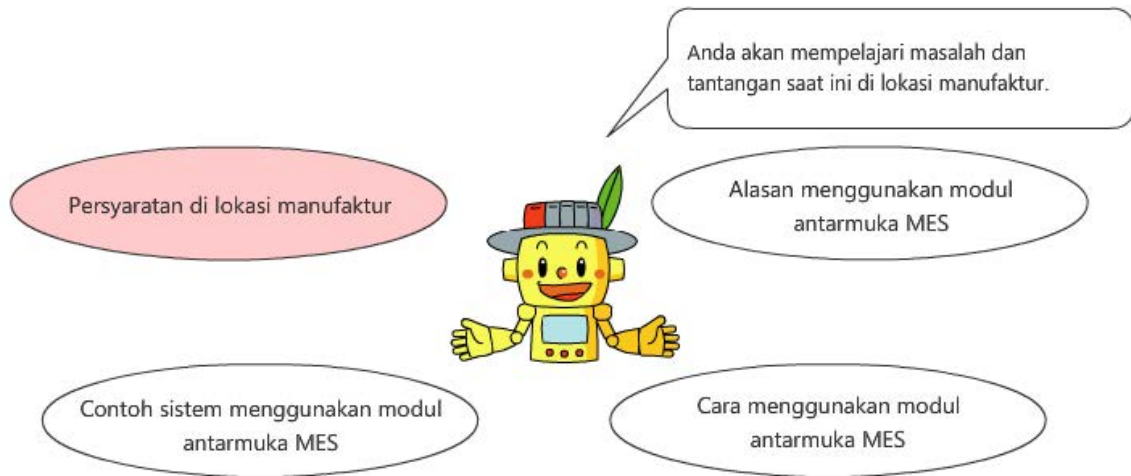


PLC

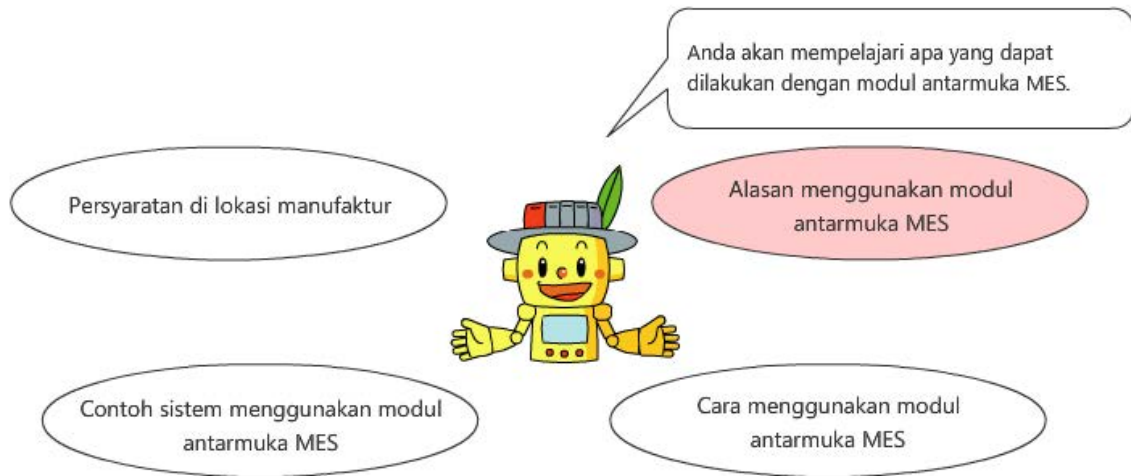
**Dasar-Dasar Visualisasi
Manufaktur
(modul antarmuka MES seri
MELSEC iQ-R)**

Kursus pelatihan ini ditujukan bagi peserta yang akan mengimplementasikan konfigurasi database atau sistem yang menggunakan modul antarmuka MES (RD81MES96), atau akan mengusulkannya.

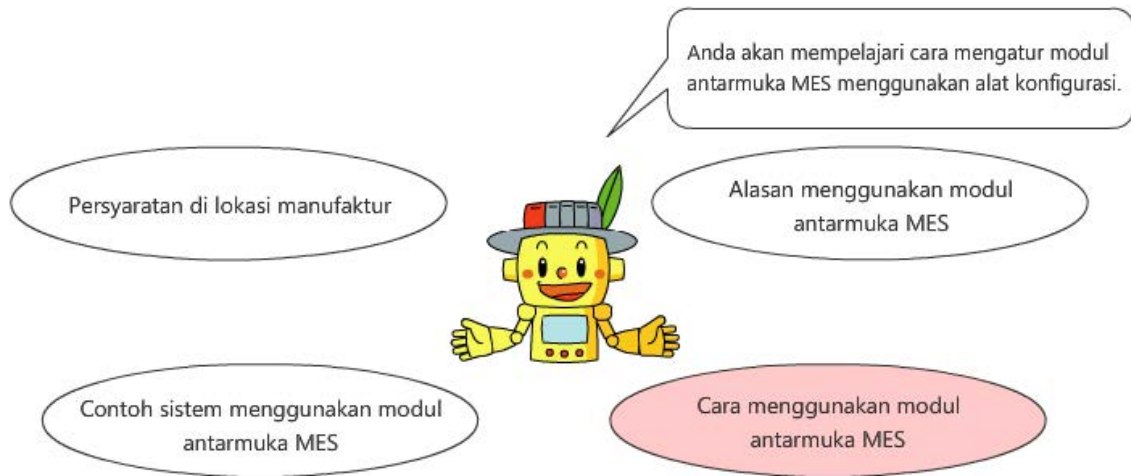
Kursus ini ditujukan agar Anda memahami masalah dan tantangan saat ini di lokasi produksi, dan modul antarmuka MES dapat digunakan untuk menyelesaikannya. Anda juga dapat mempelajari fitur dan cara menggunakan modul antarmuka MES, dan contoh sistem yang menggunakannya.



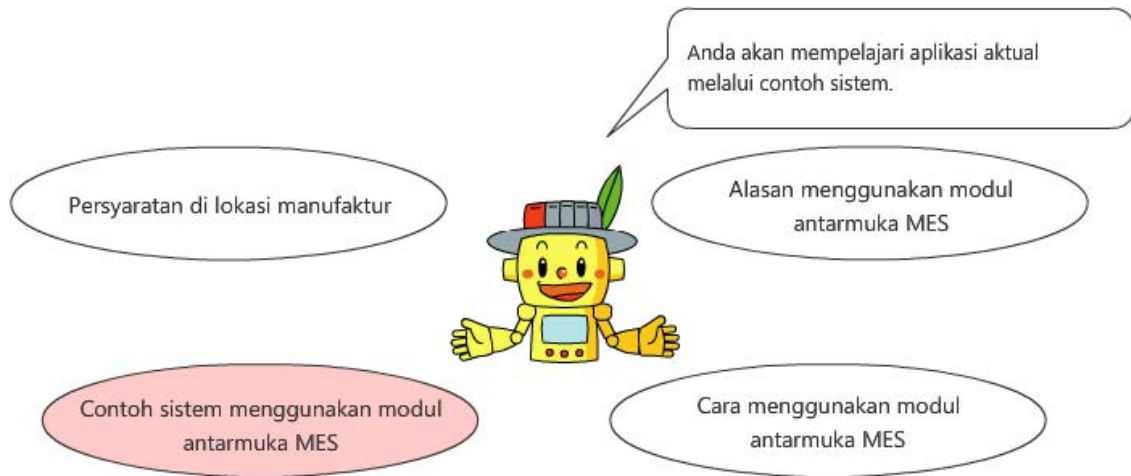
Kursus ini ditujukan agar Anda memahami masalah dan tantangan saat ini di lokasi produksi, dan modul antarmuka MES dapat digunakan untuk menyelesaikannya. Anda juga dapat mempelajari fitur dan cara menggunakan modul antarmuka MES, dan contoh sistem yang menggunakannya.



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Isi dari kursus ini adalah sebagai berikut.
Kami sarankan sebaiknya dimulai dari Bab 1.

Bab 1 Persyaratan di Industri Manufaktur

Pelajari persyaratan untuk mengurangi total biaya di lokasi manufaktur industri manufaktur saat ini, dan sistem seperti apa yang dapat mewujudkannya.

Bab 2 Alasan Memilih Modul Antarmuka MES

Pelajari keuntungan menggunakan database dan modul antarmuka MES.

Bab 3 Cara Menggunakan Modul Antarmuka MES

Pelajari cara mengonfigurasi pengaturan menggunakan MES interface function configuration tool sambil mengikuti poin-poinnya.

Tes Akhir

Total 5 bagian (5 pertanyaan) Nilai kelulusan: 60% atau lebih tinggi

Buka halaman berikutnya		Membuka halaman berikutnya.
Kembali ke halaman sebelumnya		Kembali ke halaman sebelumnya.
Beralih ke halaman yang diinginkan		"Daftar Isi" akan ditampilkan, memungkinkan Anda untuk menavigasi ke halaman yang diinginkan.
Keluar dari kursus		Keluar dari kursus Jendela seperti layar "Daftar Isi" dan kursus akan ditutup.

Tindakan Pencegahan Pengamanan

Ketika Anda belajar dengan menggunakan produk aktual, baca sepenuhnya tindakan pencegahan keselamatan di panduan yang sesuai.

Tindakan Pencegahan dalam Kursus Ini

- Layar yang ditampilkan dari versi perangkat lunak yang Anda gunakan mungkin berbeda dari yang ada di kursus ini. Berikut ini menunjukkan perangkat lunak yang digunakan dalam kursus ini dan setiap versi perangkat lunak.
 - MELSOFT MX MESInterface-R Version1 Ver.1.07H
(MES interface function configuration tool)

Referensi

Berikut ini adalah referensi yang terkait dengan topik dalam kursus ini. (Perlu diperhatikan bahwa materi referensi ini tidak mutlak diperlukan karena Anda masih dapat menyelesaikan kursus ini tanpa menggunakannya.)
Klik nama file referensi untuk mengunduh.

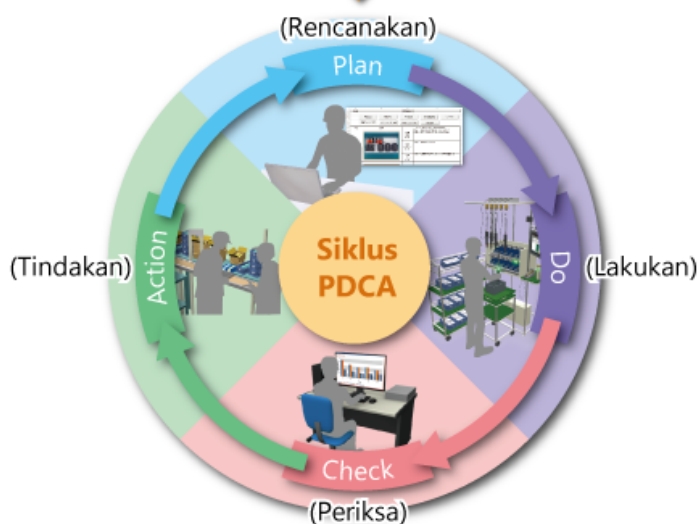
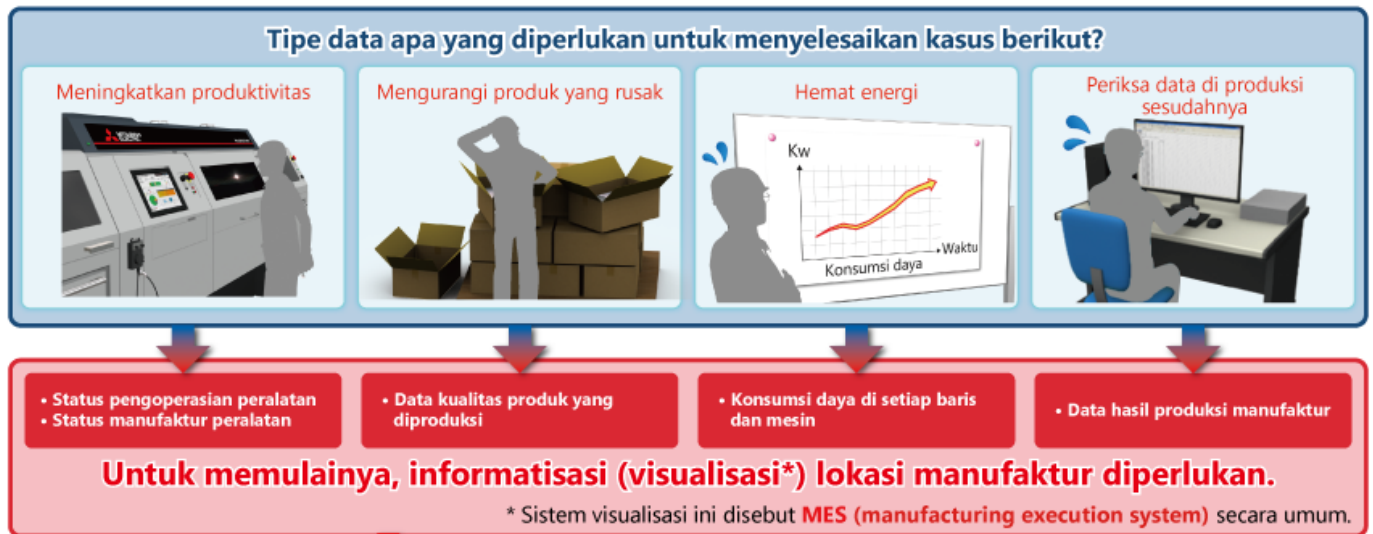
Nama referensi	Format file	Ukuran file
Kertas rekaman	File terkompresi	5.80 kB

Dalam bab ini, Anda akan mempelajari persyaratan untuk mengurangi total biaya di lokasi manufaktur industri manufaktur saat ini, dan sistem seperti apa yang dapat mewujudkannya.

 Isi Bab 1

- 1.1 Masalah di Lokasi Manufaktur
- 1.2 "Visualisasi" dan Pengumpulan Data dari Lokasi Manufaktur
- 1.3 Ringkasan

Industri manufaktur saat ini berada dalam persaingan harga yang ekstrem. Dalam situasi seperti itu, lokasi manufaktur dihadapkan pada berbagai persyaratan untuk mengurangi total biaya. Lalu, bagaimana lokasi manufaktur dapat memenuhi permintaan tersebut?

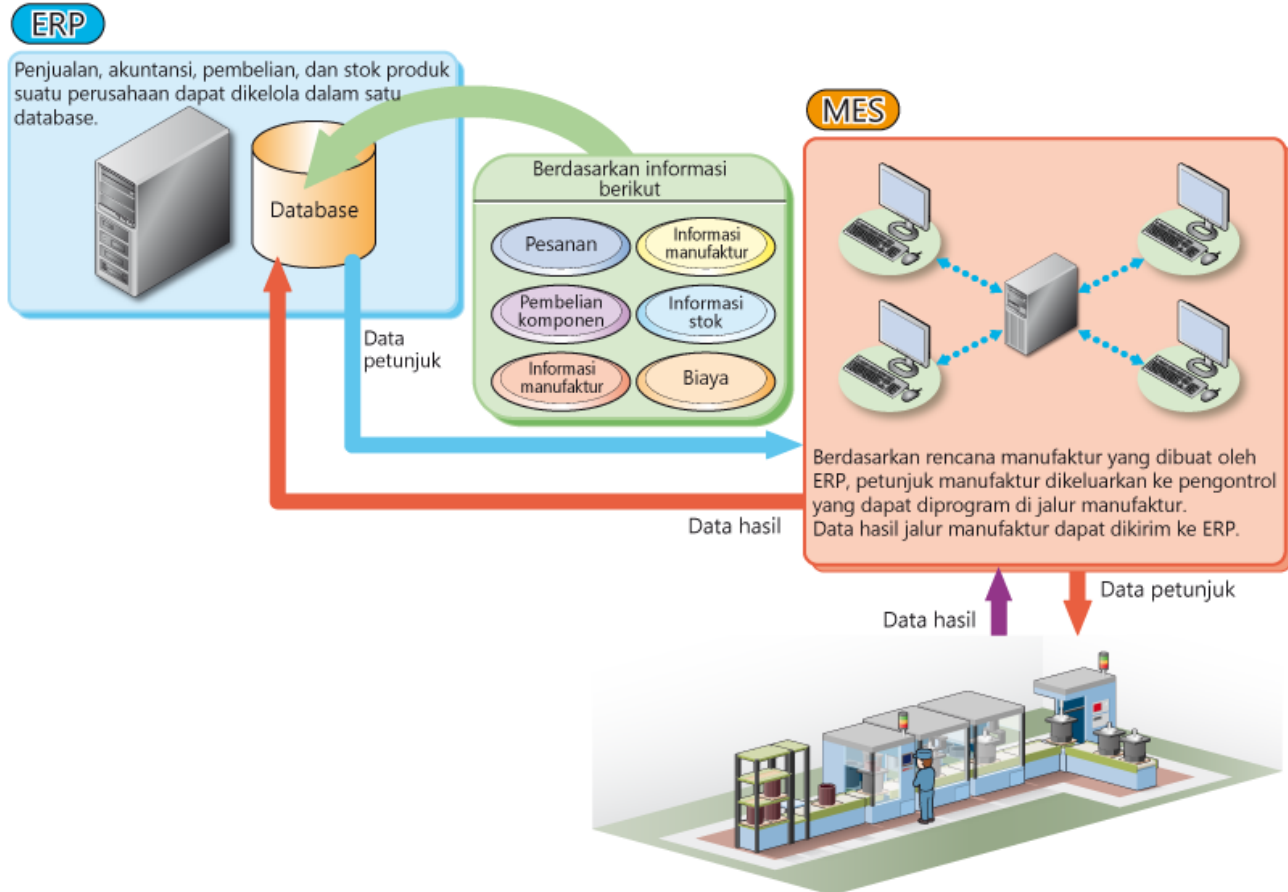


Penting untuk mengekstrak data yang dikumpulkan, menjalankan siklus PDCA untuk meningkatkan manufaktur, dan melanjutkan tindakan ini.

Umumnya, sistem yang mengelola lokasi manufaktur untuk melaksanakan rencana manufaktur secara efisien berdasarkan informasi yang dikumpulkan dari lokasi manufaktur disebut **MES (Manufacturing Execution System)**.

MES sering digunakan dengan **ERP**, yang mengelola pesanan, penjualan, stok, biaya, dan rencana produksi.

Dengan terhubung ke sistem atas, rencana dan hasil dapat dipahami, yang dapat digunakan untuk manajemen bisnis yang efisien.



Di lokasi manufaktur, siklus PDCA telah diimplementasikan dengan mengumpulkan data di lokasi manufaktur untuk meningkatkan manufaktur.

Sekarang, apa keuntungan penggunaan modul antarmuka MES?

Bagaimana sistem informasi dikembangkan seiring dengan kemajuan TI dijelaskan pada bagian ini.



Di lokasi manufaktur, siklus PDCA telah diimplementasikan dengan mengumpulkan data di lokasi manufaktur untuk meningkatkan manufaktur.

Sekarang, apa keuntungan penggunaan modul antarmuka MES?

Bagaimana sistem informasi dikembangkan seiring dengan kemajuan TI dijelaskan pada bagian ini.



Dalam sistem saat ini, seiring dengan perkembangan perangkat, komputer pribadi gateway untuk fungsi antarmuka telah digunakan untuk bagian yang dilakukan secara manual. Ini tampaknya berjalan dengan semestinya, tetapi tidak sempurna. Apa saja masalah yang tersembunyi?

- Tidak cocok untuk operasi terus menerus
- Banyak suku cadang yang dikonsumsi digunakan untuk komponen dan keandalannya rendah
- Peristiwa instan mungkin tidak dikumpulkan

Di lokasi manufaktur, siklus PDCA telah diimplementasikan dengan mengumpulkan data di lokasi manufaktur untuk meningkatkan manufaktur.

Sekarang, apa keuntungan penggunaan modul antarmuka MES?

Bagaimana sistem informasi dikembangkan seiring dengan kemajuan TI dijelaskan pada bagian ini.



Bagaimana jika modul antarmuka MES digunakan?

Dengan mengumpulkan fungsi ke sisi peralatan, data secara otomatis ditransfer oleh peralatan. Oleh karena itu, semua data dikumpulkan dan sistem tanpa komputer pribadi gateway dapat direalisasikan.

Dengan menggunakan modul antarmuka MES, data dapat dikumpulkan secara real-time, dan sistem dengan keandalan tinggi dapat direalisasikan.

Anda akan mempelajari fitur-fitur lain di Bab 2.

Dalam bab ini, Anda telah mempelajari:

- Masalah di lokasi manufaktur
- "Visualisasi" dan pengumpulan data dari lokasi manufaktur

Poin-poin

Masalah di lokasi manufaktur	• Untuk memenuhi berbagai kebutuhan di industri manufaktur, diperlukan implementasi siklus PDCA melalui informatisasi (visualisasi) lokasi manufaktur. • Sistem yang mengelola lokasi manufaktur untuk melaksanakan rencana manufaktur secara efisien berdasarkan informasi yang dikumpulkan dari lokasi manufaktur disebut MES (Manufacturing Execution System). • Dengan terhubung ke sistem atas (ERP), rencana dan hasil dapat dipahami, yang dapat digunakan untuk manajemen bisnis yang efisien.
"Visualisasi" dan pengumpulan data dari lokasi manufaktur	Komputer pribadi gateway menggunakan banyak MES. Namun, sistem yang dapat mengumpulkan semua data secara real-time dapat dengan mudah diimplementasikan menggunakan modul antarmuka MES.

[Tes Pemahaman]

Sudahkah Anda memahami sepenuhnya isi Bab 1?
Ikuti tes pemahaman untuk memeriksa dan meninjau isinya.
(3 bagian, 3 pertanyaan)

Pilih aplikasi yang tepat untuk mengelola lokasi manufaktur dan melakukan manufaktur secara efisien. (Pilih satu.)

☐ ERP

☐ PDM

☐ MES

Pilih jawaban yang salah sebagai keuntungan menggunakan modul antarmuka MES untuk mengumpulkan data di lokasi manufaktur. (Pilih satu.)

- ☐ Data dikirim/diterima ke/dari database secara otomatis dengan menginstal modul antarmuka MES ke pengontrol terprogram yang mengontrol peralatan.
- ☐ Modul database dan CPU dapat dihubungkan dengan membuat program komunikasi dan mendaftarkannya ke modul antarmuka MES.
- ☐ Data dapat dikumpulkan secara real-time dalam sistem yang menggunakan modul antarmuka MES, dan keandalan sistemnya tinggi.

Pilih deskripsi yang benar untuk siklus PDCA yang diterapkan untuk meningkatkan manufaktur di lokasi manufaktur. (Pilih satu.)

- ☐ Satu eksekusi siklus PDCA sudah cukup untuk meningkatkan manufaktur.
- ☐ Menjalankan siklus PDCA secara terus menerus penting untuk meningkatkan manufaktur.
- ☐ Dalam perencanaan, langkah pertama dari siklus PDCA, rencana kasar berdasarkan asumsi dibuat tanpa menggunakan data aktual.

Pilih aplikasi yang tepat untuk mengelola lokasi manufaktur dan melakukan manufaktur secara efisien. (Pilih satu.)

☐ ERP

☐ PDM

☒ MES

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- ☐ Dalam perencanaan, langkah pertama dari siklus PDCA, rencana kasar berdasarkan asumsi dibuat tanpa menggunakan data aktual.

Anda telah menyelesaikan tes pemahaman Bab 1.
Berikut adalah hasil tes Anda.

Bagaimana hasil Anda?
Sebaiknya coba lagi pertanyaan yang Anda jawab dengan salah.

		1	2	3	4	5	6	7	8	9	10
	Tes Pemahaman 1	✓									
	Tes Pemahaman 2	✓									
	Tes Pemahaman 3	✓									

Jumlah total pertanyaan: 3

Jawaban yang benar: 3

Persentase: 100 %

Hapus

Pada bab sebelumnya, konsep MES dan keuntungan menggunakan modul antarmuka MES untuk "memvisualisasikan" dan mengumpulkan data di lokasi manufaktur telah dijelaskan.

Bahkan, ada lebih banyak keuntungan dalam implementasi MES.

Keuntungan menggunakan database dan modul antarmuka MES dijelaskan dalam bab ini.

**Isi Bab 2**

- 2.1 Mengapa Database Digunakan?
- 2.2 Fitur Modul Antarmuka MES
- 2.3 Ringkasan

Pertama, mari pikirkan mengapa database digunakan untuk pengumpulan data.

Bagaimana data yang dikumpulkan akan digunakan?

Data digunakan untuk menampilkan status saat ini, membandingkan situasi sebelum dan sesudah tindakan diambil, mengekstraksi data dalam kondisi tertentu, dll.

Oleh karena itu, diperlukan pengumpulan data.

Penting juga agar data dapat digunakan dengan mudah.

Untuk alasan ini, data sering dikumpulkan dengan salah satu dari dua cara: Menyimpan dalam file seperti Excel, atau menyimpan dalam database.

Berikut ini adalah perbedaan antara kedua cara tersebut.

	Database	File (Excel, dll.)	Deskripsi
Jumlah data	○	△	Tidak banyak data yang dapat disimpan dalam file. 1048576 baris × 16384 kolom (dalam 1 lembar) * Untuk Excel 2016
Kemampuan pencarian data	○	△	Data tidak dapat dicari dengan mudah dalam file.
Pemrosesan eksklusif	○	×	Pengeditan simultan tidak dapat dilakukan dalam file.

Seperti yang dijelaskan di atas, ada berbagai keuntungan menggunakan database. Meskipun dapat dengan mudah digunakan dengan aplikasi yang dioperasikan dalam sistem TI, namun cenderung dihindari karena penggunaan data memerlukan pengetahuan pemrograman.

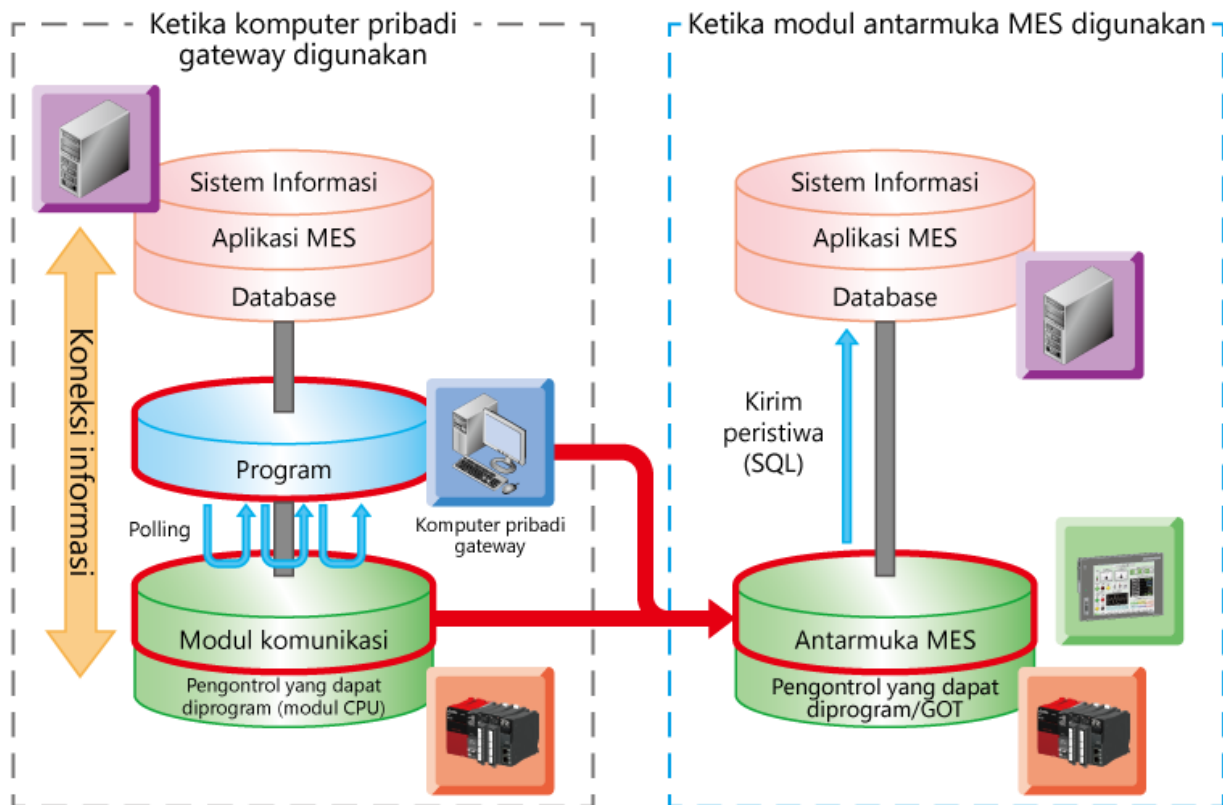
Namun, dengan menggunakan modul antarmuka MES, data tersebut dapat digunakan dengan mudah.

Modul antarmuka MES adalah modul yang membuat koneksi dengan database lebih mudah. Ada lebih banyak fitur selain yang telah Anda pelajari di bagian 1.2. Pada bagian ini, fitur-fitur tersebut dijelaskan.

<1. Tanpa komputer pribadi/tanpa program>

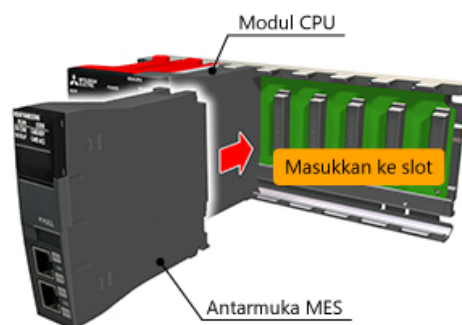
Saat menghubungkan database dengan menggunakan komputer pribadi sebagai gateway, program komunikasi untuk mengumpulkan data peralatan dan program untuk mengakses database harus dibuat.

Dengan menggunakan modul antarmuka MES, komputer pribadi sebagai gateway atau program tidak diperlukan, dan database dapat dengan mudah dihubungkan dengan biaya rendah.



<2. Implementasi sederhana>

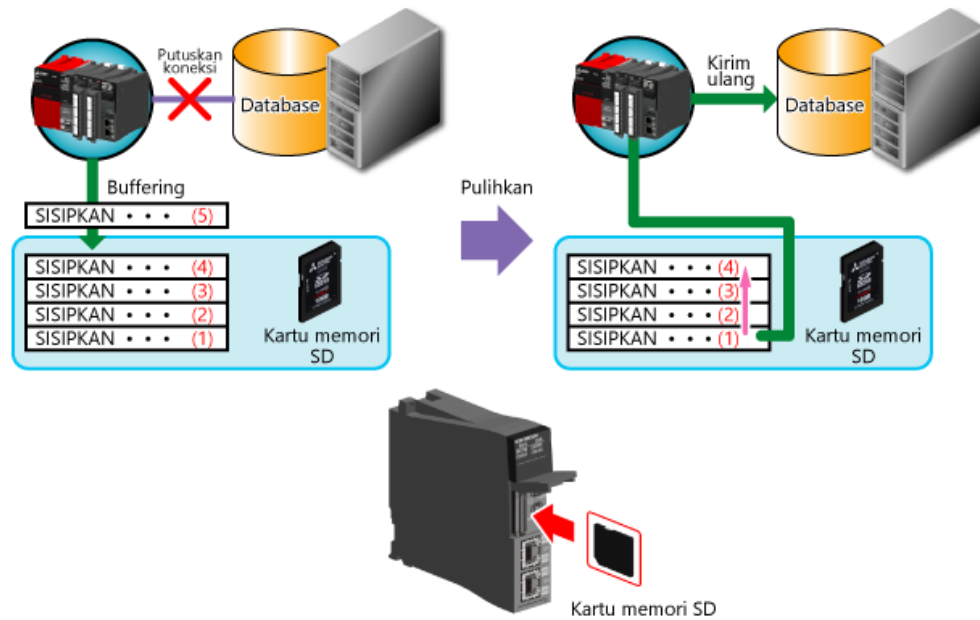
Modul antarmuka MES dapat diimplementasikan hanya dengan menginstalnya ke pengontrol yang dapat diprogram, dan program tangga untuk kontrol tidak perlu diubah.



<3. Mencegah hilangnya pengumpulan data dengan fungsi buffering DB>

Ketika komputer pribadi sebagai gateway digunakan, apa yang terjadi jika jaringan terputus atau server database nonaktif? Data tidak dapat dikirim, dan terjadi kelalaian pengumpulan data.

Dengan modul antarmuka MES, data di-buffer ke kartu memori SD yang dimasukkan dan dikirim ulang secara otomatis setelah pemulihan.

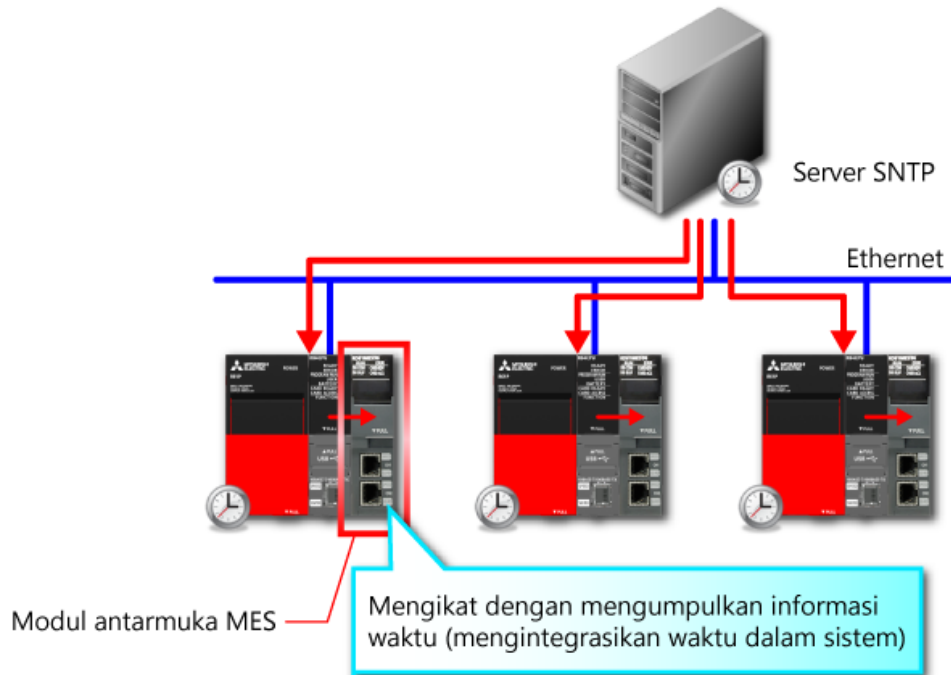


<4. Sinkronisasi waktu dengan sistem>

Pencocokan waktu di setiap peralatan dalam sistem sangat penting.

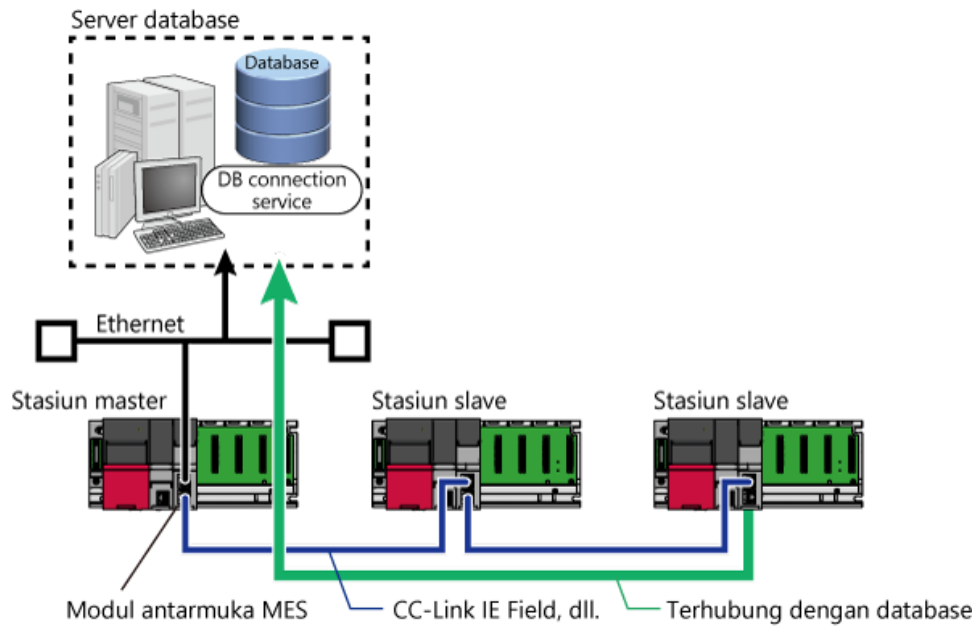
Misalnya, ketika terjadi kesalahan di lini produksi, jika waktu antar peralatan berbeda, status akurat tidak dapat diketahui dengan data yang dikumpulkan.

Waktu pada modul antarmuka MES dapat disinkronkan dengan modul CPU. Oleh karena itu, diperlukan sinkronkan waktu modul CPU dengan server SNTP terlebih dahulu untuk memberi stempel waktu yang akurat pada data dari setiap peralatan.



<5. Informasi tentang stasiun PLC lainnya dapat dihubungkan>

Karena mendukung jaringan lain seperti CC-Link IE Field, informasi dari stasiun PLC lain dapat dihubungkan melalui jaringan.



Dalam bab ini, Anda telah mempelajari:

- Mengapa database digunakan?
- Fitur modul antarmuka MES

Poin-poin

Mengapa database digunakan?	• Dengan menggunakan database, informasi yang dikumpulkan secara bersamaan oleh banyak orang dapat diperiksa, dan informasi yang dikumpulkan dapat disortir dan diekstraksi dengan mudah. • Karena status manufaktur diperiksa secara bersamaan dari beberapa perangkat di lokasi manufaktur, dan progres seluruh pabrik diperiksa dari kantor, sehingga penggunaan database menjadi optimal.
Fitur modul antarmuka MES	Lima fitur berikut merupakan fitur utama dari modul antarmuka MES. 1) Database dapat dihubungkan tanpa komputer pribadi dan program. 2) Prose instalasi yang sederhana hanya dengan menginstal modul antarmuka MES ke PLC dapat dilakukan. 3) Kalalaian pengumpulan data tidak terjadi bahkan pada kesalahan komunikasi karena data dikirim ulang secara otomatis setelah pemulihan. 4) Waktu dapat disinkronkan dengan server dengan menggunakan fungsi pengaturan sinkronisasi waktu dari modul CPU. 5) Informasi stasiun PLC lain dapat dihubungkan dengan database melalui jaringan.

[Tes pemahaman]

Sudahkah Anda memahami sepenuhnya isi Bab 2?

Ikuti tes pemahaman untuk memeriksa dan meninjau isinya.

(3 bagian, 3 pertanyaan)

Pilih jawaban yang salah dari keuntungan menggunakan database dibandingkan dengan pengelolaan data menggunakan file. (Pilih satu.)

- ☐ Banyak data yang dapat dikelola dan kemampuan pencarian data yang tinggi.
- ☐ Lebih sedikit data yang dapat dikelola, tetapi kemampuan penelusuran datanya tinggi.
- ☐ Beberapa akses simultan didukung karena memiliki performa tinggi dalam pemrosesan eksklusif.

Pilih deskripsi yang benar untuk fungsi buffering DB, yang merupakan fitur modul antarmuka MES. (Pilih satu.)

- ☐ Kelalaian pengumpulan data dapat dicegah bahkan pada kegagalan jaringan karena data dapat di-buffer di kartu memori SD dan secara otomatis dikirim ulang setelah pemulihan.
- ☐ Data dalam database dapat disimpan ke dalam kartu SD kapan saja dengan mengatur MES interface function configuration tool terlebih dahulu.
- ☐ Fungsi buffering DB menyangga data ke memori internal di modul antarmuka MES saat terjadi kegagalan jaringan.

Pilih deskripsi yang benar untuk fungsi sinkronisasi waktu dari modul antarmuka MES. (Pilih satu.)

☐ Hanya waktu modul CPU yang dapat disinkronkan.

☐ Hanya waktu server yang dapat disinkronkan.

☐ Waktu tidak dapat disinkronkan.

Pilih jawaban yang salah dari keuntungan menggunakan database dibandingkan dengan pengelolaan data menggunakan file. (Pilih satu.)

- ☐ Banyak data yang dapat dikelola dan kemampuan pencarian data yang tinggi.
- ☒ Lebih sedikit data yang dapat dikelola, tetapi kemampuan penelusuran datanya tinggi.
- ☐ Beberapa akses simultan didukung karena memiliki performa tinggi dalam pemrosesan eksklusif.

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☒ Hanya waktu modul CPU yang dapat disinkronkan.

☐ Hanya waktu server yang dapat disinkronkan.

☐ Waktu tidak dapat disinkronkan.

Anda telah menyelesaikan ujian pemahaman Bab 2.
Berikut adalah hasil tes Anda.

Bagaimana hasil Anda?
Sebaiknya coba lagi pertanyaan yang Anda jawab dengan salah.

		1	2	3	4	5	6	7	8	9	10
	Tes pemahaman 1	✓									
	Tes pemahaman 2	✓									
	Tes pemahaman 3	✓									

Jumlah total pertanyaan: 3

Jawaban yang benar: 3

Persentase: 100 %

Hapus

Pada bab sebelumnya, efektivitas database dan berbagai fitur modul antarmuka MES dijelaskan.

Dalam bab ini, cara mengonfigurasi pengaturan dengan menggunakan MES interface function configuration tool dijelaskan dengan poin-poin yang dijelaskan.

Saat menginstal modul antarmuka MES, hal-hal berikut diperlukan.

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

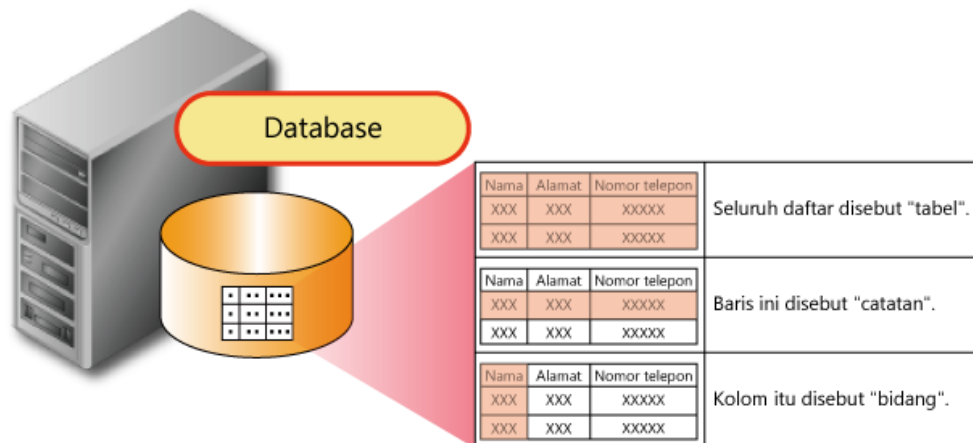
Perangkat lunak berikut disimpan di MX MESInterface-R.

- MES interface function configuration tool
 - Layanan koneksi DB dan alat pengaturan
 - Alat konversi file proyek * Tidak digunakan dalam bab ini.
- Kartu memori SD

Isi Bab 3

- 3.1 Struktur Database
- 3.2 Konfigurasi Sistem
- 3.3 Memulai MES interface function configuration tool
- 3.4 Pengaturan dengan MES interface function configuration tool
- 3.5 Contoh Sistem Modul Antarmuka MES
- 3.6 Ringkasan

Sebelum penjelasan tentang metode pengaturan, bagaimana data dikelola dalam database akan dijelaskan.

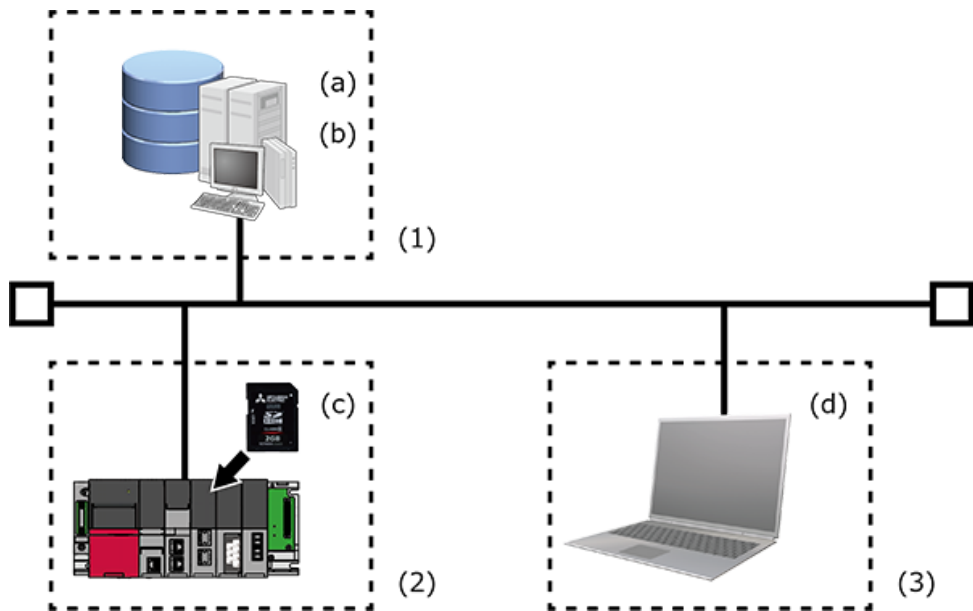


Konfigurasi sistem modul antarmuka MES ditunjukkan di bawah ini.

Dalam konfigurasi sistem, ada pengontrol yang dapat diprogram yang mengontrol server database dan mesin, dan modul antarmuka MES diinstal ke pengontrol yang dapat diprogram.

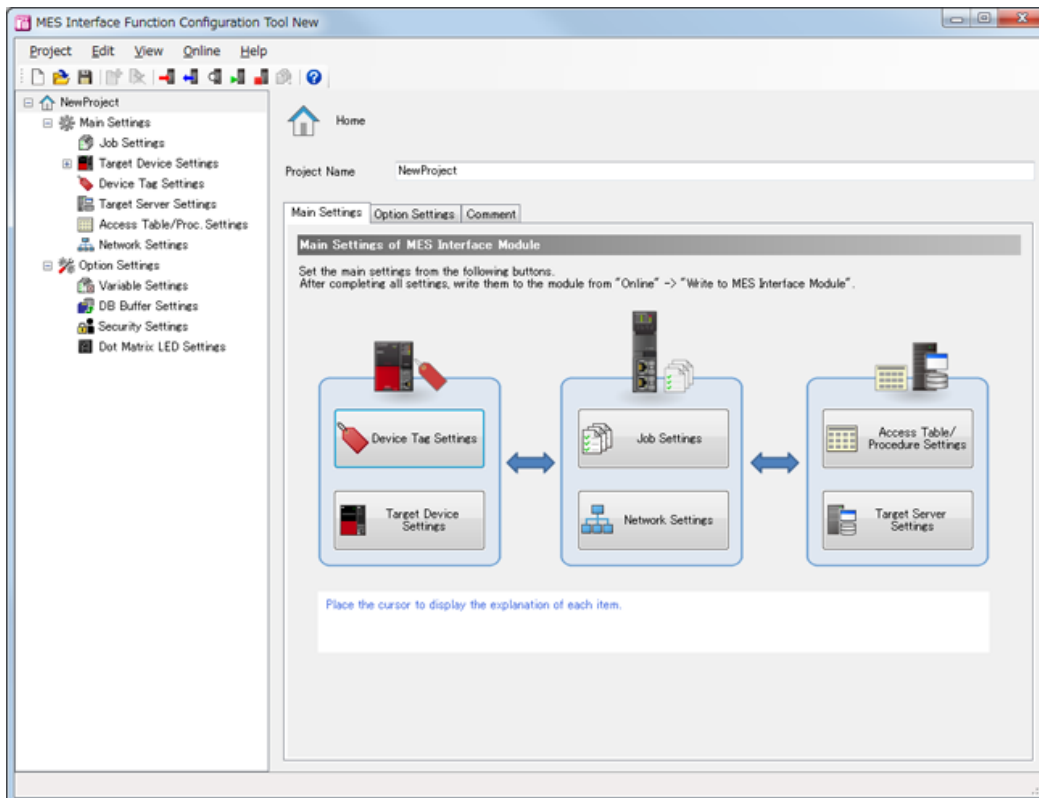
Server database dan modul antarmuka MES terhubung melalui Ethernet.

Dalam bab ini, diasumsikan bahwa penginstalan MES interface function configuration tool, layanan koneksi DB, dan alat pengaturan telah selesai.



