> 	H<E

	2. L, 3 . . m. L, 3 1. <ALCD _m > 2. <ALID _m > 3. <ALTX _m >	
S5F7	List Enabled Alarm Request Header only.	H>E
S5F8	List Enabled Alarm Data L, m 1. L, 3 1. <ALCD ₁ > 2. <ALID ₁ > 3. <ALTX ₁ > 2. L, 3 . . m. L, 3 1. <ALCD _m > 2. <ALID _m > 3. <ALTX _m >	H<E

Stream 6 Data Collection

Stream Function	Description	Direction
S6F1	Trace Data Send L, 4 1. <TRID> 2. <SMPLN> 3. <STIME>	H<E

	4. L, n 1. <SV ₁ > . n. <SV _n >	
S6F2	Trace Data Acknowledge <ACKC6>	H>E
S6F11	Event Report Send L, 3 1. <DATAID> 2. <CEID> 3. L, n 1. L, 2 1. <DSID ₁ > 2. L, m 1. L, 2 1. <DVNAME ₁ > 2. <DVVAL ₁ > 2. L, 2 . . m. L, 2 1. <DVNAME _m > 2. <DVVAL _m > 2. L, 2 . . n. L, 2 1.<DSID _n > 2. etc.	H<E
S6F12	Event Report Acknowledge	H>E

	<ACKC6>	
S6F15	Event Report Request <CEID>	H<E
S6F16	Event Report Data L, 3 1. <DATAID> 2. <CEID> 3. L, n 1. L, 2 1. <RPTID> 2. L, m 1. L, 2 1. <DVNAME ₁ > 2. <DVVAL ₁ > 2. L, 2 . . m. L, 2 1. <DVNAME _m > 2. <DVVAL _m >	H>E
S6F19	Individual Report Request ,RPTID is Value ,No Name. <RPTID>	H<E
S6F20	Individual Report Data L, m 1. L, 2 1. <DVNAME ₁ > 2. <DVVAL ₁ > 2. L, 2 . .	H>E

	m. L, 2 1. <DVNAME _m > 2. <DVVAL _m >	
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Stream 7 Process Program Management

Stream Function	Description	Direction
S7F0	Abort Transaction Header only.	H<E
S7F17	Delete Process Program Send L, n 1. <A>Process Program ID 2.	H>E
S7F18	Delete Process Program Acknowledge Acknowledge code 0 - Accepted 1 - Permission not granted 2 - length error 3 - matrix overflow 4 - PPID not found 5 - unsupported mode 6 - initiated for asynchronous completion 7 - storage limit error	H<E
S7F19	Current PPList Request Header only.	H>E
S7F20	Current PPList Data L, n 1. <PPID ₁ > .	H<E

	<p>.</p> <p>n. <PPID_n></p>	
S7F23	<p>Process Program Send</p> <p>L, 4</p> <ol style="list-style-type: none"> 1. <PPID> 2. <MDLN> 3. <SOFTREV> 4. L, c c = number of process commands <ol style="list-style-type: none"> 1. L, 2 <ol style="list-style-type: none"> 1. <CCODE> 2. L, p p = number of parameters <ol style="list-style-type: none"> 1.<PPARM₁> . . p.<PPARM_p> 2. L, 2 . . c. L, 2 	H>E
S7F24	<p>Process Program Acknowledge</p> <p>Acknowledge code</p>	H<E
S7F25	<p>Current PPBody Request</p> <p><PPID></p>	H>E
S7F26	<p>Current PPBody Data</p> <p>L, 4</p> <ol style="list-style-type: none"> 1. <PPID> 2. <MDLN> 3. <SOFTREV> 	H<E

	<p>4. L, c c = number of process commands</p> <p> 1. L, 2</p> <p> 1. <CCODE></p> <p> 2. L, p p = number of parameters</p> <p> 1.<PPARM₁></p> <p> .</p> <p> .</p> <p> p.<PPARM_p></p> <p> 2. L, 2</p> <p> .</p> <p> .</p> <p> c. L, 2</p>	
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Stream 9 Terminal Services

Stream Function	Description	Direction
S9F1	Unrecognized Device ID <MHEAD>	H<E
S9F3	Unrecognized Stream Type <MHEAD>	H<E
S9F5	Unrecognized Function Type <MHEAD>	H<E
S9F7	Illegal Data <MHEAD>	H<E
S9F9	Transaction Timer Timeout <SHEAD>	H<E

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Stream 10 Terminal Services

Stream Function	Description	Direction
S10F0	Abort Transaction Header only.	H<E
S10F1	Terminal Request L,2 1. <TID> 2. <TEXT>	H<E
S10F2	Terminal Request Acknowledge <ACKC10>	H>E
S10F3	Terminal Display, Single L, 2 1. <TID> 2. <TEXT>	H>E
S10F4	Terminal Display, Single Acknowledge <ACKC10>	H<E

