

PLC

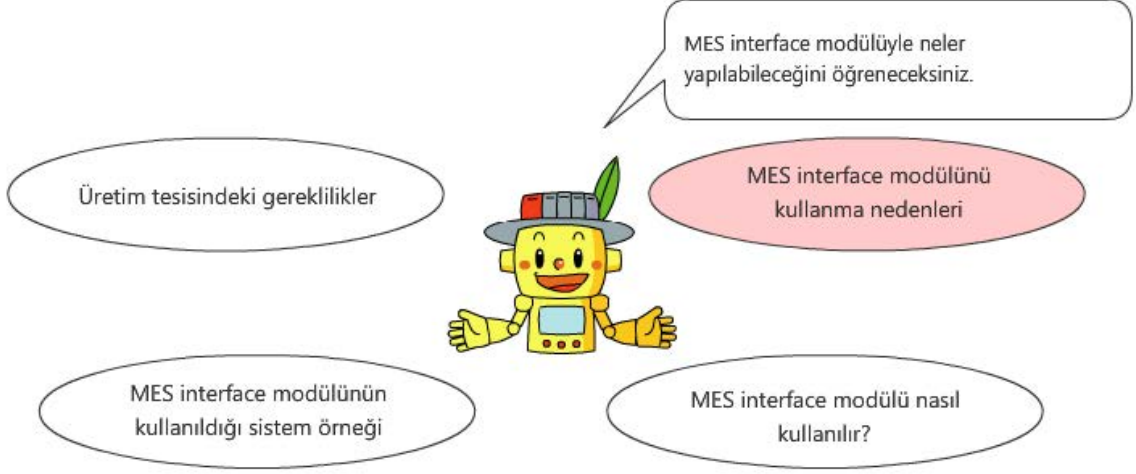
Üretim Görselleştirme Temelleri (MELSEC iQ-R serisi MES interface modülü)

Bu kurs, MES interface modülü (RD81MES96) kullanarak, bir sistem veya yapılandırılacak bir veritabanını uygulayacak ya da bunu teklif edecek katılımcılar için hazırlanmıştır.

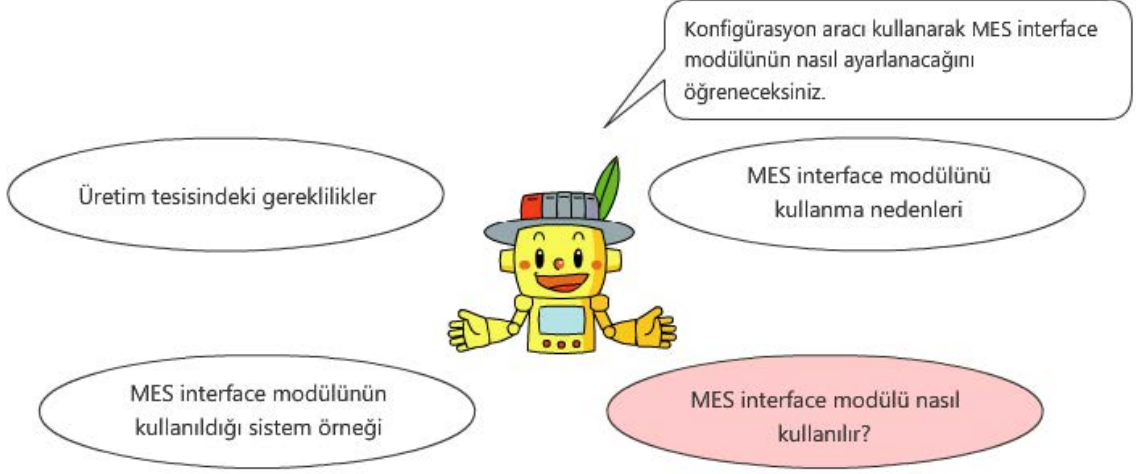
Bu kurs, size üretim tesisindeki mevcut sorunlar ve zorlukları ve MES interface modülünün bunları çözmek için nasıl kullanılabileceğini anlamanız için düzenlenmektedir. Ayrıca, MES interface modülünü kullanmayı, özelliklerini ve kullanımına ilişkin sistem örneklerini de öğrenebilirsiniz.



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Bu kursun içeriği aşağıdaki gibidir.
Bölüm 1'den başlamanızı tavsiye ederiz.

Bölüm 1 Üretim Endüstrisindeki Gereklilikler

Mevcut üretim endüstrisindeki üretim tesisinde toplam maliyeti düşürmek için nelerin gerekli olduğunu ve bunu nasıl bir sistemin gerçekleştirebileceğini öğrenin.

Bölüm 2 MES Interface Modülünü Seçme Gereççeleri





Veri tabanı ve MES interface modülü kullanmanın avantajlarını öğrenin.

Bölüm 3 MES Interface Modülü Nasıl Kullanılır

Aşağıdaki noktaları takip ederken MES interface function configuration tool kullanarak ayarları nasıl yapılandıracağınızı öğrenin.

Son Test

Toplam 5 kısım (5 soru), Geçer not: %60 veya üzeri

Sonraki sayfaya git		Sonraki sayfaya git
Önceki sayfaya dön		Önceki sayfaya dön
İstene sayfaya ulaş		"İçindekiler Tablosu" görüntülenerek istediğiniz sayfaya ulaşabilmenizi sağlar.
Eğitimden çık		Eğitimden çıkın. "İçindekiler" ekranı gibi pencereler ve eğitim kapatılacaktır.

Güvenlik Önlemleri

Kursu tamamlarken mevcut ürünler kullanacaksanız, lütfen ürünlerin ilgili kılavuzlarındaki güvenlik önlemlerini tam olarak okuyun.

Bu Kurstaki Önlemler

- Kullandığınız yazılım sürümünde görüntülenen ekranlar bu kurstakilerden farklı olabilir. Aşağıda, bu kursta kullanılan yazılım ve her bir yazılım sürümü gösterilmektedir.
 - MELSOFT MX MESInterface-R Version1 Ver.1.07H
(MES interface function configuration tool)

Referans

Aşağıda bu kurstaki konu başlıklarıyla ilgili bir referans yer almaktadır. (Bu referans materyalini kullanmadan da bu kursu tamamlayabileceğiniz için, bu materyalin kesinlikle gerekli olmadığını lütfen unutmayın.) İndirmek için referans dosyasının adını tıklayın.

Referansın adı	Dosya biçimi	Dosya boyutu
Kayıt kağıdı	Sıkıştırılmış dosya	5.80 kB

Bu bölümde, mevcut üretim endüstrisindeki üretim tesisinde toplam maliyeti düşürmek için gerekenleri ve bunun hangi sistemle gerçekleştirilebileceğini öğreneceksiniz.

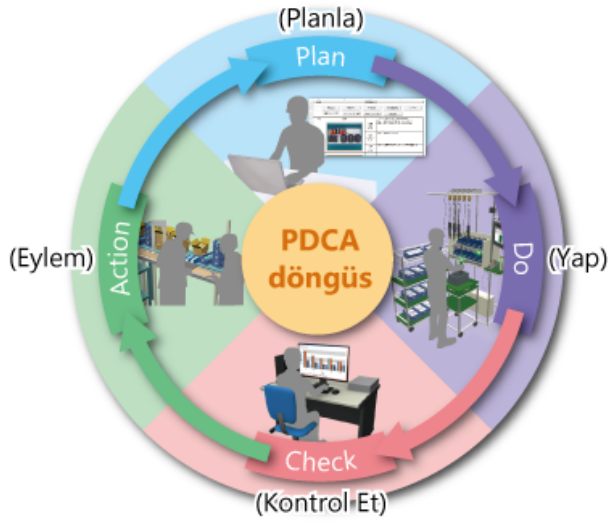
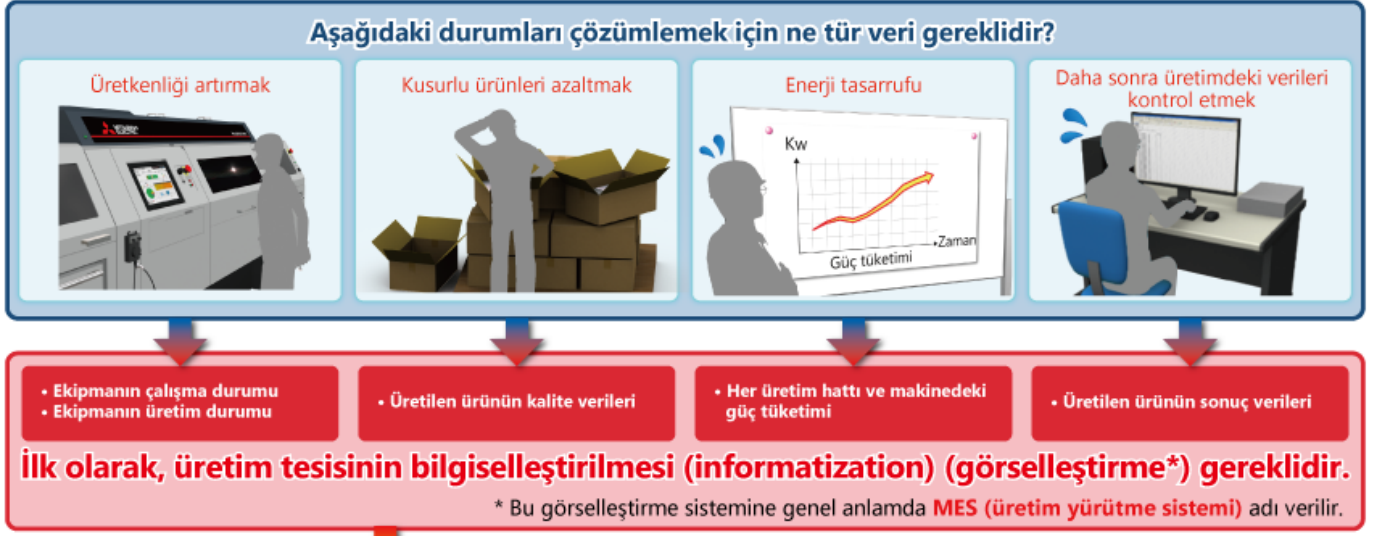
Bölüm 1'in İçindekiler

- 1.1 Üretim Tesisindeki Sorunlar
- 1.2 Üretim Tesisinde "Görselleştirme" ve Veri Toplama
- 1.3 Özet

Üretim Endüstrisi şu anda aşırı düzeyde fiyat rekabeti içindedir.

Bu tür durumlarda, üretim tesisi toplam maliyeti düşürmek için çeşitli gereksinimlerle karşı karşıya kalır.

O halde, üretim tesisleri bu talepleri nasıl karşılayabilir?

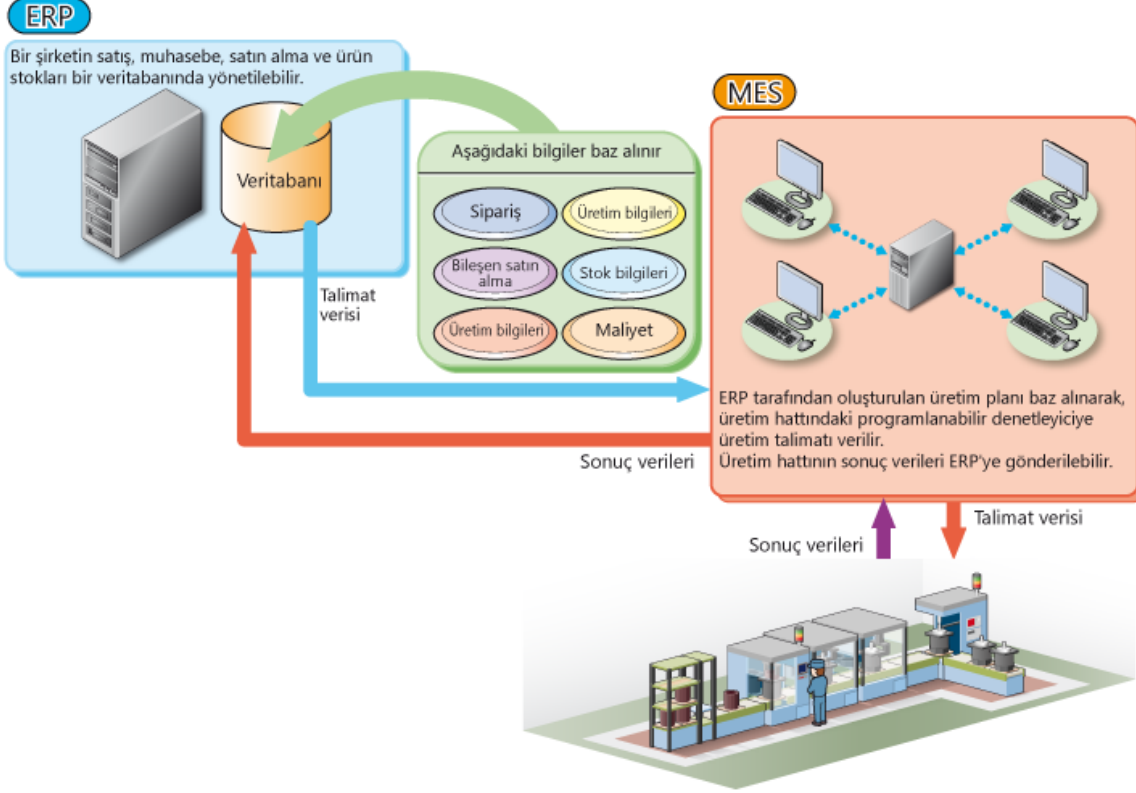


Toplanmış verileri çıkartmak, üretim kalitesini artırmak üzere PDCA döngüsünü yürütmek ve bu eylemleri sürdürmek önemlidir.

Genel olarak, üretim tesisinde toplanan bilgiler baz alınarak üretim tesisinin üretim planını verimli şekilde yürütmesini sağlayan sisteme **MES (Üretim Yürütme Sistemi)** adı verilir.

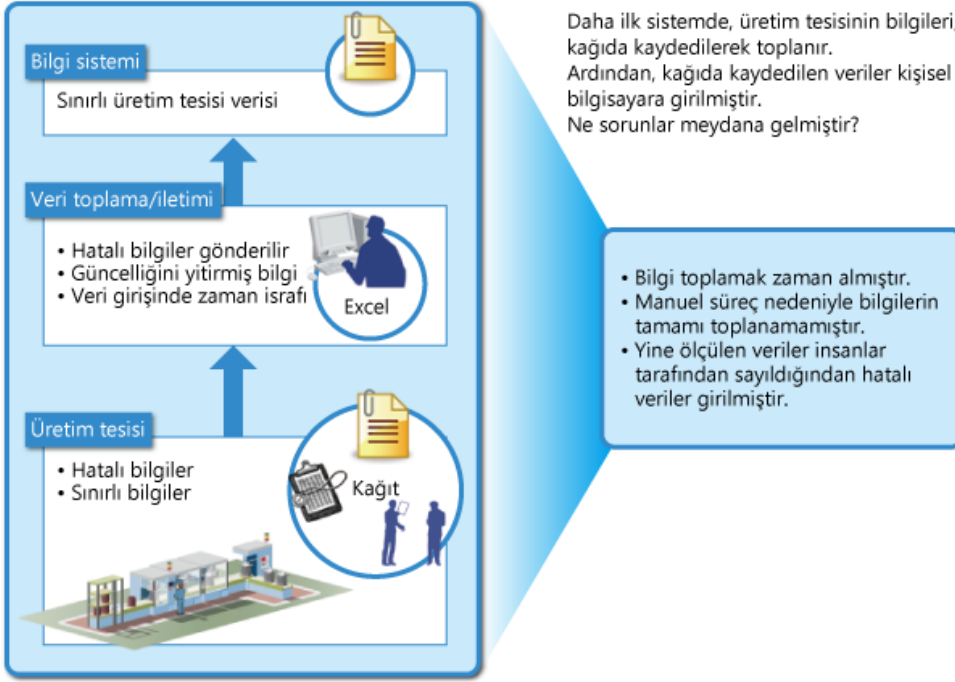
MES genelde siparişler, satışlar, stoklar, maliyetler ve üretim planını yöneten **ERP** ile birlikte kullanılır.

Bir üst sisteme bağlanılarak plan ve sonuç elde edilebilir ve bu da verimli işletme yönetimi için kullanılabilir.



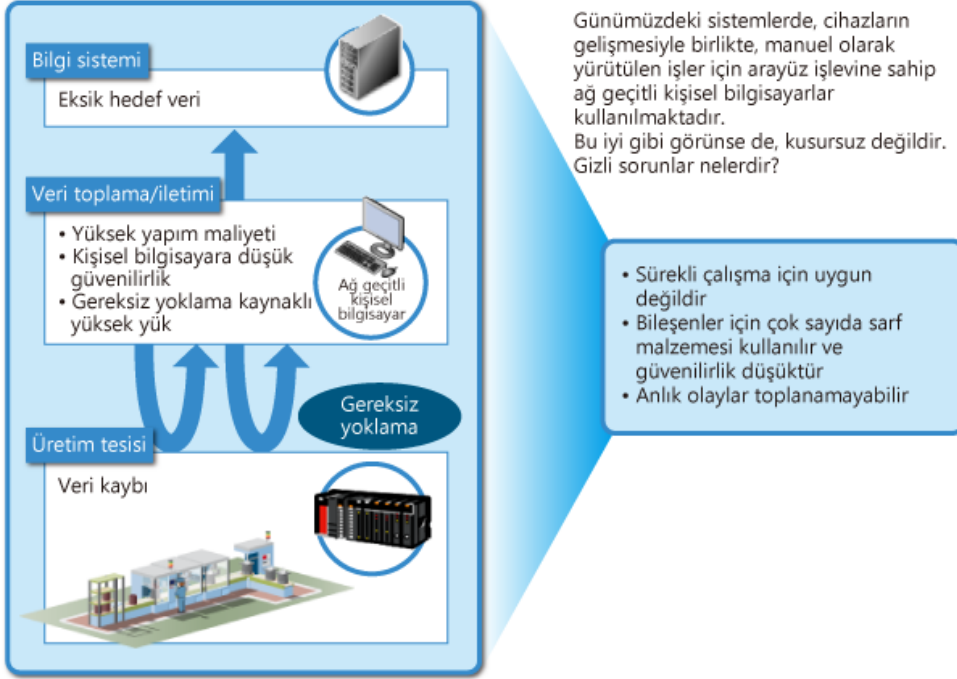
Üretim tesislerinde, üretimi iyileştirmek üzere üretim tesisi içindeki veriler toplanarak PDCA döngüsü uygulanmıştır. Şimdi, MES interface modülünü kullanmanın avantajları nelerdir?

Bu bölümde, ilerleyen IT (Bilişim Teknolojileri) ile birlikte bilgi sisteminin nasıl geliştirildiği açıklanmaktadır.



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MES interface modülü kullanılırsa ne olur?

Ekipman tarafında fonksiyonlar bir araya getirildiğinde, veriler ekipman tarafından otomatik olarak aktarılır. Bu sayede, verilerin tamamı toplanır ve ağ geçitli kişisel bilgisayar bulunmayan bir sistem hayata geçirilebilir.

MES interface modülü kullanılarak veriler gerçek zamanlı olarak toplanabilir ve güvenilirliği yüksek sistem hataya geçirilebilir.

Bölüm 2'de diğer özellikleri öğreneceksiniz.

Bu bölümde, şunları öğrendiniz:

- Üretim tesisindeki sorunlar
- Üretim tesisinde "Görselleştirme" ve veri toplama

Noktalar

Üretim tesisindeki sorunlar	<ul style="list-style-type: none">• Üretim endüstrisindeki çeşitli ihtiyaçların karşılanması için, üretim tesisinin bilgilendirilmesi (informatization) (görselleştirme) ile PDCA döngüsünün uygulanması gereklidir.• Üretim tesisinde toplanan bilgiler baz alınarak üretim tesisinin üretim planını verimli şekilde yürütmesini sağlayan sisteme MES (Üretim Yürütme Sistemi) adı verilir.• Bir üst sisteme (ERP) bağlanılarak plan ve sonuç elde edilebilir ve bu da verimli işletme yönetimi için kullanılabilir.
Üretim tesisinde "Görselleştirme" ve veri toplama	Ağ geçitli kişisel bilgisayarlar, MES lotlarını kullanır. Ancak, MES interface modülü kullanılarak tüm verileri gerçek zamanda toplayabilen bir sistem kolayca uygulanabilir.

[Kavrama testi]

1. Bölümdeki içerikleri tam olarak anladınız mı?

İçerikleri kontrol etmek ve gözden geçirmek için lütfen kavrama testini uygulayın.

(3 kısım, 3 soru)

Üretim tesisini yönetmek ve üretimi verimli şekilde yürütmek için doğru uygulamayı seçin. (Birini seçin.)

ERP

PDM

MES

Üretim tesisinde veri toplamak için MES interface modülünü kullanmanın avantajı olarak yanlış cevabı seçin. (Birini seçin.)

- MES interface modülü, ekipmanı kontrol eden programlanabilir denetleyiciye kurularak veriler veritabanına/veritabanından otomatik olarak alınır/gönderilir.
- Bir haberleşme programı oluşturularak ve MES interface modülüne kaydedilerek veritabanı ve CPU modülü bağlanabilir.
- MES interface modülünü kullanan sistemde veriler gerçek zamanda toplanabilir ve bu sistemin güvenilirliği yüksektir.

Üretim tesisinde üretimi iyileştirmek için uygulanan PDCA döngüsü için doğru açıklamayı seçin.(Birini seçin.)

- Üretimi iyileştirmek için PDCA döngüsünün bir kez yürütülmesi yeterlidir.
- Üretimi iyileştirmek için PDCA döngüsünün sürekli olarak yürütülmesi önemlidir.
- PDCA döngüsünün ilk adımı olan Planda, gerçek veriler kullanılmadan varsayıma dayalı kaba bir plan yapılır.

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Bölüm 1'in kavrama testini tamamladınız.
Test sonucunuz aşağıdadır.

Sonucunuz nasıl çıktı?
Yanlış cevapladığınız soruları Yeniden Denemeniz önerilir.

	1	2	3	4	5	6	7	8	9	10
Kavrama testi 1	✓									
Kavrama testi 2	✓									
Kavrama testi 3	✓									

Toplam soru: **3**

Doğru cevaplar: **3**

Yüzde: **100 %**

Temizle

Önceki bölümde, MES konsepti ve MES interface modülünü üretim tesisinde verileri toplamak ve "görselleştirmek" için kullanmanın avantajları açıklanmıştı.

Aslında, MES uygulamasında daha fazla avantaj vardır.

Veritabanı ve MES interface modülünü kullanmanın avantajları bu bölümde açıklanmaktadır.

Bölüm 2'nin İçindekiler

- 2.1 Veritabanı Neden Kullanılır?
- 2.2 MES Interface Modülünün Özellikleri
- 2.3 Özet

İlk olarak, veri toplama için neden veritabanlarının kullanıldığını düşünelim.

Toplanan veriler nasıl kullanılır?

Güncel durumu görüntülemek, önlemler alınmadan önceki ve alındıktan sonraki durumu karşılaştırmak, belirli bir koşulda veri çıkartmak vb. için kullanılırlar.

Dolayısıyla, verilerin biriktirilmesi gerekir.

Verilerin kolayca kullanılabilmesi de önemlidir.

Bu nedenlerle, veriler genellikle şu iki yoldan biriyle biriktirilir: Excel gibi dosyalarda saklama veya veritabanında saklama.

Aşağıda, iki yöntem arasındaki farklar gösterilmektedir.

	Veritabanı	Dosya (Excel vb.)	Açıklama
Veri miktarı	○	△	Bir dosyada büyük miktarda veri saklanamaz. 1048576 satır × 16384 sütun (1 sayfada) * Excel 2016 için
Verilerin aranabilirliği	○	△	Veriler bir dosya içinde kolayca aranamaz.
Özel işleme	○	X	Bir dosyada eşzamanlı düzenleme yapılamaz.

Yukarıda açıklandığı gibi, veritabanı kullanmanın çeşitli avantajları vardır. IT sistemi içinde işletilen uygulamalarla kolayca kullanılabilse de, verilerin kullanımı için programlama bilgisi gerektiğinden kullanımından kaçınılabilmektedir.

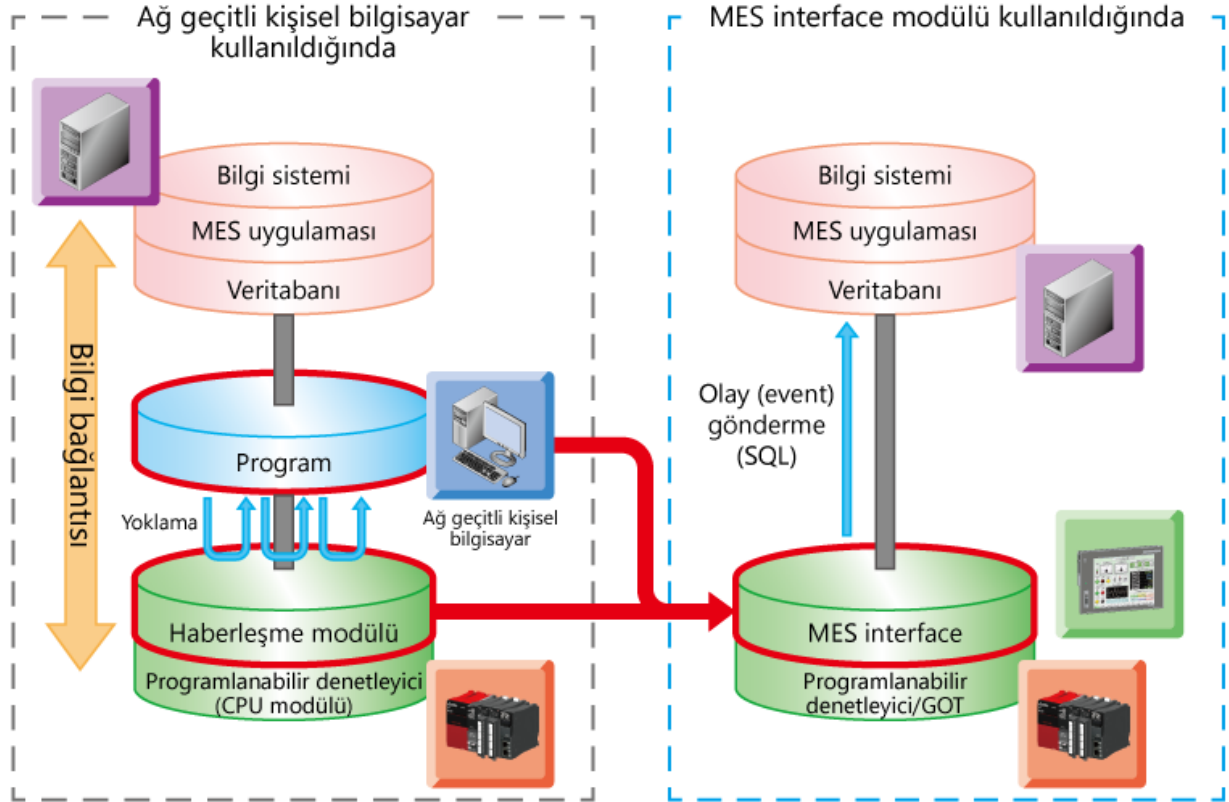
Buna karşın, MES interface modülü yardımıyla bu veriler kolayca kullanılabilir.

MES interface modülü, veritabanı ile bağlantıyı daha kolay hale getiren bir modüldür. Kısım 1.2'de öğrendiğiniz özelliklerden daha fazlası vardır. Bu kısımda, bu özellikler açıklanmaktadır.

<1. Kişisel bilgisayarsız/programsız>

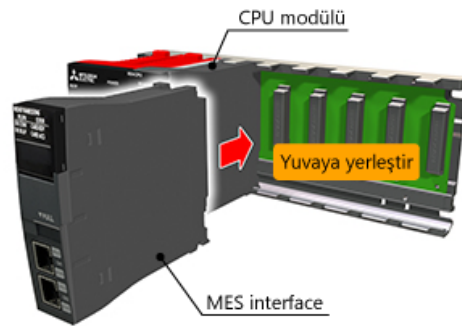
Ağ geçitli bir bilgisayar kullanarak veritabanına bağlanırken, ekipman verilerini toplamak için bir haberleşme programı ve veritabanına erişmek için bir program oluşturulması gerekir.

MES interface modülü kullanıldığında, ağ geçitli kişisel bilgisayar veya program kullanılmasına gerek kalmaz ve veritabanı bağlantısı düşük maliyetle kolayca yapılabilir.



<2. Basit uygulama>

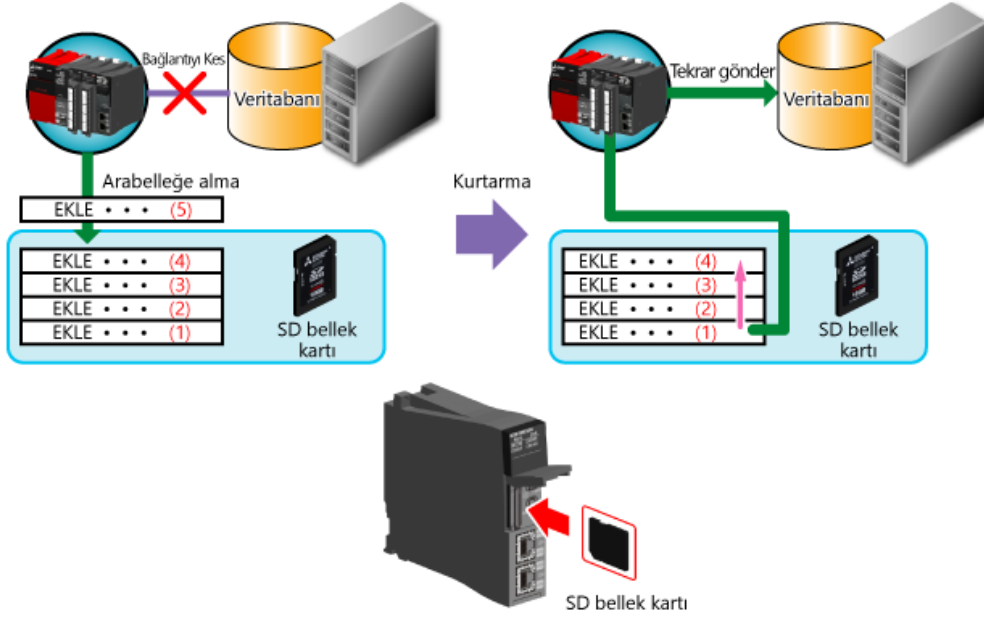
MES interface modülü yalnızca programlanabilir denetleyiciye kurularak uygulanabilir ve kontrol için ladder programının değiştirilmesi gerekmez.



<3. DB arabelleğe alma işleviyle veri toplamının atlanması önlenir>

Ağ geçitli bir kişisel bilgisayar kullanıldığında, ağ bağlantısı kesilirse veya veritabanı sunucusu arızalanırsa ne olur? Veriler gönderilemez ve veri toplamada atlamalar meydana gelir.

MES interface modülüyle, veriler takılan SD kartın arabelleğine alınır ve kurtarma sonrasında otomatik olarak yeniden gönderilir.

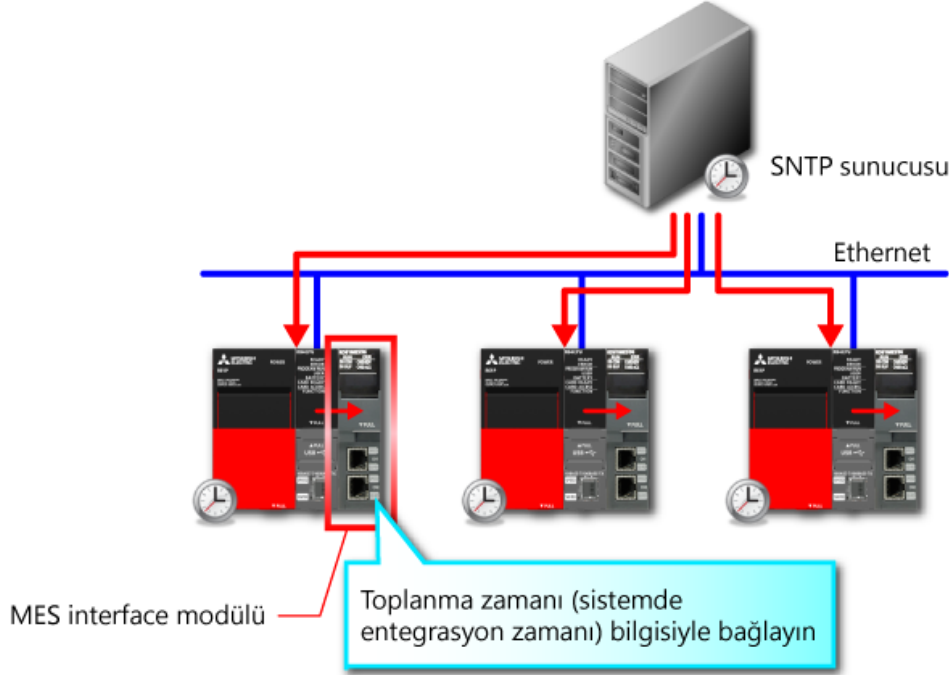


<4. Sistemler içinde zaman senkronizasyonu>

Sistem içindeki her ekipmanda zamanın eşleşmesi çok önemlidir.

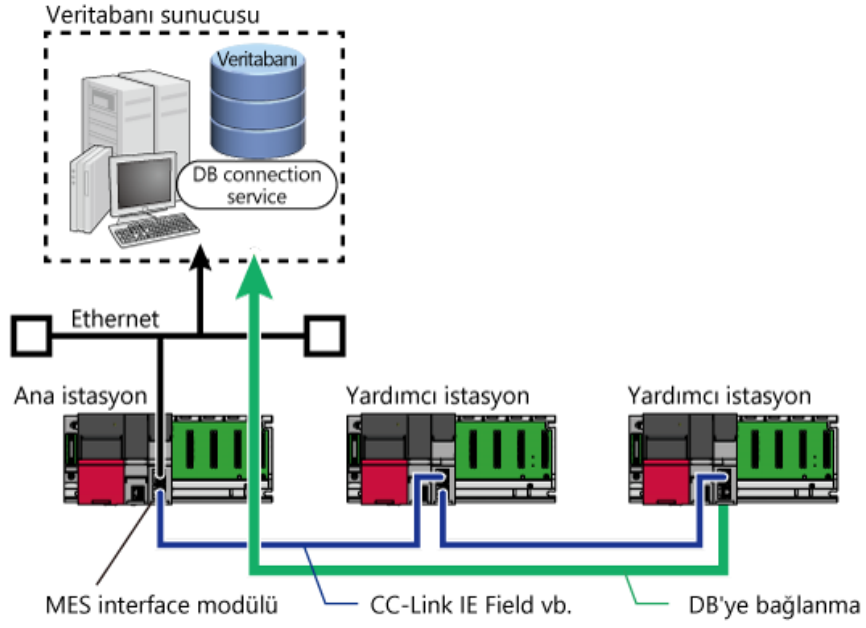
Örneğin, üretim hattında bir hata oluştuğunda, ekipmanlar arasında zaman farklılığı varsa, toplanan verilerle gerçek durum bilinemez.

MES interface modülü, CPU modülünün zamanıyla senkronize edilebilir. Bu nedenle, her ekipmandan alınan veriler üzerine doğru zaman damgasının uygulanması için CPU modülünün zamanının SNTP sunucusuyla senkronize edilmesi gerekir.



<5. Diğer PLC istasyonunun bilgileri bağlanabilir>

CC-Link IE Field gibi diğer ağları desteklediğinden, diğer PLC istasyonlarının bilgileri bir ağ yoluyla bağlanabilir.



Bu bölümde, şunları öğrendiniz:

- Veritabanı neden kullanılır?
- MES interface modülünün özellikleri

Noktalar

Veritabanı neden kullanılır?	<ul style="list-style-type: none">• Veritabanı kullanılarak, birden fazla insan tarafından eşzamanlı olarak toplanan bilgi kontrol edilebilir ve toplanan bilgi kolaylıkla sıralanabilir ve çıkartılabilir.• Üretim tesisindeki birden fazla cihazdan üretim durumu eşzamanlı olarak kontrol edildiğinden ve tüm fabrikanın ilerleme durumu ofisten kontrol edildiğinden, veritabanı kullanımı optimumdur.
MES interface modülünün özellikleri	<p>Aşağıdaki beş özellik, MES interface modülünün temel özellikleridir.</p> <ol style="list-style-type: none">1) Veritabanı, bir kişisel bilgisayar ve program olmadan bağlanabilir.2) Yalnızca MES interface modülünün PLC'ye kurulumu ile basit kurulum mümkündür.3) Haberleşme hatasında bile veri toplamada atlama meydana gelmez, çünkü kurtarma sonrasında veriler otomatik olarak tekrar gönderilir.4) CPU modülünün zaman senkronizasyon ayar işlevi kullanılarak sunucuyla zaman senkronizasyonu yapılabilir.5) Diğer PLC istasyonlarının bilgileri, bir ağ vasıtasıyla veritabanına bağlanabilir.

[Kavrama testi]

Bölüm 2'deki içerikleri tam olarak anladınız mı?

İçerikleri kontrol etmek ve gözden geçirmek için lütfen kavrama testini uygulayın.

(3 kısım, 3 soru)

Dosyaların kullanıldığı veri yönetimine kıyasla veritabanı kullanmanın avantajı olarak yanlış cevabı seçin.
(Birini seçin.)

- Çok miktarda veri yönetilebilir ve verilerin aranabilirliği yüksektir.
- Az miktarda veri yönetilebilir, ancak verilerin aranabilirliği yüksektir.
- Özel işlemede yüksek performansa sahip olduğundan birden fazla eşzamanlı erişim desteklenir.

MES interface modülünün özelliđi olan DB arabelleđine alma işlevi için dođru açıklamayı seçin. (Seçeneklerden birini seçin.)

- Ağ arızası olduđunda bir veri toplamada atlanma önlenir, çünkü veriler SD kart arabelleđine alınabilir ve kurtarma sonrasında otomatik olarak tekrar gönderilebilir.
- MES interface function configuration tool önceden ayarlanarak veritabanındaki veriler istendiđi zaman SD karta kaydedilebilir.
- DB arabelleđe alma işlevi, ağ arızası durumunda verileri MES interface modülündeki dahili ara belleđe alır.

MES interface modülünün zaman senkronizasyon işlevi için doğru açıklamayı seçin. (Seçeneklerden birini seçin.)

Yalnızca CPU modülünün zamanı senkronize edilebilir.

Yalnızca sunucunun zamanı senkronize edilebilir.

Zaman senkronize edilemez.

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- MES interface function configuration tool önceden ayarlanarak veritabanındaki veriler istendiđi zaman SD karta kaydedilebilir.
- DB arabelleđe alma işlevi, ağ arızası durumunda verileri MES interface modülündeki dahili ara belleđe alır.

MES interface modülünün zaman senkronizasyon işlevi için doğru açıklamayı seçin. (Seçeneklerden birini seçin.)

Yalnızca CPU modülünün zamanı senkronize edilebilir.

Yalnızca sunucunun zamanı senkronize edilebilir.

Zaman senkronize edilemez.

Bölüm 2'in kavrama testini tamamladınız.
Test sonucunuz aşağıdadır.

Sonucunuz nasıl çıktı?
Yanlış cevapladığınız soruları Yeniden Denemeniz önerilir.

	1	2	3	4	5	6	7	8	9	10
Kavrama testi 1	✓									
Kavrama testi 2	✓									
Kavrama testi 3	✓									

Toplam soru: **3**

Doğru cevaplar: **3**

Yüzde: **100 %**

Temizle

Önceki bölümde, veritabanının etkinliği ve MES interface modülünün çeşitli özellikleri açıklanmıştı.

Bu bölümde ise noktalar açıklanarak MES interface function configuration tool kullanılarak ayarların nasıl yapılandırıldığı açıklanmaktadır.

MES interface modülü kurulumu yapılırken aşağıdakiler gereklidir.

- MES interface modülü (RD81MES96)
- MES interface function configuration tool MX MESInterface-R (SW1DND-RMESIF-J/E)

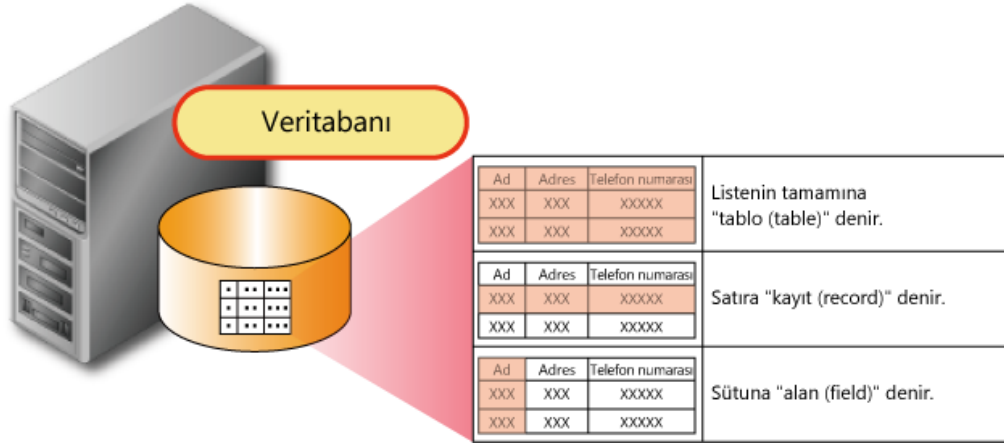
Aşağıdaki yazılımlar MX MESInterface-R'de saklanır.

- MES interface function configuration tool
 - DB bağlantı hizmeti ve ayarlama aracı
 - Proje dosyası dönüştürme aracı * Bu bölümde kullanılmaz.
- SD bellek kartı

Bölüm 3'ün İçindekiler

- 3.1 Veritabanının Yapısı
- 3.2 Sistem Konfigürasyonu
- 3.3 MES interface function configuration tool Başlatma
- 3.4 MES interface function configuration tool Ayarlama
- 3.5 MES Interface Modülünün Sistem Örneği
- 3.6 Özet

Ayarlama yöntemi açıklanmadan önce, veritabanında verilerin nasıl yönetildiği açıklanmaktadır.

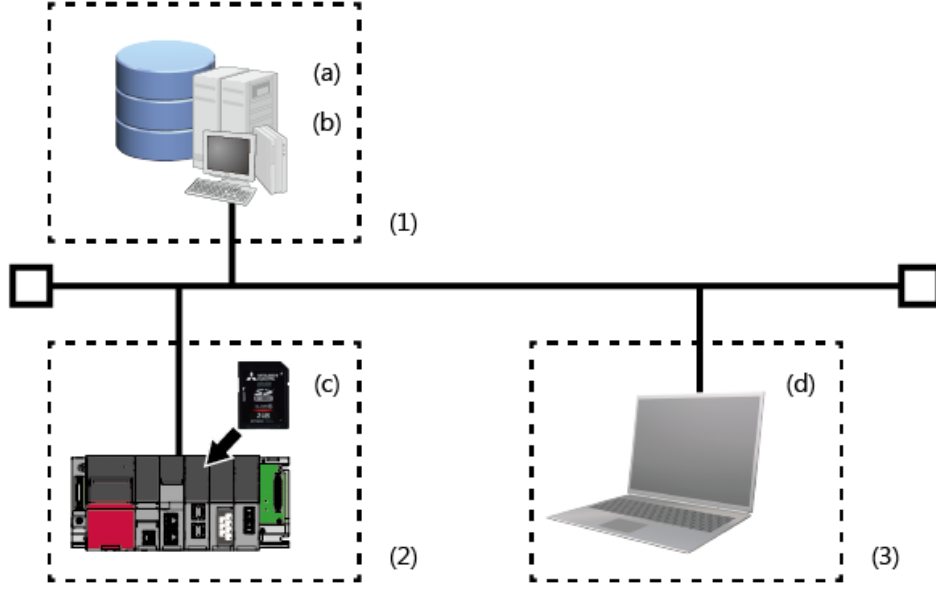


MES interface modülünün sistem konfigürasyonu aşağıda gösterilmektedir.

Sistem konfigürasyonunda, veritabanı sunucusu ve makinesini kontrol eden bir programlanabilir denetleyici vardır ve MES interface modülü programlanabilir denetleyiciye kurulur.

Veritabanı sunucusu ve MES interface modülü, Ethernet yoluyla bağlanır.

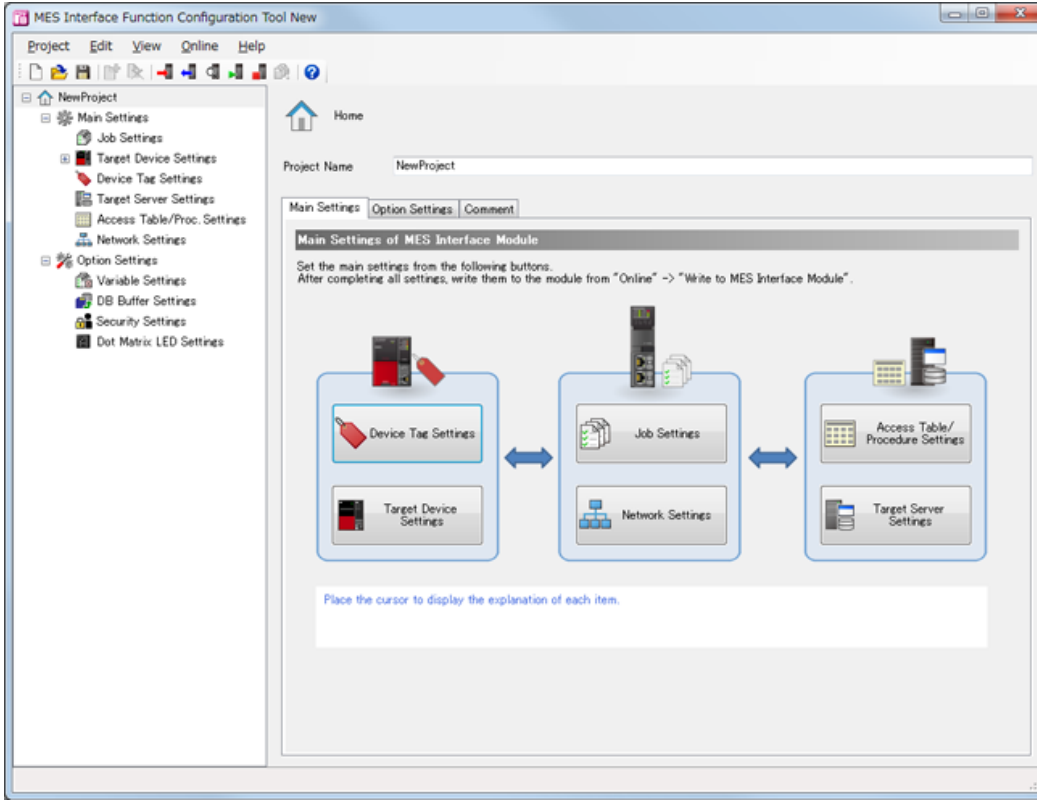
Bu bölümde, MES interface function configuration tool, DB bağlantı hizmeti ve ayarlama aracının kurulumunun tamamlandığı varsayılmaktadır.



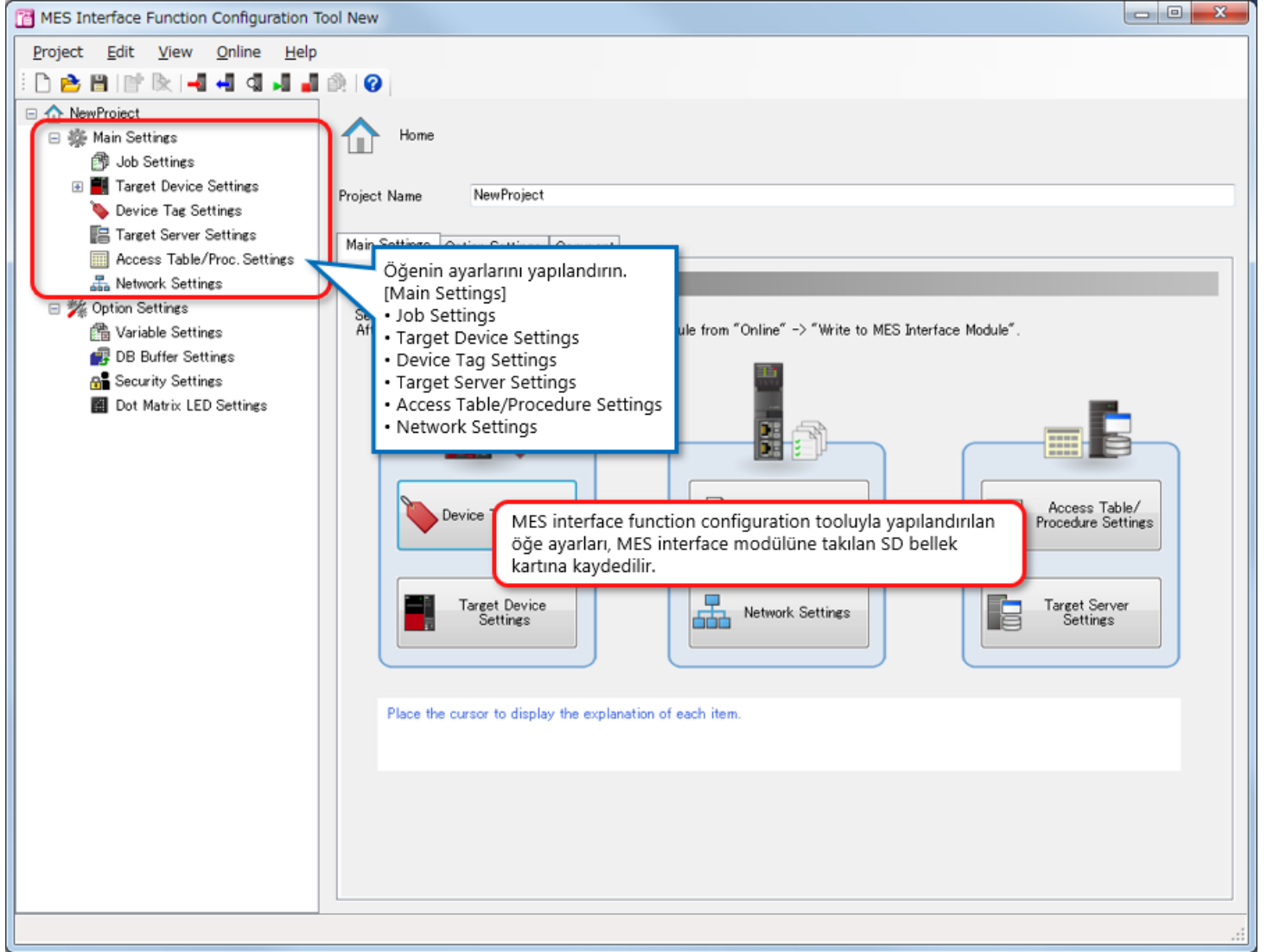
Sistem konfigürasyonu

(1)	Veritabanı sunucusu	(a)	<ul style="list-style-type: none"> • DB bağlantı hizmeti • DB bağlantı sunucusu ayarlama aracı
		(b)	<ul style="list-style-type: none"> • Microsoft Access
(2)	MES interface modülü	(c)	<ul style="list-style-type: none"> • SD bellek kartı (gerekli)
(3)	Konfigürasyon için kişisel bilgisayar	(d)	<ul style="list-style-type: none"> • MES interface function configuration tool

MES interface function configuration tool, MES interface modülünü çalıştırmada gerekli olan ayarları yapılandırmak için kullanılır.



MES interface function configuration tool başlatıldığında, aşağıdaki penceresi görüntülenir. Ekranın sol tarafında pencerede, yapılandırılacak öğeler "NewProject" altında ana öğeler olarak görüntülenir.



Gerçek ekranın kullanıldığı ayarlar Kısım 3.3'te açıklanmaktadır. Sonraki sayfadan itibaren her ayar öğesi açıklanmaktadır.

3.3 MES interface function configuration tool Öğeleri Ayarlama

Aşağıda, MES interface function configuration toolunda ayarlanan "Job Settings" ve "Network Settings" gösterilmektedir.

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help), a toolbar, and a left-hand navigation pane with a tree view containing categories like 'Main Settings', 'Job Settings', 'Target Device Settings', 'Device Tag Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The main workspace shows the 'Main Settings' tab selected, with a 'Project Name' field set to 'NewProject'. Below this, the 'Main Settings of MES Interface Module' section contains a diagram of interconnected settings boxes: 'Device Tag Settings' and 'Target Device Settings' on the left; 'Job Settings' and 'Network Settings' in the center; and 'Access Table/Procedure Settings' and 'Target Server Settings' on the right. Two callout boxes provide instructions: one for '<Job Settings>' stating to set trigger conditions and action timing, and another for '<Network Settings>' stating to set Ethernet ports and host names. A note at the bottom of the diagram reads 'Place the cursor to display the explanation of each item.'

<Job Settings>
Tetikleyici koşul ve eylem ile bilgi bağlantısının başlama zamanını ve işlemlerini (bağlanacak içerikler) ayarlayın.

<Network Settings>
İki Ethernet portunu ve ortak ana bilgisayar adını ayarlayın.

3.3 MES interface function configuration tool Öğeleri Ayarlama

Aşağıda, MES interface function configuration toolunda ayarlanan "Target Device Settings" ve "Device Tag Settings" gösterilmektedir.

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar lists various settings categories: Main Settings, Job Settings, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area displays a 'Home' button, a 'Project Name' field with 'NewProject', and tabs for 'Main Settings', 'Option Settings', and 'Comment'. A diagram in the center shows three interconnected boxes: 'Device Tag Settings' and 'Target Device Settings' on the left, 'Job Settings' and 'Network Settings' in the middle, and 'Access Table/Procedure Settings' and 'Target Server Settings' on the right. Two callout boxes provide additional information:

<Device Tag Settings>
Mantıksal adı, device tag bileşeni olarak target device belleğine ayarlayın.
Ayrıca, device tag bileşeni grubu, device tag olarak ayarlanır.
Mühendislik aracı projesinde ayarlanan global label ve common device comment device tag bileşenine aktarılabilir.

<Target Device Settings>
Ünite türü, çoklu CPU No. ve MES interface modülünden erişim için ağ haberleşme yolunu vb. ayarlayın.

3.3 MES interface function configuration tool Öğeleri Ayarlama

Aşağıda, MES interface function configuration toolunda ayarlanan "Target Server Settings" ve "Access Table/Procedure Settings" gösterilmektedir.

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings Job Settings Target Device Settings Device Tag Settings Target Server Settings Access Table/Proc. Settings Network Settings Option Settings Variable Settings DB Buffer Settings Security Settings Dot Matrix LED Settings

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

Set the main settings from the... After completing all settings.

<Access Table/Procedure Settings>
Mantıksal adı, access tablosu/işlemi ve access alanı/işlemi olarak veritabanının tablo/işlem ve alan/işlem argümanlarına ayarlayın.

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

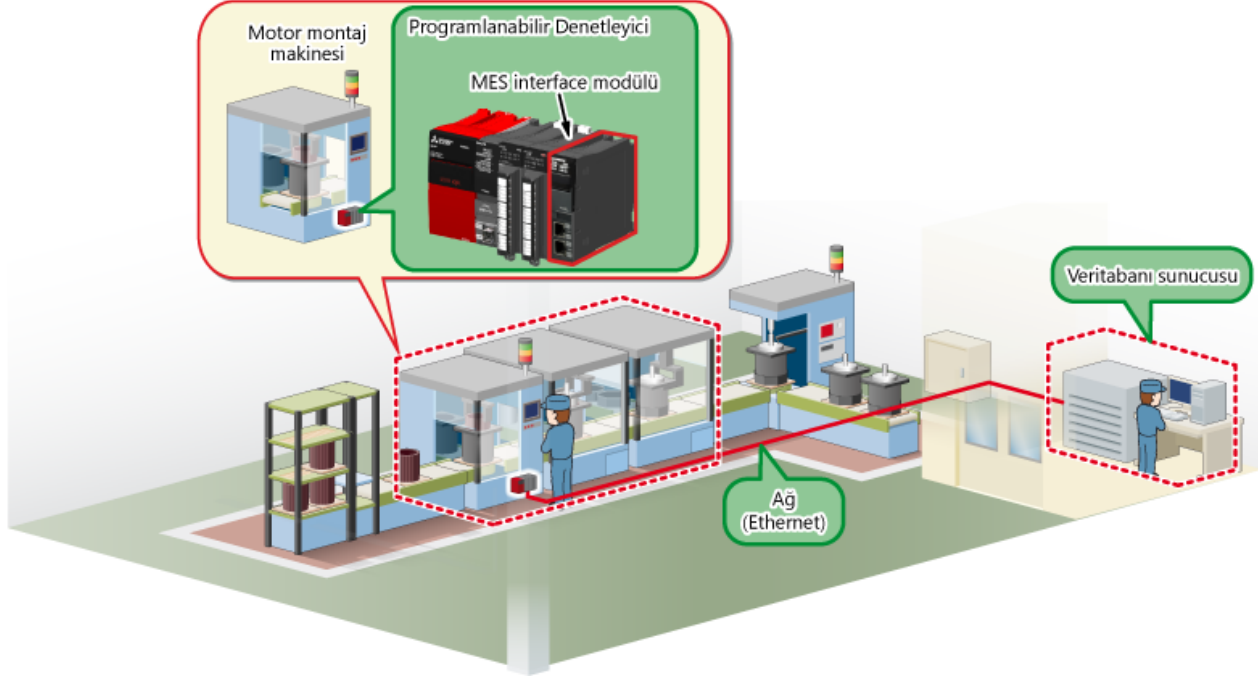
Target Server Settings

Place the cursor to display the explanation of each item.

<Target Server Settings>
Sunucu türü, ağ bilgileri ve kullanıcı kimlik doğrulama bilgisini ayarlayın.

Ana öğeleri anladığınıza göre, şimdi ayrıntıların konfigürasyonuna geçelim. Bu noktada ayarlanan üretim ekipmanının işletimi açıklanmaktadır.

Ayar konfigürasyonu için örnek olarak motor montaj makinesi kullanılmaktadır.



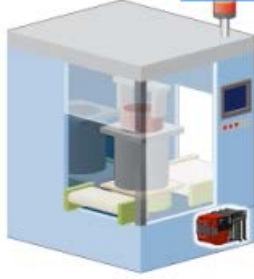
Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

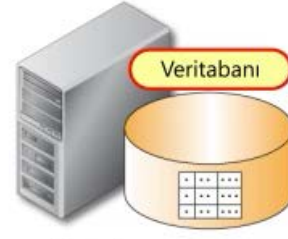
Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.

Oynat butonunu tıklayın.



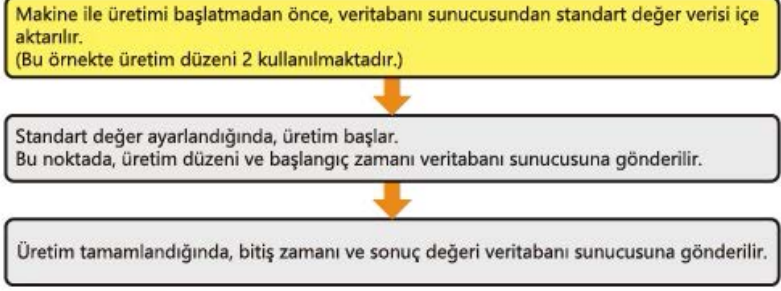
Üretim makinesi



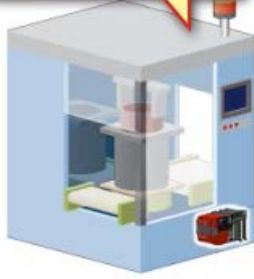
Veritabanı sunucusu

İleri

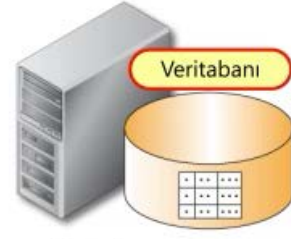
Üretim ekipmanı aşağıda gösterildiği gibi çalışır.



Düzen 2'nin standart değerine yönelik istek



Üretim makinesi



Veritabanı sunucusu

İleri

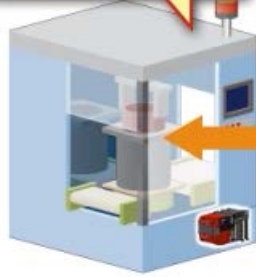
Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

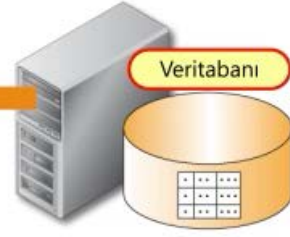
Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.

Düzen 2'nin standart değerine yönelik istek



Üretim makinesi

Düzen 2'nin standart değeri



Veritabanı sunucusu

İleri

Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

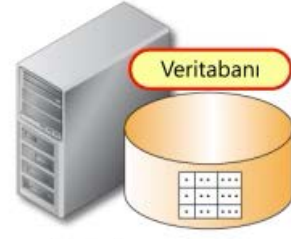
Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.

Üretimi başlat



Üretim makinesi



Veritabanı sunucusu

İleri

Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.



Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

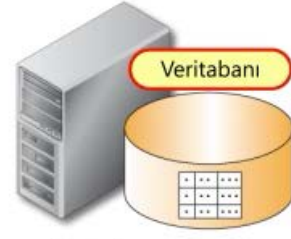
Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.