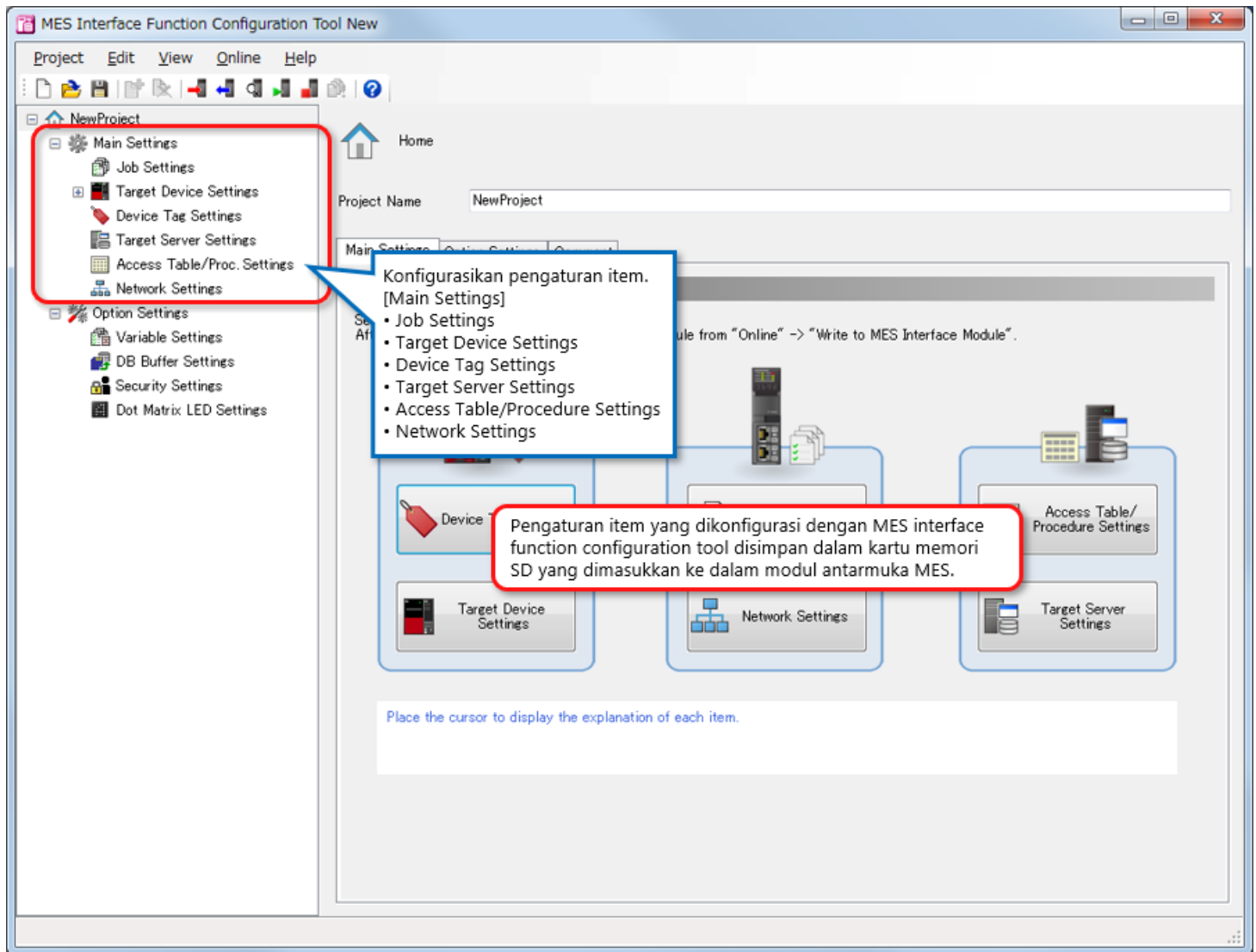
Konfigurasi Sistem			
(1)	Server database	(a)	• Layanan koneksi DB • Server koneksi DB dan alat pengaturan
		(b)	• Microsoft Access
(2)	Modul antarmuka MES	(c)	• Kartu memori SD (diperlukan)
(3)	Komputer pribadi untuk konfigurasi	(d)	• MES interface function configuration tool

MES interface function configuration tool adalah perangkat lunak untuk mengonfigurasi pengaturan ke modul antarmuka MES yang diperlukan untuk mengoperasikannya.



Ketika MES interface function configuration tool terbuka, jendela berikut akan ditampilkan.

Di jendela di sisi kiri layar, item yang akan dikonfigurasi ditampilkan sebagai item utama di bawah "NewProject".

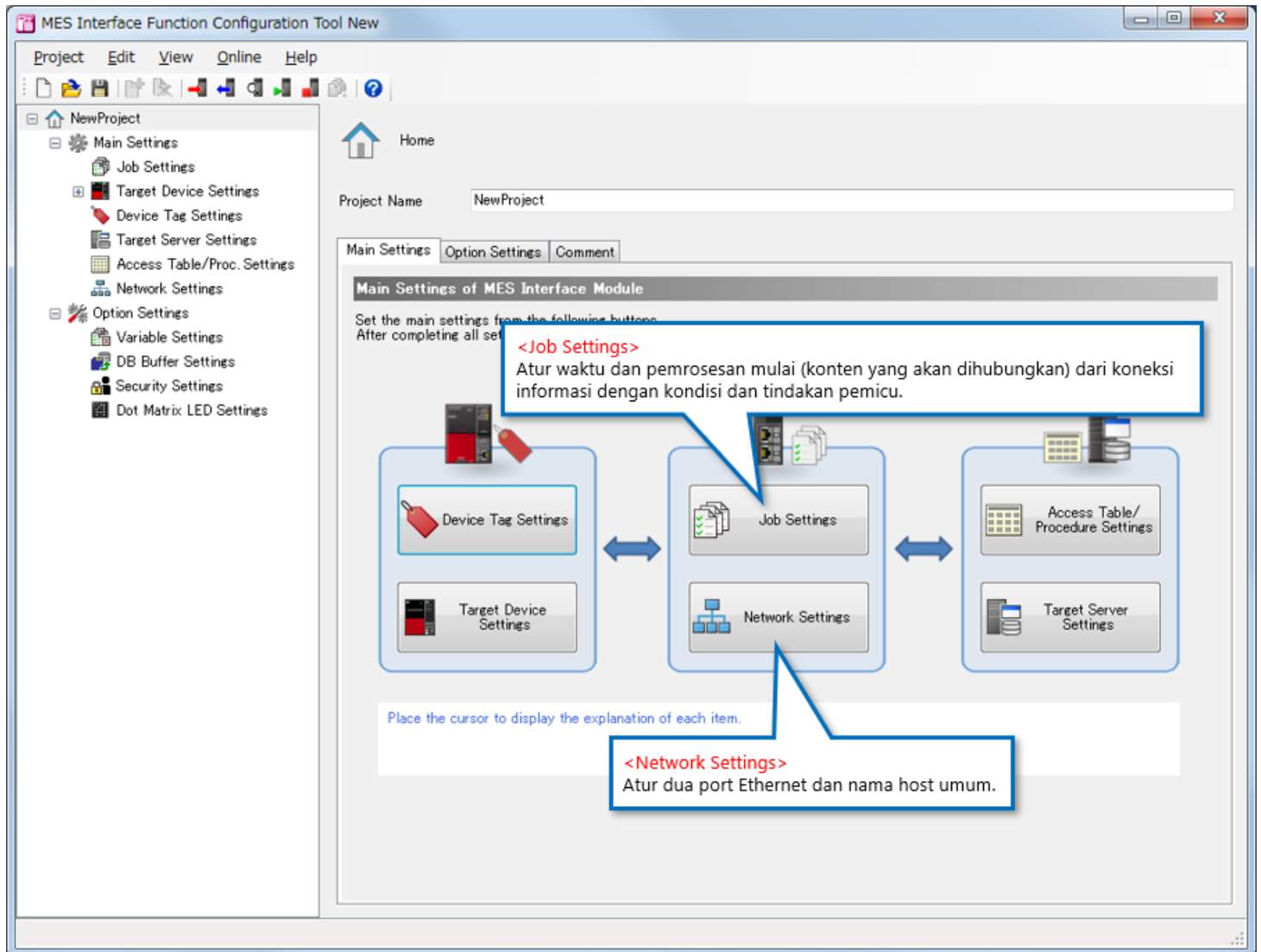


Pengaturan menggunakan layar sebenarnya dijelaskan di Bagian 3.3.

Setiap item pengaturan dijelaskan secara singkat dari halaman berikutnya.

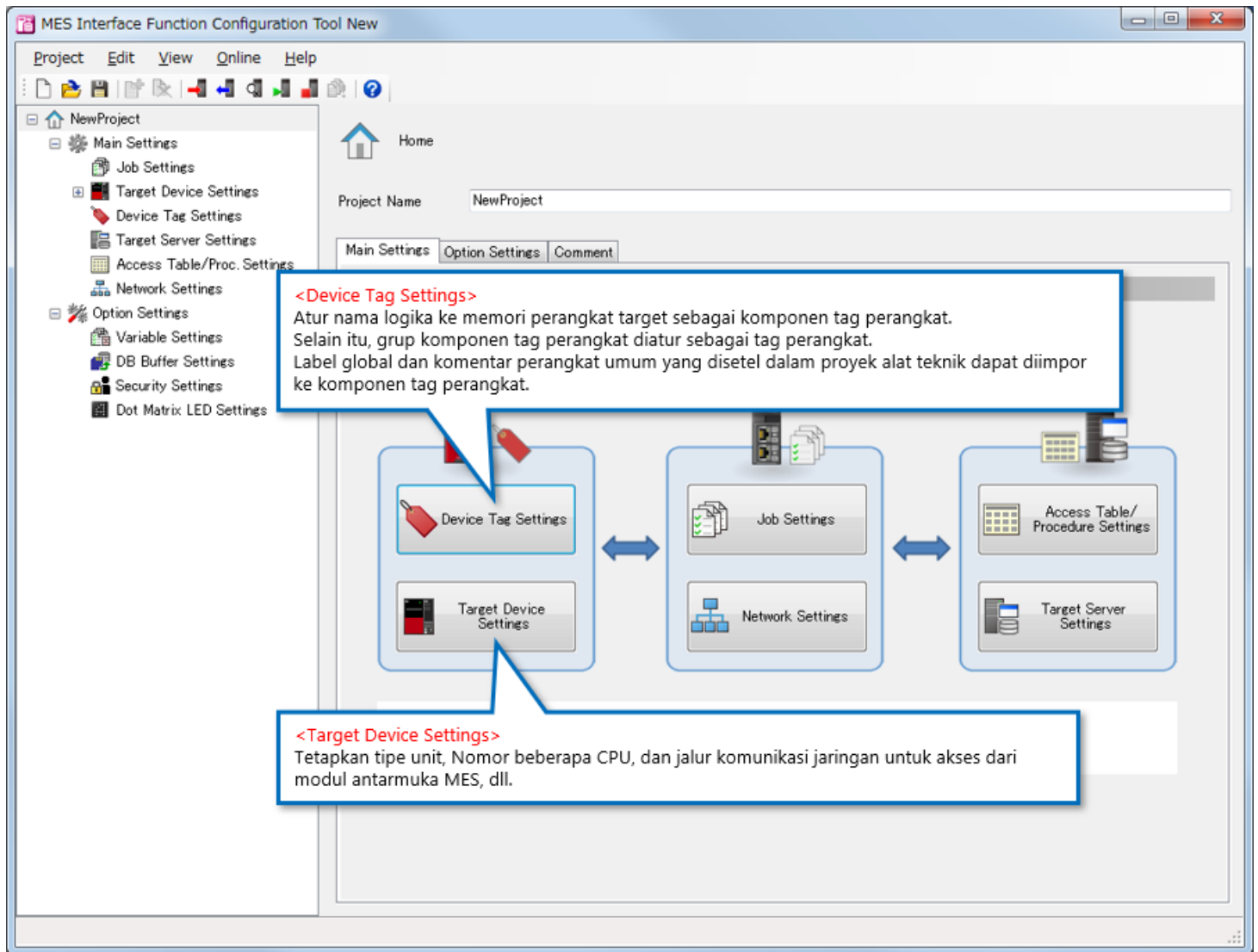
3.3 Item Pengaturan MES interface function configuration tool

Berikut ini menunjukkan "Job Settings" dan "Network Settings" yang diatur di MES interface function configuration tool.



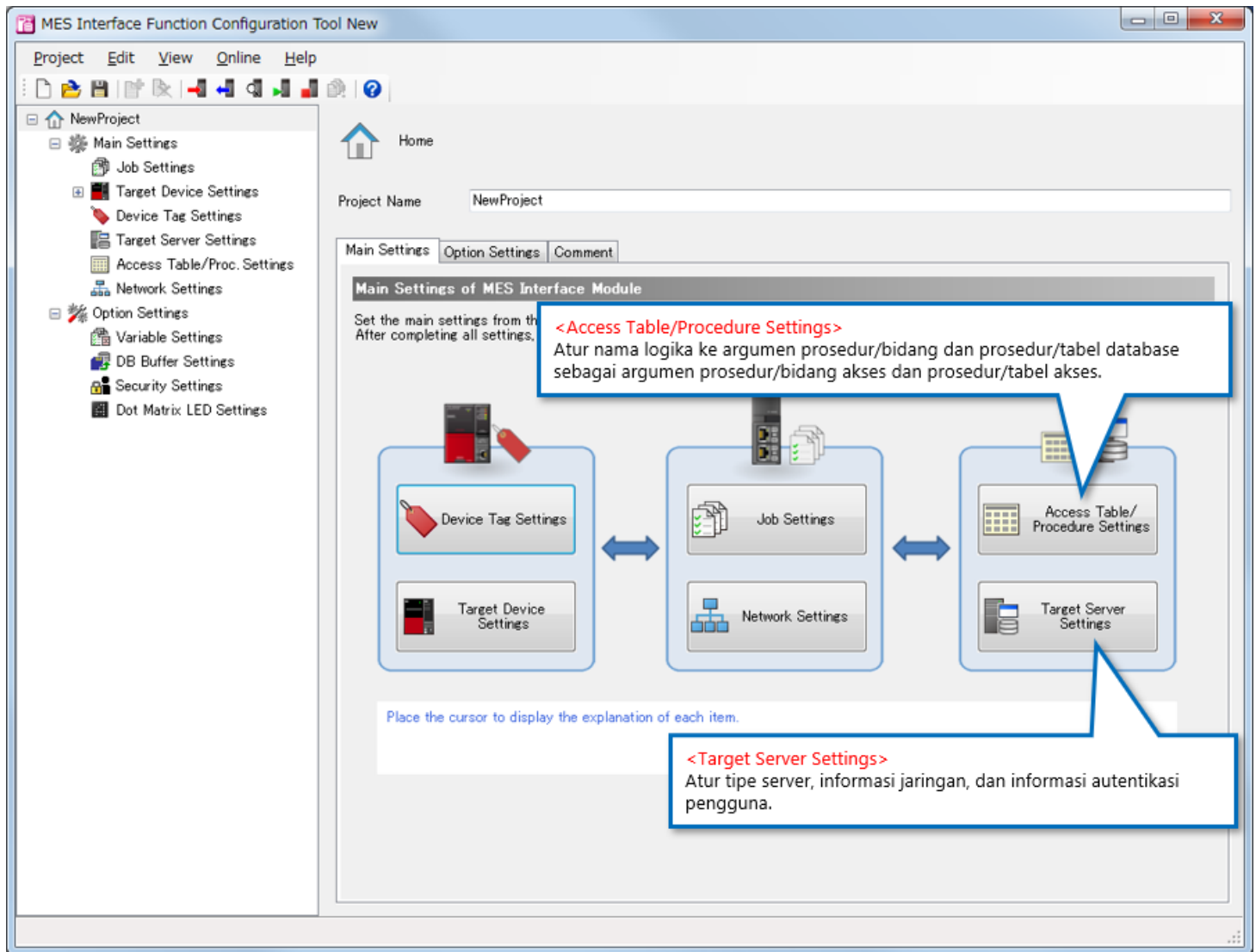
3.3 Item Pengaturan MES interface function configuration tool

Berikut ini menunjukkan "Target Device Settings" dan "Device Tag Settings" yang diatur di MES interface function configuration tool.



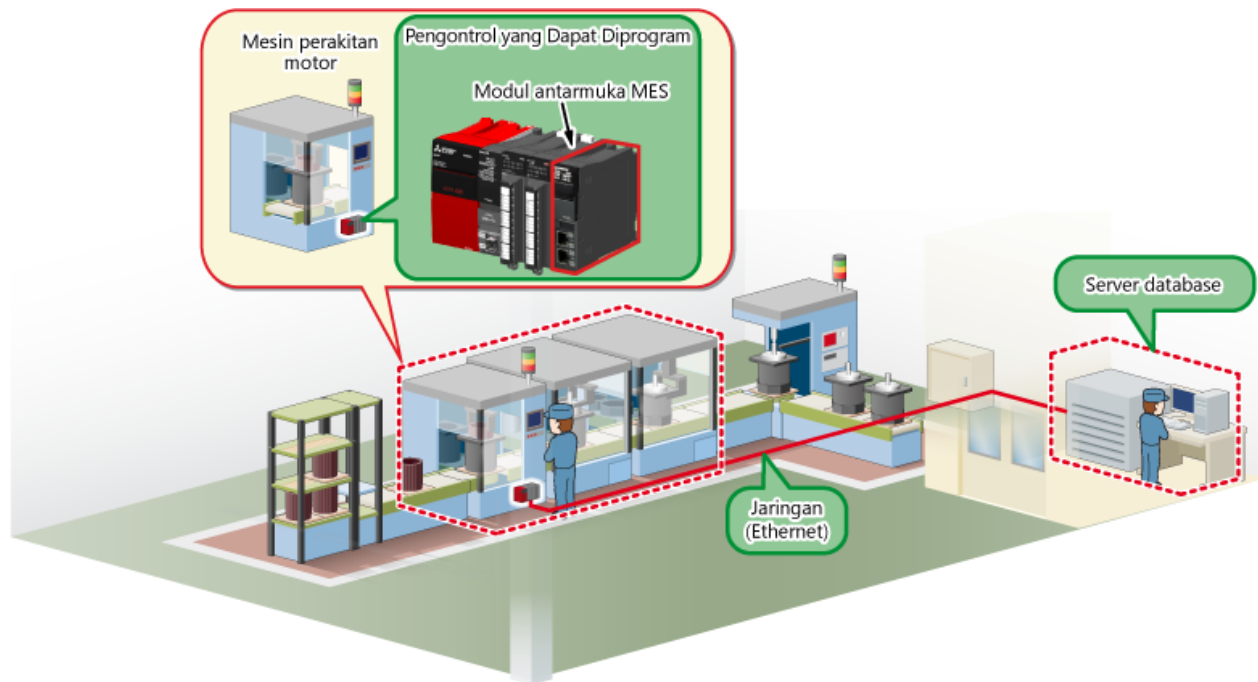
3.3 Item Pengaturan MES interface function configuration tool

Berikut ini menunjukkan "Target Server Settings" dan "Access Table/Procedure Settings" yang diatur di MES interface function configuration tool.

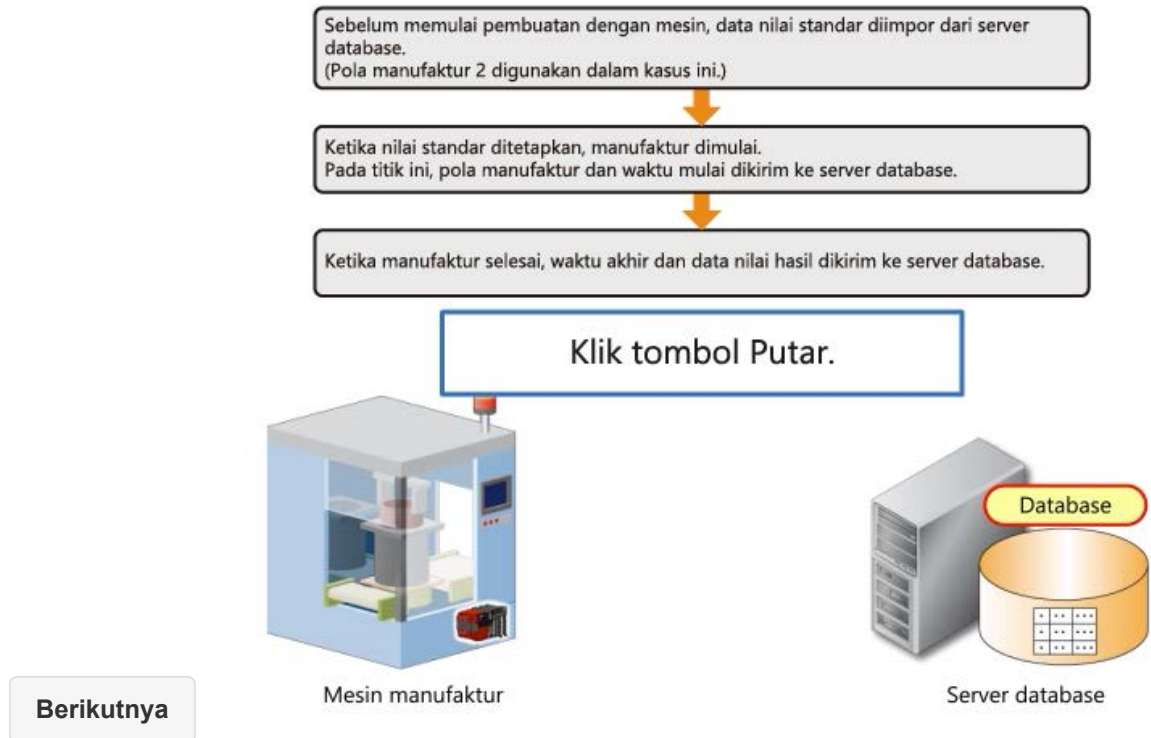


Anda telah memahami item utama, lalu mari konfigurasi detailnya.
Operasi peralatan manufaktur yang diatur kali ini akan dijelaskan.

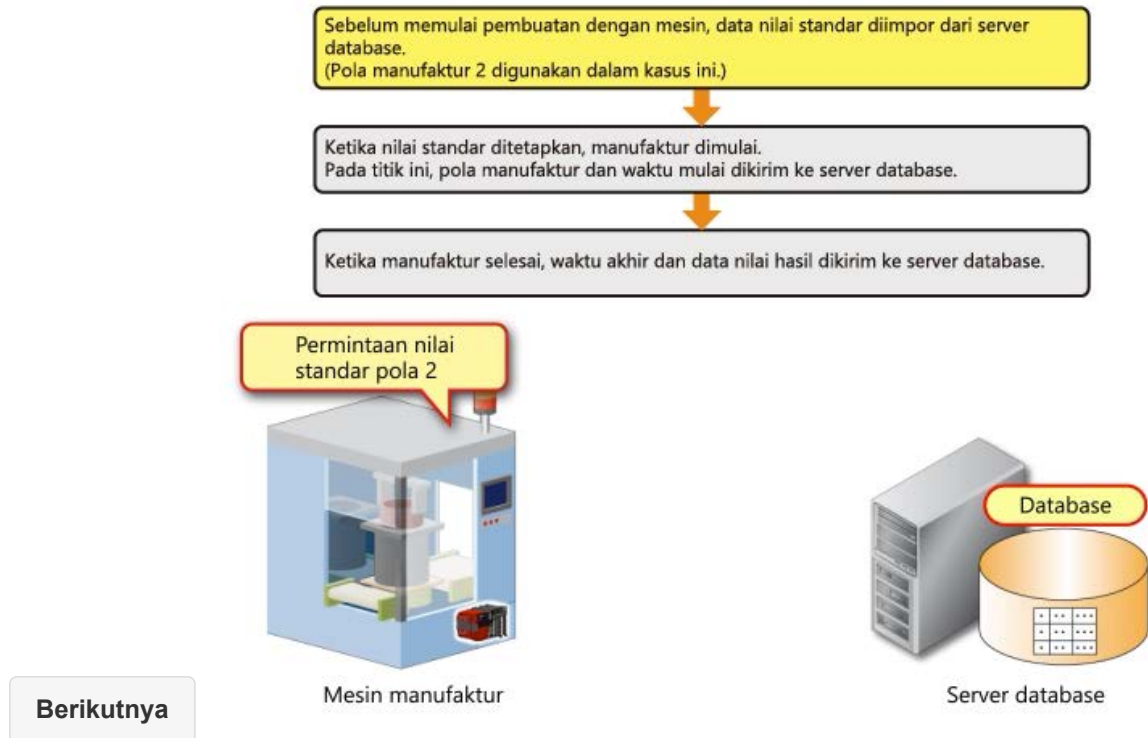
Mesin perakitan motor digunakan sebagai contoh untuk konfigurasi pengaturan.



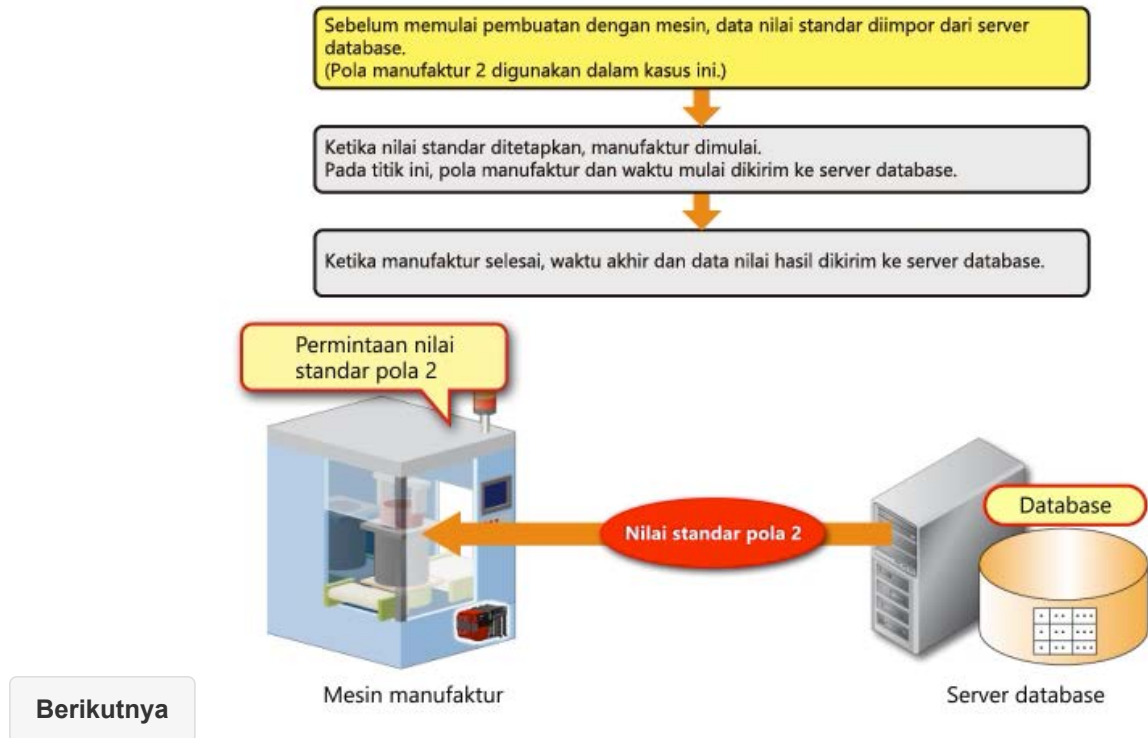
Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



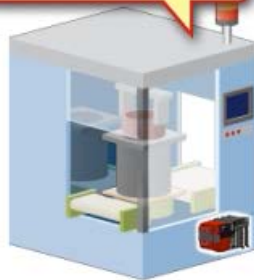
Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.

Sebelum memulai pembuatan dengan mesin, data nilai standar diimpor dari server database.
(Pola manufaktur 2 digunakan dalam kasus ini.)

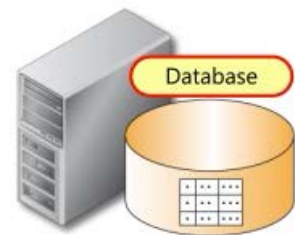
Ketika nilai standar ditetapkan, manufaktur dimulai.
Pada titik ini, pola manufaktur dan waktu mulai dikirim ke server database.

Ketika manufaktur selesai, waktu akhir dan data nilai hasil dikirim ke server database.

Mulai manufaktur



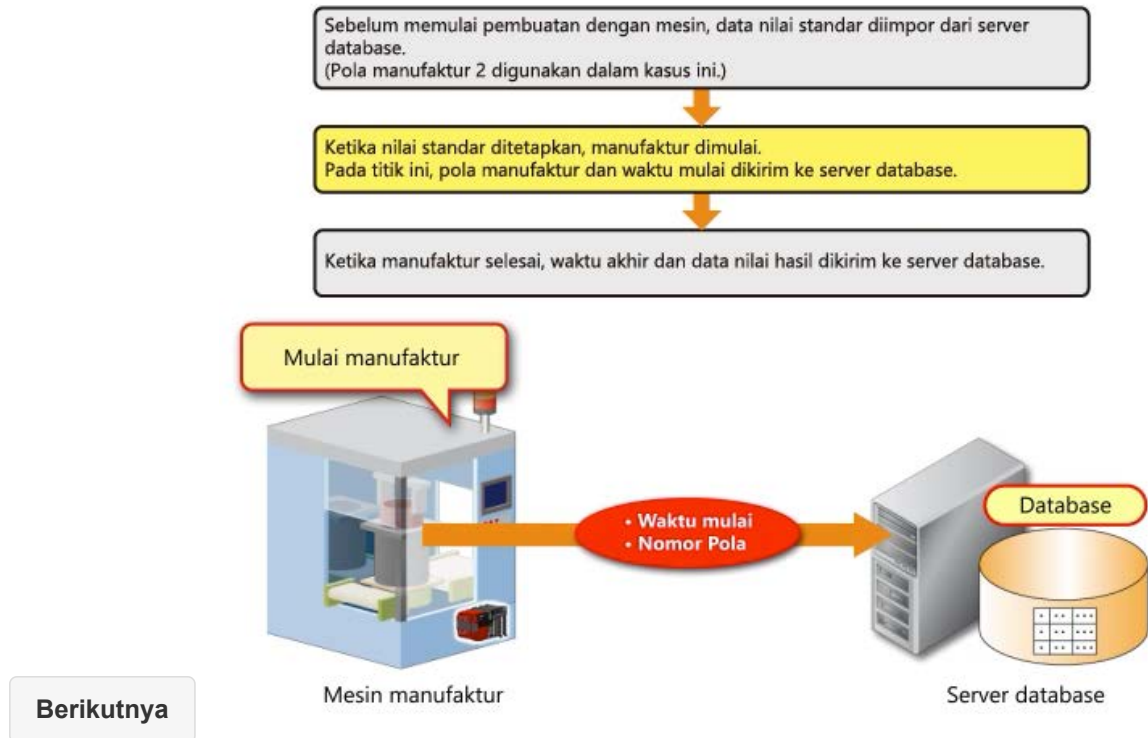
Mesin manufaktur



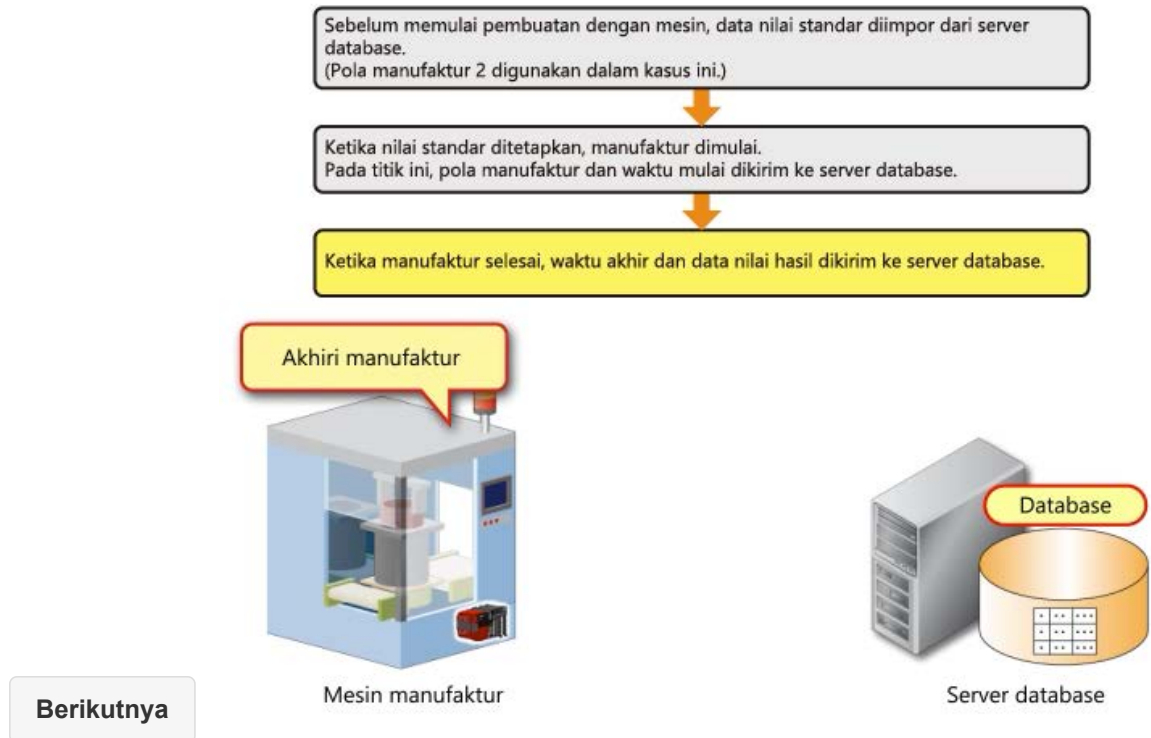
Server database

Berikutnya

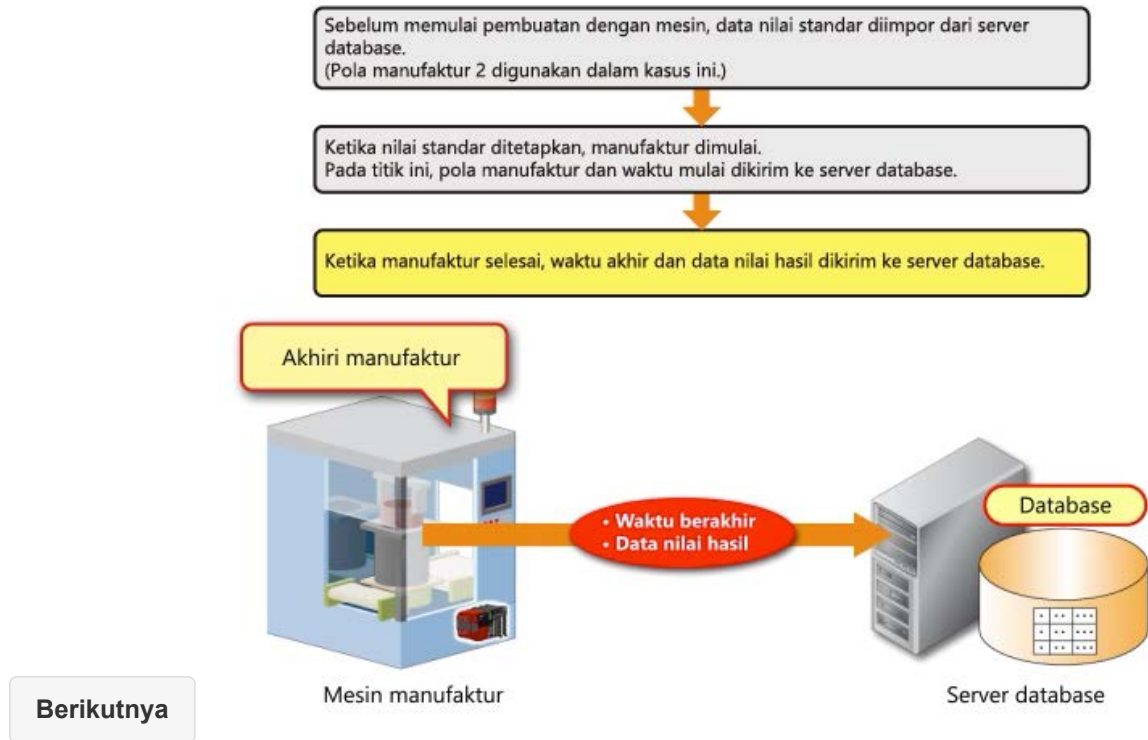
Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



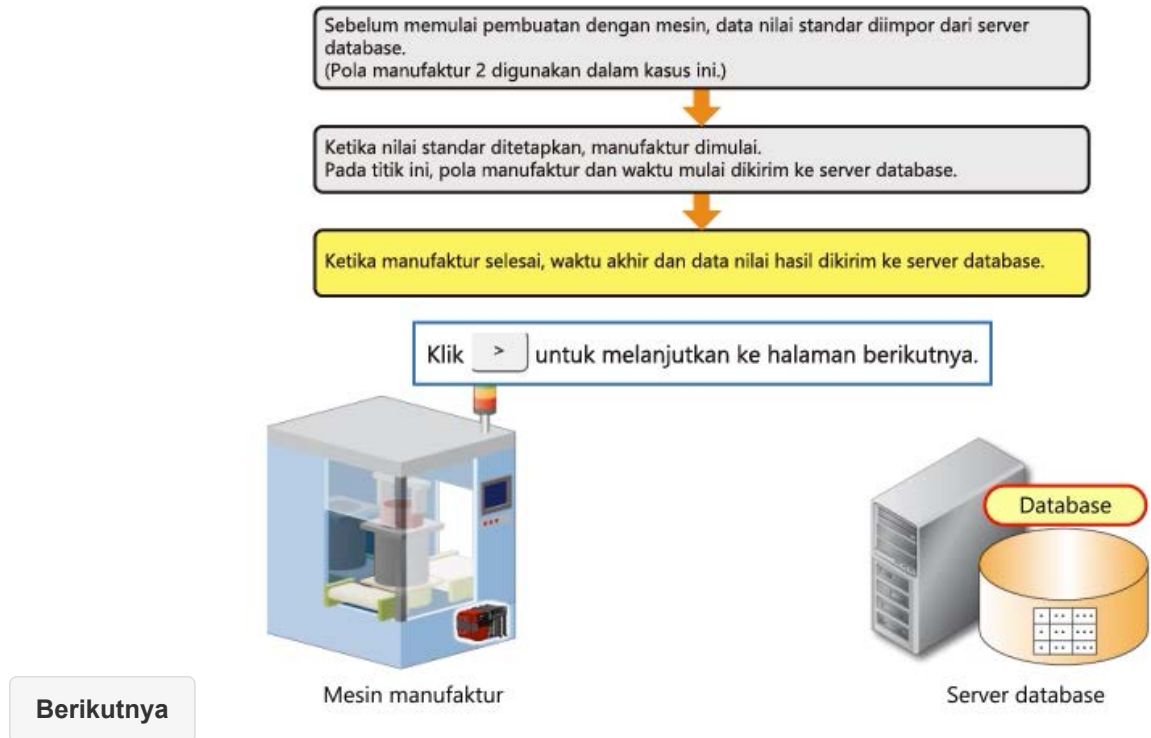
Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



Peralatan manufaktur beroperasi seperti yang ditunjukkan di bawah ini.



Dalam kursus ini, Access 2016 digunakan sebagai database.

Diasumsikan bahwa dua tabel berikut, ParamTable dan ResultTable, disiapkan di server database.

Nilai standar (parameter) dari peralatan yang akan digunakan untuk pembuatan didaftarkan di ParamTable terlebih dahulu. Ada tiga bidang dalam tabel:

- Nomor Pola (PatterNo)
- Beban press-fitting (Load)
- Tinggi press-fitting (Height)

Pengontrol yang dapat diprogram mengontrol alat berat sesuai dengan beban dan ketinggian pas tekan.

<Table name: ParamTable>

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

ResultTable digunakan untuk menyimpan data hasil setelah manufaktur selesai.

Ada lima bidang dalam tabel:

- Nomor Pola Produksi (PatternNo)
- Nilai hasil beban press-fitting (LoadResult)
- Nilai hasil tinggi press-fitting (HeightResult)
- Waktu mulai manufaktur (StartTime)
- Waktu akhir manufaktur (EndTlme)

Buat catatan dan atur PatternNo dan StartTime saat perakitan motor dimulai. Atur data ke bidang yang tersisa setelah perakitan selesai.

<Table name: ResultTable>

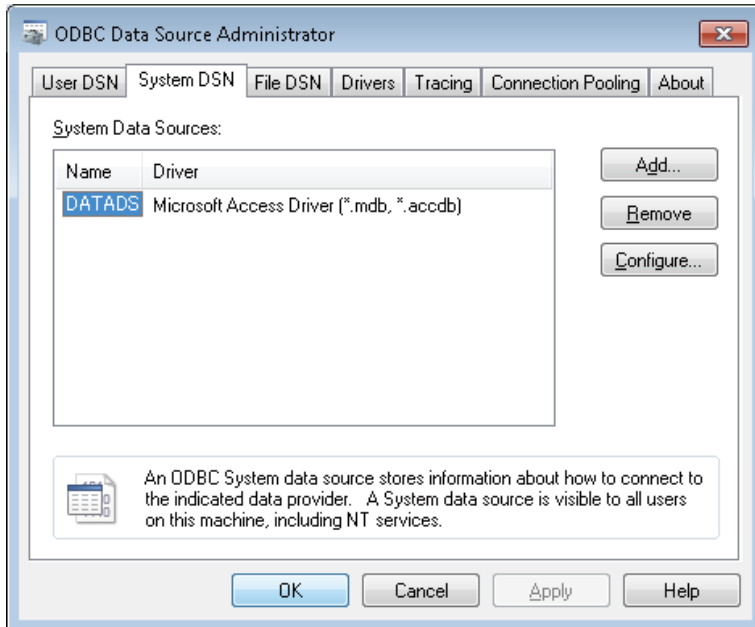
PatternNo	LoadResult	HeightResult	StartTime	EndTime

Modul antarmuka MES mengakses database melalui ODBC.

Untuk menggunakan fungsi ODBC, tipe database, nama sumber data, dan nama database yang akan digunakan harus diatur dalam pengaturan ODBC Windows.

Nama sumber data digunakan dalam pengaturan server target MES interface function configuration tool.

Dalam kursus ini, diasumsikan bahwa pengaturan ODBC sudah selesai terlebih dahulu.



<Peta perangkat modul CPU>

Berikut ini adalah daftar memori perangkat yang digunakan dalam pengaturan ini.

<Perangkat bit>

Memori perangkat	Arti memori perangkat
M0	Manufaktur sudah siap
M1	Mulai manufaktur
M2	Manufaktur selesai

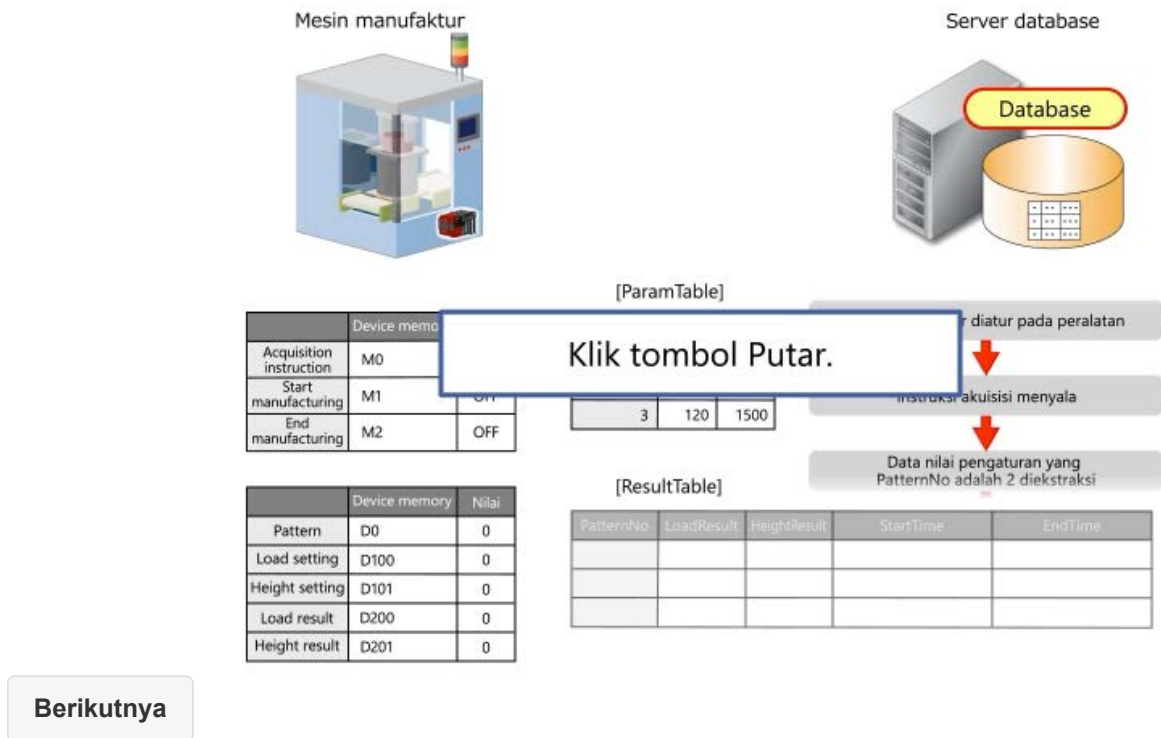
<Perangkat kata>

Memori perangkat	Arti memori perangkat
D0	Pattern No.
D100	Nilai pengaturan beban press-fitting
D101	Nilai pengaturan tinggi press-fitting
D200	Nilai hasil dari beban press-fitting
D201	Nilai hasil tinggi press-fitting