CCode (S7F23 & S7F26 Format Example)

Name	Type	Value	Direction
L,4			
1.<PPID>	A	"UVVWXX"	Recipe Name
2.<GEM_MDLN>	A	"NT300"	Name
3.<GEM_SOFTREV>	A	"1.0.0.1"	GEM Revision
4.L,80			
1.L,2			
1.<CCODE>	U2	101	Film Thickness, 膜厚
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Film Thickness"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"0.543"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"9.999"	MaxiMum Value
2.L,2			
1.<CCODE>	A	102	Panel X, 基板 X
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Panel X"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"404"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9"	MaxiMum Value
3.L,2			
1.<CCODE>	A	103	Panel Y, 基板 Y
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Panel Y"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"523"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9"	MaxiMum Value
4.L,2			
1.<CCODE>	A	104	Clamp, 夾取量

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Clamp"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"6"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value
5.L,2			
1.<CCODE>	A	105	Thacking Point F, 預貼位置前
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Thacking Point F"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value
6.L,2			
1.<CCODE>	A	106	Thacking Point R, 預貼位置後
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Thacking Point R"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value
7.L,2			
1.<CCODE>	A	107	Tacking Time, 預貼時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Tacking Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value
8.L,2			
1.<CCODE>	A	108	UP Temperature 5, 溫度上 5

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Temperature 5"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
9.L,2			
1.<CCODE>	A	109	UP Temperature 4, 溫度上 4
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Temperature 4"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
10.L,2			
1.<CCODE>	A	110	UP Temperature 3, 溫度上 3
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Temperature 3"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
11.L,2			
1.<CCODE>	A	111	UP Temperature 2, 溫度上 2
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
12.L,2			
1.<CCODE>	A	112	UP Temperature 1, 溫度上 1

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Temperature 1"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
13.L,2			
1.<CCODE>	A	113	UP Keeper, UP Keeper
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Keeper"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"40"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"80.0"	MaxiMum Value
14.L,2			
1.<CCODE>	A	114	LO Temperature 5, 溫度下 5
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Temperature 5"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
15.L,2			
1.<CCODE>	A	115	LO Temperature 4, 溫度下 4
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Temperature 4"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
16.L,2			
1.<CCODE>	A	116	LO Temperature 3, 溫度下 3

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Temperature 3"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
17.L,2			
1.<CCODE>	A	117	LO Temperature 2, 溫度下 2
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
18.L,2			
1.<CCODE>	A	118	LO Temperature 1, 溫度下 1
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Temperature 1"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"50"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
19.L,2			
1.<CCODE>	A	119	LO Keeper, LO Keeper
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Keeper"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"40"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"140.0"	MaxiMum Value
20.L,2			
1.<CCODE>	A	120	UP Niproll Delay, 上送出滾輪啟動延遲

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP 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
21.L,2			
1.<CCODE>	A	121	UP Quick Stop Distance, 上到達位置停止距離
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Quick Stop Distance"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	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			
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			
1.<CCODE>	A	124	LO Quick Stop Distance, 下到達位置停止距離

2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Quick Stop Distance"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"1.75"	MaxiMum Value
25.L,2			
1.<CCODE>	A	125	LO Speed, 下速度
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Speed"	ProcessParameter
3.<PPARM2-3>	A	"m/min"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1.99"	SetValue
6.<PPARM2-6>	A	"0.999"	Minimum Value
7.<PPARM2-7>	A	"99.999"	MaxiMum Value
26.L,2			
1.<CCODE>	A	126	UP ClampTorq, 上夾板張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP ClampTorq"	ProcessParameter
3.<PPARM2-3>	A	"V"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1.2"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"1.50"	MaxiMum Value
27.L,2			
1.<CCODE>	A	127	UP Plate Close Torque, 上吸板卷出張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Plate Close Torque"	ProcessParameter
3.<PPARM2-3>	A	"V"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"3.2"	SetValue
6.<PPARM2-6>	A	"3.00"	Minimum Value
7.<PPARM2-7>	A	"5.00"	MaxiMum Value
28.L,2			

1.<CCODE>	A	128	LO ClampTorq, 下夾板張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO ClampTorq"	ProcessParameter
3.<PPARM2-3>	A	"V"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1.2"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"1.50"	MaxiMum Value
29.L,2			
1.<CCODE>	A	129	LO Plate Close Torque, 下吸板卷出張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO Plate Close Torque"	ProcessParameter
3.<PPARM2-3>	A	"V"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"3.2"	SetValue
6.<PPARM2-6>	A	"3.00"	Minimum Value
7.<PPARM2-7>	A	"5.00"	MaxiMum Value
30.L,2			
1.<CCODE>	A	130	Tacking Offset Rear, 預貼後位置補正
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Tacking Offset Rear"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"4.5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value
31.L,2			
1.<CCODE>	A	131	Speed, 上下切刀驅動速度
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Speed"	ProcessParameter
3.<PPARM2-3>	A	"m/min"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"18.84"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.999"	MaxiMum Value
32.L,2			

