






Data Items Available Listed by Functionality Group












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Machine Make: OKUMA OSP-P Control
 Machine Model: P300S, P300L, P200L/ Multus/Macturn, P100II-L
 MTConnect Version: 1.3
 Adapter Version: 2.1

Functional Group: Motion



Data Item	Description	Included
Axis Feed Rate	The feed rate of a linear axis.	
Feed Rate Override	Feed Rate Override expressed as a percentage of the calculated feed rate.	
Path Feed Rate (Actual)	The feed rate of the tool path.	
Rotary Velocity (Actual)	The rotational speed of a rotary axis. Spindle Speed of the C Axis.	
Rotary Velocity Override	Rotary Velocity Override expressed as a percentage of the rotary velocity. Spindle Speed Override of the C Axis.	

Functional Group: State



Data Item	Description	Included
Execution Ready	An Execution State of the Controller identifying the machine is ready to run	
Execution Active	An Execution State of the Controller identifying the machine is actively running	
Execution Interrupted	An Execution State of the Controller identifying the machine has been interrupted	
Execution Feed Hold	An Execution State of the Controller identifying motion has been stopped due to Feed Hold	
Execution Stopped	An Execution State of the Controller identifying the controller has been stopped	
Execution Optional Stop	An Execution State of the Controller identifying motion has been stopped due to an Optional Stop	
Execution Program Stopped	An Execution State of the Controller identifying motion has been stopped due to a Program Stop	
Execution Program Completed	An Execution State of the Controller identifying motion has been stopped due to the program completing execution	
Controller Mode Automatic	The current mode of the Controller.	
Controller Mode Manual	The current mode of the Controller.	
Controller Mode Manual Data Input	The current mode of the Controller.	

Controller Mode Semi-Automatic	The current mode of the Controller.	
Controller Mode Edit	The current mode of the Controller.	
Emergency Stop Armed	The current state of the emergency stop signal indicating that emergency stop is not currently active	
Emergency Stop Triggered	The current state of the emergency stop signal indicating that emergency stop is currently active	
Chuck State Open	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is open.	
Chuck State Closed	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is closed.	
Chuck State Unlatched	An indication that the operating state of a mechanism that holds a part or stock material during a manufacturing process is unlatched.	
Door State Open	The state of the door is currently open.	
Door State Closed	The state of the door is currently closed.	
Door State Unlatched	The state of the door is currently unlatched.	
Functional Mode Production	The current intended production status of the device or component is production.	
Functional Mode Teardown	The current intended production status of the device or component is teardown.	
Functional Mode Maintenance	The current intended production status of the device or component is maintenance.	
Functional Mode Process Development	The current intended production status of the device or component is process development.	

Functional Group: Error

Data Item	Description	Included
Logic Program	An error occurred in the logic program or PLC (programmable logic controller).	
System	A CONDITION representing something that is not the operator, program, or hardware.	

Functional Group: Program / Parts

Data Item	Description	Included
Part Count	The current count of parts produced as represented by the Controller.	
Program	The name of the program being executed by the Controller component.	

Functional Group: Tooling

Data Item	Description	Included
Tool Number	The identifier of a tool provided by the device controller.	

Functional Group: Other

Data Item	Description	Included
<pre> <Assets> <CuttingTool> <CuttingToolLifeCycle> <CutterStatus/> <ToolLife/> <ProgramToolGroup/> <ProgramToolNumber/> <Location/> <CuttingItems> <CuttingItem> <ItemLife/> <x:ItemCutterStatus/> <x:ItemProgramToolGroup/> </CuttingItem> </CuttingItems> </CuttingToolLifeCycle> </CuttingTool> </Assets> </pre>	<p>Assets:</p> <p>CuttingTool: A Cutting Tool can be a single item or an assembly of one or more Adaptive Items, a Tool Item and several Cutting Items on a Tool Item</p> <p>CuttingToolLifeCycle: The tool life cycle</p> <p>CutterStatus: The state of the tool assembly - only for Instance (not archetype)</p> <p>ToolLife: The life of the cutting tool assembly</p> <p>ProgramToolGroup: The tool group this tool is assigned in the part program</p> <p>ProgramToolNumber: The number used to identify this tool in the program.</p> <p>Location: The pocket location</p> <p>CuttingItems: An optional list of edges for this assembly</p> <p>CuttingItem: A cutting item is the portion of the tool that physically removes the material from the workpiece by shear deformation.</p> <p>ItemLife: The life of an edge</p> <p>x:ItemCutterStatus: The state of an edge</p> <p>x:ItemProgramToolGroup: The tool group this tool edge is assigned in the part program</p> <p>x:ItemProgramToolNumber: The number used to identify this tool edge in the program</p>	

Path Feed Rate (Programmed)	The feed rate of the tool path.	
Path Feed Rate Override	Path feed rate override (programmed)	
Rotary Velocity (Programmed)	The rotational speed of a rotary axis. Spindle Speed of the C Axis.	
Load	The measurement of the actual versus the standard rating of a device. Spindle load of the C Axis.	
Functional Mode Setup	The current intended production status of the device or component is setup.	
Line	The current line of code being executed.	
Block	The block of code being executed. Block contains the entire expression for a line of program code	