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

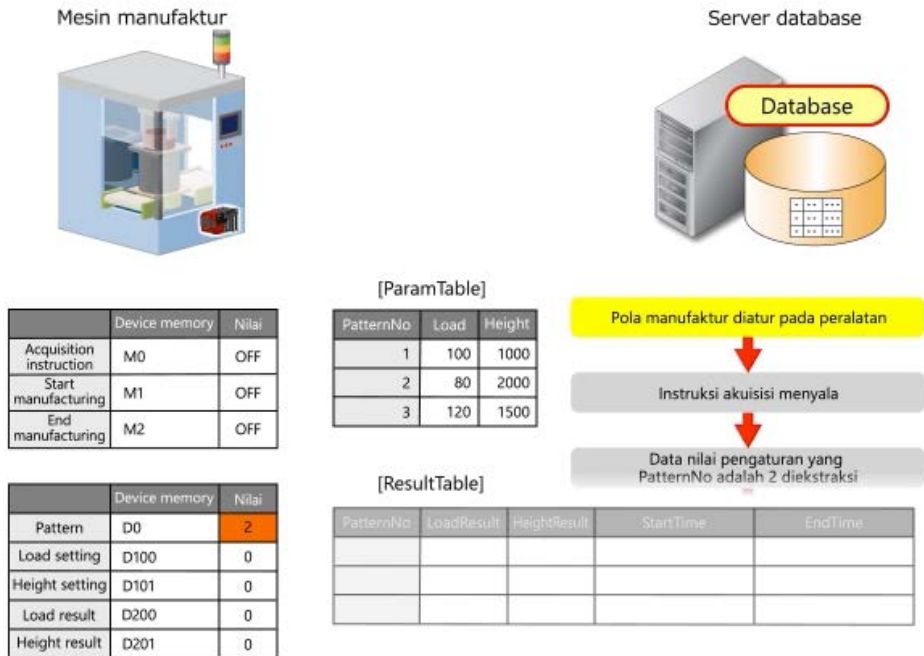
<Proses data>



<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>

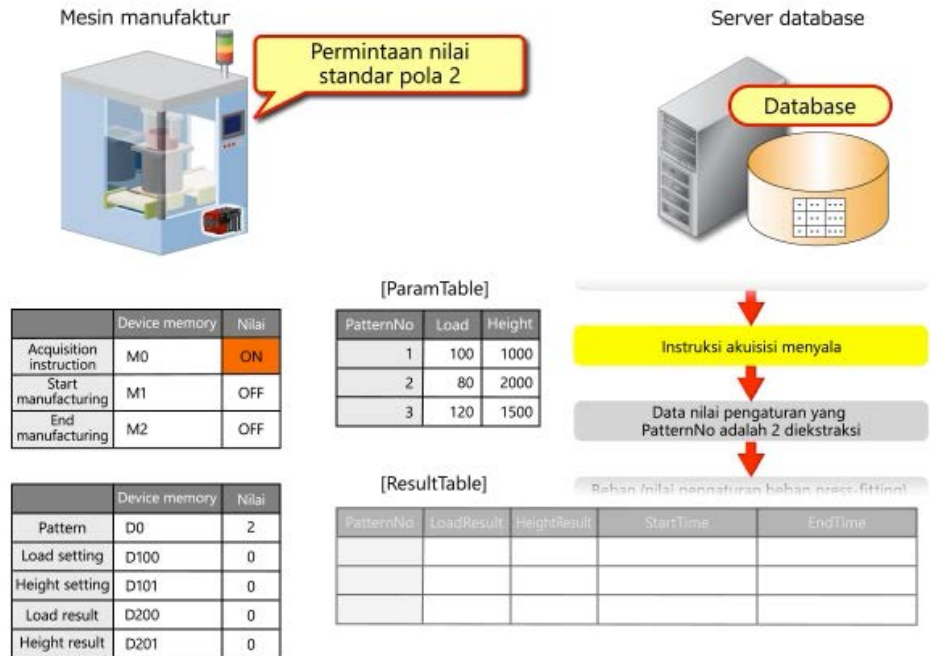


Berikutnya

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>

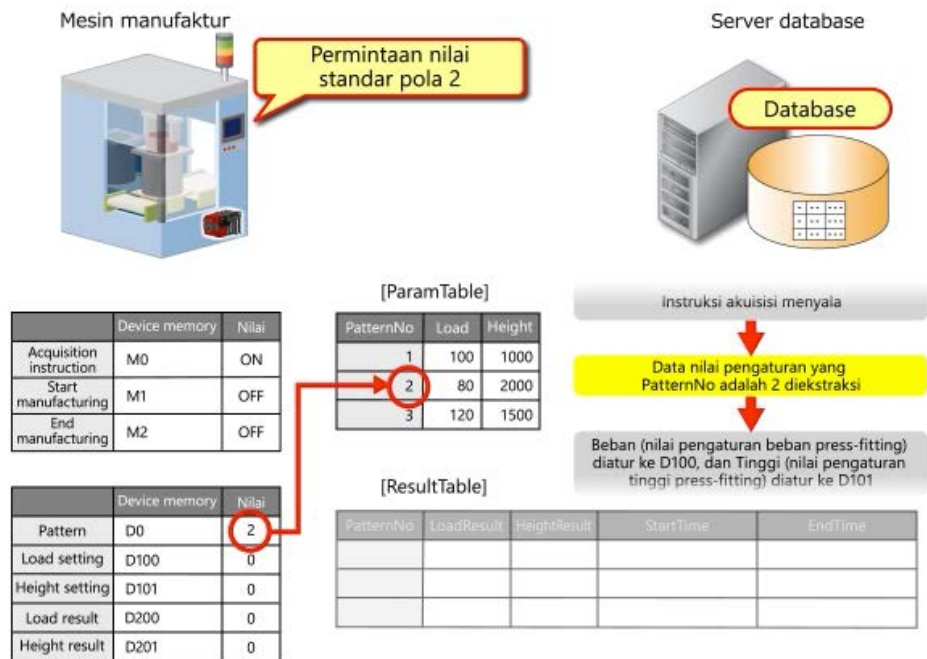


Berikutnya

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>

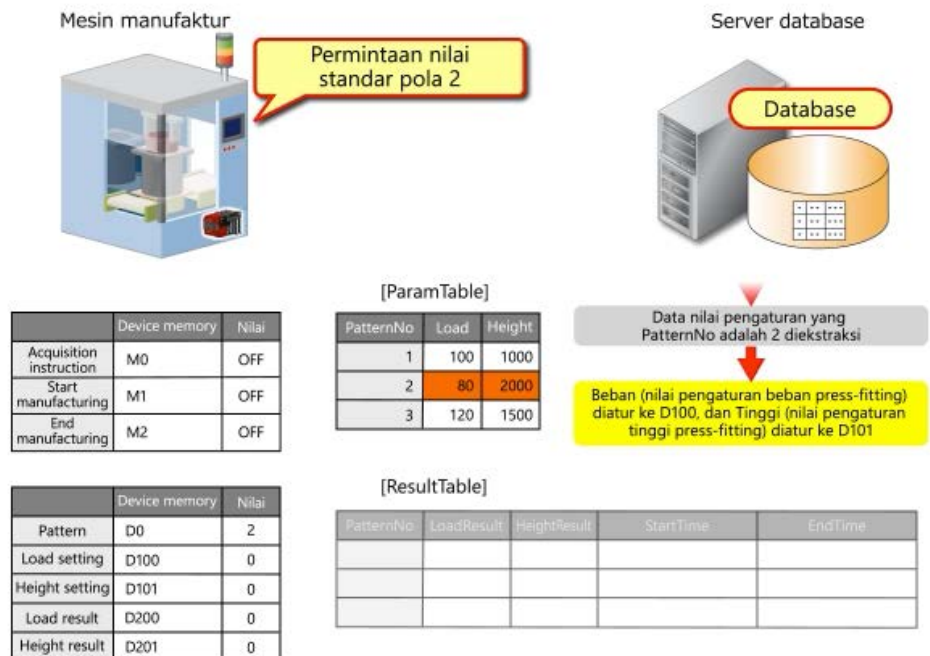


Berikutnya

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>

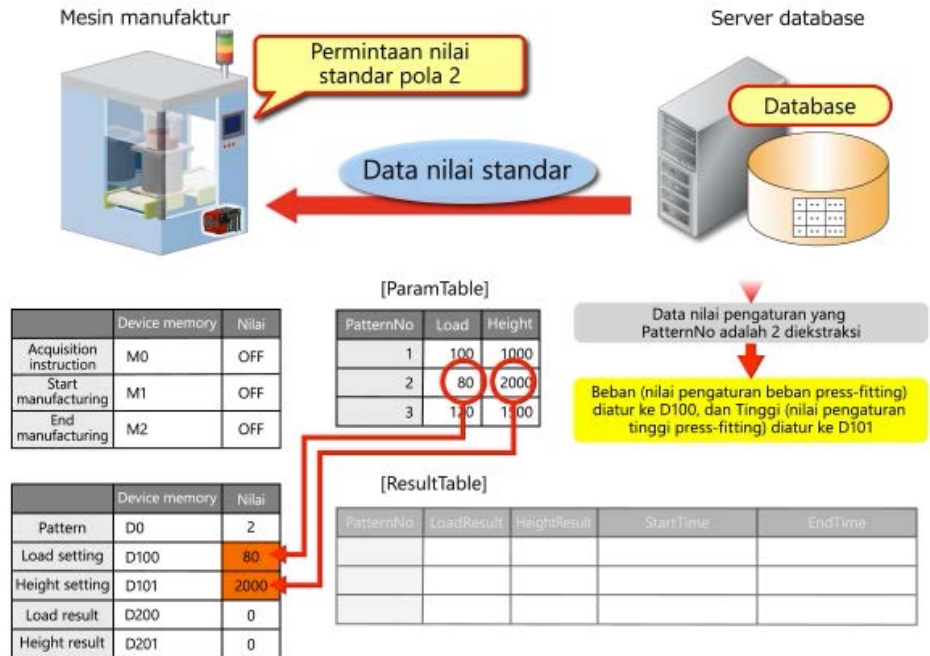


Berikutnya

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>



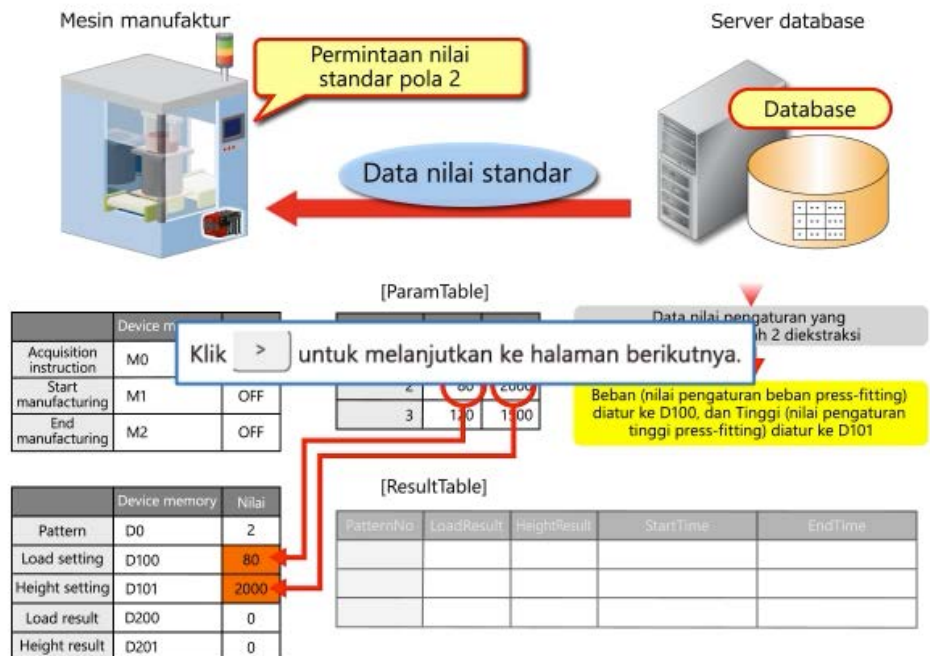
Berikutnya

3.4 Pengaturan dengan MES interface function configuration tool (Akuisisi Data)

<Proses memperoleh data dari database>

Ketika instruksi akuisisi (M0) diaktifkan saat pola manufaktur (D0 = 2) diatur di peralatan, modul antarmuka MES mengekstrak data nilai pengaturan PatternNo = 2 di ParamTable, Beban (nilai pengaturan beban press-fitting) diatur ke D100, dan Tinggi (nilai pengaturan tinggi press-fitting) diatur ke D101.

<Proses data>

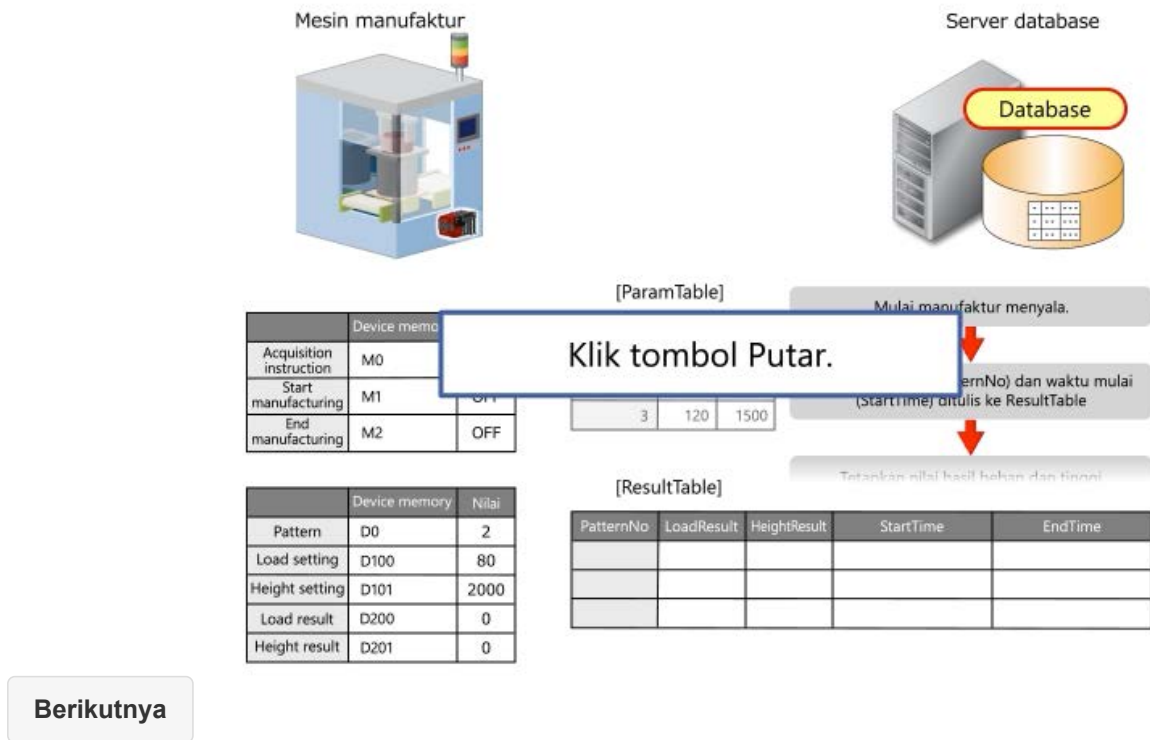


Berikutnya

<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
 - 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).
- * Untuk waktu, data waktu dari modul antarmuka MES digunakan.

<Proses data>

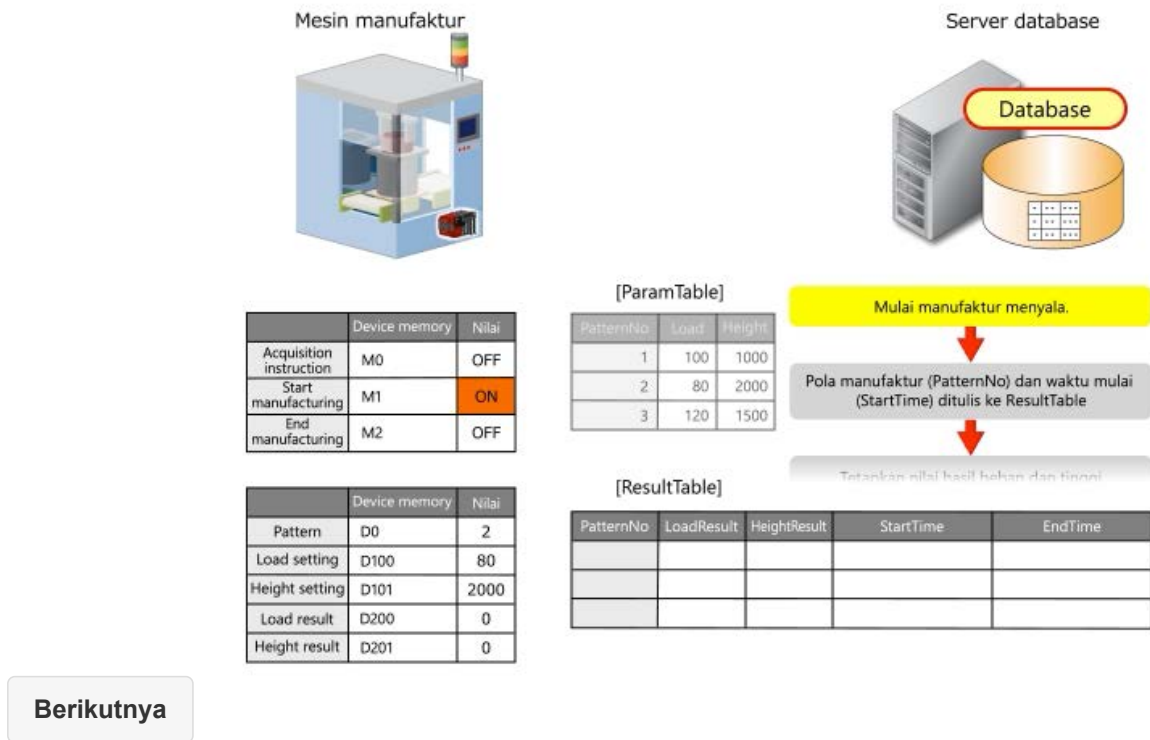


<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
- 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).

* Untuk waktu, data waktu dari modul antarmuka MES digunakan.

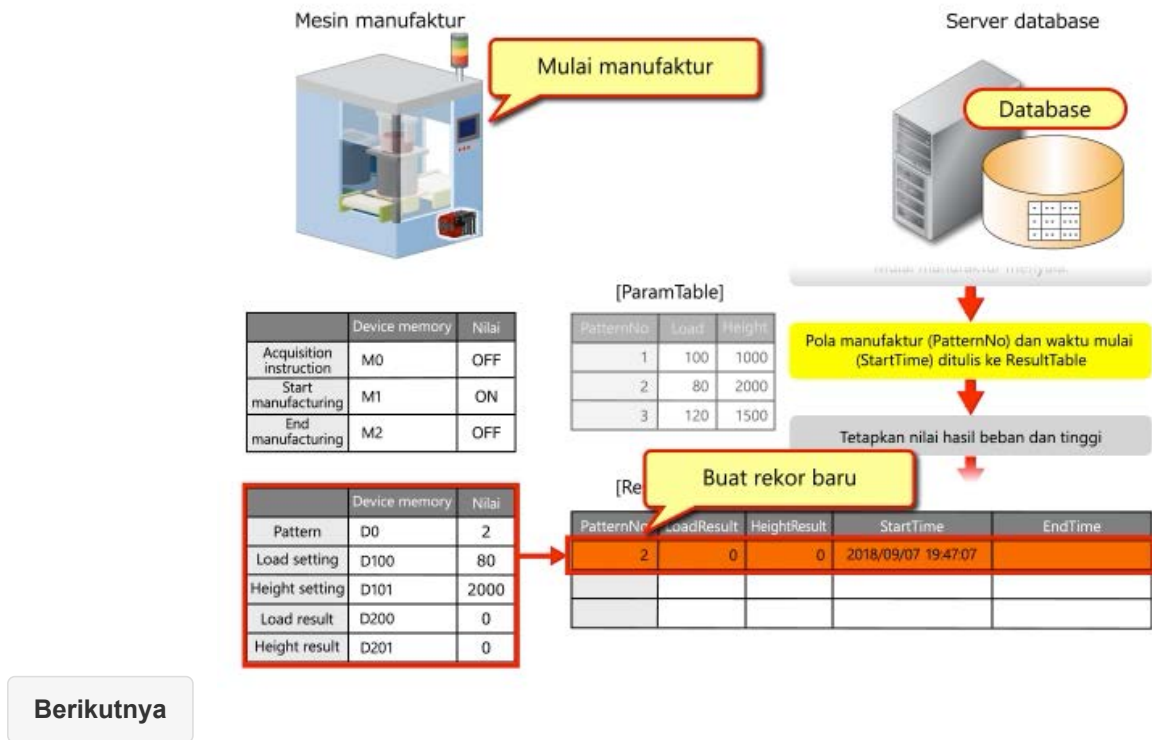
<Proses data>



<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
 - 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).
- * Untuk waktu, data waktu dari modul antarmuka MES digunakan.

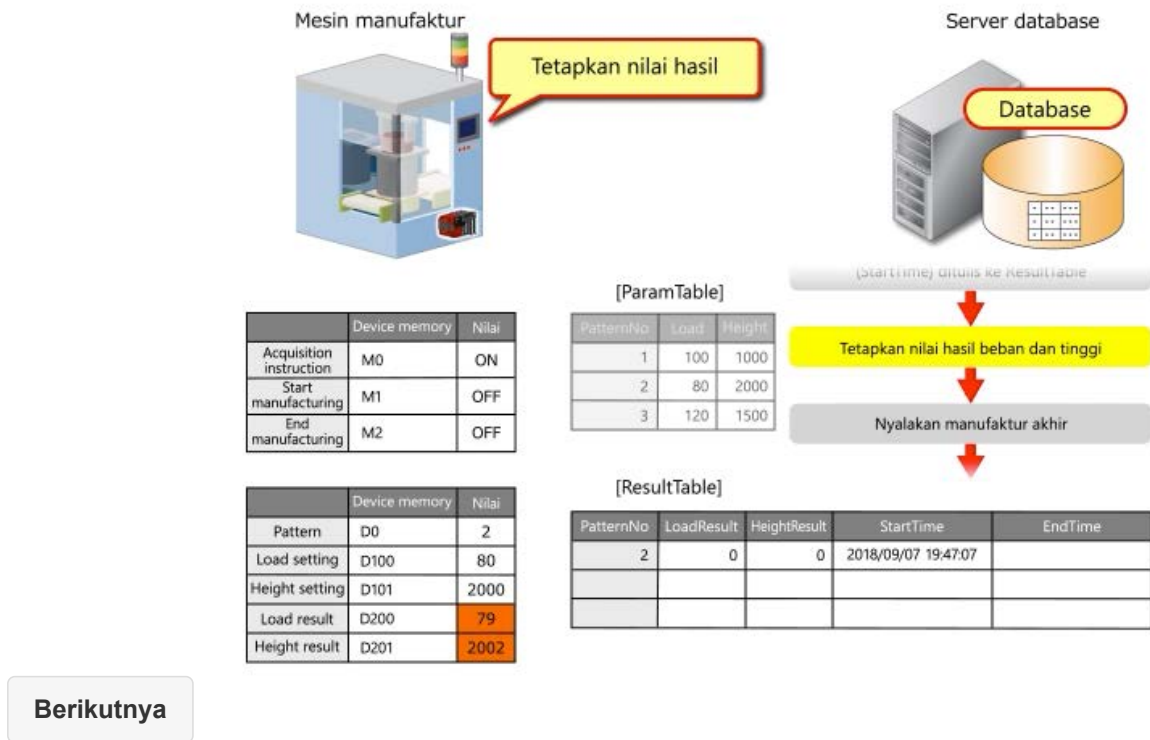
<Proses data>



<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
 - 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).
- * Untuk waktu, data waktu dari modul antarmuka MES digunakan.

<Proses data>

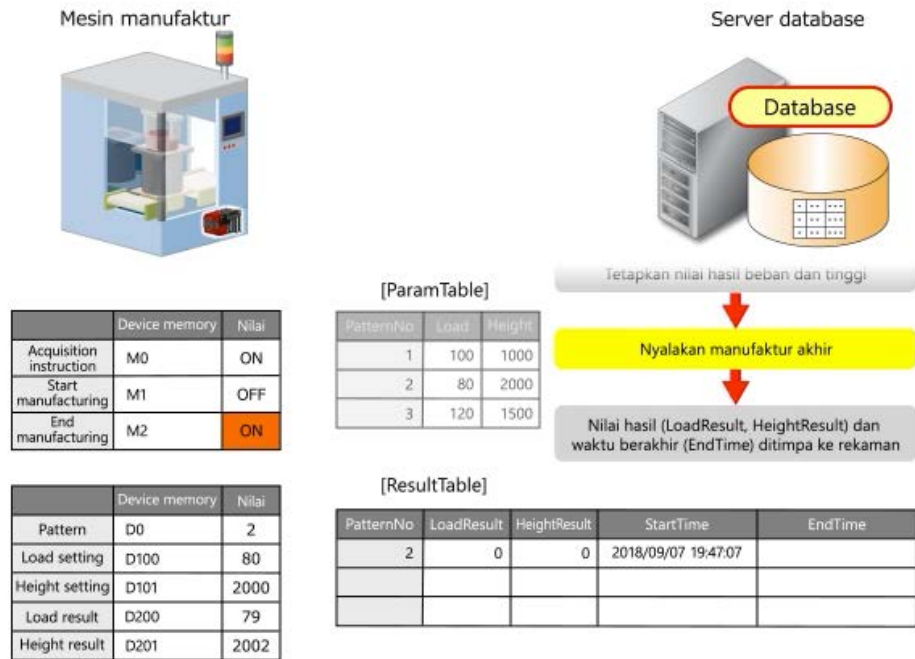


<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
- 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).

* Untuk waktu, data waktu dari modul antarmuka MES digunakan.

<Proses data>



Berikutnya

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
- 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).

* Untuk waktu, data waktu dari modul antarmuka MES digunakan.

Mesin manufaktur

Akhiri manufaktur

Server database

Database

Data nilai hasil

[ParamTable]

Nyalakan manufaktur akhir

Nilai hasil (LoadResult, HeightResult) dan waktu berakhir (EndTime) ditimpa ke rekaman

Catatan diperbarui

	Device memory	Nilai
Acquisition instruction	M0	ON
Start manufacturing	M1	OFF
End manufacturing	M2	ON

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

Pattern	Device memory	Nilai
Load setting	D100	80
Height setting	D101	2000
Load result	D200	79
Height result	D201	2002

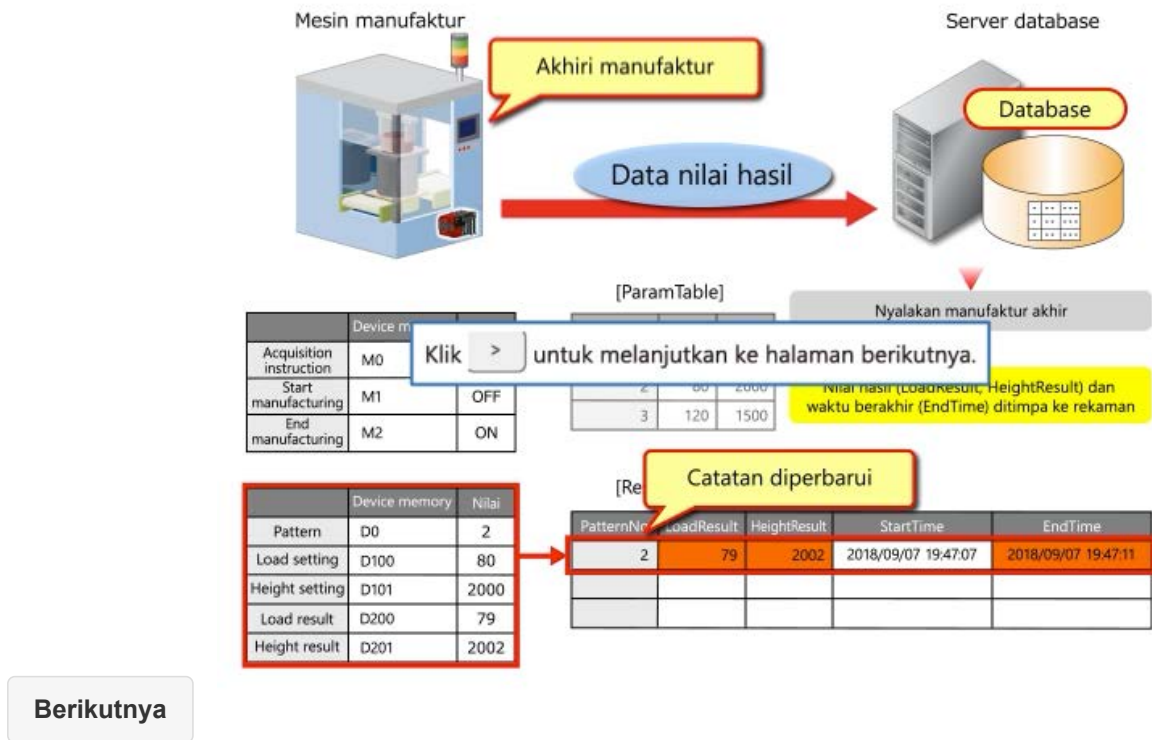
PatternNo	LoadResult	HeightResult	StartTime	EndTime
2	79	2002	2018/09/07 19:47:07	2018/09/07 19:47:11

Berikutnya

<Proses pengaturan data pengontrol yang dapat diprogram ke database>

- 1) Dengan melihat manufaktur (M1 = ON), tulis pola manufaktur (NoPattern) dan waktu mulai (StartTime) ke ResultTable.
 - 2) Saat manufaktur selesai (M2 = ON), catatan 1) ditimpa oleh nilai hasil (LoadResult dan HeightResult) dan waktu berakhir (EndTime).
- * Untuk waktu, data waktu dari modul antarmuka MES digunakan.

<Proses data>

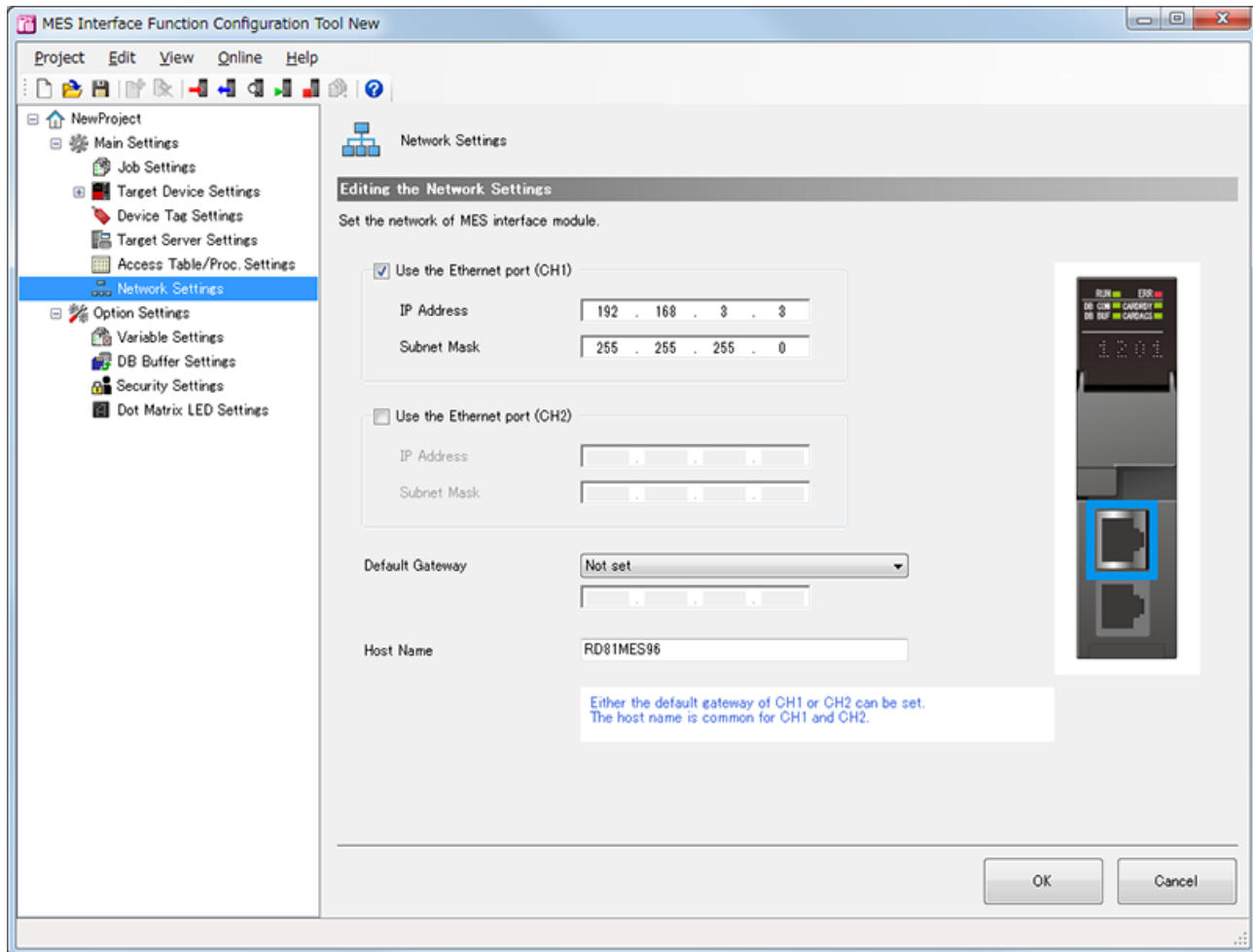


<Pengaturan modul antarmuka MES>

Konfigurasi pengaturan untuk mengekstrak data dalam database dan menuliskannya ke memori perangkat modul CPU. Berikut ini menjelaskan pengaturan yang diperlukan dalam MES interface function configuration tool.

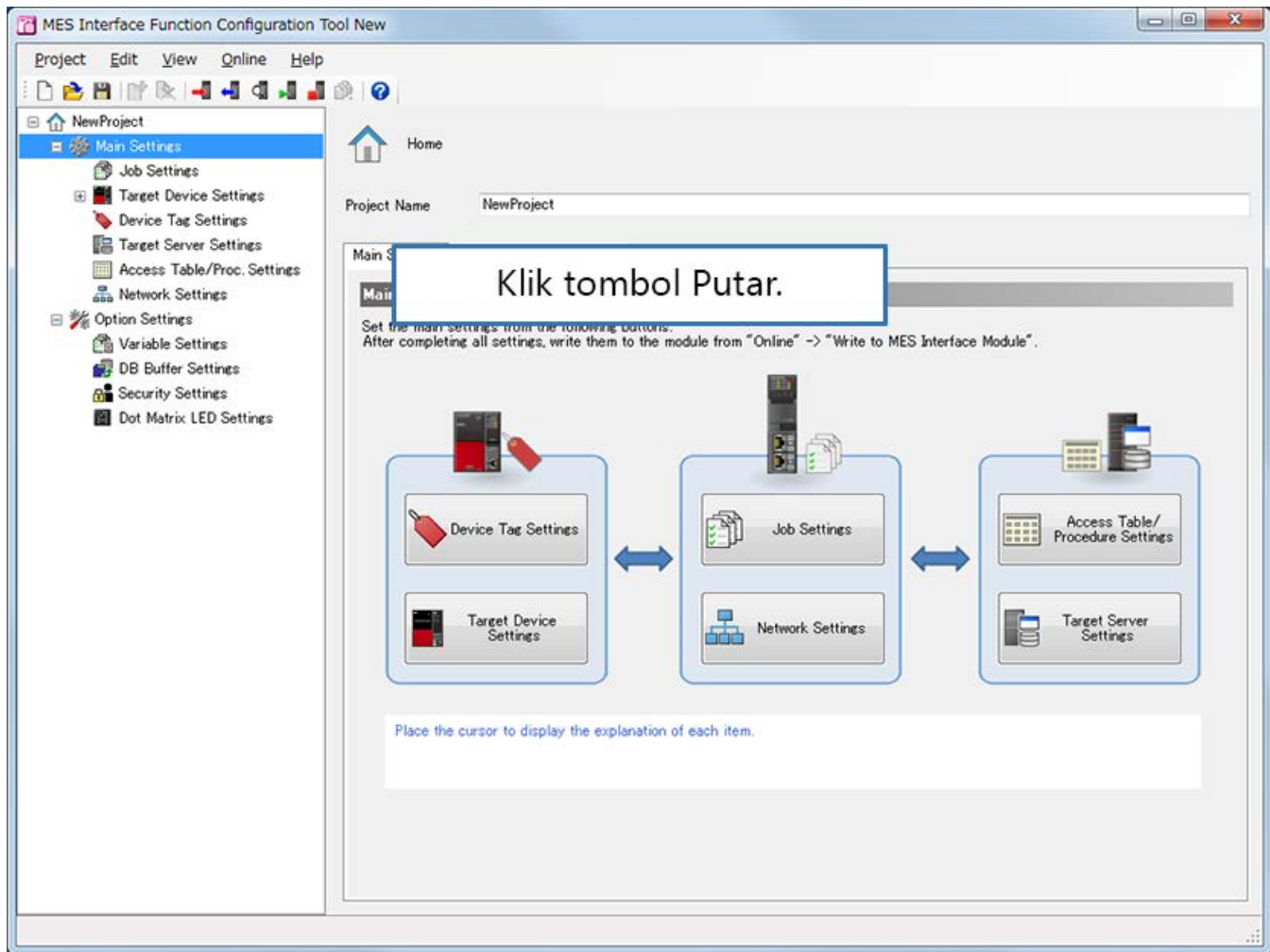
[Network Settings]

Pengaturan bawaan digunakan dalam kursus ini.



Kembali

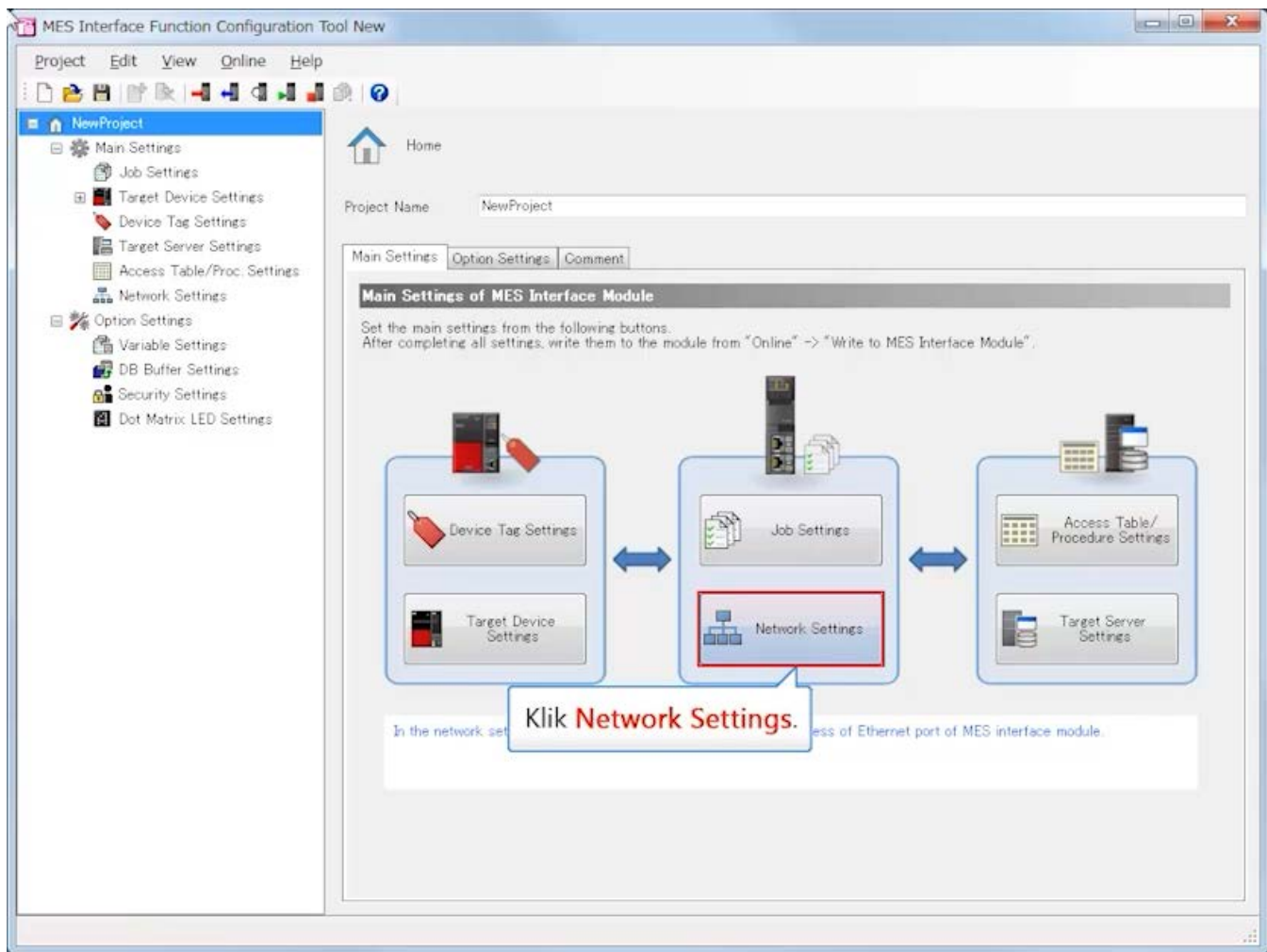
Berikutnya



3.4 Pengaturan dengan MES interface function configuration tool (Network Settings)

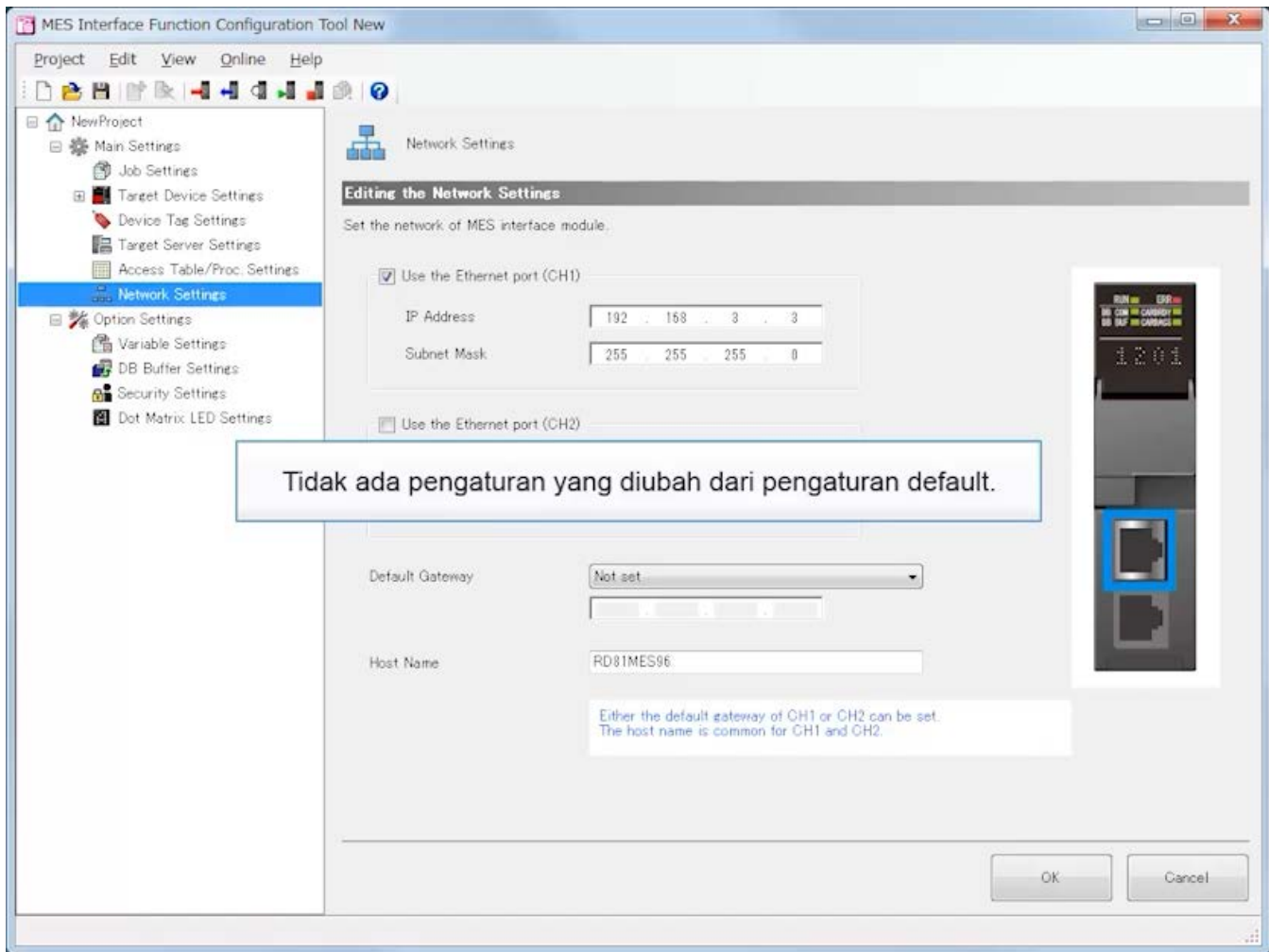
Kembali

Berikutnya



Kembali

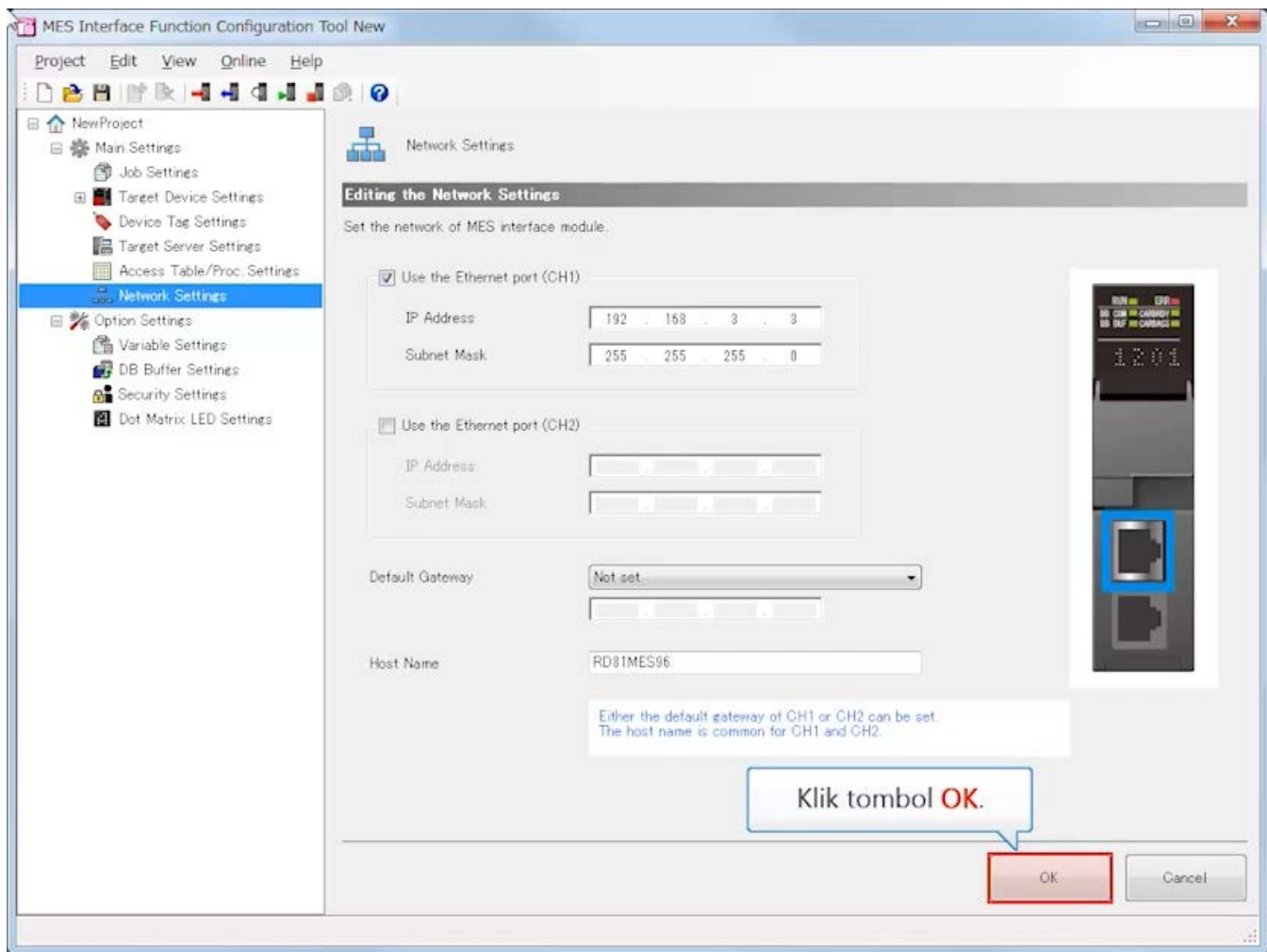
Berikutnya



3.4 Pengaturan dengan MES interface function configuration tool (Network Settings)

Kembali

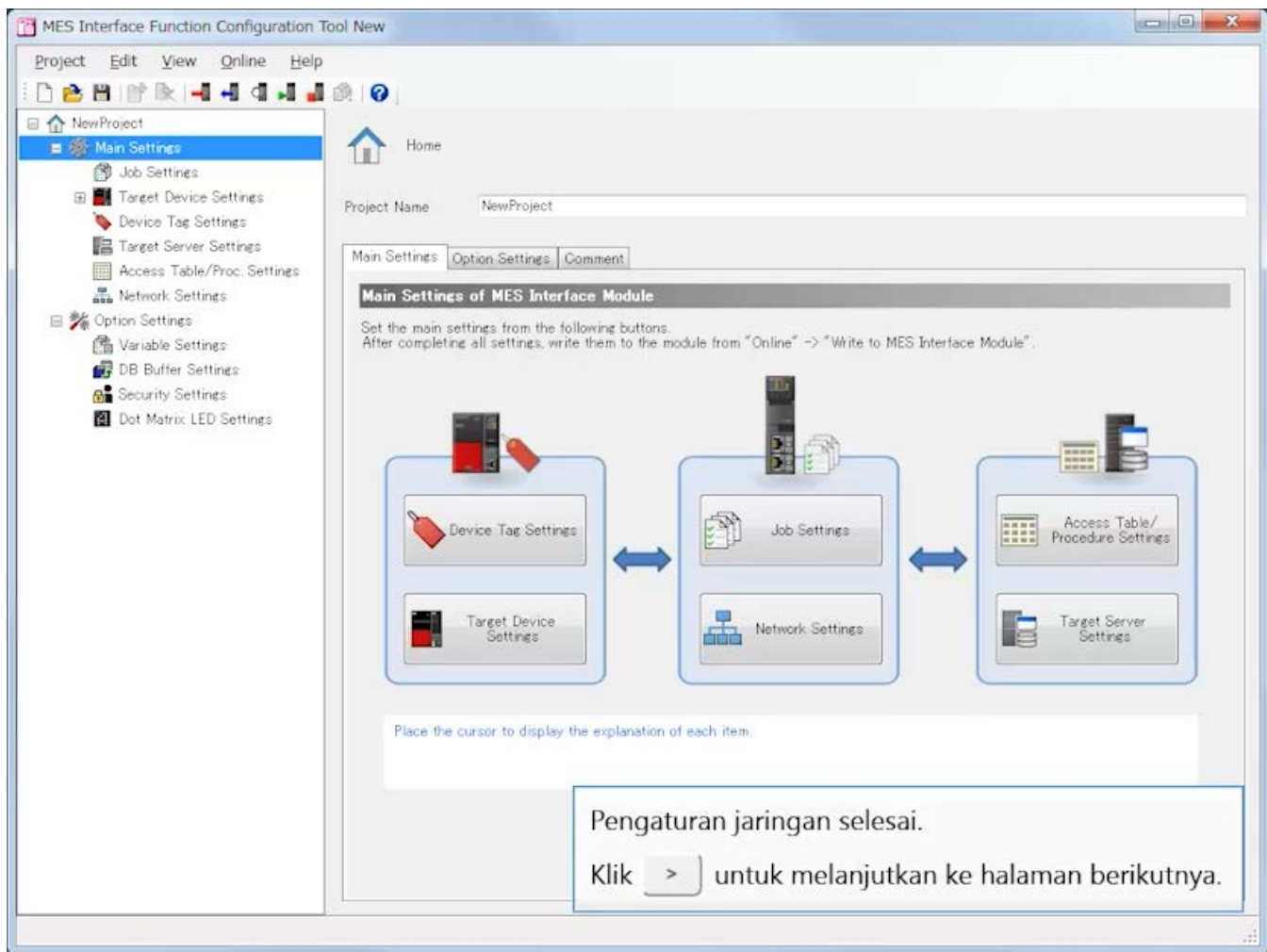
Berikutnya



3.4 Pengaturan dengan MES interface function configuration tool (Network Settings)

Kembali

Berikutnya



[Target Device Settings]

Pengaturan default digunakan dalam kursus ini.

Target Device Setting No.[1]

Target Device Name Comment

Target Device Settings

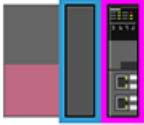
Set the target device for data access from MES interface module.