1.<CCODE>	A	132	Revolution, 切刀轉速
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Revolution"	ProcessParameter
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.L,2			
1.<CCODE>	A	133	Upper Tack ON, 上預貼啟動
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Upper 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
34.L,2			
1.<CCODE>	A	134	Up Pet Mode ON, 上 PET 模式啟動
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
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"	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
36.L,2			

1.<CCODE>	A	136	Lo Pet Mode ON, 下 PET 模式啟動
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Lo 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
37.L,2			
1.<CCODE>	A	137	UP 1, 真空吸板上 1
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP 1"	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
38.L,2			
1.<CCODE>	A	138	UP 2, 真空吸板上 2
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP 2"	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
39.L,2			
1.<CCODE>	A	139	UP 3, 真空吸板上 3
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP 3"	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
40.L,2			

1.<CCODE>	A	140	LO 1, 真空吸板下 1
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"LO 1"	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
41.L,2			
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	"LO 2"	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
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.<PPARM2-5>	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	""	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
44.L,2			

1.<CCODE>	A	144	GC-Fime Vacuum, 真空吸板啟動
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"GC-Fime Vacuum"	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
45.L,2			
1.<CCODE>	A	145	Film Check Front ON, 基板進板檢知
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Film Check Front 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
46.L,2			
1.<CCODE>	A	146	Film Check Rear ON, 排出基板檢知
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Film Check Rear 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
47.L,2			
1.<CCODE>	A	147	File Check OFF, 檔案檢察關閉
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"File Check OFF"	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
48.L,2			

1.<CCODE>	A	148	Timmer, 計時器
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Timmer"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"30"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	""	MaxiMum Value
49.L,2			
1.<CCODE>	A	201	Size X, 基板寬
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Size X"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"410"	SetValue
6.<PPARM2-6>	A	"200.0"	Minimum Value
7.<PPARM2-7>	A	"700.0"	MaxiMum Value
50.L,2			
1.<CCODE>	A	202	Size Y, 基板長
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Size Y"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"510"	SetValue
6.<PPARM2-6>	A	"200.0"	Minimum Value
7.<PPARM2-7>	A	"700.0"	MaxiMum Value
51.L,2			
1.<CCODE>	A	203	Film Thickness, 基板厚
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Film Thickness"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"0.026"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"9.999"	MaxiMum Value
52.L,2			

1.<CCODE>	A	204	1st Vacuum, 一段真空值
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st Vacuum"	ProcessParameter
3.<PPARM2-3>	A	"hPa"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.99"	Maximum Value
53.L,2			
1.<CCODE>	A	205	1st Vacuum Time, 一段抽真空時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st Vacuum Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"30"	SetValue
6.<PPARM2-6>	A	"1"	Minimum Value
7.<PPARM2-7>	A	"999"	Maximum Value
54.L,2			
1.<CCODE>	A	206	1st 1step Press, 一段 1Step 壓合壓力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st 1step Press"	ProcessParameter
3.<PPARM2-3>	A	"kgf/cm2"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"6.5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9"	Maximum Value
55.L,2			
1.<CCODE>	A	207	1st 1step Press Time, 一段 1Step 壓合時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st 1step Press Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"30"	SetValue
6.<PPARM2-6>	A	"1"	Minimum Value
7.<PPARM2-7>	A	"999"	Maximum Value
56.L,2			

1.<CCODE>	A	208	1st 2step Press, 一段 2Step 壓合壓力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st 2step Press"	ProcessParameter
3.<PPARM2-3>	A	"kgf/cm2"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"8"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9"	MaxiMum Value
57.L,2			
1.<CCODE>	A	209	1st 2step Press Time, 一段 2Step 壓合時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st 2step Press Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"40"	SetValue
6.<PPARM2-6>	A	"1"	Minimum Value
7.<PPARM2-7>	A	"999"	MaxiMum Value
58.L,2			
1.<CCODE>	A	210	1st Upper Temp, 一段上溫度
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st Upper Temp"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"90"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
59.L,2			
1.<CCODE>	A	211	1st Lower Temp, 一段下溫度
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1st Lower Temp"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"90"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
60.L,2			