Üretimi sonlandır



Üretim makinesi



Veritabanı sunucusu

İleri

Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.



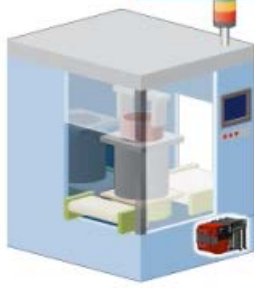
Üretim ekipmanı aşağıda gösterildiği gibi çalışır.

Makine ile üretimi başlatmadan önce, veritabanı sunucusundan standart değer verisi içe aktarılır.
(Bu örnekte üretim düzeni 2 kullanılmaktadır.)

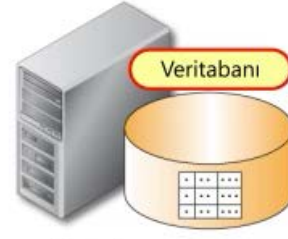
Standart değer ayarlandığında, üretim başlar.
Bu noktada, üretim düzeni ve başlangıç zamanı veritabanı sunucusuna gönderilir.

Üretim tamamlandığında, bitiş zamanı ve sonuç değeri veritabanı sunucusuna gönderilir.

Sonraki sayfaya geçmek için



Üretim makinesi



Veritabanı sunucusu

İleri

Bu kursta, veritabanı olarak Access 2016 kullanılmaktadır.

Aşağıdaki ParamTable ve ResultTable tablolarının veritabanı sunucusunda hazırlandığı varsayılmaktadır.

Üretimde kullanılacak ekipmanın standart değerleri (parametreler) önceden ParamTable tablosuna kayıtlıdır. Tabloda üç alan mevcuttur:

- Düzen No. (PatterNo)
- Pres-geçme yükü (Load)
- Pres-geçme yüksekliği (Height)

Programlanabilir denetleyici, pres-geçme yüküne ve yüksekliğine göre makineyi kontrol eder.

<Tablo adı: ParamTable>

PatternNo	Load	Height
1	100	1000
2	80	2000
3	120	1500

ResultTable, üretim tamamlandıktan sonra sonuç verilerini saklamak için kullanılır.

Tabloda beş alan mevcuttur:

- Üretilen Düzen No. (PatternNo)
- Pres-geçme yükünün sonuç değeri (LoadResult)
- Pres-geçme yüksekliğinin sonuç değeri (HeightResult)
- Üretim başlangıç zamanı (StartTime)
- Üretim bitiş zamanı (EndTime)

Bir kayıt oluşturun ve motor montajı başladığında PatternNo ve StartTime ayarlarını yapın. Montaj tamamlandıktan sonra verileri kalan alanlara ayarlayın.

<Tablo adı: ResultTable>

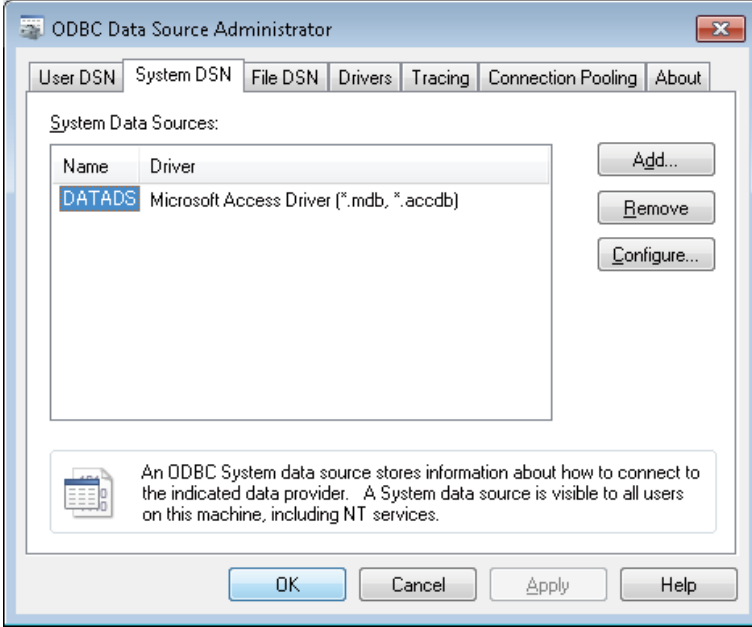
PatternNo	LoadResult	HeightResult	StartTime	EndTime

MES interface modülü, veritabanına ODBC yoluyla erişir.

ODBC işlevini kullanmak için, Windows'un ODBC ayarında veritabanı türü, veri kaynağı adı ve kullanılacak veritabanı adının ayarlanması gerekir.

MES interface function configuration toolunun hedef sunucu ayarında, veri kaynağı adı kullanılır.

Bu kursta, ODBC ayarının önceden tamamlandığı varsayılmaktadır.



<CPU modülünün device haritası>

Aşğıda, bu ayarda kullanılan cihaz belleđi (device memory) listeleri gösterilmektedir.

<Bit device>

Device memory	Device memory'nin anlamı
M0	Üretim hazır
M1	Üretimi başlat
M2	Üretim tamamlandı

<Word device>

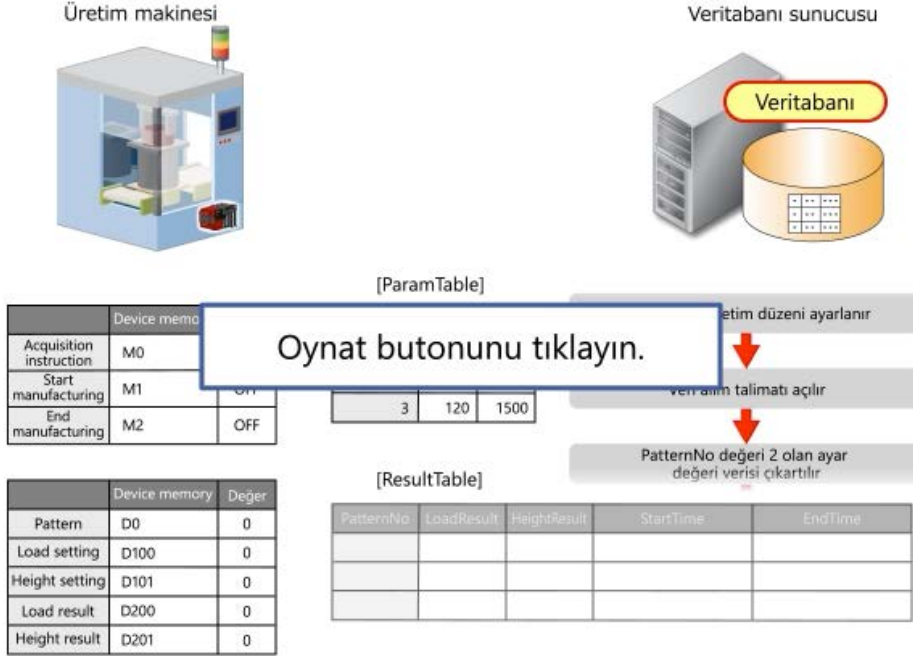
Device memory	Device memory'nin anlamı
D0	Düzen No.
D100	Pres-geçme yükünün ayar değeri
D101	Pres-geçme yüksekliğinin ayar değeri
D200	Pres-geçme yükünün sonuç değeri
D201	Pres-geçme yüksekliğinin sonuç değeri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



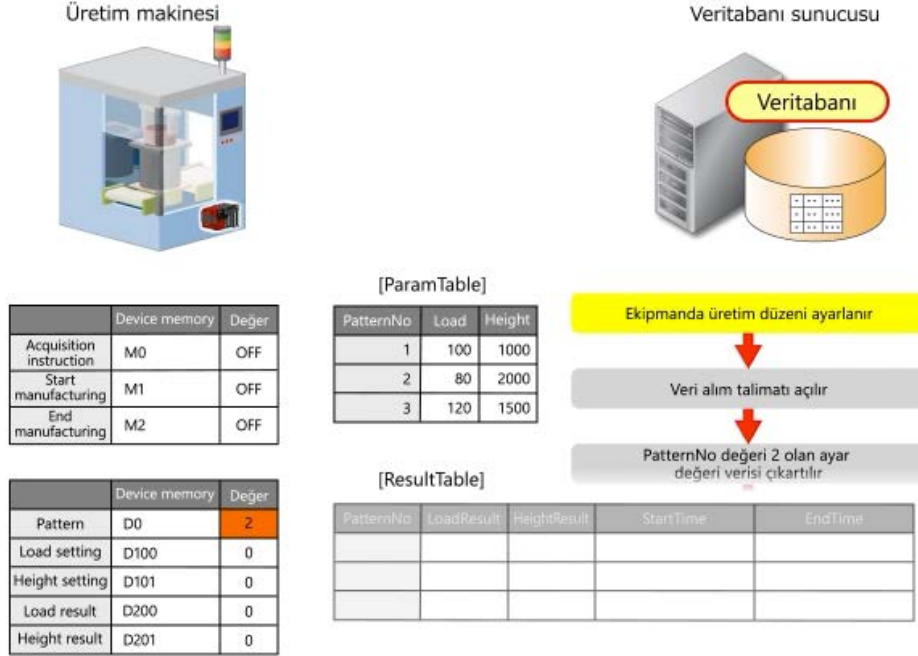
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



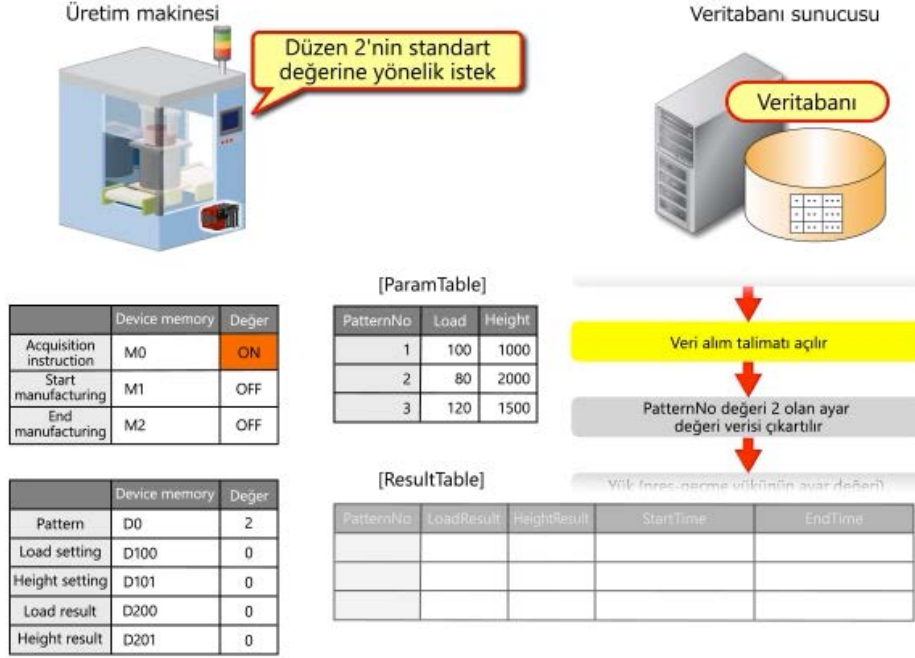
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



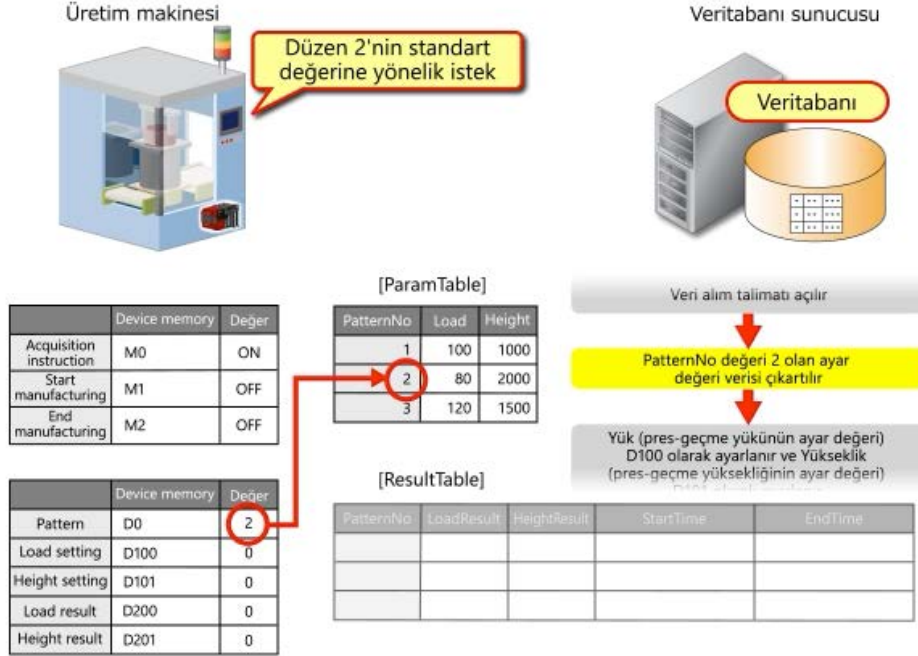
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



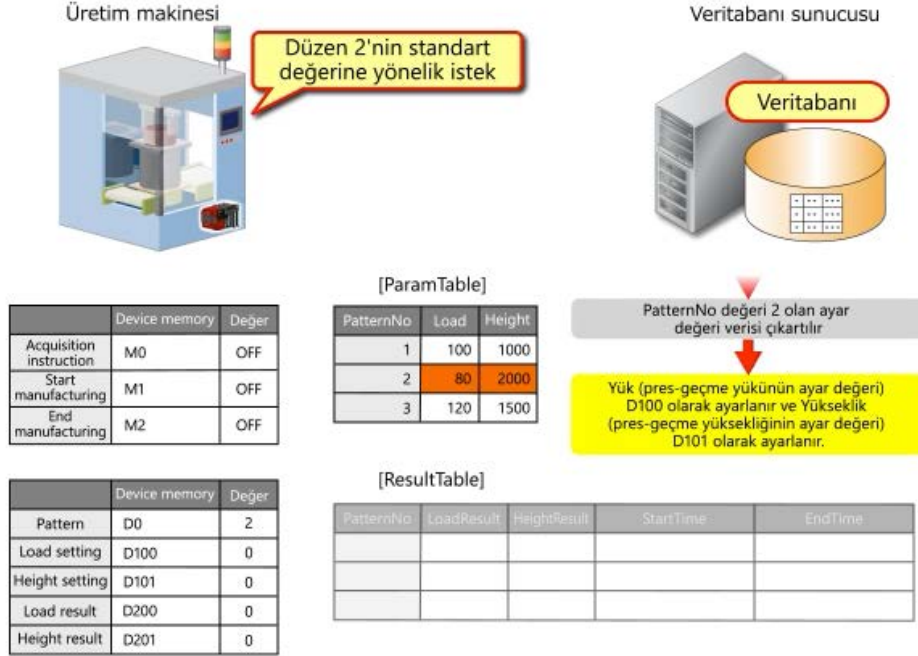
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



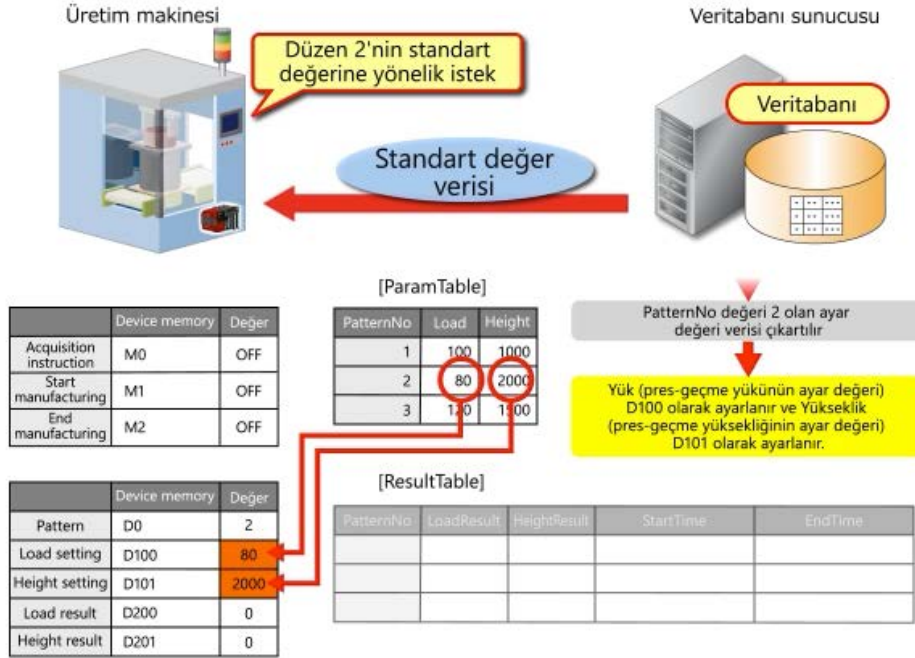
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>



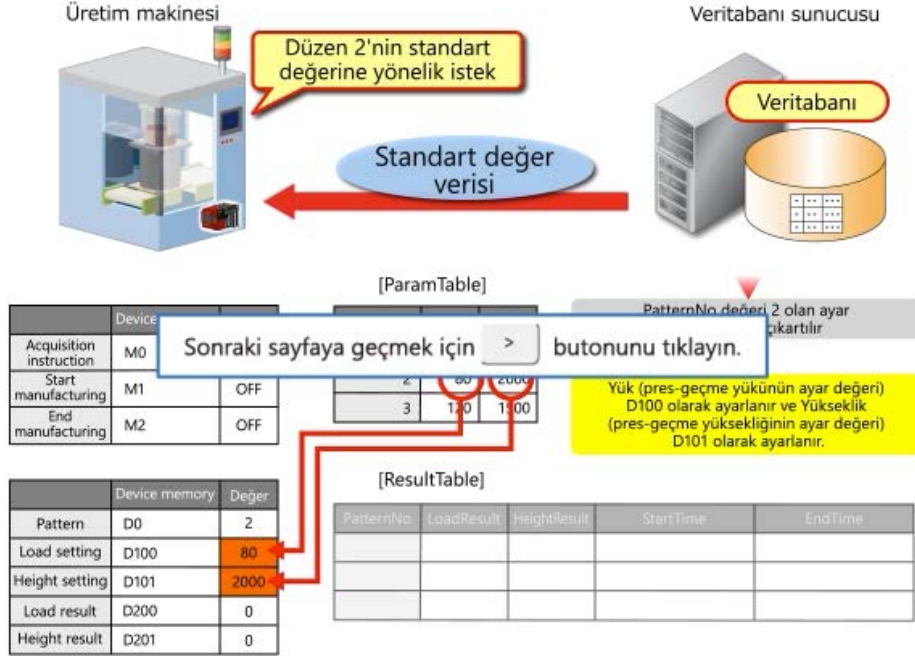
İleri

3.4 MES interface function configuration tool Ayarlama (Veri Alımı)

<Veritabanından veri alma süreci>

Ekipmanda üretim düzeni (D0 = 2) ayarlıyken veri alım talimatı (M0) açıldığında, MES interface modülü, ParamTable tablosunda PatternNo = 2 ayar değer verisini çıkarır, Load (pres-geçme yükünün ayar değeri) D100 olarak ayarlanır ve Height (pres-geçme yüksekliğinin ayar değeri) D101 olarak ayarlanır.

<Veri süreci>

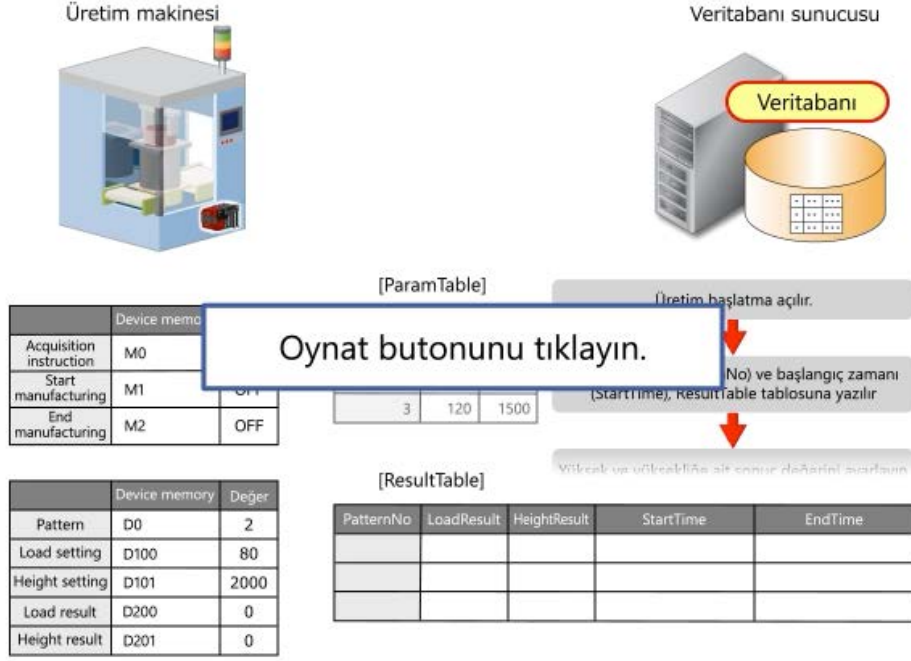


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

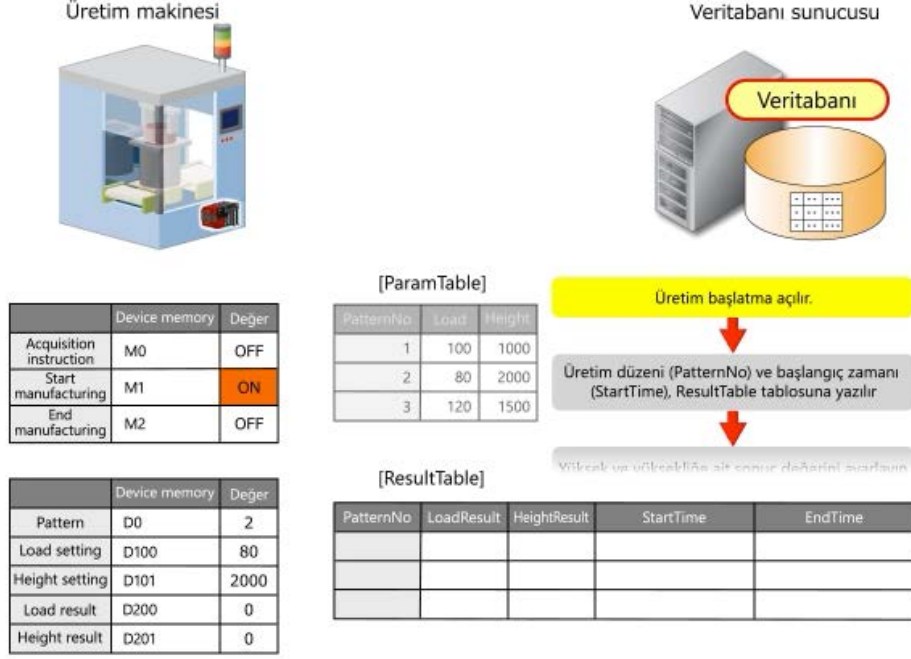


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

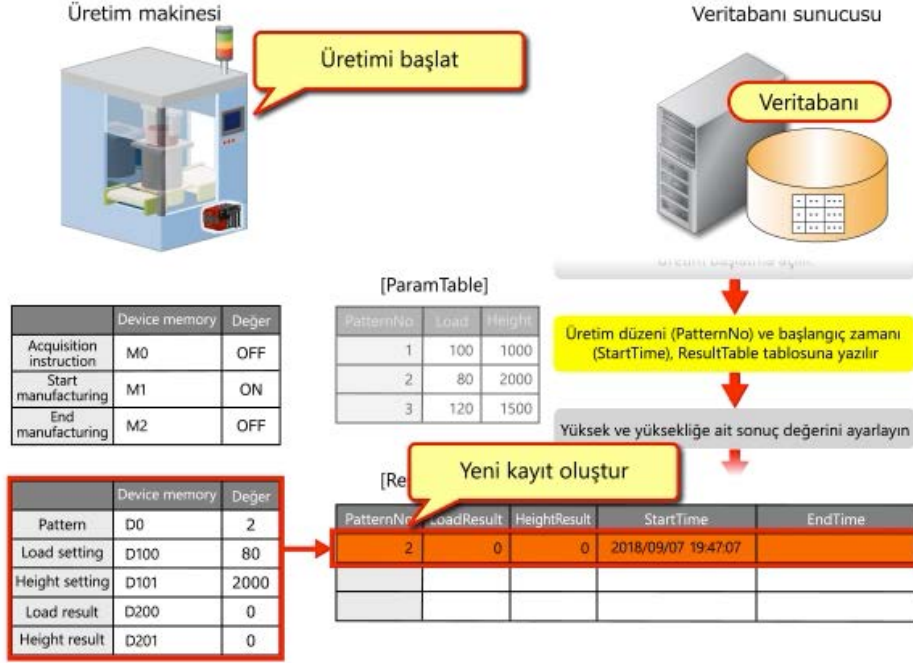


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

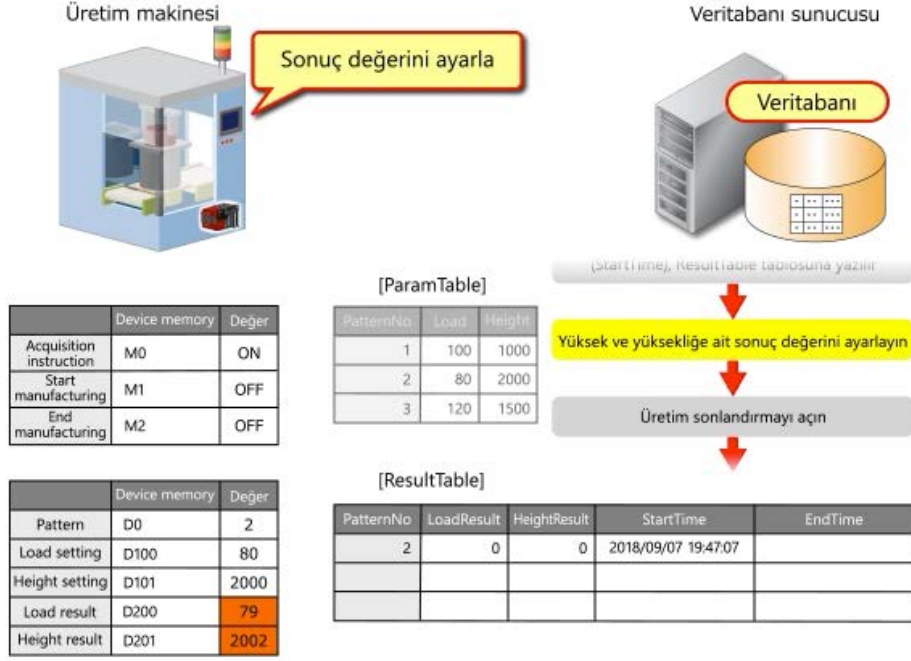


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

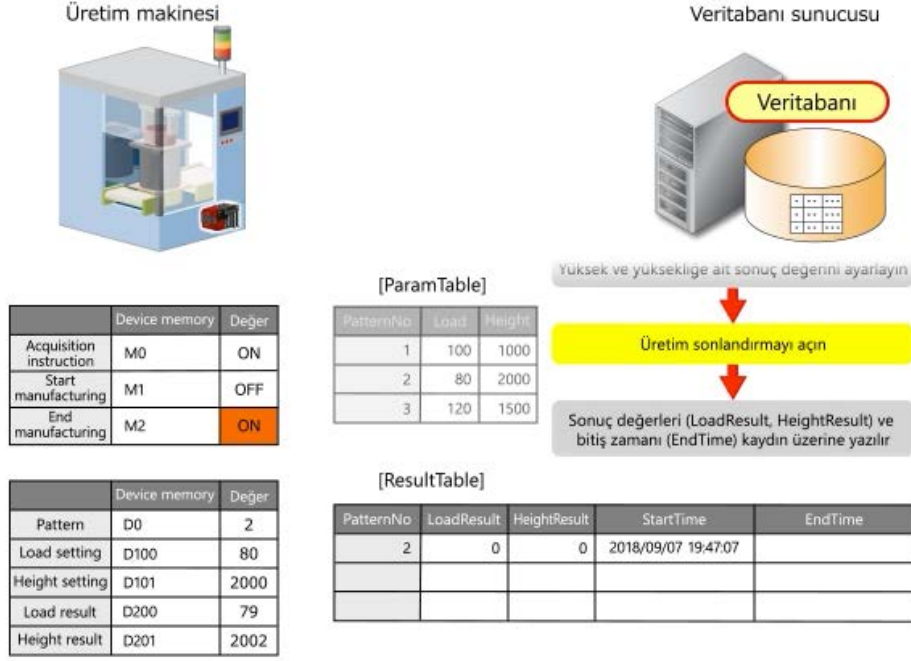


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

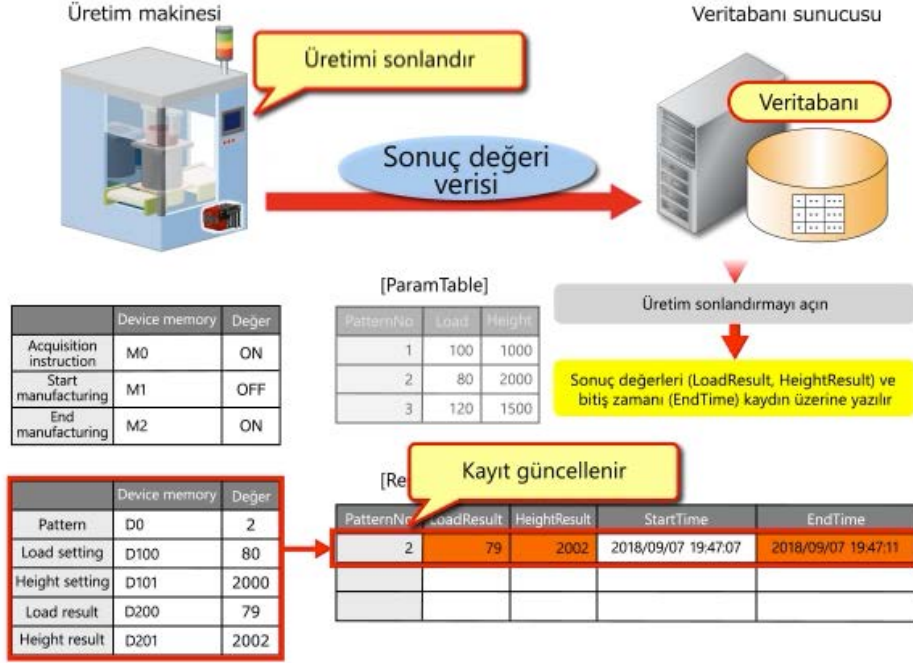


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>

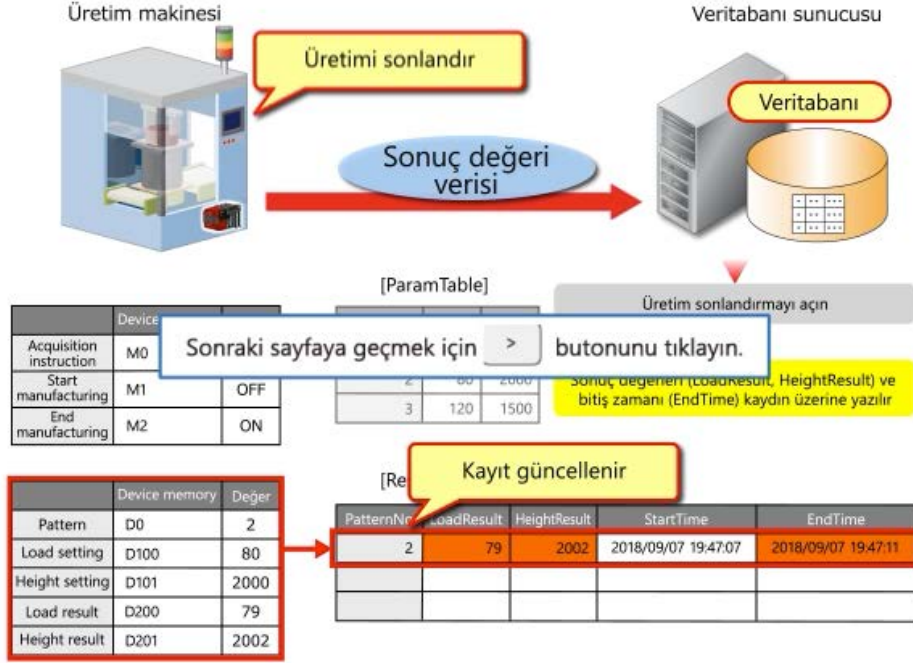


İleri

<Programlanabilir denetleyici verilerini veritabanına ayarlama süreci>

- 1) Üretimi başlatarak (M1 = ON), ResultTable tablosuna üretim düzenini (PatternNo) ve başlangıç zamanını (StartTime) yazın.
 - 2) Üretim tamamlandığında (M2 = ON), sonuç değerleriyle (LoadResult ve HeightResult) ve bitiş zamanıyla (EndTime) 1) kayıtlarının üzerine yazılır.
- * Zaman için, MES interface modülünün zaman verileri kullanılır.

<Veri süreci>



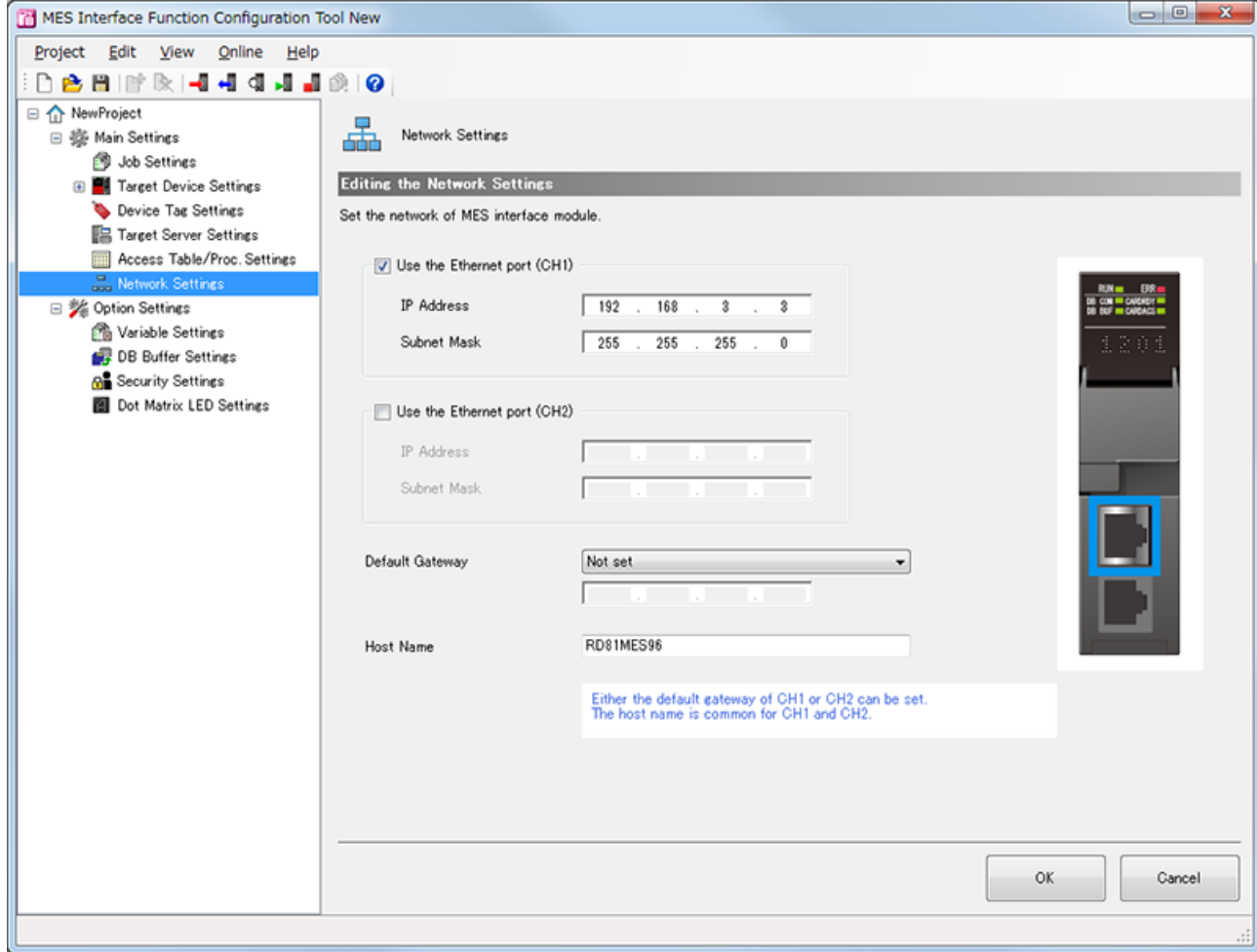
İleri

<MES interface modülünün ayarları>

Veritabanında verileri çıkartma ve CPU modülünün cihaz belleğine yazma ayarlarını yapılandırın. Aşağıda, MES interface function configuration toolındaki gerekli ayarlar açıklanmaktadır.

[Network Settings]

Bu kursta varsayılan ayar kullanılmaktadır.



Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help), a toolbar, and a left-hand navigation pane. The navigation pane is expanded to show 'Main Settings', which includes 'Job Settings', 'Device Tag Settings', 'Target Device Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The main workspace shows a 'Project Name' field with 'NewProject' entered. A large blue box with white text 'Oynat butonunu tıklayın.' (Click the play button.) is overlaid on the 'Main Settings' area. Below this, a diagram shows three interconnected boxes representing configuration modules: 'Device Tag Settings' (with a red tag icon), 'Job Settings' (with a document icon), and 'Access Table/Procedure Settings' (with a calendar icon). Each box contains sub-items: 'Device Tag Settings' includes 'Target Device Settings'; 'Job Settings' includes 'Network Settings'; and 'Access Table/Procedure Settings' includes 'Target Server Settings'. Double-headed arrows connect the boxes. Below the diagram, a text box contains the instruction: 'Place the cursor to display the explanation of each item.'

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The left sidebar shows a tree view of configuration categories, with 'Network Settings' selected. The main area is titled 'Main Settings of MES Interface Module' and contains a diagram of three interconnected boxes representing different settings modules: 'Device Tag Settings' (left), 'Job Settings' (middle), and 'Access Table/ Procedure Settings' (right). The 'Job Settings' box is highlighted with a red border, and a callout box points to it with the text 'Network Settings'i tıklayın.' Below the diagram, a text box contains the instruction: 'In the next step, you will enter the IP address of Ethernet port of MES interface module.'

Project Name: NewProject

Main Settings: Option Settings Comment

Main Settings of MES Interface Module

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

Device Tag Settings

Job Settings

Access Table/ Procedure Settings

Target Device Settings

Target Server Settings

Network Settings

Network Settings'i tıklayın.

In the next step, you will enter the IP address of Ethernet port of MES interface module.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject
Main Settings
Job Settings
Target Device Settings
Device Tag Settings
Target Server Settings
Access Table/Proc. Settings
Network Settings
Option Settings
Variable Settings
DB Buffer Settings
Security Settings
Dot Matrix LED Settings

Network Settings

Editing the Network Settings

Set the network of MES interface module.

Use the Ethernet port (CH1)

IP Address: 192 . 168 . 3 . 3
Subnet Mask: 255 . 255 . 255 . 0

Use the Ethernet port (CH2)

Varsayılan ayardaki ayarlar değiştirilmez.

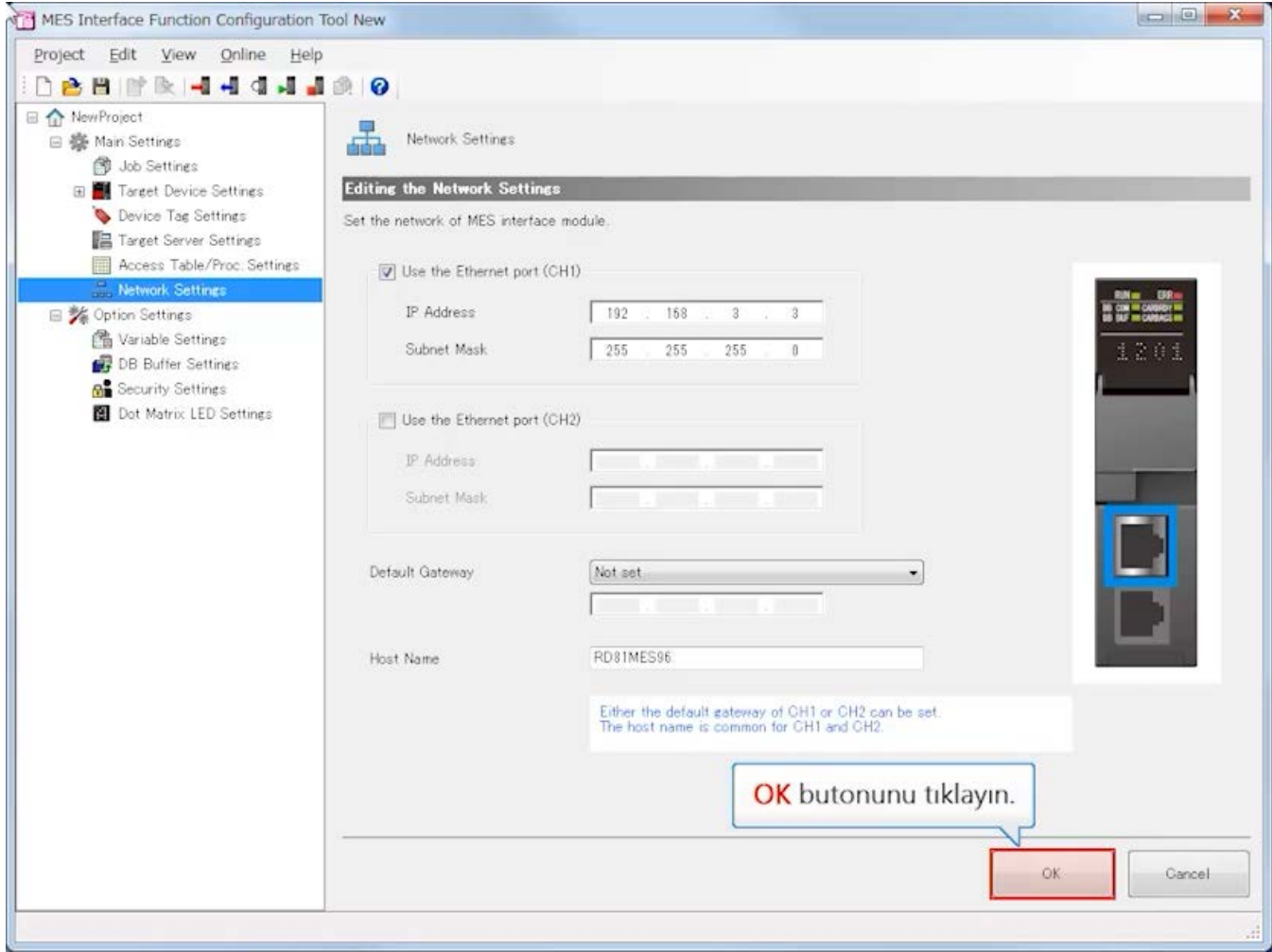
Default Gateway: Not set
Host Name: RD81MES96

Either the default gateway of CH1 or CH2 can be set.
The host name is common for CH1 and CH2.

OK Cancel

Geri

İleri



Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help) and a toolbar. A left sidebar shows a tree view of settings categories: Main Settings (selected), Job Settings, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area features a 'Home' button, a 'Project Name' field containing 'NewProject', and tabs for 'Main Settings', 'Option Settings', and 'Comment'. The 'Main Settings' tab is active, showing the 'Main Settings of MES Interface Module' section. Below this, there is a diagram with three interconnected boxes. The first box contains 'Device Tag Settings' and 'Target Device Settings'. The second box contains 'Job Settings' and 'Network Settings'. The third box contains 'Access Table/ Procedure Settings' and 'Target Server Settings'. Double-headed arrows connect the boxes. Below the diagram, there is a text box with the instruction: 'Place the cursor to display the explanation of each item.' At the bottom of the window, a white box contains the text: 'Ağ ayarlama tamamlanmıştır. Sonraki sayfaya geçmek için > butonunu tıklayın.'

[Target Device Settings]

Bu kursta varsayılan ayar kullanılmaktadır.

Target Device Setting No.[1]

Target Device Name Comment

Target Device Settings

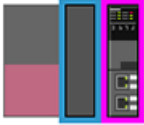
Set the target device for data access from MES interface module.

Device Type Multiple CPU Setting

Network Communication Route

Set the network communication route to a device existing over a single network

Source System Settings	Target (Relay Station) System Settings
Module Type <input type="text" value="CC-Link IE Controller Network Module"/>	Module Type <input type="text" value="CC-Link IE Controller Network Module
CC-Link IE Field Network Module
MELSECNET/H Network Module
Ethernet Interface Module"/>
Route <input type="text" value="Direct access to Ethernet Port"/>	
	Network No. <input type="text" value="1"/>
	Station No. <input type="text" value="1"/>



Global Label/Common Device Comment Settings (optional)

Use the global label/common device comment

Global Label/Common Device Comment Import Source Setting ...

Communication Test

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - Target Server Settings
 - Access Table/Proc. Settings
 - Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Home

Project Name NewProject

Main S

Oynat butonunu tıklayın.

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

```
graph LR; DT[Device Tag Settings] <--> JS[Job Settings]; TD[Target Device Settings] <--> JS; JS <--> AT[Access Table/Procedure Settings]; JS <--> NS[Network Settings]; AT <--> TS[Target Server Settings];
```

Place the cursor to display the explanation of each item.

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The left sidebar shows a tree view of settings categories, with 'Target Device Settings' selected. The main area shows the 'Main Settings of MES Interface Module' section, which includes a 'Project Name' field set to 'NewProject' and three tabs: 'Main Settings', 'Option Settings', and 'Comment'. Below the tabs, there is a diagram with three main boxes connected by double-headed arrows. The first box contains 'Device Tag Settings' and 'Target Device Settings' (highlighted with a red border). The second box contains 'Job Settings' and 'Network Settings'. The third box contains 'Access Table/ Procedure Settings' and 'Target Server Settings'. A callout box with a red border points to the 'Target Device Settings' button, containing the text 'Target Device Settings'i tıklayın.' Below the diagram, there is a text input field with the placeholder 'Place the cu...'. The top menu bar includes 'Project', 'Edit', 'View', 'Online', and 'Help'.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject
Main Settings
Job Settings
Target Device Settings
ControlCPU
Device Tag Settings
Target Server Settings
Access Table/Proc. Settings
Network Settings
Option Settings
Variable Settings
DB Buffer Settings
Security Settings
Dot Matrix LED Settings

Target Device Setting List

Home

Adding/Editing the Target Device Settings

When adding a target device setting, select a blank line and click the "Edit" button.
When editing the existing target device setting, select the applicable line and click the "Edit" button.

No.	Target Device Name	Comment	Device Type	Multiple CPU Setting
1	ControlCPU		MELSEC (RCPU)	No Specification
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

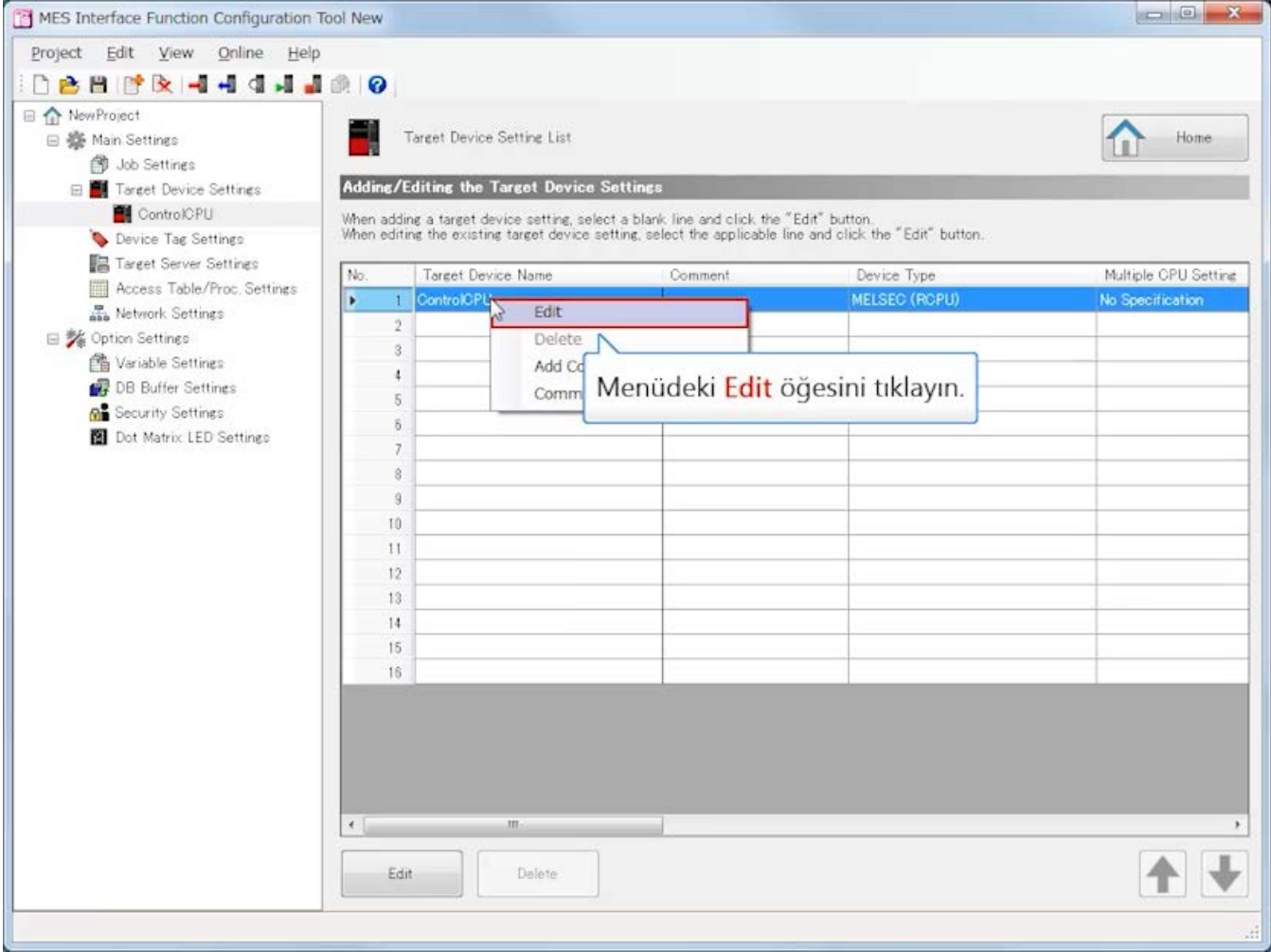
Edit Delete

↑ ↓

Bu ayarda, MES interface modülünün kurulduğu PLC CPU modülünün device bilgisi kullanılır.
Target Device Settings List listesinden ControlCPU üzerine sağ tıklayın.

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Target Device Setting List

Home

Adding/Editing the Target Device Settings

When adding a target device setting, select a blank line and click the "Edit" button.
When editing the existing target device setting, select the applicable line and click the "Edit" button.

No.	Target Device Name	Comment	Device Type	Multiple CPU Setting
1	ControlCPU		MELSEC (ROPU)	No Specification
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Menüdeki Edit öğesini tıklayın.

Edit Delete

↑ ↓

Geri

İleri

MES Inter Target Device Setting No.[1]

Target Device Name Comment

Target Device Settings

Set the target device for data access from MES interface module.

Device Type Multiple CPU Setting

Network Communication Route


Set the network communication route to a device existing over a single network.

Source System Settings **Target (Relay Station) System Settings**

Module Type Module Type

Route

Varsayılan ayardaki ayarlar değiştirilmez.
Diğer PLC istasyonlarının bilgilerini bir ağ üzerinden veritabanına ağlarken,
target device ayarını ekleyin.



Global Label/Common Device Comment Settings (optional)

Use the global label/common device comment

Global Label/Common Device Comment Import Source Setting

Communication Test

Geri

İleri

MES Inter Target Device Setting No.[1]

Target Device Name Comment

Target Device Settings

Set the target device for data access from MES interface module.

Device Type Multiple CPU Setting

Network Communication Route

Set the network communication route to a device existing over a single network.

Source System Settings **Target (Relay Station) System Settings**

Module Type Module Type

Route

Network No.

Station No.

Global Label/Common Device Comment Settings (optional)

Use the global label/common device comment

Global Label/Common Device Comment Import Source Setting

Communication Test

OK butonunu tıklayın.

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with the following items: NewProject, Main Settings, Job Settings, Target Device Settings (selected), ControlCPU, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area is titled 'Target Device Setting List' and contains a table with the following data:

No.	Target Device Name	Comment	Device Type	Multiple CPU Setting
1	ControlCPU		MELSEC (ROPU)	No Specification
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Below the table, there is a text box with the following text: 'Target device ayarları tamamlanır. Sonraki sayfaya geçmek için > butonunu tıklayın.' The text box also contains a right-pointing arrow button. The window also features a 'Home' button in the top right corner and 'Edit' and 'Delete' buttons at the bottom left.

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

[Device Tag Settings]

Veritabanından verileri çıkartan ve CPU modülünün device memory "GettingData" olarak yazan ayarı yapılandırın.

(1) Device tag name : GettingData

Component Name	Target Device	Device Memory (Start)	Data Type
PatternNo	ControlCPU	D0	Word [Unsigned]/Bit String [16-bit]
SettingValueofPressFittingLoad	ControlCPU	D100	Word [Unsigned]/Bit String [16-bit]
SettingValueofPressFittingHeight	ControlCPU	D101	Word [Unsigned]/Bit String [16-bit]
ManufacturingSettingValueAcquisition	ControlCPU	M0	Bit

Device Tag Setting No.[1]

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	ControlCPU	D0	D0	Word [Unsigned]/Bit String [16-bit]
2	SettingValueofPressFittingLoad	ControlCPU	D100	D100	Word [Unsigned]/Bit String [16-bit]
3	SettingValueofPressFittingHeight	ControlCPU	D101	D101	Word [Unsigned]/Bit String [16-bit]
4	ManufacturingSettingValueAcquisi	ControlCPU	M0	M0	Bit
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: [] Change

OK Cancel

[Device Tag Components in the Project] 4

CPU modülünün cihaz belleğindeki verileri veritabanına "PuttingData" olarak yazan ayarı yapılandırın.

(2) Device tag name : PuttingData

Component Name	Target Device	Device Memory (Start)	Data Type
PatternNo	ControlCPU	D0	Word [Unsigned]/Bit String [16-bit]
ResultValueofPressFittingLoad	ControlCPU	D200	Word [Unsigned]/Bit String [16-bit]
ResultValueofPressFittingHeight	ControlCPU	D201	Word [Unsigned]/Bit String [16-bit]

StartManufacturing	ControlCPU	M1	Bit
EndManufacturing	ControlCPU	M2	Bit

Device Tag Setting No.[2]

Device Tag Name Comment

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data Type	
1	PatternNo	ControlCPU	...	D0	D0	Word [Unsigned]/Bit String [16-bit]
2	ResultValueofPressFittingLoad	ControlCPU	...	D200	D200	Word [Unsigned]/Bit String [16-bit]
3	ResultValueofPressFittingHeight	ControlCPU	...	D201	D201	Word [Unsigned]/Bit String [16-bit]
4	StartManufacturing	ControlCPU	...	M1	M1	Bit
5	EndManufacturing	ControlCPU	...	M2	M2	Bit
6			...			
7			...			
8			...			
9			...			
10			...			
11			...			
12			...			

Delete ↑ ↓

Data Write-Protect Setting (optional) **Array Tag Settings (optional)**

Protect data writing Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting Change

OK Cancel

[Device Tag Components in the Project] 9

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help) and a toolbar. A left sidebar lists various configuration categories, with 'Device Tag Settings' highlighted. The main workspace shows a 'Project Name' field set to 'NewProject'. A central instruction box reads 'Oynat butonunu tıklayın.' (Click the play button). Below this, a diagram illustrates the configuration flow: 'Device Tag Settings' and 'Target Device Settings' are linked to 'Job Settings' and 'Network Settings', which are in turn linked to 'Access Table/Procedure Settings' and 'Target Server Settings'. A text box at the bottom prompts the user to 'Place the cursor to display the explanation of each item.'

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Home

Project Name NewProject

Main S

Oynat butonunu tıklayın.

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

Target Server Settings

Place the cursor to display the explanation of each item.

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' application window. The interface includes a menu bar (Project, Edit, View, Online, Help) and a toolbar with various icons. A left-hand sidebar lists configuration categories: Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main workspace shows a 'Project Name' field with 'NewProject' entered. Below this, there are tabs for 'Main Settings', 'Option Settings', and 'Comment'. The 'Main Settings' tab is active, displaying the 'Main Settings of MES Interface Module' section. This section contains a diagram with three main boxes: 'Device Tag Settings' (highlighted in red), 'Job Settings', and 'Access Table/Procedure Settings'. Below these are 'Target Server Settings' and 'Settings'. A callout box points to the 'Device Tag Settings' box with the text 'Device Tag Settings'i tıklayın.' (Click on Device Tag Settings). Below the diagram, there is a text box with the instruction: 'Place the cursor to display the explanation of each item.'

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings**
- Target Server Settings
- Access Table/Proc. Settings
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

[Device Tag Components in the Project] 0

Device tag setting list içindeki satır No. 1'i tıklayın.

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete Add

Yeni device tagi oluşturmak için Edit'i seçin.
Menüdeki **Edit** öğesini tıklayın.

Edit Delete

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: Tag01 Comment:

Device Tag Settings
Set the device tag as the logical error. Further, set a component name as follows.

No.	Component Name
1	...
2	...
3	...
4	...
5	...
6	...
7	...
8	...
9	...
10	...
11	...
12	...

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: [] Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData

Comment:

Device Tag Settings

Set the device tag as the location of the data. Further, set a component name.

Device Tag Name giriş alanına "GettingData" girin.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

Up

Down

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings
Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings
Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3					
4					
5					
6					
7					
8			...		
9			...		
10			...		
11			...		
12			...		

Programlanabilir denetleyiciye ait D0'ı, bileşen adı olarak "PatternNo" ögesine ayarlayın.
Component Name ögesini tıklayın.

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings
Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo		...		
2			...		
3					
4					
5					
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

↑ ↓

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings
Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo	ControlCPU			
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo	ControlGPU			Word
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 1

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job. Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo	ControlCPU	D0		Word
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 1

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting No.[1]

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	D0	D0	Word [Signed]
2				Bit
3				Word [Unsigned]/Bit String [16-bit]
4				Double Word [Unsigned]/Bit String [32-bit]
5				Character String [unicode]
6				Character String [ASCII/SJIS]
7				
8				
9				
10				
11				
12				

Pattern No. sayısal veri (word tipi) olduğundan, "Word [Unsigned]/Bit String [16-bit]" belirtin.

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: [] Change

OK Cancel

[Device Tag Components in the Project] 1

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job. Further, set a component name as the logical name for each device memory.

No.	Component Name	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	D0	D0	Word [Unsigned]/Bit String [16-bit]
2				
3				
4				
5				

"PatternNo" ile aynı işlemi uygulayarak aşağıdaki tabloda gösterilen üç bileşeni kaydedin. Bu kursta ayarlama işlemi göz ardı edilmiştir.

Component Name	Target Device	Device Memory (Start)	Data Type
SettingValueofPressFittingLoad	ControlCPU	D100	Word [Unsigned]/Bit String [16-bit]
SettingValueofPressFittingHeight	ControlCPU	D101	Word [Unsigned]/Bit String [16-bit]
ManufacturingSettingValueAcquisition	ControlCPU	M0	Bit

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 1

[Device Tag Components in the Project] 0

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Setting No.[1]

Device Tag Name: GettingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	ControlCPU	D0	D0	Word [Unsigned]/Bit String [16-bit]
2	SettingValueofPressFittingLoad	ControlCPU	D100	D100	Word [Unsigned]/Bit String [16-bit]
3	SettingValueofPressFittingHeight	ControlCPU	D101	D101	Word [Unsigned]/Bit String [16-bit]
4	ManufacturingSettingValueAcquisi	ControlCPU	M0	M0	Bit
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
Destination of Multiple Select: [] Change

OK Cancel

[Device Tag Components in the Project] 0

Tüm bileşenler kaydedildikten sonra, OK butonunu tıklayın.

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

The screenshot shows the MES Interface Function Configuration Tool New window. The left sidebar contains a tree view with the following items: NewProject, Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings (selected), GettingData, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area is titled "Device Tag Setting List" and contains a table with the following columns: No., Device Tag Name, Comment, Data Writing, and Array Size. The table has 21 rows, with the first row (No. 1) containing "GettingData" in the Device Tag Name column. Below the table, there are "Edit" and "Delete" buttons. A text box with a blue border contains the following text: "GettingData" device tag ayarı tamamlanmıştır. Sonraki sayfaya geçmek için > butonunu tıklayın. At the bottom right of the window, there is a status bar that reads "[Device Tag Components in the Project] 4".