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 CC-Link IE Controller Network Module	Module Type CC-Link IE Controller Network Module CC-Link IE Field Network Module MELSECNET/H Network Module Ethernet Interface Module
Route Direct access to Ethernet Port	
	Network No. 1
	Station No. 1

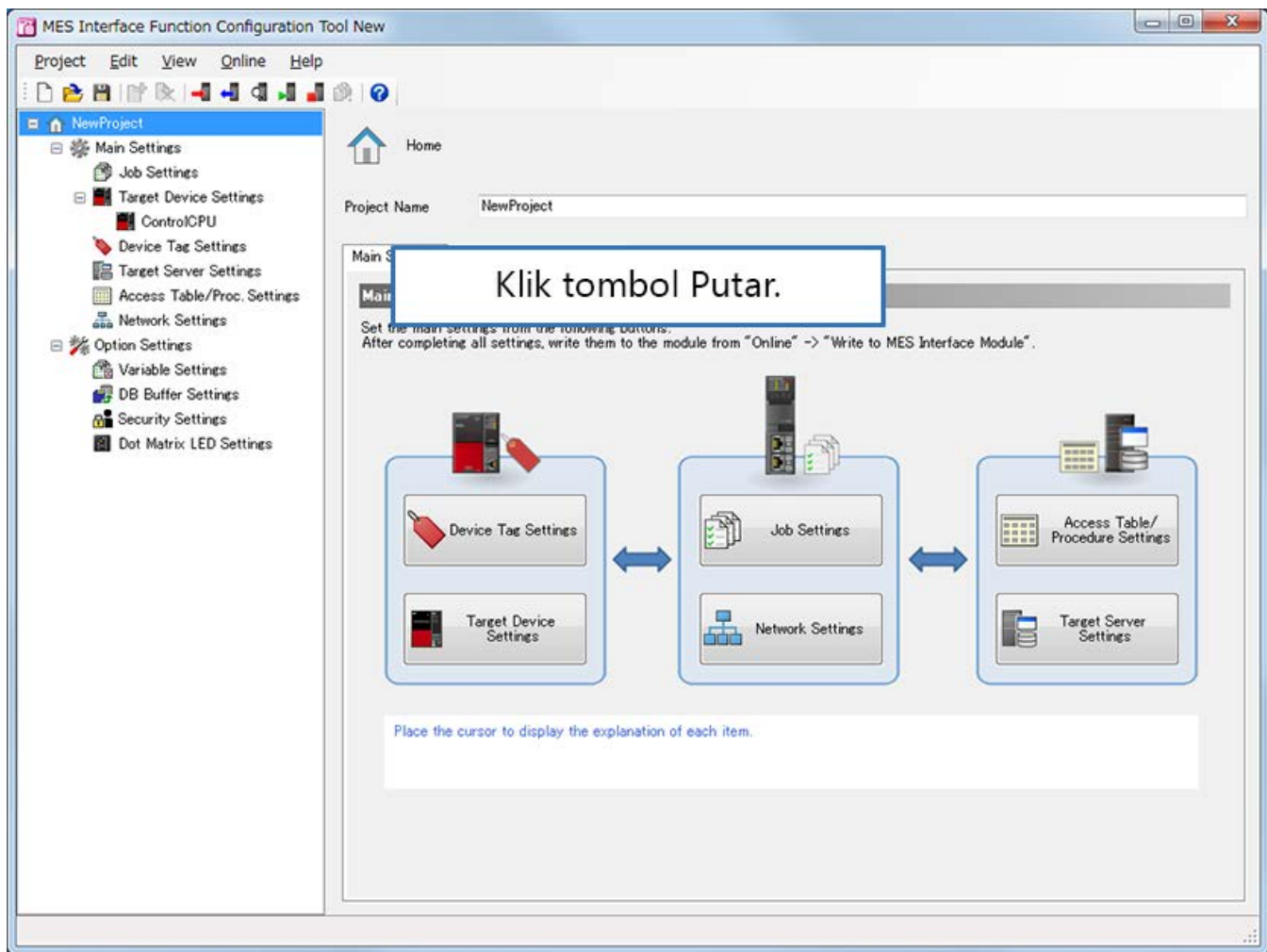


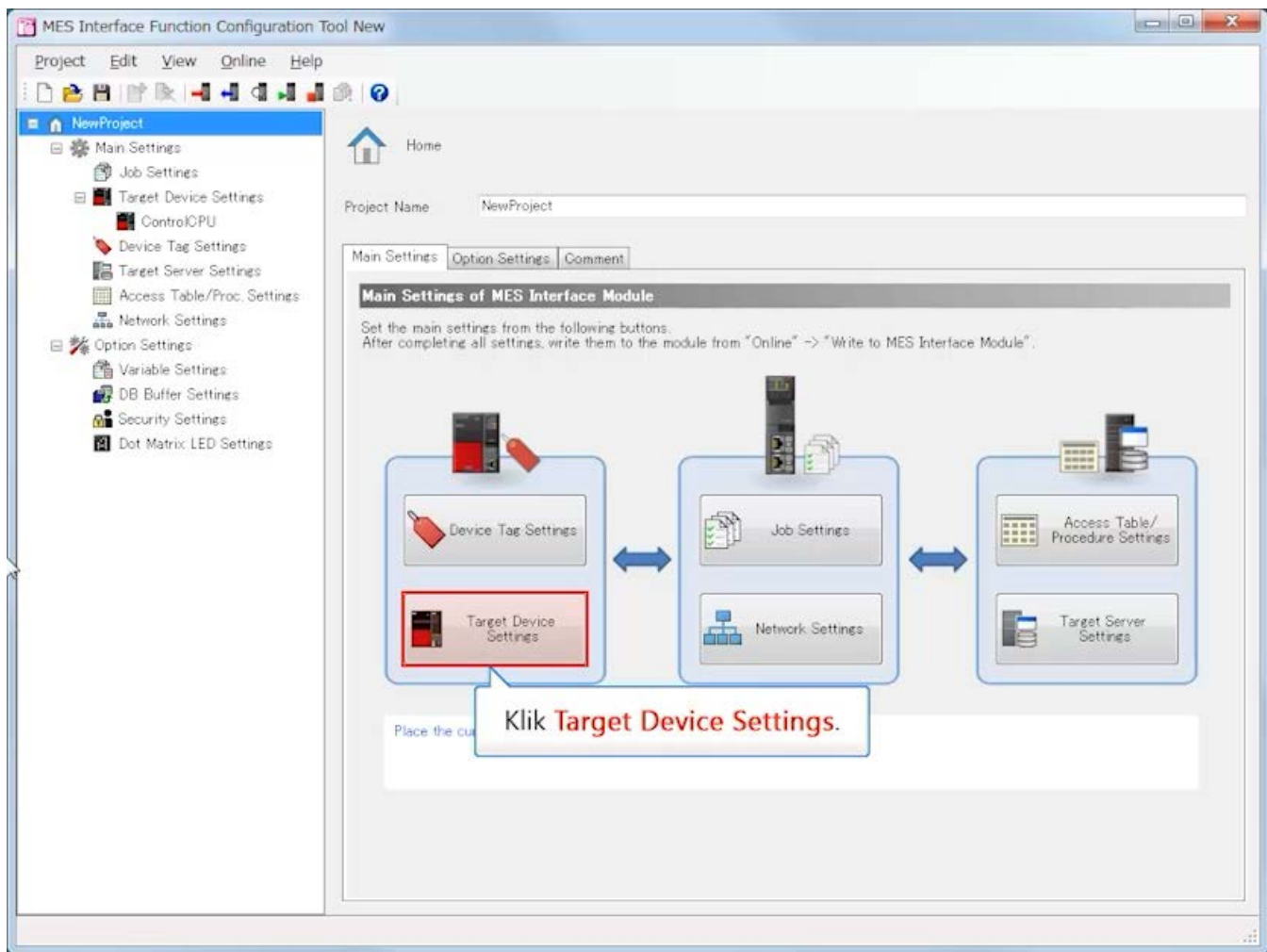
Global Label/Common Device Comment Settings (optional)

☐ Use the global label/common device comment

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

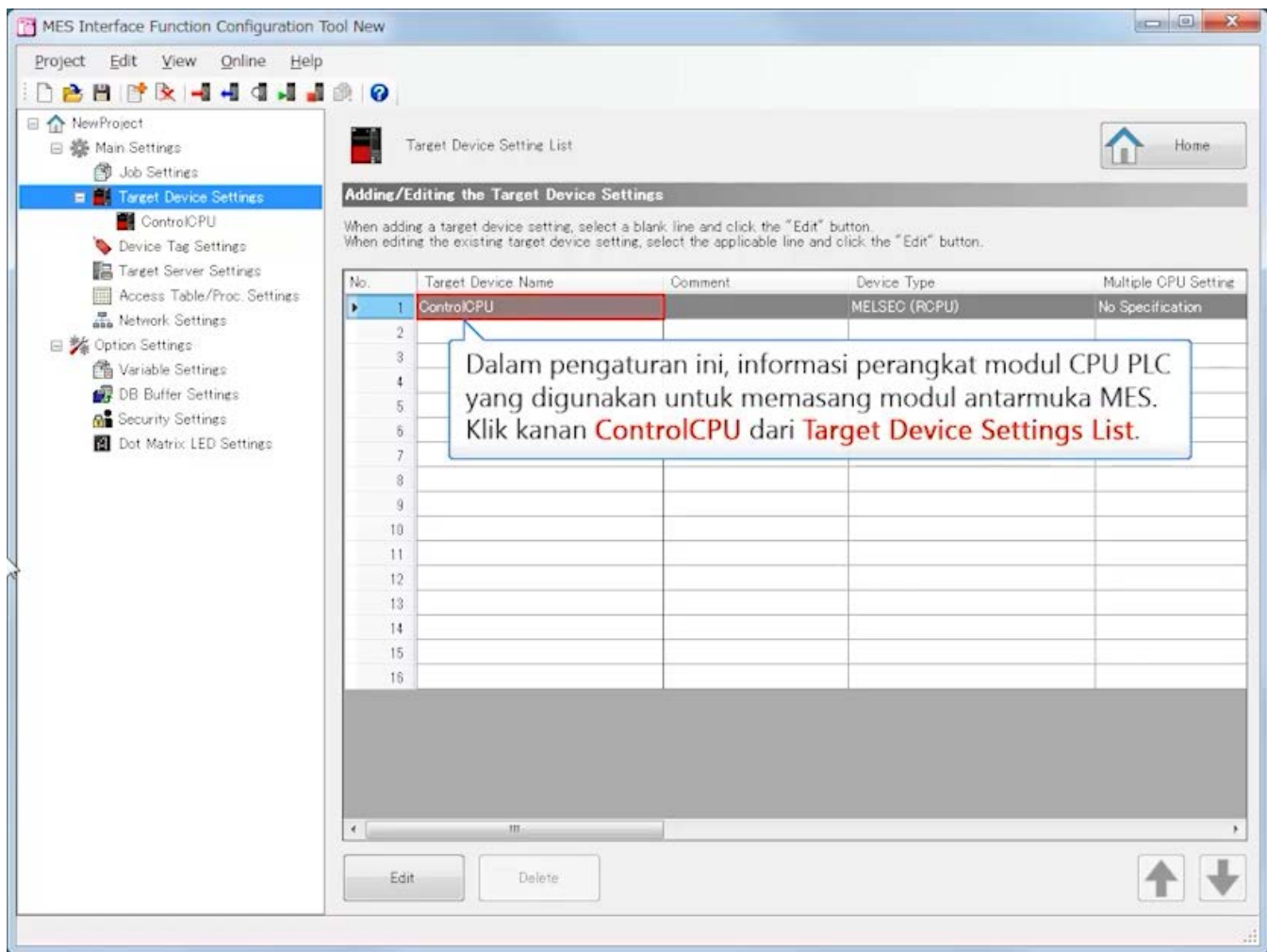
Communication Test

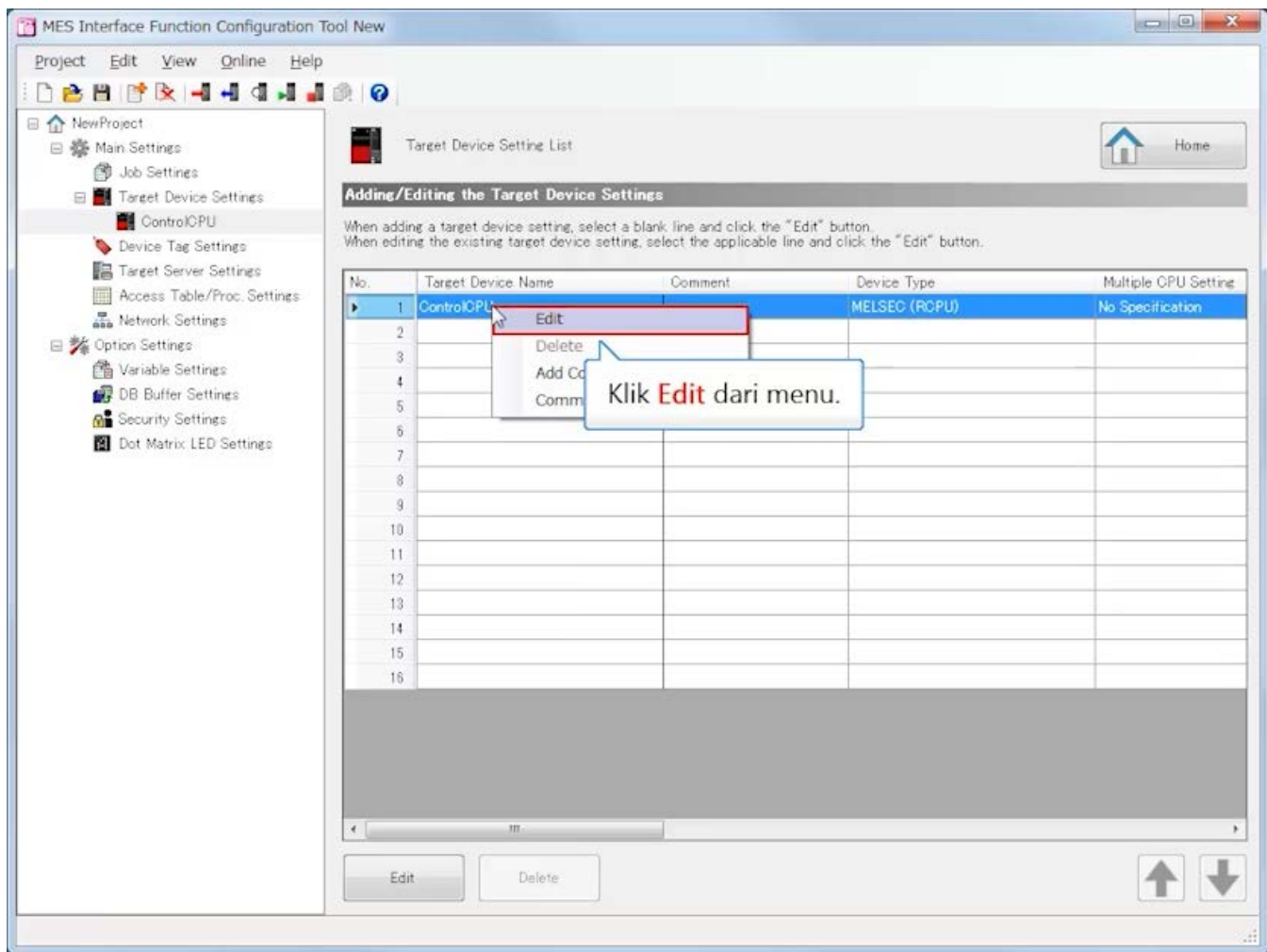
[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya



[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

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

Module Type: Route:

Target (Relay Station) System Settings

Module Type:
CC-Link IE Field Network Module
MELSECNET/H Network Module
Ethernet Interface Module

Tidak ada pengaturan yang diubah dari pengaturan default.
Saat menghubungkan informasi stasiun PLC lain dengan database
melalui jaringan, tambahkan pengaturan perangkat target.



Global Label/Common Device Comment Settings (optional)

☐ Use the global label/common device comment
Global Label/Common Device Comment Import Source Setting:

Communication Test

[Kembali](#)[Berikutnya](#)

MES Interface 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: CC-Link IE Controller Network Module	Module Type: CC-Link IE Controller Network Module CC-Link IE Field Network Module MELSECNET/H Network Module Ethernet Interface Module
Route: Direct access to Ethernet Port	
	Network No: 1
	Station No: 1



Global Label/Common Device Comment Settings (optional)

☐ Use the global label/common device comment

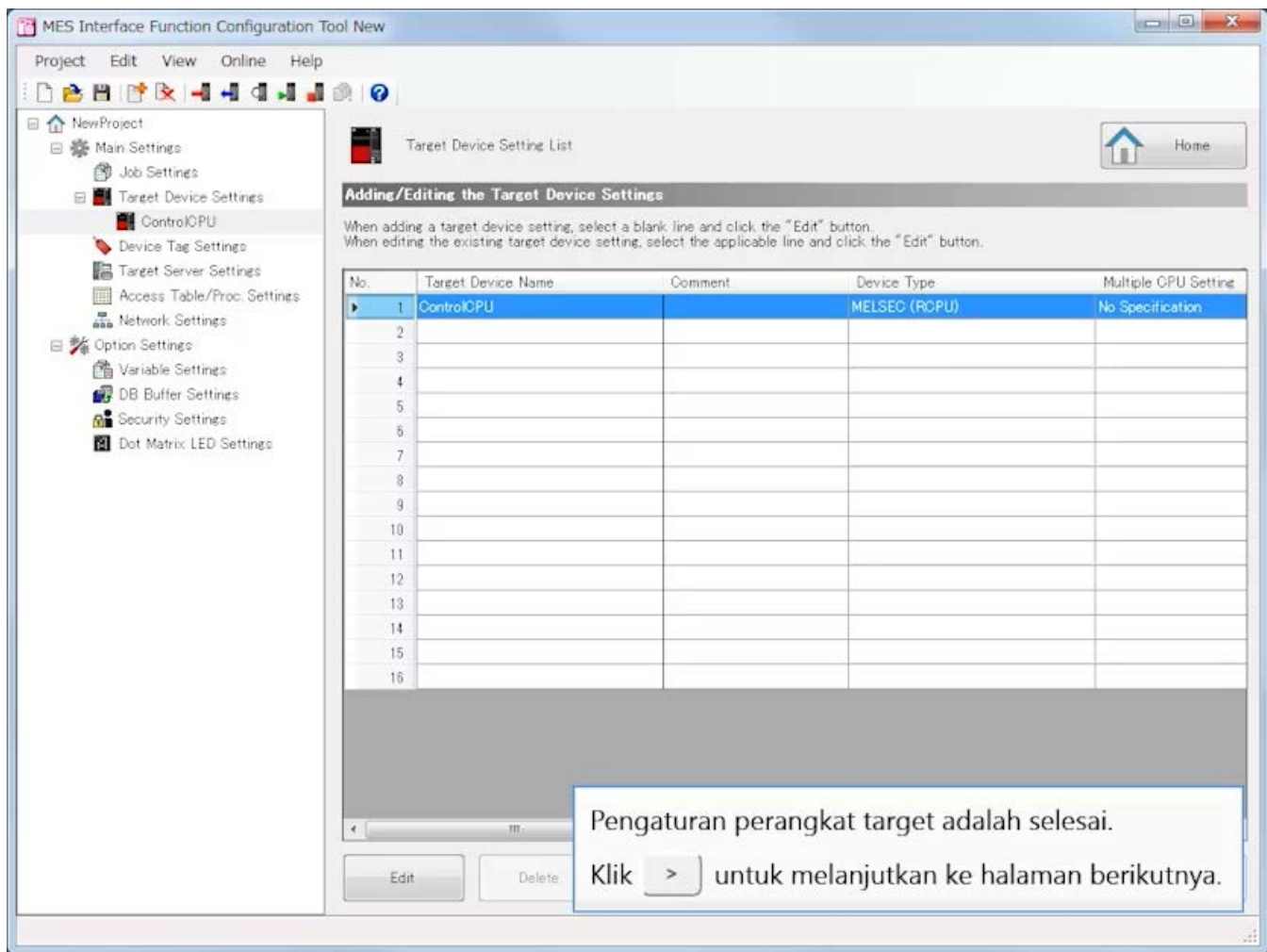
Global Label/Common Device Comment Import Source Setting:

Communication Test:

Klik tombol **OK**.

Kembali

Berikutnya



[Device Tag Settings]

Konfigurasi pengaturan yang mengekstrak data dari database dan menuliskannya ke memori perangkat modul CPU sebagai "GettingData".

(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: 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:

[Device Tag Components in the Project] 4

Konfigurasi pengaturan yang menulis data dalam memori perangkat modul CPU ke database sebagai "PuttingData".

(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
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

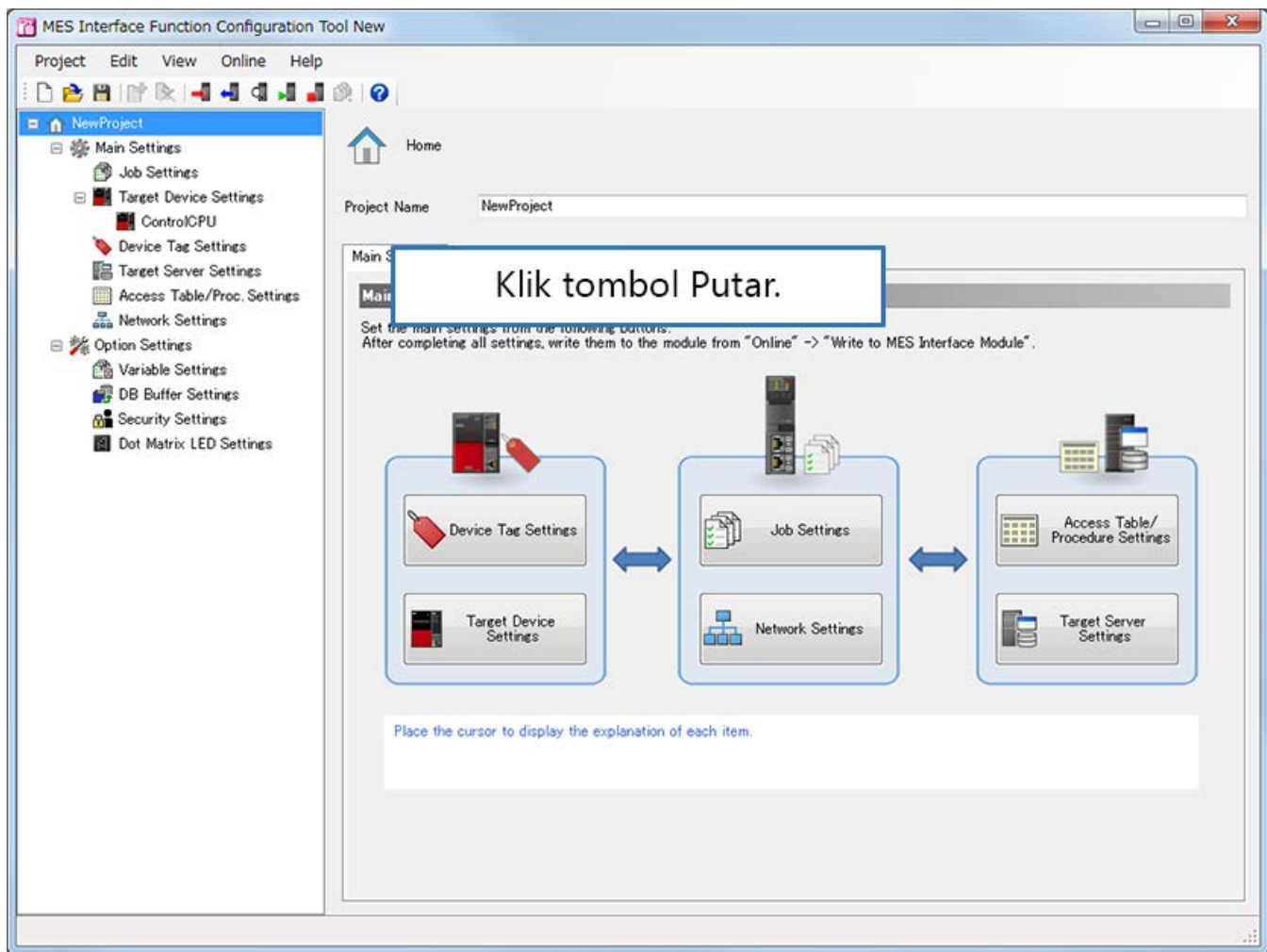
Array Tag Settings (optional)

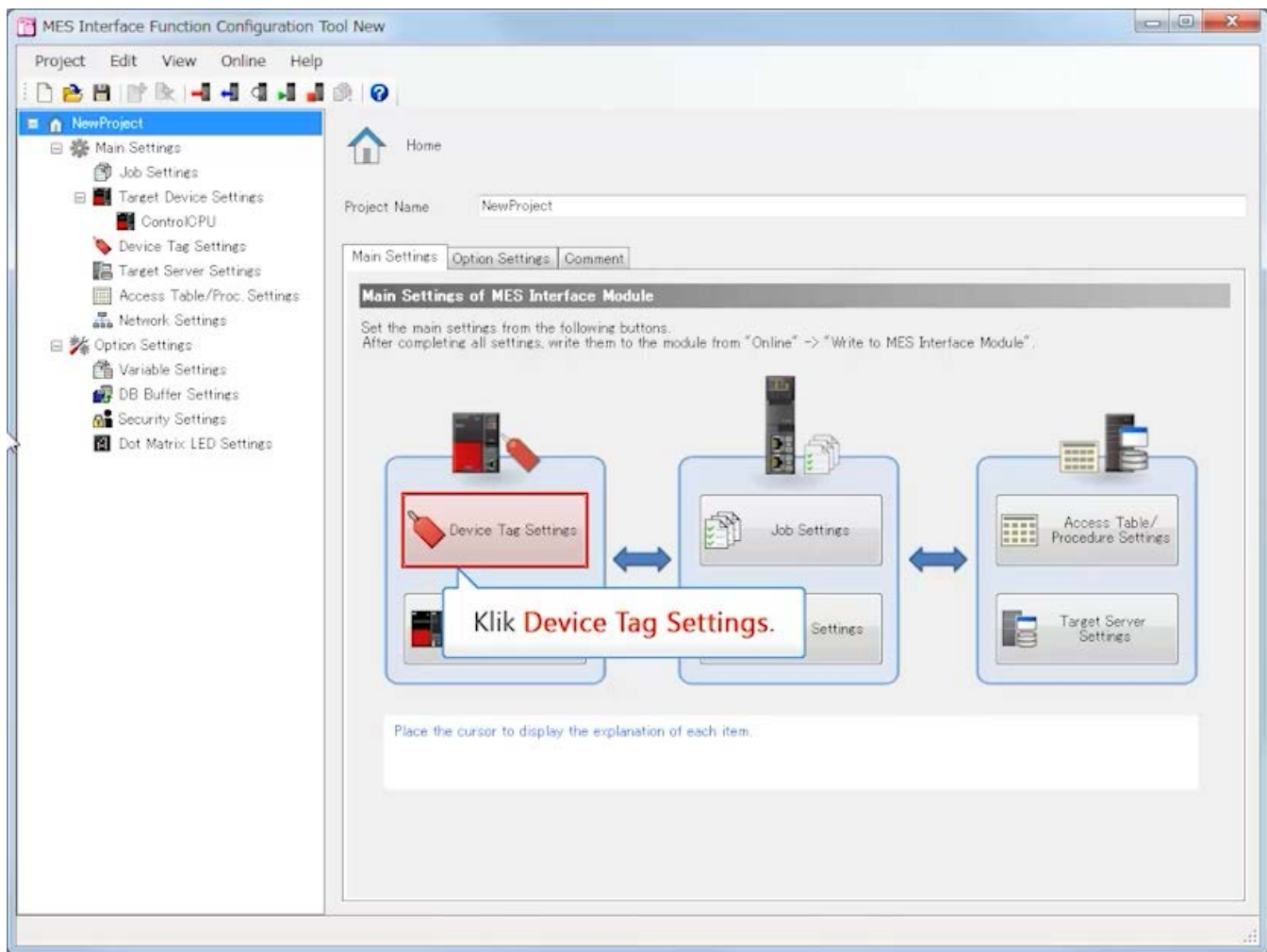
☐ Set the array tag to be used for the assignment destination of Multiple Select

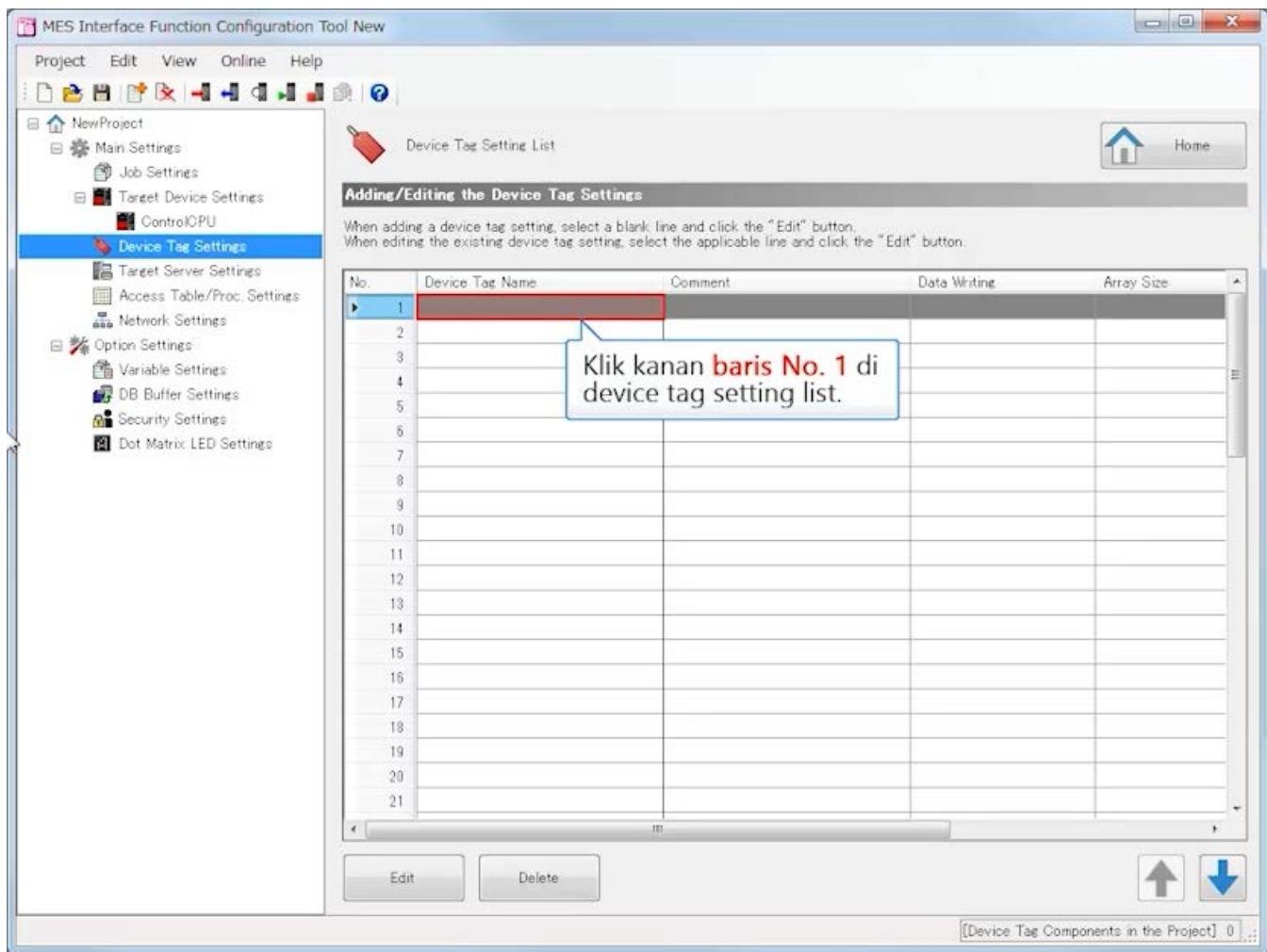
Array Tag Setting
Change

OK
Cancel

[Device Tag Components in the Project] 9

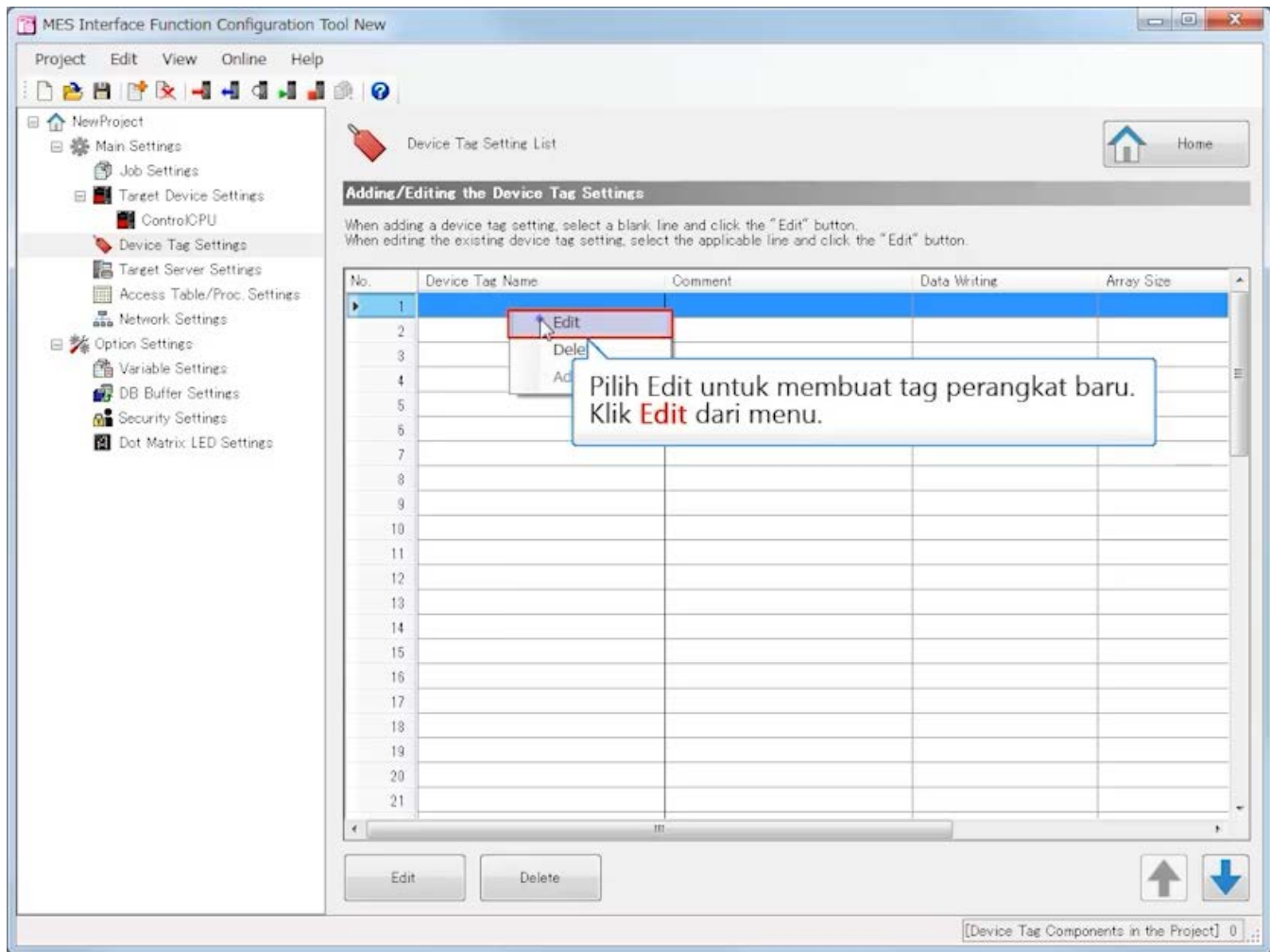
[Kembali](#)[Berikutnya](#)

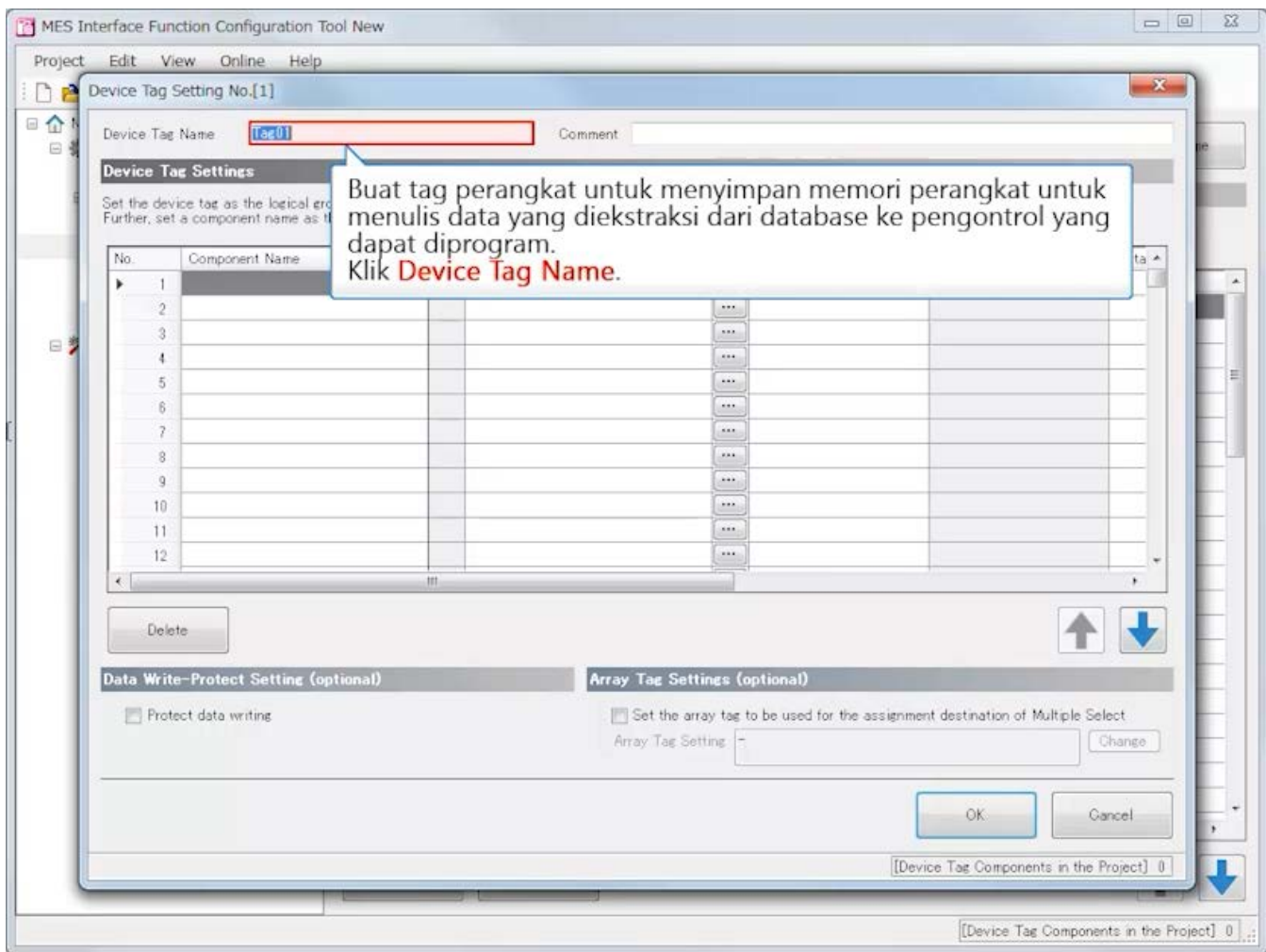
[Kembali](#)[Berikutnya](#)

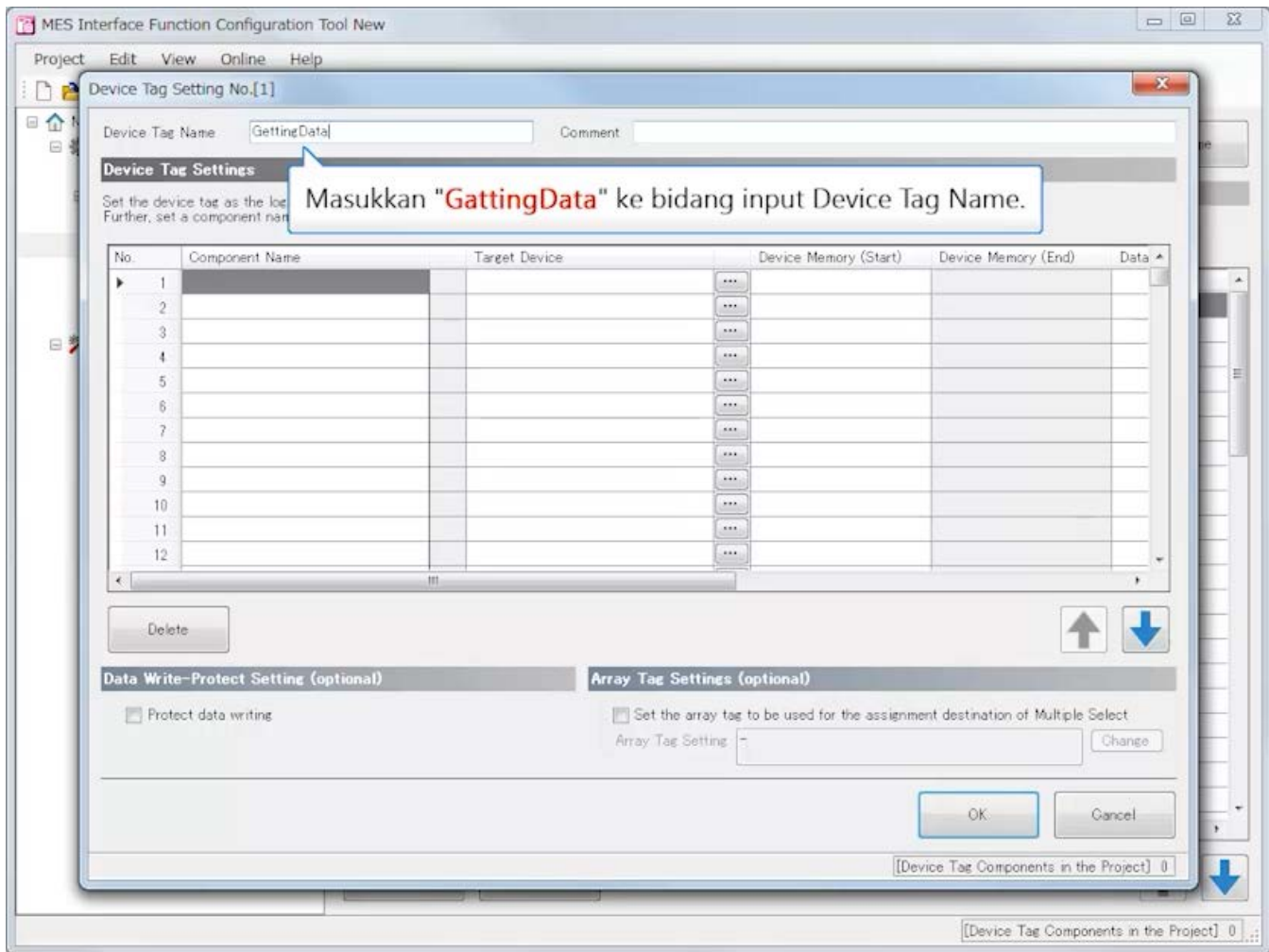
[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

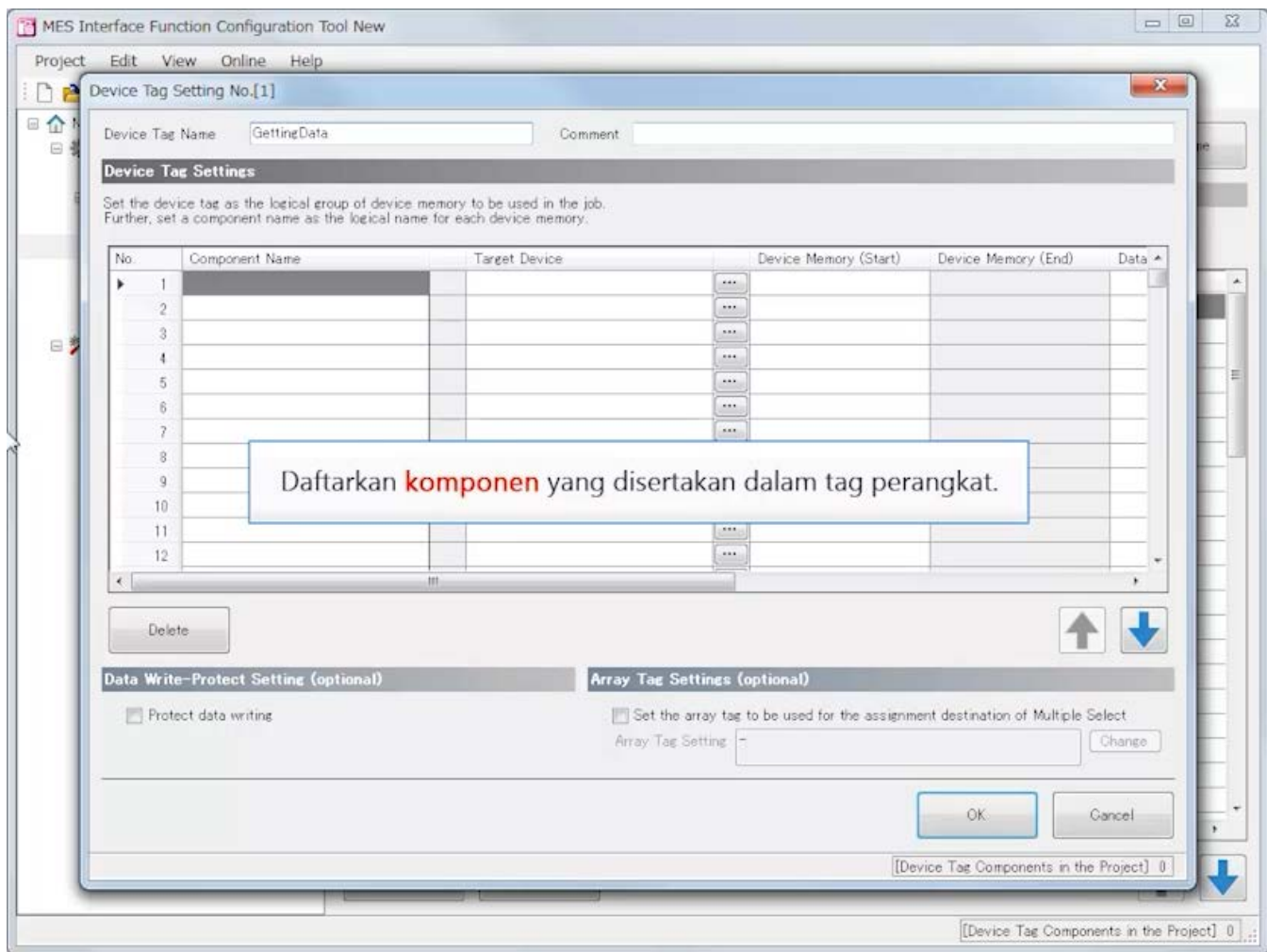


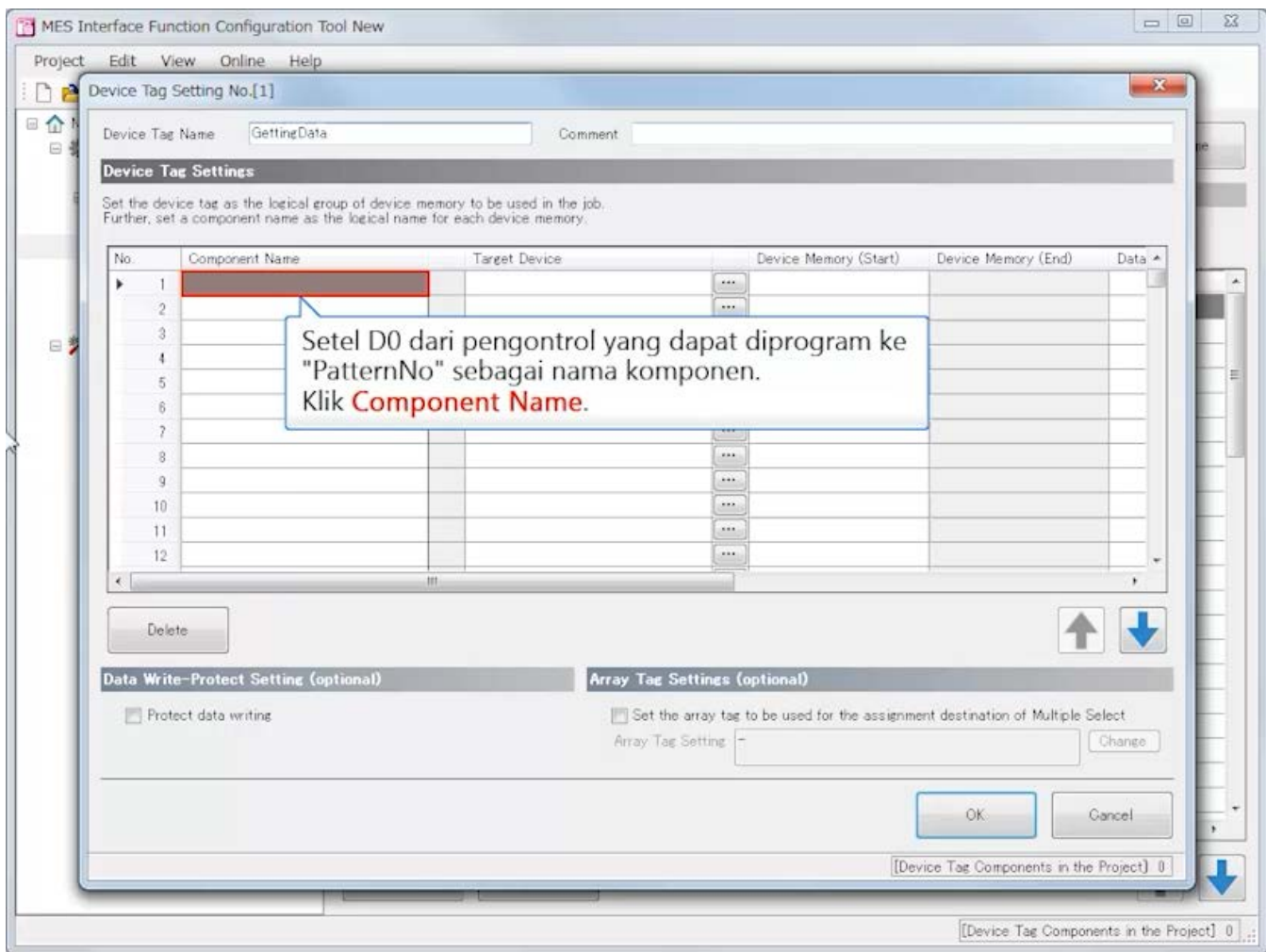
[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya



[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

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	Target Device	Device Memory (Start)	Device Memory (End)	Data
1	PatternNo		...		
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Masukkan "PatternNo" ke bidang input Component Name.