1.<CCODE>	A	212	2nd Press, 二段壓力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2nd Press"	ProcessParameter
3.<PPARM2-3>	A	"kgf/cm2"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"8"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9"	MaxiMum Value
61.L,2			
1.<CCODE>	A	213	2nd Press Time, 二段壓合時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2nd Press Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"60"	SetValue
6.<PPARM2-6>	A	"1"	Minimum Value
7.<PPARM2-7>	A	"999"	MaxiMum Value
62.L,2			
1.<CCODE>	A	214	2ndStage Up Temperature 3, 二段上溫度 3
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Up Temperature 3"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
63.L,2			
1.<CCODE>	A	215	2ndStage Up Temperature 2, 二段上溫度 2
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Up Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value

64.L,2			
1.<CCODE>	A	216	2ndStage Up Temperature 1, 二段上溫度 1
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Up Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
65.L,2			
1.<CCODE>	A	217	2ndStage Lo Temperature 3, 二段下溫度 3
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Lo Temperature 3"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
66.L,2			
1.<CCODE>	A	218	2ndStage Lo Temperature 2, 二段下溫度 2
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Lo Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	MaxiMum Value
67.L,2			
1.<CCODE>	A	219	2ndStage Lo Temperature 1, 二段下溫度 1
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2ndStage Lo Temperature 2"	ProcessParameter
3.<PPARM2-3>	A	"Celsius"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"85"	SetValue

6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"185.0"	Maximum Value
68.L,2			
1.<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>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Input Conveyor Pre-Process Waiting Time"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"U4"	Type
5.<PPARM2-5>	A	"10"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999"	Maximum Value
69.L,2			
1.<CCODE>	A	221	Conveyor Stop Timing Timer, 傳送帶停止時間計時器
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Conveyor Stop Timing Timer"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"2.5"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.99"	Maximum Value
70.L,2			
1.<CCODE>	A	222	Waiting Time Limit, 等待時間限制
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Waiting Time Limit"	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	"999.0"	Maximum Value
71.L,2			
1.<CCODE>	A	223	Input Timing Timer, 投入時間計時器
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Input Timing Timer"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit

4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1.25"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"99.99"	MaxiMum Value
72.L,2			
1.<CCODE>	A	224	Input Start Timing Fime Feed Amount, 投入時傳送帶傳送量
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Input Start Timing Fime Feed Amount"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"115"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"999.9999"	MaxiMum Value
73.L,2			
1.<CCODE>	A	225	1Step Crimp First Position Film Feed Amount, 1Step 初次咬合位置距離
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1Step Crimp First Position Film Feed Amount"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"30"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"150.0000"	MaxiMum Value
74.L,2			
1.<CCODE>	A	226	2Step Second Crimp Increment Position, 1Step 咬合增量距離
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"2Step Second Crimp Increment Position"	ProcessParameter
3.<PPARM2-3>	A	"mm"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"1.9264"	SetValue
6.<PPARM2-6>	A	"0"	Minimum Value
7.<PPARM2-7>	A	"150.0000"	MaxiMum Value
75.L,2			
1.<CCODE>	A	227	Film Feed Speed, 傳送膜速度
2.L,7			

1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Film Feed Speed"	ProcessParameter
3.<PPARM2-3>	A	"m/min"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"6"	SetValue
6.<PPARM2-6>	A	"1"	Minimum Value
7.<PPARM2-7>	A	"18.0"	MaxiMum Value
76.L,2			
1.<CCODE>	A	228	UP Tension, 上張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"UP Tension"	ProcessParameter
3.<PPARM2-3>	A	"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"40"	SetValue
6.<PPARM2-6>	A	"0.1"	Minimum Value
7.<PPARM2-7>	A	"100.0"	MaxiMum Value
77.L,2			
1.<CCODE>	A	229	Lo Tension, 下張力
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Lo Tension"	ProcessParameter
3.<PPARM2-3>	A	"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"40"	SetValue
6.<PPARM2-6>	A	"0.1"	Minimum Value
7.<PPARM2-7>	A	"100.0"	MaxiMum Value
78.L,2			
1.<CCODE>	A	230	1 st Vacuum slow On, 1st 真空低速閥有效
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"1 st Vacuum slow 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
79.L,2			
1.<CCODE>	A	231	Vaccum postition Lower postition, 真空位置下限
2.L,7			

1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"Vaccum postition Lower postition"	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
80.L,2			
1.<CCODE>	A	232	OutPut Cooling Timmer, 排出段冷卻時間
2.L,7			
1.<PPARM1-1>	A	"True"	ProcessParameterEnableFlag
2.<PPARM2-2>	A	"OutPut Coooling Timmer"	ProcessParameter
3.<PPARM2-3>	A	"sec"	Unit
4.<PPARM2-4>	A	"F4"	Type
5.<PPARM2-5>	A	"4"	SetValue
6.<PPARM2-6>	A	"0.1"	Minimum Value
7.<PPARM2-7>	A	"99.9"	MaxiMum Value

Normal Flow Chart