Device Tag Setting List

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1	GettingData		-	-
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

"GettingData" device tag ayarı tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with the following items: NewProject, Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings (selected), GettingData, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area is titled 'Device Tag Setting List' and contains a table with the following columns: No., Data Writing, and Array Size. The table has 21 rows, with the first row (No. 1) highlighted in blue. A text box with the text 'Oynat butonunu tıklayın.' is overlaid on the first row. Below the table are 'Edit' and 'Delete' buttons, and a 'Home' button in the top right. The status bar at the bottom right shows '[Device Tag Components in the Project] 4'.

Project Edit View Online Help

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Data Writing	Array Size
1		
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		
13		
14		
15		
16		
17		
18		
19		
20		
21		

Edit Delete

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with the following items: NewProject, Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings (selected), GettingData, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area is titled 'Device Tag Setting List' and contains a table with the following columns: No., Device Tag Name, Comment, Data Writing, and Array Size. The table has 21 rows. Row 1 is highlighted in blue and contains 'GettingData'. Row 2 is highlighted in red. A callout box with a blue border and a white background is positioned over row 2, containing the text: 'Sonra, ikinci device tagi ayarlayın. Device tag setting list içindeki **satır No. 2**'yi tıklayın.' Below the table are 'Edit' and 'Delete' buttons. At the bottom right, there are up and down arrow buttons and a status bar showing '[Device Tag Components in the Project] 4'.

Device Tag Setting List

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1	GettingData		-	-
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1	GettingData		-	-
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

Yeni device tagi oluşturmak için Edit seçin.
Menüdeki Edit öğesini tıklayın.

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: Tag01

Comment:

Device Tag Settings
Set the device tag as the logical e
Further, set a component name as

No.	Component Name			
1		...		
2		...		
3		...		
4		...		
5		...		
6		...		
7		...		
8		...		
9		...		
10		...		
11		...		
12		...		

Delete

↑ ↓

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData

Comment:

Device Tag Settings

Set the device tag as the location of the data. Further, set a component name.

Device Tag Name giriş alanına "PuttingData" girin.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

Up

Down

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings
Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

↑ ↓

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[[Device Tag Components in the Project] 4]

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1			...		
2			...		
3					
4					
5					
6					
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

Up Down

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting No.[2]

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job. Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo		...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete

↑ ↓

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo				
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting No.[2]

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo	ControlCPU			Word
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Up Down

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo	ControlCPU	D0		Word
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional) Protect data writing

Array Tag Settings (optional) Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job.
Further, set a component name as the logical name for each device memory.

No.	Component Name	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	D0	D0	Word [Signed]
2				Bit
3				Word [Unsigned]/Bit String [16-bit]
4				Double Word [Unsigned]/Bit String [32-bit]
5				[Signed]
6				recision]
7				recision]
8				[Unicode]
9				Character String [ASCII/SJIS]
10				
11				
12				

Pattern No. sayısal veri (sözcük türü) olduğundan, "Word [Unsigned]/Bit String [16-bit]" belirtin.

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
 Set the array tag to be used for the assignment destination of Multiple Select
Array Tag Setting: - Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job. Further, set a component name as the logical name for each device memory.

No.	Component Name	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	D0	D0	Word [Unsigned]/Bit String [16-bit]
2				
3				
4				
5				
6				

"PatternNo" ile aynı işlemi uygulayarak aşağıdaki tabloda gösterilen dört bileşeni kaydedin. Bu kursta ayarlama işlemi göz ardı edilmiştir.

Component Name	Target Device	Device Memory (Start)	Data Type
ResultValueofPressFittingLoad	ControlCPU	D200	Word [Unsigned]/Bit String [16-bit]
ResultValueofPressFittingHeight	ControlCPU	D201	Word [Unsigned]/Bit String [16-bit]
StartManufacturing	ControlCPU	M1	Bit
EndManufacturing	ControlCPU	M2	Bit

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri

Device Tag Name: PuttingData Comment:

Device Tag Settings

Set the device tag as the logical group of device memory to be used in the job. Further, set a component name as the logical name for each device memory.

No.	Component Name	Target Device	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	ControlCPU	D0	D0	Word [Unsigned]/Bit String [16-bit]
2	ResultValueofPressFittingLoad	ControlCPU	D200	D200	Word [Unsigned]/Bit String [16-bit]
3	ResultValueofPressFittingHeight	ControlCPU	D201	D201	Word [Unsigned]/Bit String [16-bit]
4	StartManufacturing	ControlCPU	M1	M1	Bit
5	EndManufacturing	ControlCPU	M2	M2	Bit
6					
7					
8					
9					
10					
11					
12					

Delete

Data Write-Protect Setting (optional)
 Protect data writing

Array Tag Settings (optional)
Destination of Multiple Select
Change

OK Cancel

[Device Tag Components in the Project] 9

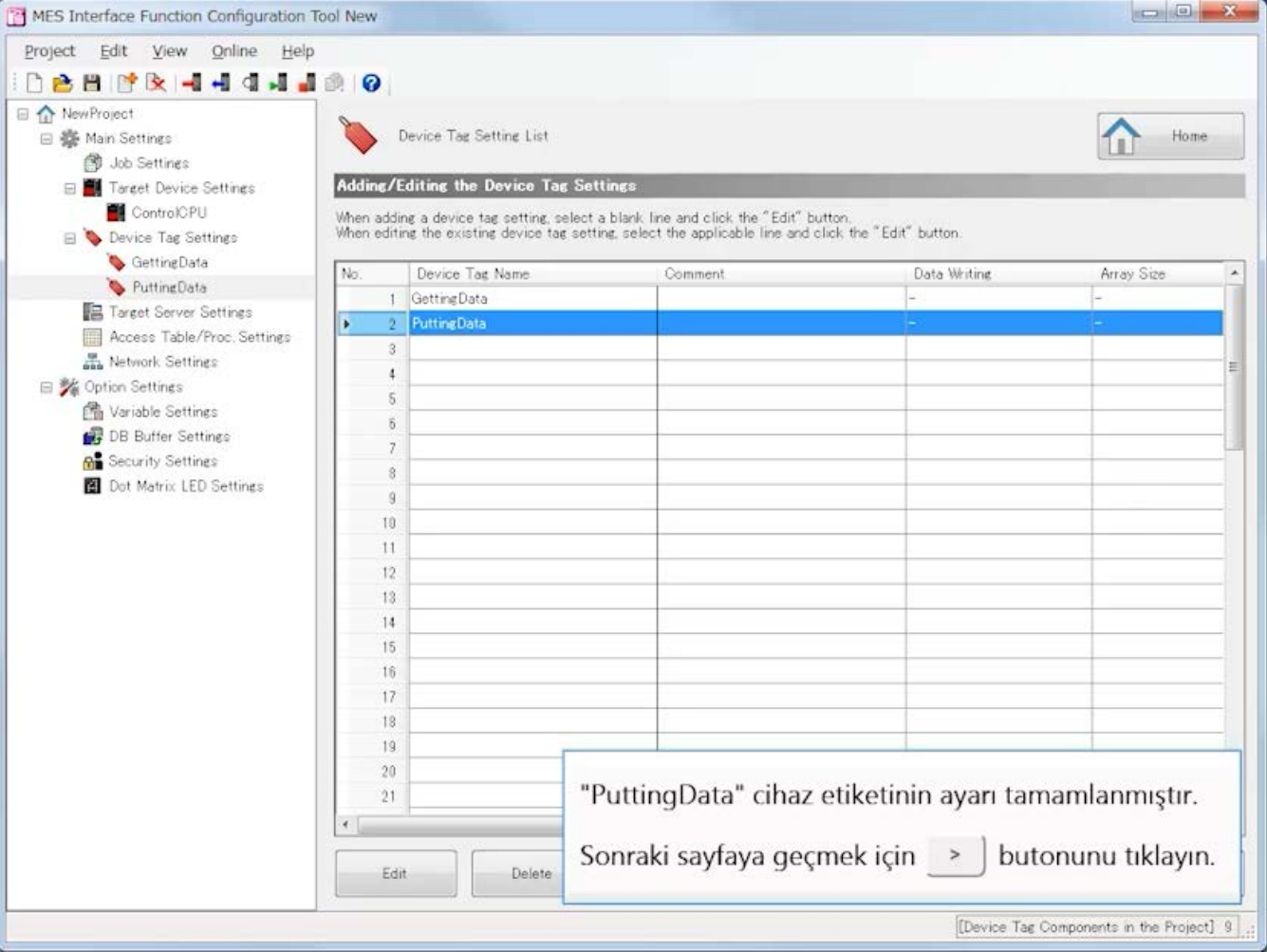
[Device Tag Components in the Project] 4

Tüm bileşenler kaydedildikten sonra, OK butonunu tıklayın.

3.4 MES interface function configuration tool Ayarlama (Device Tag Settings)

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
 - GettingData
 - PuttingData
- Target Server Settings
- Access Table/Proc. Settings
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

No.	Device Tag Name	Comment	Data Writing	Array Size
1	GettingData		-	-
2	PuttingData		-	-
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

[Device Tag Components in the Project] 9

"PuttingData" cihaz etiketinin ayarı tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

[Target Server Settings]

ODBC ayarlarında yapılandırılan aynı veri kaynağı adını kullanın.

Ayar ögesi	Ayar
Target Server Name	DataServer
Server Type	Database Server
IP Address	192.168.3.100
Port No.	5112
Communication Timeout Time	10
Data Source Name	DATADS
User Name	-
Password	-
Database Type	Access 2016
Access Error Notification Setting	Not Notify

Target Server Setting No.[1]

Target Server Name Comment

Target Server Common Settings

Set the target server with which MES interface module communicates.

Server Type

IP Address

Port No.

Communication Timeout Time s

Target Server Individual Settings

Set the information to access the database.

Data Source Name

User Name

Password

Database Type

Access Error Notification Settings (optional)

Access Error Notification Setting

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Server Settings
 - Access Table/Proc. Settings
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Home

Project Name NewProject

Main S

Mail

Oynat butonunu tıklayın.

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

```
graph LR; DT[Device Tag Settings] <--> JS[Job Settings]; TDS[Target Device Settings] <--> JS; JS <--> ATP[Access Table/Procedure Settings]; JS <--> TSS[Target Server Settings];
```

Place the cursor to display the explanation of each item.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Device Settings

ControlCPU

Device Tag Settings

GettingData

PuttingData

Target Server Settings

Access Table/Proc. Settings

Network Settings

Option Settings

Variable Settings

DB Buffer Settings

Security Settings

Dot Matrix LED Settings

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/ Procedure Settings

Target Server Settings

Target Server Settings öğesini tıklayın.

Place the cursor to display the exp...

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
 - GettingData
 - PuttingData
- Target Server Settings**
- Access Table/Proc. Settings
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Target Server Setting List

Home

Adding/Editing the Target Server Settings

When adding a target server setting, select a blank line and click the "Edit" button.
When editing the existing target server setting, select the applicable line and click the "Edit" button.

No.	Target Server Name	Comment	Server Type	IP Address
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Target Server Setting List içindeki satır No. 1'i sağ tıklayın.

Edit Delete

↑ ↓

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Target Server Settings' selected. The main area displays a 'Target Server Setting List' table with columns: No., Target Server Name, Comment, Server Type, and IP Address. A context menu is open over the first row (No. 1), showing options: Edit, Delete, Add, and Com. A tooltip in Turkish reads: 'Edit seçin ve hedef sunucuyu ayarlayın. Menüdeki Edit öğesini tıklayın.' Below the table are 'Edit' and 'Delete' buttons, and navigation arrows.

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Server Settings
 - Access Table/Proc. Settings
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Target Server Setting List

Home

Adding/Editing the Target Server Settings

When adding a target server setting, select a blank line and click the "Edit" button.
When editing the existing target server setting, select the applicable line and click the "Edit" button.

No.	Target Server Name	Comment	Server Type	IP Address
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Edit Delete Add Com

Edit seçin ve hedef sunucuyu ayarlayın.
Menüdeki Edit öğesini tıklayın.

Edit Delete

↑ ↓

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Server Settings

Device Settings

Get Settings

Put Settings

Target Server Access Settings

Network Settings

Option Settings

Variable Settings

DB Backup Settings

Security Settings

Dot Matrix Settings

Home

Address

Target Server Setting No.[1]

Target Server Name: Comment:

Target Server Common Settings

Set the target server with which MES

Server Type:

IP Address:

Port No.:

Communication Timeout Time: s

Target Server Individual Settings

Set the information to access the database.

Data Source Name:

User Name:

Password:

Database Type:


Access Error Notification Settings (optional)

Access Error Notification Setting:

↑ ↓

Target Server Name: **Server01**

Hedef sunucu adını ayarlayın.
Target Server Name öğesini tıklayın.



Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Setting

Job Setting

Target Server

Communication

Device

Get

Put

Target Server

Access

Network

Option Setting

Variable

DB Backup

Security

Dot Matrix

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer1 Comment:

Target Server Common

Set the target server with

Target Server Name giriş alanına "DataServer" girin.

Server Type: Database Server

IP Address:

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name:

User Name:

Password:

Database Type: Oracle 12c

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify Change

Communication Test

OK Cancel

Up Down

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Setting

Job Setting

Target Server

Communication

Device

Get

Put

Target Server

Access

Network

Option Setting

Variable

DB Backup

Security

Dot Matrix

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates.

Server Type: Database Server

IP Address: 192 . 168 . 3 . 100

Port No.:

Communication Timeout Time:

Target Server Individual Settings

Set the information to access the database.

Data Source Name:

User Name:

Password:

Database Type: Oracle 12c

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify Change

Communication Test

OK Cancel

Up Down

Bağlanacak veritabanı sunucusuna ait IP address değerini ayarlayın.
IP Address olarak "192.168.3.100" belirtin.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Server Settings

Communication Settings

Device Settings

Get Settings

Put Settings

Target Server Access Settings

Network Settings

Option Settings

Variable Settings

DB Burden Settings

Security Settings

Dot Matrix Settings

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates:

Server Type: Database Server

IP Address: 192 . 168 . 8 . 100

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name:

User Name:

Password:

Database Type: Oracle 12c

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify Change

Communication Test

OK Cancel

Windows ODBC ayarının kısmında kaydedilen veri kaynağı adını ayarlayın. Data Source Name ögesini tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Server Settings

Communication Settings

Device Settings

Get Settings

Put Settings

Target Server Access Settings

Network Settings

Option Settings

Variable Settings

DB Backup Settings

Security Settings

Dot Matrix Settings

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates:

Server Type: Database Server

IP Address: 192 . 168 . 8 . 100

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name: DATADS

User Name:

Password:

Database Type: Oracle 12c

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify Change

Communication Test

OK Cancel

Up Down

Target Server Setting No.[1]

Data Source Name giriş alanına "DATADS" girin.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Setting

Job Setting

Target Server

Communication

Device

Get

Put

Target Server

Access

Network

Option Setting

Variable

DB Backup

Security

Dot Matrix

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates:

Server Type: Database Server

IP Address: 192 . 168 . 8 . 100

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name: DATADS

User Name:

Password:

Database Type: Oracle 12c

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify

Communication Test

OK Cancel

Bağlanacak veritabanı türünü ayarlayın.
Database Type öğesini tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates:

Server Type: Database Server

IP Address: 192 . 168 . 8 . 100

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name: DATADS

User Name:

Password:

Database Type:

Access Error Notification Setting

Access Error Notification Setting:

Communication Test

Veritabanı için "Access2016" kullanılır. Listedен Access2016 ögesini tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Server Settings

Communication Settings

Option Settings

Variable Settings

DB Backup Settings

Security Settings

Dot Matrix Settings

Home

Address

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common Settings

Set the target server with which MES interface module communicates:

Server Type: Database Server

IP Address: 192 . 168 . 8 . 100

Port No.: 5112

Communication Timeout Time: 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name: DATADS

User Name:

Password:

Database Type: Access 2016

Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify

Communication Test

OK Cancel

OK butonunu tıklayın.

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Target Server Settings' selected. The main area displays the 'Target Server Setting List' table. The table has five columns: 'No.', 'Target Server Name', 'Comment', 'Server Type', and 'IP Address'. The first row is highlighted in blue and contains the values: 1, DataServer, (empty), Database Server, and 192.168.3.100. Below the table, there is a confirmation message in a white box with a blue border: 'Access hedef sunucu ayarı tamamlanmıştır. Sonraki sayfaya geçmek için > butonunu tıklayın.' Below the message are 'Edit' and 'Delete' buttons.

Target Server Setting List

Adding/Editing the Target Server Settings

When adding a target server setting, select a blank line and click the "Edit" button.
When editing the existing target server setting, select the applicable line and click the "Edit" button.

No.	Target Server Name	Comment	Server Type	IP Address
1	DataServer		Database Server	192.168.3.100
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Access hedef sunucu ayarı tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

Edit Delete

[Access Table/Procedure Settings]

MES interface modülünün bağılandığı access tablosunu/işlemini yapılandırın.

- (1) Access Table/Procedure Name : GetPlan
 Target Server : DataServer
 Table/Procedure Type : Access Table
 DB Table Name : ParamTable

Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting	Default Value
PatternNo	PatternNo	Integer	Disable	Disable	-
Load	Load	Integer	Disable	Disable	-
Height	Height	Integer	Disable	Disable	-

Access Table/Procedure Setting No.[1]

Access Table/Procedure Name: GetPlan Comment: _____

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information Browse DB Field Information

DB Table Name: ParamTable

No.	Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting
1	PatternNo	PatternNo	Integer	Disable	Disable
2	Load	Load	Integer	Disable	Disable
3	Height	Height	Integer	Disable	Disable
4					
5					
6					
7					
8					

Delete ↑ ↓

OK Cancel

[DB Field Name] 19 characters

- (2) Access Table/Procedure Name : PutPlan1
 Target Server : DataServer
 Table/Procedure Type : Access Table
 DB Table Name : ResultTable

Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting	Default Value
-------------------	---------------	-----------	----------------	-----------------------	---------------

PatternNo	PatternNo	Integer	Disable	Disable	-
LoadResult	LoadResult	Integer	Disable	Disable	-
HeightResult	HeightResult	Integer	Disable	Disable	-
StartTime	StartTime	Date and Time [Without Time Zone]	Disable	Disable	-

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment: _____

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information Browse DB Field Information

DB Table Name: ResultTable

No.	Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting
1	PatternNo	PatternNo	Integer	Disable	Disable
2	LoadResult	LoadResult	Integer	Disable	Disable
3	HeightResult	HeightResult	Integer	Disable	Disable
4	StartTime	StartTime	Date and Time [Without Time Zone]	Disable	Disable
5					
6					
7					
8					

Delete ↑ ↓

OK Cancel

[DB Field Name] 40 characters

(3) Access Table/Procedure Name : PutPlan2
 Target Server : DataServer
 Table/Procedure Type : Access Table
 DB Table Name : ResultTable

Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting	Default Value
PatternNo	PatternNo	Integer	Disable	Disable	-
LoadResult	LoadResult	Integer	Disable	Disable	-
HeightResult	HeightResult	Integer	Disable	Disable	-
EndTime	EndTime	Date and Time [Without Time Zone]	Disable	Disable	-



Access Table/Procedure Name Comment

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server

Table/Procedure Type Access Table Access Procedure

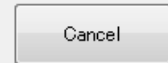
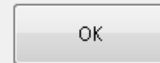
Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.



DB Table Name

No.	Access Field Name	DB Field Name	Data Type	Precision Hold	Default Value Setting
1	PatternNo	PatternNo	Integer	Disable	Disable
2	LoadResult	LoadResult	Integer	Disable	Disable
3	HeightResult	HeightResult	Integer	Disable	Disable
4	EndTime	EndTime	Date and Time [Without Time Zone]	Disable	Disable
5					
6					
7					
8					



[DB Field Name] 38 characters

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Server Settings
 - DataServer
 - Access Table/Proc. Settings
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Home

Project Name NewProject

Main S

Oynat butonunu tıklayın.

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

```
graph LR; DT[Device Tag Settings] <--> JS[Job Settings]; JS <--> AT[Access Table/Procedure Settings]; TD[Target Device Settings]; NS[Network Settings]; TS[Target Server Settings];
```

Place the cursor to display the explanation of each item.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Device Settings

ControlCPU

Device Tag Settings

GettingData

PuttingData

Target Server Settings

DataServer

Access Table/Proc. Settings

Network Settings

Option Settings

Variable Settings

DB Buffer Settings

Security Settings

Dot Matrix LED Settings

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

Device Tag Settings

Job Settings

Access Table/
Procedure Settings

Access Table/Procedure Settings öğesini tıklayın.

Place the cursor to display the explanation of each item.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Server Settings
 - DataServer
 - Access Table/Proc. Settings**
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Ty
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Access Table/Procedure Settings List içindeki satır No. 1'i sağ tıklayın.

Edit Delete

↑ ↓

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Access Table/Proc. Settings' selected. The main area displays a table titled 'Access Table/Procedure Setting List'. A context menu is open over the first row, showing 'Edit', 'Delete', and 'Add' options. A tooltip points to the 'Edit' option with the text: 'Edit seçin ve access tablosunu ve işlemini ayarlayın. Menüdeki Edit öğesini tıklayın.' Below the table are 'Edit' and 'Delete' buttons, and navigation arrows.

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Server Settings
 - DataServer
 - Access Table/Proc. Settings
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Ty
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete Add

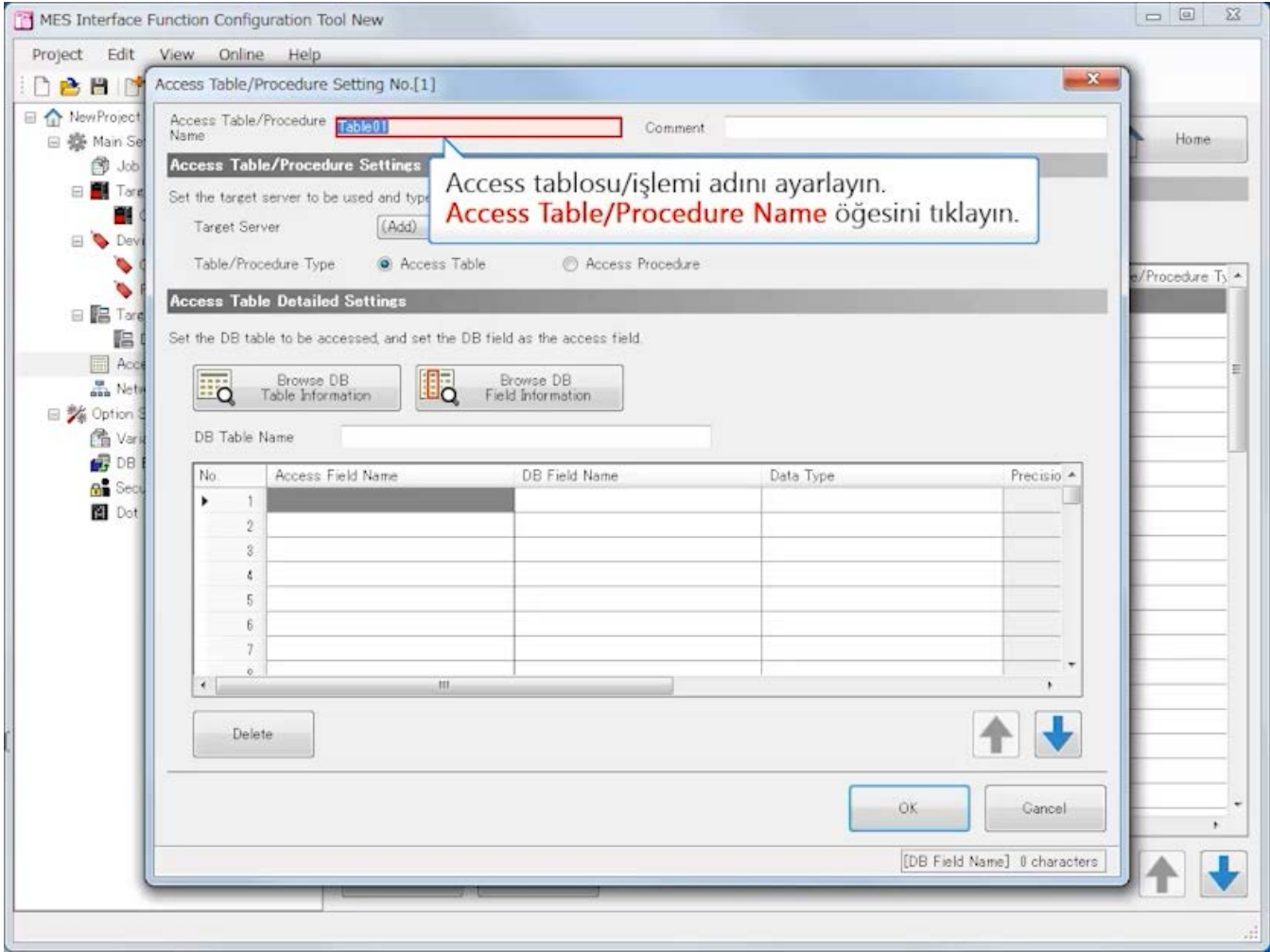
Edit seçin ve access tablosunu ve işlemini ayarlayın.
Menüdeki Edit öğesini tıklayın.