Delete

↑ ↓

Data Write-Protect Setting (optional)

☐ Protect data writing

Array Tag Settings (optional)

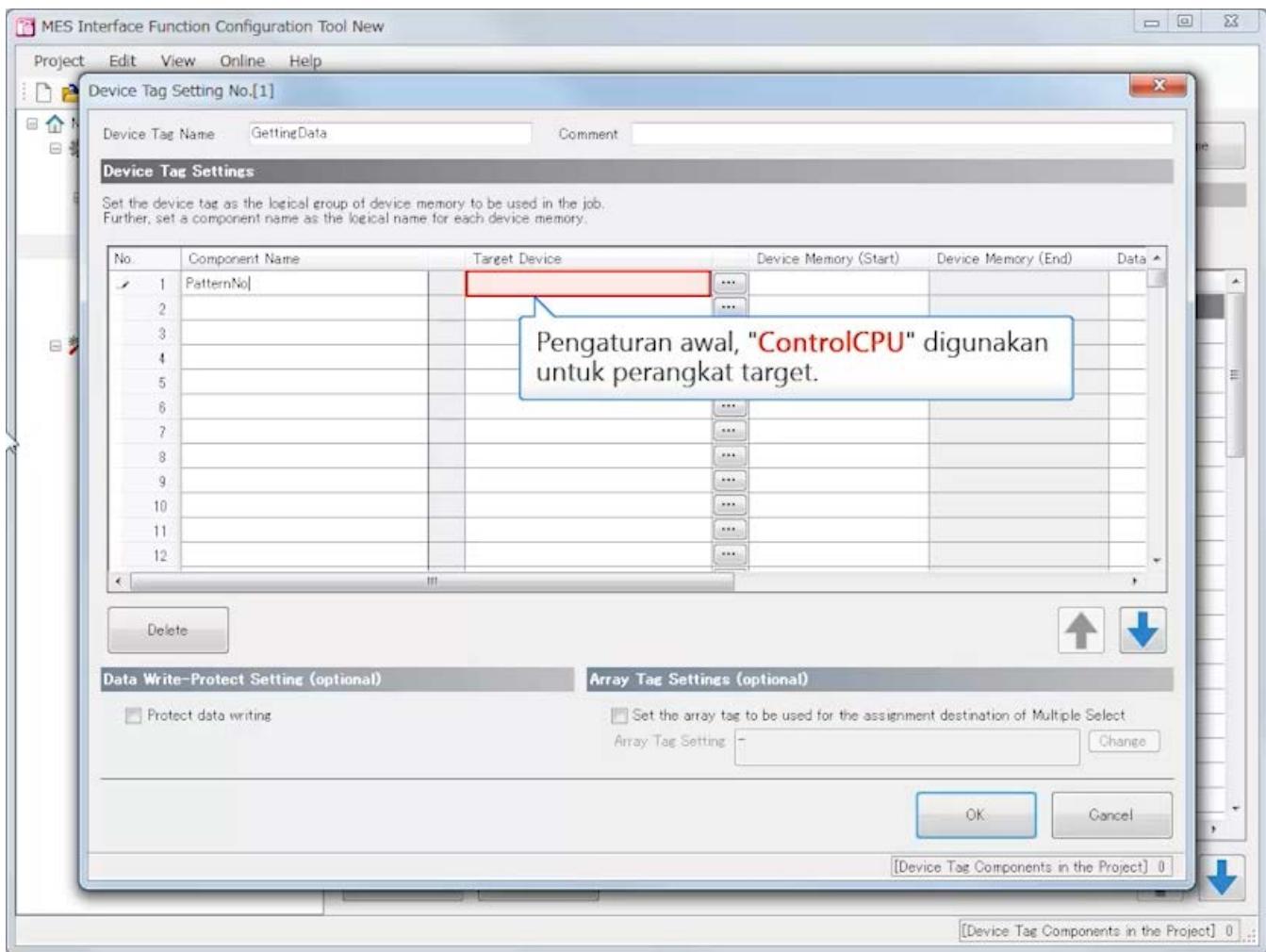
☐ Set the array tag to be used for the assignment destination of Multiple Select

Array Tag Setting: Change

OK Cancel

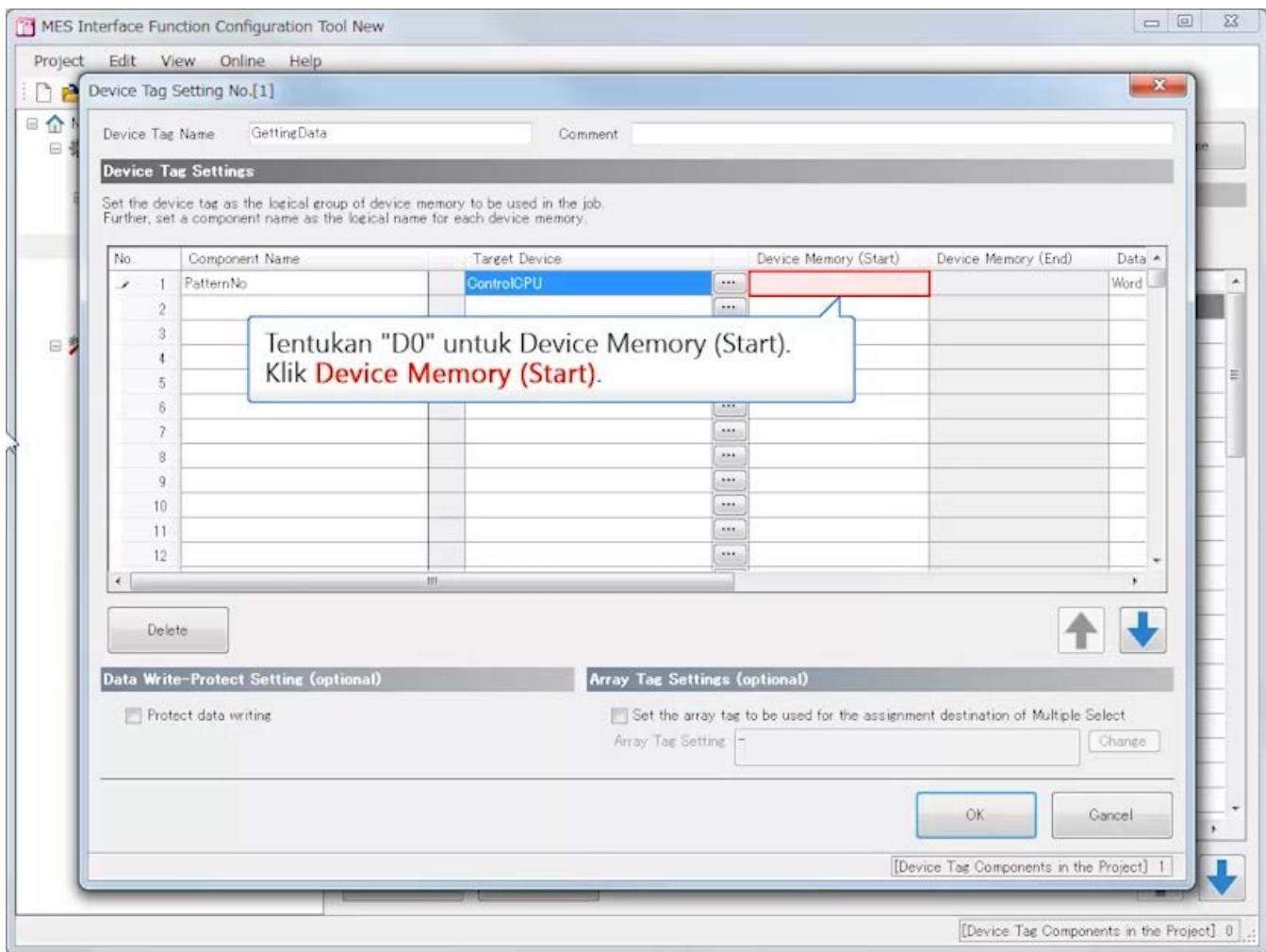
[Device Tag Components in the Project] 0

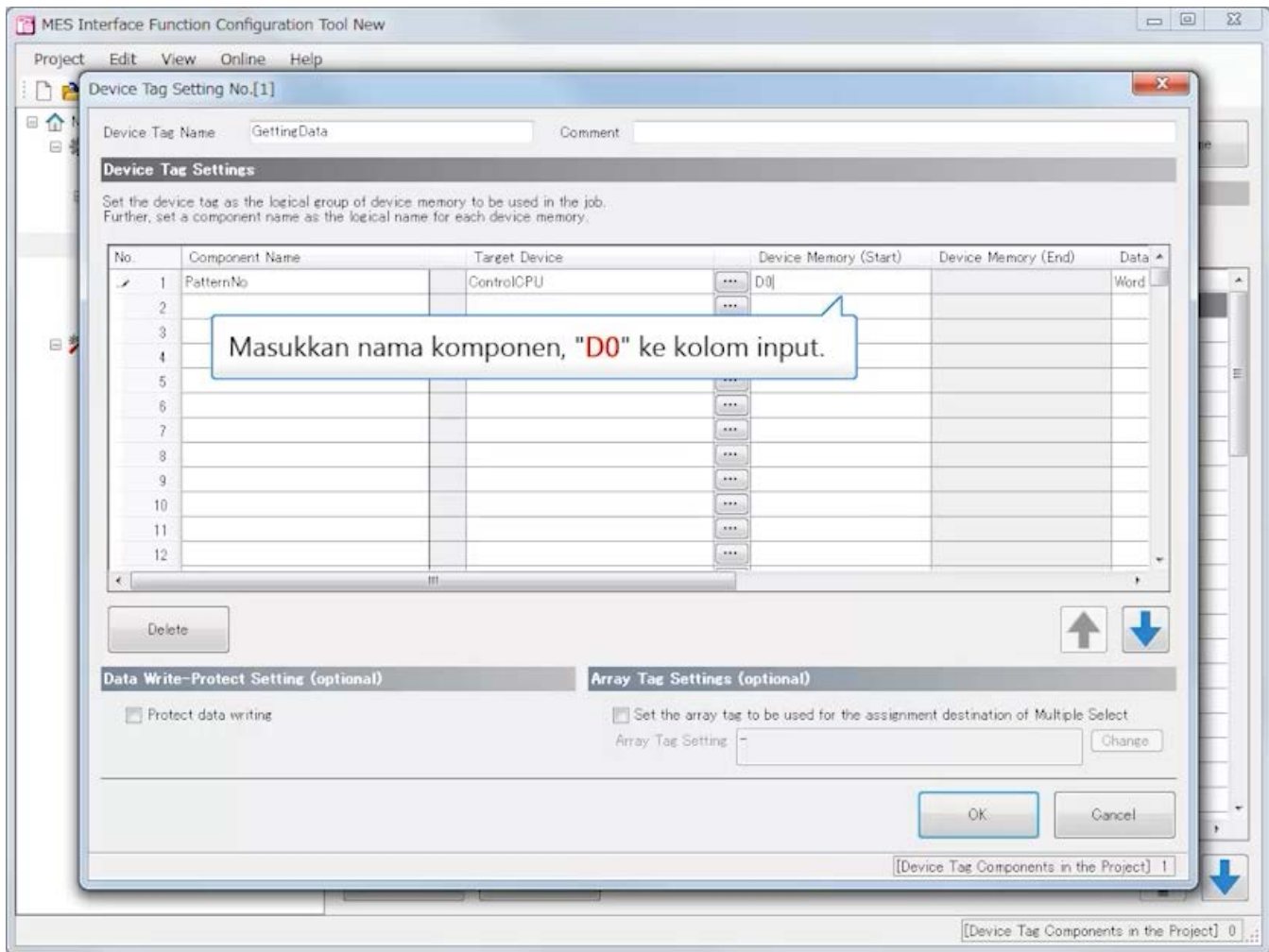
[Device Tag Components in the Project] 0

[Kembali](#)[Berikutnya](#)

Kembali

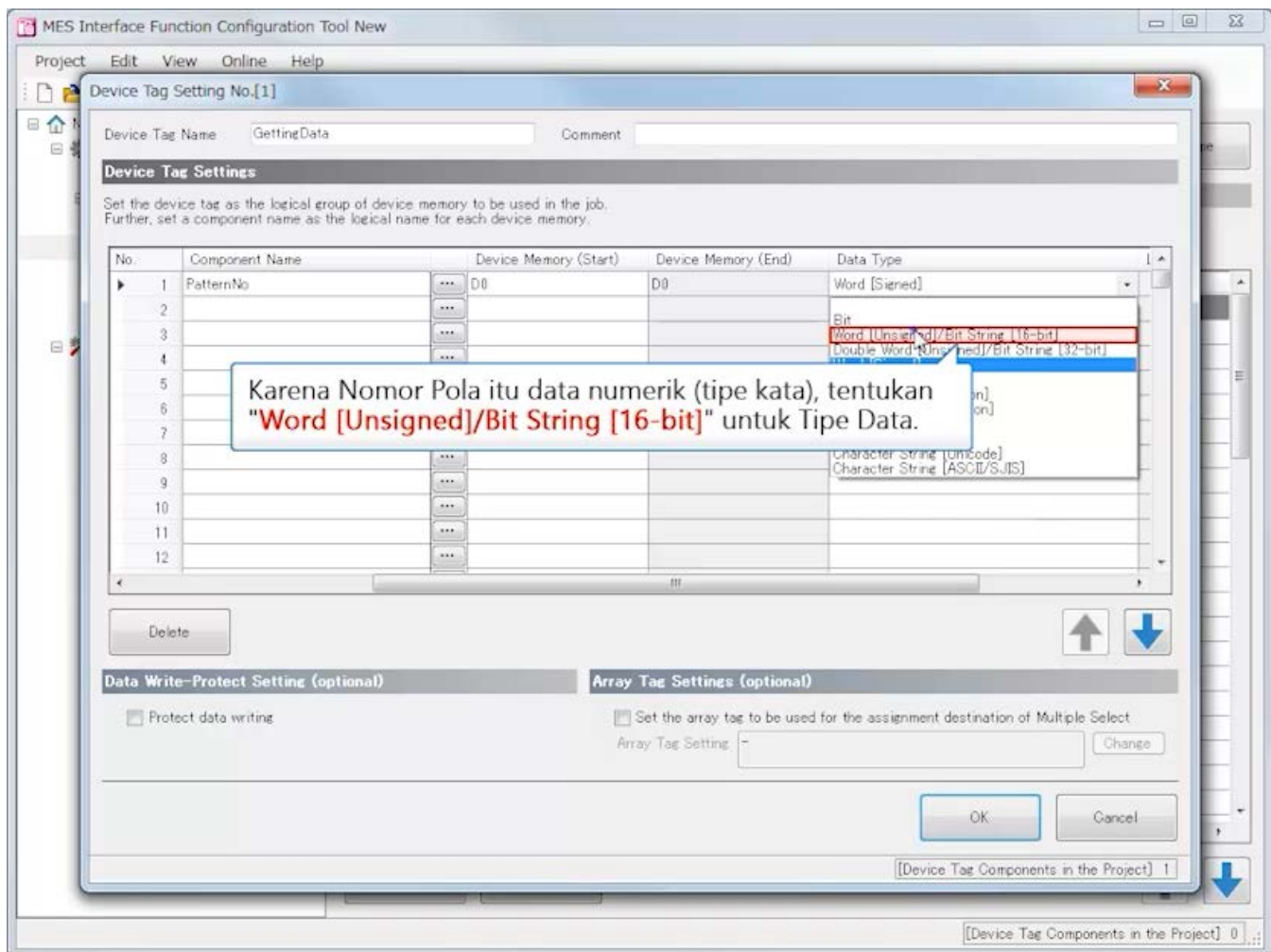
Berikutnya

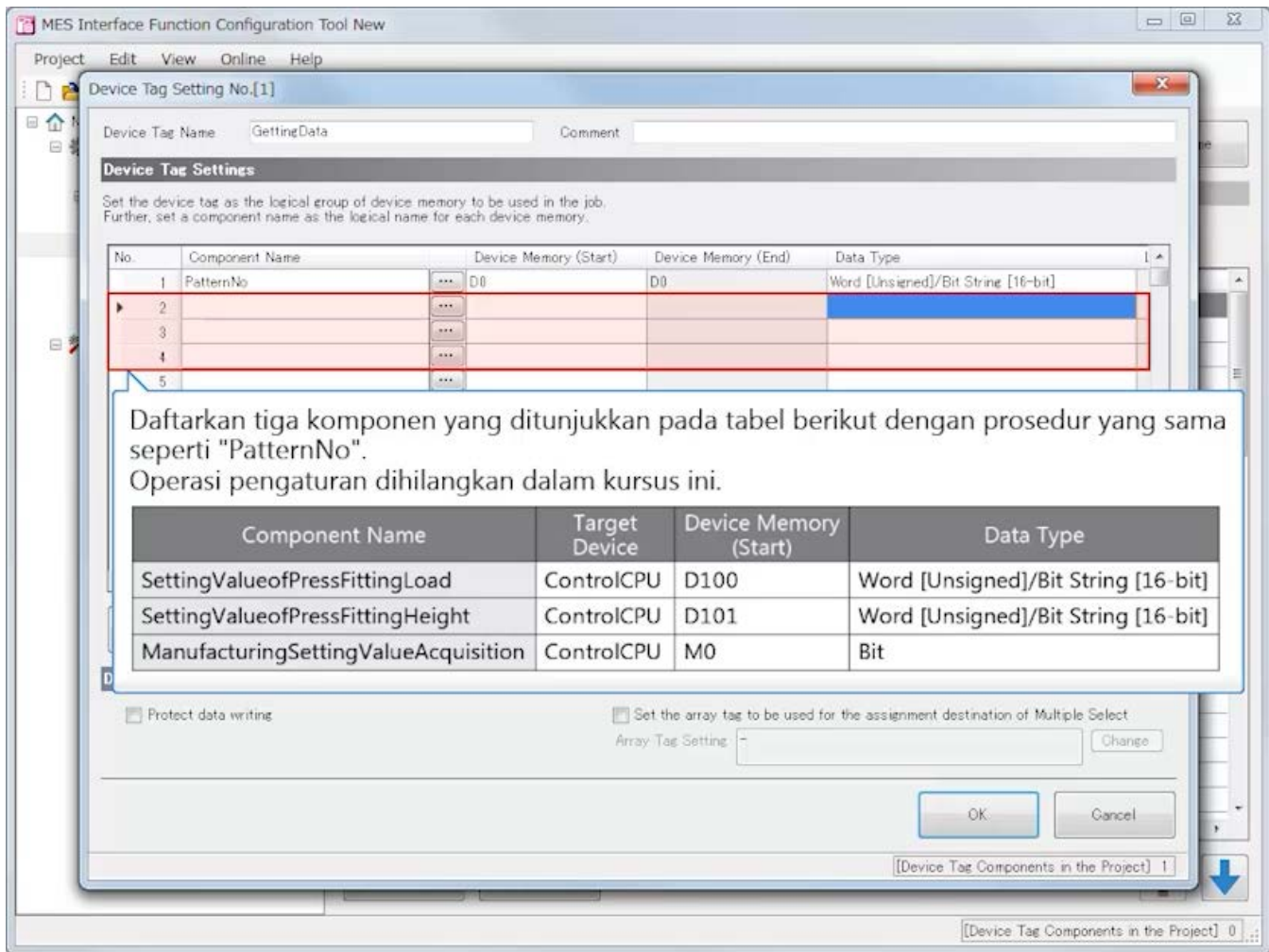


[Kembali](#)[Berikutnya](#)

Kembali

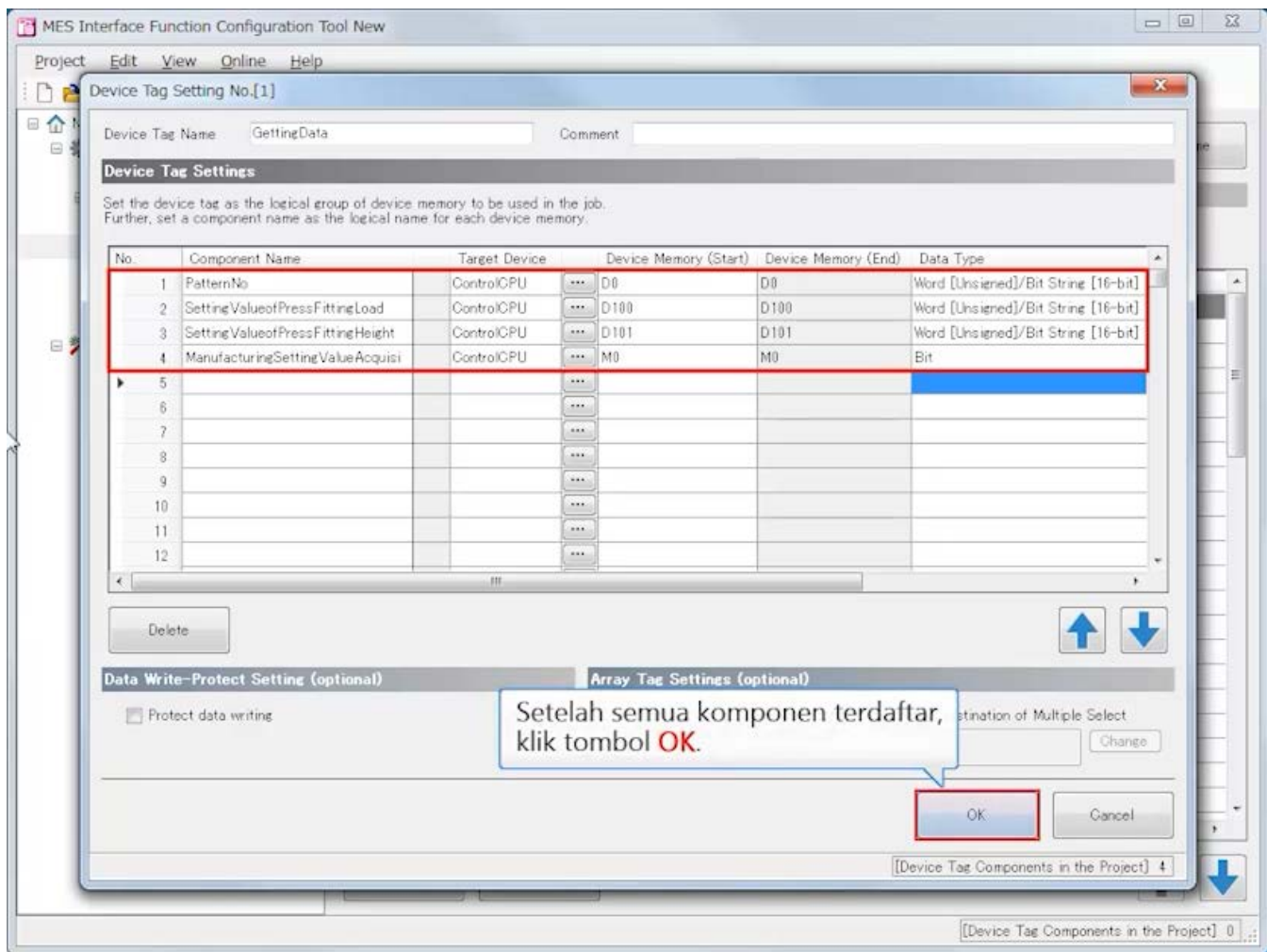
Berikutnya



[Kembali](#)
[Berikutnya](#)


Kembali

Berikutnya



[Kembali](#)
[Berikutnya](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting List

Adding/Editing the Device Tag Settings

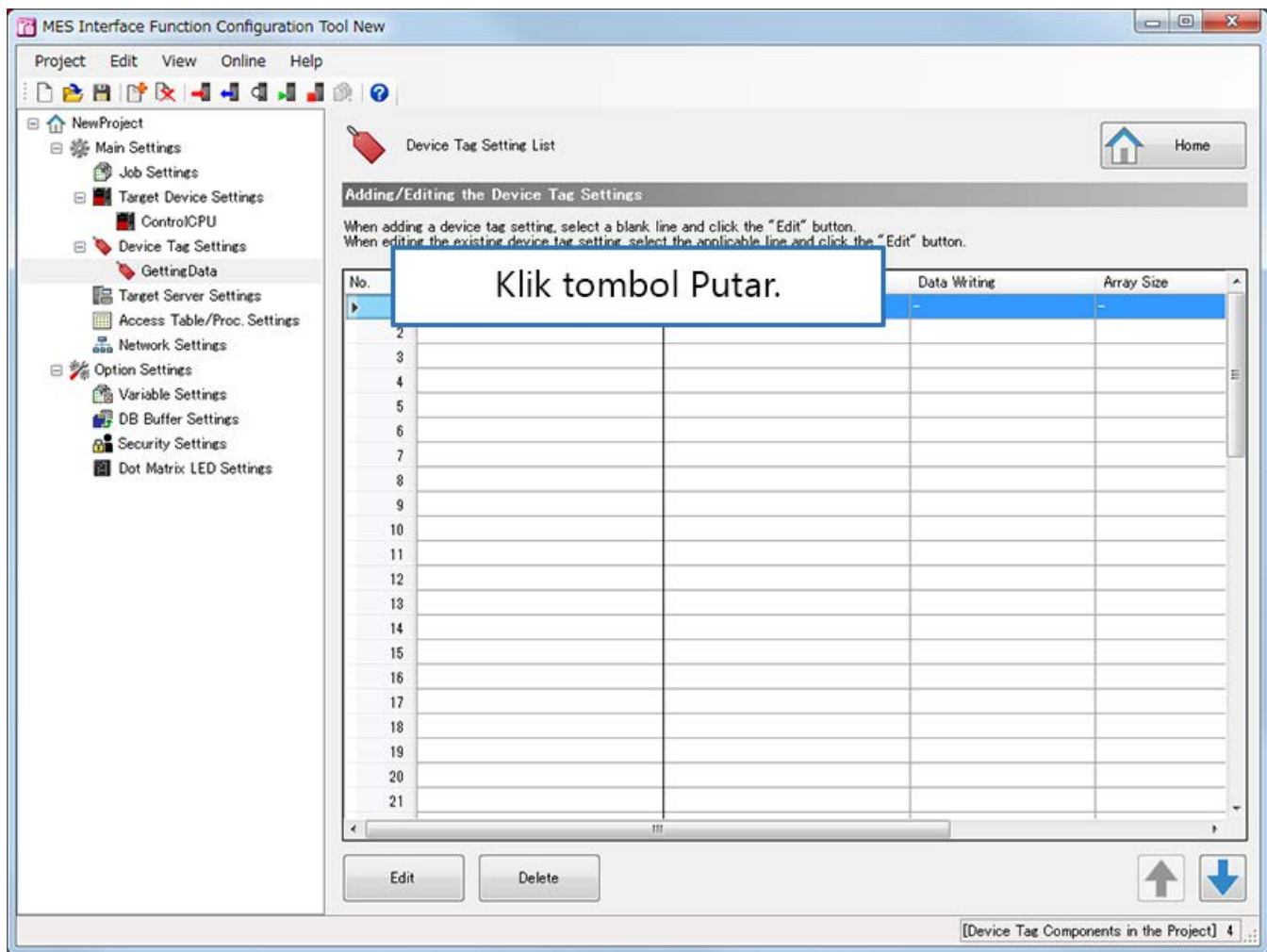
When adding a device tag setting, select a blank line and click the "Edit" button.
When editing the existing device tag setting, select the applicable line and click the "Edit" button.

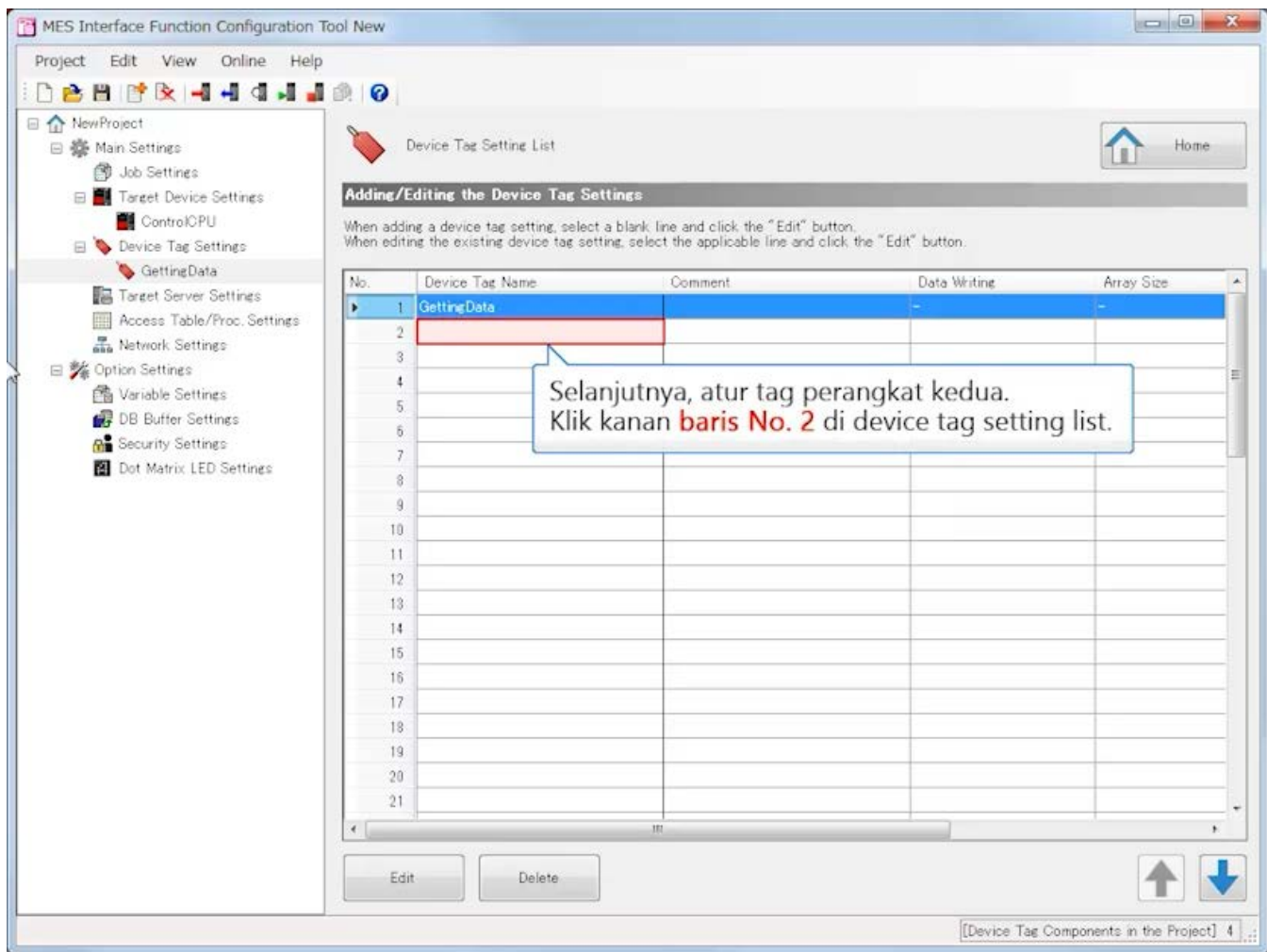
No.	Device Tag Name	Comment	Data Writing	Array Size
1	GettingData			
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

[Device Tag Components in the Project] 4

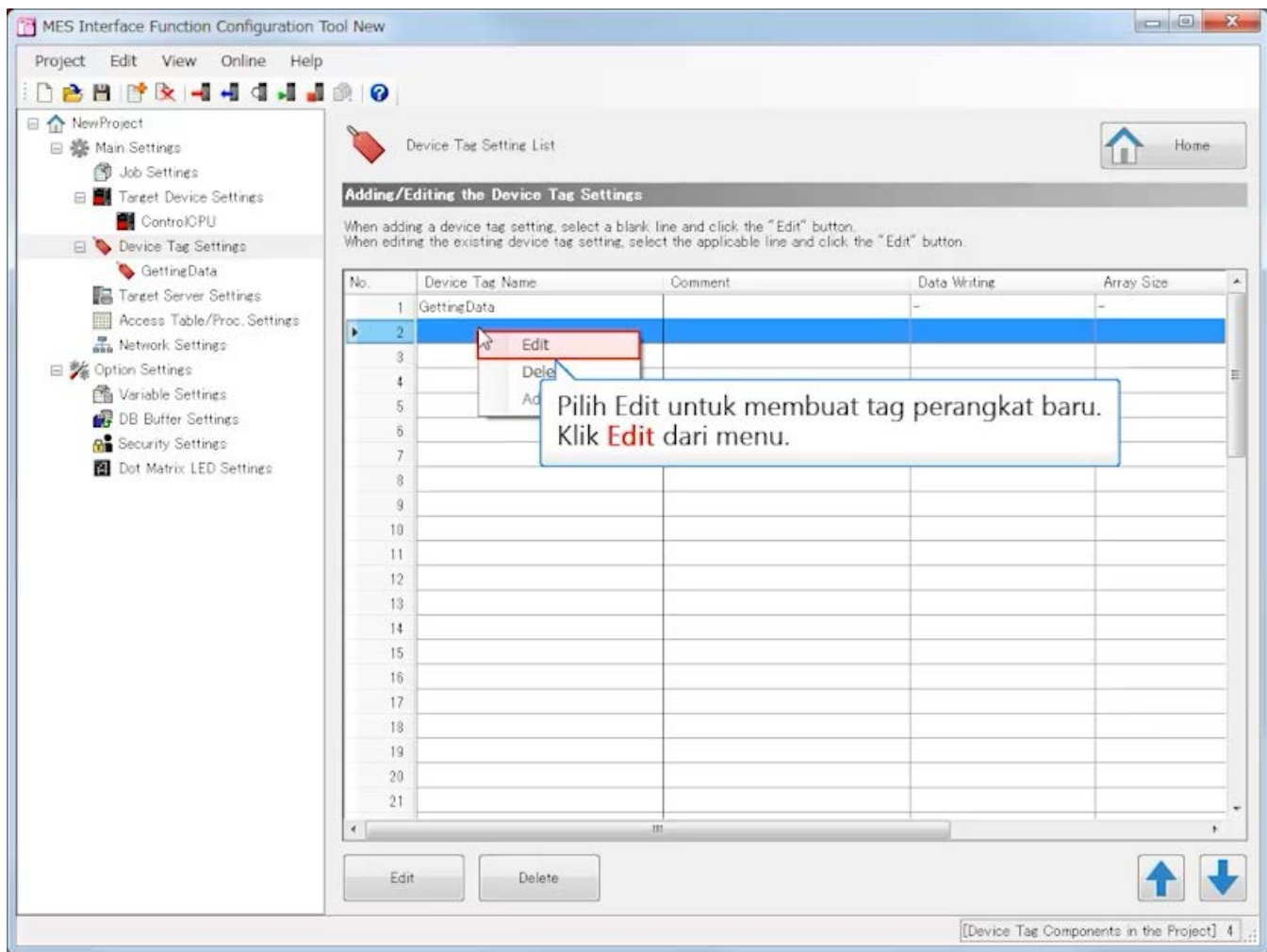
Pengaturan tag perangkat "GettingData" selesai.
Klik [>](#) untuk melanjutkan ke halaman berikutnya.

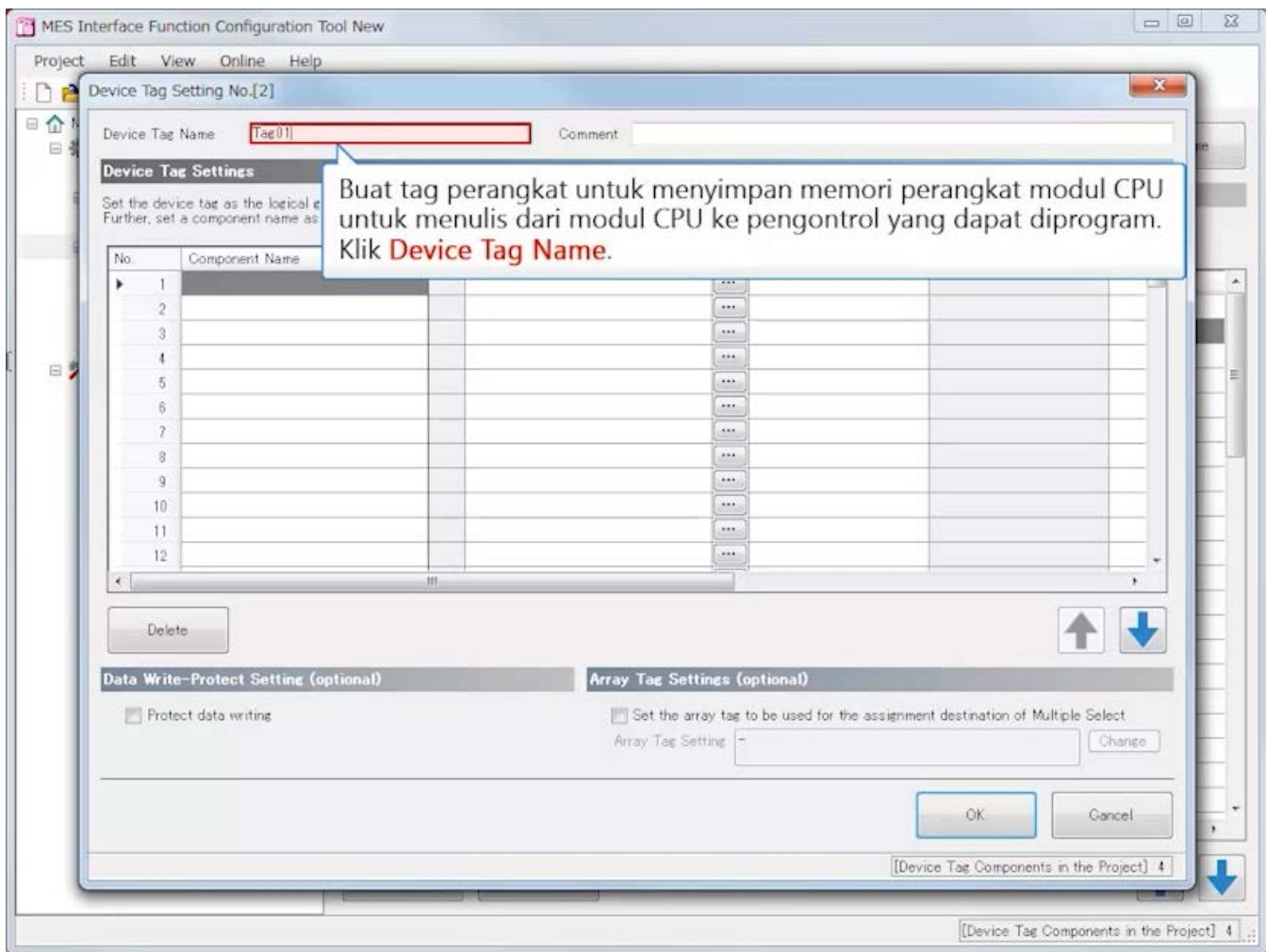
[Kembali](#)[Berikutnya](#)

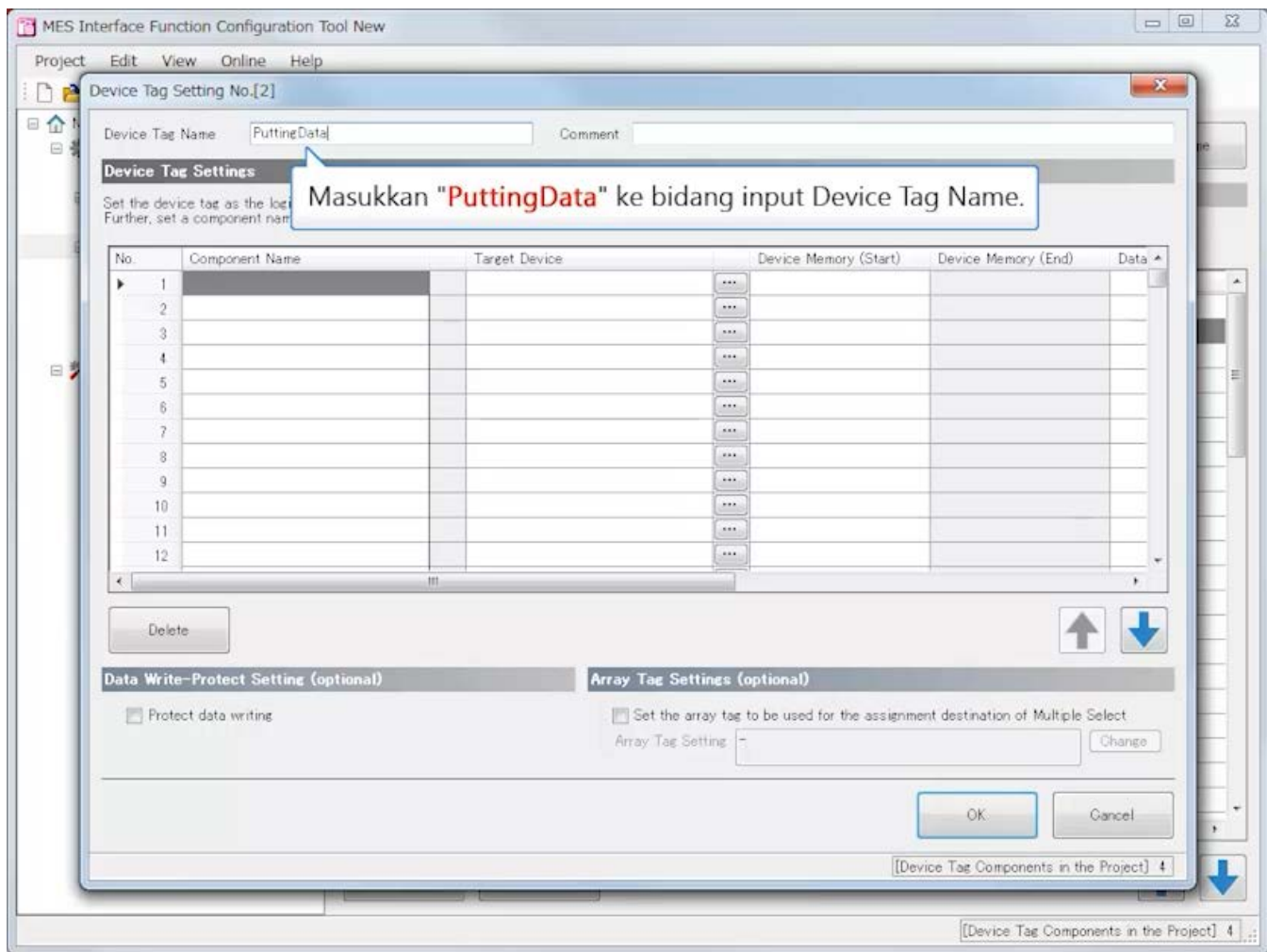
[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