Edit Delete

↑ ↓

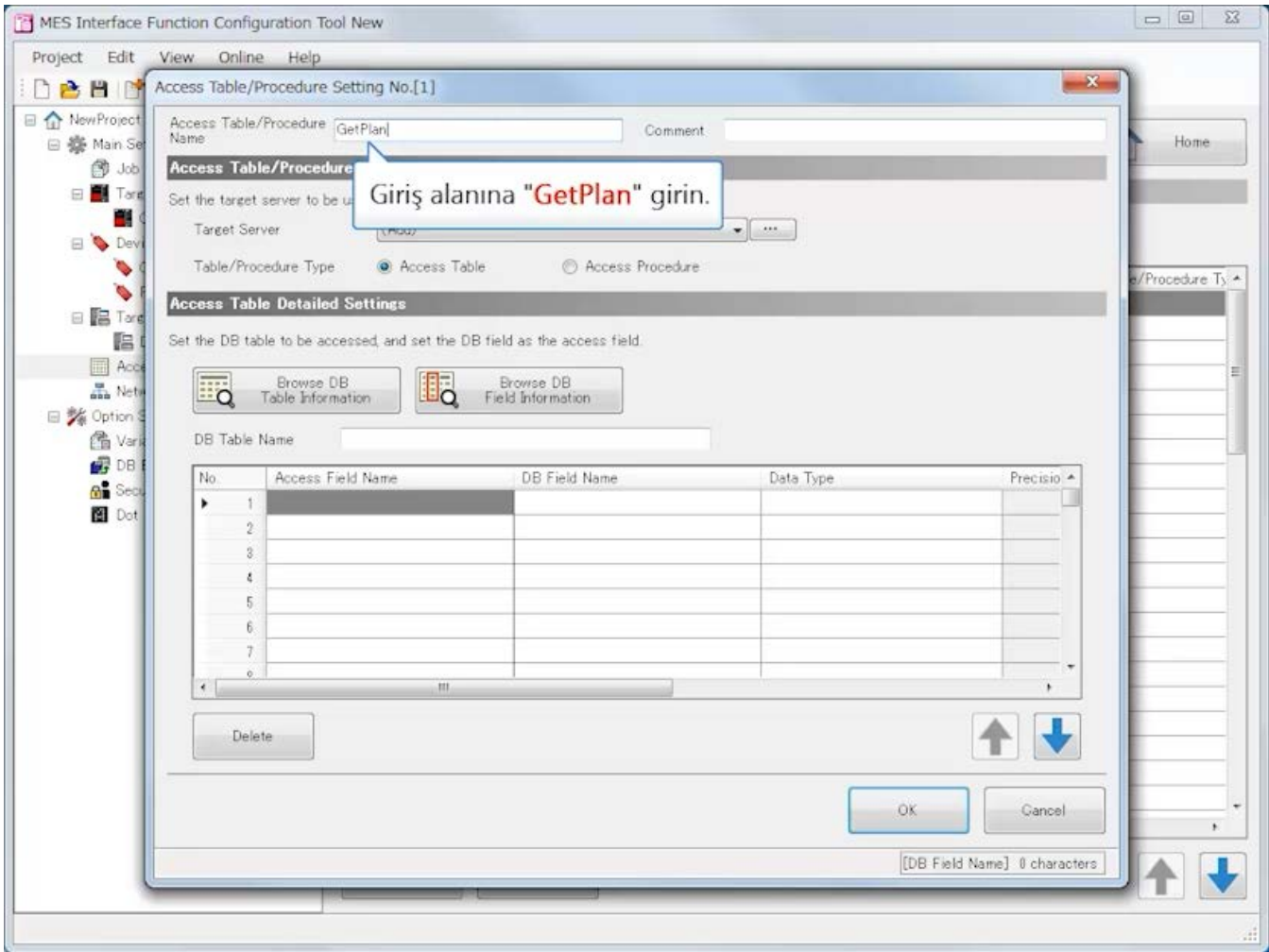
Geri

İleri



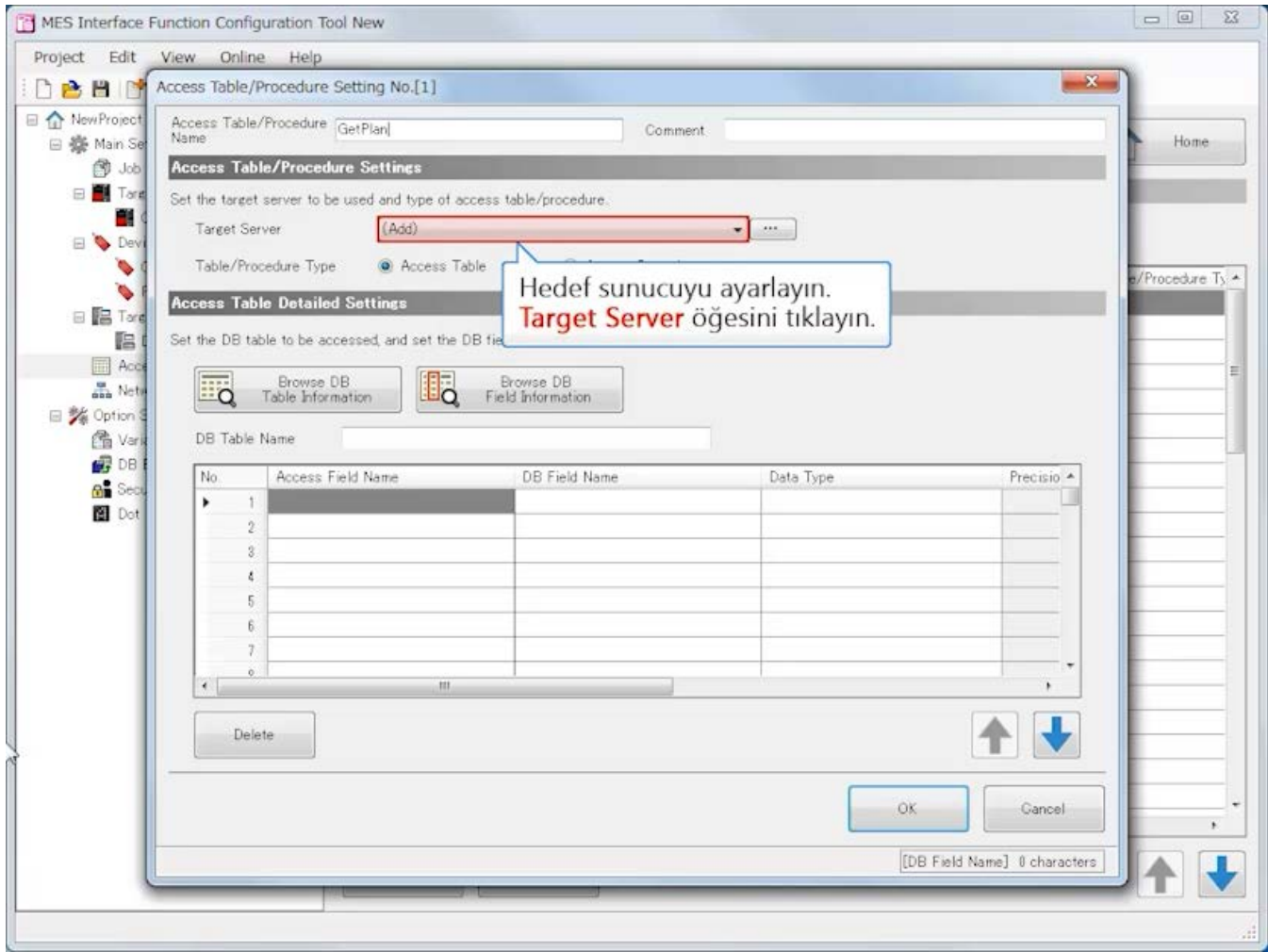
Geri

İleri



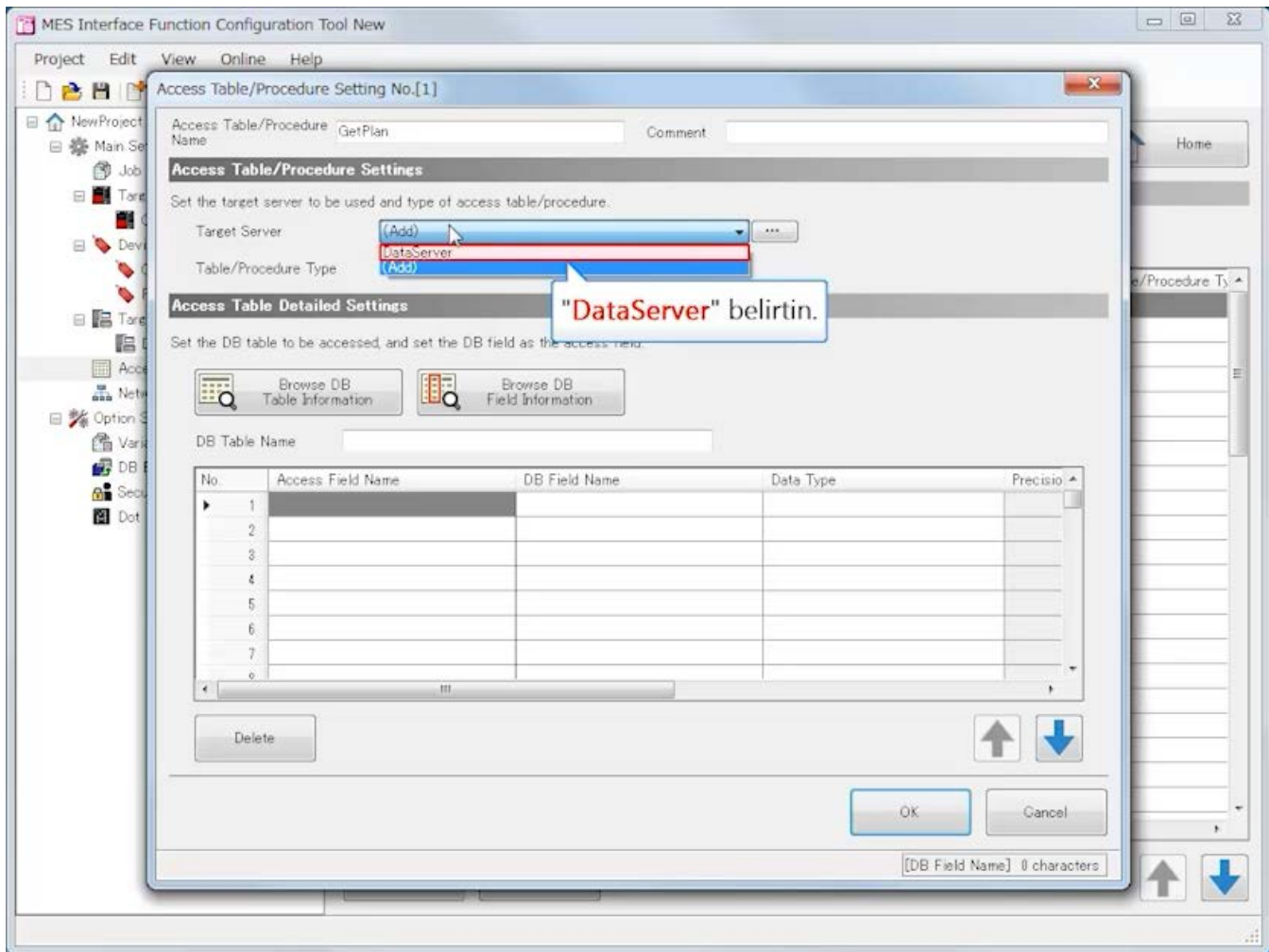
Geri

İleri



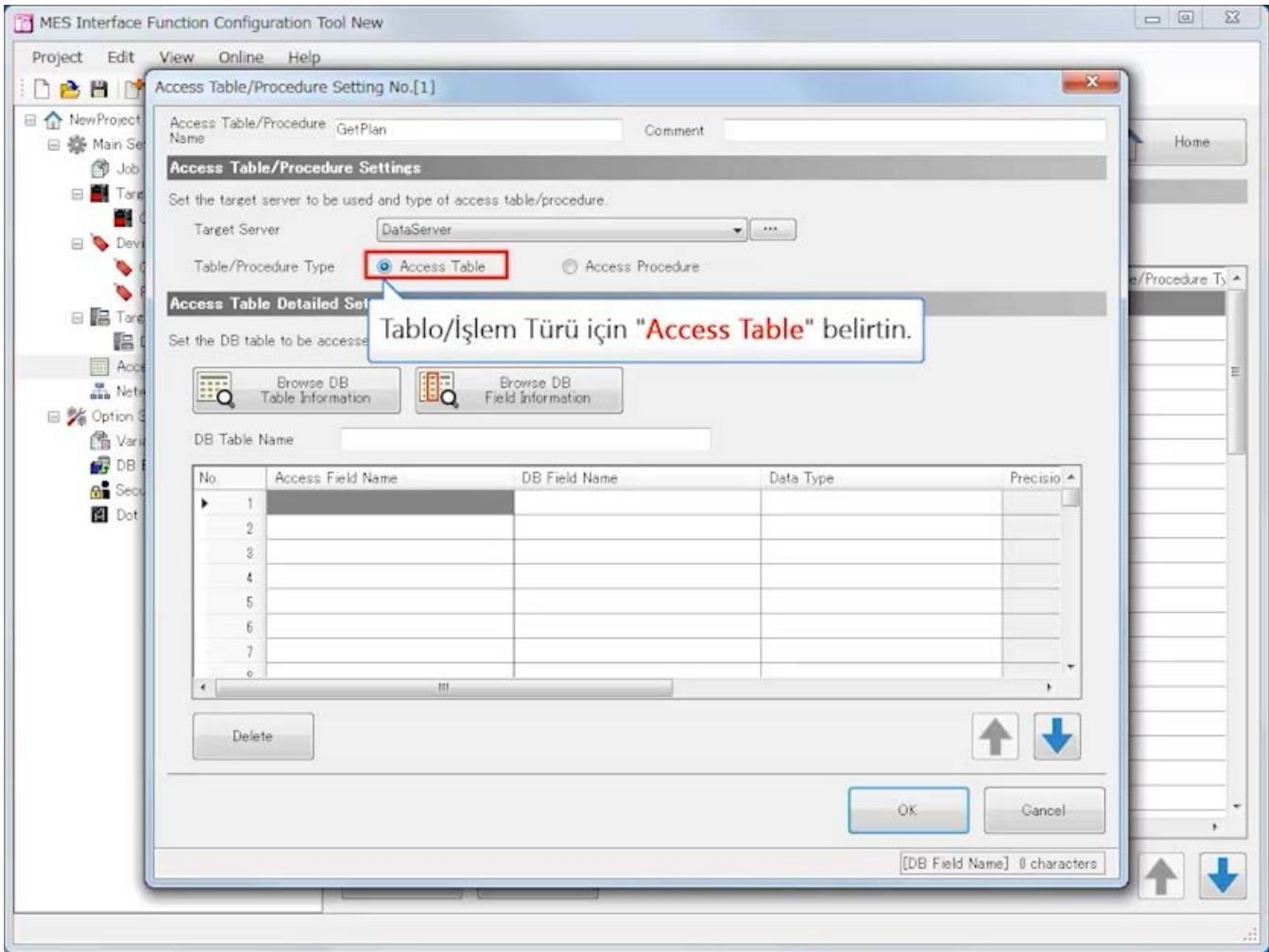
Geri

İleri



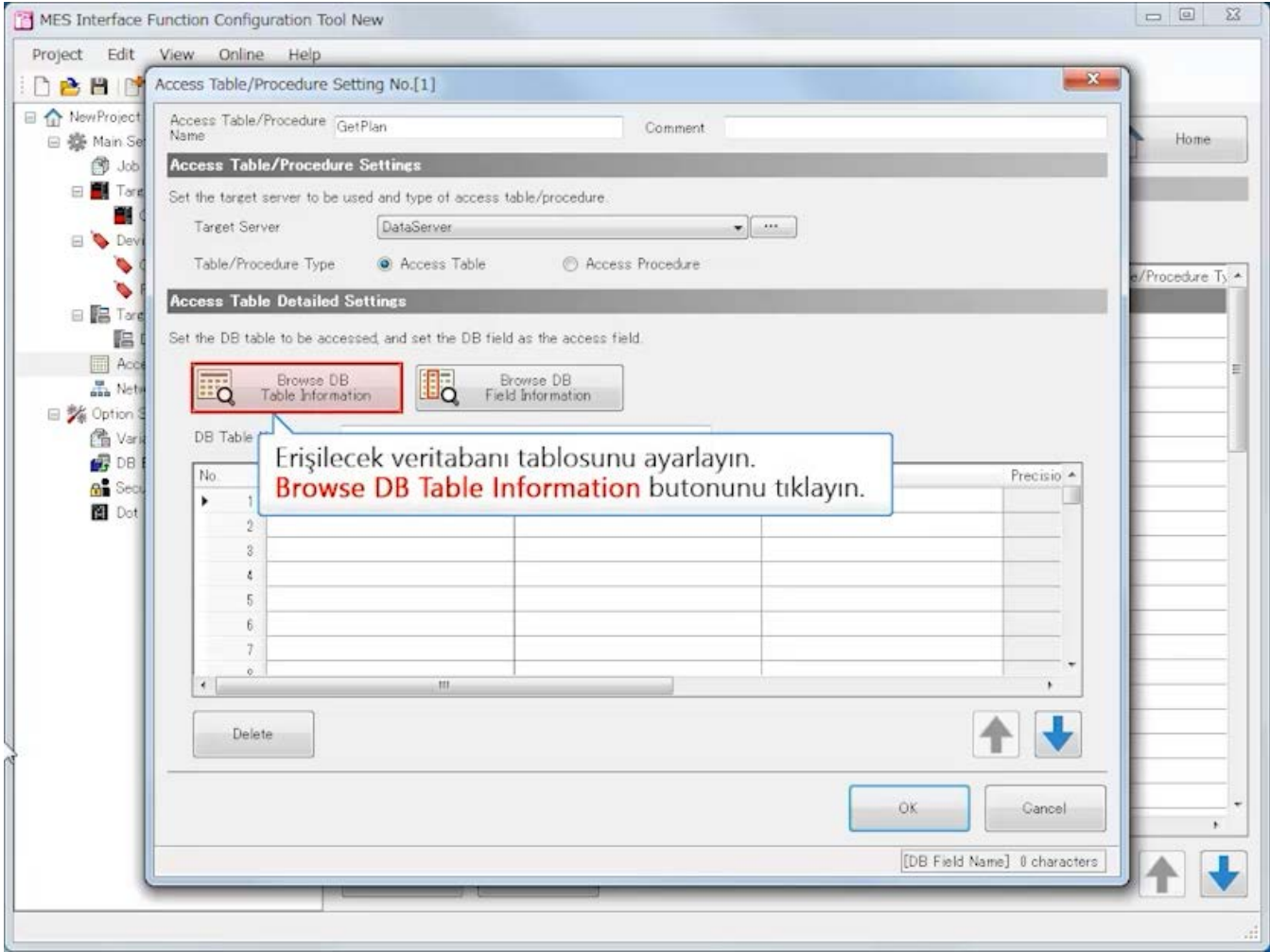
Geri

İleri



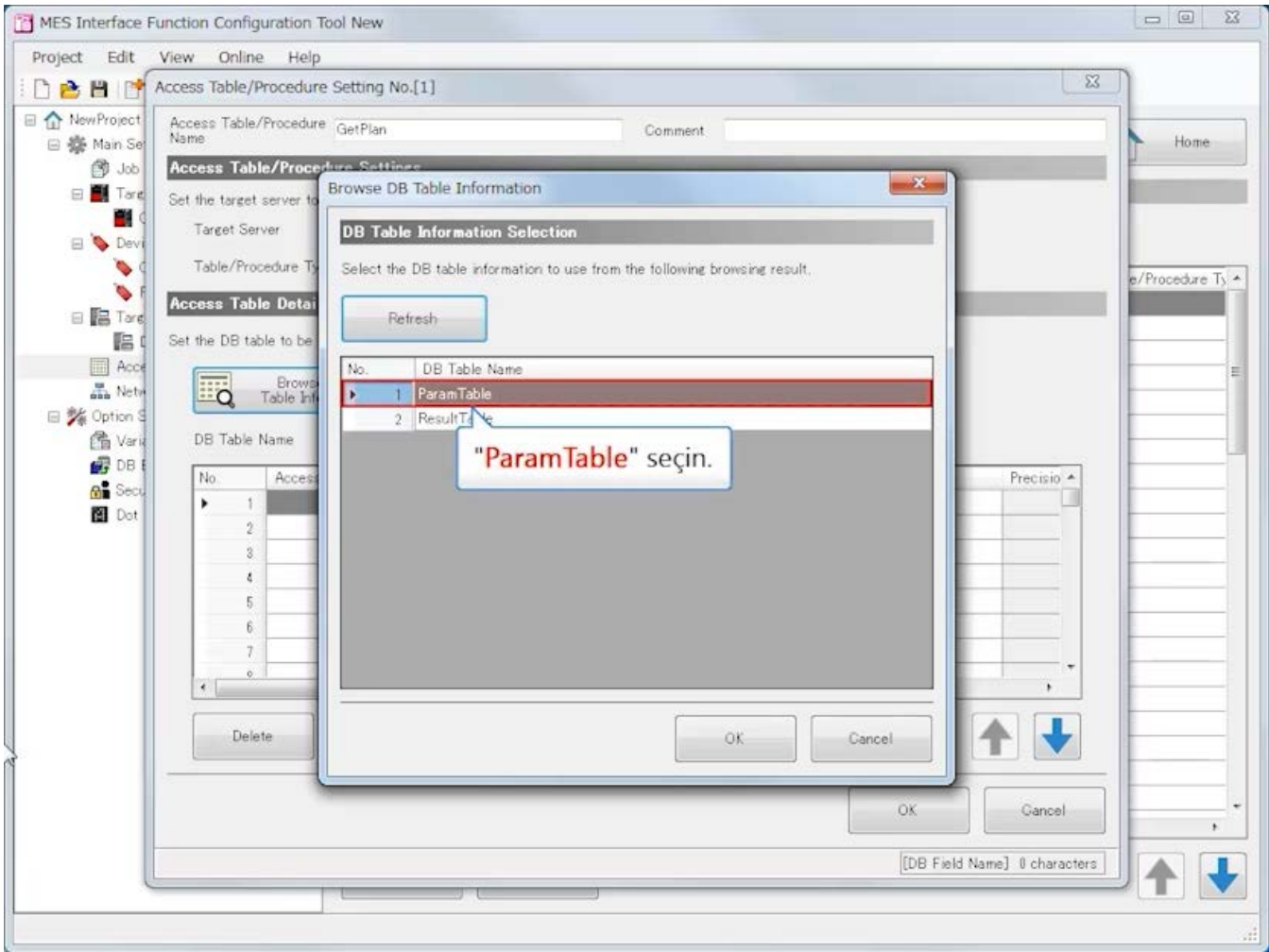
Geri

İleri



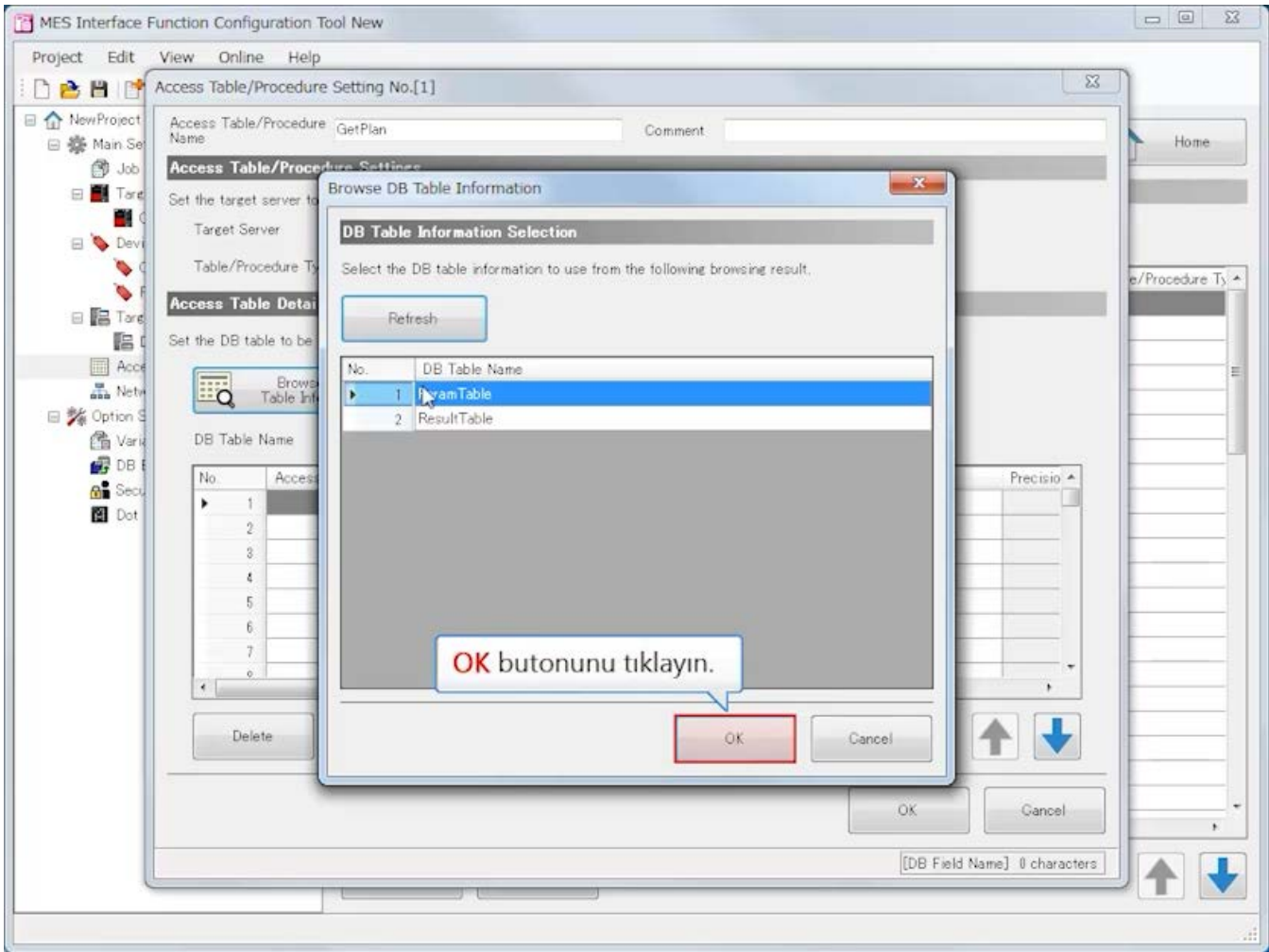
Geri

İleri



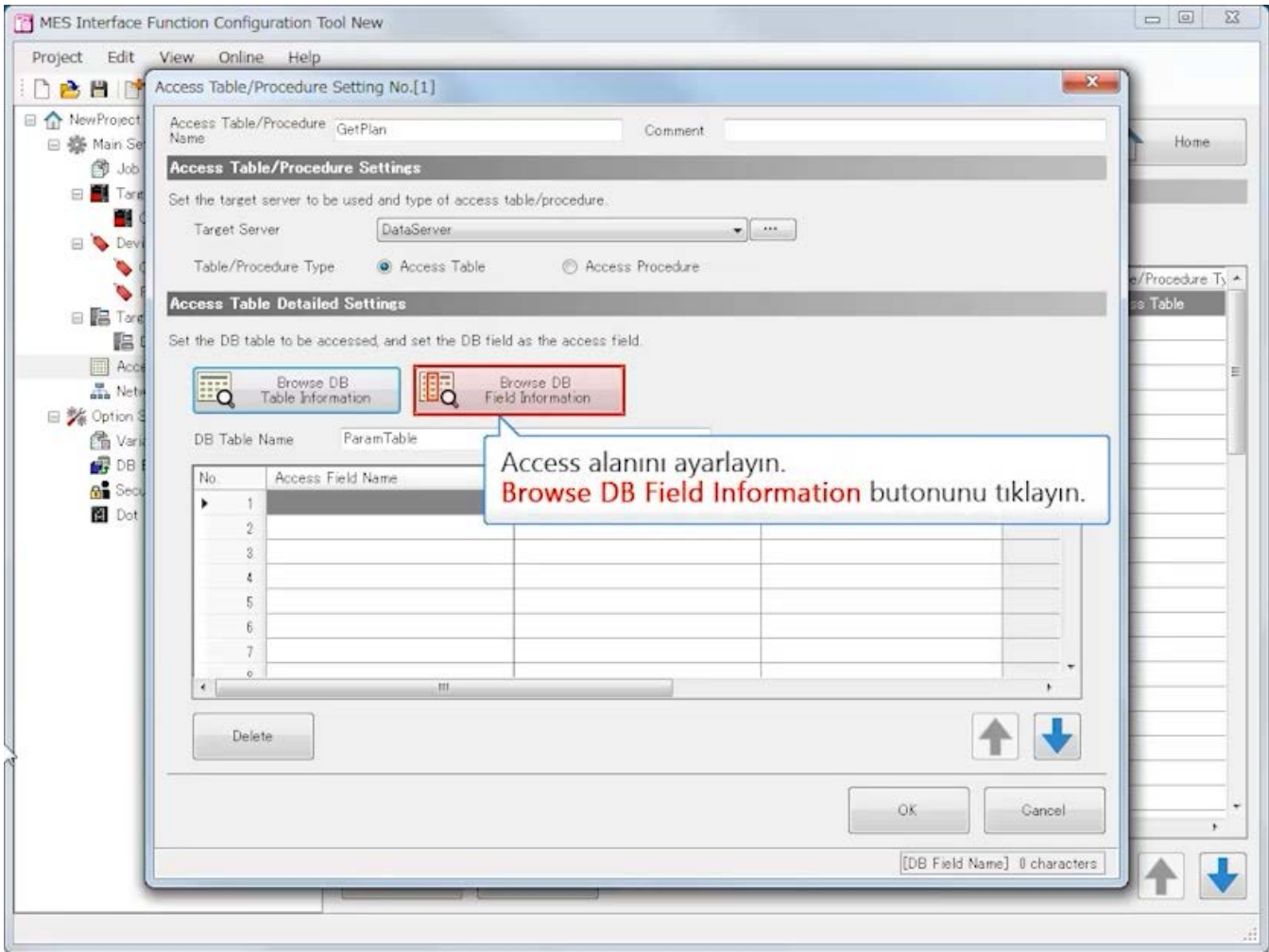
Geri

İleri



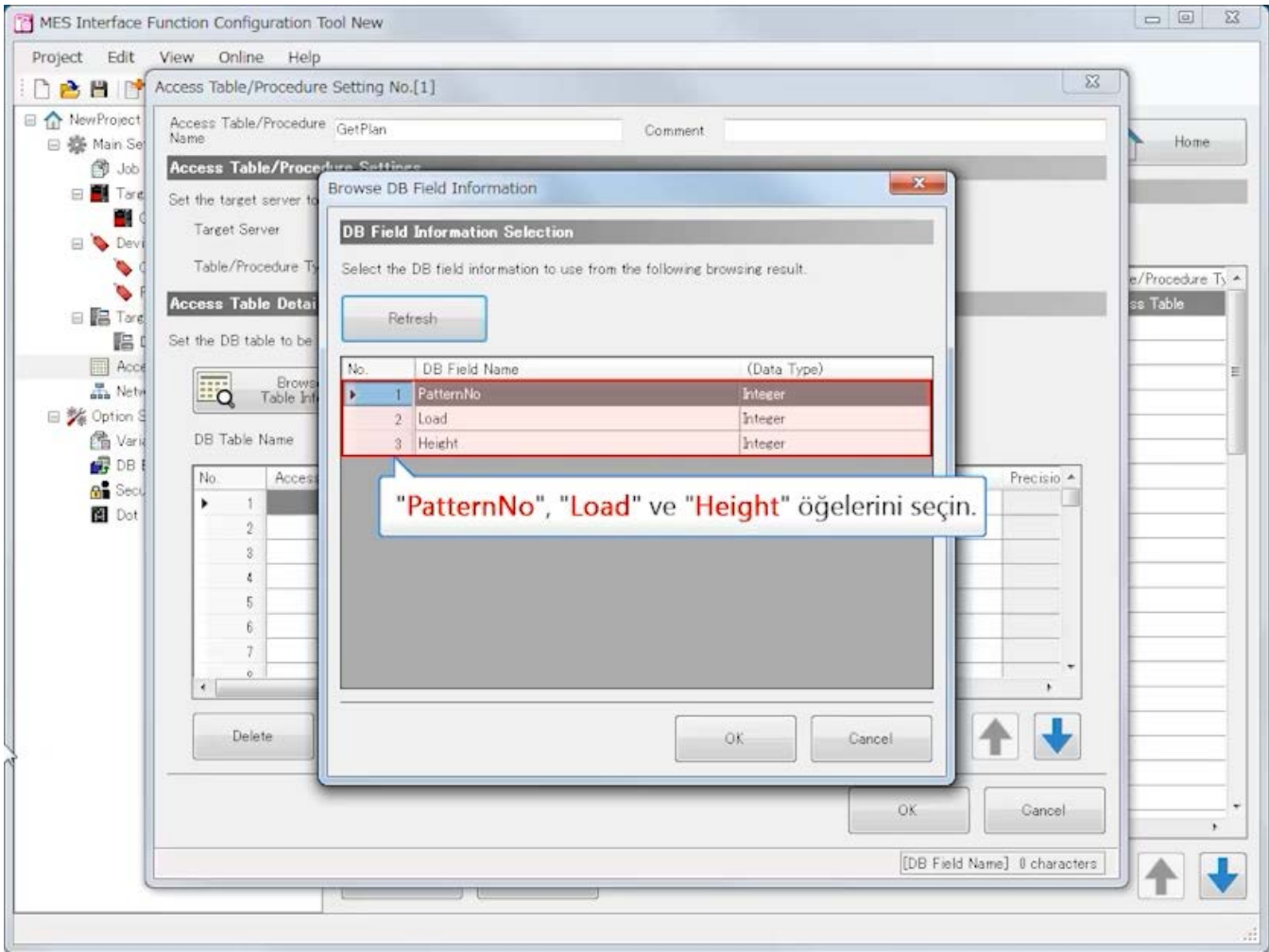
Geri

İleri



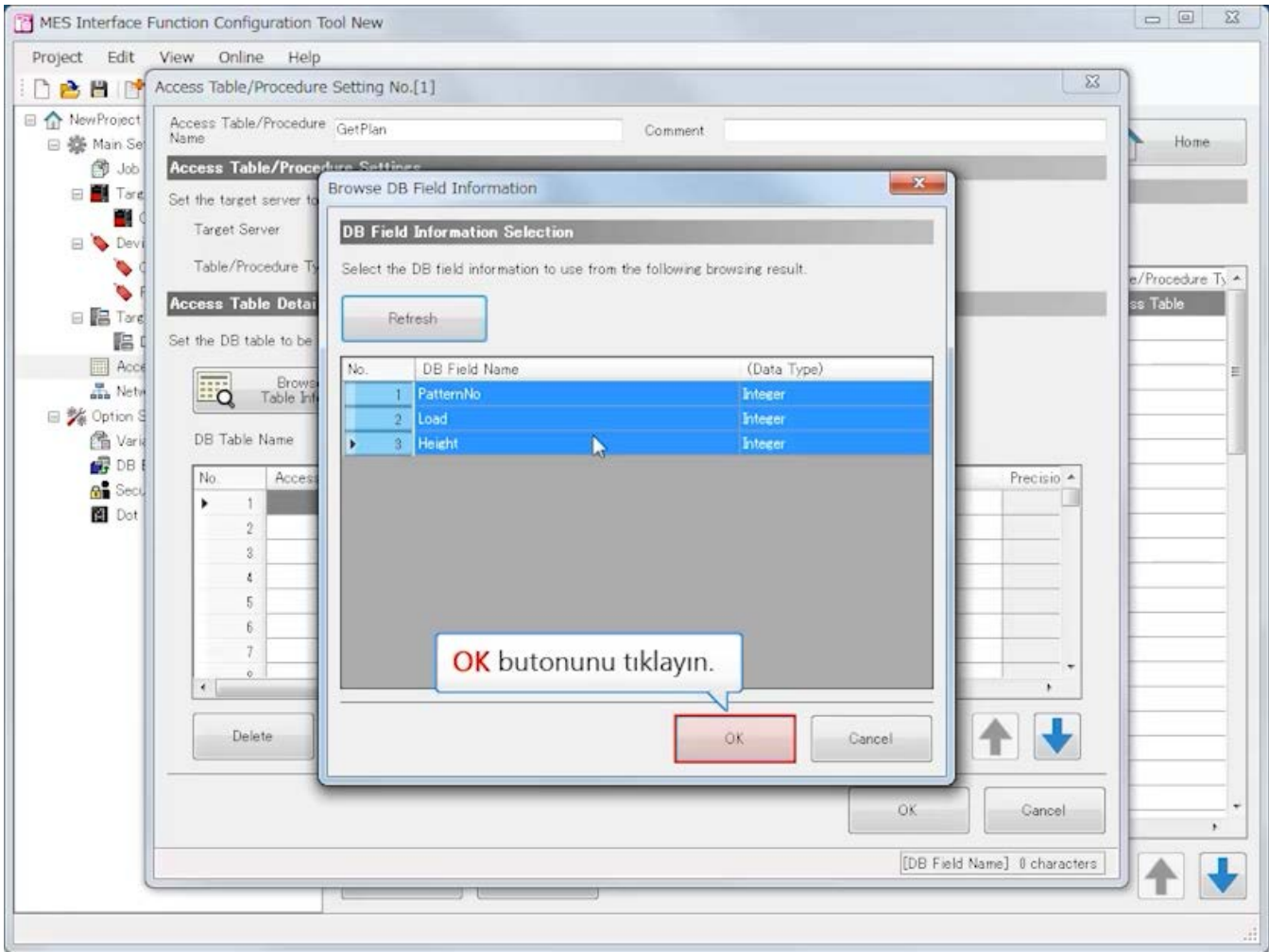
Geri

İleri



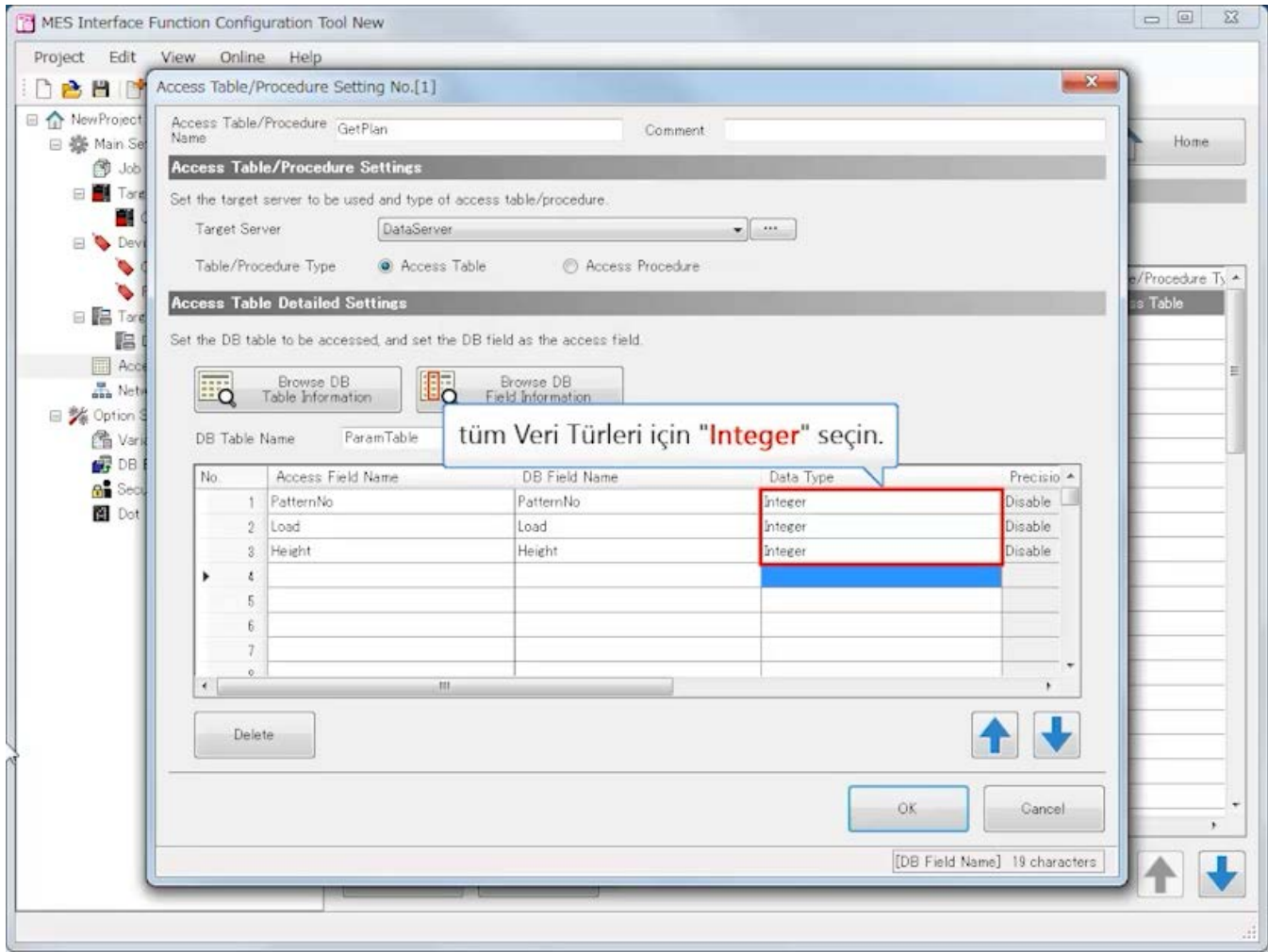
Geri

İleri



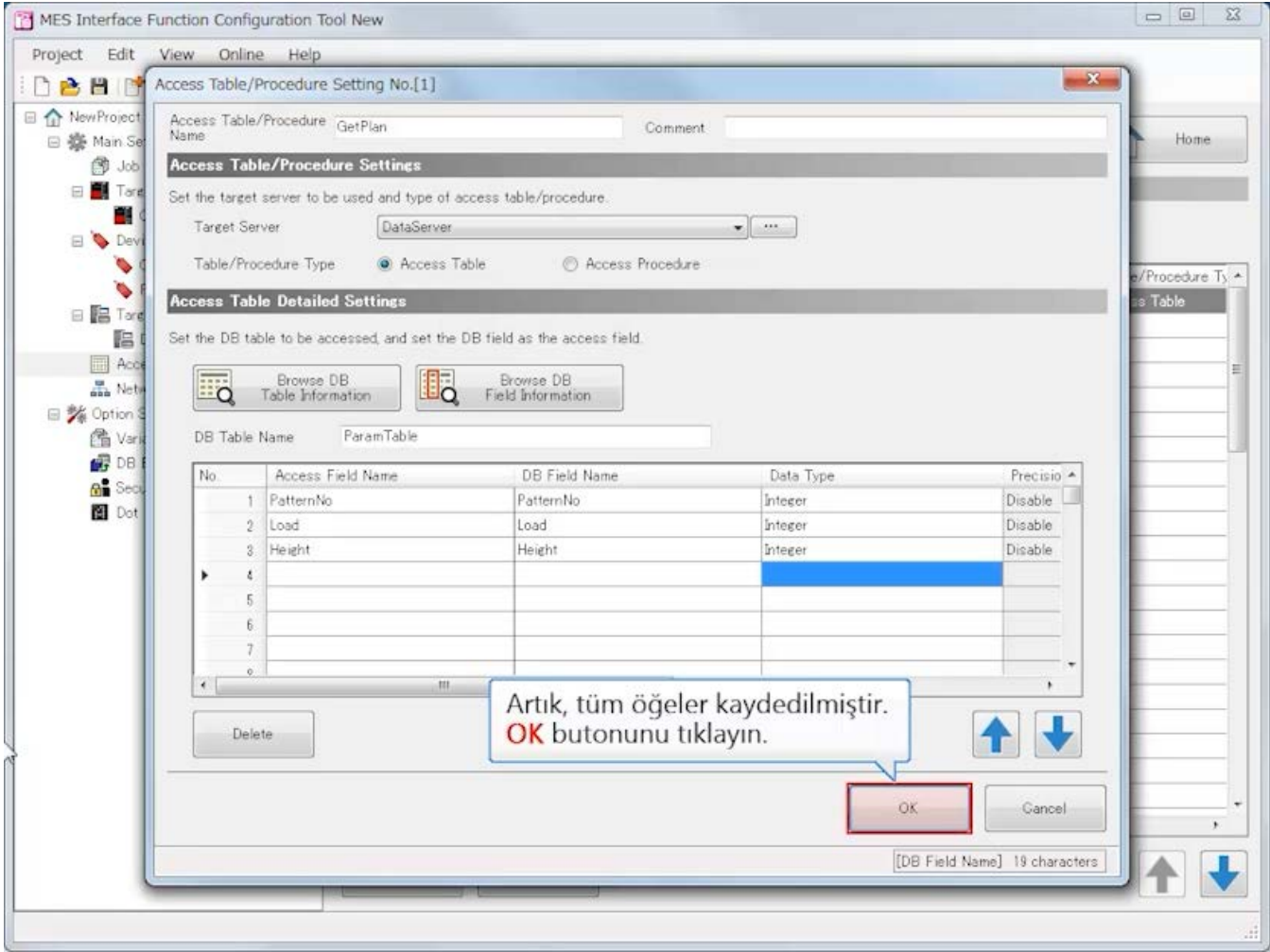
Geri

İleri



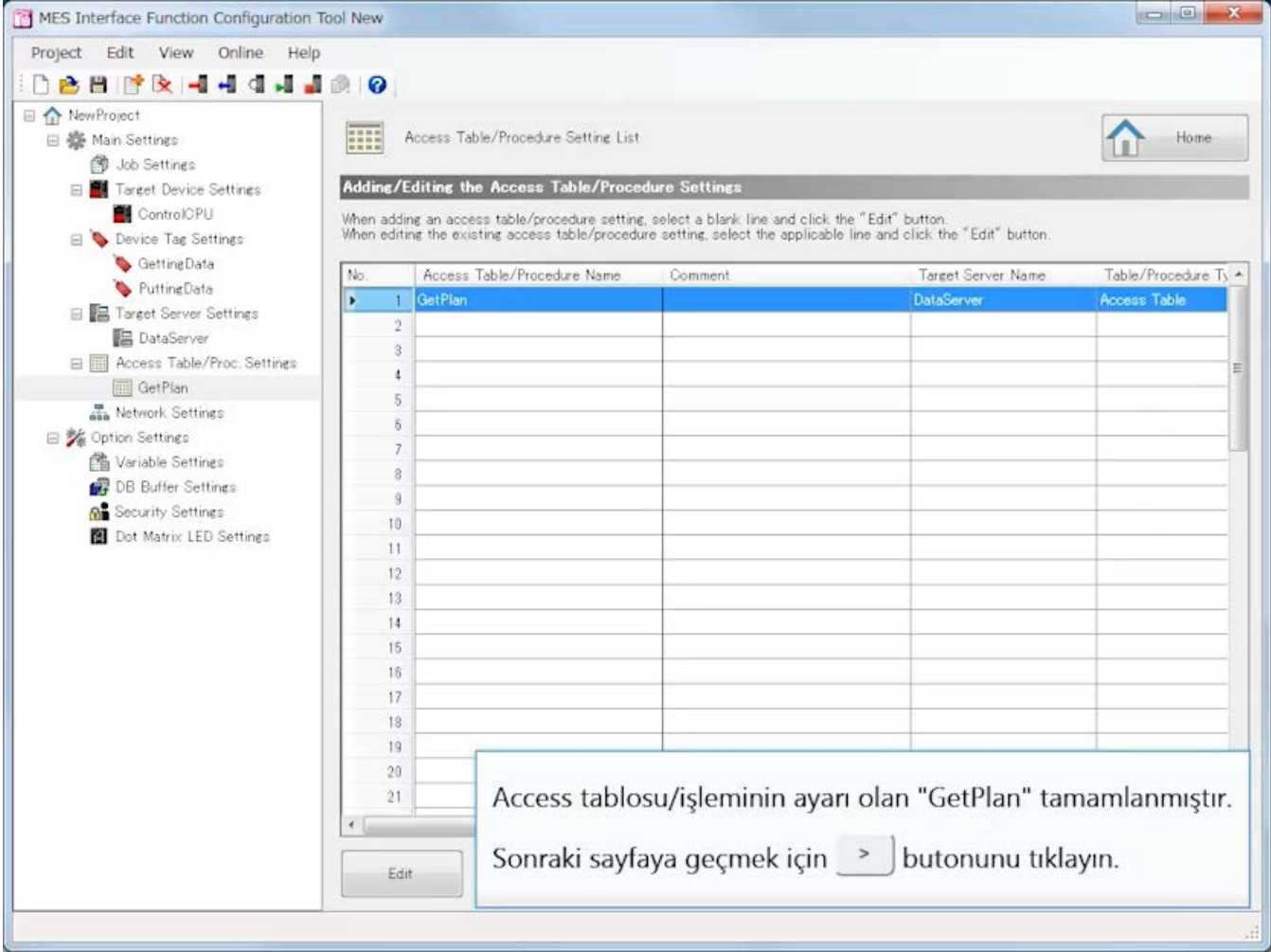
Geri

İleri



Geri

İleri



The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Access Table/Proc. Settings' and 'GetPlan' selected. The main area displays the 'Access Table/Procedure Setting List' table. The table has five columns: 'No.', 'Access Table/Procedure Name', 'Comment', 'Target Server Name', and 'Table/Procedure Ty'. The first row is highlighted in blue and contains the values: 1, GetPlan, (empty), DataServer, and Access Table. Below the table, there is an 'Edit' button. A text box at the bottom of the window contains the following text:

Access tablosu/işleminin ayarı olan "GetPlan" tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

Geri

İleri

MES Interface Function Configuration Tool E:\RnMTCPU\%a.mu2

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Target Server Name	Table/Procedure Ty
1	DataServer	Access Table
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		
13		
14		
15		
16		
17		
18		
19		
20		
21		

Edit Delete

↑ ↓

Oynat butonunu tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
 - GettingData
 - PuttingData
- Target Server Settings
 - DataServer
- Access Table/Proc. Settings
 - GetPlan
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Ty
1	GetPlan		DataServer	Access Table
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

↑ ↓

Sonra, ikinci access tablosunu/işlemini ayarlayın.
Access Table/Procedure Settings List içindeki
satır No. 2'yi sağ tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
- GettingData
- PuttingData
- Target Server Settings
- DataServer
- Access Table/Proc. Settings
- GetPlan
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit

Delete

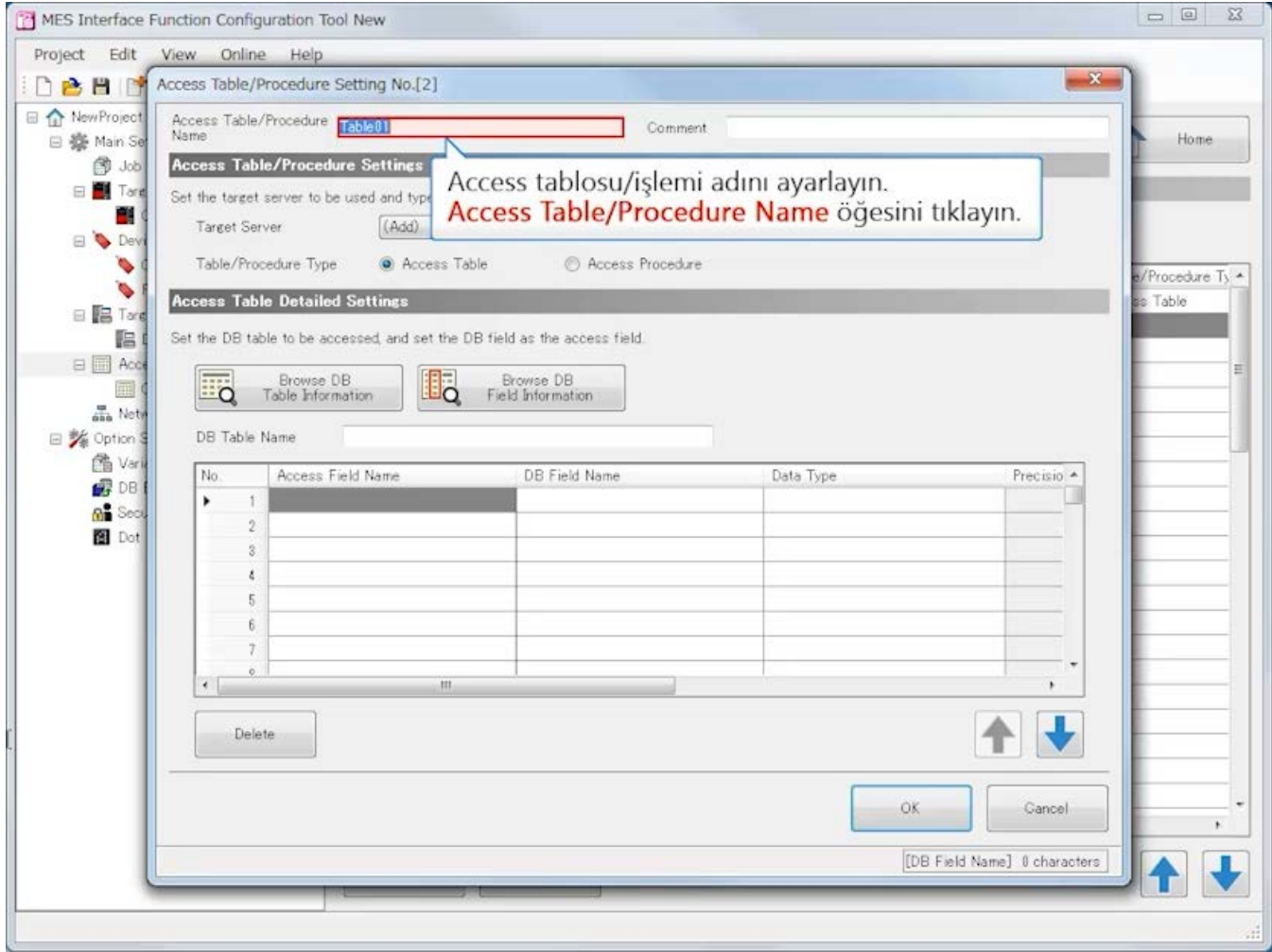
↑

↓

Edit seçin ve access tablosunu ve işlemini ayarlayın.
Menüdeki Edit öğesini tıklayın.

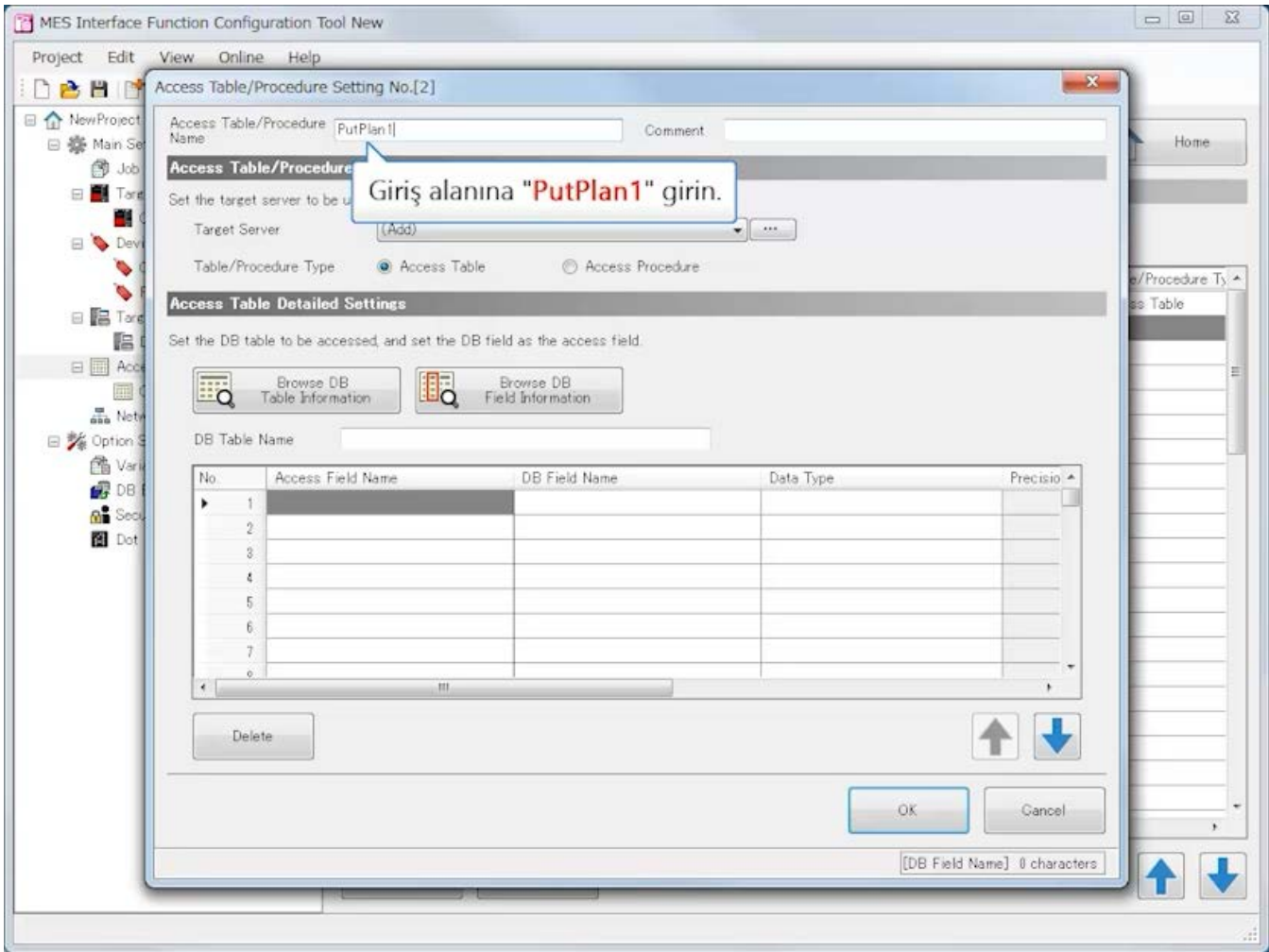
Geri

İleri



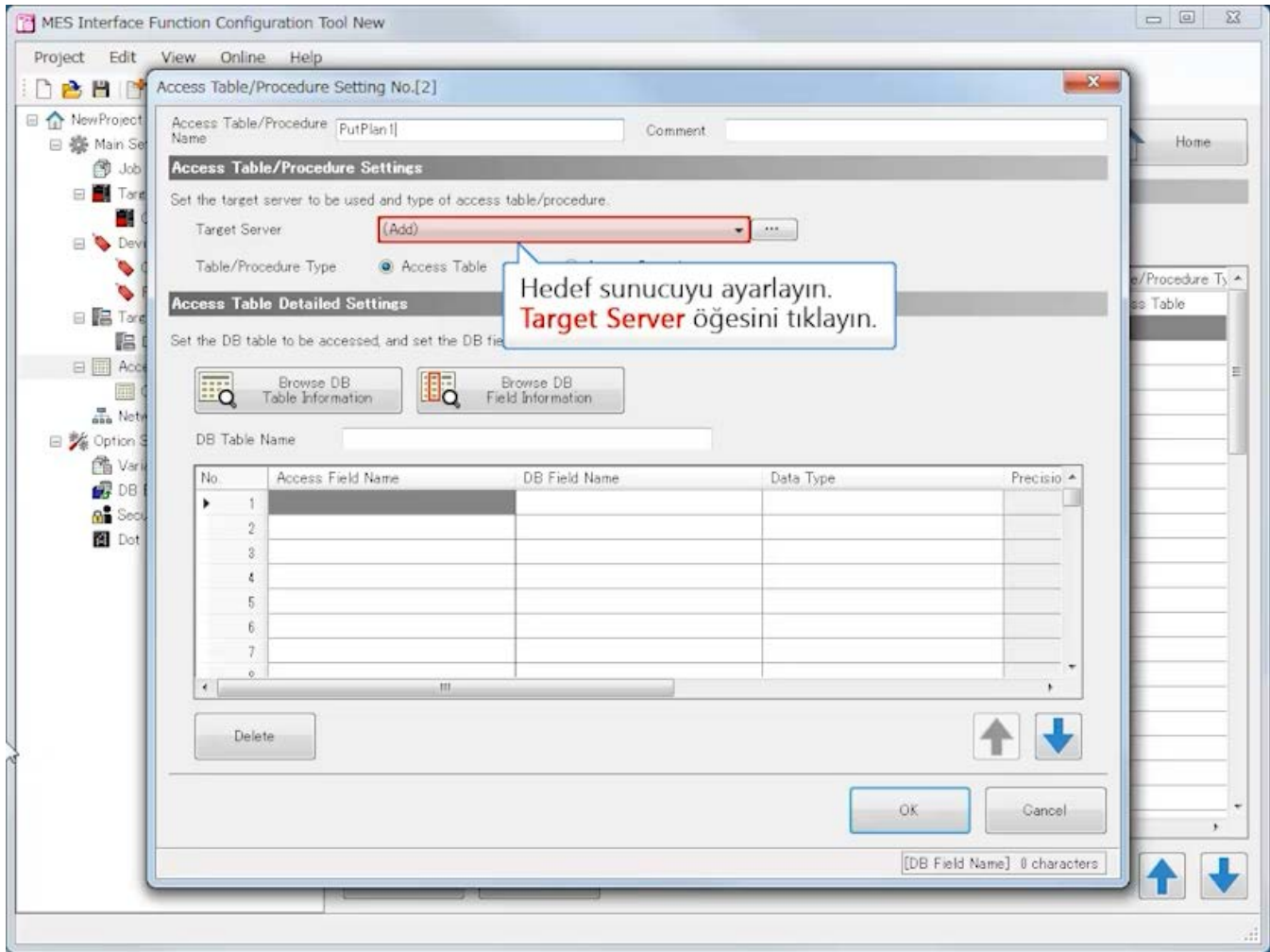
Geri

İleri



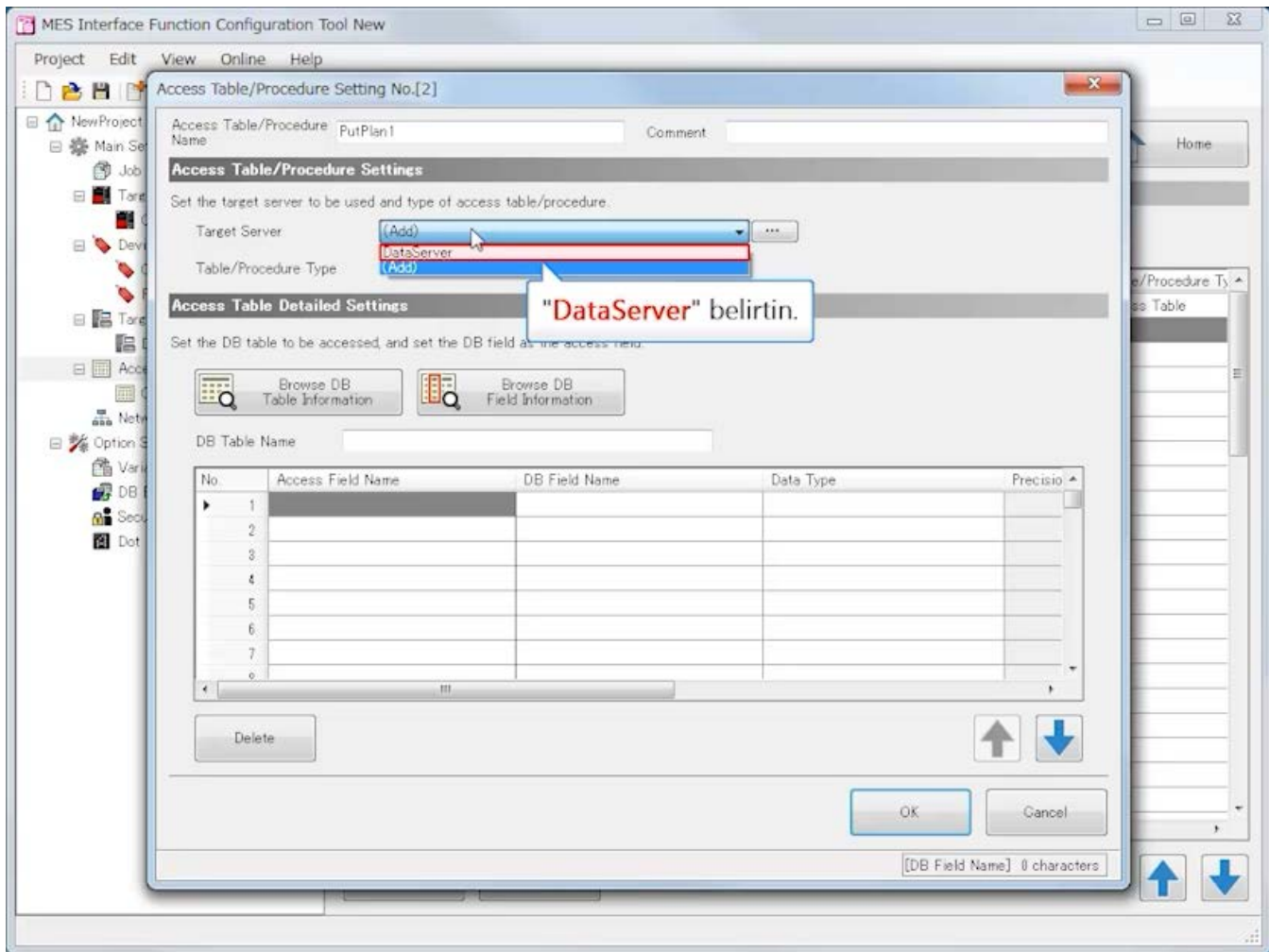
Geri

İleri



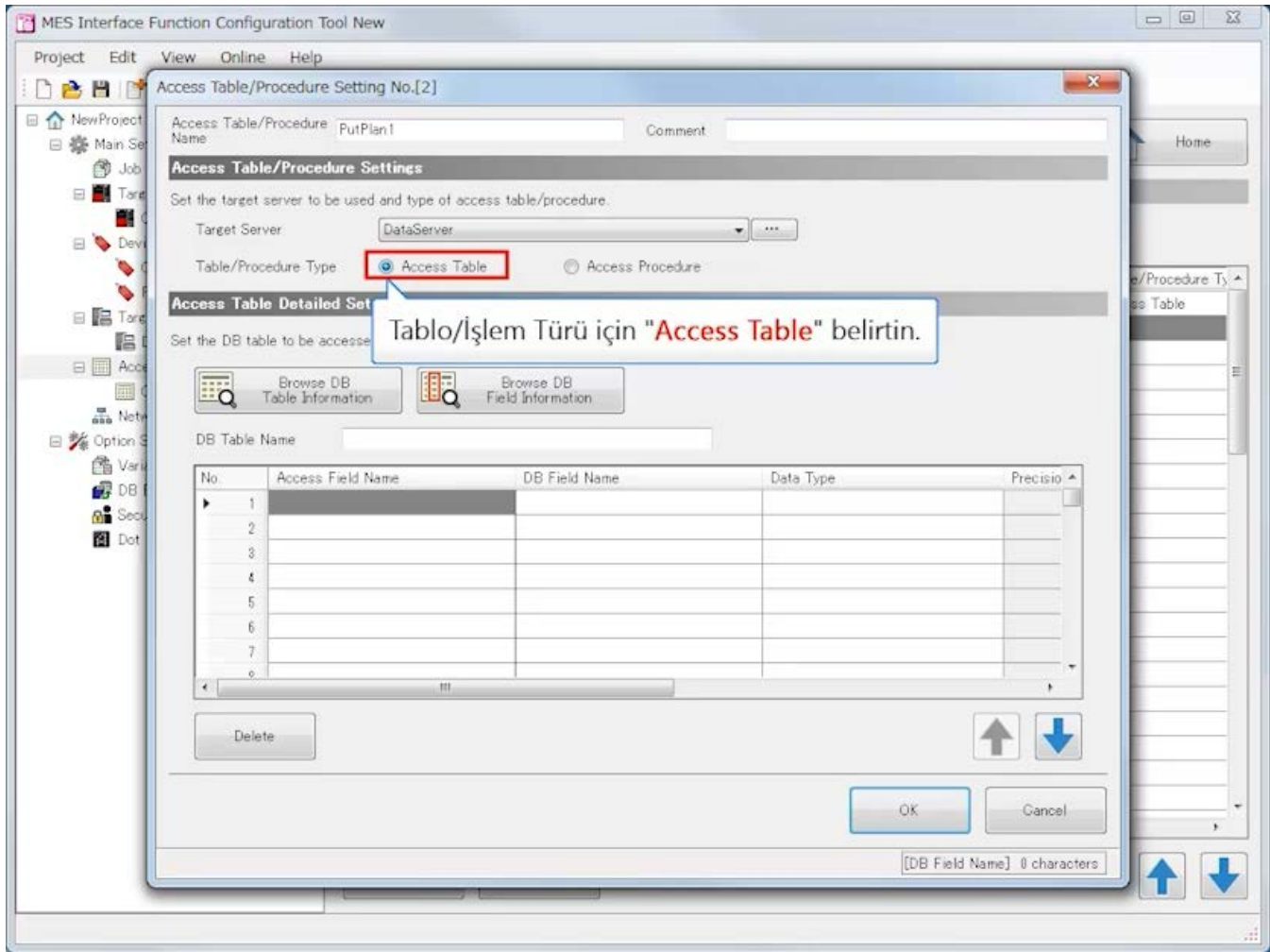
Geri

İleri



Geri

İleri



Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information Browse DB Field Information

DB Table

No. 1 2 3 4 5 6 7 8

Delete

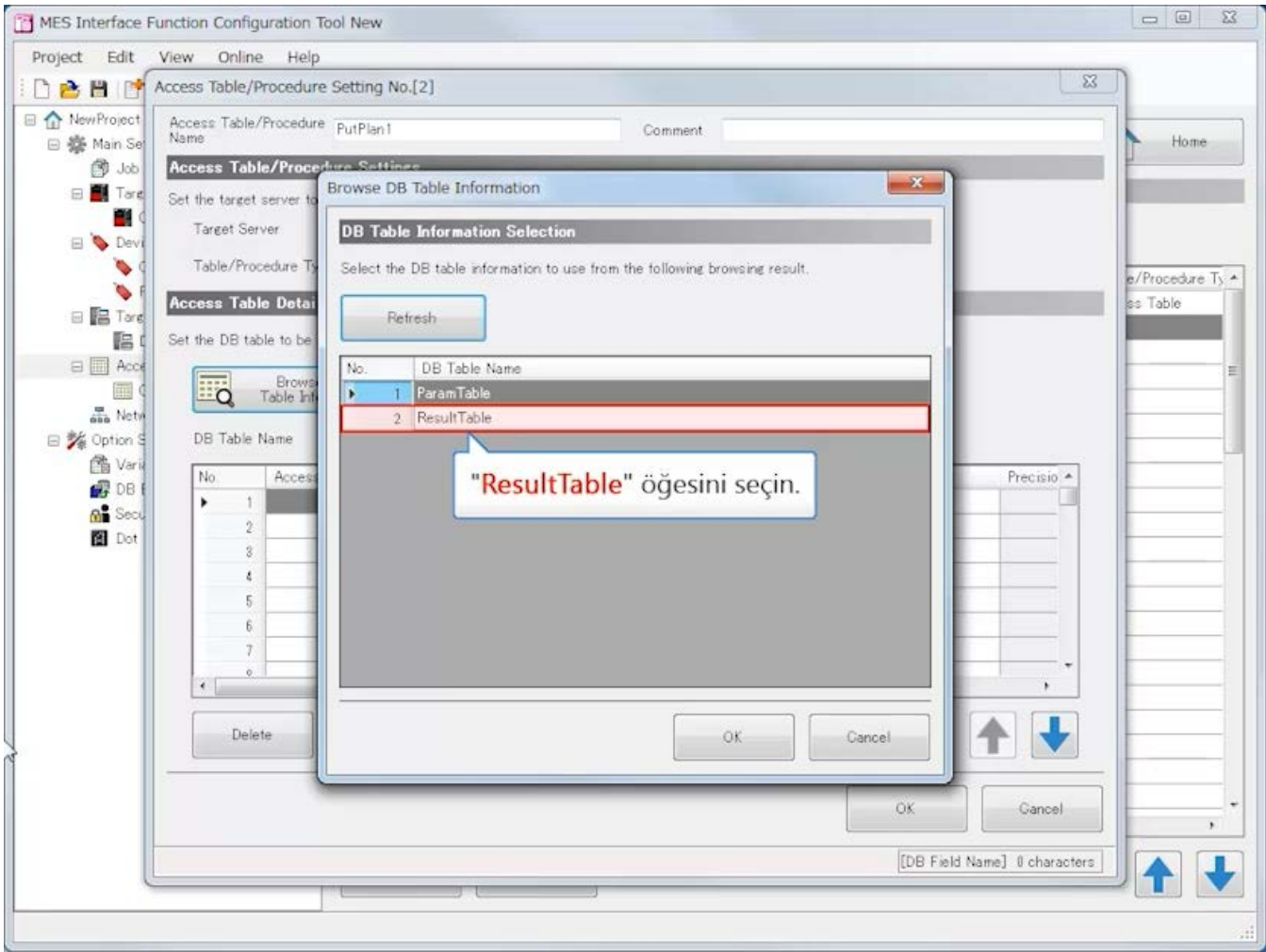
OK Cancel

[DB Field Name] 0 characters

Erişilecek veritabanı tablosunu ayarlayın.
Browse DB Table Information butonunu tıklayın.

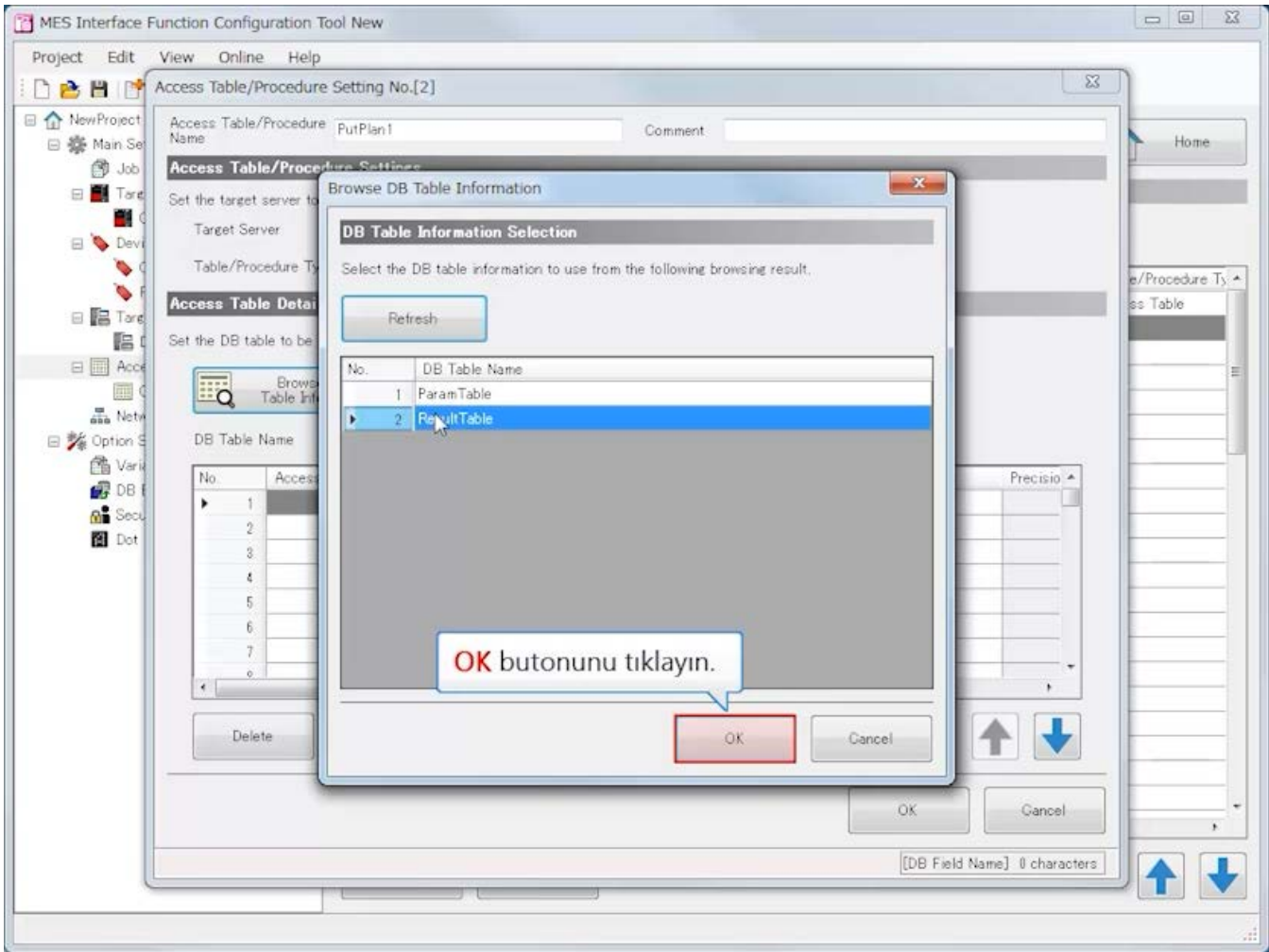
Geri

İleri



Geri

İleri



Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information Browse DB Field Information

DB Table Name: ResultTable

No.	Access Field Name
1	
2	
3	
4	
5	
6	
7	
8	

Delete

OK Cancel

[DB Field Name] 0 characters

Access alanını ayarlayın.
Browse DB Field Information butonunu tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

Set the target server to use

Target Server:

Table/Procedure Type:

Access Table Details

Set the DB table to be used

DB Table Name:

DB Table Info

No. Access

1

2

3

4

5

6

7

8

Delete

Browse DB Field Information

DB Field Information Selection

Select the DB field information to use from the following browsing result.

Refresh

No.	DB Field Name	(Data Type)
1	PatternNo	Integer
2	LoadResult	Integer
3	HeightResult	Integer
4	StartTime	Date and Time [Without Time]
5	EndTime	Date and Time [Without Time]

"PatternNo", "LoadResult", "HeightResult" ve "StartTime" öğelerini seçin.

OK Cancel

OK Cancel

[DB Field Name] 0 characters

Geri

İleri

The screenshot shows the 'Browse DB Field Information' dialog box in the MES Interface Function Configuration Tool. The dialog is titled 'Browse DB Field Information' and contains a section for 'DB Field Information Selection'. It instructs the user to 'Select the DB field information to use from the following browsing result.' Below this instruction is a 'Refresh' button and a table of database fields.

No.	DB Field Name	(Data Type)
1	PatternNo	Integer
2	LoadResult	Integer
3	HeightResult	Integer
4	StartTime	Date and Time [Without Time
5	EndTime	Date and Time [Without Time

A callout box with a red border and a white background points to the 'OK' button, containing the text 'OK butonunu tıklayın.' (Click the OK button).

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB Field Name, Access Field Name, and Data Type.

DB

"PatternNo", "LoadResult" ve "HeightResult" Veri Türü olarak "Integer" seçin ve "StartTime" Veri Türü olarak "Date and Time [Without Time Zone]" seçin.

No	Access Field Name	DB Field Name	Data Type	Precisio
1	PatternNo	PatternNo	Integer	Disable
2	LoadResult	LoadResult	Integer	Disable
3	HeightResult	HeightResult	Integer	Disable
4	StartTime	StartTime	Date and Time [Without Time Zone]	Disable
5				
6				
7				
8				

Delete

OK Cancel

[DB Field Name] 40 characters

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information Browse DB Field Information

DB Table Name: ResultTable

No.	Access Field Name	DB Field Name	Data Type	Precisio
1	PatternNo	PatternNo	Integer	Disable
2	LoadResult	LoadResult	Integer	Disable
3	HeightResult	HeightResult	Integer	Disable
4	StartTime	StartTime	Date and Time [Without Time Zone]	Disable
5				
6				
7				
8				

Delete

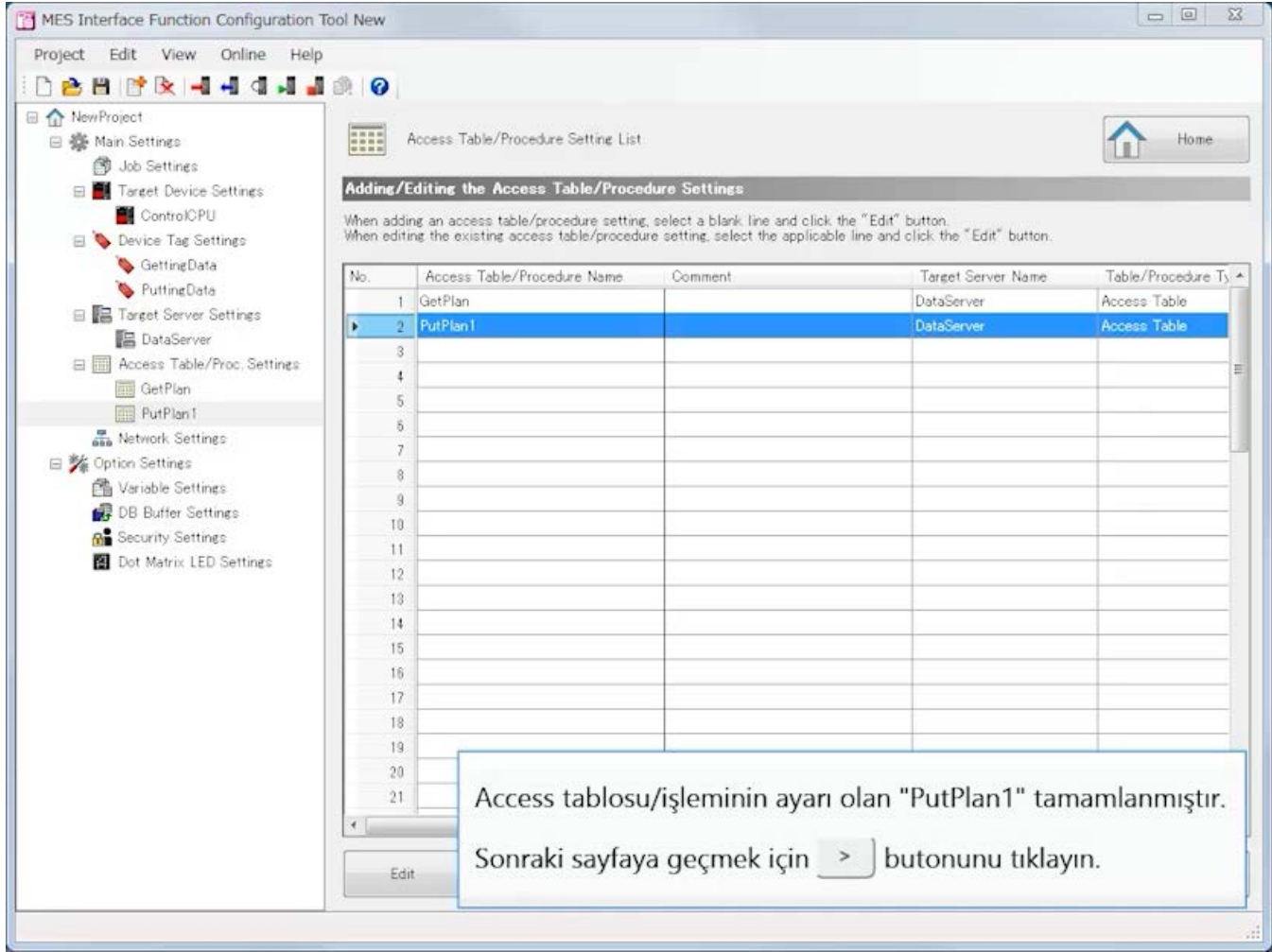
Artık, tüm öğeler kaydedilmiştir.
OK butonunu tıklayın.

OK Cancel

[DB Field Name] 40 characters

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit

Access tablosu/işleminin ayarı olan "PutPlan1" tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

Geri

İleri

MES Interface Function Configuration Tool E:\RnMTCPU\%a.mu2

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
 - ControlCPU
- Device Tag Settings
 - GettingData
 - PuttingData
- Target Server Settings
 - DataServer
- Access Table/Proc. Settings
 - GetPlan
 - PutPlan I
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Table/Procedure Name	Target Server Name	Table/Procedure Type
2	PutPlan I	DataServer	Access Table
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
14			
15			
16			
17			
18			
19			
20			
21			

Edit Delete

↑ ↓

Oynat butonunu tıklayın.

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

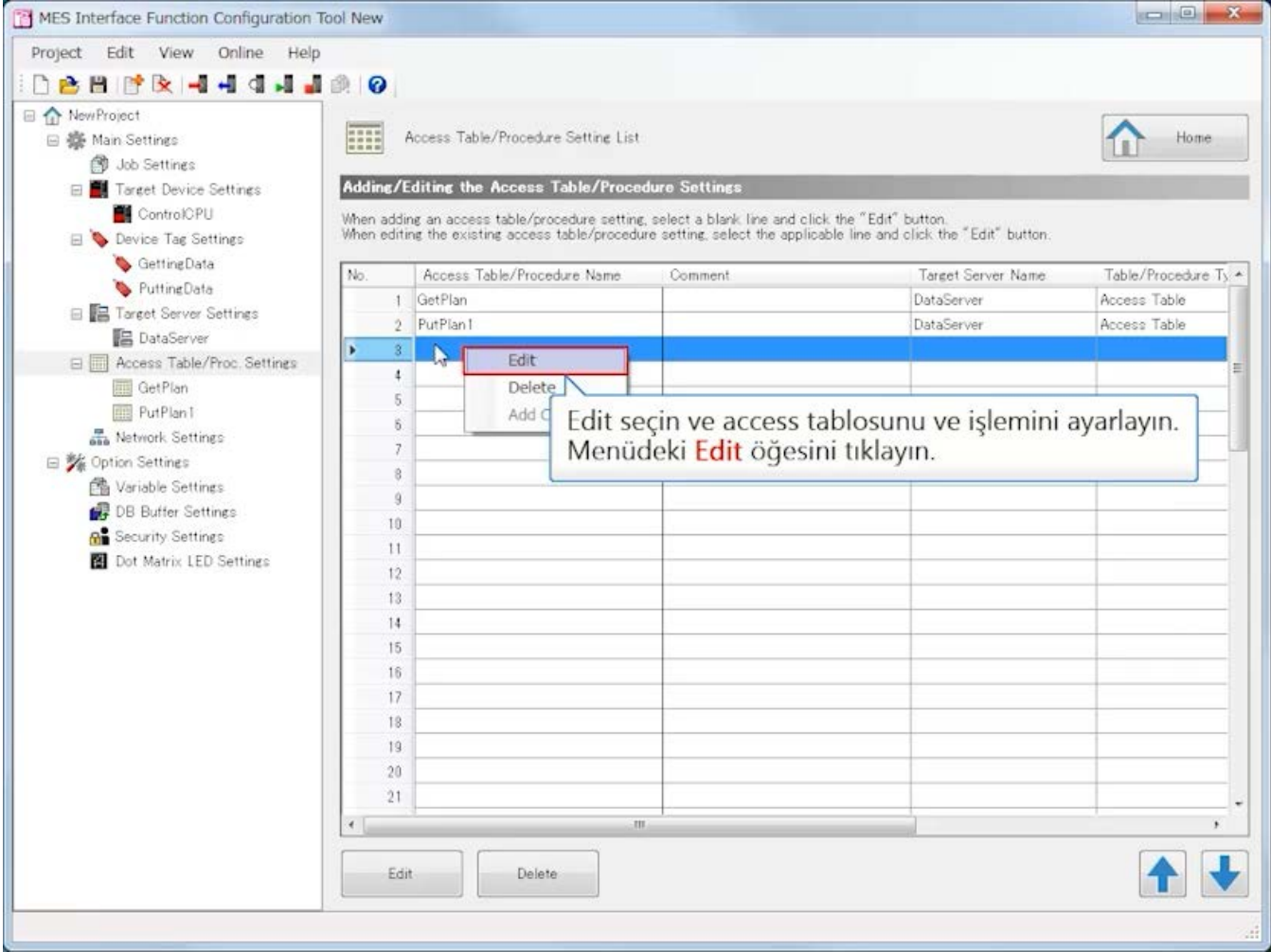
Edit Delete

↑ ↓

Sonra, üçüncü access tablosunu/işlemini ayarlayın.
Access Table/Procedure Settings List içindeki satır No. 3'ü sağ tıklayın.

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2	PutPlanI		DataServer	Access Table
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit
Delete
Add C

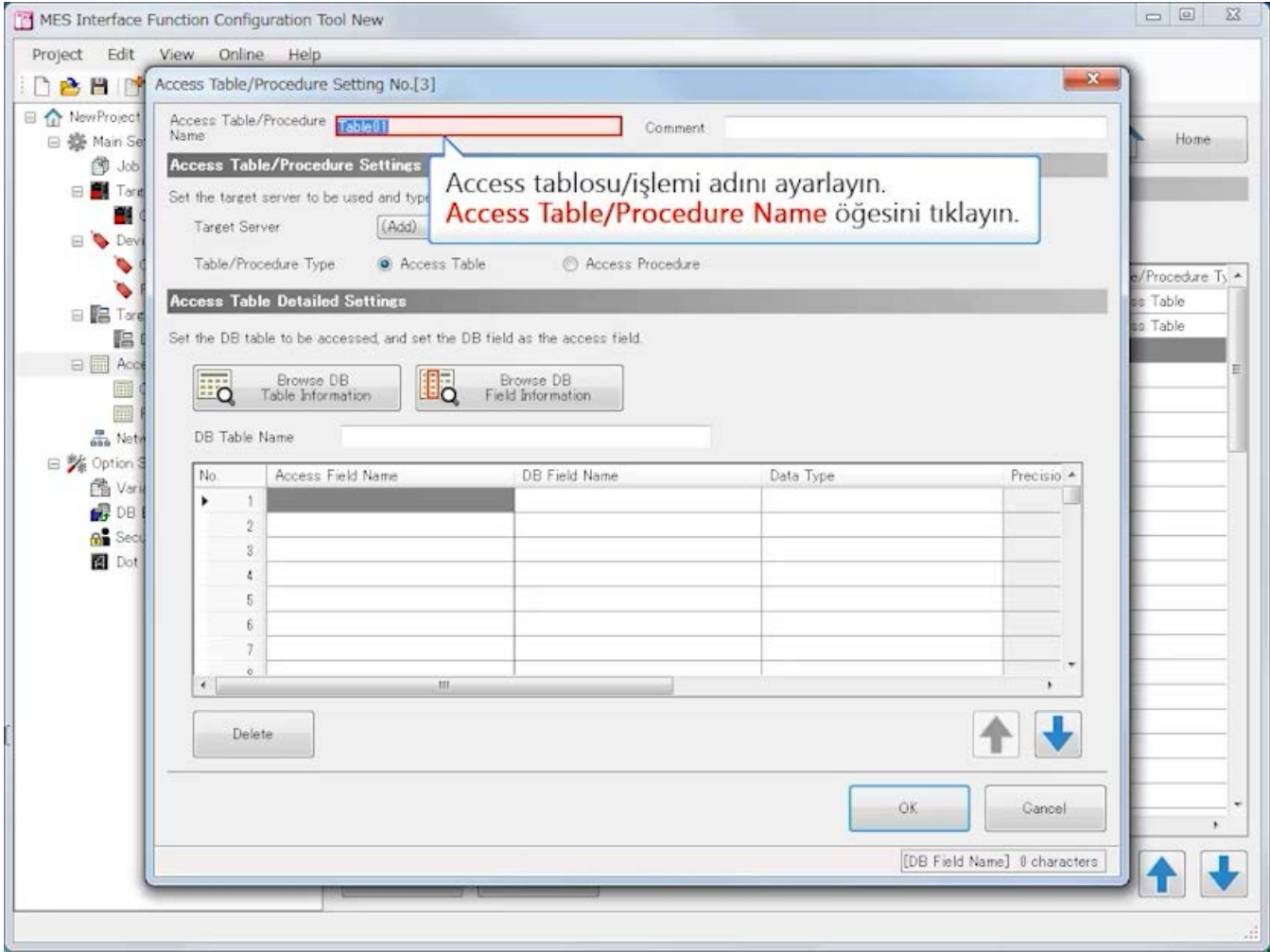
Edit seçin ve access tablosunu ve işlemini ayarlayın.
Menüdeki **Edit** öğesini tıklayın.

Edit Delete

↑ ↓

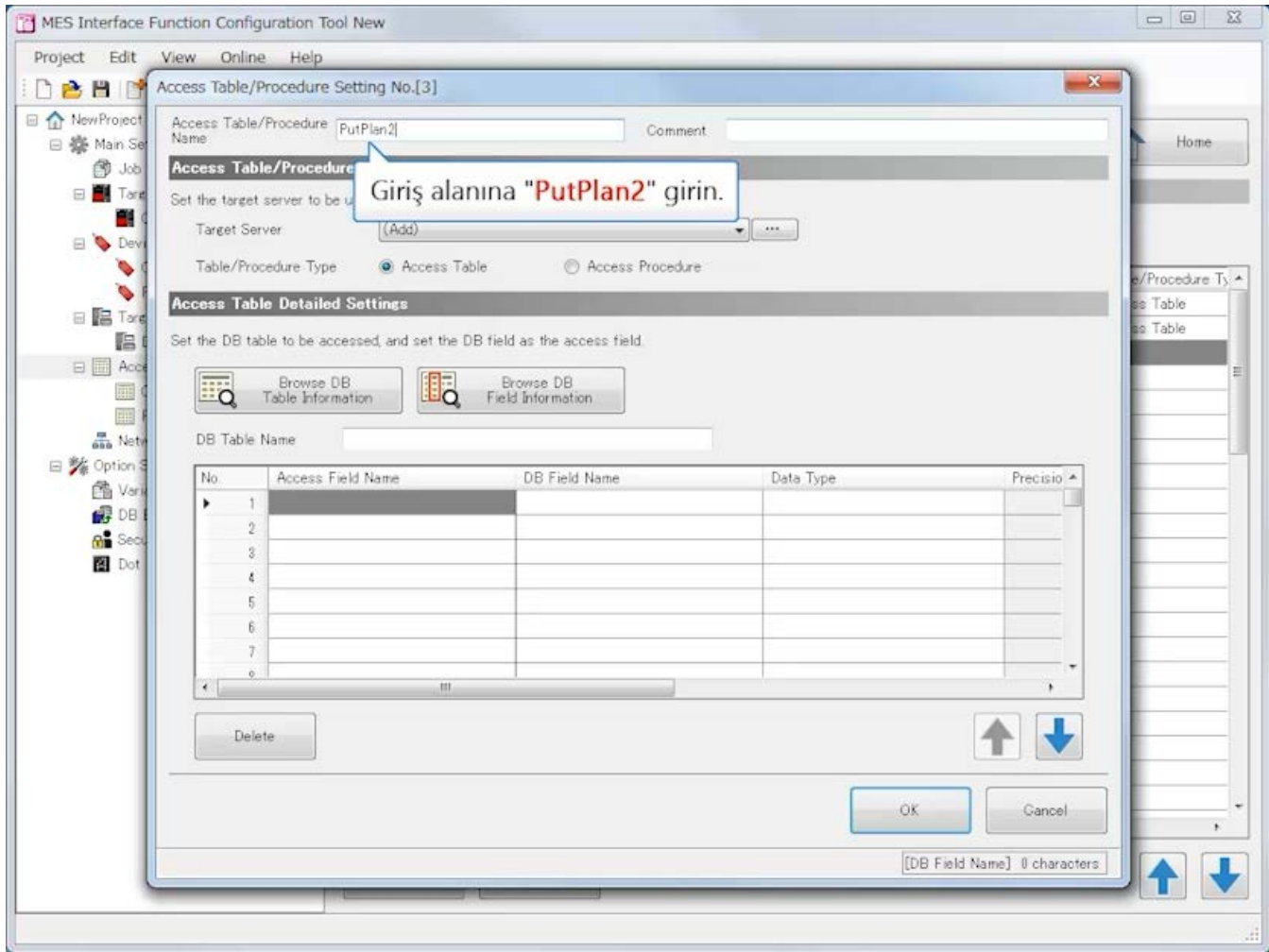
Geri

İleri



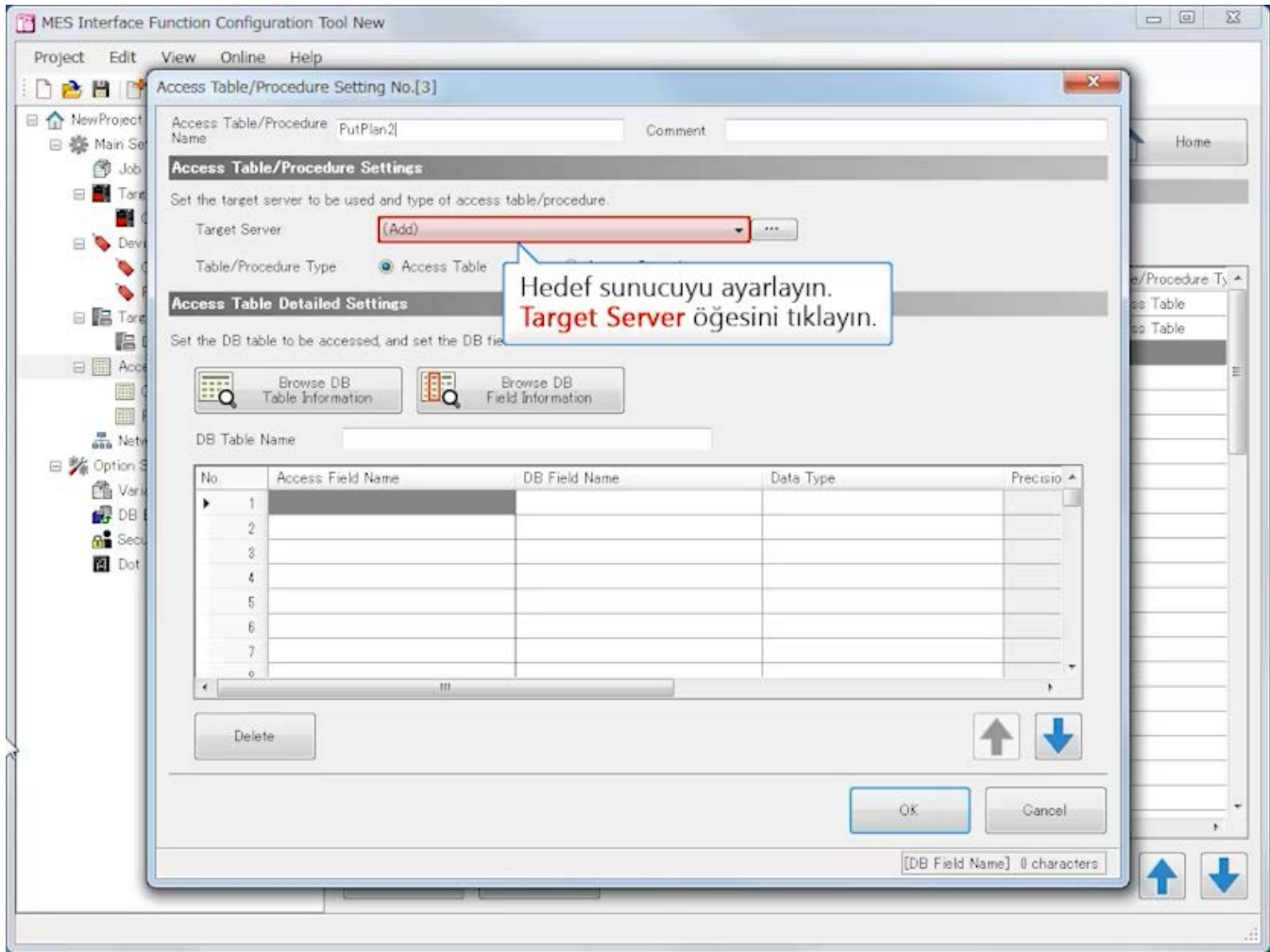
Geri

İleri



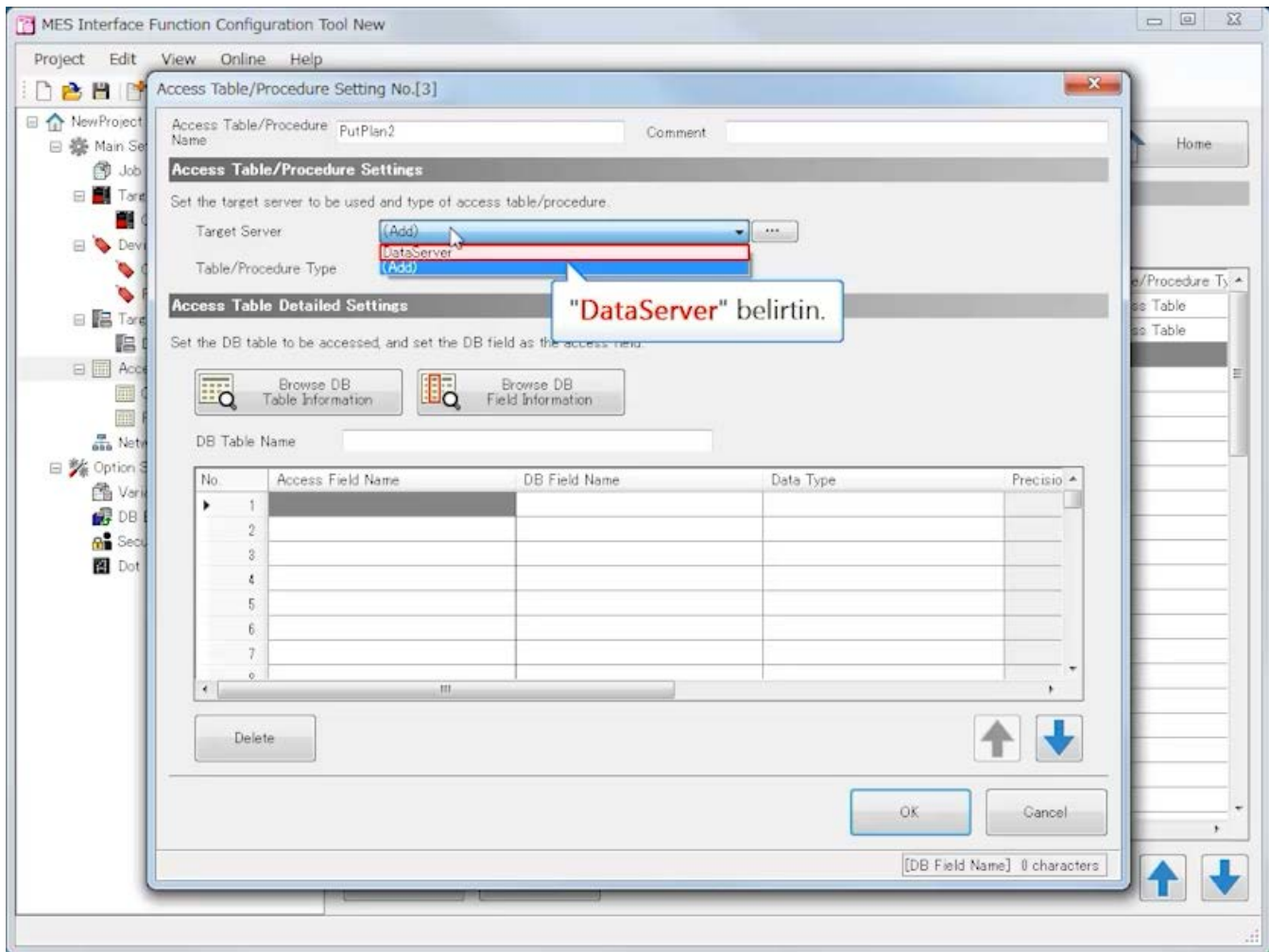
Geri

İleri



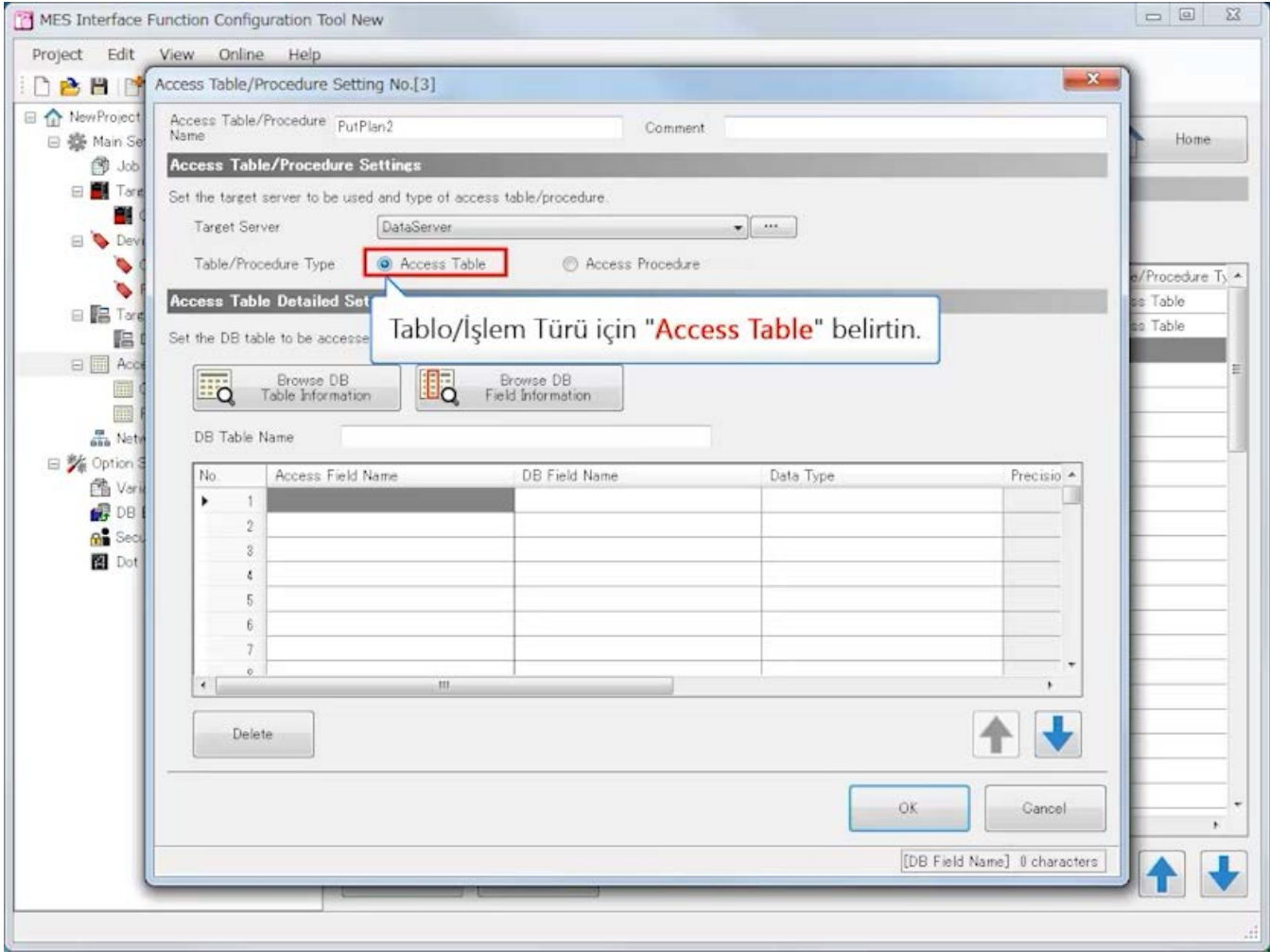
Geri

İleri



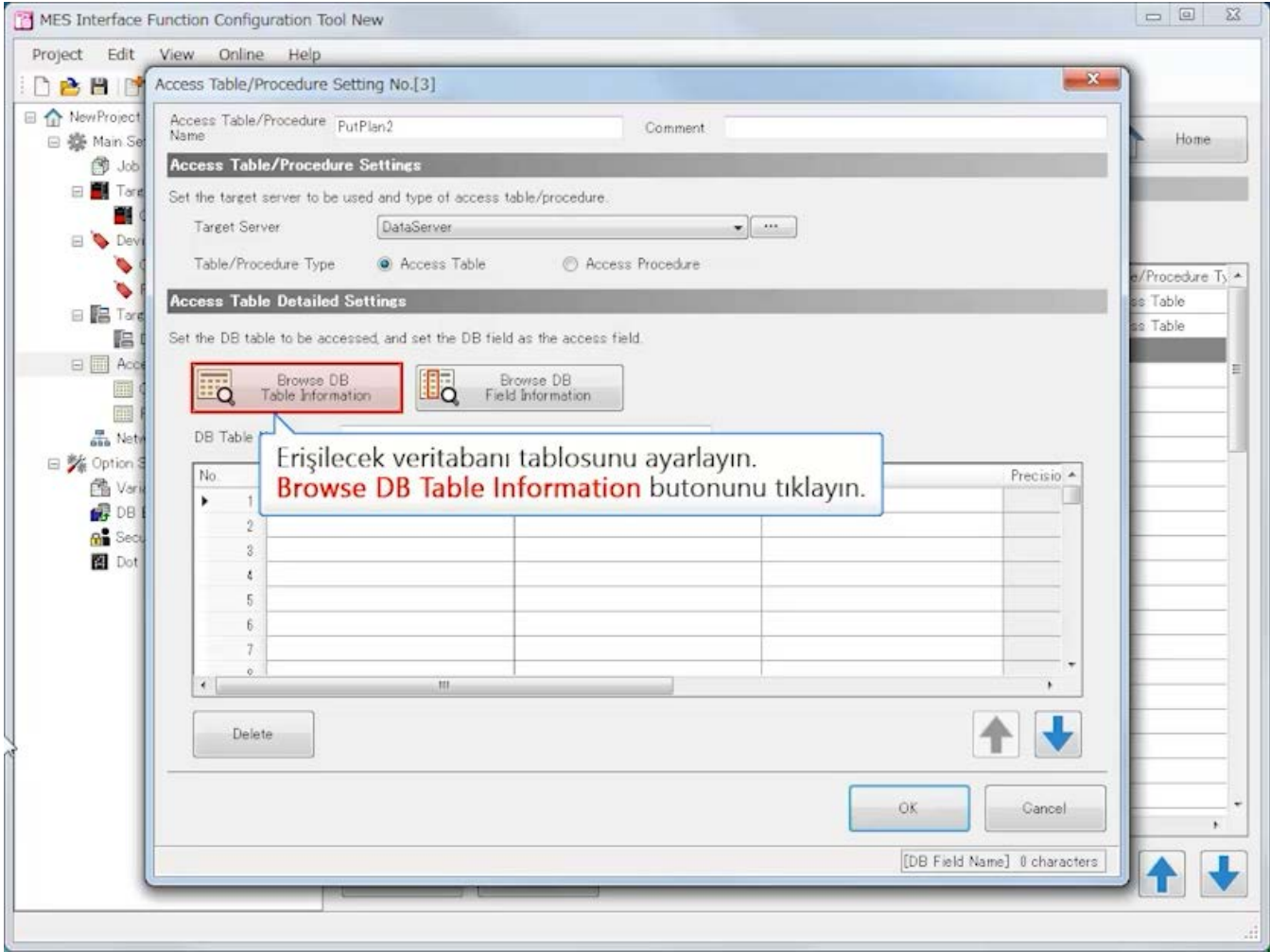
Geri

İleri



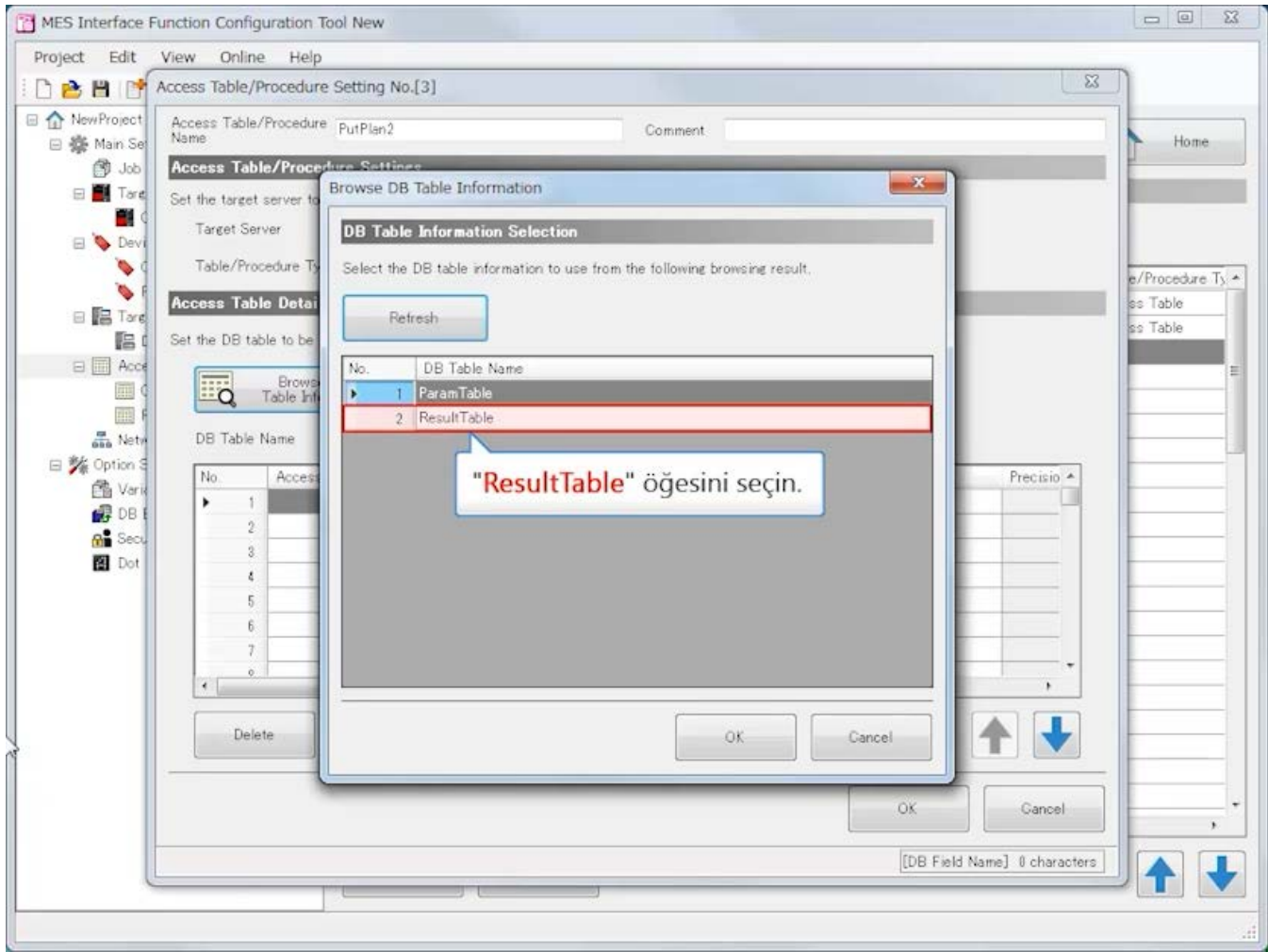
Geri

İleri



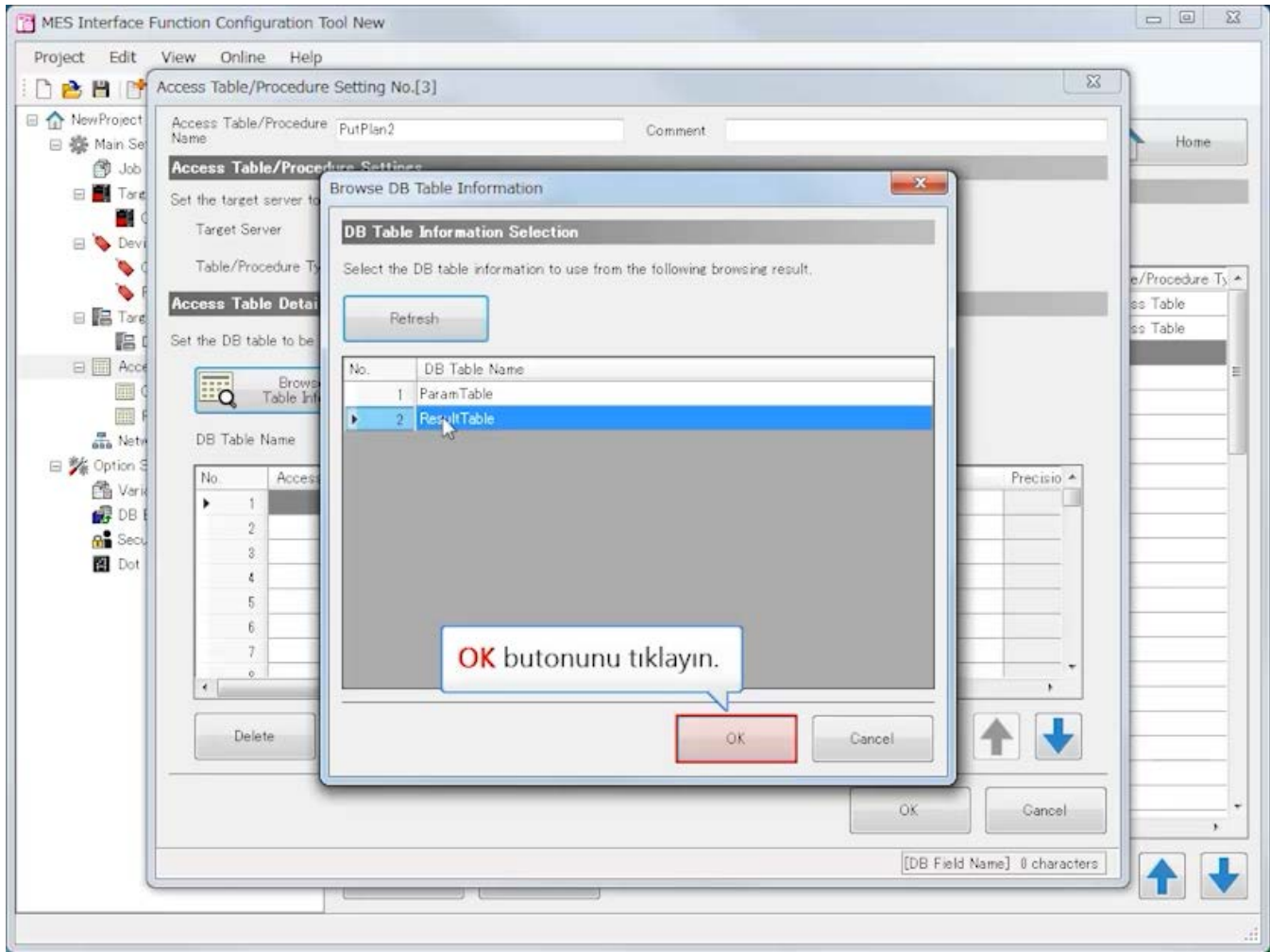
Geri

İleri



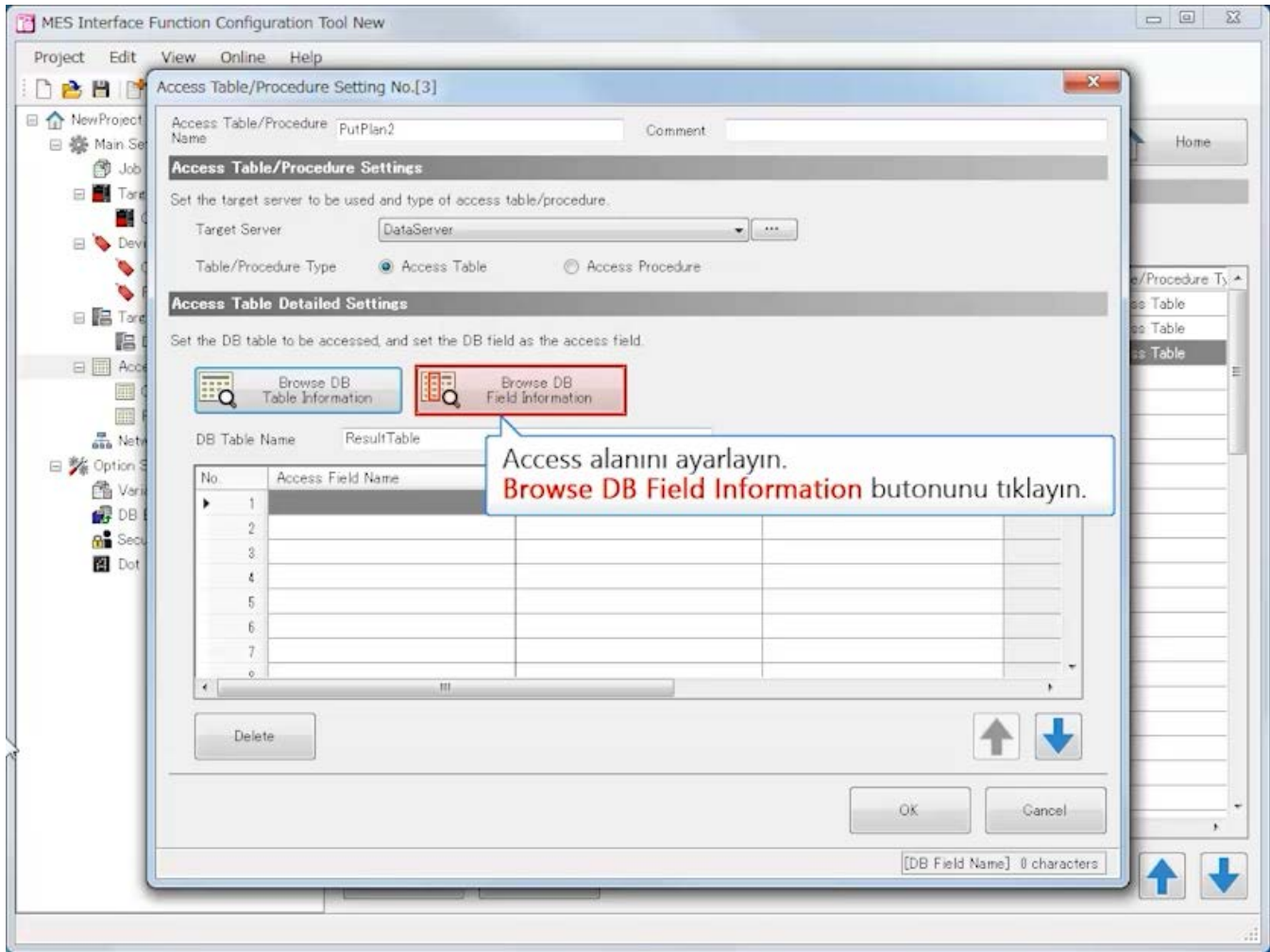
Geri

İleri



Geri

İleri



Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The 'Access Table/Procedure Setting No.[3]' dialog is open, with the 'Access Table/Procedure Name' field set to 'PutPlan2'. A 'Browse DB Field Information' dialog is overlaid on top, showing a table of database fields. A callout box highlights the selection of 'PatternNo', 'LoadResult', 'HeightResult', and 'EndTime'.

DB Field Information Selection

Select the DB field information to use from the following browsing result.

Refresh

No.	DB Field Name	(Data Type)
1	PatternNo	Integer
2	LoadResult	Integer
3	HeightResult	Integer
4	StartTime	Date and Time [Without Time]
5	EndTime	Date and Time [Without Time]

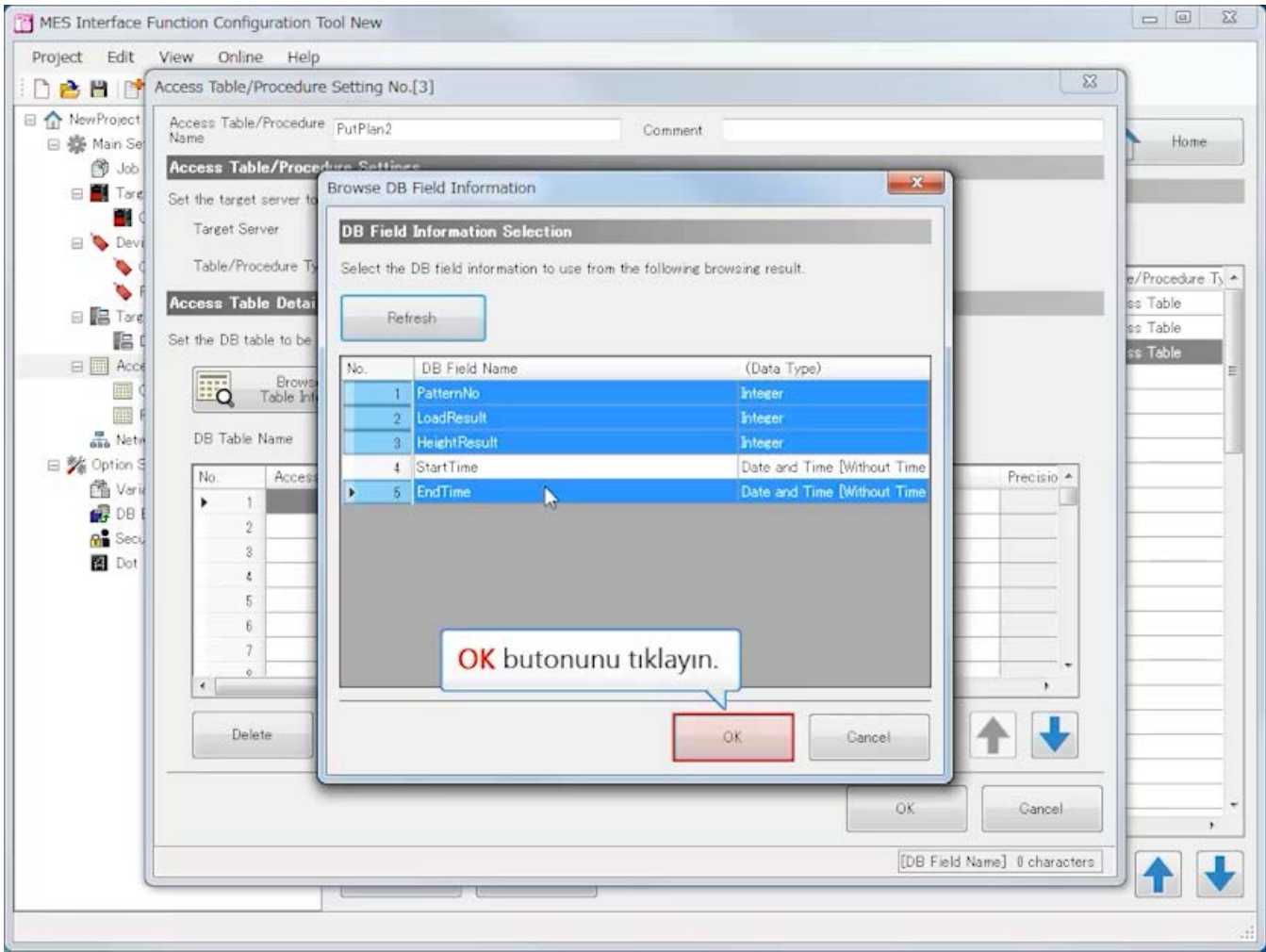
"PatternNo", "LoadResult", "HeightResult" ve "EndTime" öğelerini seçin.

OK Cancel

[DB Field Name] 0 characters

Geri

İleri



Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[3]

Access Table/Procedure Name: PutPlan2 Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

DB Table:

"PatternNo", "LoadResult" ve "HeightResult" Veri Türü olarak **Integer** seçin ve "EndTime" Veri Türü olarak **Date and Time [Without Time Zone]** seçin.

No.	Access Field Name	DB Field Name	Data Type	Precisio
1	PatternNo	PatternNo	Integer	Disable
2	LoadResult	LoadResult	Real Number	Disable
3	HeightResult	HeightResult	Real Number	Disable
4	EndTime	EndTime	Date and Time [Without Time Zone]	Disable
5				
6				
7				
8				

Delete

OK Cancel

[DB Field Name] 38 characters

Geri

İleri

Access Table/Procedure Setting No.[3]

Access Table/Procedure Name: PutPlan2

Comment:

Access Table/Procedure Settings

Set the target server to be used and type of access table/procedure.

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

Set the DB table to be accessed, and set the DB field as the access field.

Browse DB Table Information

Browse DB Field Information

DB Table Name: ResultTable

No.	Access Field Name	DB Field Name	Data Type	Precision
1	PatternNo	PatternNo	Integer	Disable
2	LoadResult	LoadResult	Real Number	Disable
3	HeightResult	HeightResult	Real Number	Disable
4	EndTime	EndTime	Date and Time [Without Time Zone]	Disable
5				
6				
7				
8				

Delete

Artık, tüm öğeler kaydedilmiştir.
OK butonunu tıklayın.

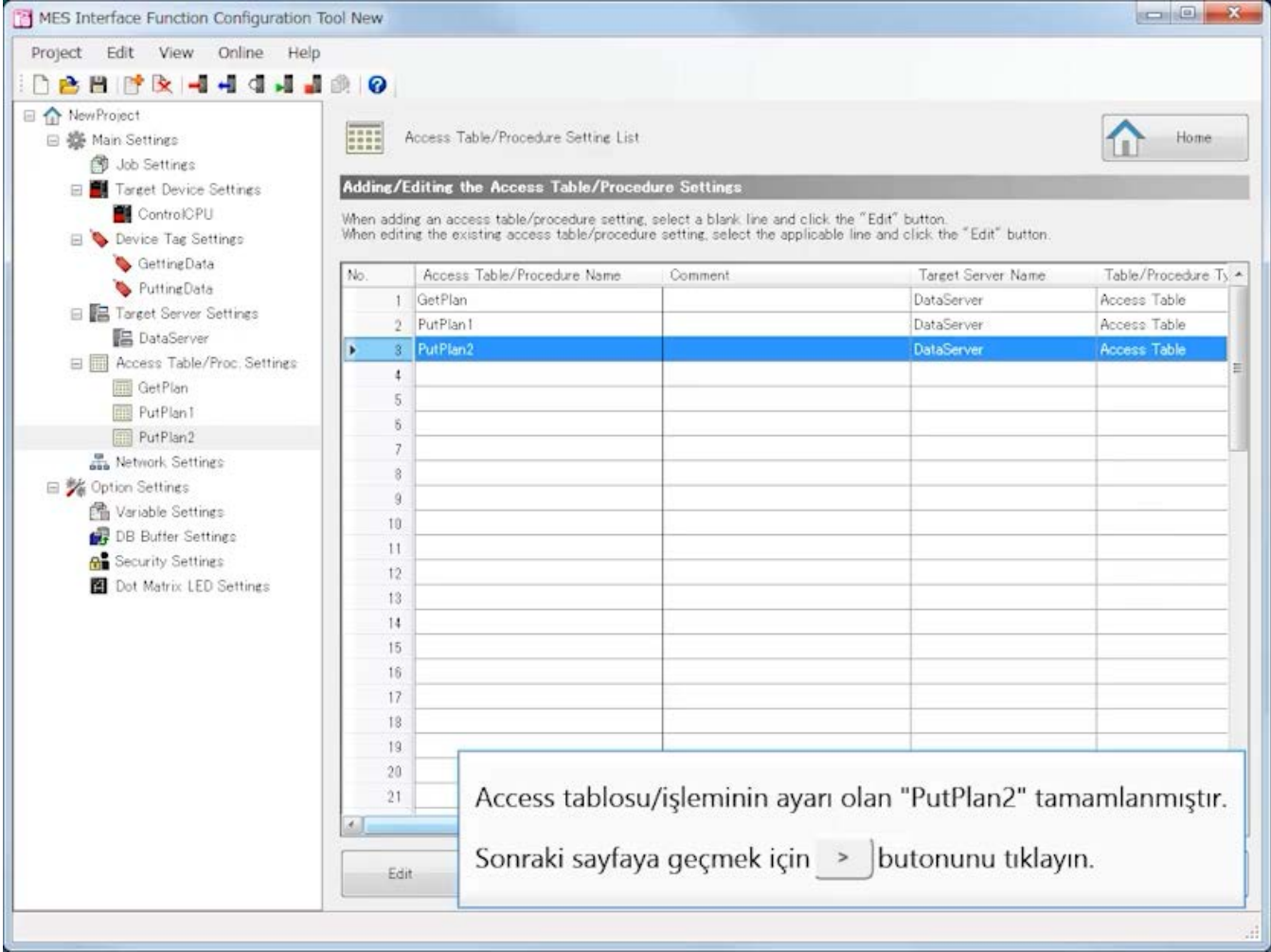
OK

Cancel

[DB Field Name] 38 characters

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3	PutPlan2		DataServer	Access Table
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Access tablosu/işleminin ayarı olan "PutPlan2" tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

Edit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

[Job Settings]

Üretim hazırken veritabanında verileri çıkartan bir iş oluşturun.

(1) Job Name: GetPlan

[Job Configuration]

Job Configuration: Main Configuration

[Trigger Conditions]

- Trigger Conditions Configuration Settings
Configuration Type: Single Event
- Event/Condition Settings
Event/Condition Type: Condition (Value Monitoring)

Monitoring target	(Data type)	Comparing condition	Comparing target	(Data type)
[TAG]GettingData.ManufacturingSettingValueAcquisition	Bit	=	[INT]1	

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[1]

Job Name: GetPlan Comment: _____

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type: The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Condition Combination Type:

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]GettingData.Manufacturing...

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering: When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

[Device Tag Components] 1 . 1 points
[Global Variable] 0 bytes
[Used Field/Arguments] 0 unit
[Date and Time] 0 unit
[Character strings] 0

[Read Data at Trigger Judgment]

- Access Type Selection
Access Type: General Access
- Access Interval Settings
Access Interval: Seconds Specification/1s
- Reading Target Data Setting (optional)
Reading Target Data: The Data to be used in Trigger Condition only

Job Setting No.[1]

Job Name: GetPlan Comment: _____

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type:

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.

Target Device MES Interface Module Target Device Network

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval: Seconds Specification 1 s
 Milliseconds Specification 1 * 100 ms

Reading Target Data Setting (optional)

Reading Target Data:

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Main-Processing]

• Main-Processing Settings

Action Type : DB Communication Action
DB Communication Type : Select
Access Table : GetPlan.Database

Data Assignment sekmesi

Access Field	(Data type)	↔	Assigned data	(Data type)
PatternNo	Integer	→	-	
Load	Integer	→	[TAG]GettingData.SettingValueofPressFittingLoad	Word [Unsigned]/Bit String [16-bit]
Height	Integer	→	[TAG]GettingData.SettingValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]

Narrowing-Down Condition sekmesi

Combination	Access Field	(Data type)	Comparing condition	Comparing target
	PatternNo	Integer	=	[TAG]GettingData.PatternNo

• DB Buffering Settings (optional)

DB Buffering: No Buffering

Job Setting No.[1]

Job Name Comment

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Select, [GetPlan] -> [[TAG]GettingData.SettingValueofPressFittingLoad...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Operation Settings at Main-Processing Failure (optional)

DB Buffering Settings (optional)

DB Buffer Use Size [byte]

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 3 unit [Date and Time] 0 unit [Character strings] 0

[Verification Settings]

- Working History Settings (optional)
 - Working History: Not output
- Data Output Inhibition Necessity Settings (optional)
 - Inhibit the data output to the target device : Seçmeyin
 - Inhibit the data output to the target server : Seçmeyin
- Job Execution Inhibition Necessity Settings (optional)
 - Inhibit the job execution even when the trigger condition is satisfied.: Seçmeyin

Job Setting No.[1] X

Job Name Comment

Job Configuration **Trigger Conditions** **Read Data at Trigger Judgment** Pre-Processing **Main-Processing** Post-Processing **Verification Settings**

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History

Detailed Log

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 3 unit [Date and Time] 0 unit [Character strings] 0

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the MES Interface Function Configuration Tool window. The title bar reads "MES Interface Function Configuration Tool E:\RnMTCPU\b.mu2". The menu bar includes "Project", "Edit", "View", "Online", and "Help". The toolbar contains various icons for file operations and navigation. On the left, a tree view shows the project structure under "NewProject", including "Main Settings", "Job Settings", "Target Device Settings", "Device Tag Settings", "Target Server Settings", "Access Table/Proc. Settings", "GetPlan", "PutPlan1", "PutPlan2", "Network Settings", "Option Settings", "Variable Settings", "DB Buffer Settings", "Security Settings", and "Dot Matrix LED Settings". The main workspace shows a "Project Name" field with "NewProject" entered. Below this, a "Main S" button is visible. A large text box in the center contains the instruction "Oynat butonunu tıklayın." (Click the play button). Below this, a diagram illustrates the configuration flow: "Device Tag Settings" and "Target Device Settings" are connected to "Job Settings" and "Network Settings", which are in turn connected to "Access Table/Procedure Settings" and "Target Server Settings". A text box at the bottom of the diagram area contains the instruction "Place the cursor to display the explanation of each item."

MES Interface Function Configuration Tool E:\RnMTCPU\b.mu2

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
- GetPlan
- PutPlan1
- PutPlan2
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Home

Project Name NewProject

Main S

Oynat butonunu tıklayın.

Set the main settings from the following buttons.
After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

Target Server Settings

Place the cursor to display the explanation of each item.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

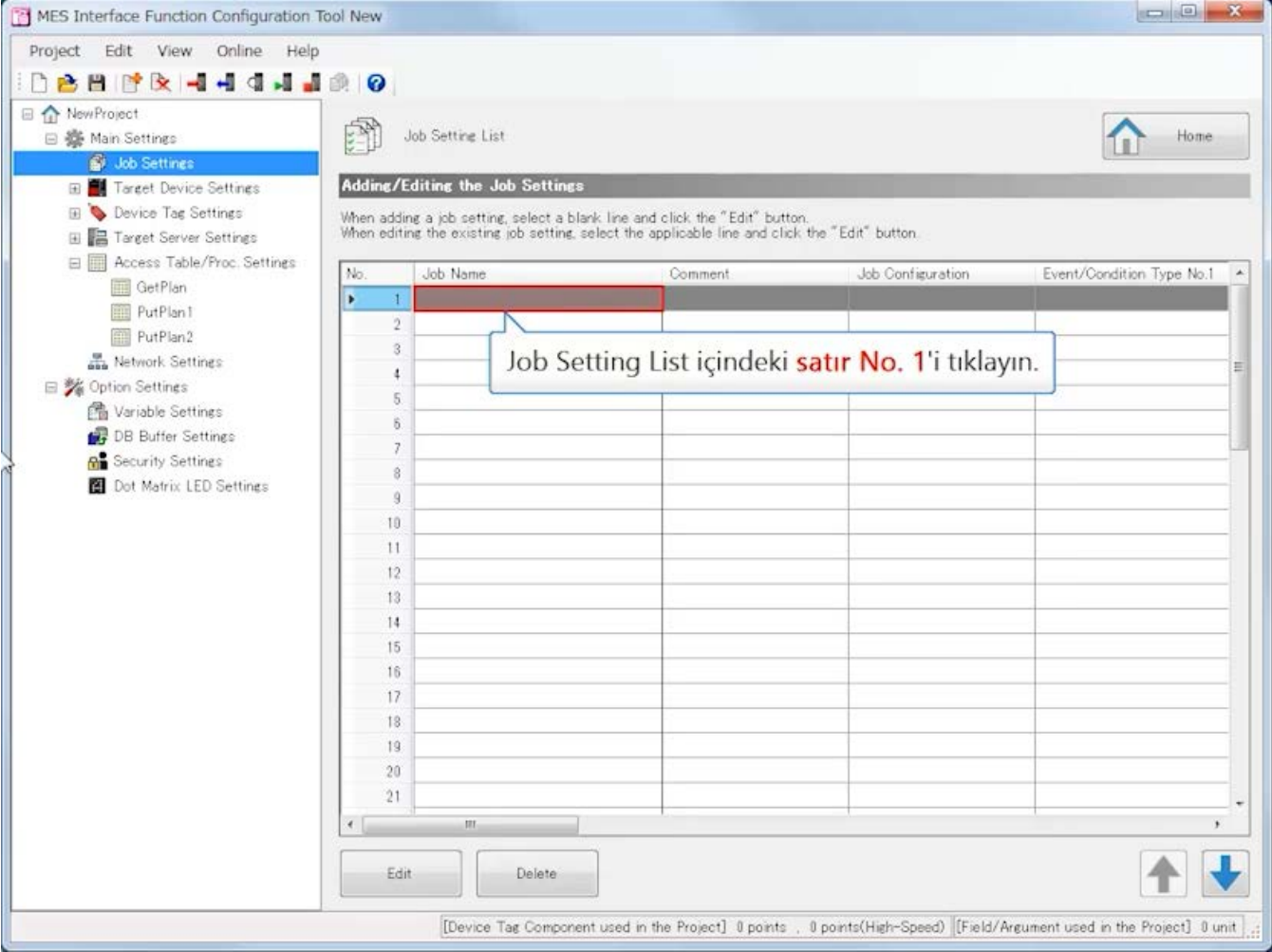
Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help) and a toolbar. A left-hand navigation tree shows a hierarchy of settings: Main Settings, Job Settings, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, GetPlan, PutPlan1, PutPlan2, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The 'Job Settings' option is selected. The main workspace shows a 'Project Name' field with 'NewProject' entered. Below this, there are tabs for 'Main Settings', 'Option Settings', and 'Comment'. The 'Main Settings' tab is active, displaying the 'Main Settings of MES Interface Module' section. This section contains a diagram with three main boxes: 'Device Tag Settings', 'Job Settings' (highlighted in red), and 'Access Table/Procedure Settings'. Below these are 'Settings' and 'Target Server Settings' boxes. A callout box points to the 'Job Settings' box with the text 'Job Settings öğesini tıklayın.' (Click the Job Settings item.). Below the diagram, there is a text box with the instruction: 'Place the cursor to display the explanation of each item.'

Geri

İleri



The screenshot displays the 'MES Interface Function Configuration Tool New' window. The left sidebar shows a tree view of settings, with 'Job Settings' selected. The main area is titled 'Job Setting List' and contains a table with the following columns: 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. The table has 21 rows, with the first row (No. 1) highlighted in red. A callout box with a blue border and white background points to the first row, containing the text 'Job Setting List içindeki satır No. 1'i tıklayın.' Below the table, there are 'Edit' and 'Delete' buttons, and a 'Home' button in the top right corner. The status bar at the bottom shows project details.

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Job Setting List içindeki satır No. 1'i tıklayın.

Edit Delete

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help), a toolbar, and a left-hand navigation tree. The 'Job Settings' section is expanded, showing a list of settings including 'Target Device Settings', 'Device Tag Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', and 'Option Settings'. The 'Option Settings' section is further expanded to show 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The main area is titled 'Job Setting List' and contains a table with columns: 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. The table has 21 rows, with row 1 selected. A context menu is open over row 1, showing options: 'Edit', 'Delete', 'Add', and 'One'. A tooltip is displayed over the 'Edit' option, containing the text: 'Yeni job ayarı oluşturmak için Edit seçin. Menüdeki Edit öğesini tıklayın.' Below the table, there are 'Edit' and 'Delete' buttons, and a scroll bar. At the bottom of the window, there is a status bar with the text: '[Device Tag Component used in the Project] 0 points , 0 points(High-Speed) [Field/Argument used in the Project] 0 unit ...'

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - Target Device Settings
 - Device Tag Settings
 - Target Server Settings
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete Add One

Yeni job ayarı oluşturmak için Edit seçin.
Menüdeki Edit öğesini tıklayın.

Edit Delete

[Device Tag Component used in the Project] 0 points , 0 points(High-Speed) [Field/Argument used in the Project] 0 unit ...

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name Job01 Comment

Job Configuration

Job Configuration Set

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Üretim hazırken veritabanında verileri çıkartan bir iş oluşturun.
Job Name öğesini tıklayın.

Post-Processing

Verification Settings

Home

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main configuration.

Ayarlanmakta olan iş konfigürasyonunu seçin.
Job Configuration öğesini tıklayın.

Target Device MES Interface Module Target Server

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Job Setting No.[1]' tab is active, showing a 'Job Name' field with 'GetPlan' and a 'Comment' field. The 'Job Configuration' step is selected in the navigation bar. Below the navigation bar, the 'Job Configuration Selection' section prompts the user to 'Select the configuration of the job being set.' A dropdown menu for 'Job Configuration' is open, showing 'Main Configuration' as the selected option. A callout box with the text 'Main Configuration seçin.' points to the dropdown. Below the dropdown, there is a diagram illustrating the data flow: 'Target Device' (represented by a red and black device icon) sends data to the 'MES Interface Module' (represented by a server rack icon), which then communicates with the 'Target Server' (represented by a server rack icon). The text 'such as DB Communication' is placed above the MES Interface Module. At the bottom of the window, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage statistics: '[Device Tag Components] 0 . . 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit'.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Verileri veritabanından çıkartma zamanlamasını belirtmek için **Trigger Conditions** ayarını yapılandırın.

Back Next OK Cancel

[Device Tag Components] 0 / 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 0 points / 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Verileri veritabanından çıkartma zamanlamasını belirtmek için **Trigger Conditions** ayarını yapılandırın.

Next butonunu tıklayın.

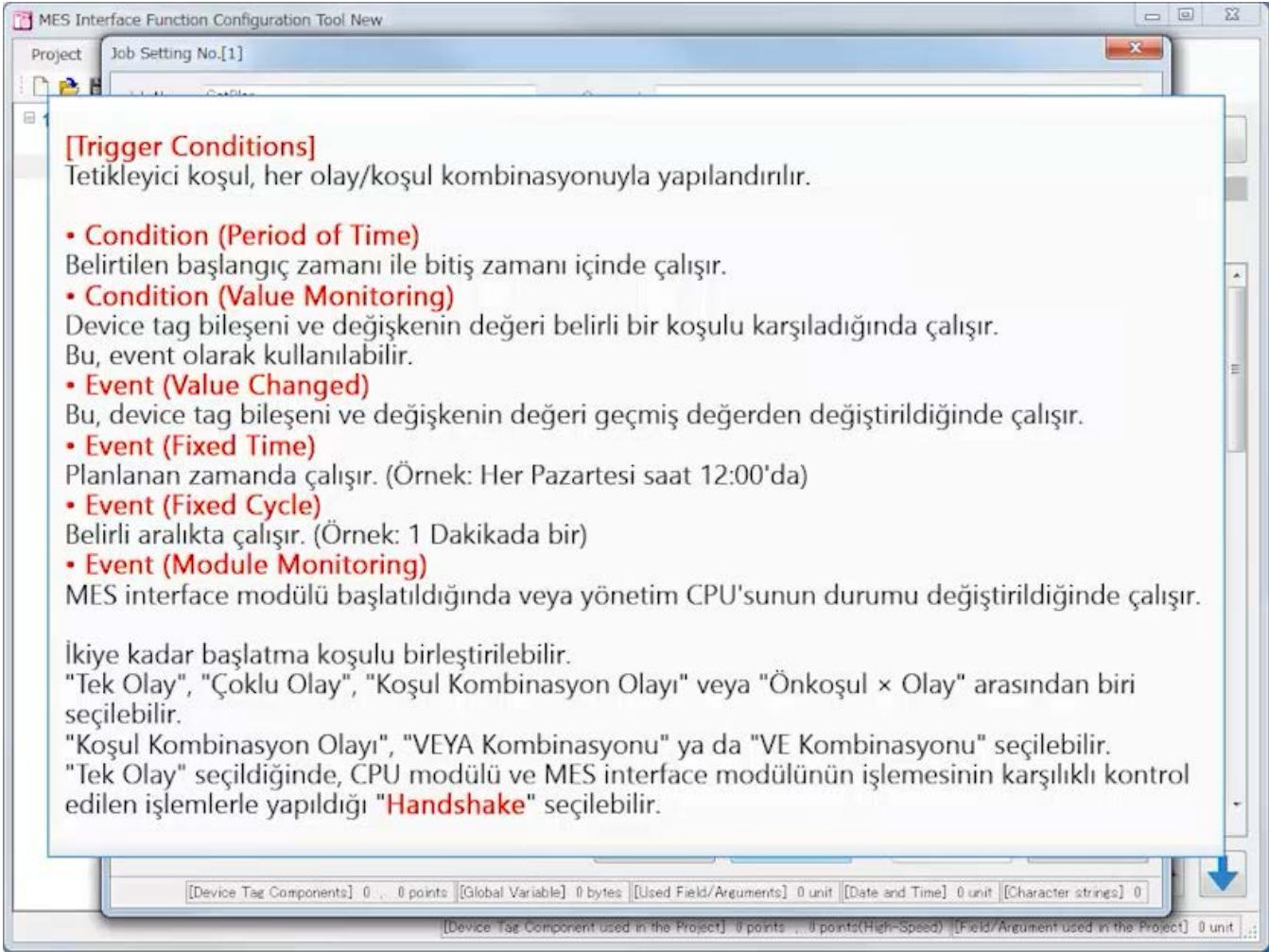
Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

Geri

İleri



[Trigger Conditions]
Tetikleyici koşul, her olay/koşul kombinasyonu ile yapılandırılır.

- **Condition (Period of Time)**
Belirtilen başlangıç zamanı ile bitiş zamanı içinde çalışır.
- **Condition (Value Monitoring)**
Device tag bileşeni ve değişkenin değeri belirli bir koşulu karşıladığında çalışır.
Bu, event olarak kullanılabilir.
- **Event (Value Changed)**
Bu, device tag bileşeni ve değişkenin değeri geçmiş değerden değiştirildiğinde çalışır.
- **Event (Fixed Time)**
Planlanan zamanda çalışır. (Örnek: Her Pazartesi saat 12:00'da)
- **Event (Fixed Cycle)**
Belirli aralıktadır çalışır. (Örnek: 1 Dakikada bir)
- **Event (Module Monitoring)**
MES interface modülü başlatıldığında veya yönetim CPU'sunun durumu değiştirildiğinde çalışır.

İkiye kadar başlatma koşulu birleştirilebilir.
"Tek Olay", "Çoklu Olay", "Koşul Kombinasyon Olayı" veya "Önkoşul × Olay" arasından biri seçilebilir.
"Koşul Kombinasyon Olayı", "VEYA Kombinasyonu" ya da "VE Kombinasyonu" seçilebilir.
"Tek Olay" seçildiğinde, CPU modülü ve MES interface modülünün işleminin karşılıklı kontrol edilen işlemlerle yapıldığı "**Handshake**" seçilebilir.

[Device Tag Components] 0 ... 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points ... 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 / 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points / 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type Multiple Events Condition Combination Precondition

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit . . .

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Olayı/koşulu ayarlayın.
Edit butonunu tıklayın.

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

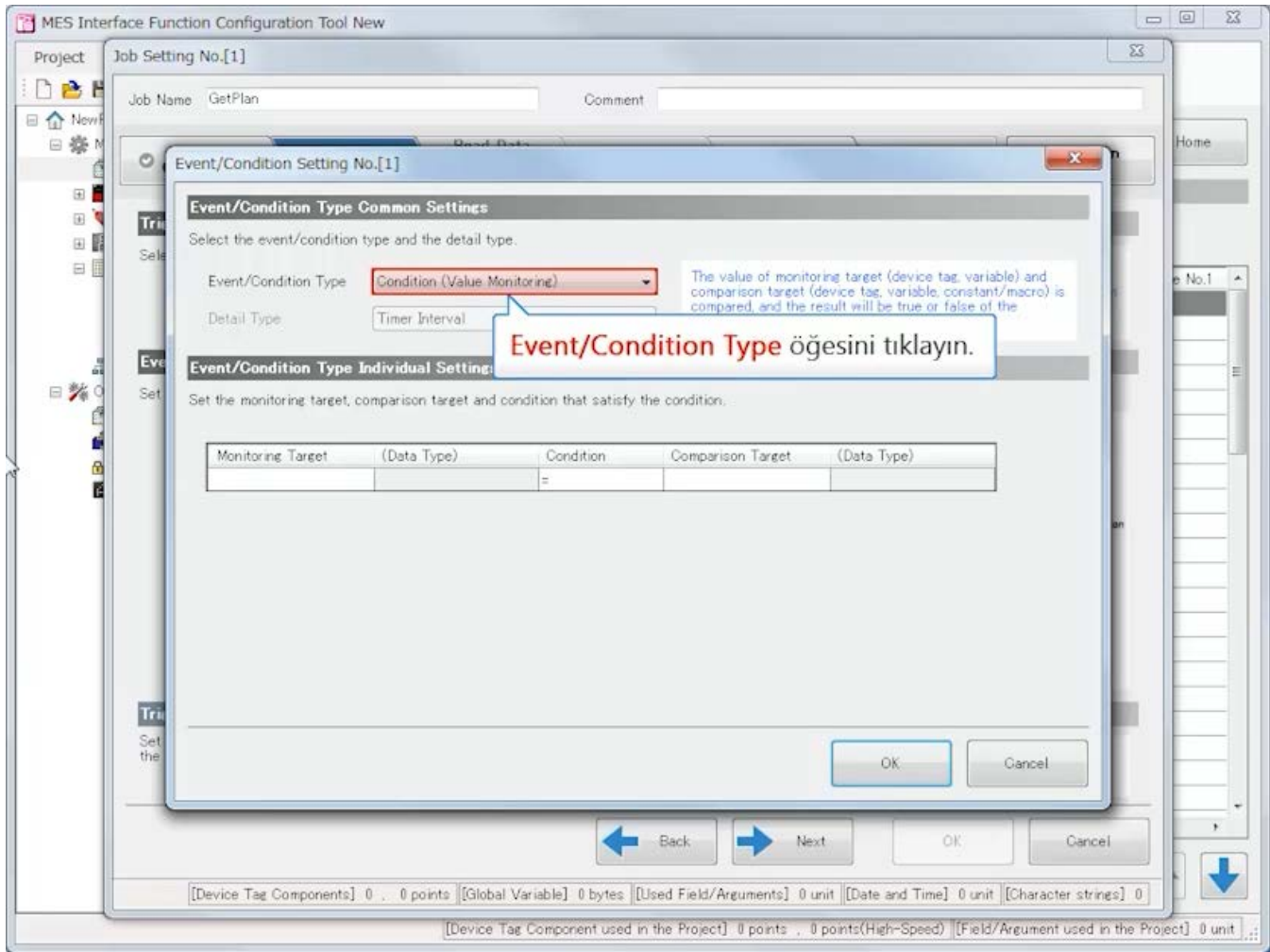
Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

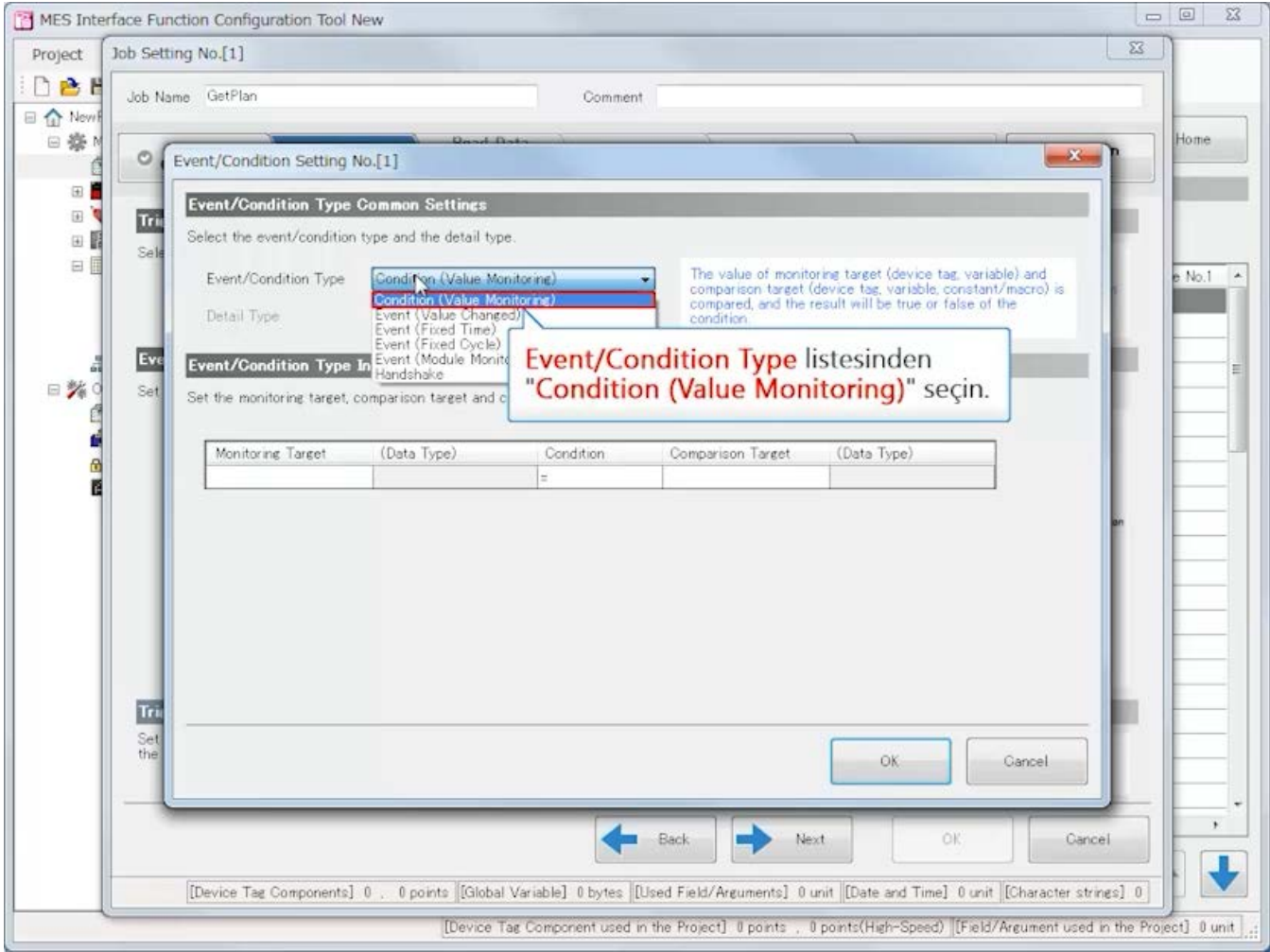
Geri

İleri



Geri

İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Koşulu, cihaz etiket ayarında yapılandırılan ayarları kullanarak ayarlayın.
Monitoring Target öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Device Tag

- GettingData
- PatternNo
- SettingValueofPressFitting
- SettingValueofPressFitting
- ManufacturingSettingValueAcquisition
- (Edit)
- PuttingData (Add)
- Variable

"Üretim ayarlama değeri alımı (M0) açıldığında" ayarını yapılandırın.
Monitoring Target listesinden "GettingData" ögesine ait "ManufacturingSettingValueAcquisition" ögesini tıklayın.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'Event/Condition Setting No.[1]' dialog box within the 'MES Interface Function Configuration Tool New' application. The dialog is titled 'Event/Condition Setting No.[1]' and has a close button (X) in the top right corner. It is divided into two main sections: 'Event/Condition Type Common Settings' and 'Event/Condition Type Individual Settings'.