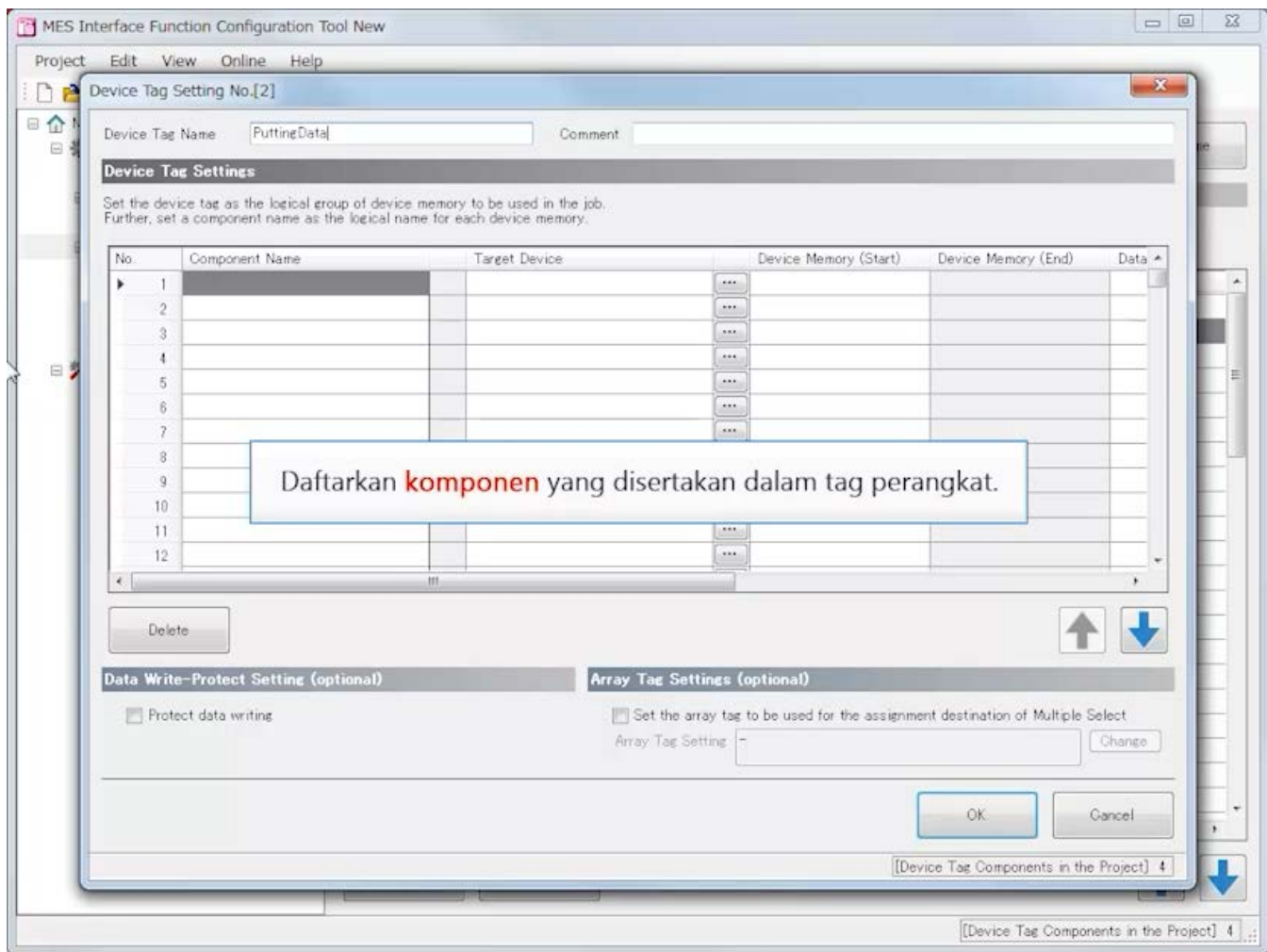


[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

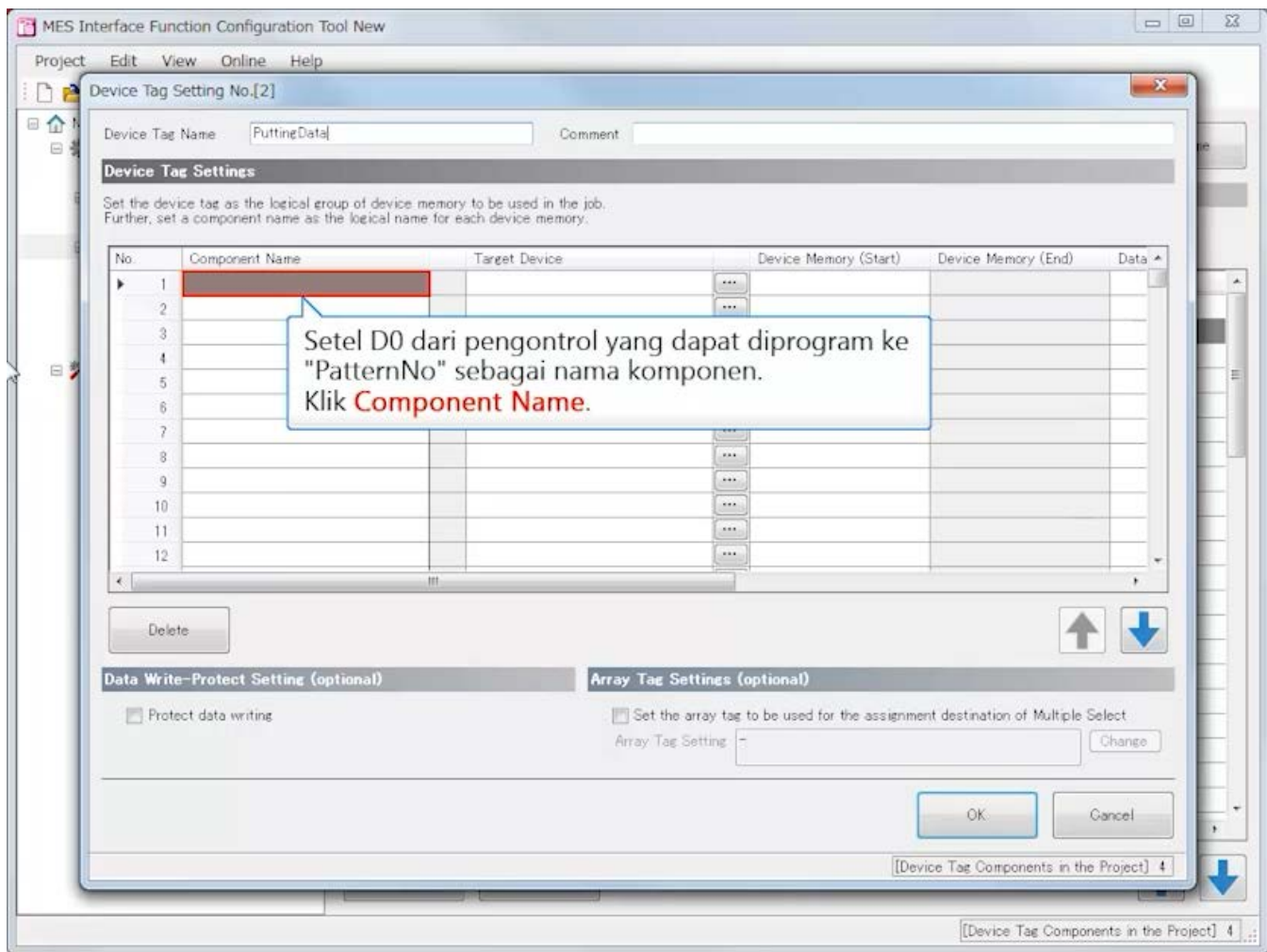
Kembali

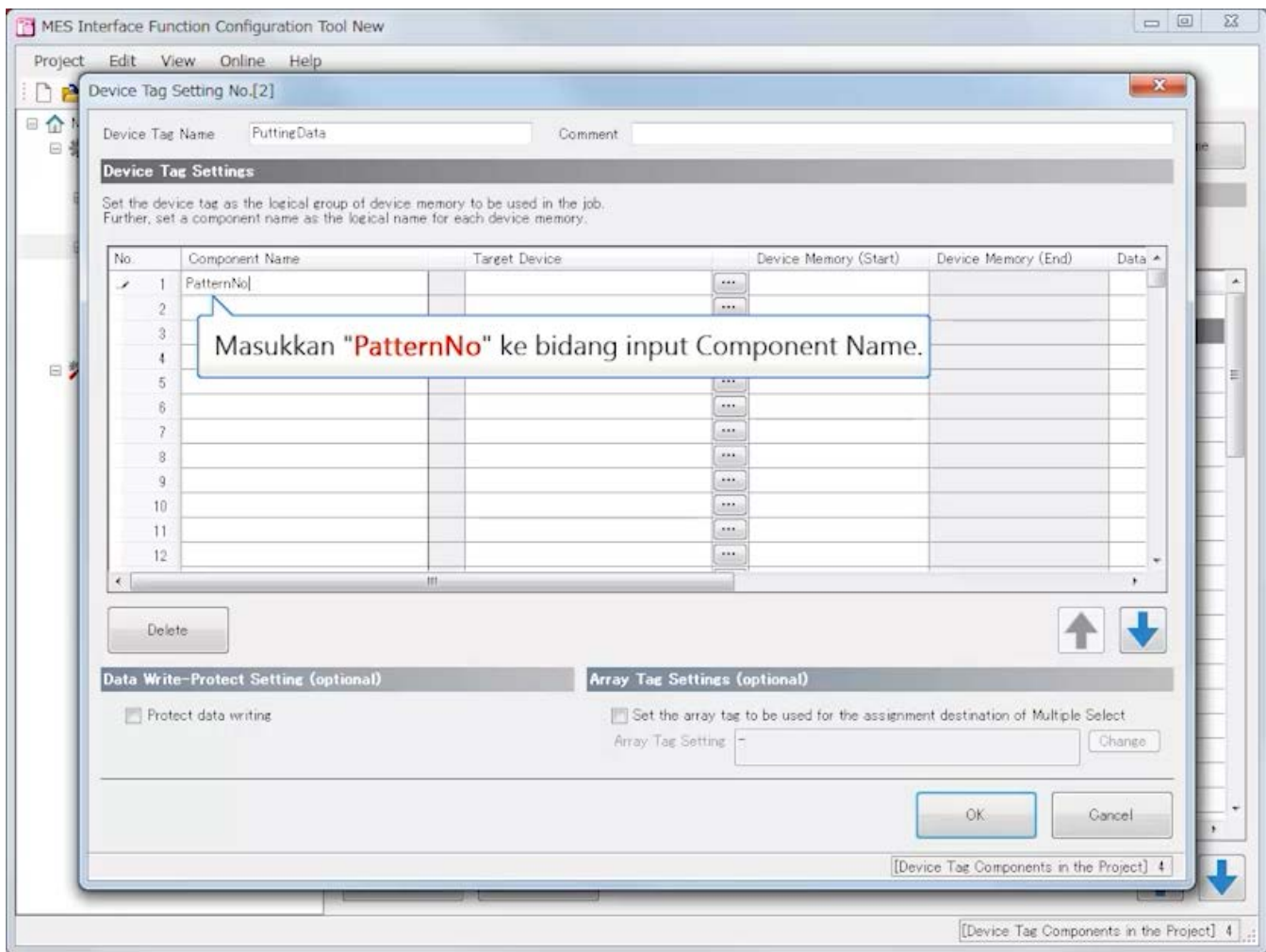
Berikutnya

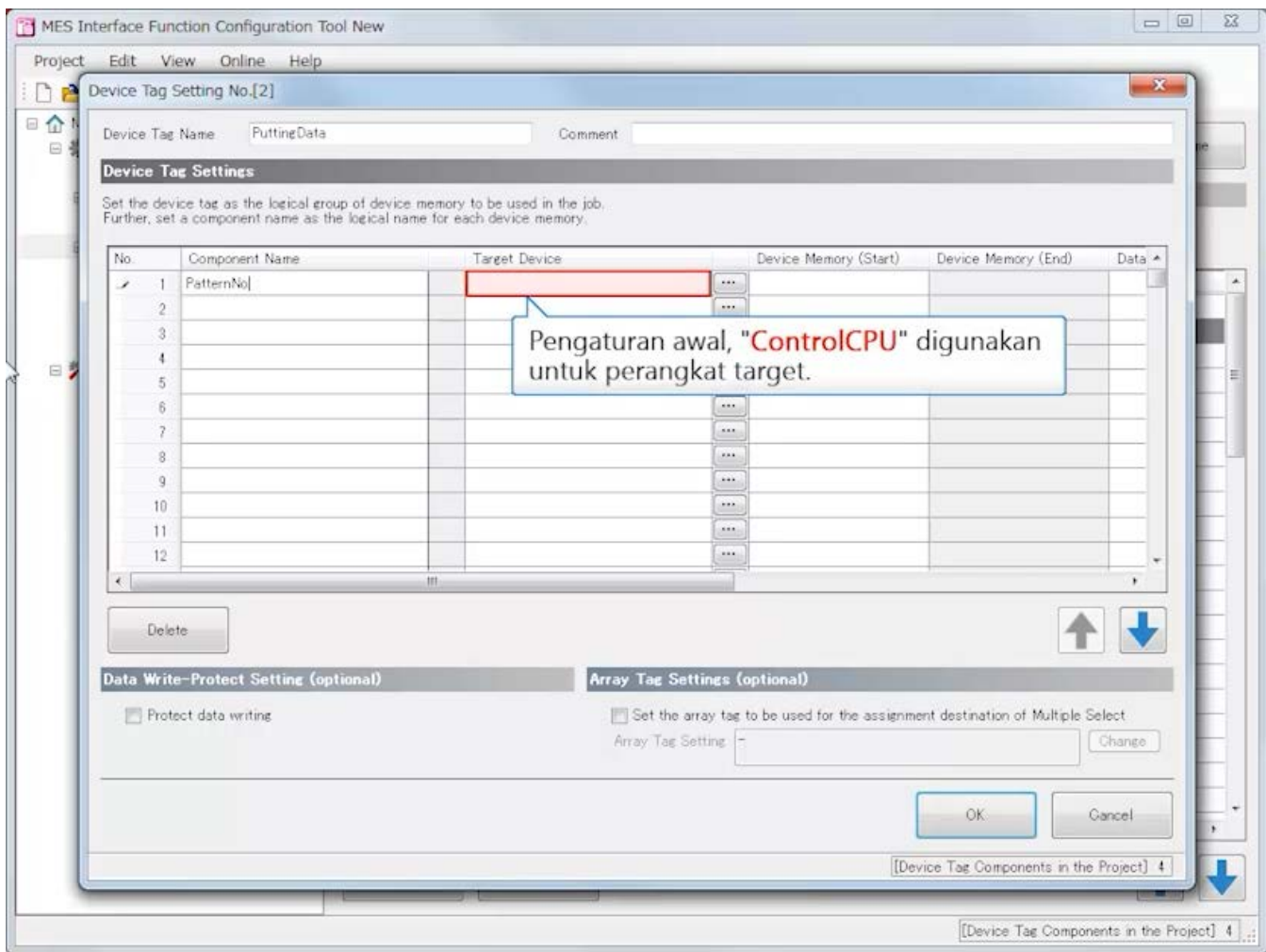


Kembali

Berikutnya

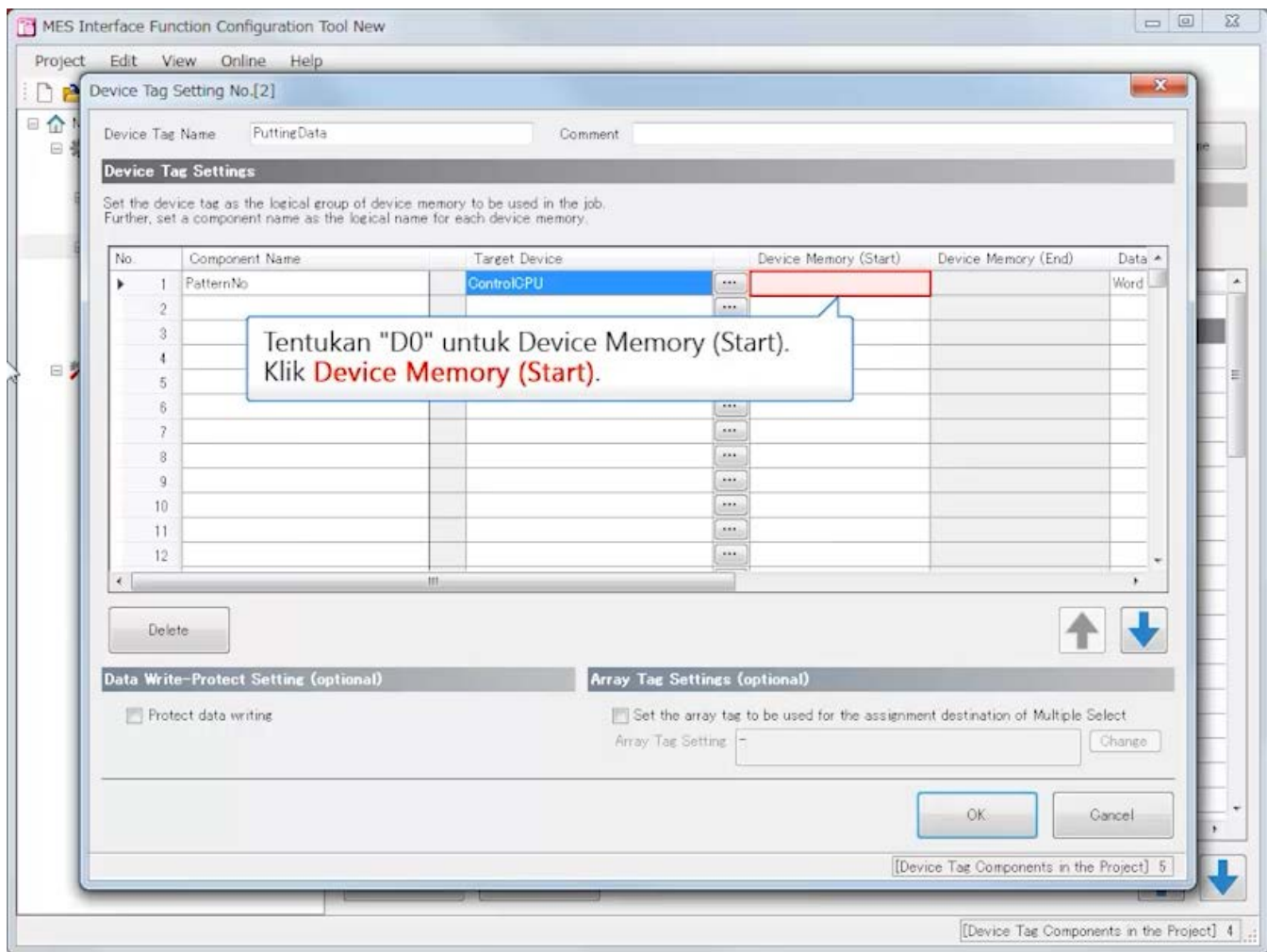


[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

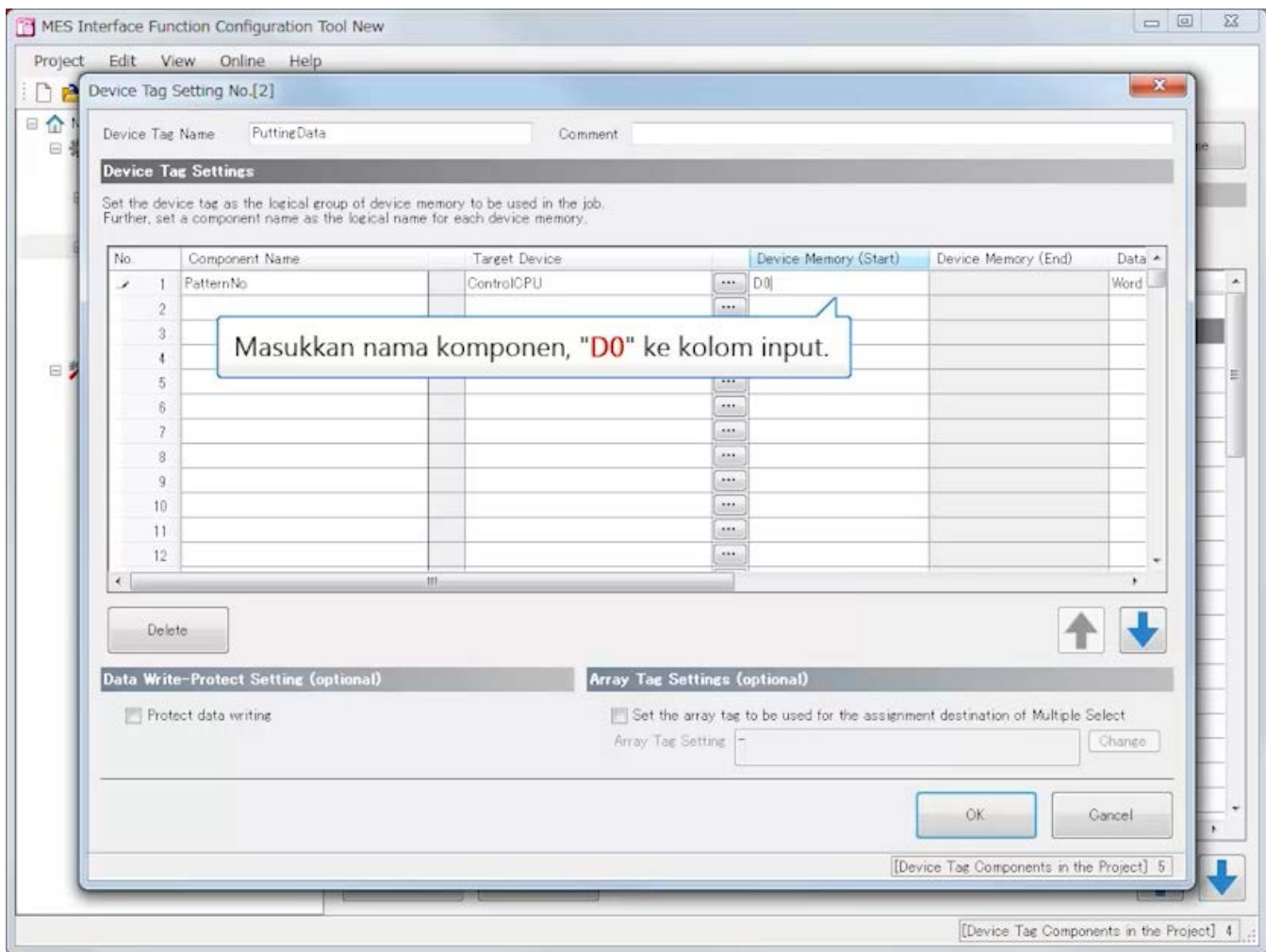
Kembali

Berikutnya



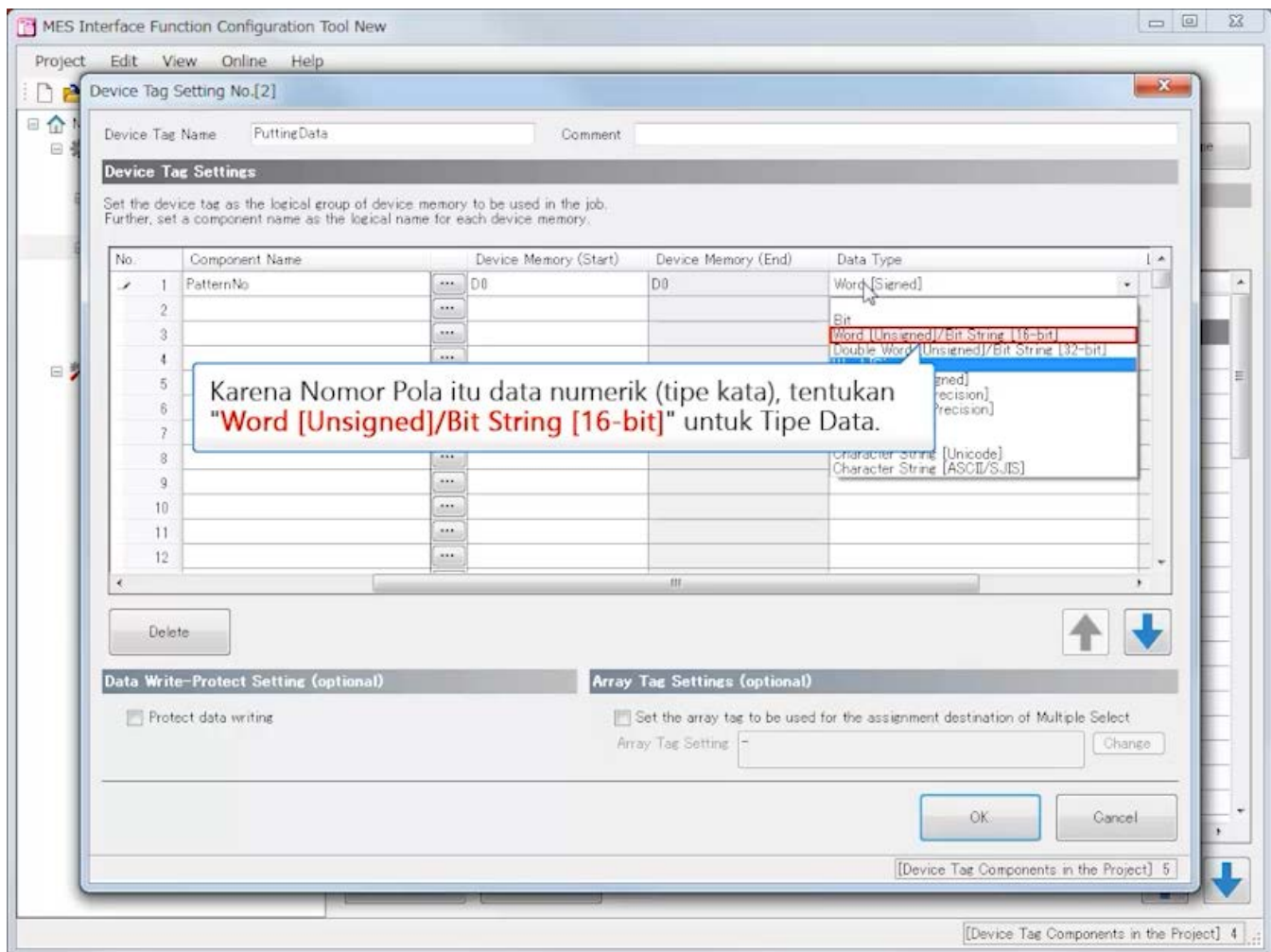
Kembali

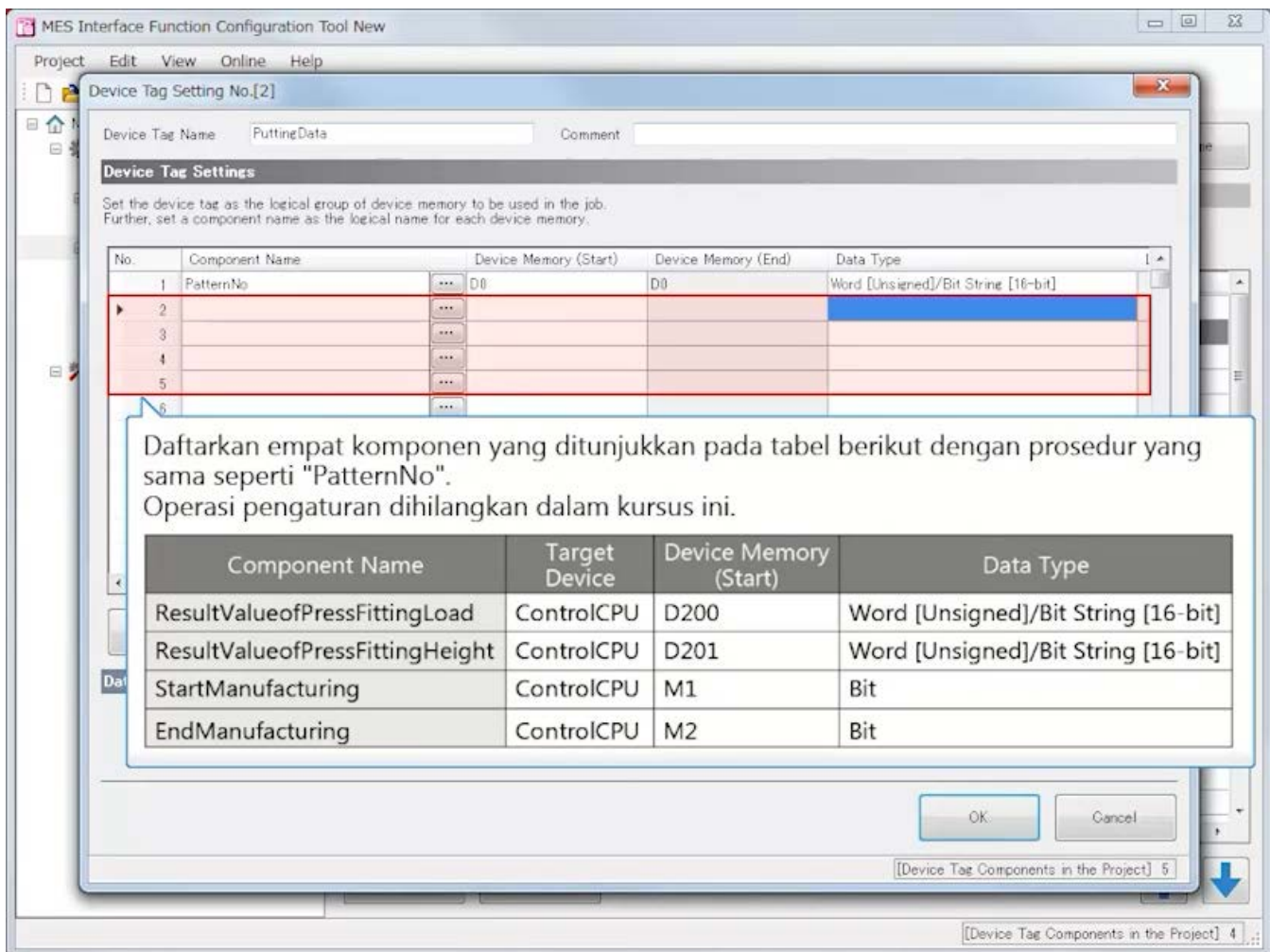
Berikutnya



Kembali

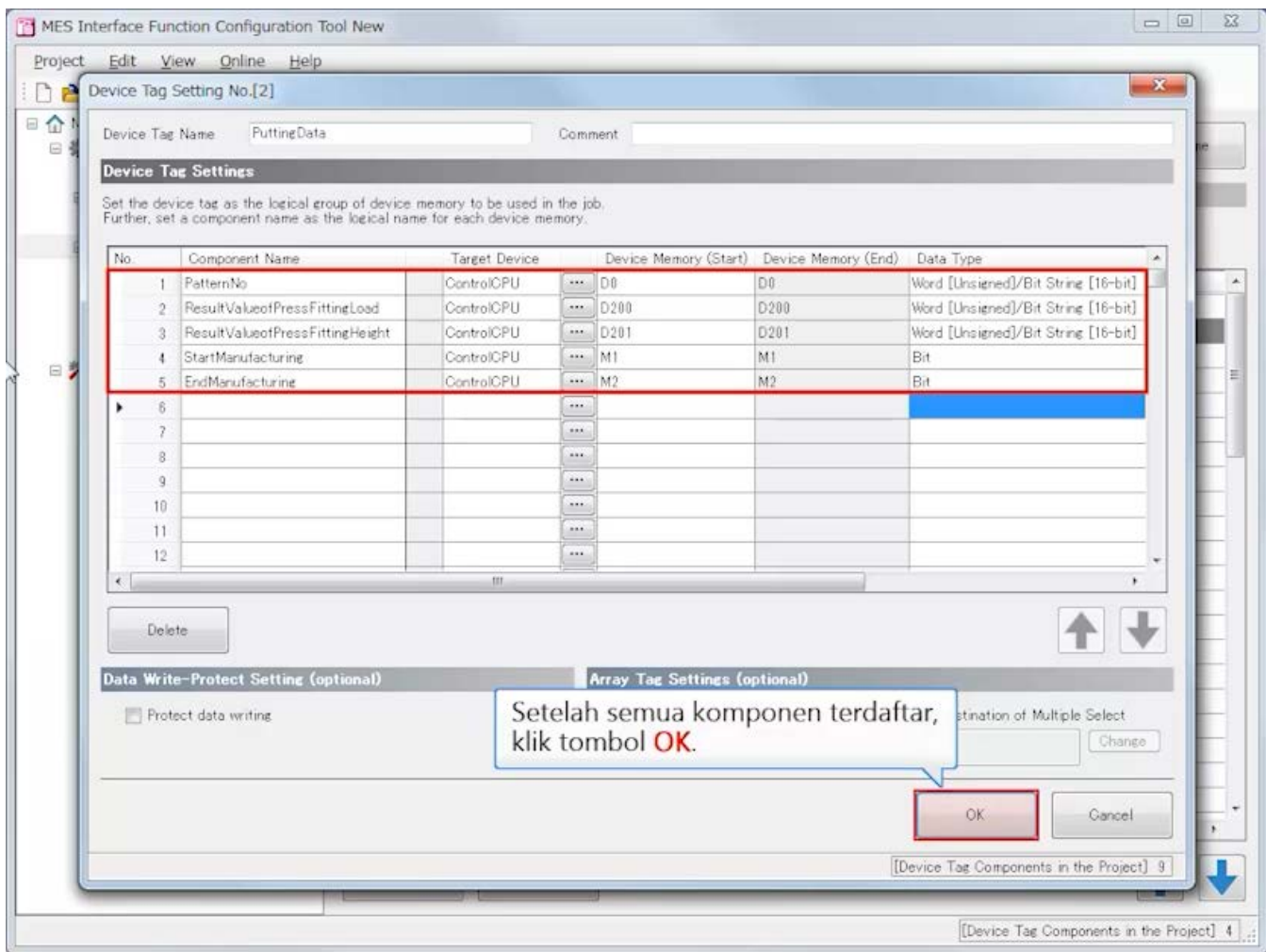
Berikutnya



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[Berikutnya](#)


Kembali

Berikutnya



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[Berikutnya](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main 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

Pengaturan tag perangkat "PuttingData" selesai.
Klik > untuk melanjutkan ke halaman berikutnya.

[Device Tag Components in the Project] 9

[Target Server Settings]

Gunakan nama sumber data yang sama seperti yang dikonfigurasi dalam pengaturan ODBC.

Pengaturan item	Pengaturan
Target Server Name	DataSeter
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 DataSeter 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. 5112

Communication Timeout Time 10 s

Target Server Individual Settings

Set the information to access the database.

Data Source Name DATADS

User Name

Password

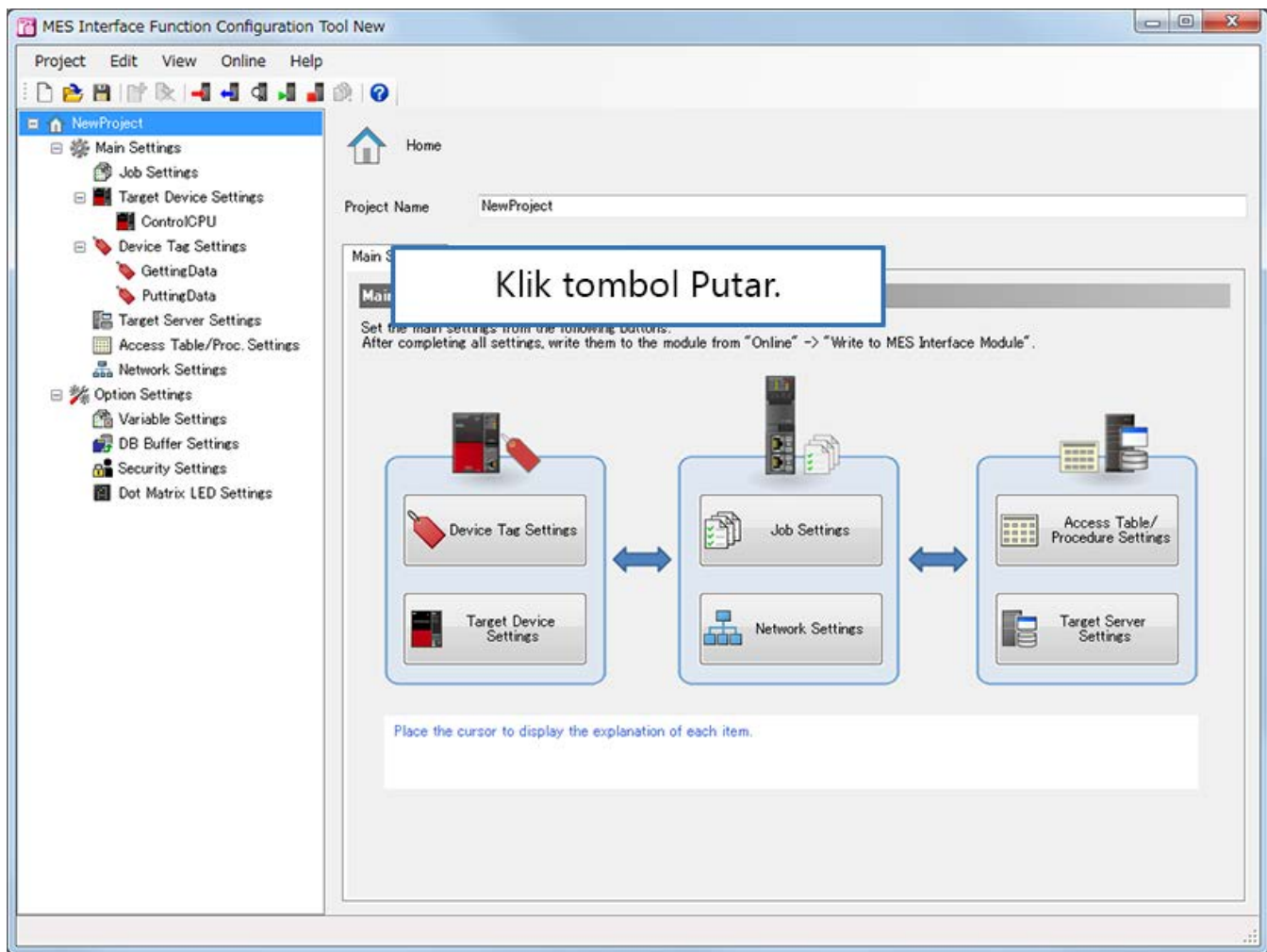
Database Type Access 2016

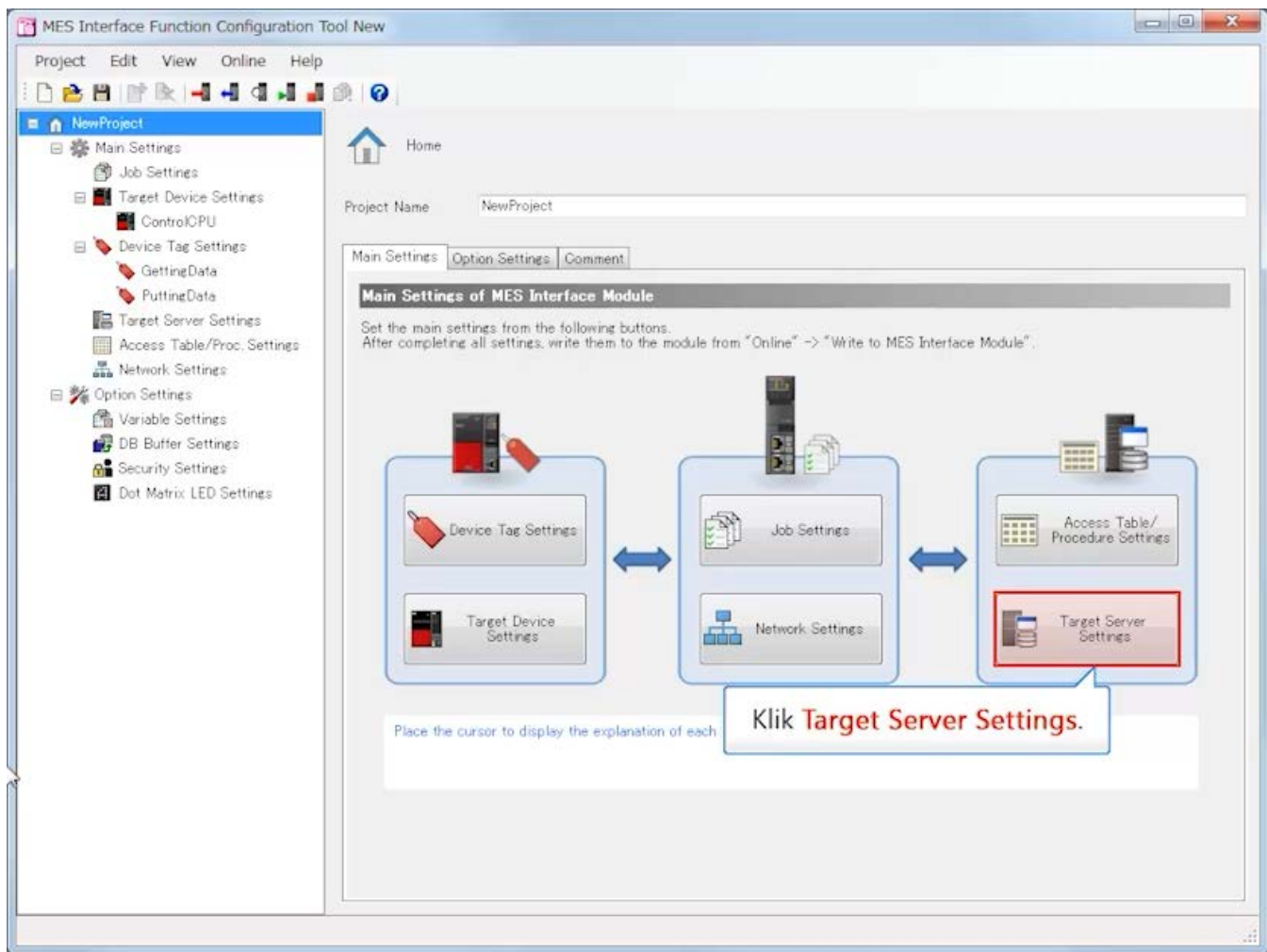
Access Error Notification Settings (optional)

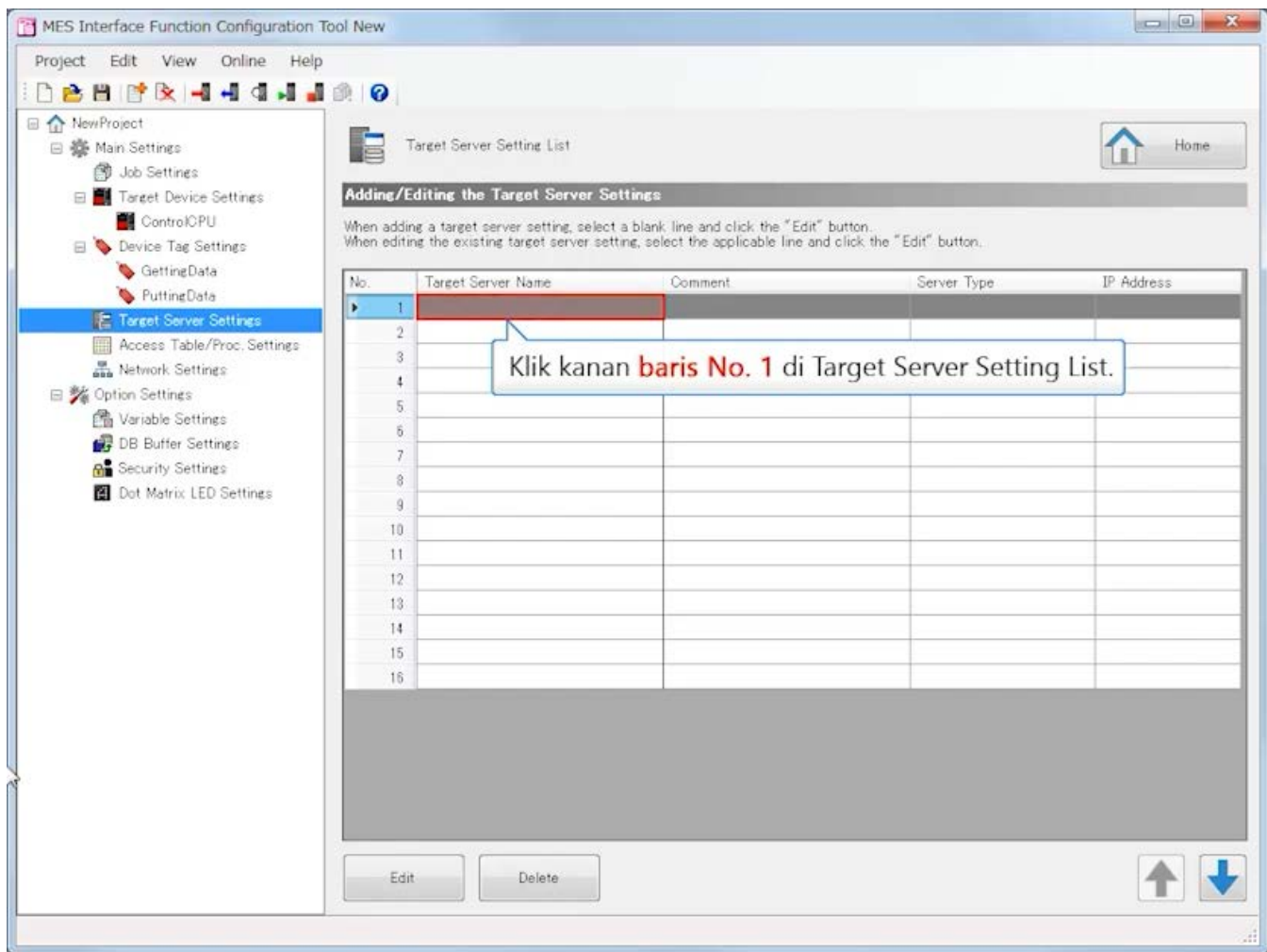
Access Error Notification Setting Not Notify Change

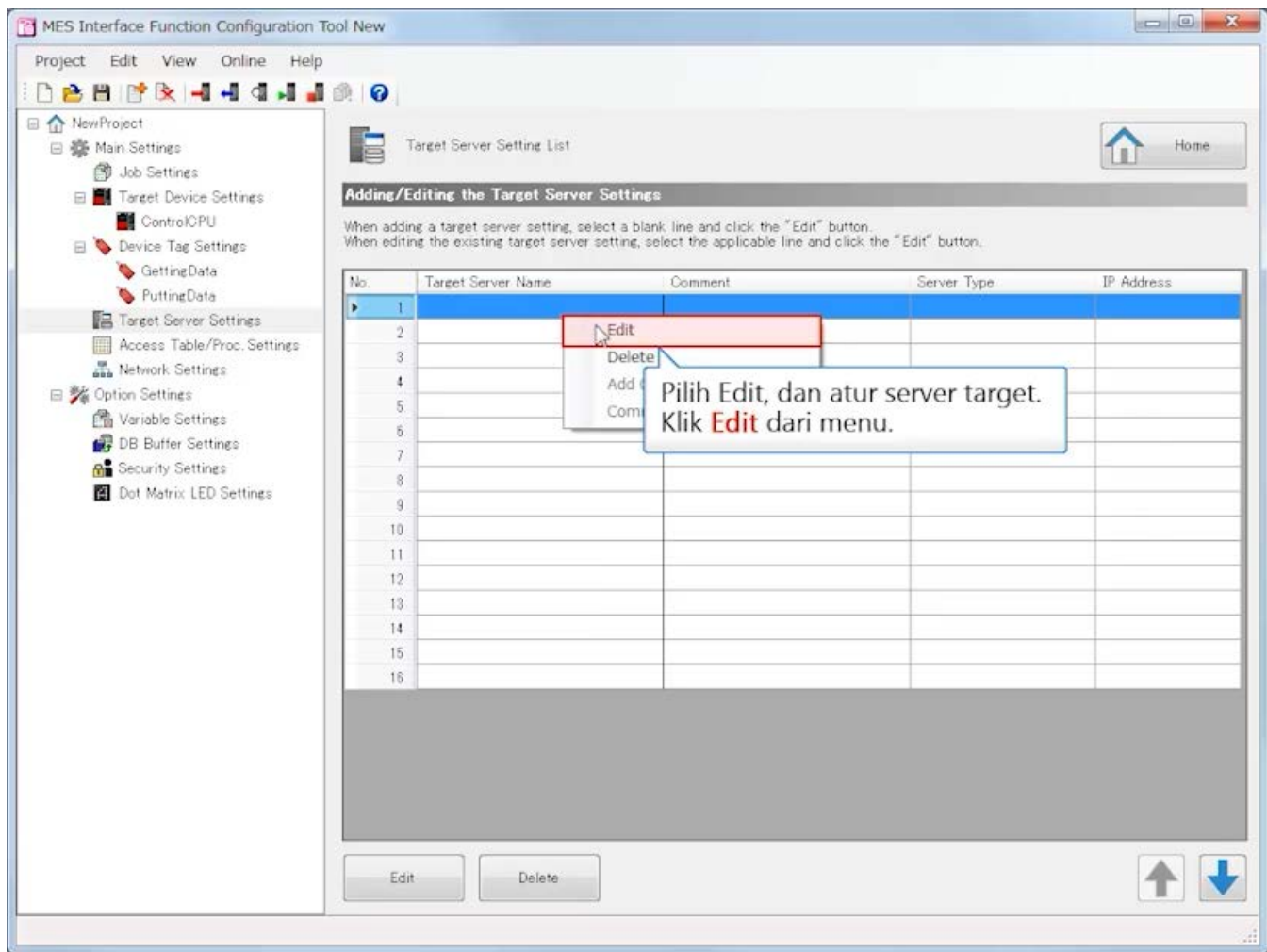
Communication Test

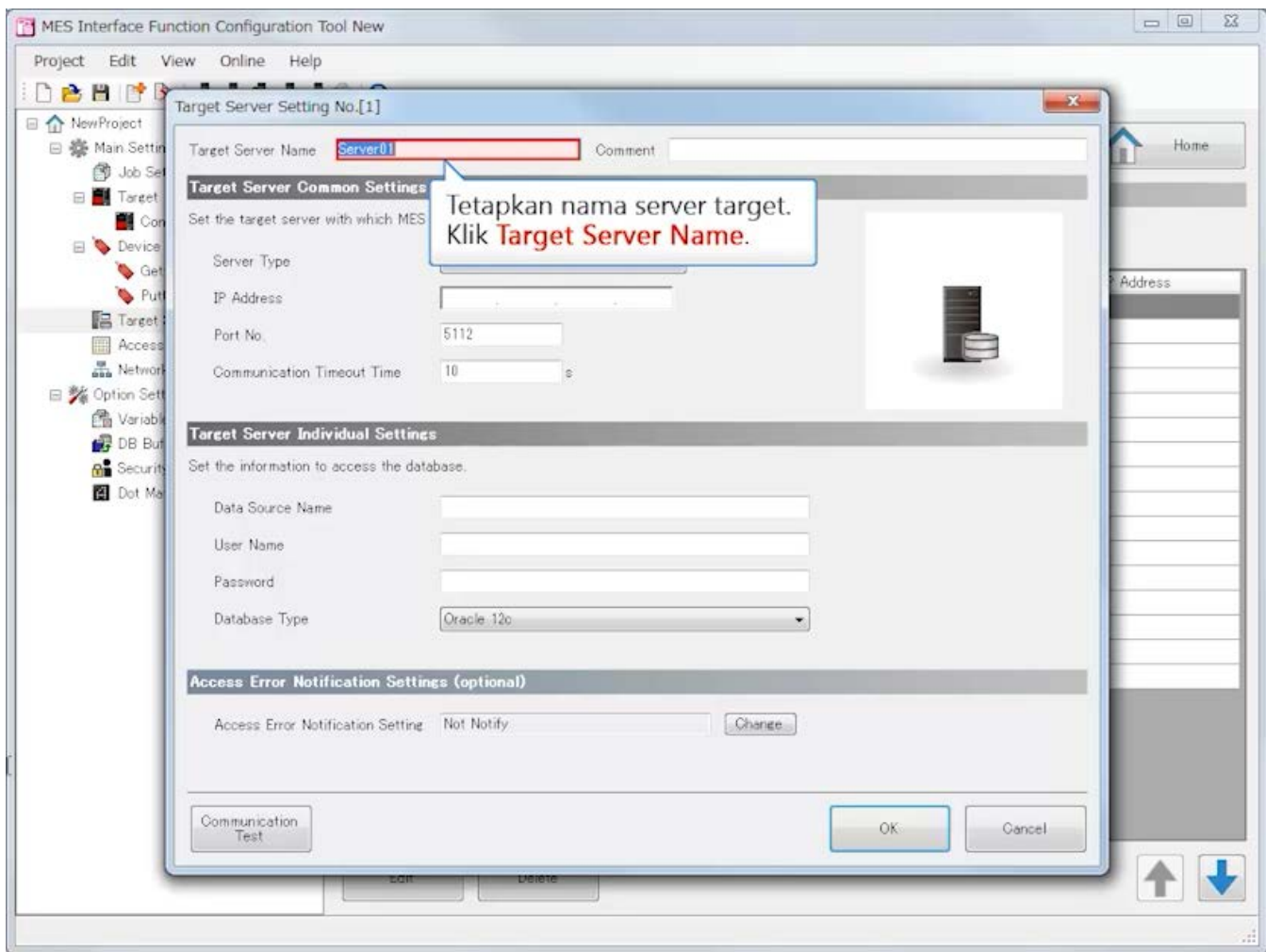
OK Cancel

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

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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 Buffer
- Security
- Dot Matrix

Target Server Setting No.[1]

Target Server Name: DataServer Comment:

Target Server Common

Set the target server with

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:

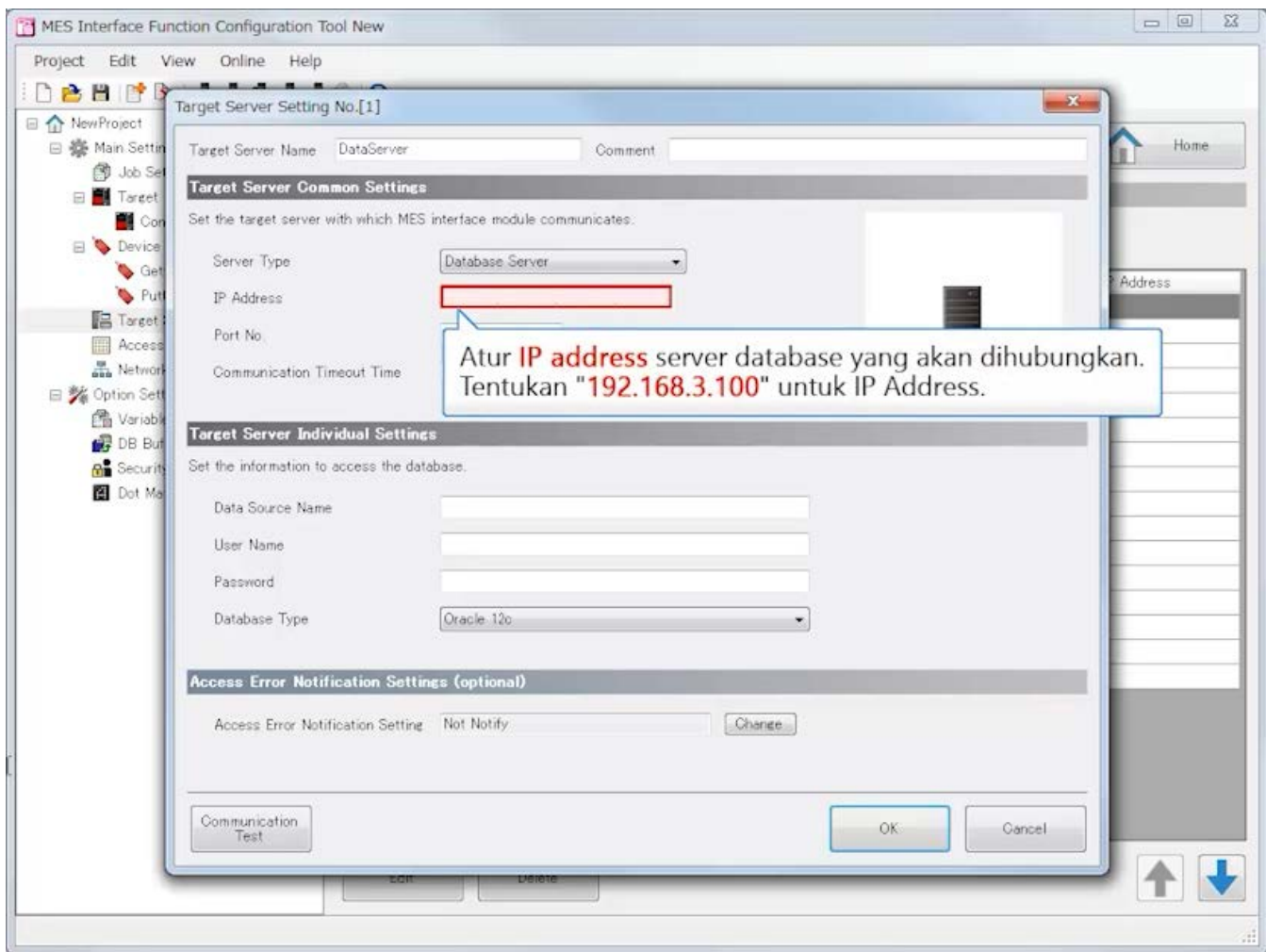
Database Type: Oracle 12c

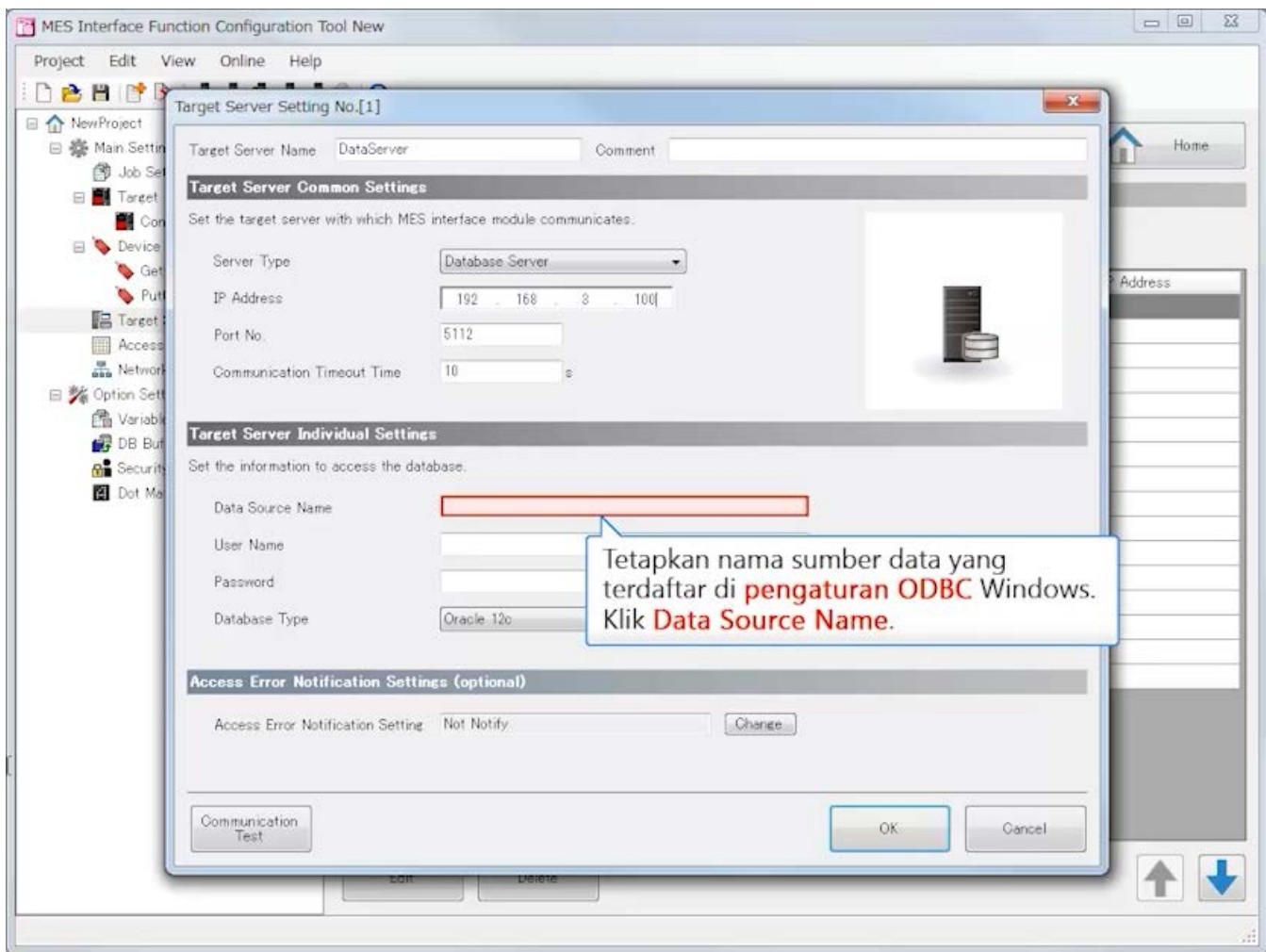
Access Error Notification Settings (optional)

Access Error Notification Setting: Not Notify Change

Communication Test OK Cancel

Masukkan "DataServer" ke bidang input Server Target Name.