Event/Condition Type Common Settings
Select the event/condition type and the detail type.
Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval
A text box explains: 'The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.'

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]GettingData.Manuf.	Bit	=		

A red box highlights the '=' symbol in the 'Condition' column. A callout box with a blue border and white background points to this symbol, containing the text 'Condition öğesini tıklayın.' (Click the condition element).

At the bottom of the dialog, there are 'OK' and 'Cancel' buttons. Below the dialog, the main application window shows 'Back' and 'Next' navigation buttons, along with 'OK' and 'Cancel' buttons. At the very bottom, there are status bars showing resource usage: '[Device Tag Components] 0 . . 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed)', '[Field/Argument used in the Project] 0 unit'.

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]GettingData Manuf...	Bit	=		

Condition listesinden "=" ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]GettingData Manuf...	Bit	=		

Comparison Target öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings
Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]GettingData Manuf...	Bit	=		

Comparison Target list options:
Device Tag
Variable
Constant
Integer
Real Number
Character String (Unicode)

Comparison Target listesinden "Integer" ögesini tıklayın.

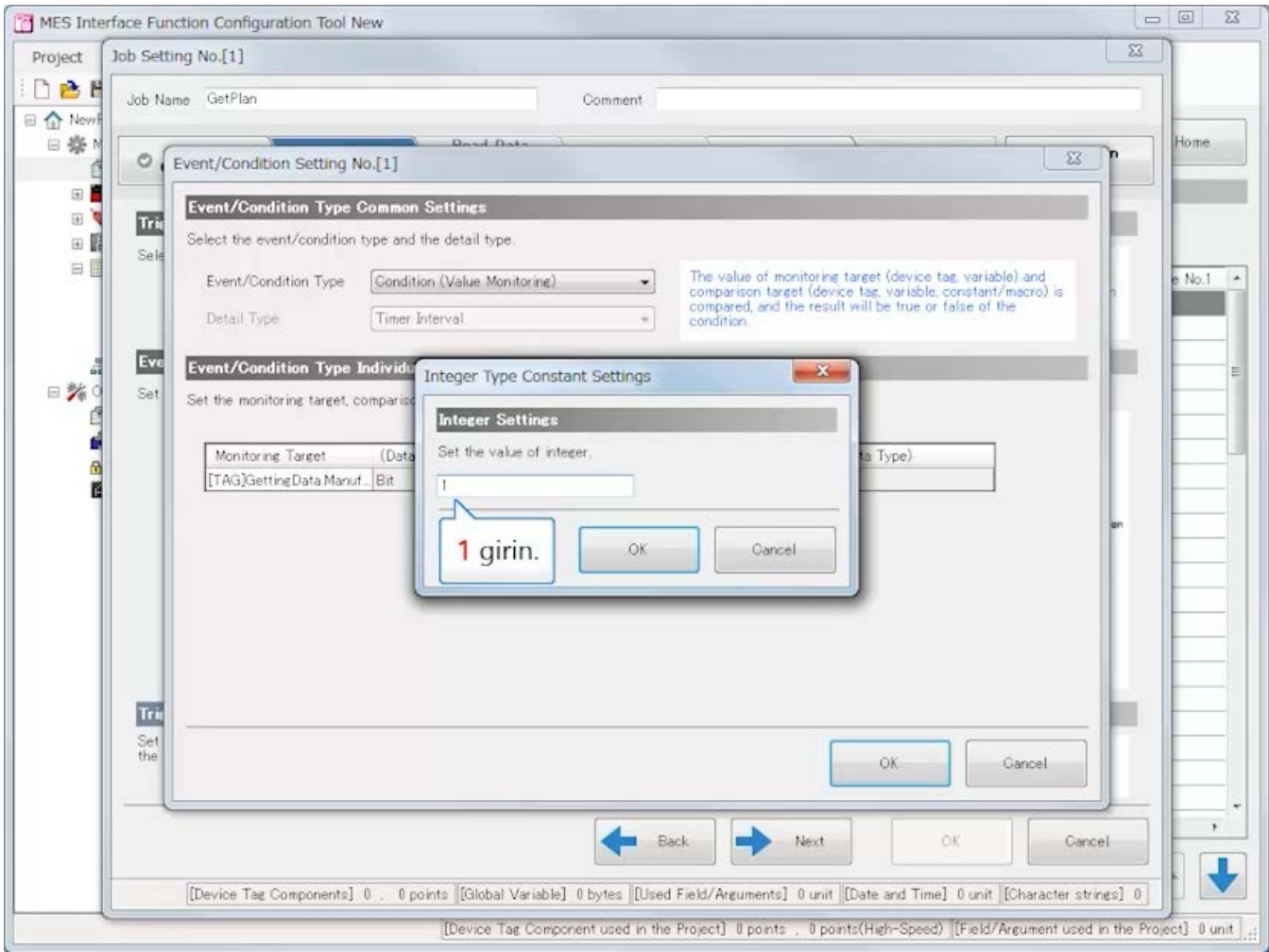
OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

Geri

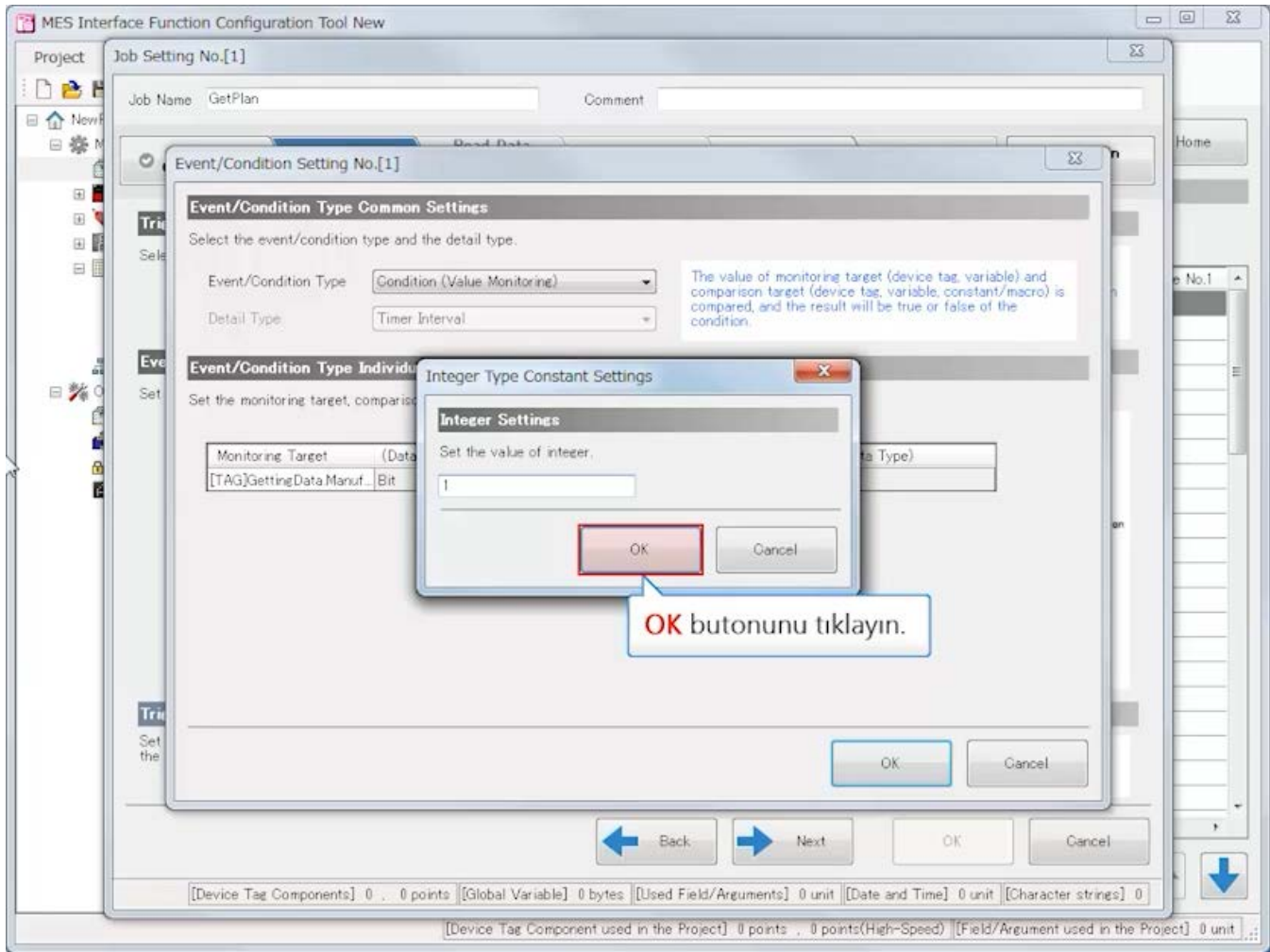
İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type Condition (Value Monitoring)

Detail Type Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]GettingData Manuf...	Bit	=	[DNT]	

"M0 açıldığında" ayarı tamamlanmıştır.
OK butonunu tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition.
In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]GettingData Manufacturing...

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger the same time.

Trigger Buffering Disable

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

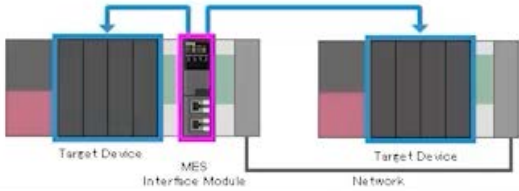
Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type General Access

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.



Target Device MES Interface Module Target Device Network

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval Seconds Specification 1 s Milliseconds Specification 1 * 100 ms

Read Data at Trigger Judgment için varsayılan ayarı kullanın.
Next butonunu tıklayın.

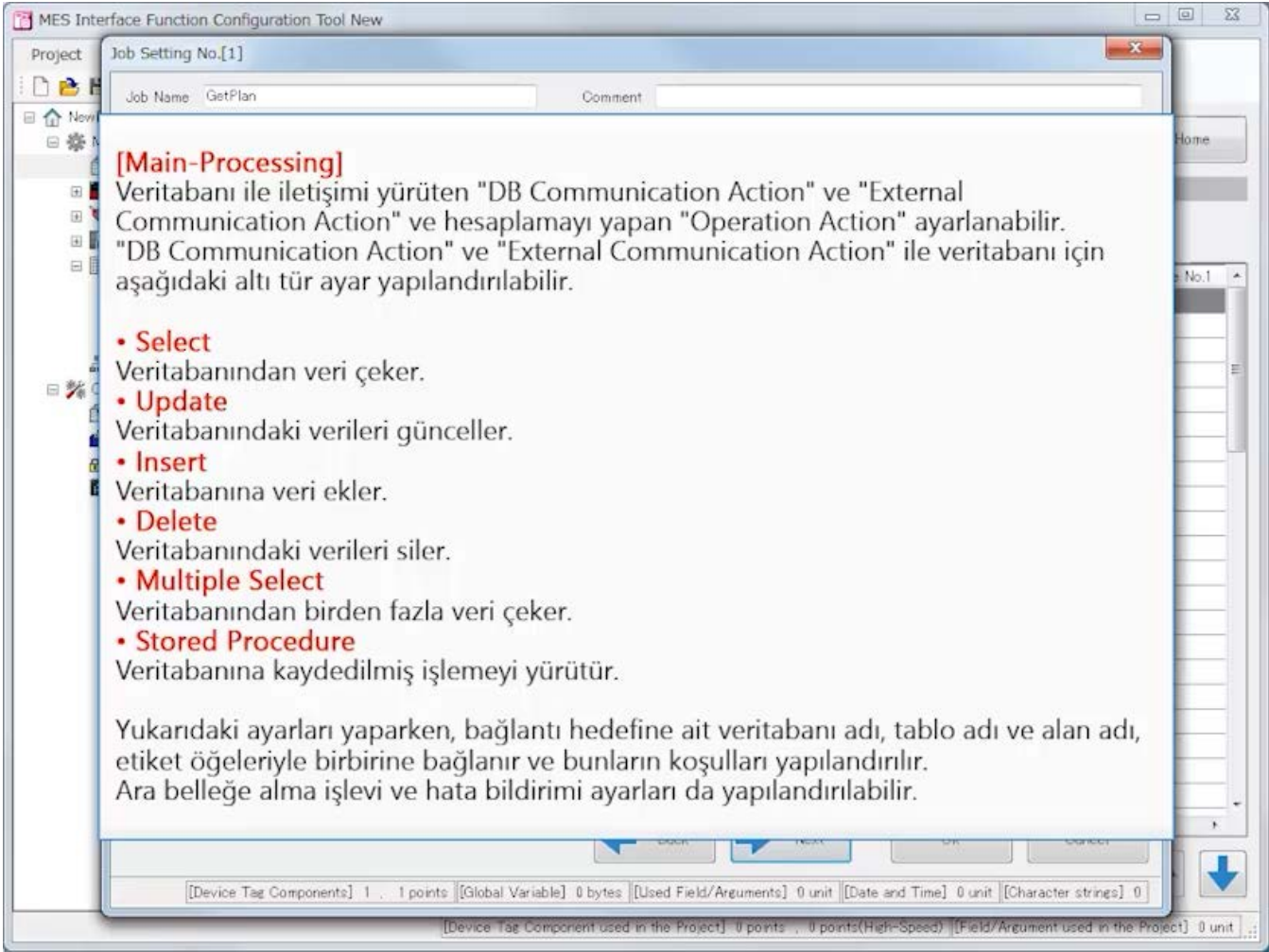
Back Next OK Cancel

[Device Tag Components] 1 . . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

Geri

İleri



The screenshot shows the MES Interface Function Configuration Tool New window. A dialog box titled "Job Setting No.[1]" is open, displaying the following content:

[Main-Processing]
Veritabanı ile iletişimi yürüten "DB Communication Action" ve "External Communication Action" ve hesaplamayı yapan "Operation Action" ayarlanabilir. "DB Communication Action" ve "External Communication Action" ile veritabanı için aşağıdaki altı tür ayar yapılandırılabilir.

- **Select**
Veritabanından veri çeker.
- **Update**
Veritabanındaki verileri günceller.
- **Insert**
Veritabanına veri ekler.
- **Delete**
Veritabanındaki verileri siler.
- **Multiple Select**
Veritabanından birden fazla veri çeker.
- **Stored Procedure**
Veritabanına kaydedilmiş işlemeyi yürütür.

Yukarıdaki ayarları yaparken, bağlantı hedefine ait veritabanı adı, tablo adı ve alan adı, etiket öğeleriyle birbirine bağlanır ve bunların koşulları yapılandırılır. Ara belleğe alma işlevi ve hata bildirimi ayarları da yapılandırılabilir.

At the bottom of the dialog box, there are navigation buttons: "Back", "Next", "OK", and "Cancel". Below the dialog box, the main window displays resource usage statistics:

[Device Tag Components] 1 ... 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 0 points ... 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1		
2		
3		
4		
5		
6		

main-processing ayarını yapılandırın.
Edit butonunu tıklayın.

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification "Not Set" Change DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 1 . . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the MES Interface Function Configuration Tool interface. The main window is titled "Job Setting No.[1]" and shows a navigation menu with tabs for Job Configuration, Trigger Conditions, Read Data at Trigger Judgment, Pre-Processing, Main-Processing (selected), Post-Processing, and Verification Settings. The Main-Processing Settings section is active, showing a table with 10 rows for action configuration. A dialog box titled "Main-Processing Action No.[1]" is open, displaying "Action Type Selection" options: DB Communication Action (highlighted with a red box), Operation Action, and External Communication Action. A callout box points to the "DB Communication Action" button with the text: "Hedef sunucuda veri giriři/çıkıřı için eylemi ayarlayın. DB Communication Action butonunu tıklayın." Below the dialog box, the "Operation Settings at Main-Processing" section is visible, including fields for "At Processing Notification" (set to "Not Set"), "DB Buffering" (set to "No Buffering"), and "DB Buffer Use Size" (set to "-"). The bottom of the window shows resource usage statistics for various components.

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, click the "Edit" button.

No.	Action Type
1	
2	
3	
4	
5	
6	
7	
8	
9	
10	

Edit

Main-Processing Action No.[1]

Action Type Selection

Click the button that is applicable to the action to be added from each following buttons.

DB Communication Action Operation Action

External Communication Action

Set the action to

Cancel

↑ ↓

Operation Settings at Main-Processing

At Processing Notification: "Not Set" Change DB Buffering: No Buffering Change

DB Buffer Use Size [byte]: -

← Back Next → OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: (Add)

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

Tetikleyici koşul karşılandığında yürütülecek eylemi ayarlayın.
DB Communication Type ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert, Select, Update, Delete, Multiple Select, Stored Proc

Access Table: ...

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: (Add)

Data Assignment: Narrowing-Down Condition

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

SELECT FROM;

OK Cancel

Verinin çıkartıldığı tablonun adını ayarlayın.
Access Table ögesini tıklayın.

MES Interface Module Database Server

[Device Tag Component used in the Project] 0 points , 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: (Add) GetPlan.DataServer PutPlan1.DataServer PutPlan2.DataServer (Add)

Data Assignment: Narrowing-Down

Data Assignment Settings

Set the assignment of the data to be input/output

Access Table listesinden "GetPlan.DataServer" ögesini seçin.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

SELECT FROM;

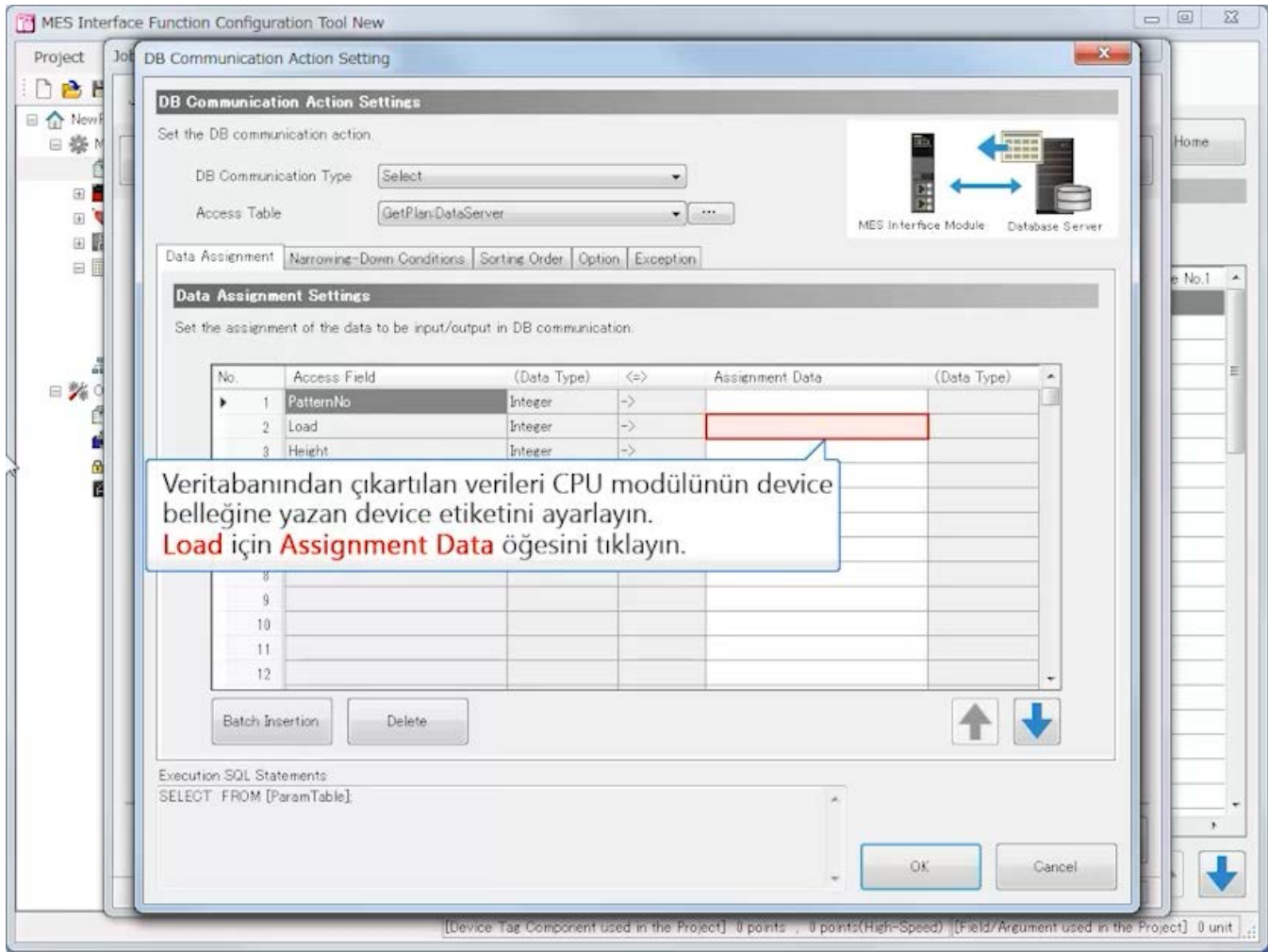
OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

Data Assignment: Narrowing-Down Conditions | Sorting Order | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	->		
2	Load	Integer	->		
3	Height	Integer	->		
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
SELECT FROM [ParamTable]

OK Cancel

Veritabanından çıkartılan verileri CPU modülünün device belleğine yazan device etiketini ayarlayın.
Load için Assignment Data ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan.DataServer

Data Assignment | Narrowing-Down Conditions | Sorting Order | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	->		
2	Load	Integer	->		
3	Height	Integer	->		
4					
5					
6					

Execution SQL Statements
SELECT FROM [ParamTable].

OK Cancel

[Device Tag Component used in the Project] 0 points 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

D100 sinyali, device tag settingsnda "SettingValueofPressFittingLoad" bileşeni olarak ayarlandığından, Assignment Data listesinden "GettingData" bölümünde SettingValueofPressFittingLoad öğesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

Data Assignment: Narrowing-Down Conditions | Sorting Order | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	->		
2	Load	Integer	->	[TAG]GettingData.SettingValueof	Word [Unsigned]
3	Height	Integer	->	[TAG]GettingData.SettingValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]

Aşağıdaki tabloda gösterildiği gibi, "Yükseklik alanının verilerini D101 device belleğine çıkart" ayarını yapılandırın.
Ayarlama işlemi "Load" ile aynıdır.
Bu kursta ayarlama işlemi göz ardı edilmiştir.

Access Field (Data Type) <=> Assignment Data (Data Type)

Height Integer -> [TAG]GettingData.SettingValueofPressFittingHeight Word [Unsigned]/Bit String [16-bit]

Batch Insertion Delete

Execution SQL Statements

SELECT [Load] FROM [ParamTable].

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

Data Assignment: Narrowing-Down Conditions | Sorting Order | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	->		
2	Load	Integer	->	[TAG]GettingData.Setting Valueof...	Word [Unsigne...
3	Height	Integer	->	[TAG]GettingData.Setting Valueof...	Word [Unsigne...
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable];
```

OK Cancel

Data assignment settings tamamlanmıştır.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

Data Assignment | **Narrowing-Down Conditions** | Sorting Order | Option | Exception

Data Assignment S

Set the assignment of

No.	Acc				
1	Patte				
2	Load	Integer	->	[TAG]GettingData.Setting Valueof...	Word [Unsigne...
3	Height	Integer	->	[TAG]GettingData.Setting Valueof...	Word [Unsigne...
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable];
```

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

Data Assignment | **Narrowing-Down Conditions** | Sorting Order | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1						
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements
SELECT [Load], [Height] FROM [ParamTable];

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1						
2		PatternNo				
3		Load				
4		Height				
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements
SELECT [Load], [Height] FROM [ParamTable];

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

Access Field listesinden "PatternNo" ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	((Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = ?;
```

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = ?;

OK Cancel

Condition listesinden "=" ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = ?
```

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	GettingData PatternNo	
2					Device Tag GettingData PatternNo	
3					Setting Value of Press Fitting Setting Value of Press Fitting	
4					Manufacturing Setting Value	

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = ?
```

OK Cancel

[Device Tag Component used in the Project] 0 points 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool E:\RnMTCPU\%b.mu2

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan.DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]GettingData.PatternNo	Word [Unsig..
2						
3						
4						
5						
6						
7						
8						

Alan değerinin (PatternNo) device belleği D0'a eşit olduğu kaydı çıkartma ayarı tamamlanır.

Batch Insertion Delete

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = (GettingData.PatternNo);
```

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]GettingData.PatternNo	Word [Unsig...
2						
3						
4						
5						
6						
7						
8						

Batch Insertion

Execution SQL Statements

```
SELECT [Load], [Height] FROM [ParamTable] WHERE [PatternNo] = (GettingData.PatternNo).
```

OK Cancel

[Device Tag Component used in the Project] 0 points ... 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

Ayar tamamlandığında, "Execution SQL Statements" otomatik olarak oluşturulur.
Buna karşın, bu SQL ibaresinin, veritabanındaki veriye erişecek kullanıcı tarafından oluşturulması gerekir.
Bu MES interface function configuration toolyla, SQL ibaresi otomatik olarak oluşturulduğu için, bunun oluşturulması düşünülmeden veritabanına erişilebilir.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]GettingData PatternNo	Word [Unsig...
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

DB Communication Action Settings tamamlanır.
OK butonunu tıklayın.

OK Cancel

[Device Tag Component used in the Project] 0 points, 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Job Name: GetPlan

Comment:

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Select, [GetPlan] -> [[TAG]GettingDataSettingValueofPressFittingLoad...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification: "Not Set" Change DB Buffering No Buffering Change

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 3 . 3 points [Global Variable] 0 bytes [Used Field/Arguments] 3 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History Not output

Detailed Log Not output

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

Verification Settings için varsayılan ayar kullanılmaktadır.
OK butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 3 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', etc. The 'Job Settings' category is expanded, showing a list of job settings including 'GetPlan', 'PutPlan1', and 'PutPlan2'. The main area displays a 'Job Setting List' table with the following data:

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Below the table, there are 'Edit' and 'Delete' buttons. A confirmation message box is overlaid on the table, stating: "GetPlan" iş ayarı tamamlanmıştır. Sonraki sayfaya geçmek için > butonunu tıklayın.

At the bottom of the window, there is a status bar with the text: [Device Tag Component used in the Project] 4 points , 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

[Job Settings]

Üretimi başlatırken kaydı veritabanına yazan bir iş oluşturun.

(2) Job Name: PutPlan1

[Job Configuration]

Job Configuration: Main Configuration

[Trigger Conditions]

- Trigger Conditions Configuration Settings
Configuration Type: Single Event
- Event/Condition Settings
Event/Condition Type: Condition (Value Monitoring)

Monitoring target	(Data type)	Comparing condition	Comparing target	(Data type)
[TAG]PuttingData.StartManufacturing	Bit	=	[INT]1	

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type:

Condition Combination Type:

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition.
In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]PuttingData.Startmanufact...

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering:

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

[Device Tag Components] 1 . 1 points
[Global Variable] 0 bytes
[Used Field/Arguments] 0 unit
[Date and Time] 0 unit
[Character strings] 0

[Read Data at Trigger Judgment]

- Access Type Selection
Access Type: General Access
- Access Interval Settings
Access Interval: Seconds Specification/1s
- Reading Target Data Setting (optional)
Reading Target Data: The Data to be used in Trigger Condition only

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type General Access

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval Seconds Specification 1 s
 Milliseconds Specification 1 * 100 ms

Reading Target Data Setting (optional)

Reading Target Data The Data to be used in Trigger Condition only Change

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Main-Processing]

- Main-Processing Settings
 - Action Type : DB Communication Action
 - DB Communication Type : Insert
 - Access Table : PutPlan1.Database

Data Assignment sekmesi

Access Field	(Data type)	↔	Assigned data	(Data type)
PatternNo	Integer	←	[TAG]PuttingData.PatternNo	Word [Unsigned]/Bit String [16-bit]
LoadResult	Integer	←	[TAG]PuttingData.ResultValueofPressFittingLoad	Word [Unsigned]/Bit String [16-bit]
HeightResult	Integer	←	[TAG]PuttingData.ResultValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]
StartTime	Date and Time [Without Time Zone]	←	[MACRO]Job Execution Start Date and Time	Date and Time

- DB Buffering Settings (optional)
 - DB Buffering: Buffering to DBBuf1

DB arabelleğe almayı yapılandırmak için, [Option Settings] içindeki [DB Buffer Settings] ayarlarında "Use the DB buffer 1." seçeneğini kullanın.

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
▶ 1	DB Communication Action	[Content] Insert, [PutPlan1] <- [[TAG]PuttingData.PatternNo], [[TAG]PuttingData...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete ↑ ↓

Operation Settings at Main-Processing Failure (optional) **DB Buffering Settings (optional)**

At Processing Failure Notification: "Not Set" Change DB Buffering Buffering to DBBuf1 Change

DB Buffer Use Size [byte] 270

[Device Tag Components] 4 . 4 points
[Global Variable] 0 bytes
[Used Field/Arguments] 4 unit
[Date and Time] 1 unit
[Character strings] 0

[Verification Settings]

- Working History Settings (optional)
Working History: Not output
- Data Output Inhibition Necessity Settings (optional)
Inhibit the data output to the target device : Seçmeyin
Inhibit the data output to the target server : Seçmeyin
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: Seçmeyin

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History Not output

Detailed Log Not output

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

Back Next OK Cancel

[Device Tag Components] 3 . 3 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool E:\RnMTCPU\b.mu2

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- GetPlan
- Target Device Settings
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
- Network Settings
- Option Settings
- Variable Settings
- DB Buffer Settings
- Security Settings
- Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Configuration	Event/Condition Type No.1
1	Configuration	Condition (Value Monitoring)
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		
13		
14		
15		
16		
17		
18		
19		
20		
21		

Edit Delete

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit ...

Geri

İleri

The screenshot shows the MES Interface Function Configuration Tool New window. The window has a menu bar (Project, Edit, View, Online, Help) and a toolbar. On the left, there is a tree view showing the configuration structure, including NewProject, Main Settings, Job Settings, GetPlan, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area displays the Job Setting List table with the following columns: No., Job Name, Comment, Job Configuration, and Event/Condition Type No.1. The table contains one row with Job Name 'GetPlan', Job Configuration 'Main Configuration', and Event/Condition Type No.1 'Condition (Value Monitoring)'. A callout box with a blue border and a white background is positioned over the table, containing the text: 'Daha sonra, ikinci iş ayarını yapılandırın. Job Setting List içindeki **satır No. 2**'yi tıklayın.' Below the table, there are 'Edit' and 'Delete' buttons, and a status bar at the bottom showing project details.

Job Setting List

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

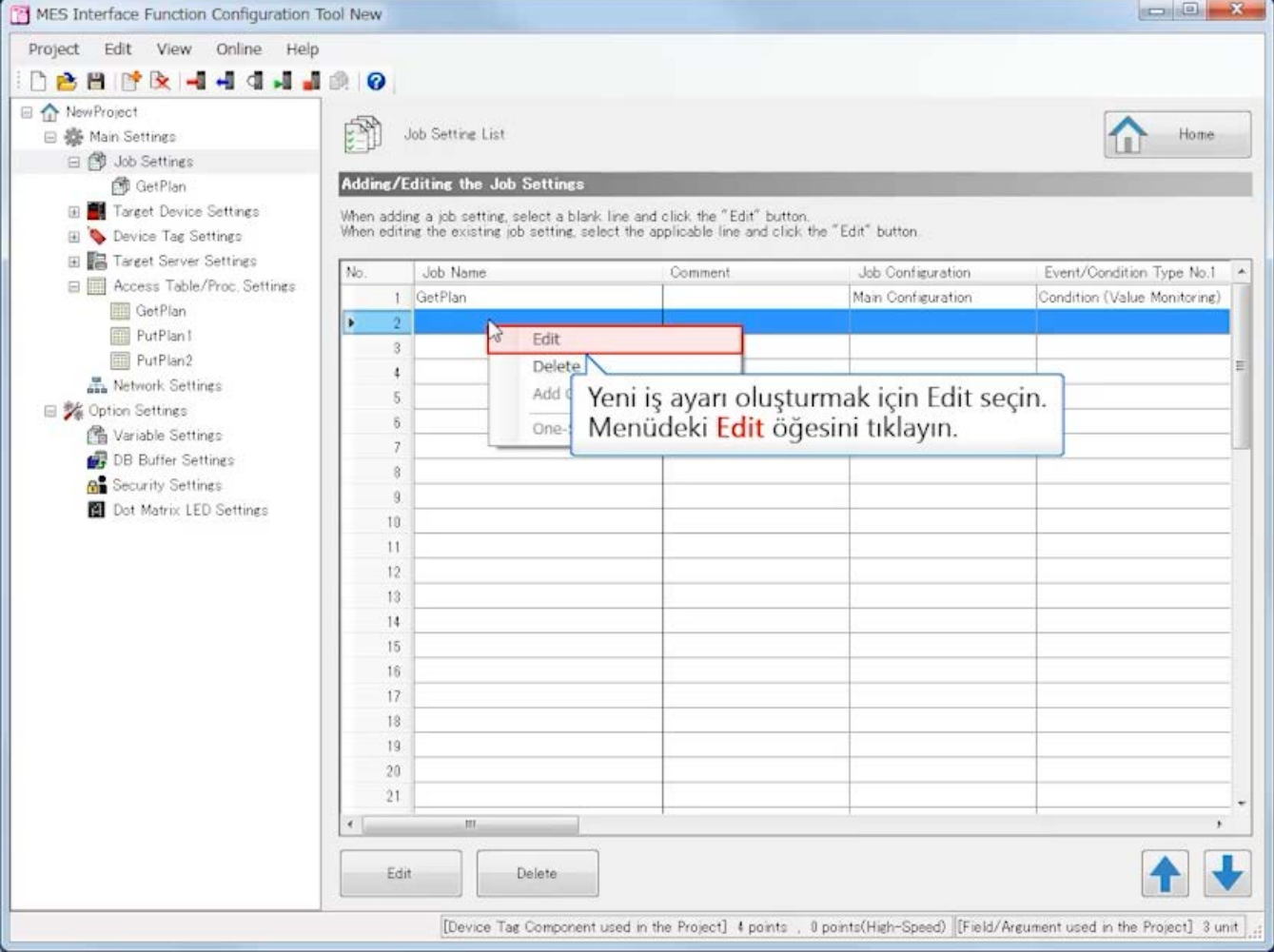
Edit Delete

[Device Tag Component used in the Project] 4 points , 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Job Settings' selected. The main area displays a 'Job Setting List' table. A context menu is open over the 'Edit' button of the first row, with a tooltip in Turkish explaining that the 'Edit' option should be selected to create a new job setting.

Adding/Editing the Job Settings
When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Yeni iş ayarı oluşturmak için Edit seçin.
Menüdeki Edit öğesini tıklayın.

[Device Tag Component used in the Project] 4 points , 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Job Setting No.[2]

Job Name Comment

Job Configuration

Job Configuration Set

Select the configuration of the job being set.

Job Configuration:

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Üretimi başlatırken kaydı veritabanına yazan bir iş oluşturun.
Job Name ögesini tıklayın.

← Back Next →

OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Job Setting No.[2]

Job Name [PutPlan1] Comment []

Job Configure Main-Processing Post-Processing Verification Settings

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration: [Main Configuration]

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device → Main-Processing (such as DB Communication) ↔ Target Server

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main configuration.

Ayarlanmakta olan iş konfigürasyonunu seçin.
Job Configuration öğesini tıklayın.

Target Device MES Interface Module Target Server

Back Next OK Cancel

[Device Tag Components] 0 / 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points / 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Job Setting No.[2]' tab is active, showing a 'Job Name' field with 'PutPlan1' and a 'Comment' field. The 'Job Configuration' step is selected in the navigation bar. Below the navigation bar, the 'Job Configuration Selection' section is visible, with the instruction 'Select the configuration of the job being set.' A dropdown menu for 'Job Configuration' is open, showing 'Main Configuration' selected. A callout box with the text 'Main Configuration seçin.' points to the selected option. Below the dropdown, there is a diagram illustrating the data flow: 'Target Device' (represented by a red and black device icon) sends data to the 'MES Interface Module' (represented by a server rack icon), which then communicates with the 'Target Server' (represented by a server rack icon). The diagram includes a green arrow pointing from the Target Device to the MES Interface Module, and a blue double-headed arrow between the MES Interface Module and the Target Server. At the bottom of the window, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage statistics: '[Device Tag Components] 0 / 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 4 points / 0 points(High-Speed)', '[Field/Argument used in the Project] 3 unit'.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Verileri veritabanına ekleme zamanlamasını belirtmek için **Trigger Conditions** ayarlarını yapılandırın.

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Verileri veritabanına ekleme zamanlamasını belirtmek için **Trigger Conditions** ayarlarını yapılandırın.

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Configuration Type öğesini tıklayın.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Edit Delete

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 / 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points / 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type Multiple Events Condition Co Precondition

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

← Back Next → OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Belirtilen bir olayın meydana gelmesini tetikleyici olarak ayarlamak için **Single Event** seçin.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition.
In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Olayı/koşulu ayarlayın.
Edit butonunu tıklayın.

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[2]' and contains fields for 'Job Name' (PutPlan1) and 'Comment'. A dialog box titled 'Event/Condition Setting No.[1]' is open in the foreground. The dialog box is divided into two sections: 'Event/Condition Type Common Settings' and 'Event/Condition Type Individual Setting'.

Event/Condition Type Common Settings
Select the event/condition type and the detail type.
Event/Condition Type: **Condition (Value Monitoring)**
Detail Type: Timer Interval
The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the

Event/Condition Type Individual Setting
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Event/Condition Type öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: **Condition (Value Monitoring)**

Detail Type: **Condition (Value Monitoring)**

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type In: **Condition (Value Monitoring)**

Set the monitoring target, comparison target

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

OK Cancel

← Back Next → OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type Condition (Value Monitoring)

Detail Type Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Koşulu, cihaz etiket ayarında yapılandırılan ayarları kullanarak ayarlayın.
Monitoring Target ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Device Tag

- GettingData
- PuttingData
- PatternNo
- ResultValueofPressFitting
- ResultValueofPressFitting
- StartManufacturing
- EndManufacturing
- [E]

[Add]

Variable

"Üretimi başlatma (M1) açıldığında" ayarını yapılandırın.
Monitoring Target listesinden "PuttingData" öğesine ait "StartManufacturing" öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData Start...	Bit	=		

Condition öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData Start...	Bit	=		

Condition listesinden "=" öğesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings
Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData Start...	Bit	=		

Comparison Target ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData Start...	Bit	=		

Comparison Target list: Device Tag, Variable, Constant, Integer, Real Number, Character String (Unicode)

Comparison Target listesinden "Integer" öğesini tıklayın.

OK Cancel

Back Next OK Cancel

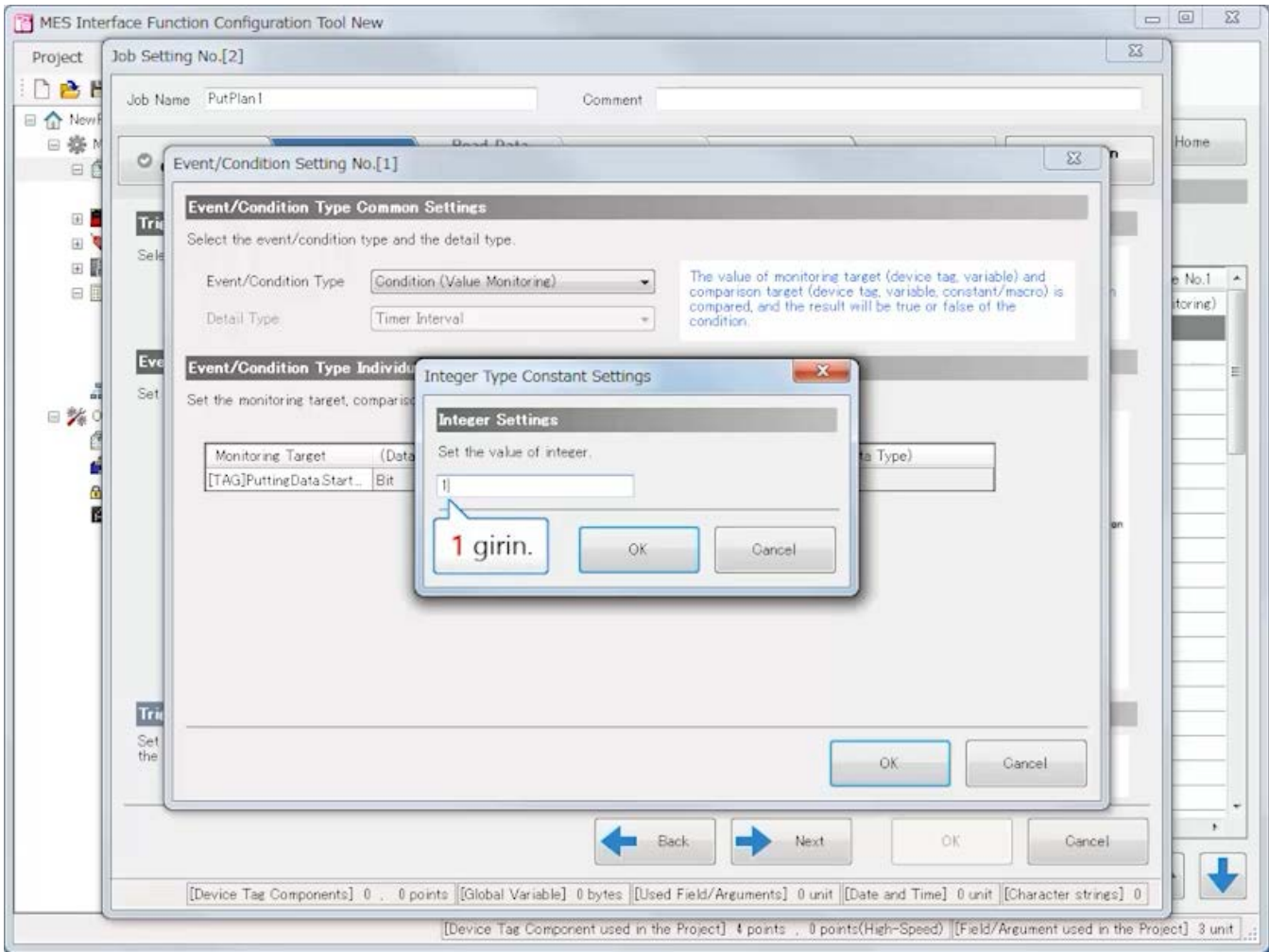
[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

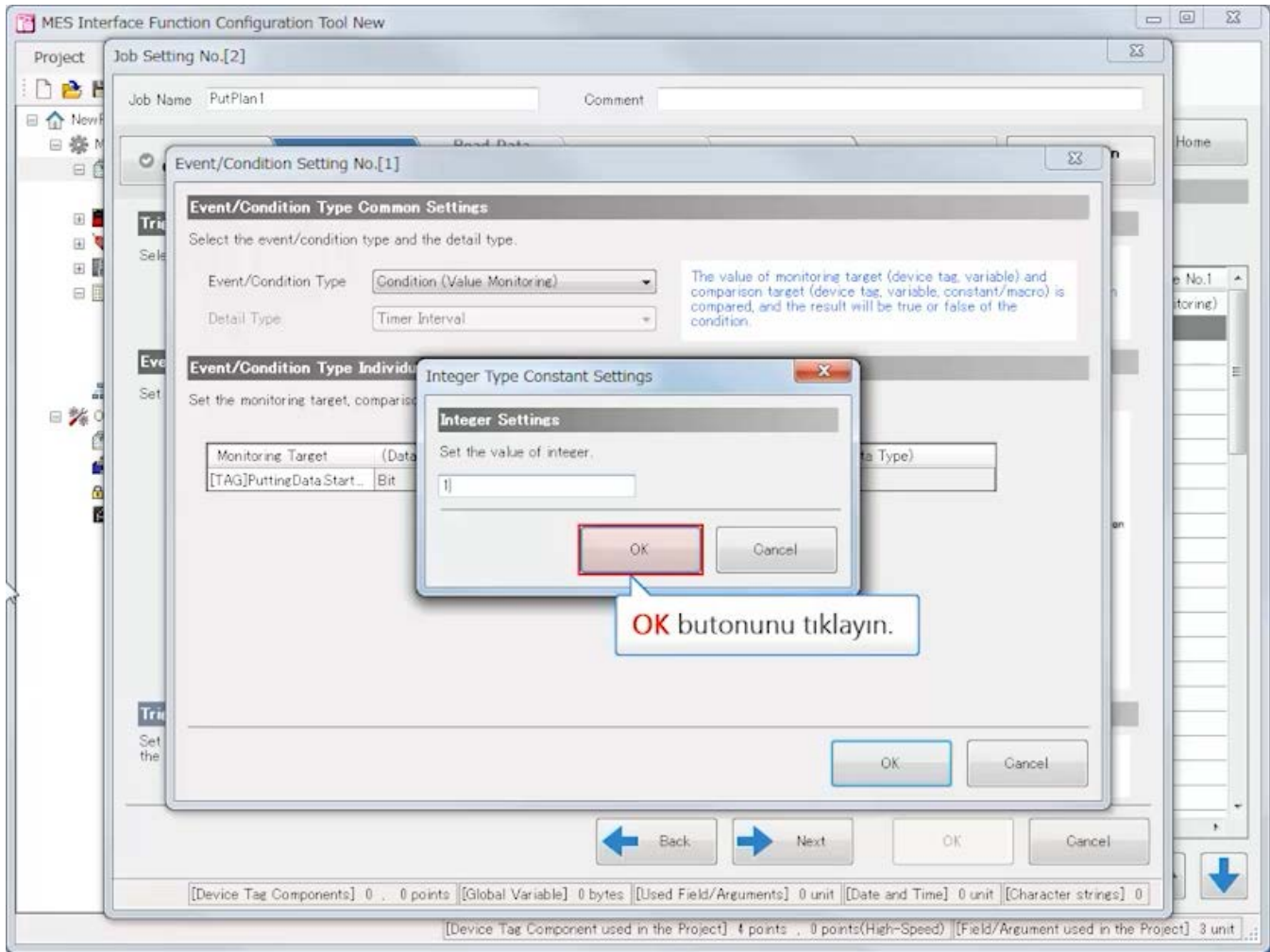
İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type Condition (Value Monitoring)

Detail Type Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData Start...	Bit	=	[DNT]	

OK butonunu tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition.
In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]PuttingData.StartManufact...

Edit Delete

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger the same time.

Trigger Buffering Disable

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Job Setting No.[2]

Job Name PutPlan1 Comment

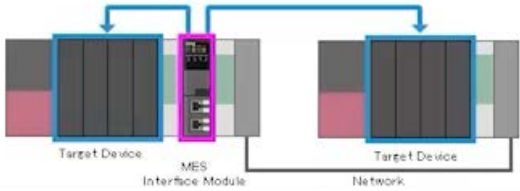
Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type General Access

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.



Target Device MES Interface Module Target Device Network

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval Seconds Specification 1 s Milliseconds Specification 1 * 100 ms

Read Data at Trigger Judgment için varsayılan ayarı kullanın.
Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 1 . . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1		
2		
3		
4		
5		
6		

main-processing ayarını yapılandırın.
Edit butonunu tıklayın.

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification: "Not Set" Change DB Buffering No Buffering Change

DB Buffer Use Size [byte] -

Back Next OK Cancel

[Device Tag Components] 1 . . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Job Setting No.[2]' is 'PutPlan1'. The 'Main-Processing' tab is selected. A dialog box titled 'Main-Processing Action No.[1]' is open, showing 'Action Type Selection' options: 'DB Communication Action' (highlighted with a red box), 'Operation Action', and 'External Communication'. A callout box points to the 'DB Communication Action' button with the text: 'Hedef sunucuda veri girişi/çıkışı için eylemi ayarlayın. DB Communication Action butonunu tıklayın.' Below the dialog, the 'Operation Settings at Main-Processing' section shows 'At Processing Notification: "Not Set"' and 'DB Buffering: No Buffering'. The bottom status bar shows resource usage: '[Device Tag Components] 1 . . 1 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed)', '[Field/Argument used in the Project] 3 unit'.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: **Insert**

Access Table: (Add)

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Tetikleyici koşul karşılandığında yürütülecek DB Haberleşme Tipini ayarlayın. Veriler veritabanına "PutPlan1" işiyle eklendiğinden, "Insert" varsayılan ayarı kullanılır.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: (Add) ...

Data Assignment Settings

Set the assignment of the data to be input.

Data Assignment Settings

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

Verilerin eklendiği tablo adını belirleyin.
Access Table öğesini tıklayın.

[Device Tag Component used in the Project] 4 points, 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Insert

Access Table: (Add), GetPlan1.DataServer, PutPlan1.DataServer, PutPlan2.DataServer, (Add)

Data Assignment: Option

Data Assignment Settings

Set the assignment of the data to be input/output

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 4 points, 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1.DataServer

MES Interface Module Database Server

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-		
2	LoadResult	Integer	<-		
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO [ResultTable] () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Veritabanına eklenecek veri olan CPU modülünün device belleğini seçin.
PatternNo için **Assignment Data** ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1.DataServer

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	Device Tag	
2	LoadResult	Integer	<-	GettingData	
3	HeightResult	Integer	<-	PuttingData	
4	StartTime	Date and Time	<-	PatternNo	
5				ResultValueofPressFit	
				ResultValueofPressFit	
				Manufacturing	
				facturing	
11				Macro	
12					

Batch Insertion Delete

Execution SQL Statements

INSERT INTO [ResultTable] () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1.DataServer

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	[TAG]PuttingData.PatternNo	Word [Unsigned]
2	LoadResult	Integer	<-		
3	HeightResult	Integer	<-		
4	StartTime	Date and Time	<-		
5					

Daha sonra, satır No. 2 ila 4 için aşağıdaki bağlantı ayarlarını yapın.
Ayarlama işlemi "PatternNo" ile aynıdır.
Bu kursta ayarlama işlemi göz ardı edilmiştir.

Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
LoadResult	Integer	<-	[TAG]PuttingData.ResultValueofPressFittingLoad	Word [Unsigned]/Bit String [16-bit]
HeightResult	Integer	<-	[TAG]PuttingData.ResultValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]
StartTime	Date and Time [Without Time Zone]	<-	[MACRO]Job Execution Start Date and Time	Date and Time

Execution SQL Statements

```
INSERT INTO [ResultTable] ([PatternNo]) VALUES ((PuttingData.PatternNo));
```