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Setting
- Job Setting
- Target Server Setting
- Communication Setting
- Device Setting
- Get Setting
- Put Setting
- Target Server Access
- Network Setting
- Option Setting
- Variable Setting
- DB Backup
- Security
- Dot Matrix

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

Masukkan "DATADS" ke bidang input Data Source Name.

[Kembali](#)[Berikutnya](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

- Main Setting
- Job Setting
- Target Server Setting
- Communication Setting
- Device Setting
- Get Setting
- Put Setting
- Target Server Access
- Access
- Network
- Option Setting
- Variable
- DB Backup
- Security
- Dot Matrix

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.: 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

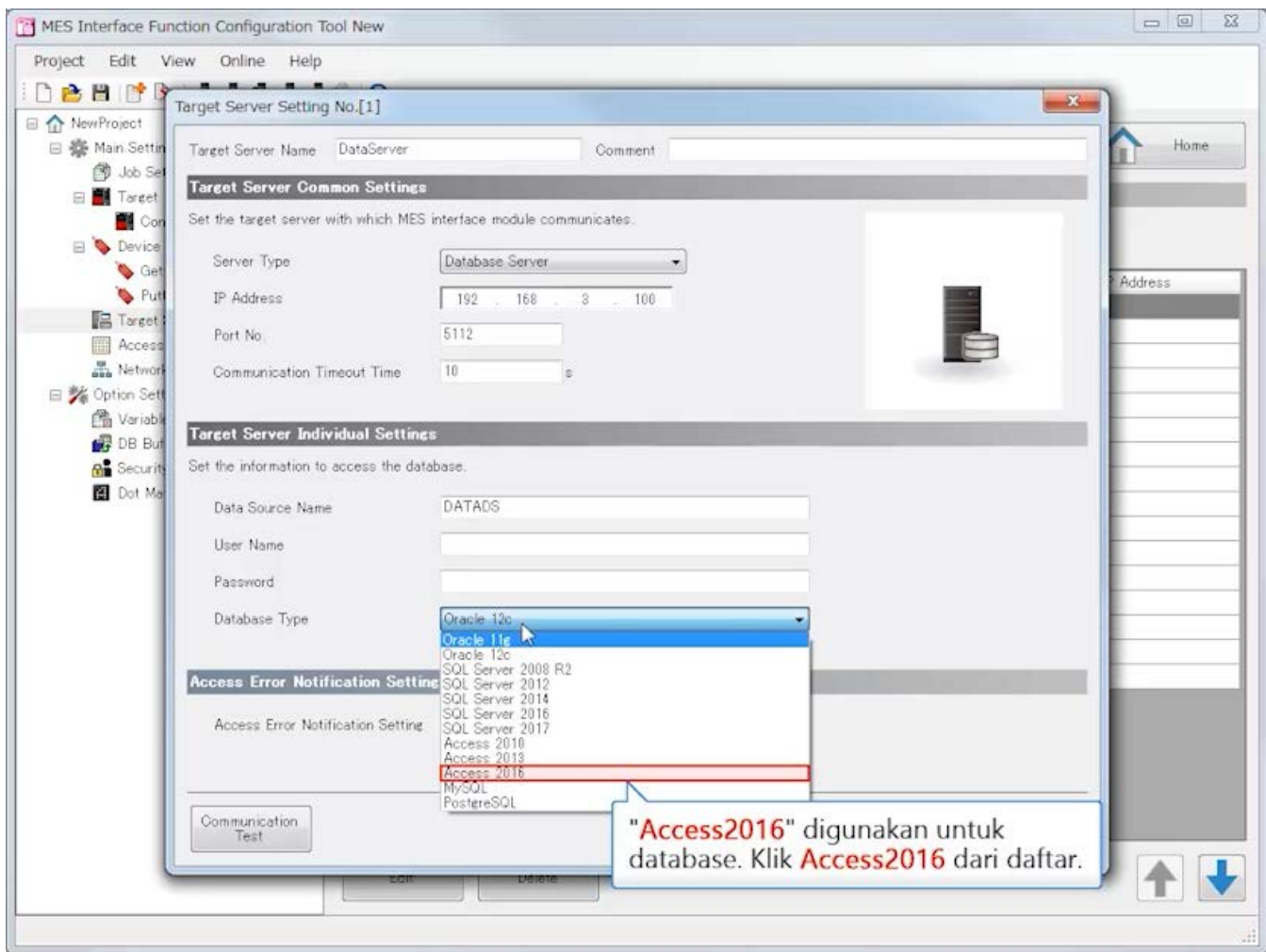
Access Error Notification Settings (optional)

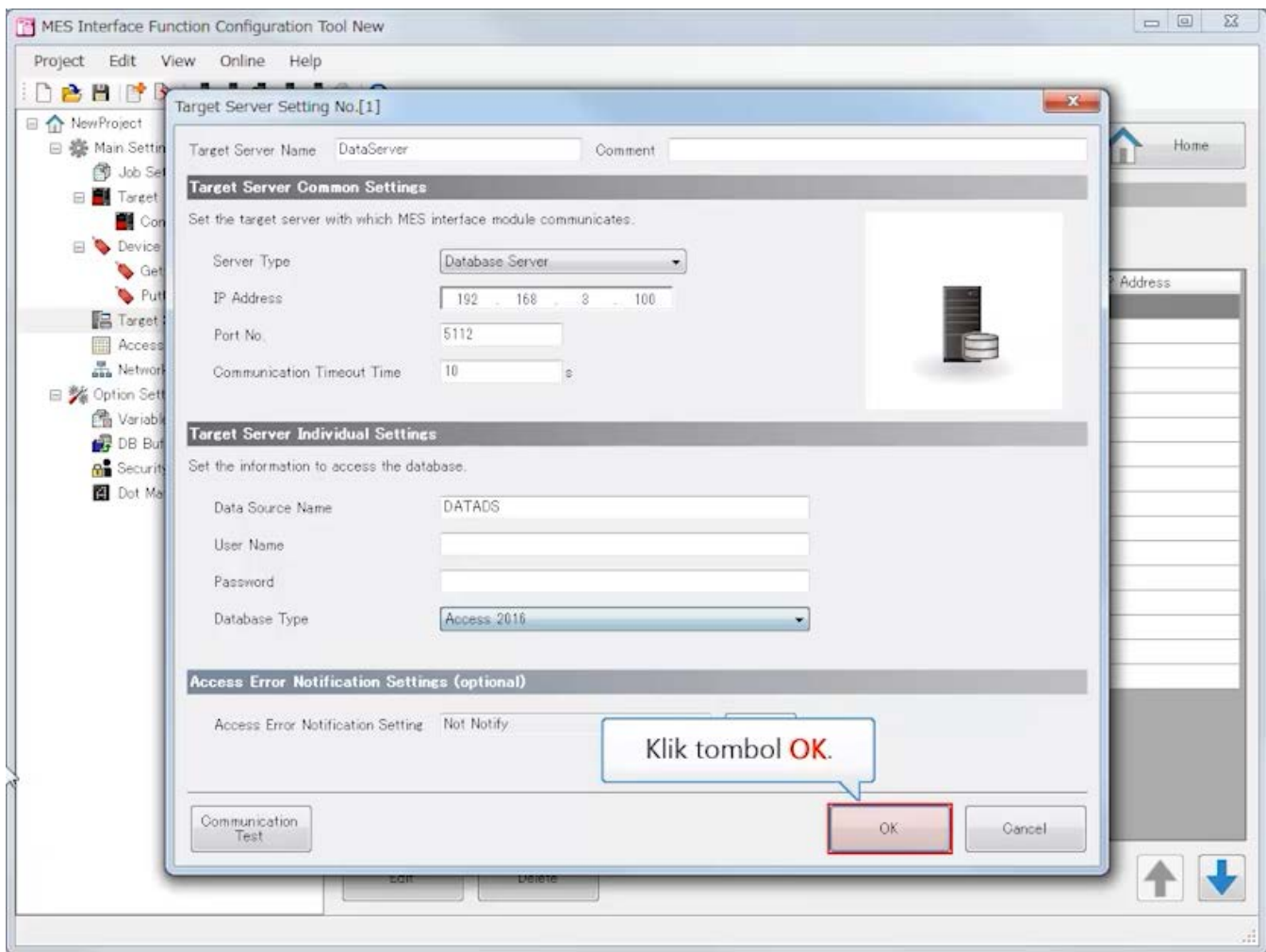
Access Error Notification Setting: Not Notify

Communication Test

OK Cancel

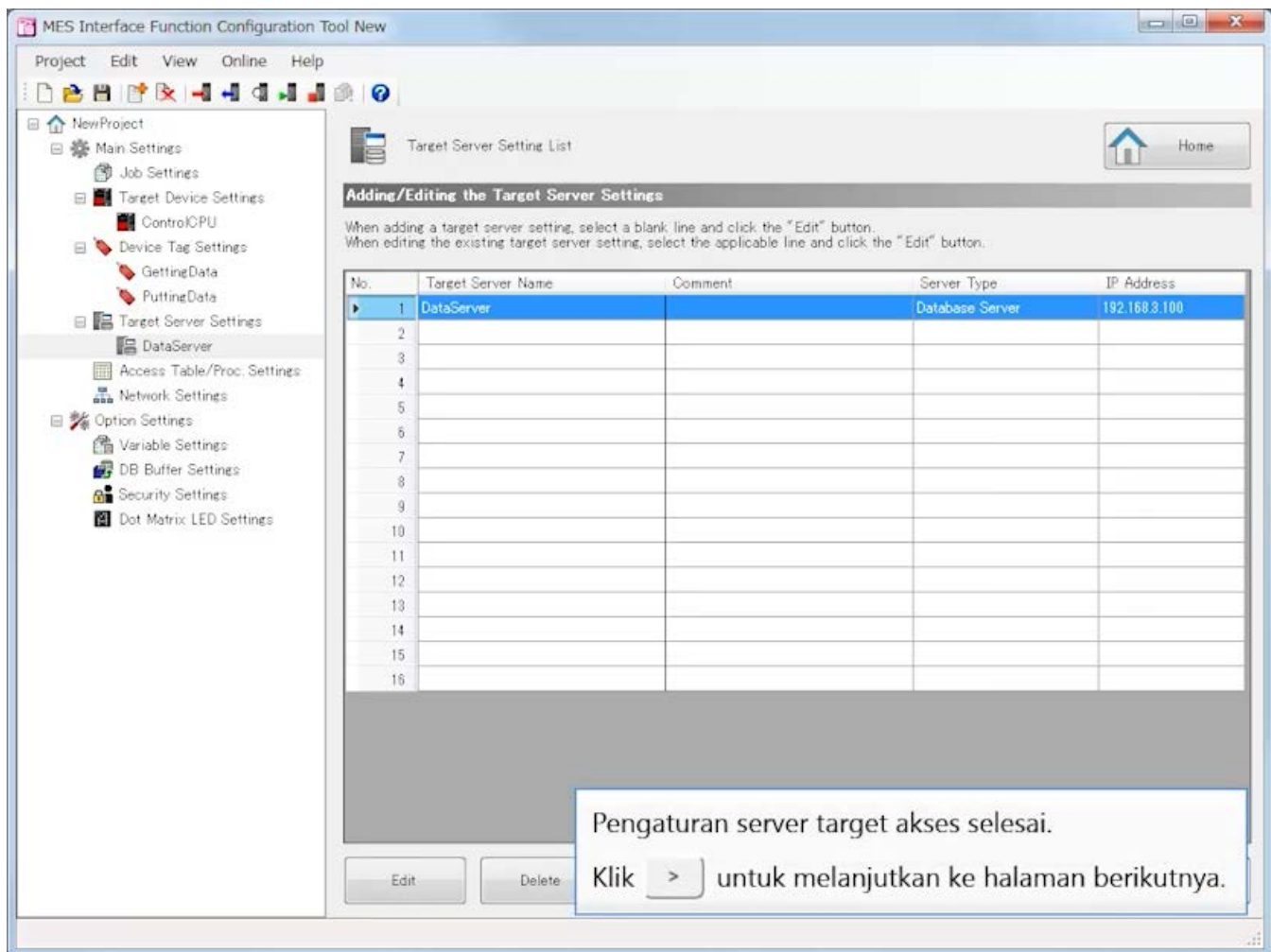
Atur jenis database yang akan dihubungkan. Klik **Database Type**.

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya



[Access Table/Procedure Settings]

Konfigurasi tabel/prosedur akses yang terhubung dengan modul antarmuka MES.

- (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 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 InformationBrowse 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	EndTime	EndTime	Date and Time [Without Time Zone]	Disable	Disable
5					
6					
7					
8					