OK Cancel

[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1:DataServer

Data Assignment Option

Data Assignment Settings

No.	Access Field	(Data Type)	<->	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	[TAG]PuttingData.PatternNo	Word [Unsigne...
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	StartTime	Date and Time ...	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
INSERT INTO [ResultTable] ([PatternNo], [LoadResult], [HeightResult], [StartTime]) VALUES ((PuttingData.PatternNo), (PuttingData.ResultValueofPressFittingLoad), (PuttingData.ResultValueofPressFittingHeight), [YYYY-MM-DD hh:mm:ss]);
```

OK Cancel

[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1.DataServer

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	[TAG]PuttingData.PatternNo	Word [Unsigne...
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	StartTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

DB communication action settings tamamlanmıştır. OK butonunu tıklayın.

Execution SQL:
INSERT INTO [PutPlan1.DataServer] ((PuttingData.P... (PuttingData.ResultValueofPressFittingHeight), [YYYY-MM-DD hh:mm:ss]);

OK Cancel

[Device Tag Component used in the Project] 4 points, 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Insert, [PutPlan1] <- [[TAG]PuttingDataPatternNo], [[TAG]PuttingData...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings

DB Buffering No Buffering Change

DB Buffer Use Size [byte] -

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Insert, [PutPlan1] <- [[TAG]PuttingDataPatternNo], [[TAG]PuttingData...
2		
3		
4		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings (optional)

DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

DB arabelleğe almayı yapılandırmak için, **Option Settings** ögesinin **DB Buffer Settings** bölümünde "Use the DB buffer 1." ögesini seçin.

DB arabelleğe almayı ayarlayın. **Change** butonunu tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

DB Buffering Setting

Select whether to buffer/not buffer the send data when the communication line with the database is disconnected.

DB Buffering No Buffering No Buffering Buffering to DBBuf1 Buffering to DBBuf2

Job Operation Setting

Set the operation to be performed

Notification Notify

No. 1

Buffering to DBBuf1 ögesini seçin.
DB arabelleğe alma işlevi, başlangıçta veritabanı sunucusu ile haberleşme hatası olduğunda MES interface modülüne takılan SD bellek kartındaki veritabanına yazılacak verileri kaydetme işlevidir.

OK Cancel

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

DB Buffering Setting

Select whether to buffer/not buffer the send data when the communication line with the database is disconnected.

DB Buffering Buffering to DBBuf1

Job Operation Settings at DB Buffering

Set the operation to be performed after executing all actions for main-processing, whenever DB buffering is executed.

Notification Notify DB Buffering

No.	Notification Destination	(Data Type)	<->	Notification Data	(Data Type)
1			<-		

OK Cancel

OK butonunu tıklayın.

Back Next OK Cancel

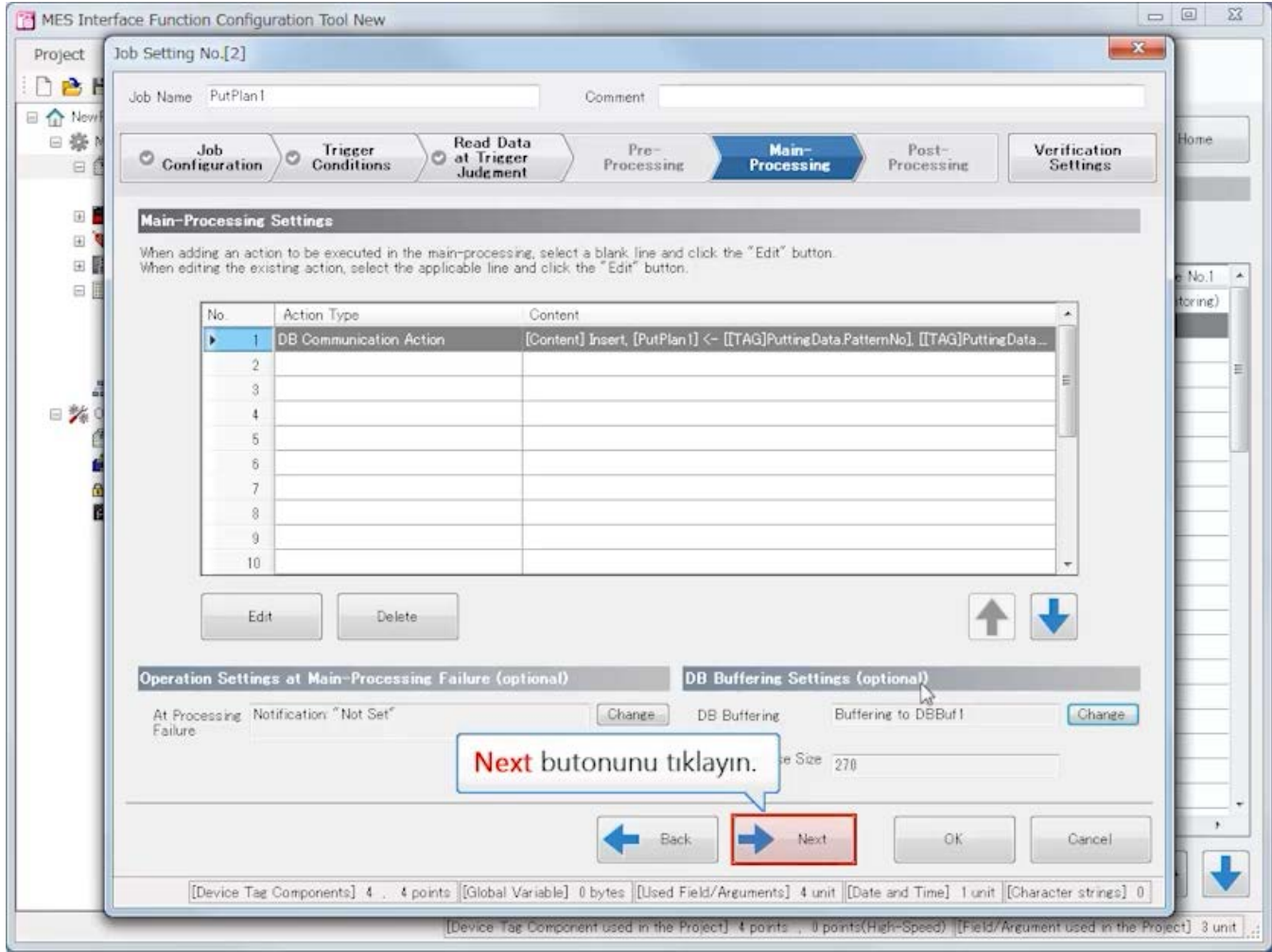
[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



MES Interface Function Configuration Tool New

Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Insert, [PutPlan1] <- [[TAG]PuttingDataPatternNo], [[TAG]PuttingData...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification "Not Set" Change DB Buffering Buffering to DBBuf1 Change

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History Not output

Detailed Log Not output

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

Verification Settings için varsayılan ayar kullanılmaktadır.
OK butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 4 points . . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot shows the MES Interface Function Configuration Tool New window. The window has a menu bar with Project, Edit, View, Online, and Help. Below the menu bar is a toolbar with various icons. On the left side, there is a tree view showing the project structure, including Main Settings, Job Settings, GetPlan, PutPlan1, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area displays the Job Setting List table. The table has columns for No., Job Name, Comment, Job Configuration, and Event/Condition Type No.1. The table contains two rows: row 1 with Job Name 'GetPlan' and row 2 with Job Name 'PutPlan1'. Row 2 is highlighted in blue. Below the table, there are 'Edit' and 'Delete' buttons. A confirmation message is displayed in a box: "PutPlan1" iş ayarı tamamlanmıştır. Sonraki sayfaya geçmek için > butonunu tıklayın. At the bottom of the window, there is a status bar with the text: [Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - GetPlan
 - PutPlan1
 - Target Device Settings
 - Device Tag Settings
 - Target Server Settings
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

"PutPlan1" iş ayarı tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

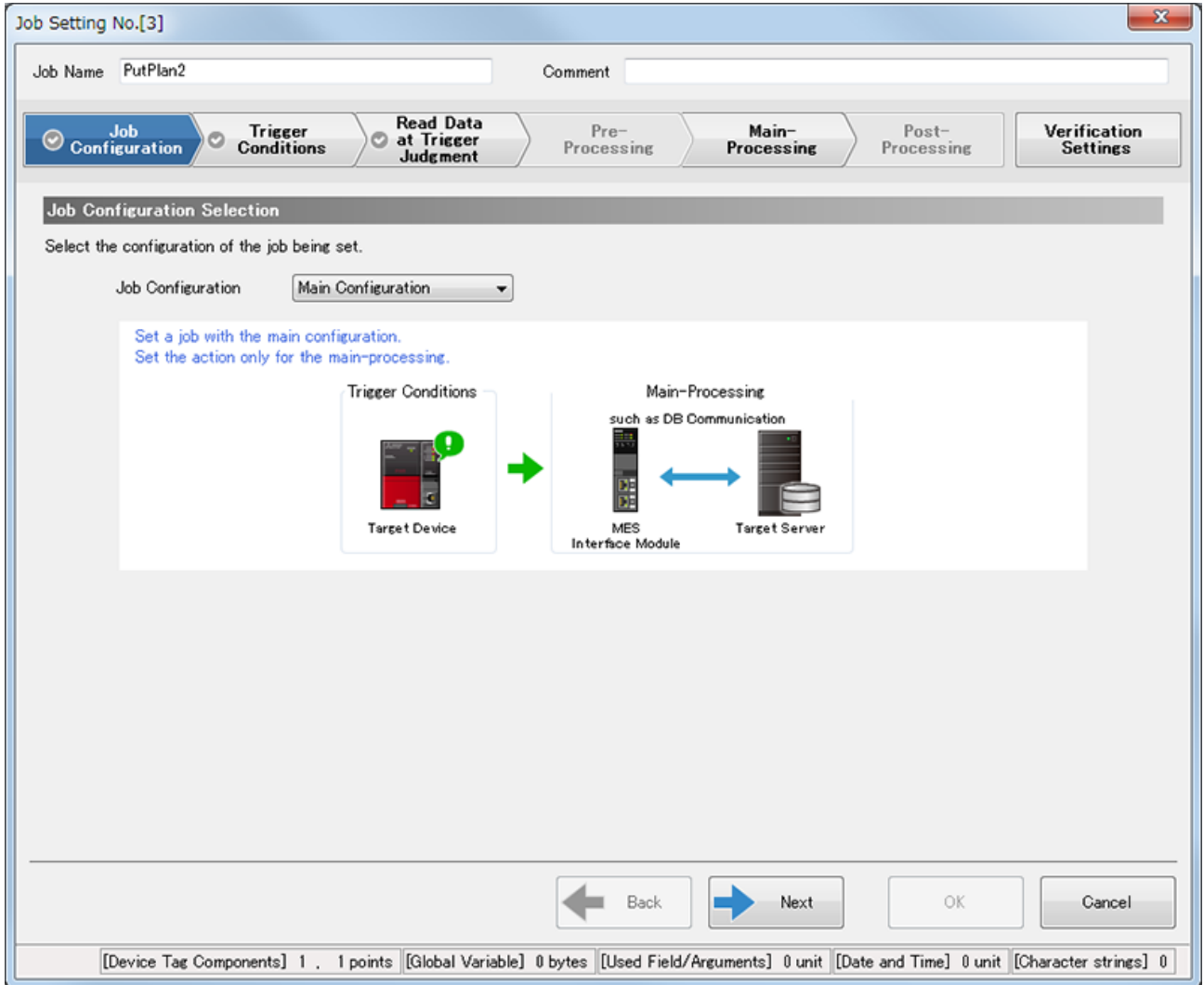
[Job Settings]

Üretim tamamlandığında veritabanının kaydındaki verileri güncelleyen bir iş oluşturun.

(3) Job Name: PutPlan2

[Job Configuration]

Job Configuration: Main Configuration



[Trigger Conditions]

- Trigger Conditions Configuration Settings
Configuration Type: Single Event
- Event/Condition Settings
Event/Condition Type: Condition (Value Monitoring)

Monitoring target	(Data type)	Comparing condition	Comparing target	(Data type)
[TAG]PuttingData.EndManufacturing	Bit	=	[INT]1	

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type: The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Condition Combination Type:

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]PuttingData.Endmanufactu...

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering: When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

[Device Tag Components] 1 . 1 points
[Global Variable] 0 bytes
[Used Field/Arguments] 0 unit
[Date and Time] 0 unit
[Character strings] 0

[Read Data at Trigger Judgment]

- Access Type Selection
Access Type: General Access
- Access Interval Settings
Access Interval: Seconds Specification/1s
- Reading Target Data Setting (optional)
Reading Target Data: The Data to be used in Trigger Condition only

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration
 Trigger Conditions
 Read Data at Trigger Judgment
 Pre-Processing
 Main-Processing
 Post-Processing
 Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type General Access

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.

Target Device MES Interface Module Network

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval Seconds Specification 1 s
 Milliseconds Specification 1 * 100 ms

Reading Target Data Setting (optional)

Reading Target Data The Data to be used in Trigger Condition only Change

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Main-Processing]

• Main-Processing Settings

Action Type : DB Communication Action
DB Communication Type : Update
Access Table : PutPlan2.Database

Data Assignment sekmesi

Access Field	(Data type)	↔	Assigned data	(Data type)
PatternNo	Integer	←	-	Word [Unsigned]/Bit String [16-bit]
LoadResult	Integer	←	[TAG]PuttingData.ResultValueofPressFittingLoad	Word [Unsigned]/Bit String [16-bit]
HeightResult	Integer	←	[TAG]PuttingData.ResultValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]
EndTime	Date and Time [Without Time Zone]	←	[MACRO]Job Execution Start Date and Time	Date and Time

Narrowing-Down Condition sekmesi

Combination	Access Field	(Data type)	Comparing condition	Comparing target	(Data type)
	PatternNo	Integer	=	[TAG]GettingData.PatternNo	Word [Unsigned]/Bit

					String [16-bit]
AND	LoadResult	Integer	=	[INT]0	
AND	HeightResult	Integer	=	[INT]0	

- DB Buffering Settings (optional)
DB Buffering: Buffering to DBBuf2

DB arabelleğe almayı yapılandırmak için, [Option Settings] içindeki [DB Buffer Settings] ayarlarında "Use the DB buffer 2." seçeneğini kullanın.

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Update, [PutPlan2] <- [[TAG]PuttingData.ResultValueofPressFittingLoa...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional) **DB Buffering Settings (optional)**

At Processing Failure Notification: "Not Set" Change DB Buffering Buffering to DBBuf2 Change

DB Buffer Use Size [byte] 350

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Verification Settings]

- Working History Settings (optional)
Working History: Not output
- Data Output Inhibition Necessity Settings (optional)
Inhibit the data output to the target device : Seçmeyin
Inhibit the data output to the target server : Seçmeyin
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: Seçmeyin

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History Not output

Detailed Log Not output

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool' window. The title bar shows the file path 'E:\RnMTCPU\b.mu2'. The menu bar includes 'Project', 'Edit', 'View', 'Online', and 'Help'. A toolbar with various icons is located below the menu. On the left, a tree view shows the project structure, with 'Job Settings' selected. The main area is titled 'Job Setting List' and contains a table with the following columns: 'No.', 'Configuration', and 'Event/Condition Type No.1'. The table has 21 rows, with row 2 selected. A tooltip with the text 'Oynat butonunu tıklayın.' is visible over the table. Below the table are 'Edit' and 'Delete' buttons, and a 'Home' button in the top right. At the bottom, a status bar shows project details: '[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit ...'.

MES Interface Function Configuration Tool E:\RnMTCPU\b.mu2

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - GetPlan
 - PutPlan1
- Target Device Settings
- Device Tag Settings
- Target Server Settings
- Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
- Network Settings
- Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Configuration	Event/Condition Type No.1
2	PutPlan1	Main Configuration
3		Condition (Value Monitoring)
4		
5		
6		
7		
8		
9		
10		
11		
12		
13		
14		
15		
16		
17		
18		
19		
20		
21		

Edit Delete

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit ...

Geri

İleri

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - GetPlan
 - PutPlan1
 - Target Device Settings
 - Device Tag Settings
 - Target Server Settings
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Daha sonra, üçüncü iş ayarını yapılandırın.
Job Setting List içindeki **satır No. 3**'ü tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', etc. The main area displays a 'Job Setting List' table with columns: No., Job Name, Comment, Job Configuration, and Event/Condition Type No.1. A context menu is open over row 3, showing options: Edit, Delete, Add, and One. A tooltip message reads: 'Yeni iş ayarı oluşturmak için Edit seçin. Menüdeki Edit öğesini tıklayın.' Below the table are 'Edit' and 'Delete' buttons. The status bar at the bottom shows project details.

Project Edit View Online Help

Job Setting List

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit
Delete
Add
One

Yeni iş ayarı oluşturmak için Edit seçin.
Menüdeki Edit öğesini tıklayın.

Edit Delete

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[3]

Job Name Job01 Comment

Job Configuration

Job Configuration Set

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Üretim tamamlandığında veritabanının kaydındaki verileri güncelleyen bir iş oluşturun.
Job Name ögesini tıklayın.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 0 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

Set a job with the main configuration.
Set the action only for the main configuration.

Ayarlanmakta olan iş konfigürasyonunu seçin.
Job Configuration öğesini tıklayın.

Target Device → MES Interface Module ↔ Target Server

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[3]' and contains several tabs: 'Job Configuration', 'Trigger Conditions', 'Read Data at Trigger Judgment', 'Pre-Processing', 'Main-Processing', 'Post-Processing', and 'Verification Settings'. The 'Job Configuration' tab is active, showing a 'Job Configuration Selection' section. This section includes a 'Job Configuration' dropdown menu with 'Main Configuration' selected. Below the dropdown, there is a diagram illustrating the configuration process: 'Target Device' (represented by a red and black device icon) is connected via a green arrow to 'MES Interface Module' (represented by a server rack icon), which is then connected via a blue double-headed arrow to 'Target Server' (represented by a server rack icon). A text box above the diagram reads 'Main Configuration seçin.' (Select Main Configuration). The diagram also includes the text 'such as DB Communication' above the MES Interface Module. At the bottom of the window, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage statistics: '[Device Tag Components] 0 / 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', '[Device Tag Component used in the Project] 8 points / 0 points(High-Speed)', and '[Field/Argument used in the Project] 7 unit'.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration: Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Veritabanında verileri güncelleme zamanlamasını belirtmek için **Trigger Conditions** ayarlarını yapılandırın.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration: Main Configuration

Set a job with the main configuration.
Set the action only for the main-processing.

Trigger Conditions Main-Processing
such as DB Communication

Veritabanında verileri güncelleme zamanlamasını belirtmek için **Trigger Conditions** ayarlarını yapılandırın.

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Configuration Type öğesini tıklayın.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Edit Delete

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type **Single Event**

Condition Combination Type Multiple Events Condition Co Precondition

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Belirtilen bir olayın meydana gelmesini tetikleyici olarak ayarlamak için **Single Event** seçin.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition. In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1			

Olayı/koşulu ayarlayın. Edit butonunu tıklayın.

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger conditions are satisfied at the same time.

Trigger Buffering Disable

When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[3]' and contains fields for 'Job Name' (PutPlan2) and 'Comment'. A modal dialog box titled 'Event/Condition Setting No.[1]' is open in the foreground. The dialog is divided into two sections: 'Event/Condition Type Common Settings' and 'Event/Condition Type Individual Settings'. In the 'Common Settings' section, the 'Event/Condition Type' dropdown is set to 'Condition (Value Monitoring)'. A tooltip explains that the value of the monitoring target and comparison target are compared, and the result is true or false. A red callout box with the text 'Event/Condition Type öğesini tıklayın.' points to the dropdown menu. The 'Detail Type' is set to 'Timer Interval'. The 'Individual Settings' section includes a table for defining monitoring targets and conditions.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

At the bottom of the dialog, there are 'OK' and 'Cancel' buttons. The main window also has 'Back' and 'Next' navigation buttons, and a status bar at the bottom showing resource usage statistics.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'Event/Condition Setting No.[1]' dialog box within the 'Job Setting No.[3]' window. The dialog is titled 'Event/Condition Type Common Settings' and instructs the user to 'Select the event/condition type and the detail type.' The 'Event/Condition Type' dropdown menu is open, showing a list of options: 'Condition (Value Monitoring)', 'Event (Value Changed)', 'Event (Fixed Time)', 'Event (Fixed Cycle)', 'Event (Module Monitor)', and 'Handshake'. The 'Condition (Value Monitoring)' option is highlighted in blue. A text box to the right of the dropdown explains: 'The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.' Below the dropdown, the 'Event/Condition Type In' section is partially visible, with the instruction 'Set the monitoring target, comparison target and co'. A table with the following structure is shown:

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

At the bottom of the dialog, there are 'OK' and 'Cancel' buttons. A red callout box with white text points to the 'Condition (Value Monitoring)' option, stating: 'Event/Condition Type listesinden "Condition (Value Monitoring)" seçin.' The background window shows 'Job Name: PutPlan2' and 'Comment:'. At the bottom of the main window, there are 'Back' and 'Next' navigation buttons, and a status bar with the following information: '[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0 [Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings
Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target (Data Type)	Condition	Comparison Target (Data Type)
	=	

Koşulu, device tag ayarında yapılandırılan ayarları kullanarak ayarlayın.
Monitoring Target ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
		=		

Device Tag

- GettingData
- PuttingData
- PatternNo
- ResultValueofPressFitting
- ResultValueofPressFitting
- StartManufacturing
- EndManufacturing
- [Edit]

[Add]

Variable

"Üretim tamamlandı (M2) açıldığında" ayarını yapılandırın.
Monitoring Target listesinden "PuttingData" öğesine ait
"EndManufacturing" öğesini tıklayın.

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[3]' and contains fields for 'Job Name' (PutPlan2) and 'Comment'. A dialog box titled 'Event/Condition Setting No.[1]' is open in the foreground. The dialog box is divided into two sections: 'Event/Condition Type Common Settings' and 'Event/Condition Type Individual Settings'. In the 'Common Settings' section, 'Event/Condition Type' is set to 'Condition (Value Monitoring)' and 'Detail Type' is set to 'Timer Interval'. A text box explains: 'The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.' The 'Individual Settings' section contains a table with the following data:

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData.EndM.	Bit	=		

A red box highlights the '=' symbol in the 'Condition' column. A callout box with the text 'Condition öğesini tıklayın.' (Click the condition element.) points to this symbol. At the bottom of the dialog box are 'OK' and 'Cancel' buttons. The main window also has 'Back' and 'Next' buttons at the bottom. The status bar at the bottom of the main window shows resource usage: '[Device Tag Components] 0 . . 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed)', '[Field/Argument used in the Project] 7 unit'.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type Condition (Value Monitoring)

Detail Type Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData EndM...	Bit	=		

Condition listesinden "=" ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings
Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData EndM...	Bit	=		

Comparison Target ögesini tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Event/Condition Setting No.[1]

Event/Condition Type Common Settings
Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)
Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings
Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData EndM...	Bit	=		

Comparison Target list options:
Device Tag
Variable
Constant
Integer
Real Number
Character String (Unicode)

Comparison Target listesinden "Integer" ögesini tıklayın.

OK Cancel

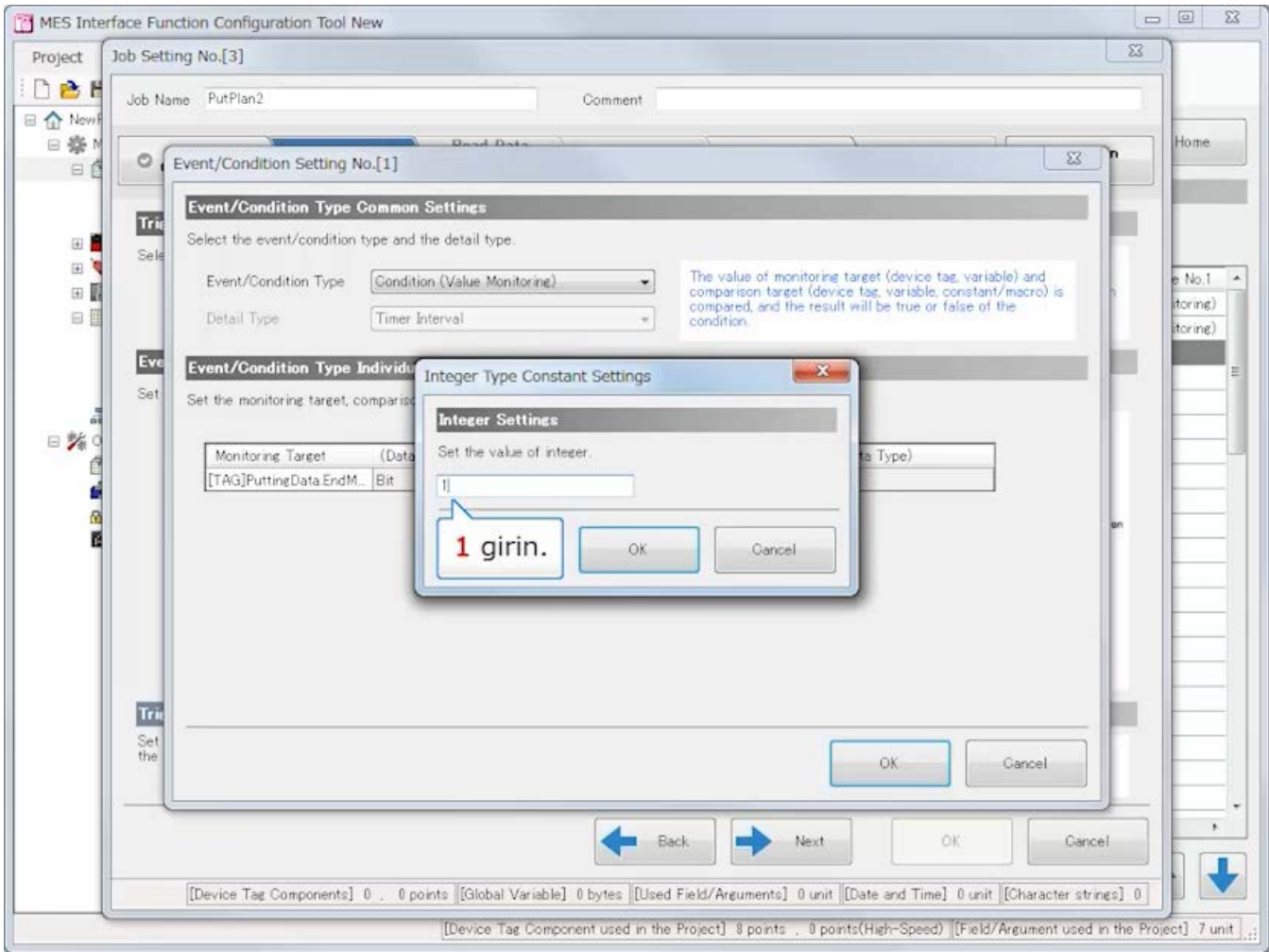
Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0
[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

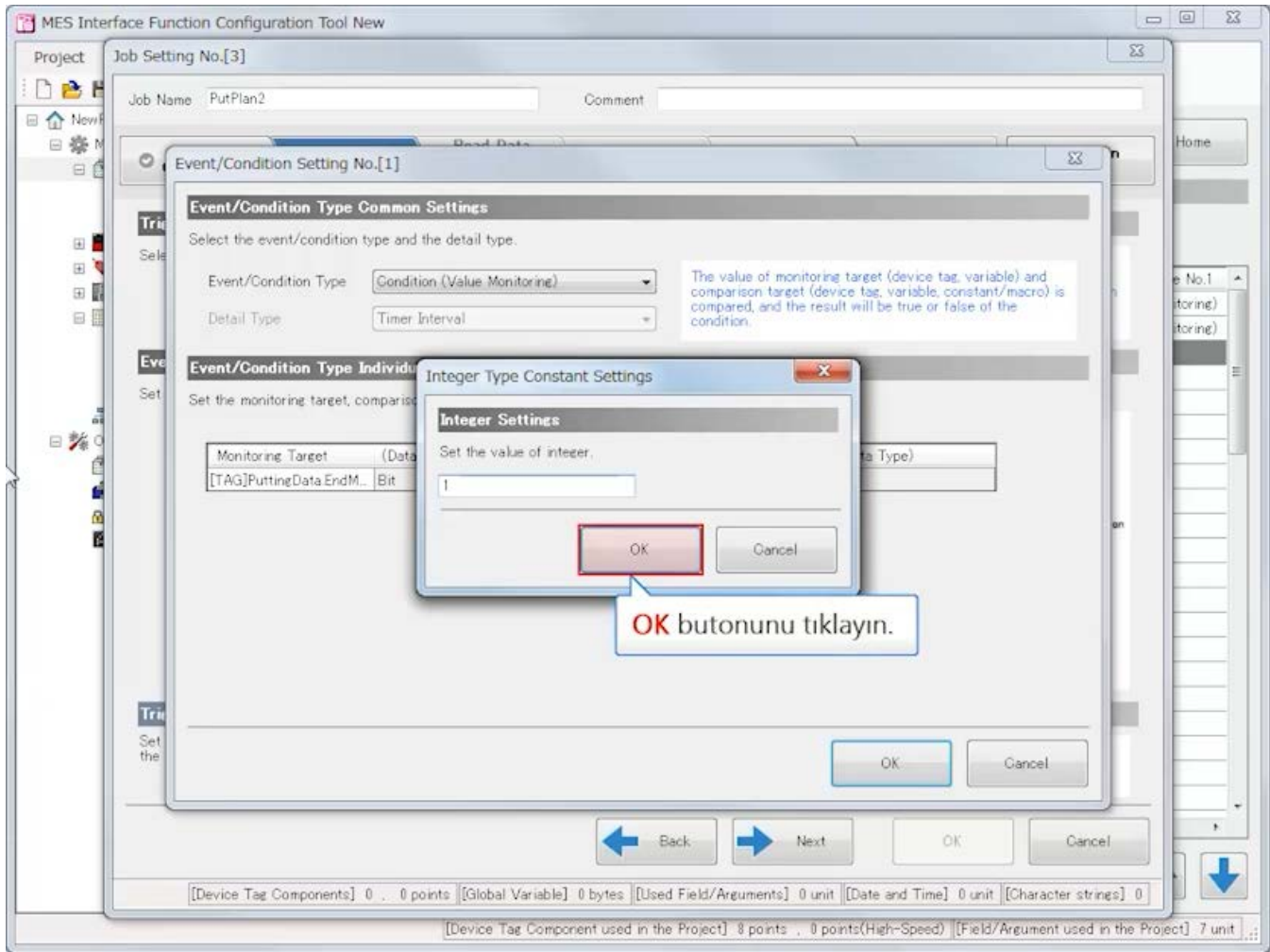
İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri



3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

The value of monitoring target (device tag, variable) and comparison target (device tag, variable, constant/macro) is compared, and the result will be true or false of the condition.

Event/Condition Type Individual Settings

Set the monitoring target, comparison target and condition that satisfy the condition.

Monitoring Target	(Data Type)	Condition	Comparison Target	(Data Type)
[TAG]PuttingData EndM...	Bit	=	[DNT]	

OK butonunu tıklayın.

OK Cancel

Back Next OK Cancel

[Device Tag Components] 0 . . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type Single Event

Condition Combination Type AND Combination

The timing of the specified event occurrence is considered as the satisfaction of the trigger condition.
In the case of using the condition, the timing of the condition satisfaction is considered as the event occurrence.

Event/Condition Settings

Set each event/condition to be used at Trigger Judgment.

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]PuttingData.EndManufactu...

Edit Delete

Trigger Buffering Setting (optional)

Set the operation of the job whenever the trigger the same time.

Trigger Buffering Disable

Next butonunu tıklayın.

if the trigger condition of the same job is satisfied
the job, the satisfied trigger condition will be

Back Next OK Cancel

[Device Tag Components] 1 / 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points / 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

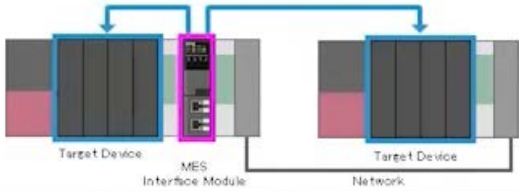
Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

Access Type Selection

Select the data reading method to be used at trigger judgment.

Access Type General Access

For "General Access", accessing to all access target devices is possible.
When the number of pieces of data is large, the data may become inconsistent.



Target Device MES Interface Module Target Device Network

Access Interval Settings

Set the interval to read the data used at trigger judgment.

Access Interval Seconds Specification 1 s Milliseconds Specification 1 * 100 ms

Read Data at Trigger Judgment için varsayılan ayarı kullanın.
Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1		
2		
3		
4		
5		
6		

main-processing ayarını yapılandırın.
Edit butonunu tıklayın.

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification: "Not Set" Change DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 1 . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 3 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the MES Interface Function Configuration Tool New window. The main window is titled "Job Setting No.[3]" and shows a "Job Name" of "PutPlan2". The "Main-Processing" tab is selected, and the "Main-Processing Settings" section is active. A dialog box titled "Main-Processing Action No.[1]" is open, showing an "Action Type Selection" window. The "DB Communication Action" button is highlighted with a red box. A callout box points to this button with the text: "Hedef sunucuda veri giriři/çıkıřı için eylemi ayarlayın. DB Communication Action butonunu tıklayın." The dialog box also includes an "Operation Action" button, an "External Comm" button, and a "Place the cursor" button. The "DB Buffering" section is set to "No Buffering" and the "DB Buffer Use Size [byte]" is set to "-". The "At Processing Failure" notification is set to "Not Set". The "Back", "Next", "OK", and "Cancel" buttons are visible at the bottom of the dialog box. The status bar at the bottom of the main window shows resource usage: "[Device Tag Components] 1 . . 1 points", "[Global Variable] 0 bytes", "[Used Field/Arguments] 0 unit", "[Date and Time] 0 unit", "[Character strings] 0", "[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed)", and "[Field/Argument used in the Project] 7 unit".

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, click the "Edit" button.

No. Action Type

1	
2	
3	
4	
5	
6	
7	
8	
9	
10	

Edit

Operation Settings at Main-Processing

At Processing Failure Notification "Not Set" Change DB Buffering No Buffering Change

DB Buffer Use Size [byte] -

Back Next OK Cancel

[Device Tag Components] 1 . . 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: **Insert**

Access Table: (Add)

Data Assignment Option

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert, Select, Import, **Update**, Delete, Multiple, Stored

Access Table: ...

Data Assignment: Option

Data Assignment Settings

Set the assignment of the data to be imported.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements: INSERT INTO () VALUES ();

OK Cancel

[Device Tag Component used in the Project] 8 points, 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: (Add)

Data Assignment Settings

Set the assignment of the data to be in

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Execution SQL Statements

UPDATE SET ;

OK Cancel

Verilerin güncelleneceği tablo adını belirleyin.
Access Table öğesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: (Add)

Data Assignment: Narrowing-Down

Data Assignment Settings

Set the assignment of the data to be input.

Access Table listesinden "PutPlan2.DataServer" ögesini seçin.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

UPDATE SET ;

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment: Narrowing-Down Conditions | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-		
2	LoadResult	Integer	<-		
3	HeightResult	Integer	<-		
4					
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete Up Down

Execution:SQL Statements
UPDATE [ResultTable] SET ;

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Veritabanında güncellenecek veri olan CPU modülünün cihaz belleğini seçin.
LoadResult için Assignment Data öğesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment: Narrowing-Down Conditions | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-		
2	LoadResult	Integer	<-		
3	HeightResult	Integer	<-		
4	EndTime	Date and Time	<-		
5					
6					

Device Tag

- GettingData
- PuttingData
- PatternNo
- ResultValueofPressFit
- ResultValueofProcessFittingLoad
- ResultValueofPressFittingLoad
- ResultValueofPressFittingLoad

Batch Insertion Delete

Execution.SQL Statements

UPDATE [ResultTable] SET ;

OK Cancel

[Device Tag Component used in the Project] 8 points | 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

D200 sinyali, device tag settingsnda "ResultValueofProcessFittingLoad" bileşeni olarak ayarlandığından, **Assignment Data** listesinden "**PuttingData**" bölümünde **ResultValueofPressFittingLoad** ögesini tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment: Narrowing-Down Conditions | Option | Exception

Data Assignment Settings

Set the assignment of the data to be input/output in DB communication.

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo.	Integer	<-		
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	EndTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss];
```

OK Cancel

[Device Tag Component used in the Project] 8 points, 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment: **Narrowing-Down Conditions** | Option | Exception

Data Assignment Settings

Set the assignment of the

No.	Access				
1	PatternN				
2	LoadResu				
3	HeightRes	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	EndTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss];

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Diagram: MES Interface Module ↔ Database Server

Execution SQL Statements:

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss];
```

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1						
2						
3						
4						
5						
6						
7						
8						

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1						
2		PatternNo				
3		LoadResult				
4		HeightRe				
5		EndTime				
6						
7						
8						

Batch Insertion | Delete

↑ | ↓

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss];
```

OK | Cancel

[Device Tag Component used in the Project] 8 points | 0 points(High-Speed) | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion | Delete

↑ ↓

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [Result Table] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = ?
```

Condition listesinden "=" öğesini tıklayın.

OK Cancel

[Device Tag Component used in the Project] 8 points, 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	PuttingData	
2						
3						
4						
5						

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = ?
```

[Device Tag Component used in the Project] 3 points | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo).
```

OK Cancel

[Device Tag Component used in the Project] 8 points 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND					
3	OR					
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo).
```

OK Cancel

[Device Tag Component used in the Project] 8 points 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND			=		
3						
4						
5						
6						
7						
8						

Batch Insertion | Delete

↑ ↓

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo).
```

OK Cancel

[Device Tag Component used in the Project] 8 points | 0 points(High-Speed) | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult		=		
3		HeightResult				
4		EndTime				
5						
6						
7						
8						

Access Field listesinden "LoadResult" öğesini tıklayın.

Execution SQL Statements

```
UPDATE [Result Table] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo).
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=		
3						
4						
5						
6						
7						
8						

Batch Insertion | Delete

↑ ↓

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = '[YYYY-MM-DD hh:mm:ss]' WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | **Narrowing-Down Conditions** | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer			
3						
4						
5						
6						
7						
8						

Batch Insertion | Delete

Execution SQL Statements

```
UPDATE [Result Table] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = '[YYYY-MM-DD hh:mm:ss]' WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] ? ?
```

OK | Cancel

[Device Tag Component used in the Project] 8 points | 0 points(High-Speed) | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=		
3						
4						
5						
6						
7						
8						

Device tag belirtmek yerine, doğrudan sayısal değeri belirtin.
Comparison Target ögesini tıklayın.

Batch Insertion Delete

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = '[YYYY-MM-DD hh:mm:ss]' WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=		
3						
4						
5						
6						

Comparison Target options: Device Tag, Variable, Constant, Integer, Number, Enter String (Unicode)

LoadResult için önceden "0" yazıldığından, üretimin sonunda kaydı LoadResult "0" ile günceller. Bu işe sonuç değerinin zaten sıfırlandığı kaydın üzerine yazılmasını önler. **Comparison Target** listesinden "Integer" öğesini tıklayın.

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = '[YYYY-MM-DD hh:mm:ss]' WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'DB Communication Action Setting' and contains the following sections:

- DB Communication Action Settings:** Includes 'DB Communication Type' set to 'Update' and 'Access Table' set to 'PutPlan2DataServer'. A diagram shows the 'MES Interface Module' connected to a 'Database Server'.
- Data Assignment:** Includes tabs for 'Narrowing-Down Conditions', 'Option', and 'Exception'.
- Narrowing-Down Condition Settings:** A table for setting narrowing-down conditions for target records. The table has columns for 'No.', 'Combination', and 'Acc'. Row 2 is selected with 'AND' in the 'Combination' column.
- Integer Type Constant Settings:** A dialog box is open, titled 'Integer Settings', with the text 'Set the value of integer.' and a text input field containing '0'. The dialog also features the 'ogirin.' logo and 'OK' and 'Cancel' buttons.
- Execution SQL Statements:** A text area showing an SQL update statement: `UPDATE [ResultTable] SET [LoadResult] = <PuttingData.ResultValueofPressFittingLoad>, [HeightResult] = <PuttingData.ResultValueofPressFittingHeight>, [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = <PuttingData.PatternNo> AND [LoadResult] = ?;`

At the bottom of the window, there is a status bar with the text: '[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit ...'

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Acc	PatternNo	(Data Type)
1				
2	AND	Load		Word [Unsig...
3				
4				
5				
6				
7				
8				

Batch Insertion | Delete

Integer Type Constant Settings

Integer Settings

Set the value of integer.

0

OK | Cancel

OK butonunu tıklayın.

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = <PuttingData.ResultValueofPressFittingLoad>, [HeightResult] = <PuttingData.ResultValueofPressFittingHeight>, [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = <PuttingData.PatternNo> AND [LoadResult] = ?
```

OK | Cancel

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Option Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=	[INT]0	
3						

Daha sonra, aşağıdaki tabloda yer alan değerleri üçüncü koşula ekleyin.
Ayarlama işlemi "LoadResult" ile aynıdır.
Bu kursta ayarlama işlemi göz ardı edilmiştir.

Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
AND	HeightResult	Integer	=	[INT]0	

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = ([PuttingData.ResultValueofPressFittingLoad], [HeightResult] = ([PuttingData.ResultValueofPressFittingHeight], [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = ([PuttingData.PatternNo] AND [LoadResult] = 0;
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=	[INT]0	
3	AND	HeightResult	Integer	=	[INT]0	
4						
5						
6						
7						
8						

Batch Insertion | Delete

↑ ↓

Narrowing-Down Condition kaydı tamamlanmıştır.

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] = 0 AND [HeightResult] = 0.
```

OK Cancel

[Device Tag Component used in the Project] 8 points | 0 points(High-Speed) | [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

Set the narrowing-down conditions for the target records for DB communication.

No.	Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
1		PatternNo	Integer	=	[TAG]PuttingData PatternNo	Word [Unsig...
2	AND	LoadResult	Integer	=	[INT]0	
3	AND	HeightResult	Integer	=	[INT]0	
4						
5						
6						
7						
8						

Batch Insertion Delete

DB Communication Action Settings tamamlanır.
OK butonunu tıklayın.

Execution SQL Statement
UPDATE [ResultTable]
= ([PuttingData ResultY
[PatternNo]) = ([PuttingData PatternNo]) AND ([LoadResult] = 0) AND ([HeightResult] = 0,

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name Job01 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Update, [PutPlan2] <- [[TAG]PuttingData.ResultValueofPressFittingLoa...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification "Not Set" Change DB Buffering No Buffering **Change**

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

DB arabelleğe almayı ayarlayın.
Change butonunu tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name Job01 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Update, [PutPlan2] <- [[TAG]PuttingData.ResultValueofPressFittingLoa...
2		
3		
4		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings (optional)

DB Buffering No Buffering Change

DB Buffer Use Size [byte] -

Back Next OK Cancel

[Device Tag Components] 4 / 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 3 points / 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

DB arabelleğe almayı yapılandırmak için, **Option Settings** ögesinin **DB Buffer Settings** bölümünde "Use the DB buffer 2." ögesini seçin.

DB arabelleğe almayı ayarlayın. **Change** butonunu tıklayın.

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

DB Buffering Setting

Select whether to buffer/not buffer the send data when the communication line with the database is disconnected.

DB Buffering No Buffering Buffering to DBBuf1 Buffering to DBBuf2

Job Operation Setting

Set the operation to be performed when the operation is executed.

Notification Notify

No.	Notification Destination	(Data Type)	<=>	Notification Data	(Data Type)
1			<-		

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

DB Buffering Setting

Select whether to buffer/not buffer the send data when the communication line with the database is disconnected.

DB Buffering Buffering to DBBut2

Job Operation Settings at DB Buffering

Set the operation to be performed after executing all actions for main-processing, whenever DB buffering is executed.

Notification Notify DB Buffering

No.	Notification Destination	(Data Type)	<->	Notification Data	(Data Type)
1			<-		

OK Cancel

OK butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing **Main-Processing** Post-Processing Verification Settings

Main-Processing Settings

When adding an action to be executed in the main-processing, select a blank line and click the "Edit" button.
When editing the existing action, select the applicable line and click the "Edit" button.

No.	Action Type	Content
1	DB Communication Action	[Content] Update, [PutPlan2] <- [[TAG]PuttingData.ResultValueofPressFittingLoa...
2		
3		
4		
5		
6		
7		
8		
9		
10		

Edit Delete

Operation Settings at Main-Processing Failure (optional) DB Buffering Settings (optional)

At Processing Failure Notification: "Not Set" Change DB Buffering Buffering to DBBuf? Change

Size 350

Next butonunu tıklayın.

Back Next OK Cancel

[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

3.4 MES interface function configuration tool Ayarlama (Job Settings)

Geri

İleri

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

Job Configuration Trigger Conditions Read Data at Trigger Judgment Pre-Processing Main-Processing Post-Processing Verification Settings

Working History Settings (optional)

Set the output necessity of the working history (job execution history) and the detailed log (execution history of each action of the job).

Working History Not output

Detailed Log Not output

Data Output Inhibition Necessity Settings (optional)

Set the settings for inhibiting the data output to avoid affecting to the database and target device at the job operation verification.

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

Inhibit the job execution even when the trigger condition is satisfied.

Verification Settings için varsayılan ayar kullanılmaktadır. OK butonunu tıklayın.

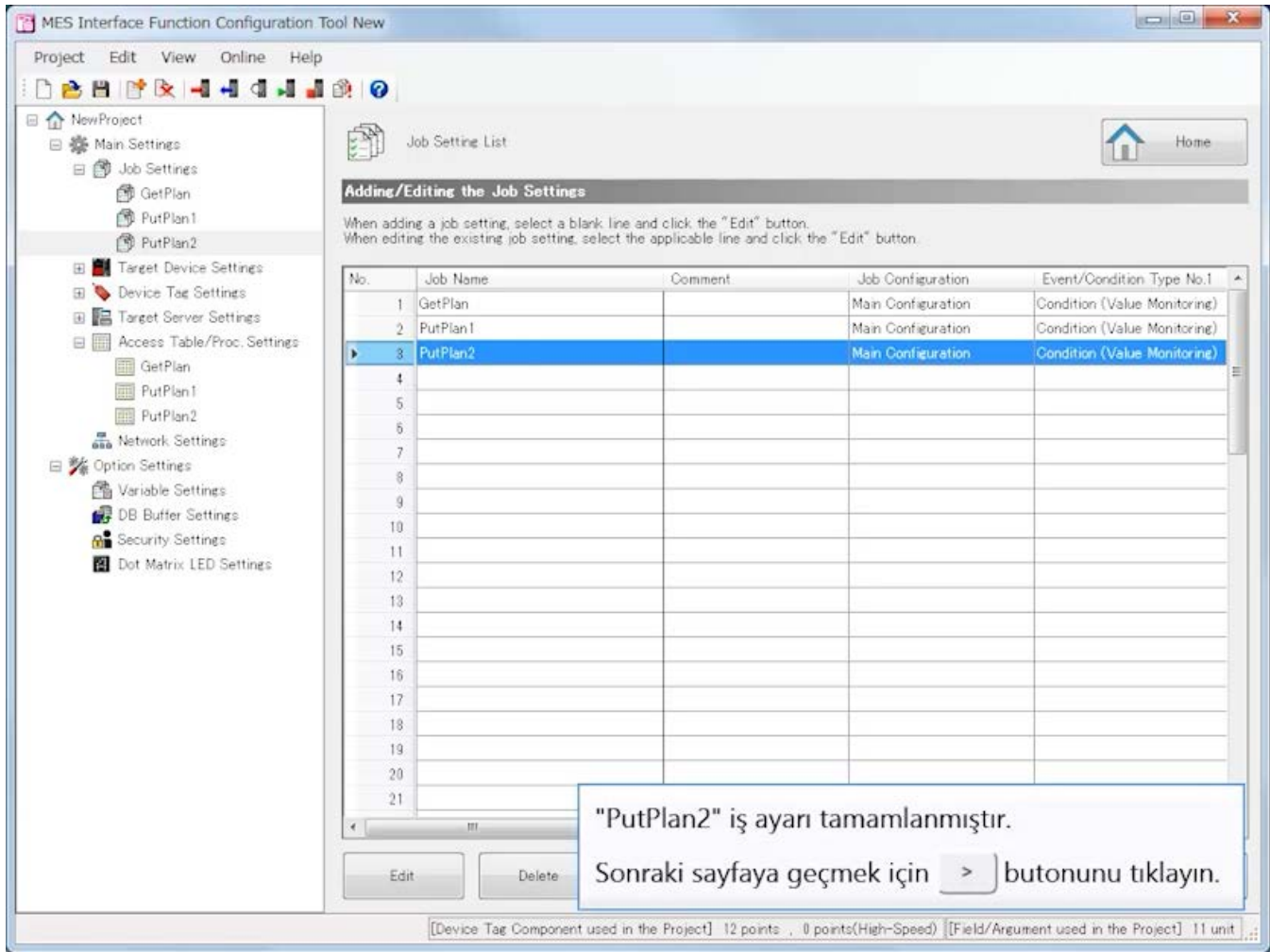
Back Next OK Cancel

[Device Tag Components] 4 . . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Geri

İleri



MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
 - Target Device Settings
 - Device Tag Settings
 - Target Server Settings
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - PutPlan2
 - Network Settings
 - Option Settings
 - Variable Settings
 - DB Buffer Settings
 - Security Settings
 - Dot Matrix LED Settings

Job Setting List

Home

Adding/Editing the Job Settings

When adding a job setting, select a blank line and click the "Edit" button.
When editing the existing job setting, select the applicable line and click the "Edit" button.

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3	PutPlan2		Main Configuration	Condition (Value Monitoring)
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

"PutPlan2" iş ayarı tamamlanmıştır.
Sonraki sayfaya geçmek için > butonunu tıklayın.

[Device Tag Component used in the Project] 12 points , 0 points(High-Speed) [[Field/Argument used in the Project] 11 unit

Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klipi kontrol edin.)**

Oynat butonunu tıklayın.

Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klipi kontrol edin.)**

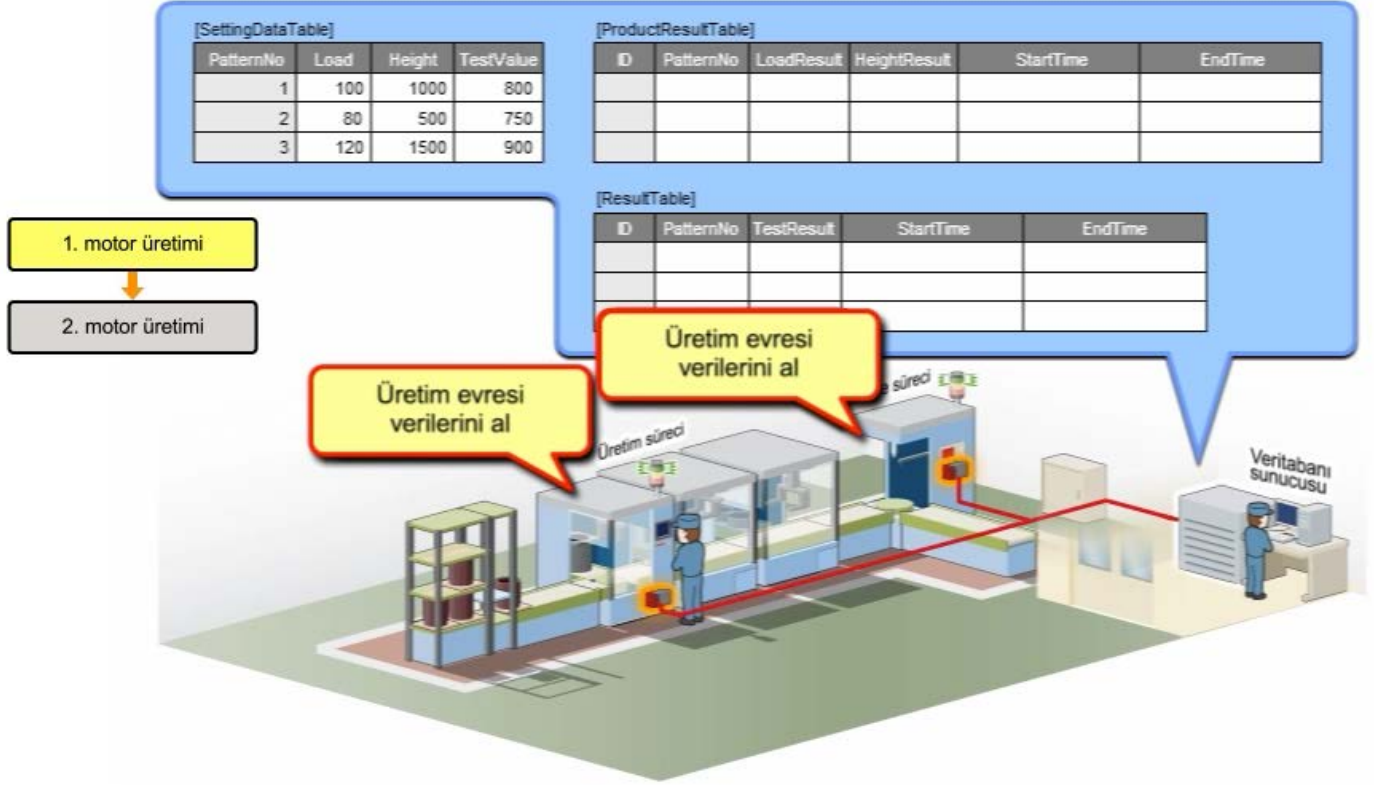
Bir ekipman bölümünde MES interface modülünü kullanarak CPU modülünün device memory ve veritabanının tablosunu bağlamayı öğrendiniz.

Bu kısımda, birden fazla makinede işletilen sistem örneğini göreceksiniz.

Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

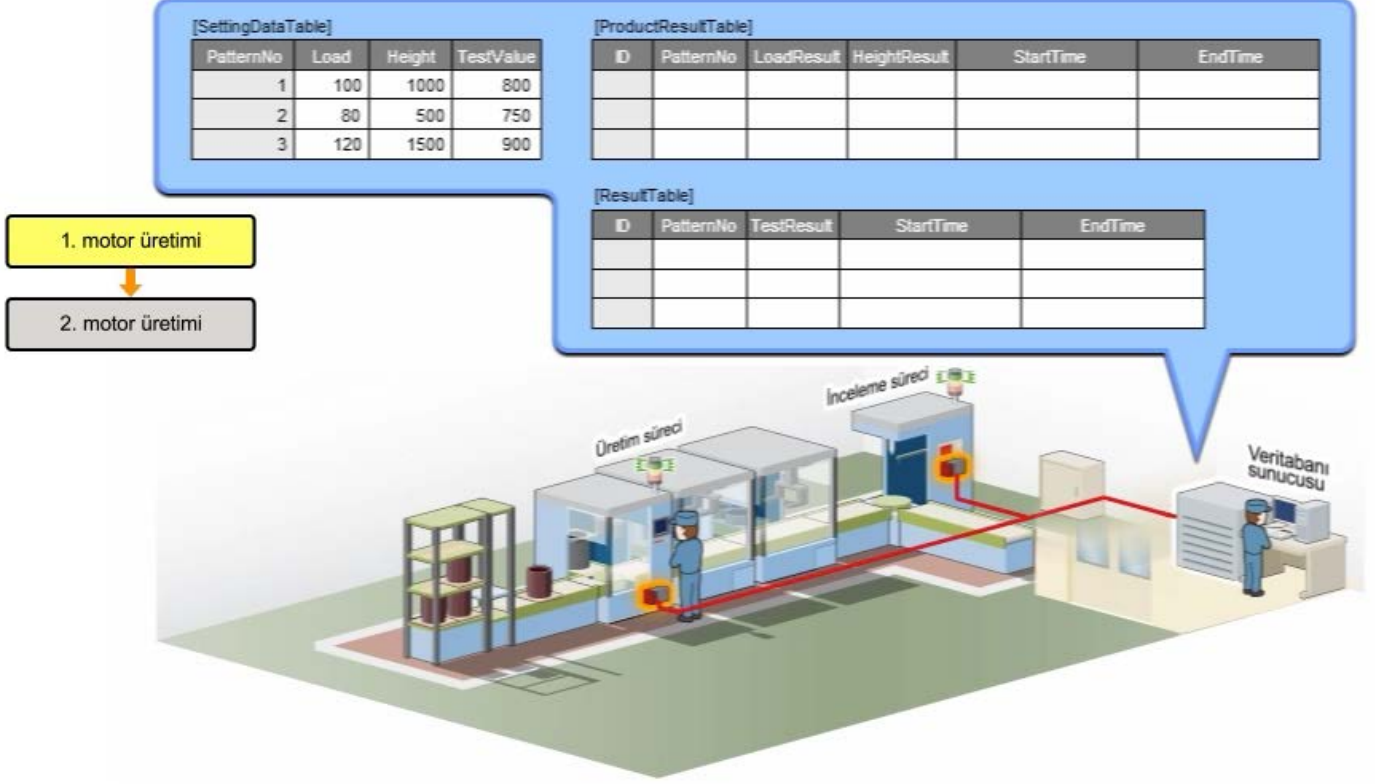
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



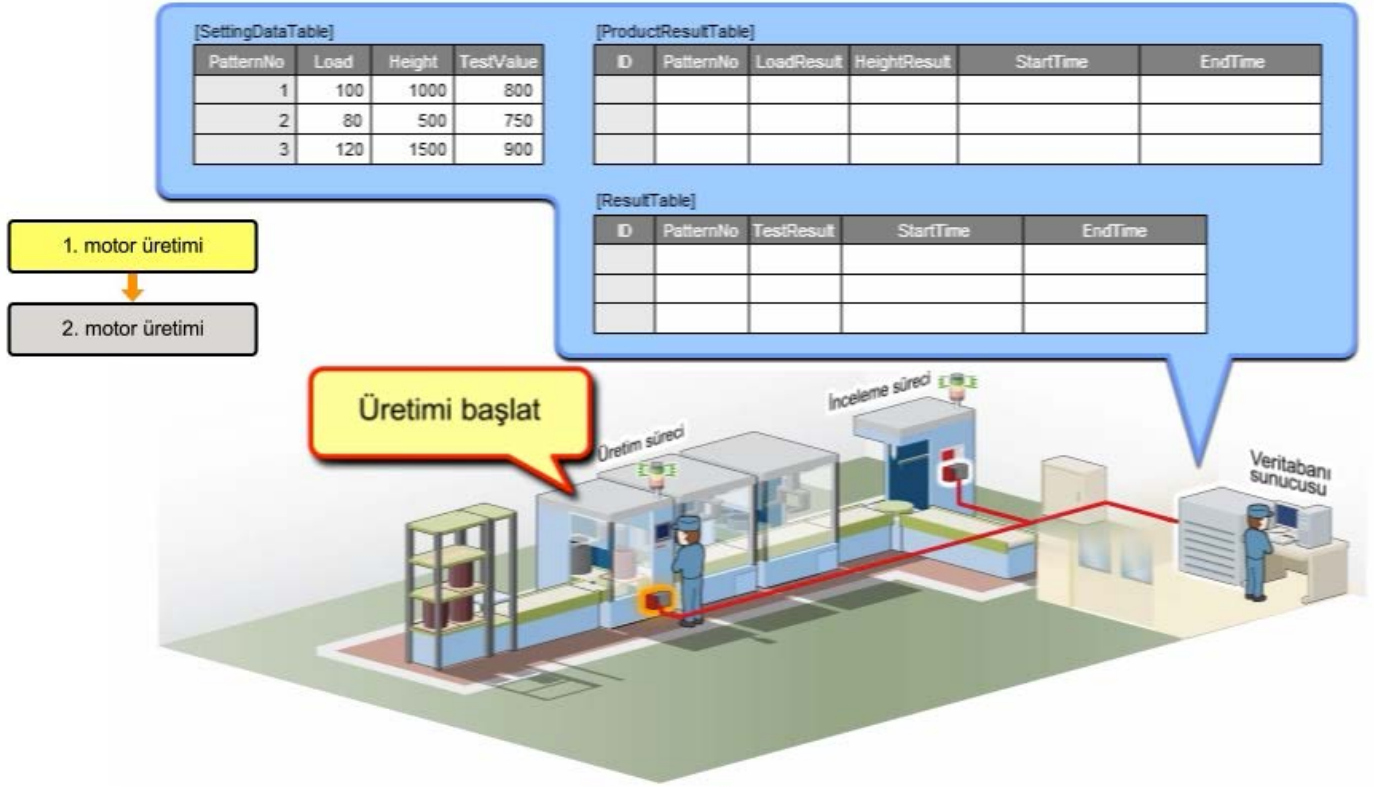
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

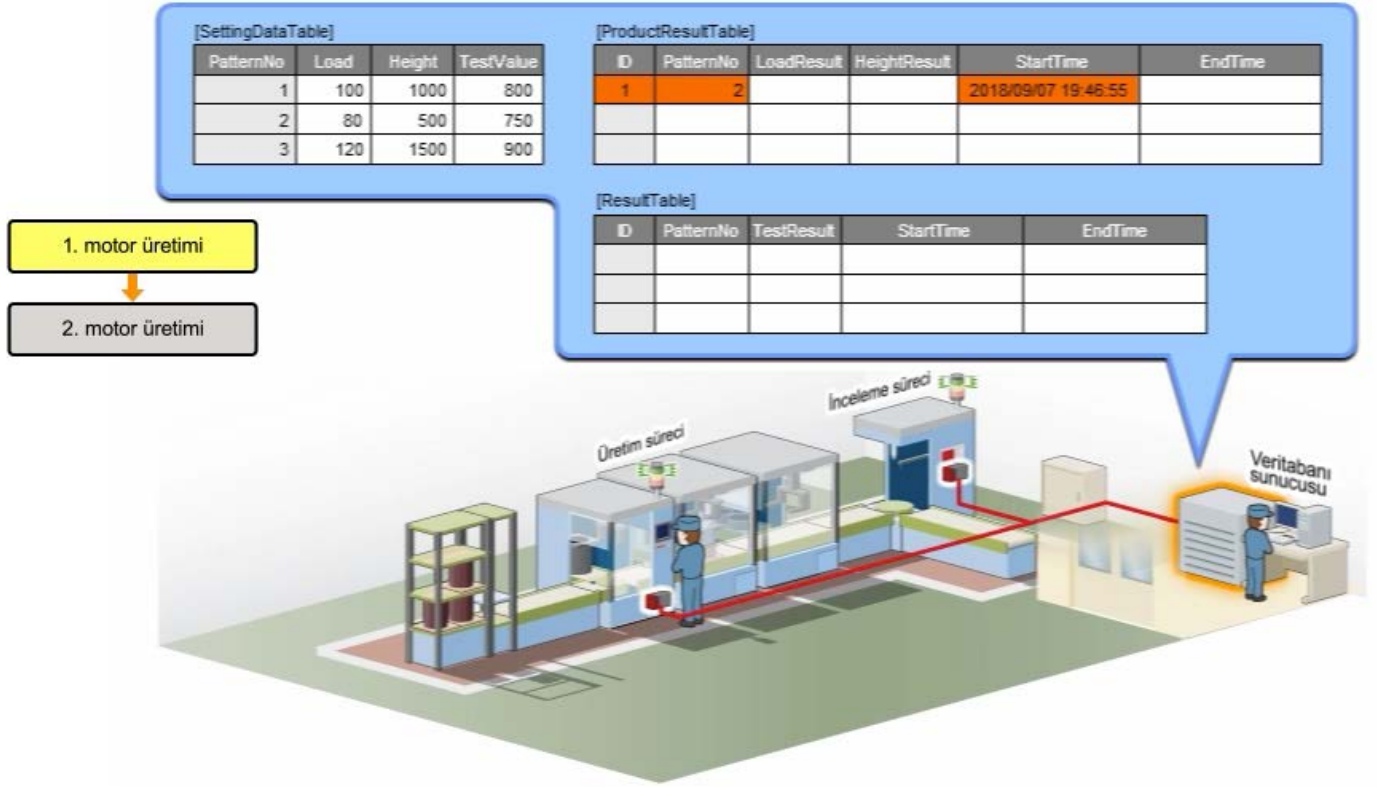
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

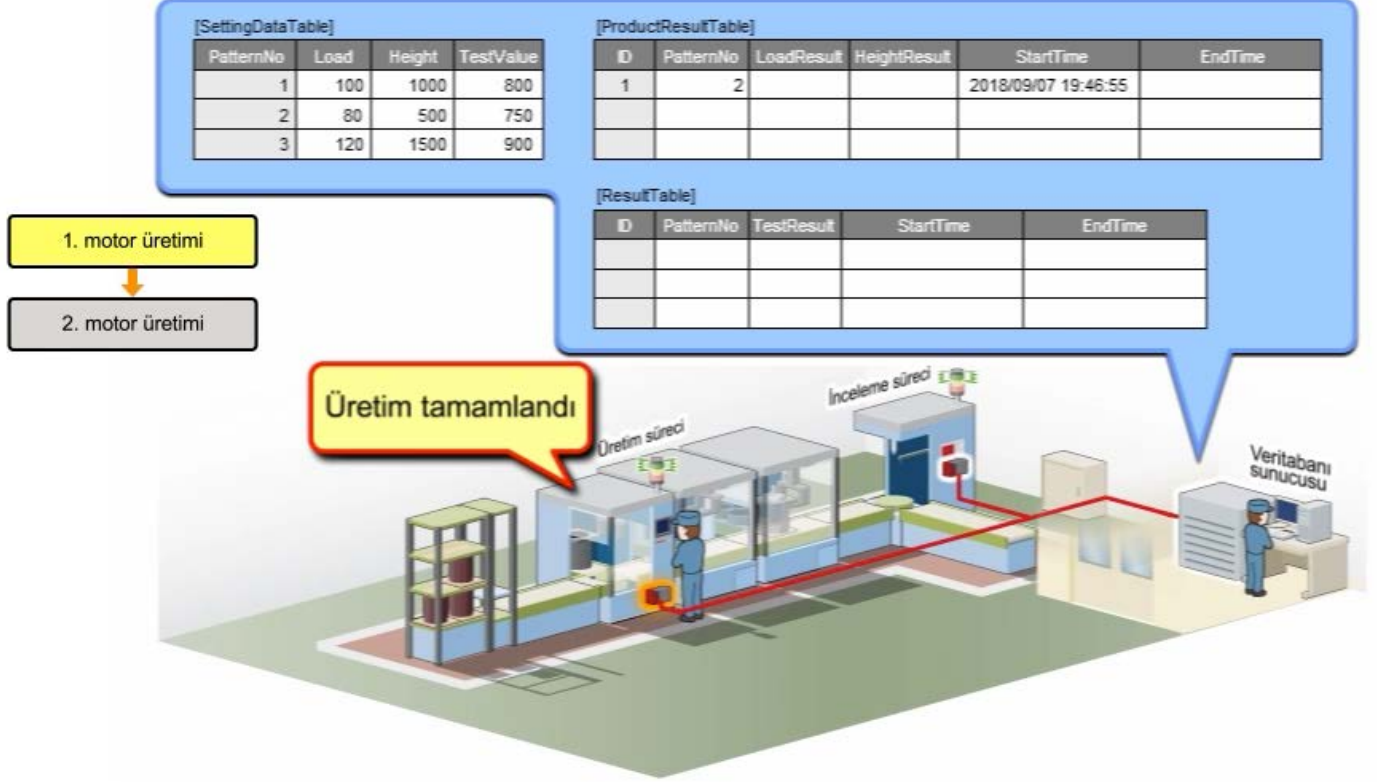
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



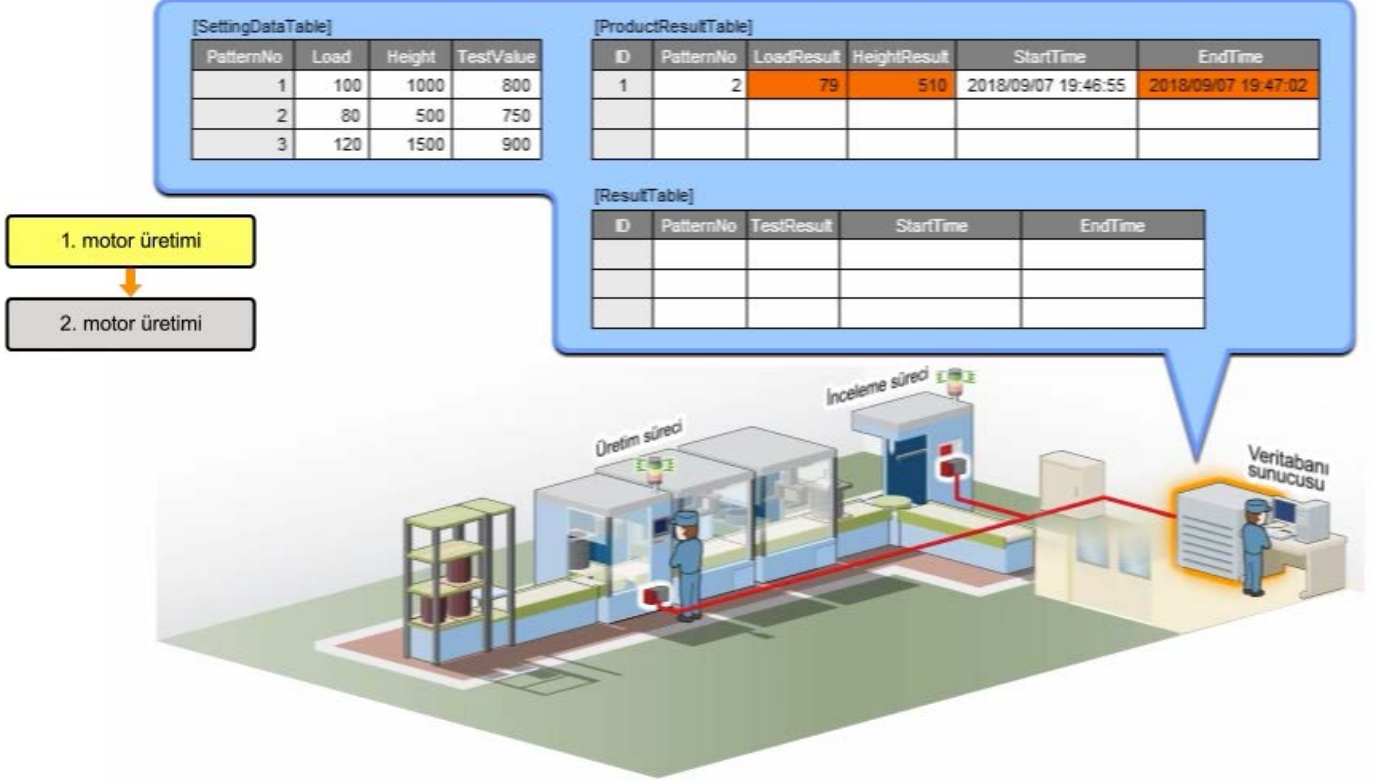
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klipi kontrol edin.)**



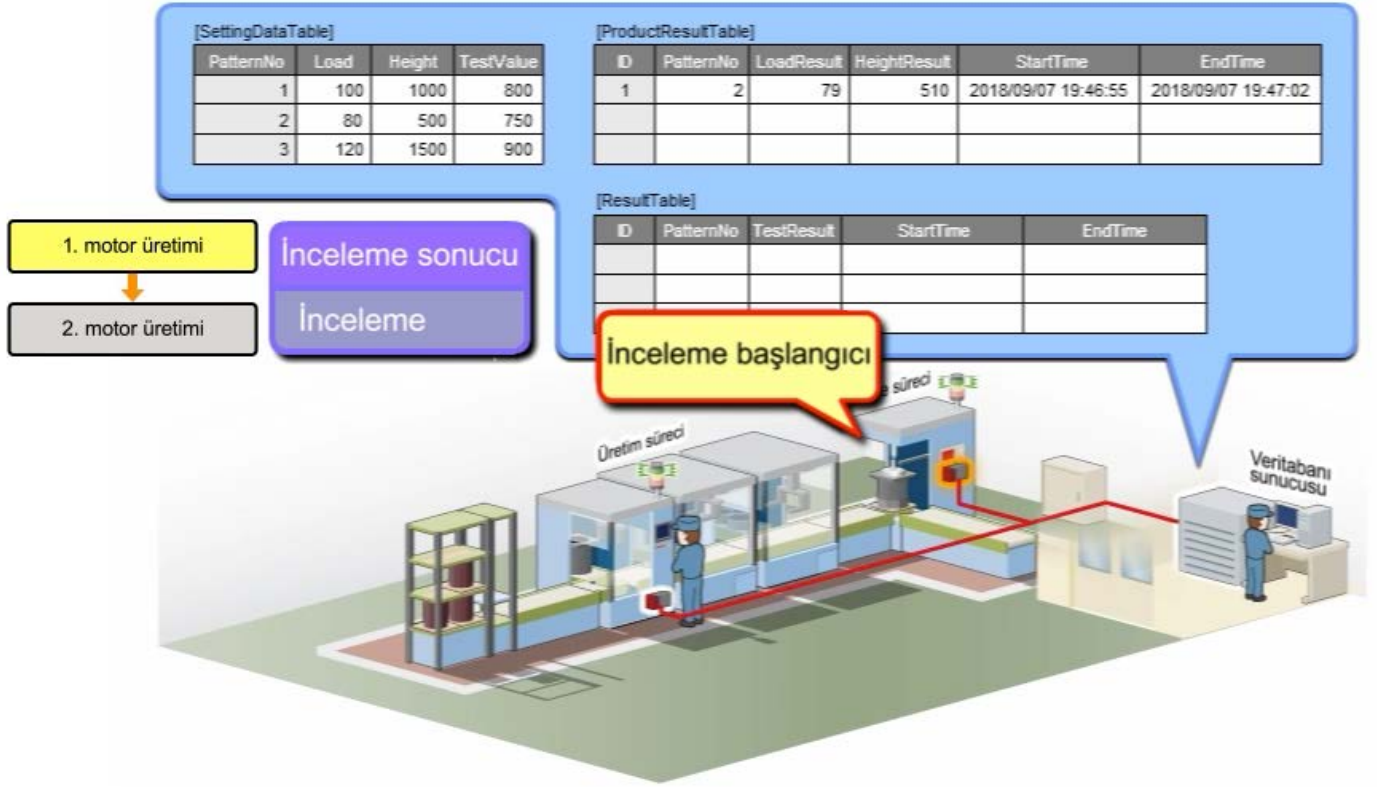
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



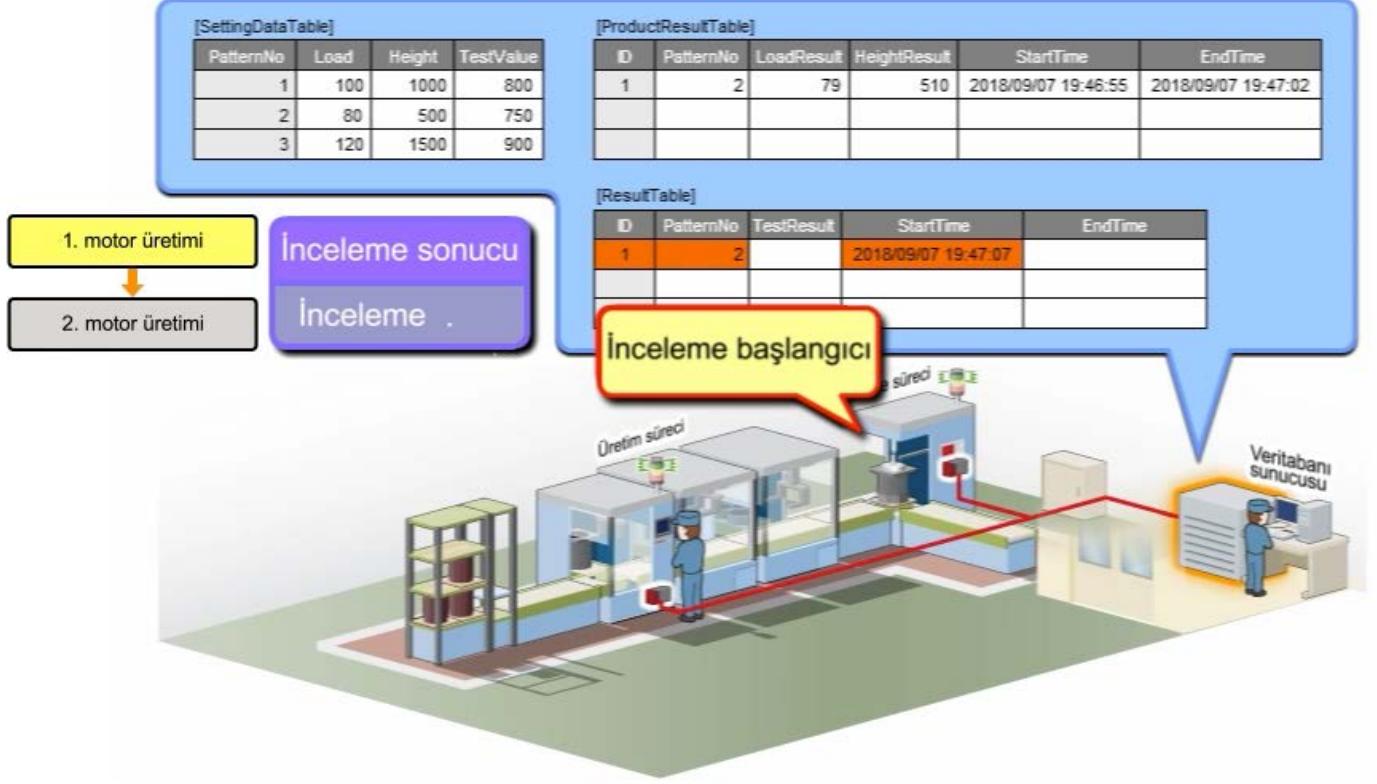
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



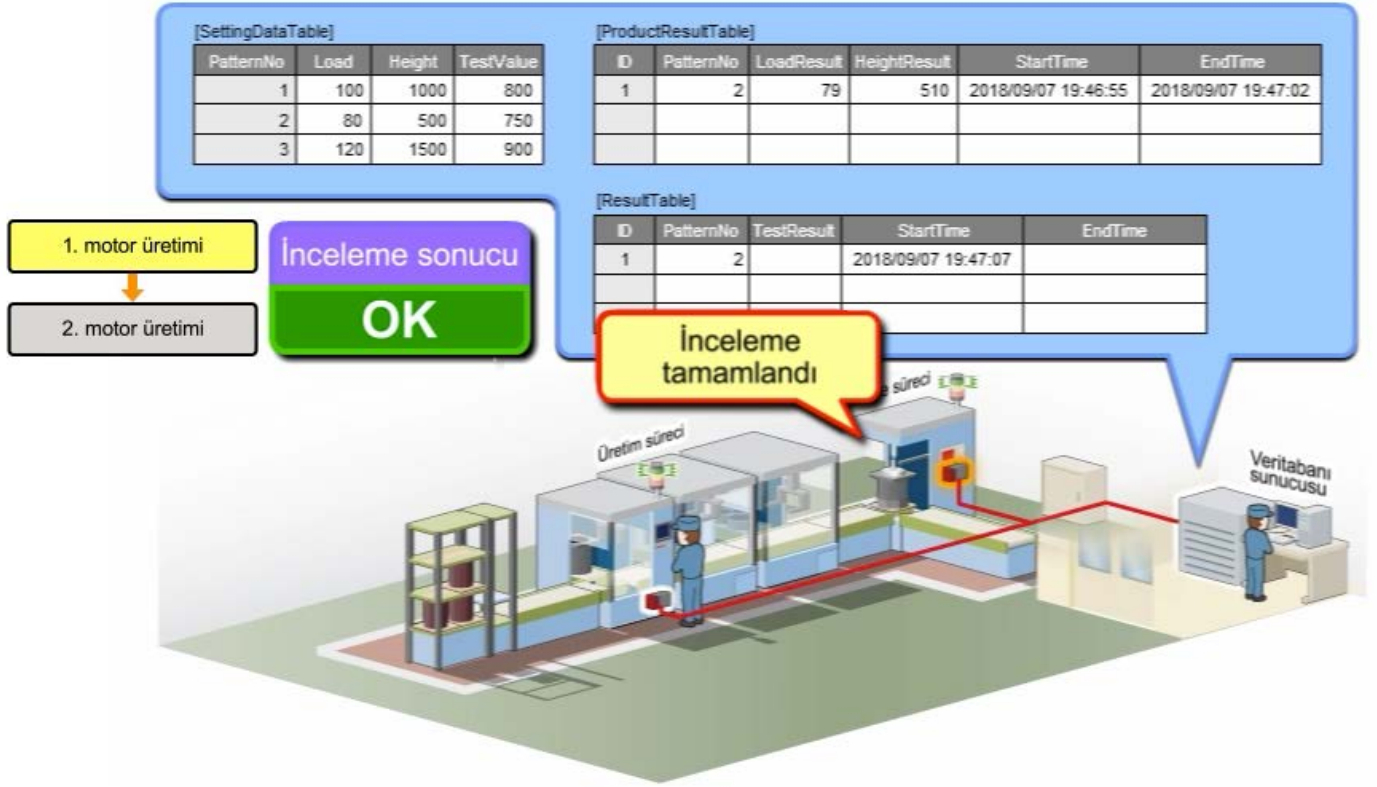
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

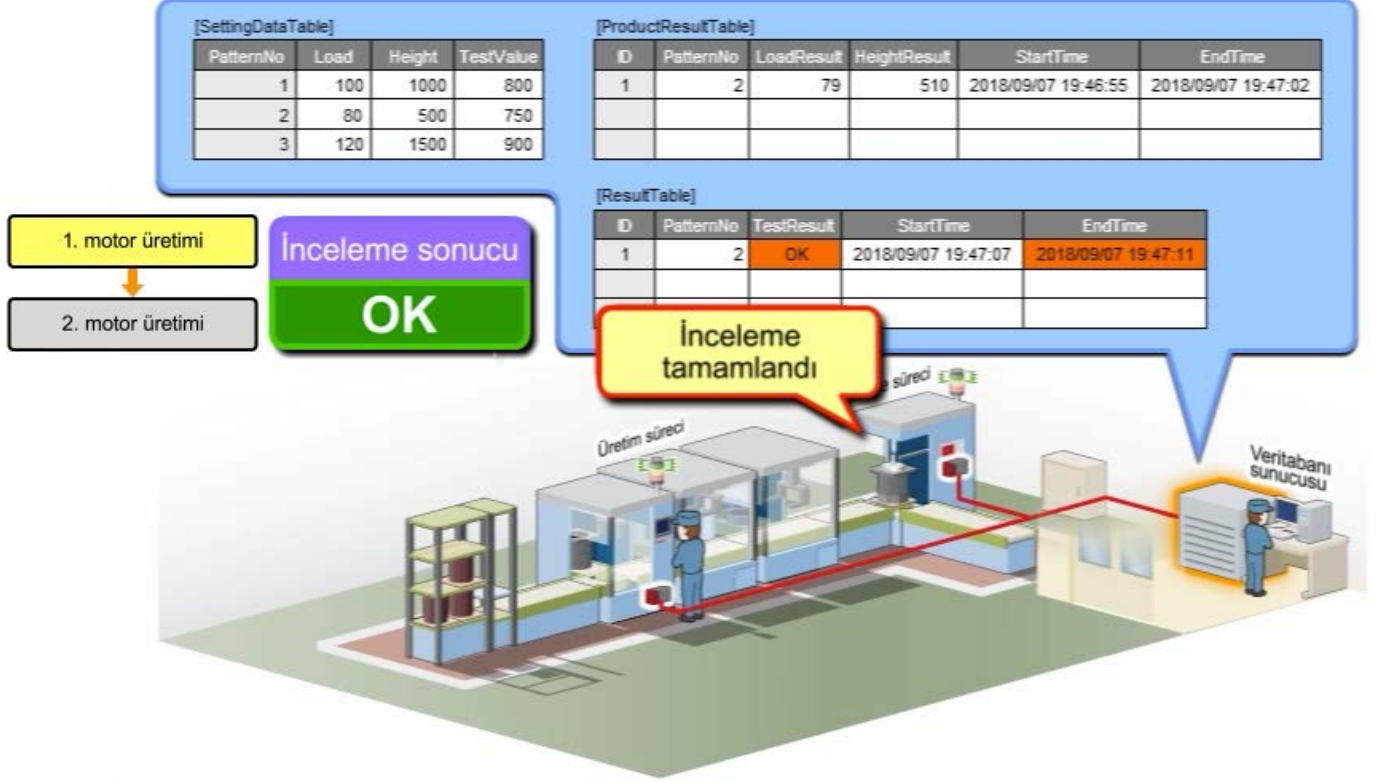
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

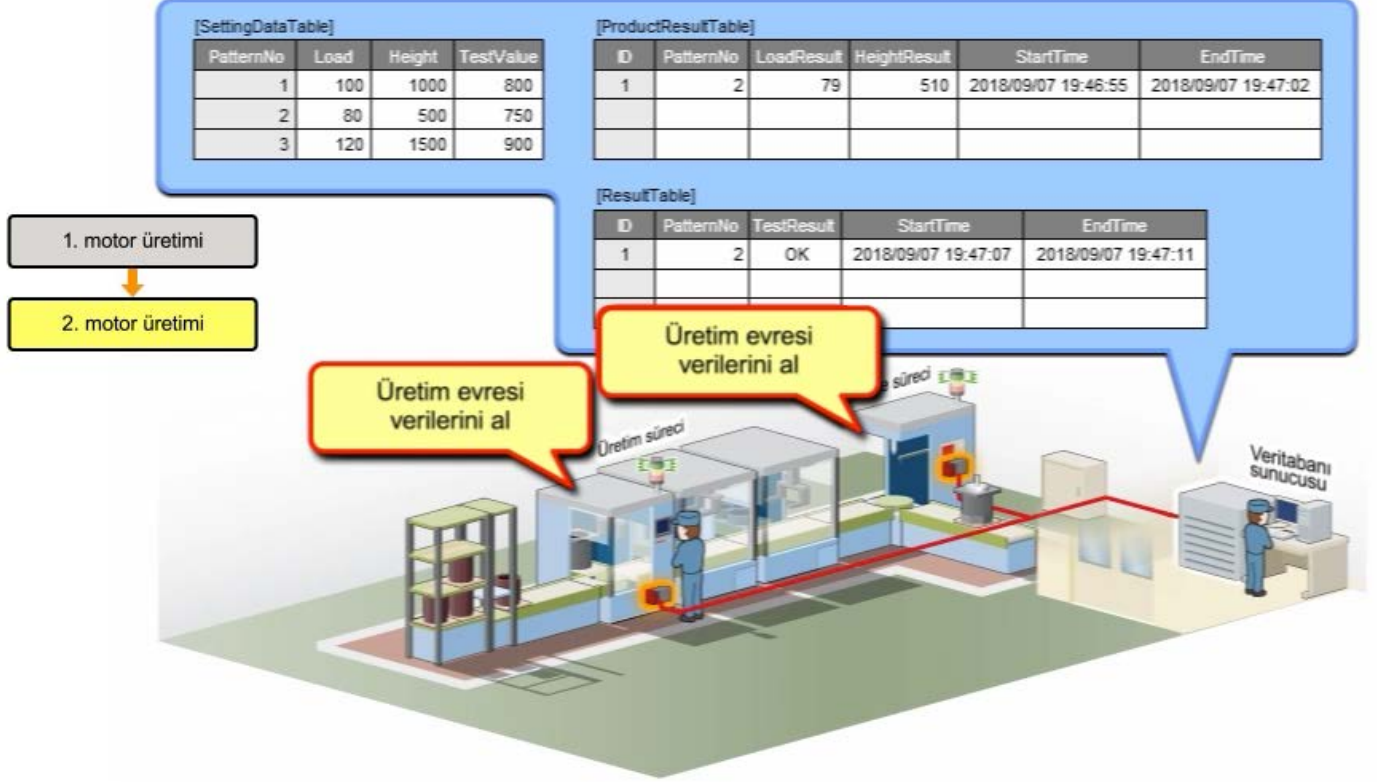
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



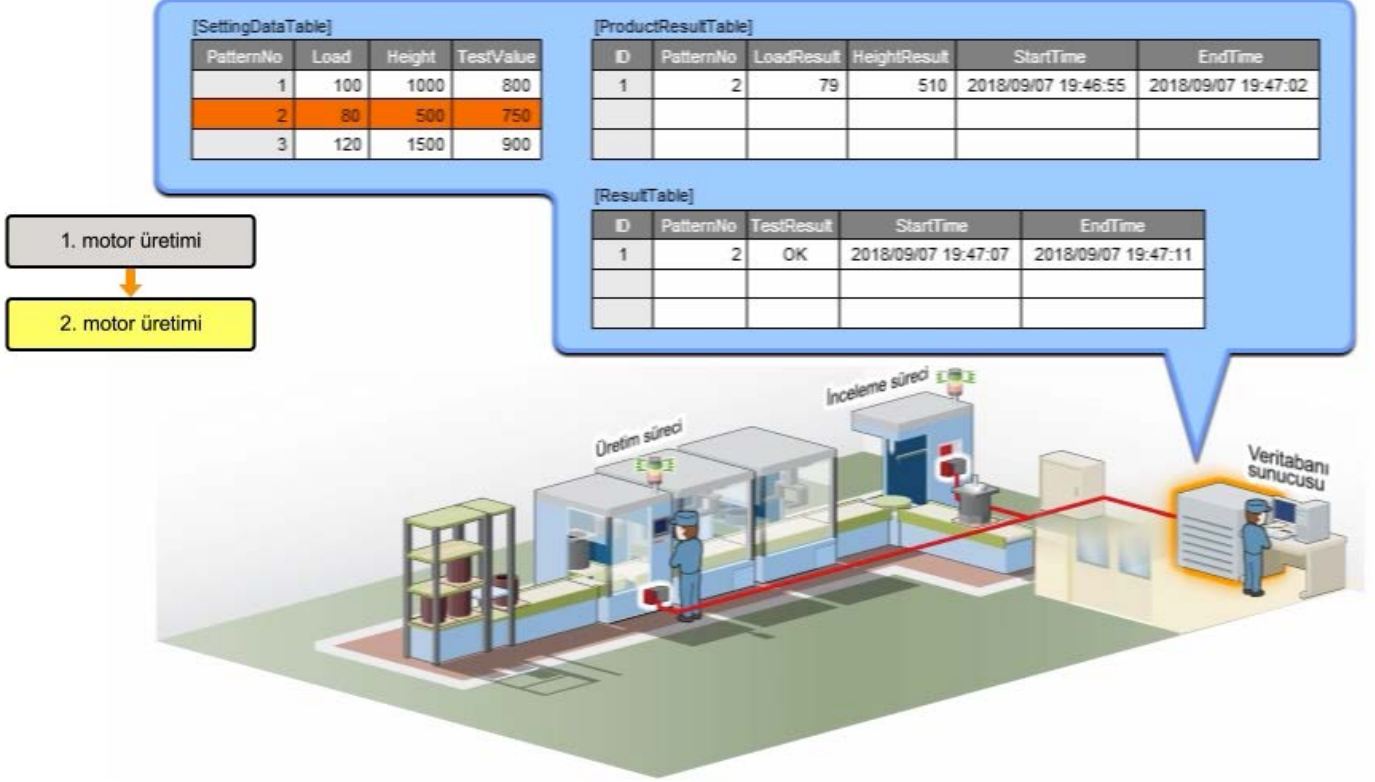
Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız.

Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır.

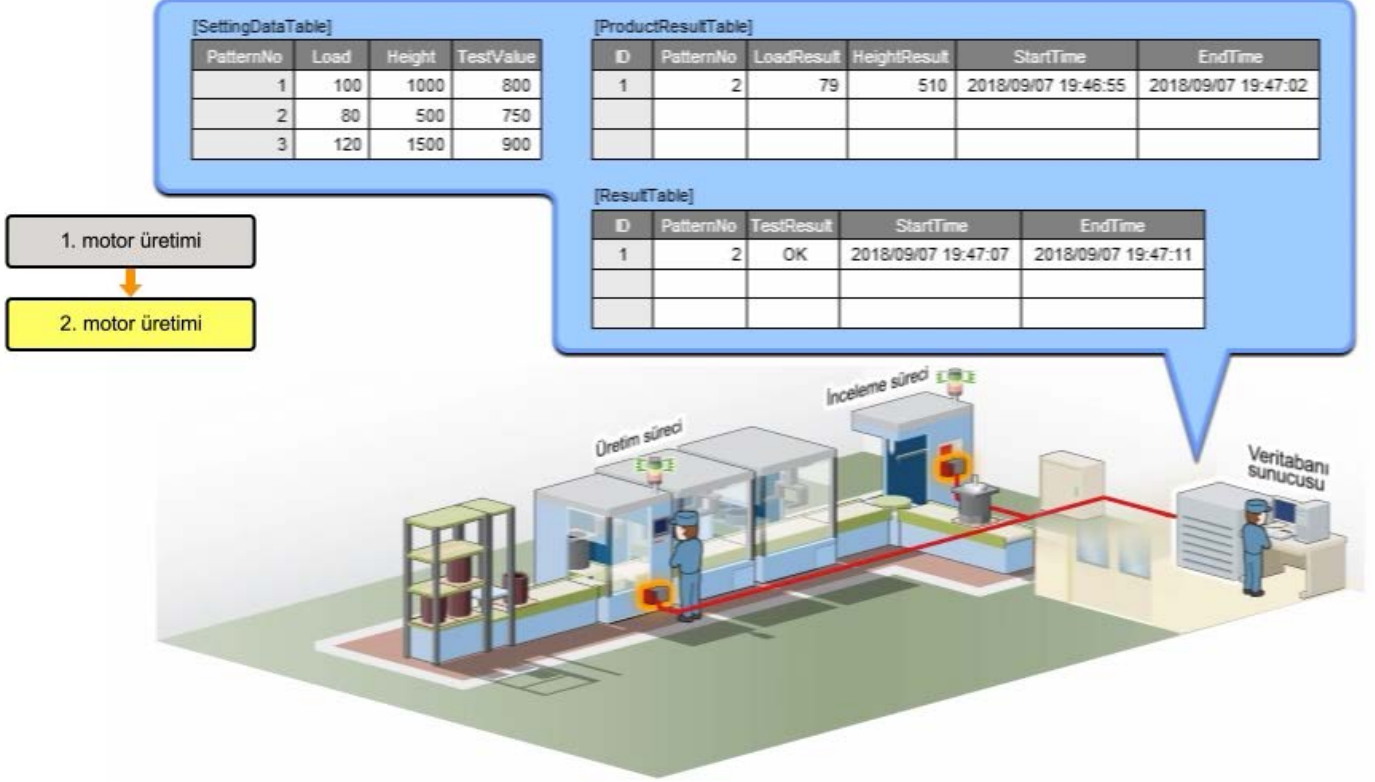
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klipi kontrol edin.)**



Bu kurs için MES interface modülü sistemini ayarlamayı tamamladınız. Tamamlandıktan sonra ayarın aslında MES interface modülüne yazılması gerekse de, bu işlem bu kursta atlanmıştır. Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



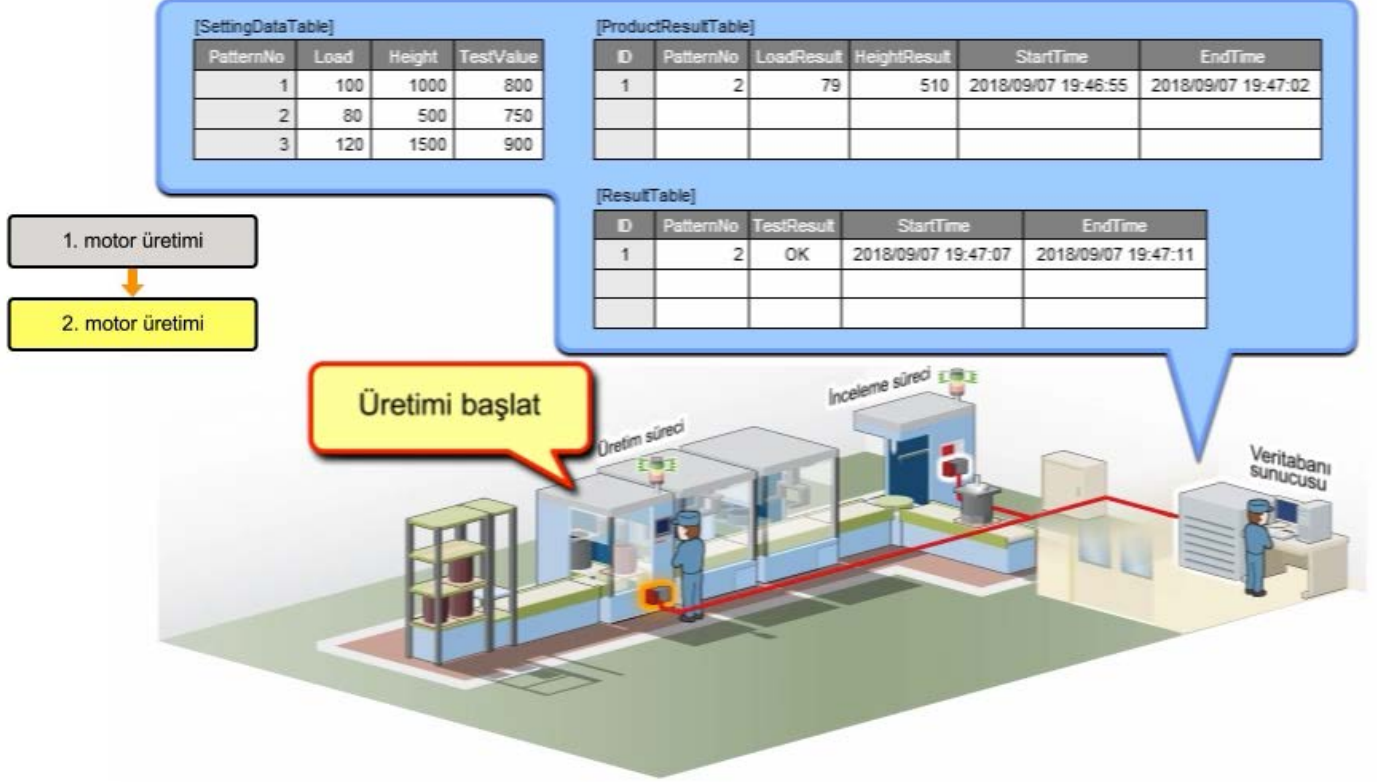
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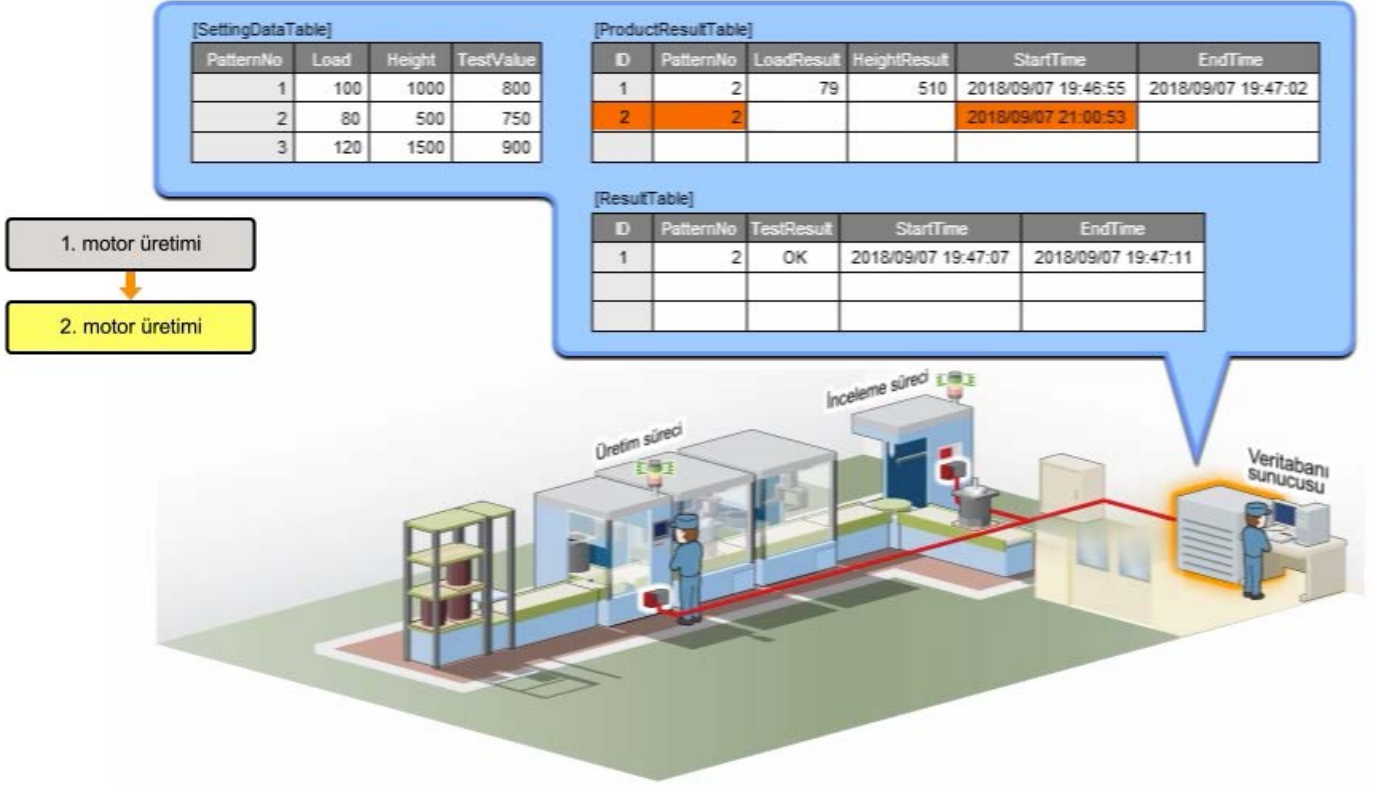
Yapılandırılan sistemin işlemleri ve veri akışı aşağıda gösterilmektedir. **(Aşağıdaki klibi kontrol edin.)**



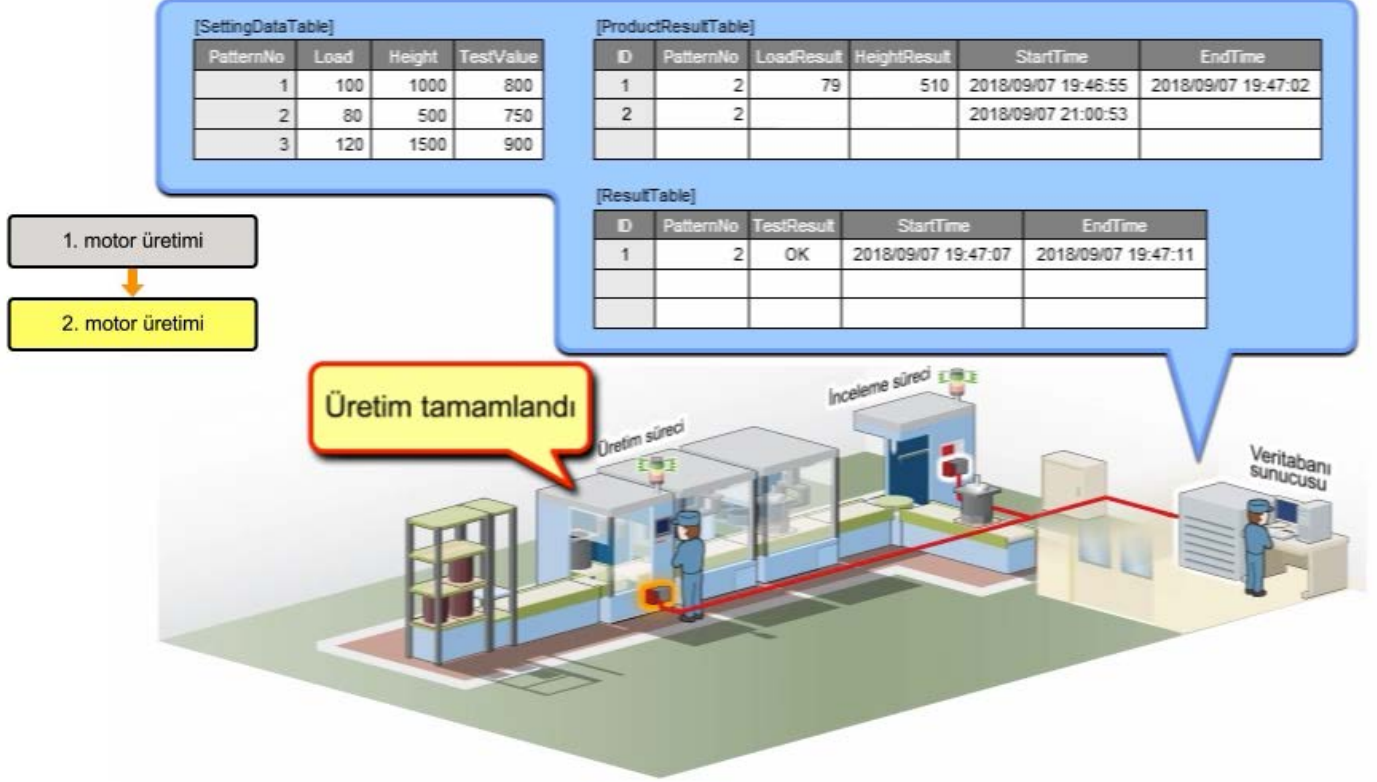
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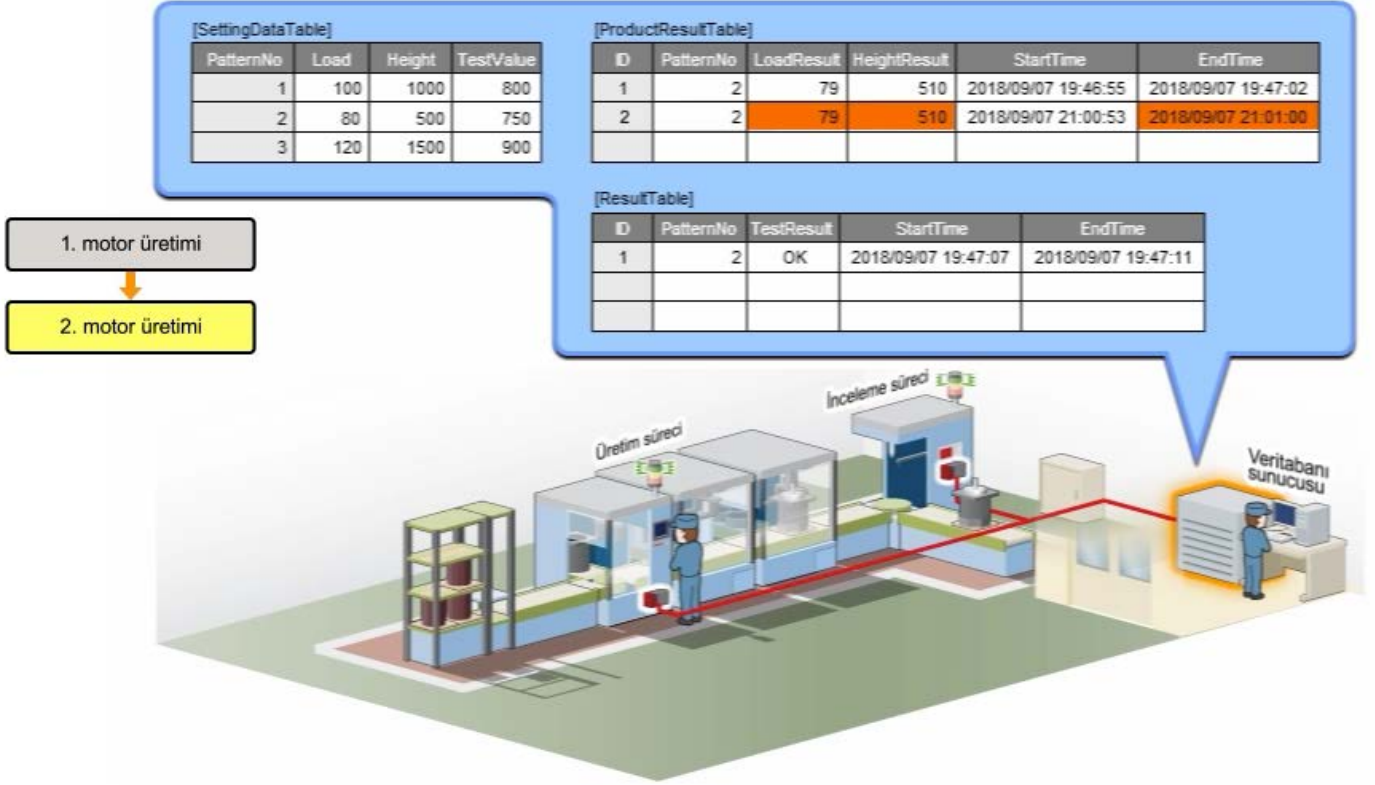
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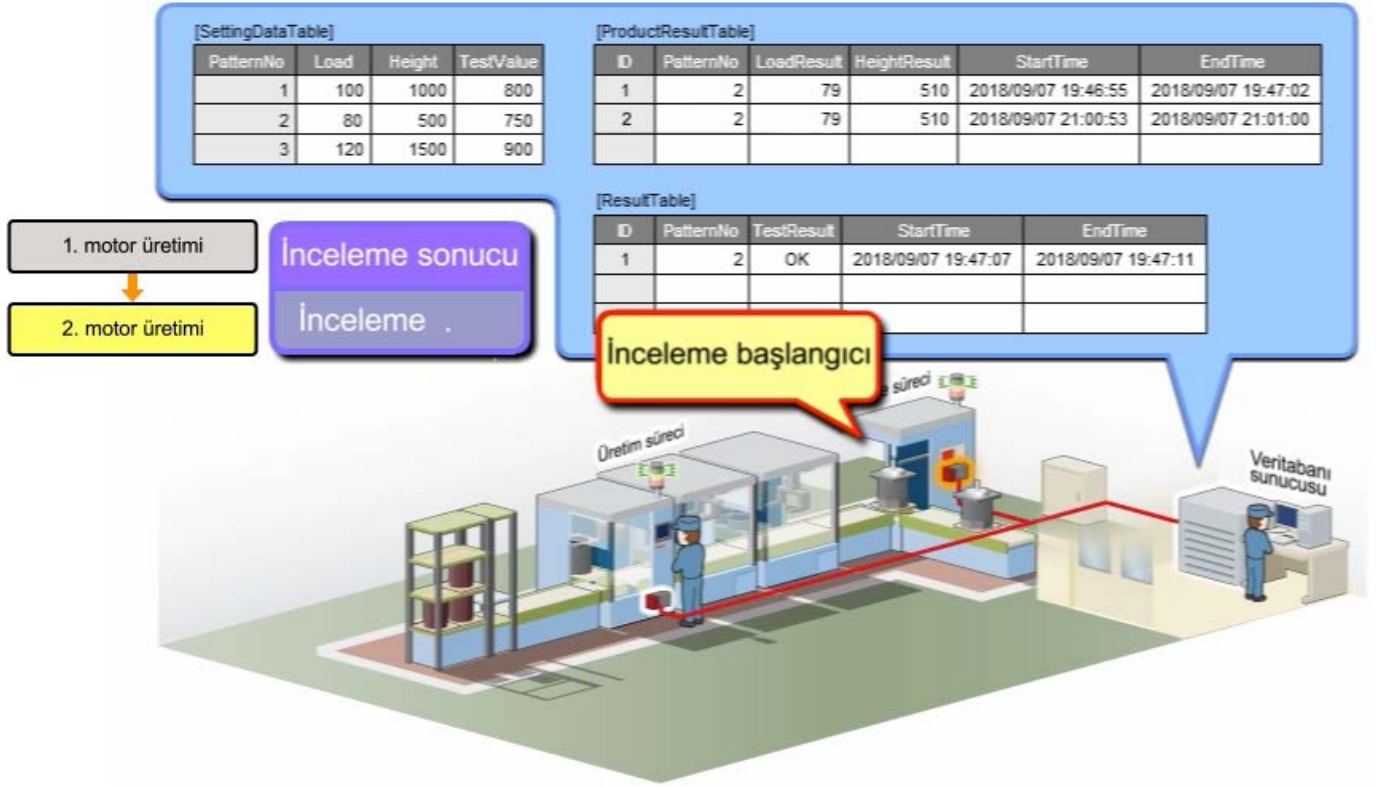
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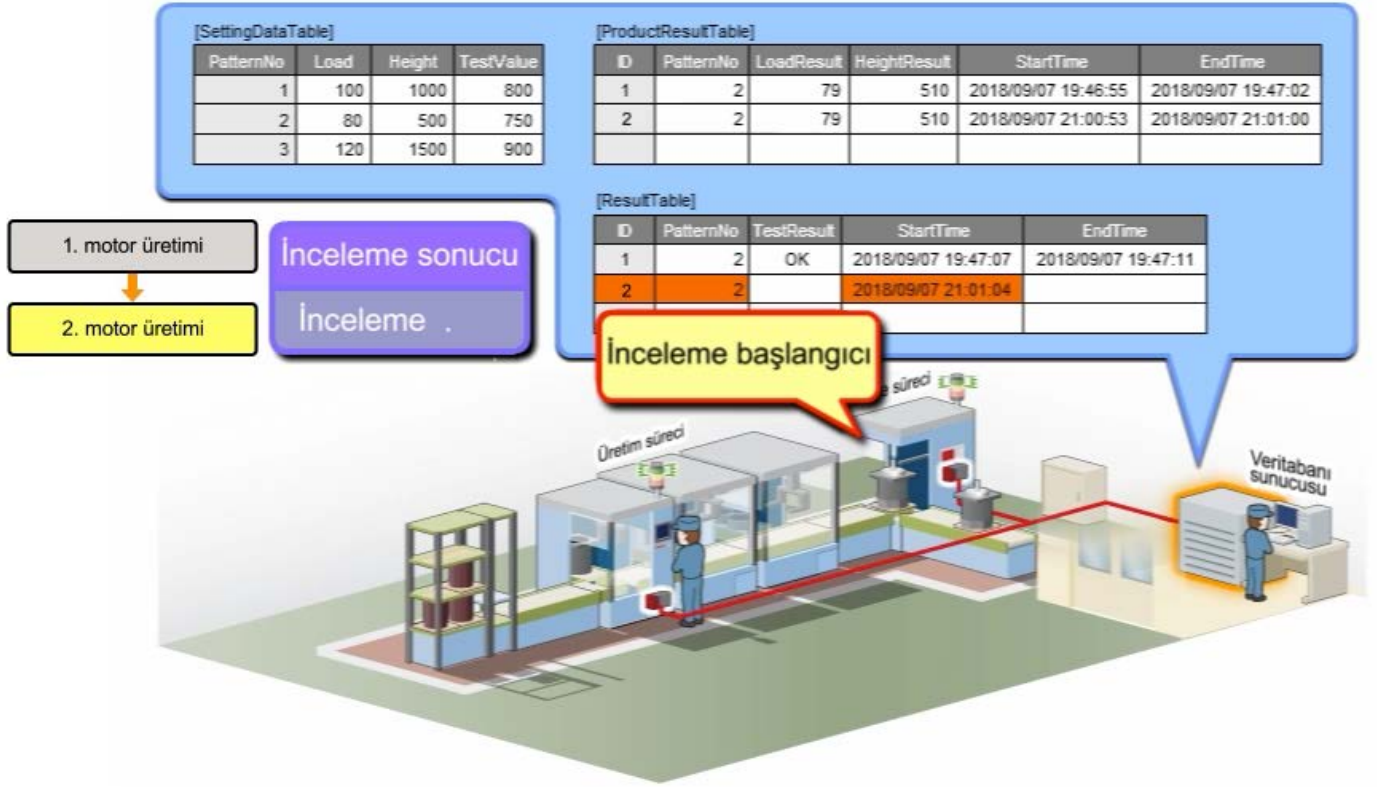
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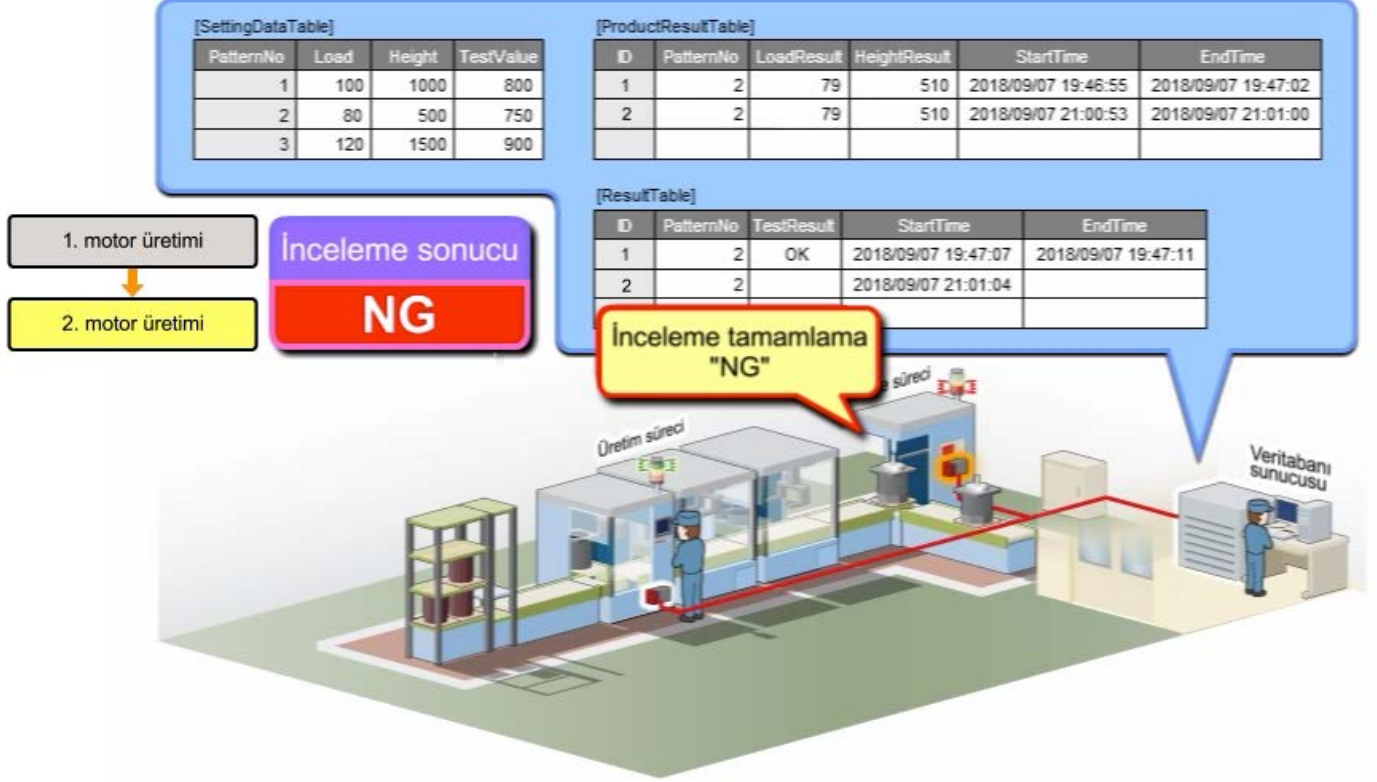
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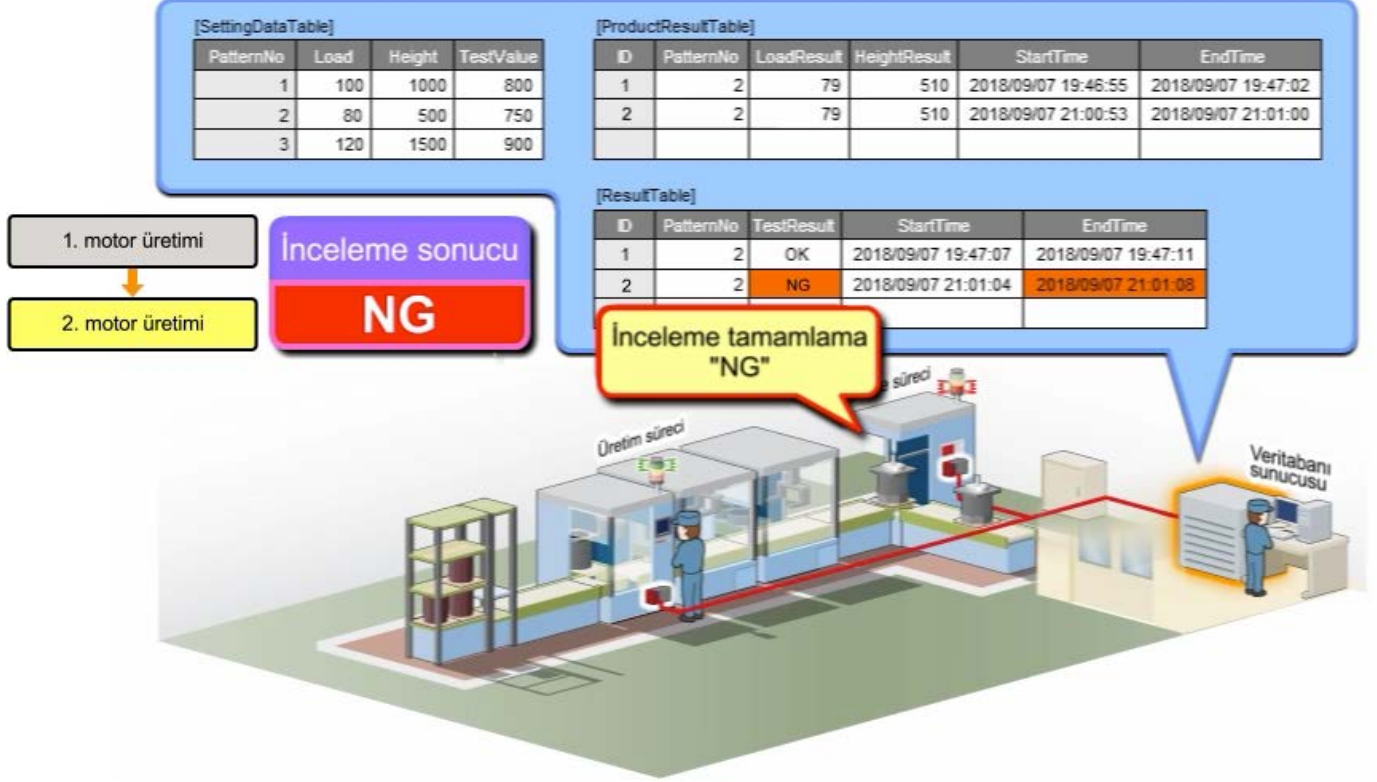
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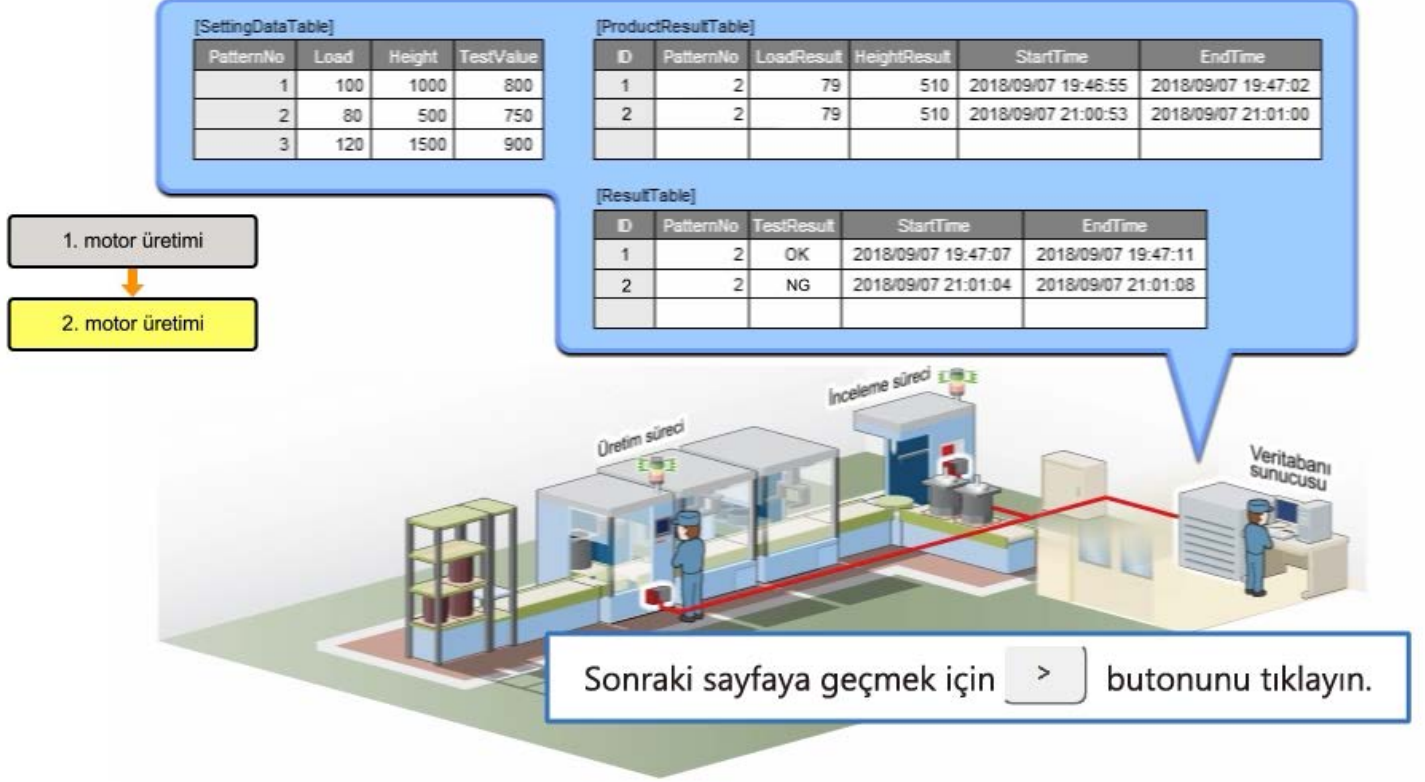
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Bu bölümde, şunları öğreniniz:

- Veritabanının yapısı
- MES interface function configuration tool'nun rolü
- Tetikleyici türleri
- Eylem türleri

Noktalar

Veritabanının yapısı	Veritabanı, birden fazla uygulama veya kullanıcı tarafından paylaşılan verilerin birleşimidir. Verilerin birleşimi tabloyla gösterilir ve sütuna alan (sütun) ve satıra kayıt adı verilir.
MES interface function configuration tool'nun rolü	MES interface modülüyle programlanabilir denetleyicinin hangi değerinin veritabanının hangi verisine ve ne hangi zamanlamayla bağlandığını ayarlayın. Tamamlanmış ayar MES interface modülüne yazıldığında, yapılandırılmış ayarla çalışır.
Tetikleyici türleri	Çalışma zamanlaması (tetikleyici koşul), altı tür olay ve koşulun kombinasyonuna bağlı olarak farklılık gösterir ve çeşitli düzenler seçilebilir. <Olay/koşulda ortak> <ul style="list-style-type: none"> • Condition (Value Monitoring): Bu, cihaz etiket bileşeni ve değişkenin değerleri belirli bir koşulu karşıladığında çalıştırmak için kullanılır. <Koşul> <ul style="list-style-type: none"> • Condition (Period of Time): Bu, belirtilen başlangıç zamanı ile bitiş zamanı arasında çalıştırmak için kullanılır. <Olay> <ul style="list-style-type: none"> • Event (Value Changed): Bu, cihaz etiket bileşeni ve değişkenin değerleri geçmiş değerden değiştirildiğinde çalıştırmak için kullanılır. • Event (Fixed Time): Bu, belirli bir zamanda çalıştırmak için kullanılır. • Event (Fixed Cycle): Bu, belirtilen zaman aralığında veya belirtilen zamana göre belirtilen zaman aralıklarında çalıştırmak için kullanılır. • Event (Module Monitoring): Bu, MES interface modülü başlatıldığında, arayüz işlevi yeniden başlatıldığında veya ayarı güncellendiğinde ya da yönetim CPU biriminin durumu değiştiğinde çalıştırmak için kullanılır. • Handshake: Bu, ekipmanın programlanabilir denetleyicisiyle senkronizasyon içinde işler başlatılırken veya tamamlanırken kullanılır.
Eylem türleri	Aşağıdaki altı eylem türü, veritabanıyla haberleşme fonksiyonudur. <ul style="list-style-type: none"> • Select: Veritabanından veri çıkarır. • Insert: Veritabanına veri ekler. • Update: Veritabanındaki verileri günceller. • Delete: Veritabanındaki verileri siler. • Multiple Select: Veritabanından birden fazla veri çıkarır. • Stored Procedure: Veritabanına kaydedilmiş işlemeyi yürütür.

[Kavrama testi]

Bölüm 3'deki içerikleri tam olarak anladınız mı?

İçerikleri kontrol etmek ve gözden geçirmek için lütfen kavrama testini uygulayın.

(3 kısım, 3 soru)

Veritabanına ait aşağıdaki açıklamalar için doğru ya da yanlış seçin.
Veritabanı, tablo adı verilen bir listeyle yapılandırılır ve satırına "alan", sütununa ise "kayıt" adı verilir.

Doğru

Yanlış

Device tag ayarlarına ait aşağıdaki açıklamalar için doğru ya da yanlış seçeneğini seçin.
"Device Tag Settings" bölümünde, CPU modülünün device adı (D100 gibi) ve veritabanının alan adı doğrudan birbirine bağlanacak şekilde ayarı yapılandırın.

Doğru

Yanlış

MES interface modülüne ait aşağıdaki açıklamalar için doğru ya da yanlış seçeneğini seçin.
MES interface modülü bir SD bellek kartı olmadan kullanılabilir.

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Doğru

Yanlış

Bölüm 3'ün kavrama testini tamamladınız.
Test sonucunuz aşağıdadır.

Sonucunuz nasıl çıktı?
Yanlış cevapladığınız soruları tekrar denemeniz önerilir.

	1	2	3	4	5	6	7	8	9	10
Kavrama testi 1	✓									
Kavrama testi 2	✓									
Kavrama testi 3	✓									

Toplam soru: **3**

Doğru cevaplar: **3**

Yüzde: **100 %**

Temizle

Üretim tesisini yönetmek ve üretimi verimli şekilde yürütmek için doğru uygulamayı seçin. (Birini seçin.)

ERP

PDM

MES

Dosyaların kullanıldığı veri yönetimine kıyasla veritabanı kullanmanın avantajı olarak yanlış cevabı seçin. (Birini seçin.)

- Çok miktarda veri yönetilebilir ve verilerin aranabilirliği yüksektir.
- Az miktarda veri yönetilebilir, ancak verilerin aranabilirliği yüksektir.
- Özel işlemede yüksek performansa sahip olduğundan birden fazla eşzamanlı erişim desteklenir.

Veritabanına ait aşağıdaki açıklamalar için doğru ya da yanlış seçin. Veritabanı, tablo adı verilen bir listeyle yapılandırılır ve satırına "alan", sütununa ise "kayıt" adı verilir.

Doğru

Yanlış

Üretim tesisinde üretimi iyileştirmek için uygulanan PDCA döngüsü için doğru açıklamayı seçin. (Birini seçin.)

- Üretimi iyileştirmek için PDCA döngüsünün bir kez yürütülmesi yeterlidir.
- Üretimi iyileştirmek için PDCA döngüsünün sürekli olarak yürütülmesi önemlidir.
- PDCA döngüsünün ilk adımı olan Planda, gerçek veriler kullanılmadan varsayıma dayalı kaba bir plan yapılır.

Üretim tesisinde veri toplamak için MES interface modülünü kullanmanın avantajı olarak yanlış cevabı seçin. (Birini seçin.)

- MES interface modülü, ekipmanı kontrol eden programlanabilir denetleyiciye kurularak veriler veritabanına/veritabanından otomatik olarak alınır/gönderilir.
- Bir haberleşme programı oluşturularak ve MES interface modülüne kaydedilerek veritabanı ve CPU modülü bağlanabilir.
- MES interface modülünü kullanan sistemde veriler gerçek zamanda toplanabilir ve bu sistemin güvenilirliği yüksektir.

Üretim tesisini yönetmek ve üretimi verimli şekilde yürütmek için doğru uygulamayı seçin. (Birini seçin.)

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Son Testi tamamladınız. Sonuç alanınız aşağıda gösterildiği gibidir.
Son Testi sonlandırmak için bir sonraki sayfaya ilerleyin.

	1	2	3	4	5	6	7	8	9	10
Son Test 1	✓									
Son Test 2	✓									
Son Test 3	✓									
Son Test 4	✓									
Son Test 5	✓									

Toplam soru: **5**

Doğru cevaplar: **5**

Yüzde: **100** %

Temizle

Üretim Görselleştirme Temelleri (MELSEC iQ-R serisi MES interface modülü) kursunu tamamladınız.

Bu kursa katıldığınız için teşekkür ederiz.

Derslerden keyif almış olmanızı ve bu kursta edindiğiniz bilgilerin gelecekte faydalı olmasını umarız.

Kursu istediğiniz kadar çok gözden geçirebilirsiniz.

İncele

Kapat