Delete



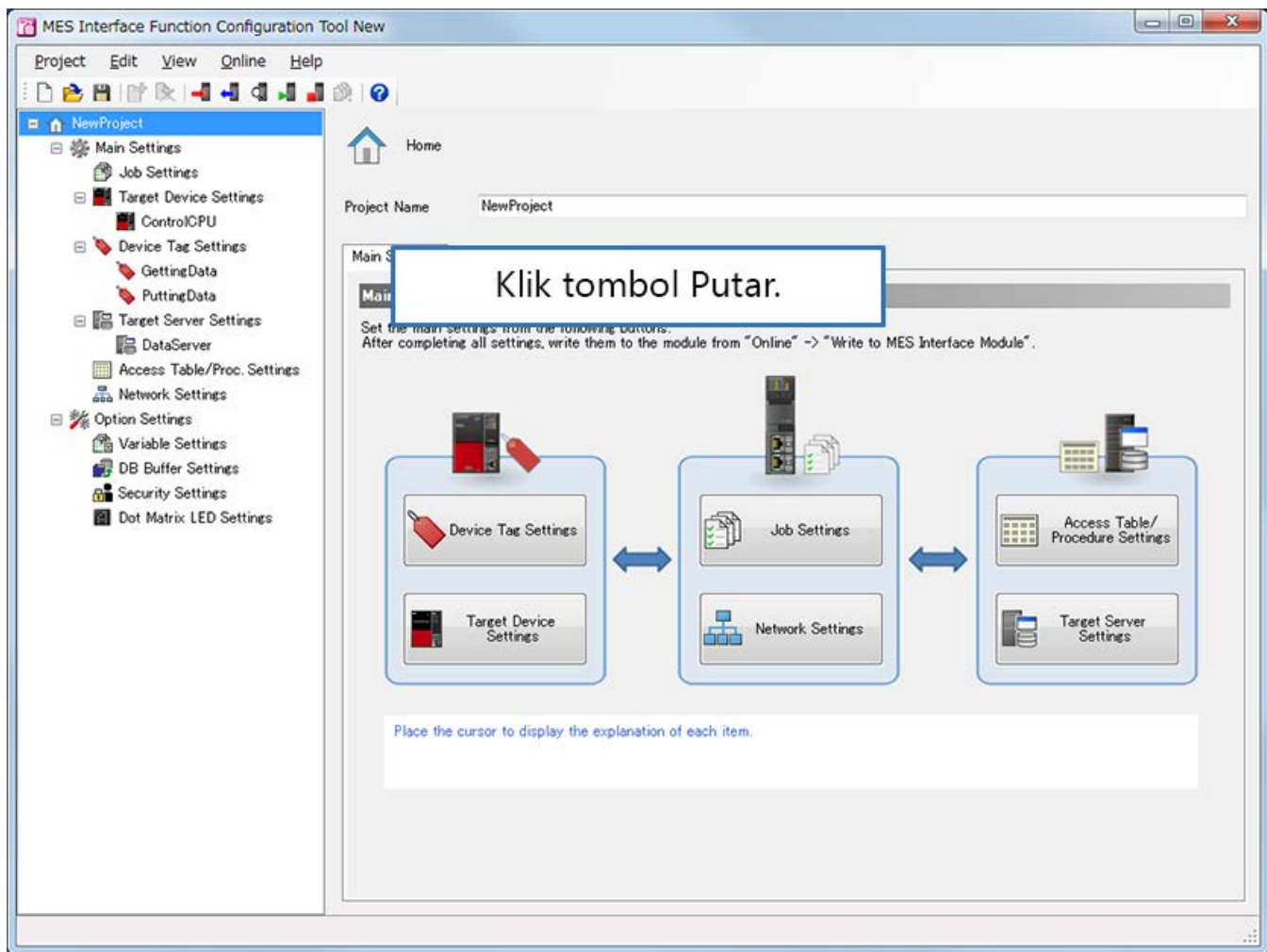
OK

Cancel

[DB Field Name] 38 characters

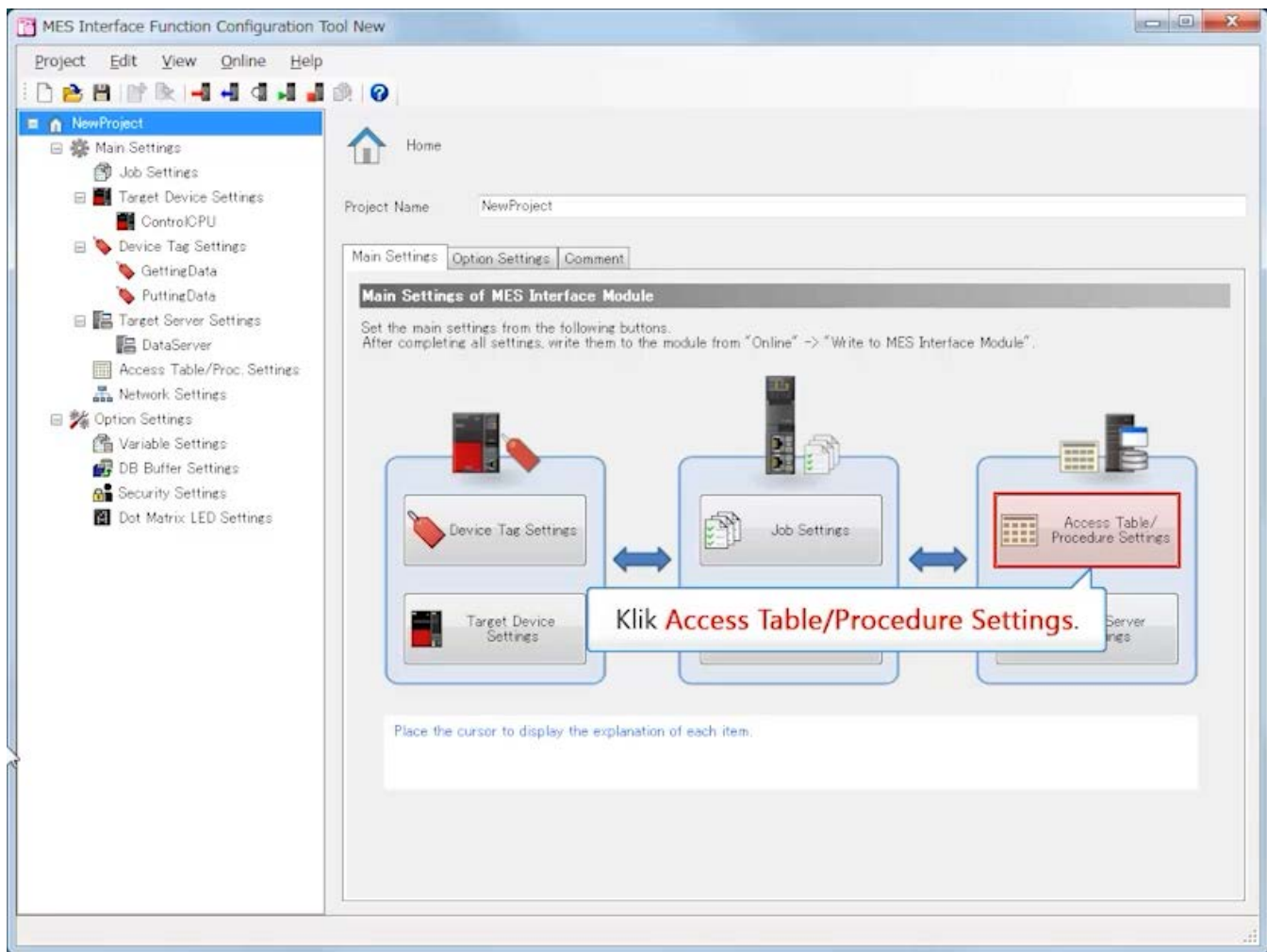
Kembali

Berikutnya



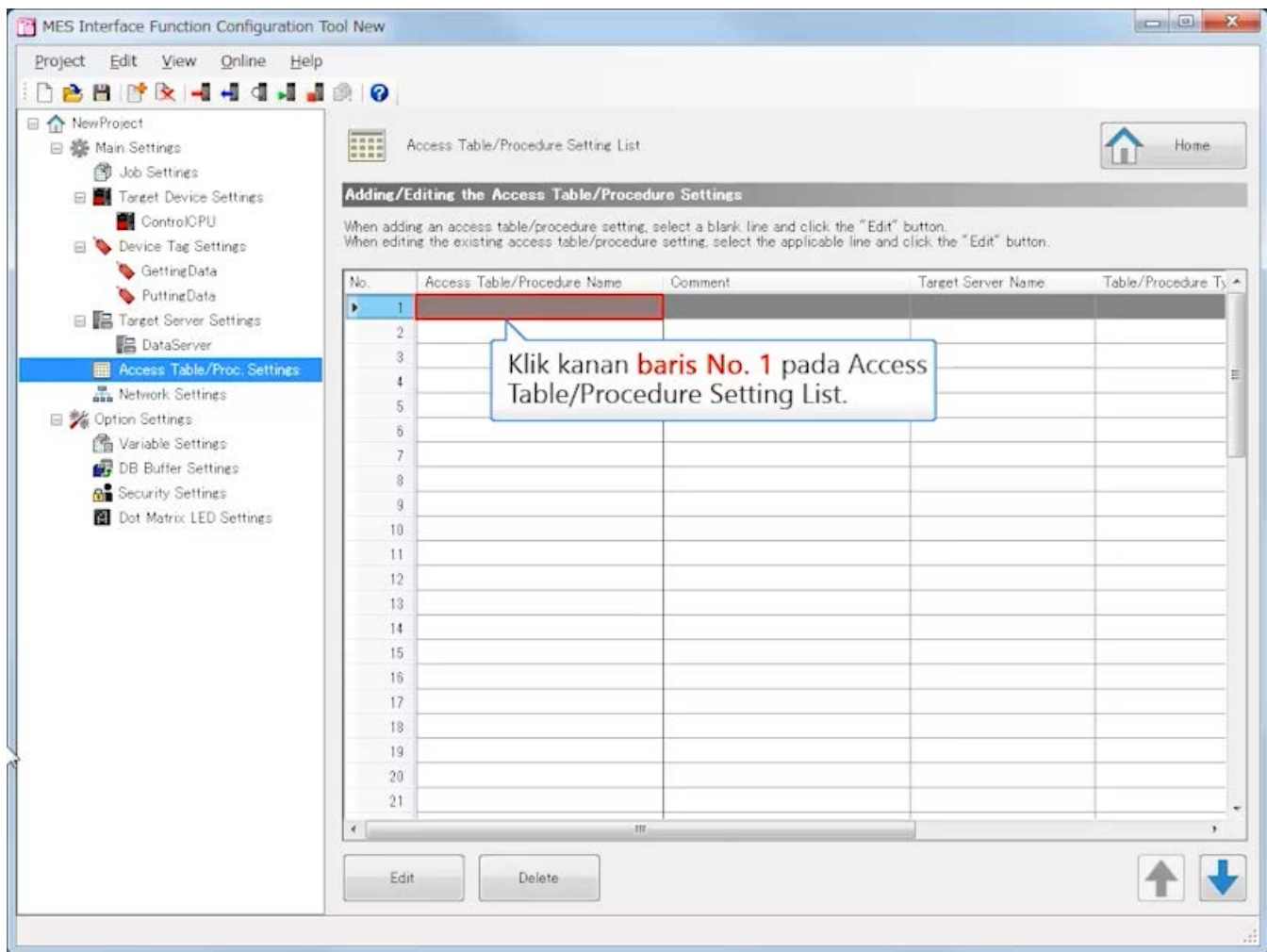
Kembali

Berikutnya



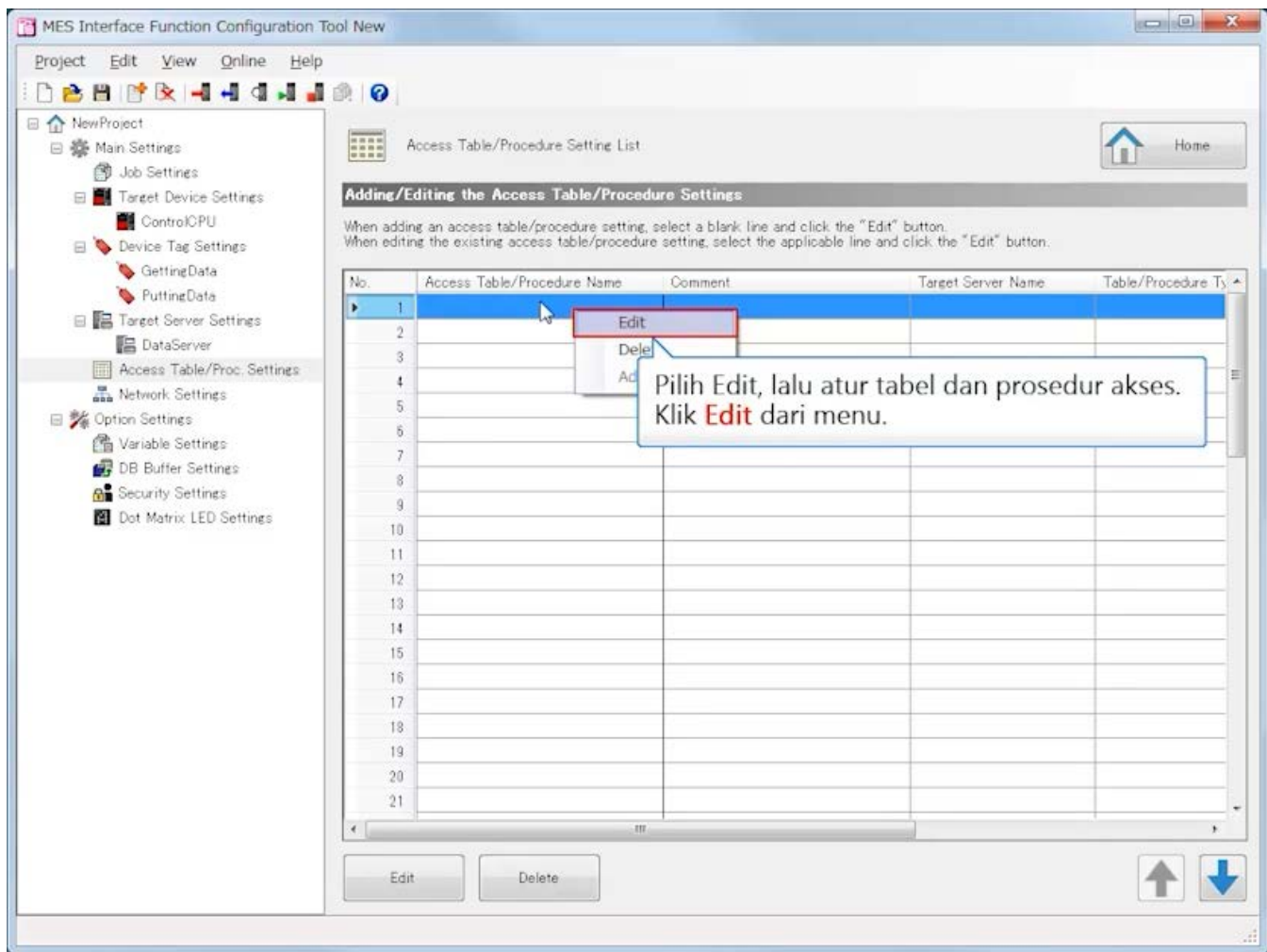
Kembali

Berikutnya



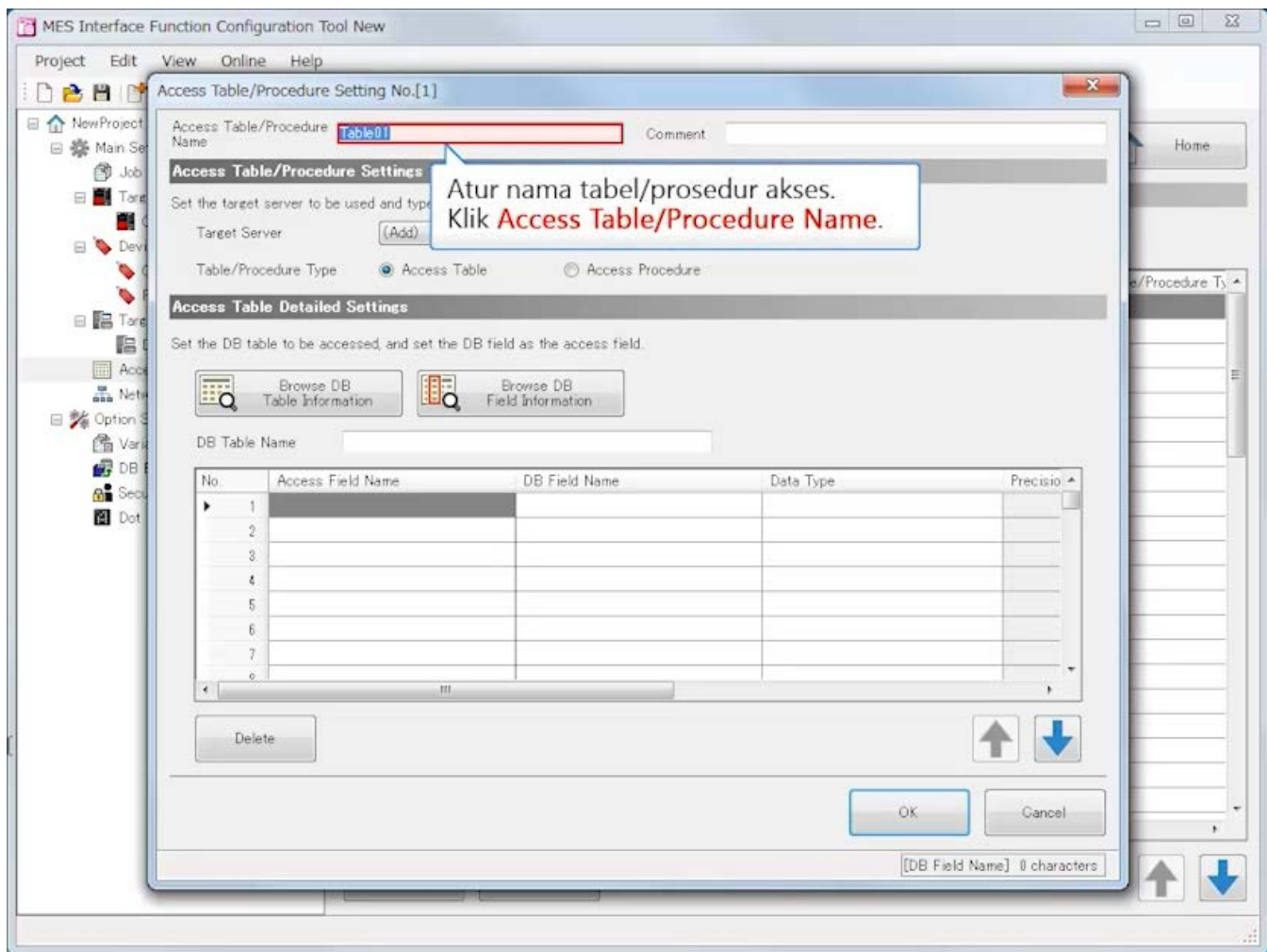
Kembali

Berikutnya



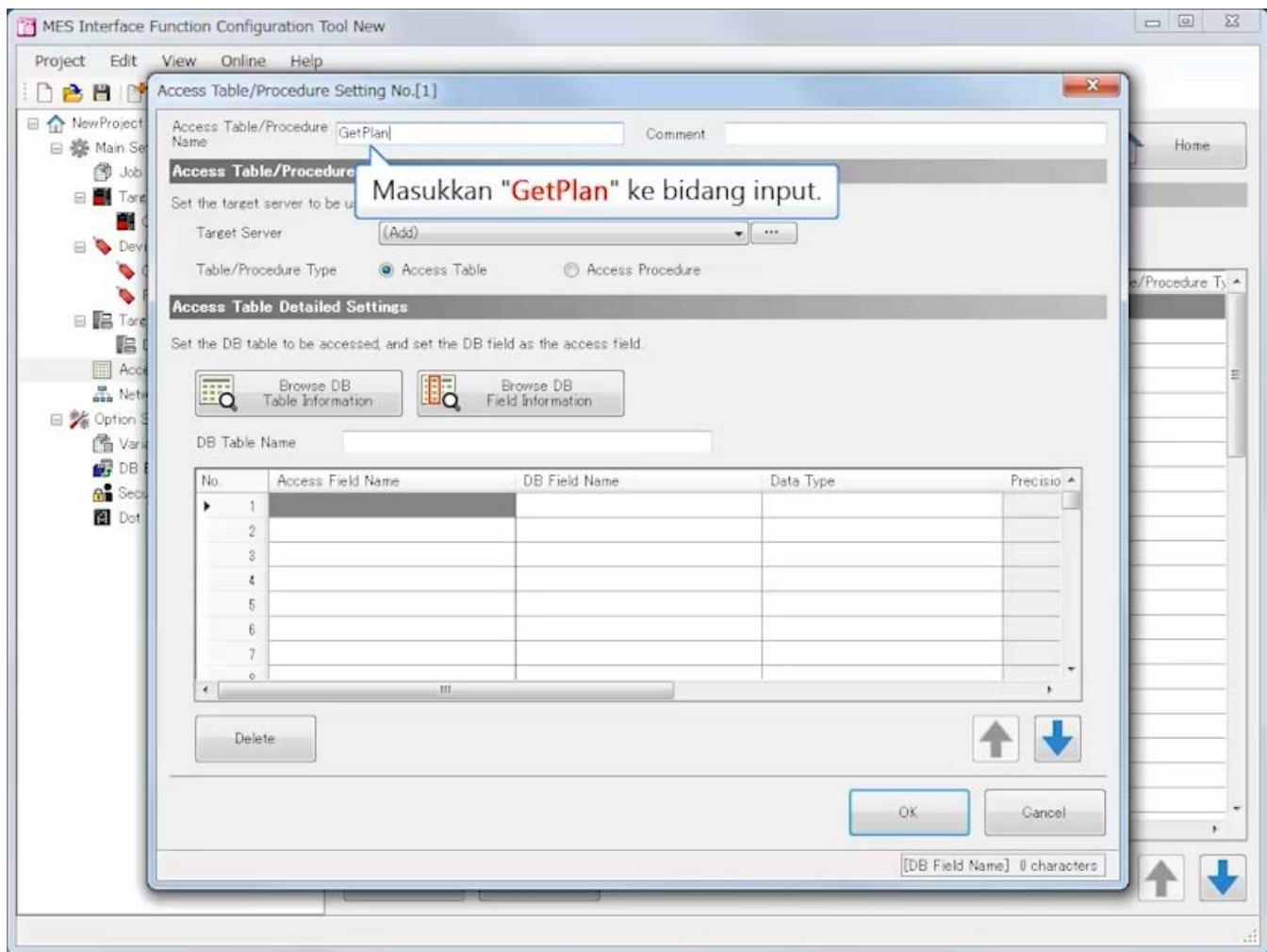
Kembali

Berikutnya



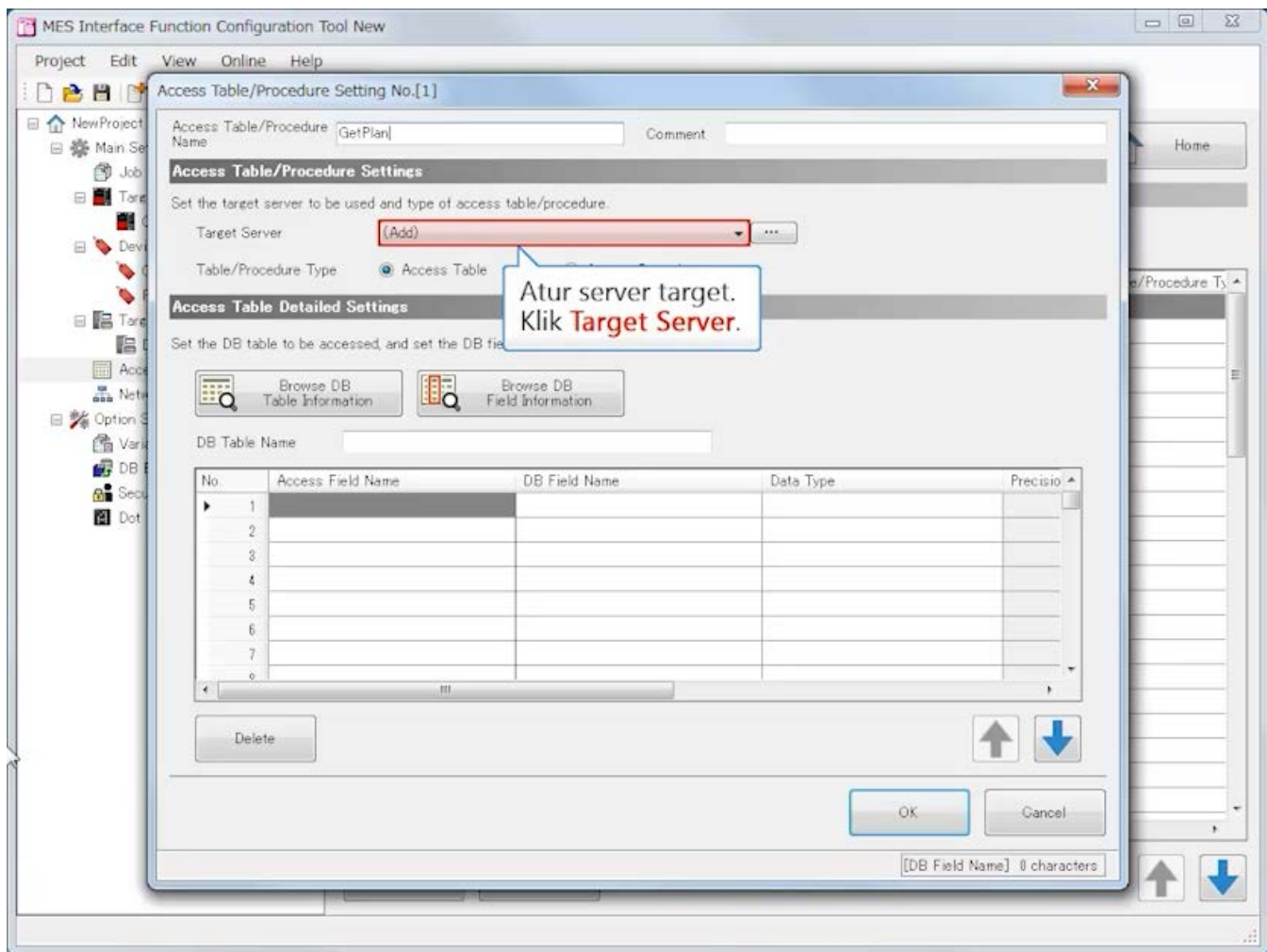
Kembali

Berikutnya



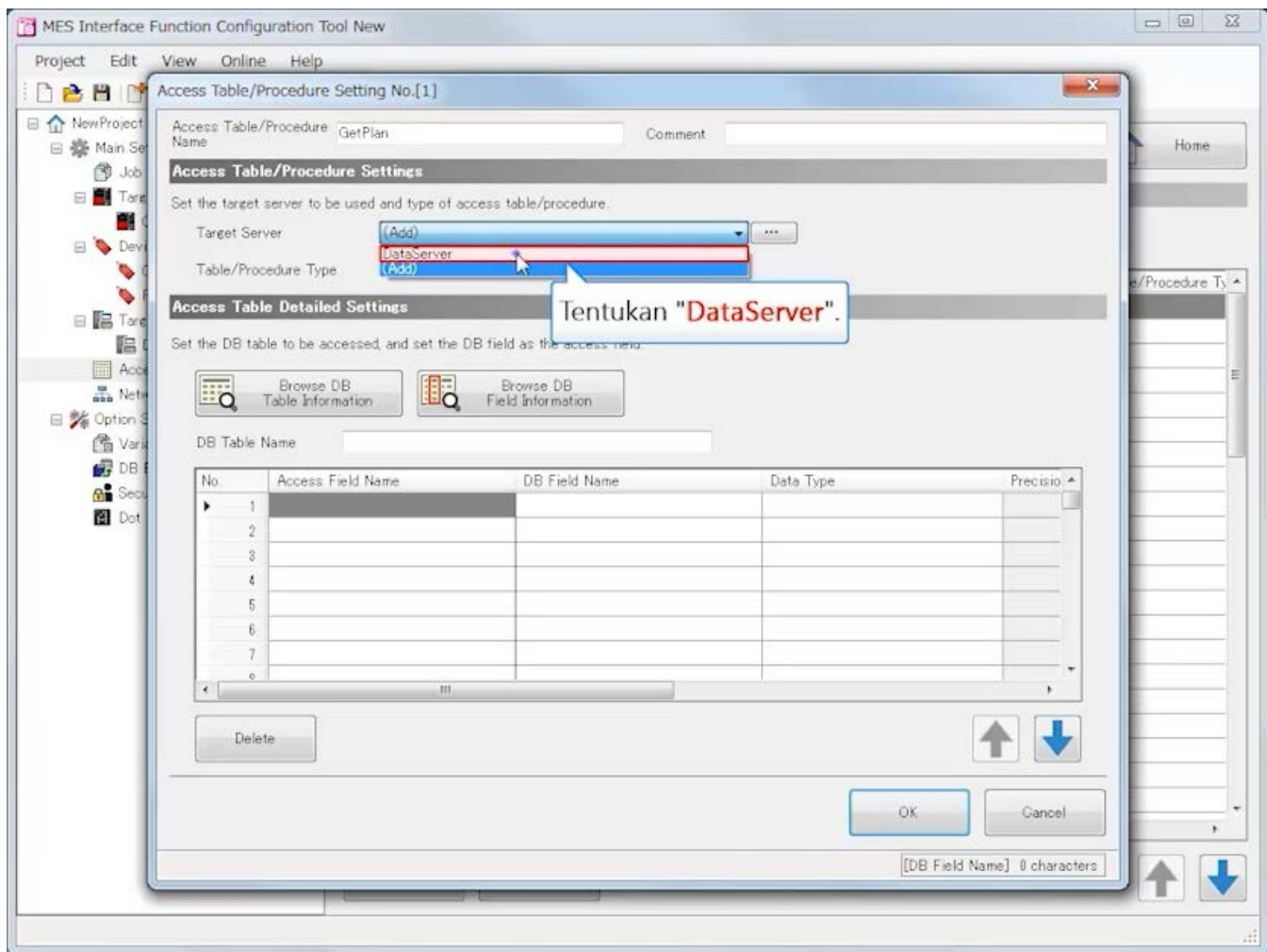
Kembali

Berikutnya



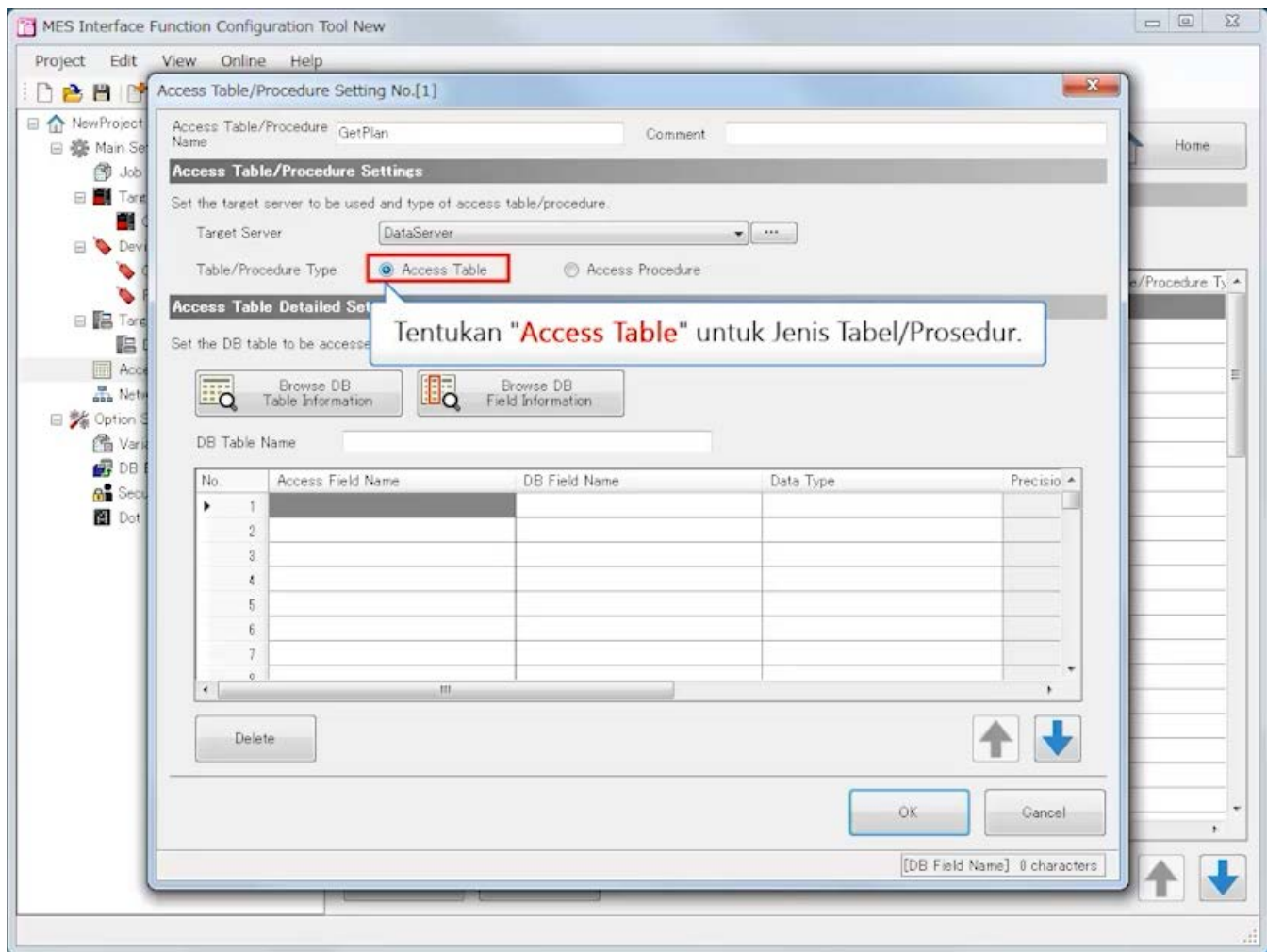
Kembali

Berikutnya



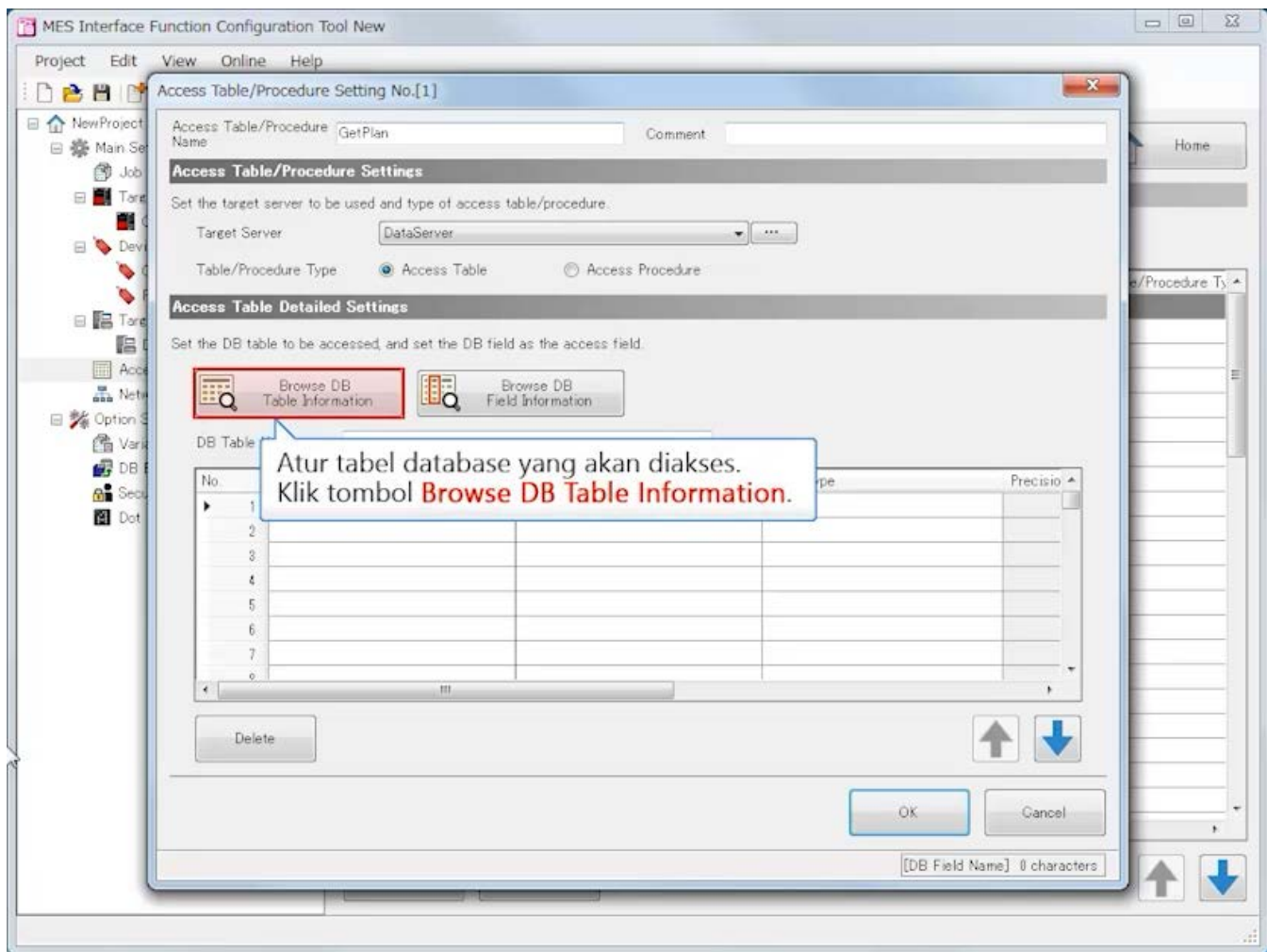
Kembali

Berikutnya



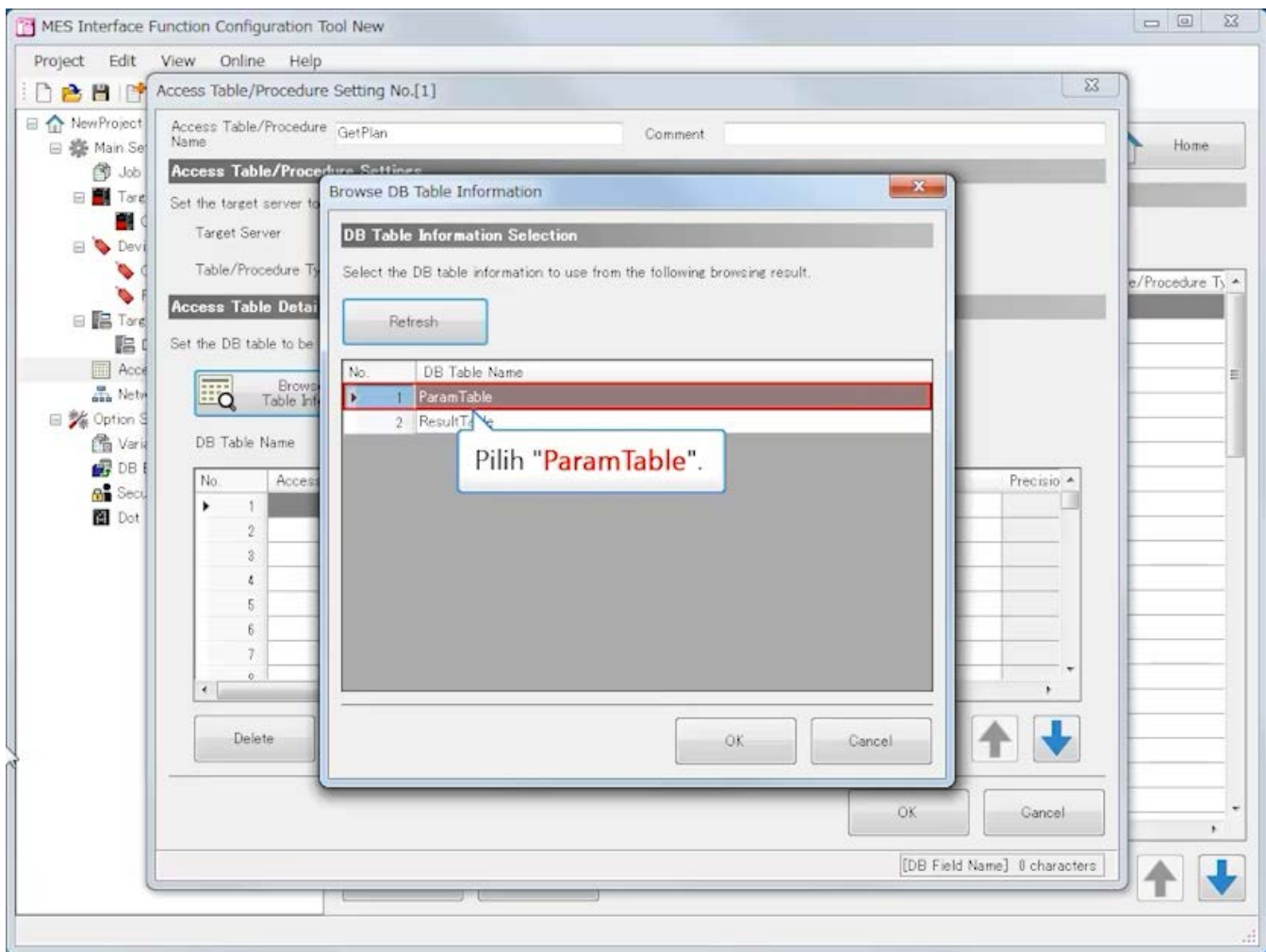
Kembali

Berikutnya



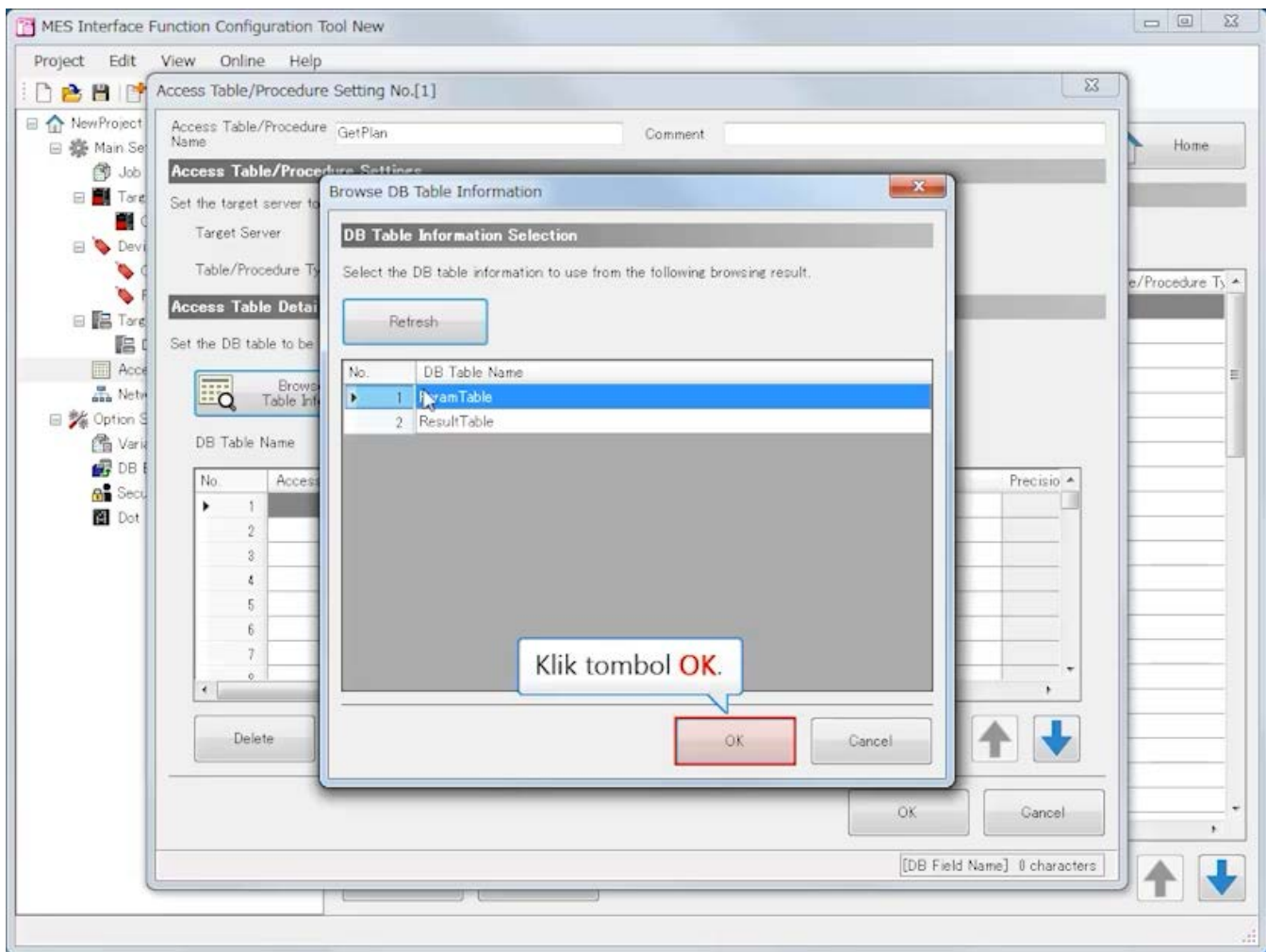
Kembali

Berikutnya



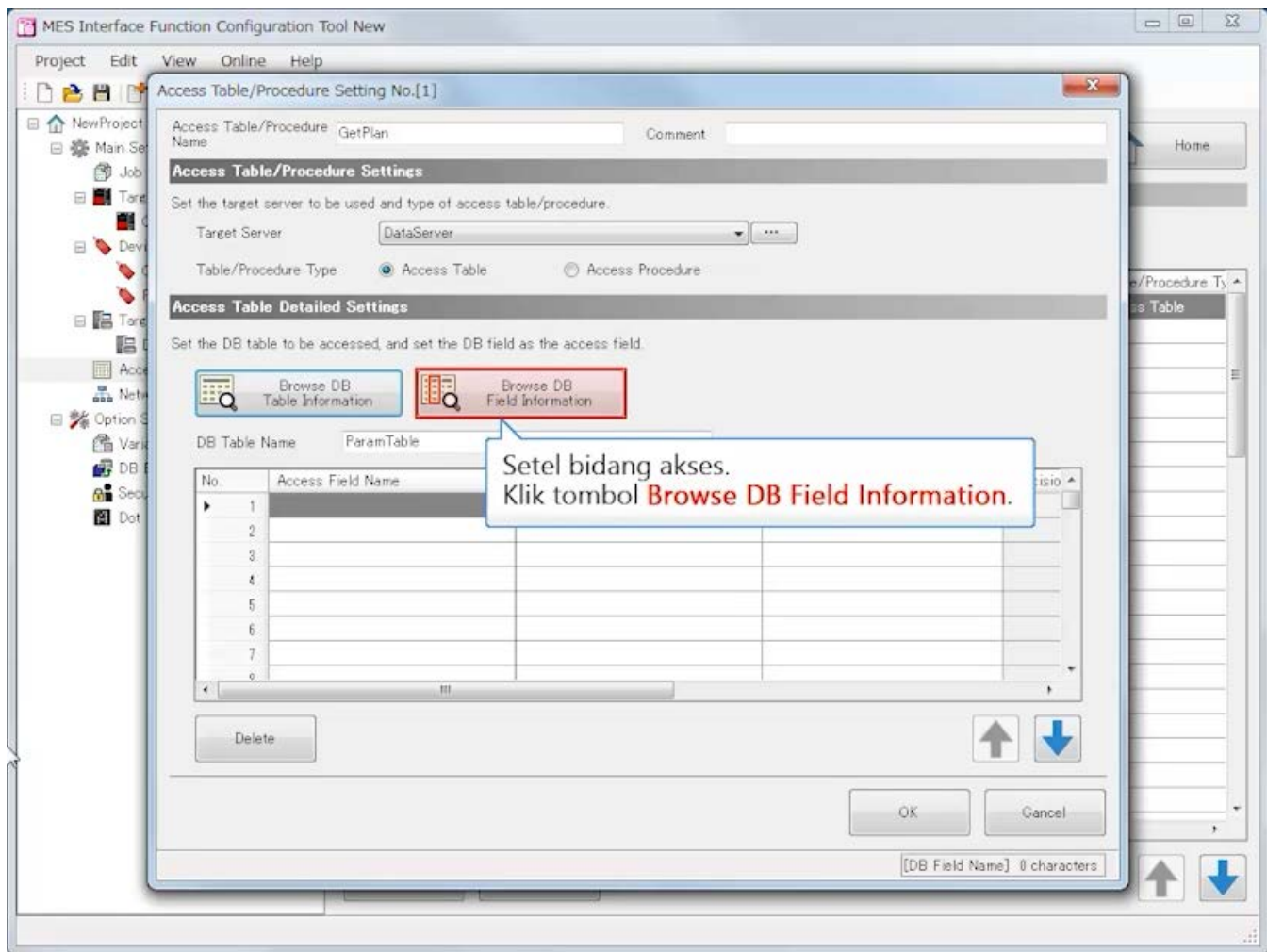
Kembali

Berikutnya



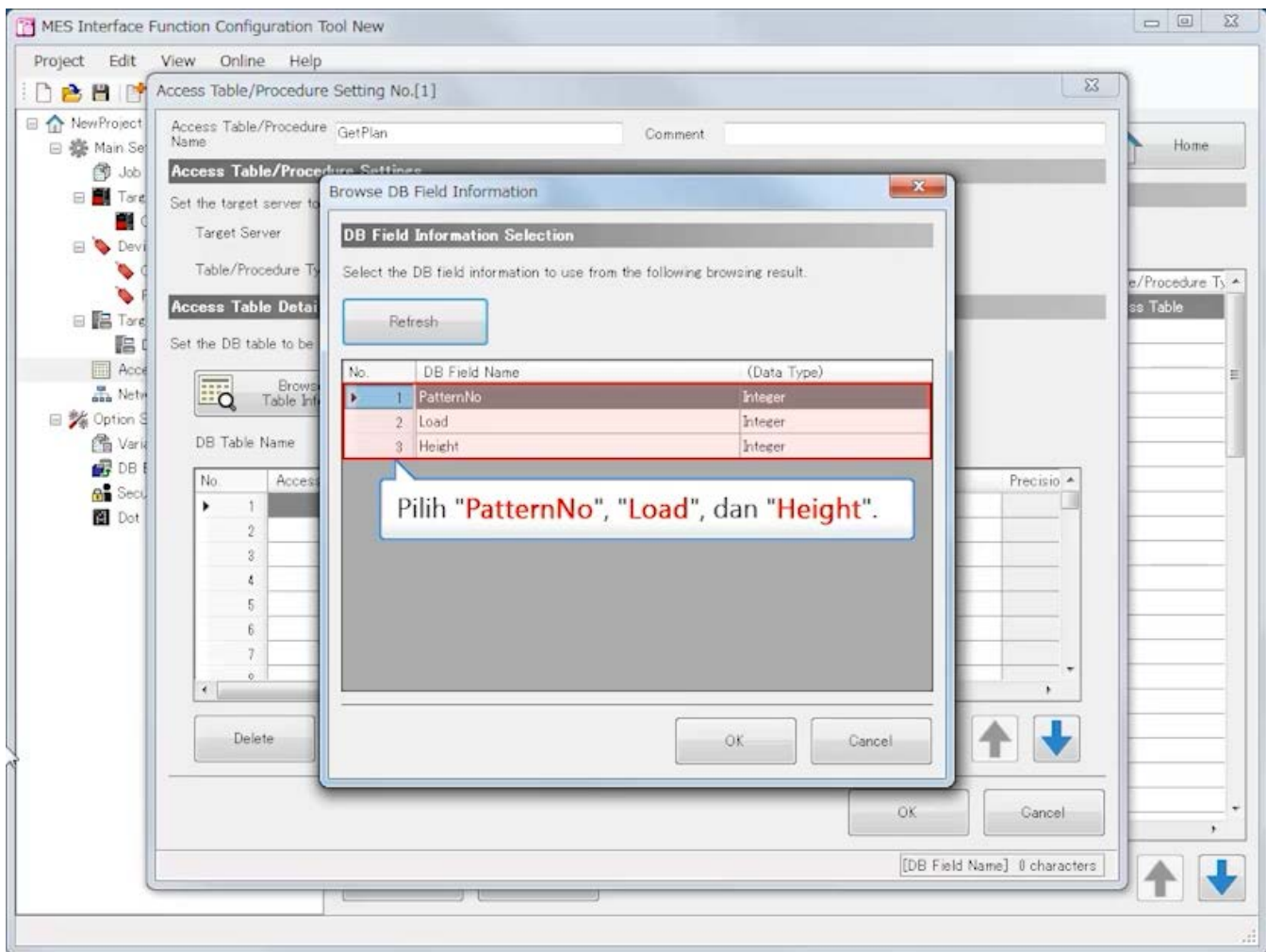
Kembali

Berikutnya



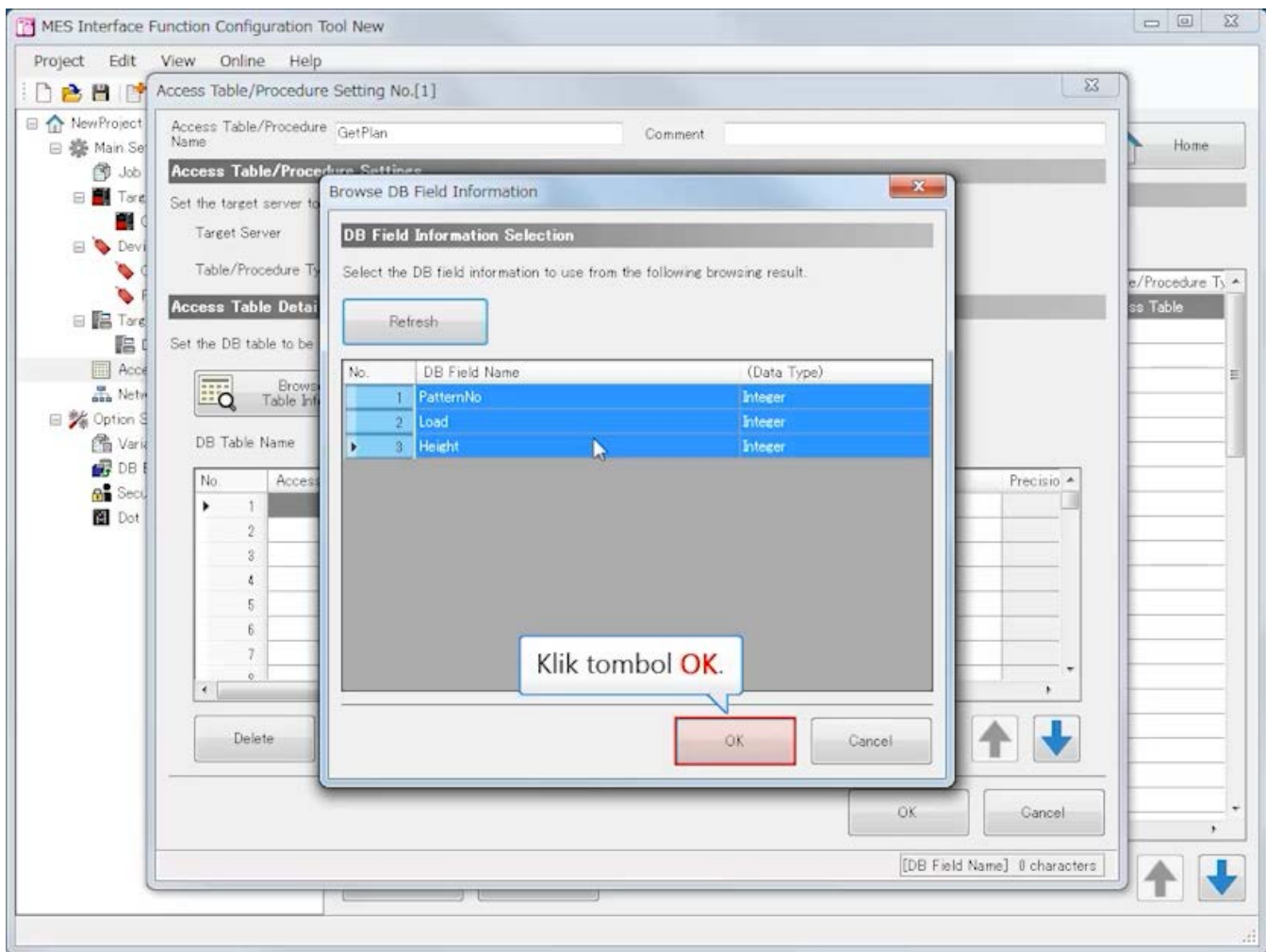
Kembali

Berikutnya



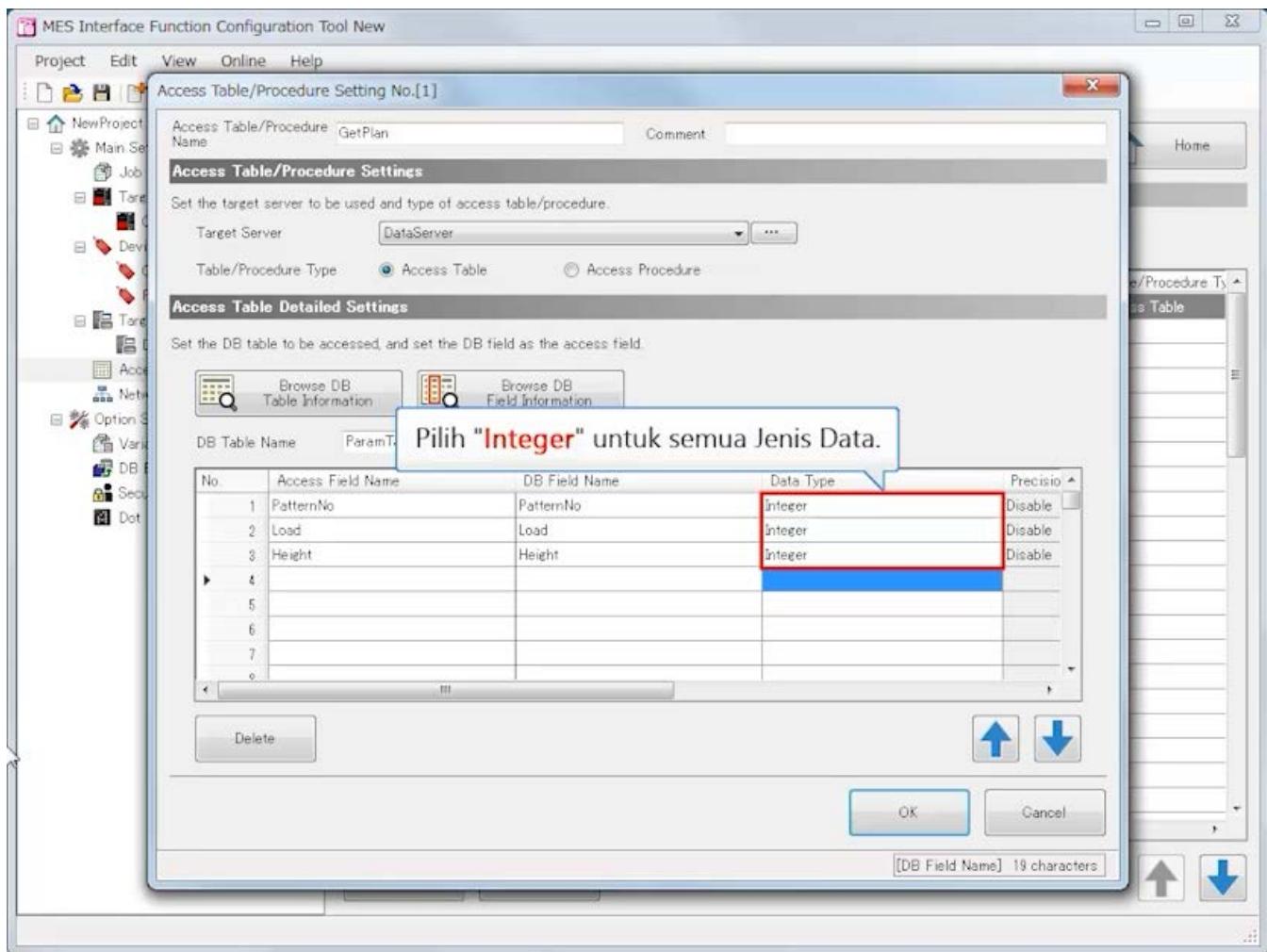
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

MES Interface Function Configuration Tool New

Project Edit View Online Help

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	Precisio
1	PatternNo	PatternNo	Integer	Disable
2	Load	Load	Integer	Disable
3	Height	Height	Integer	Disable
4				
5				
6				
7				
8				

Delete

Sekarang, semua item terdaftar. Klik tombol OK.

OK Cancel

[DB Field Name] 19 characters

Kembali

Berikutnya

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

DataSetter

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		DataSetter	Access Table
2				
3				
4				
5				
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7				
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11				
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18				
19				
20				
21				

Edit

Delete

Pengaturan tabel/prosedur akses, "GetPlan" selesai.

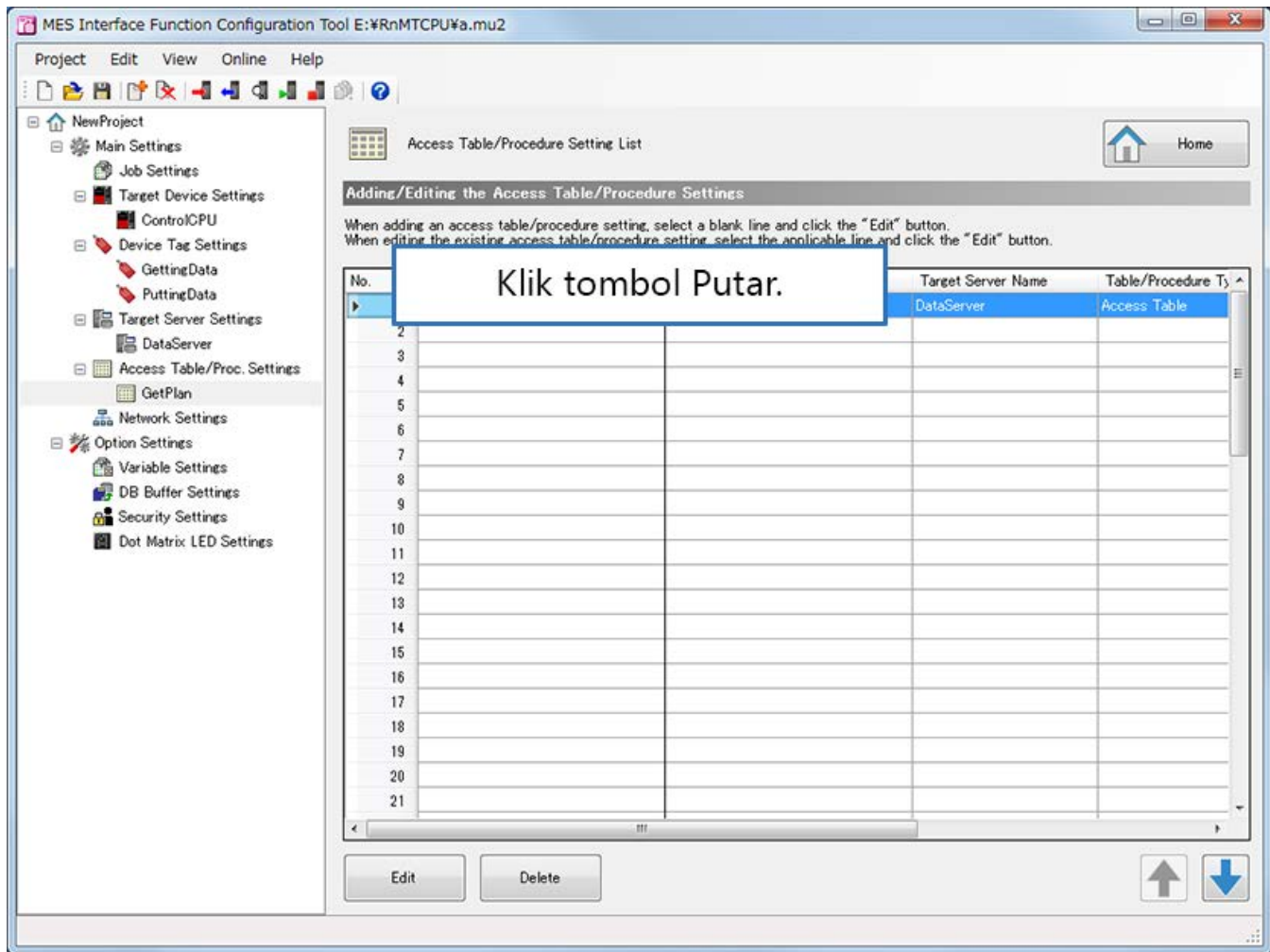
Klik

>

 untuk melanjutkan ke halaman berikutnya.

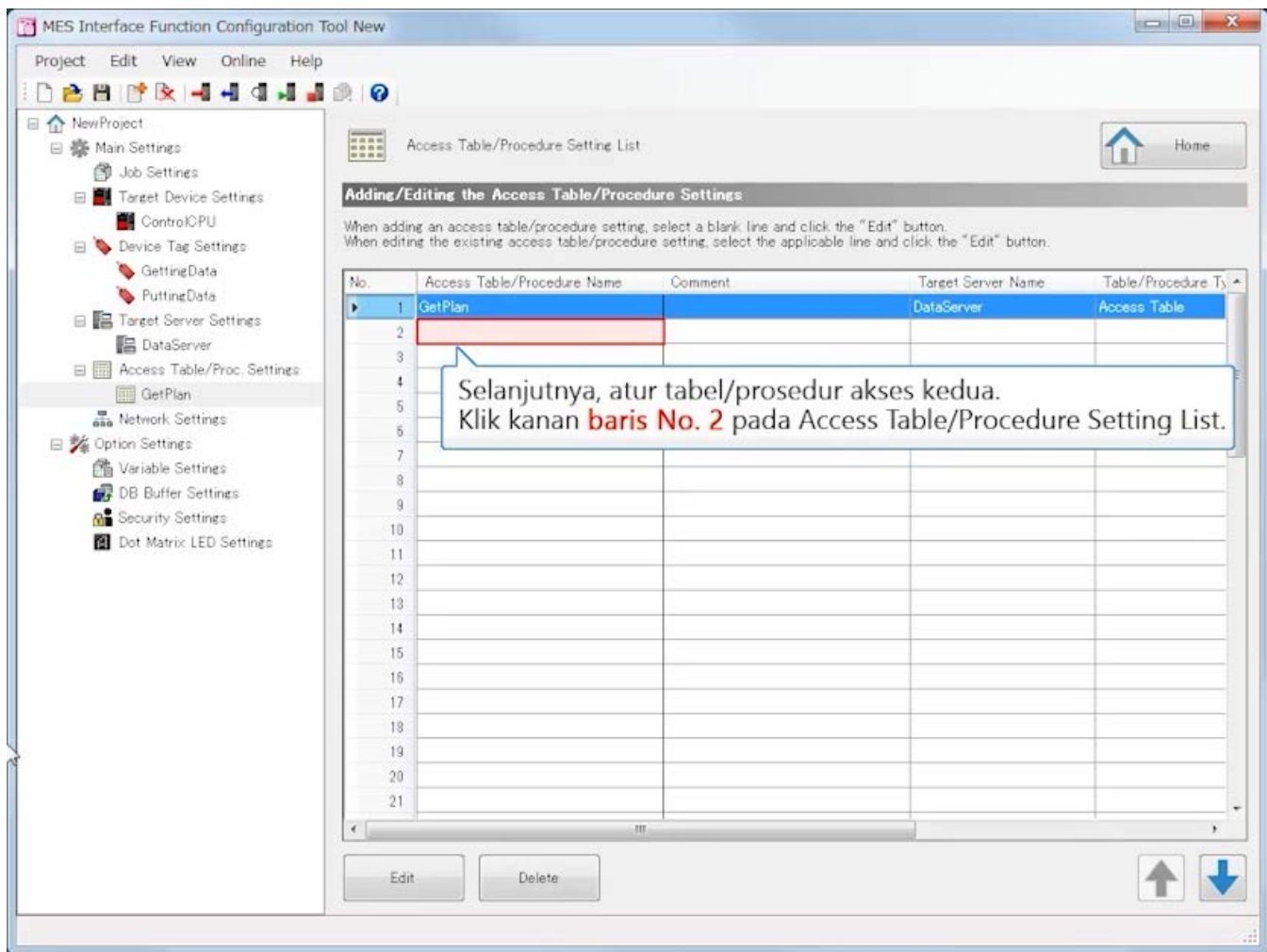
Kembali

Berikutnya



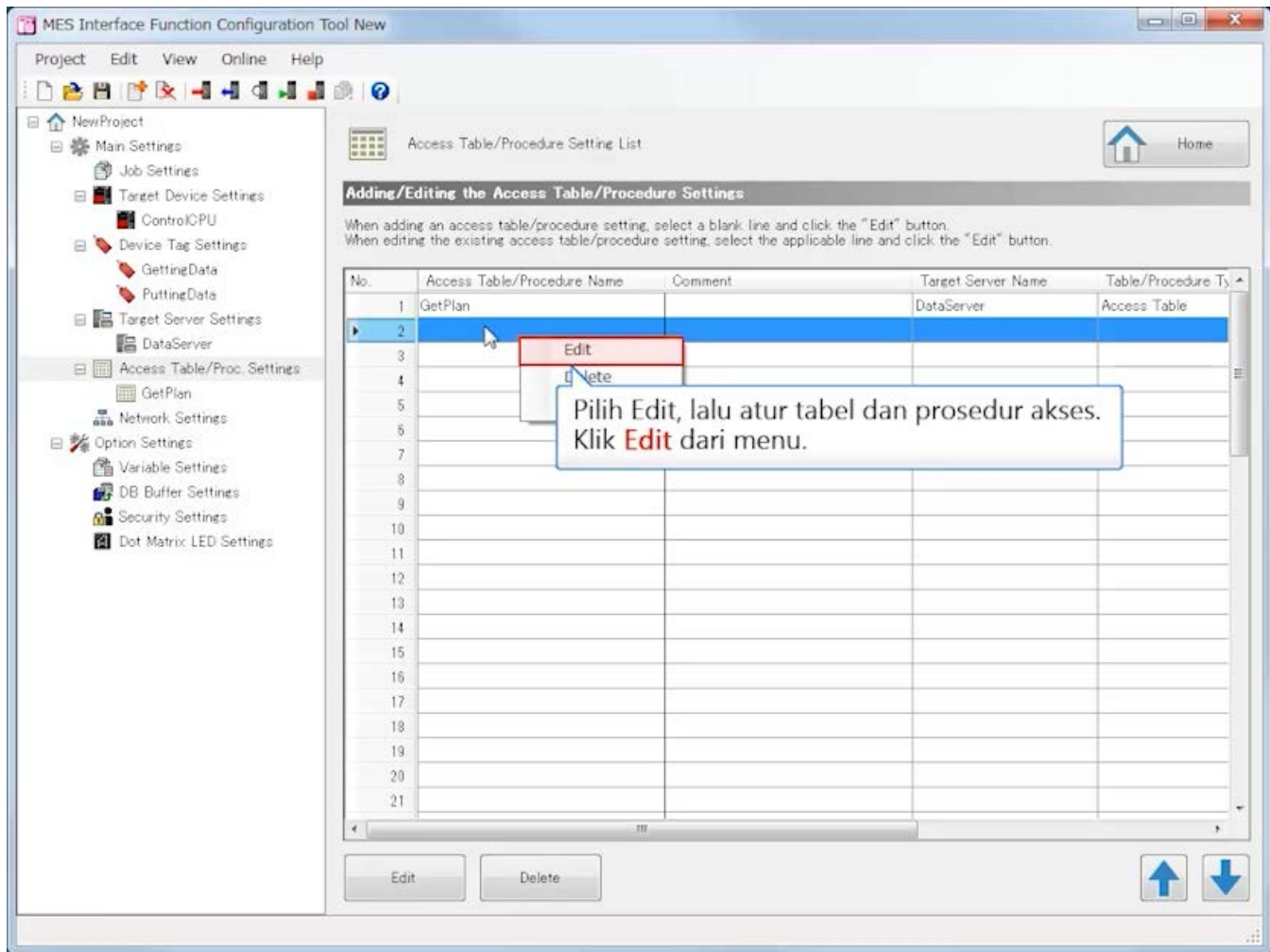
Kembali

Berikutnya



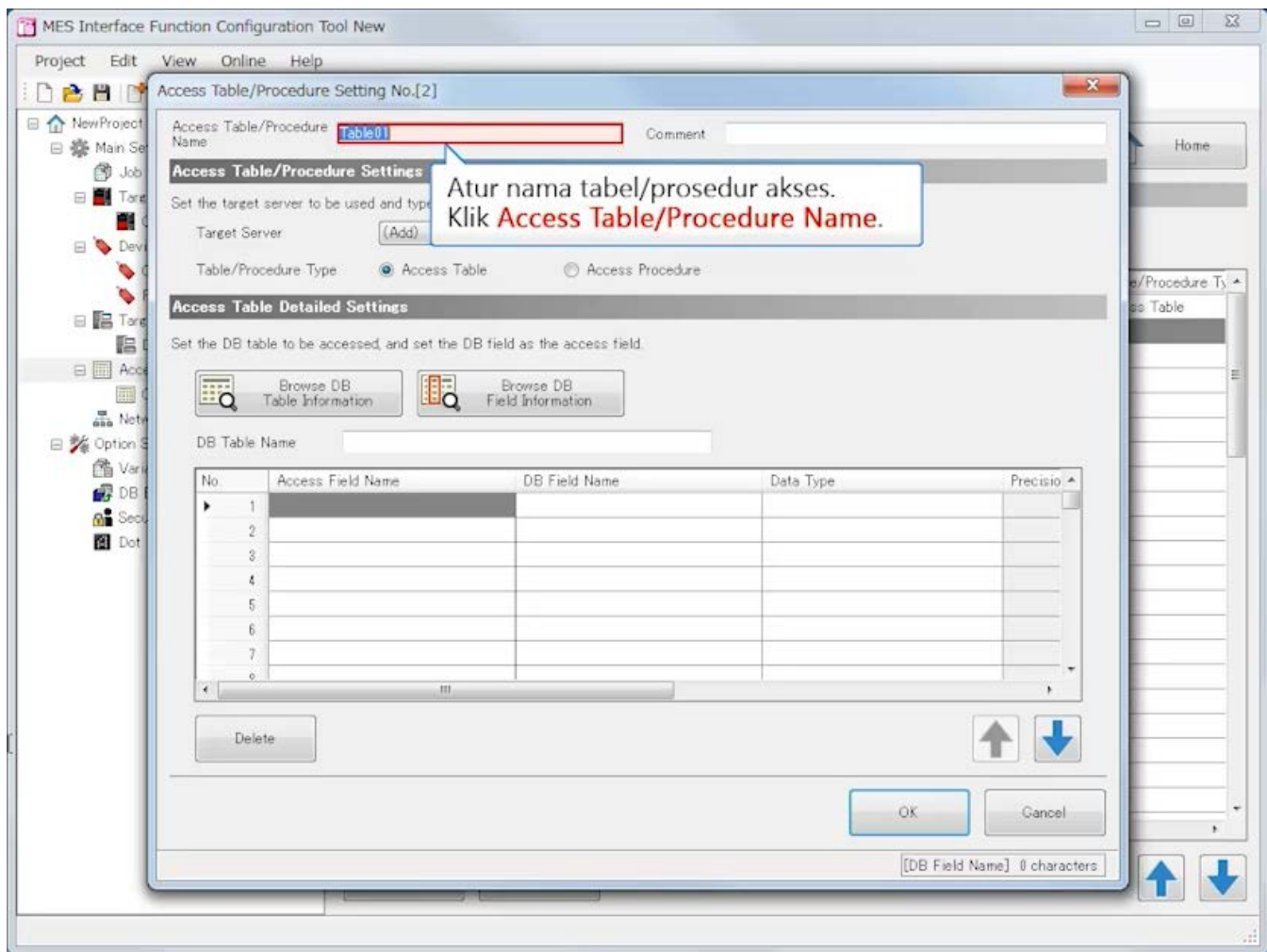
Kembali

Berikutnya



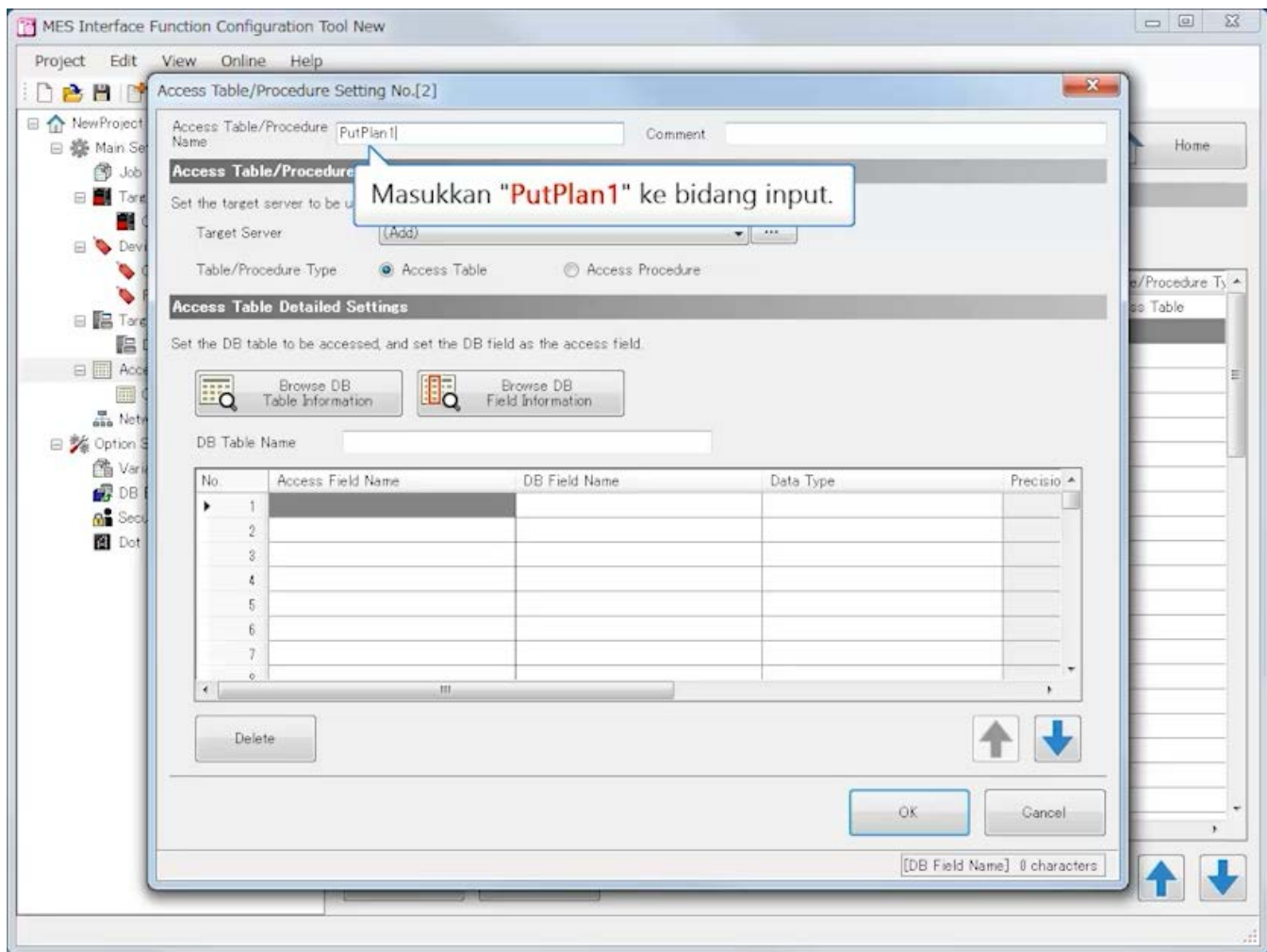
Kembali

Berikutnya



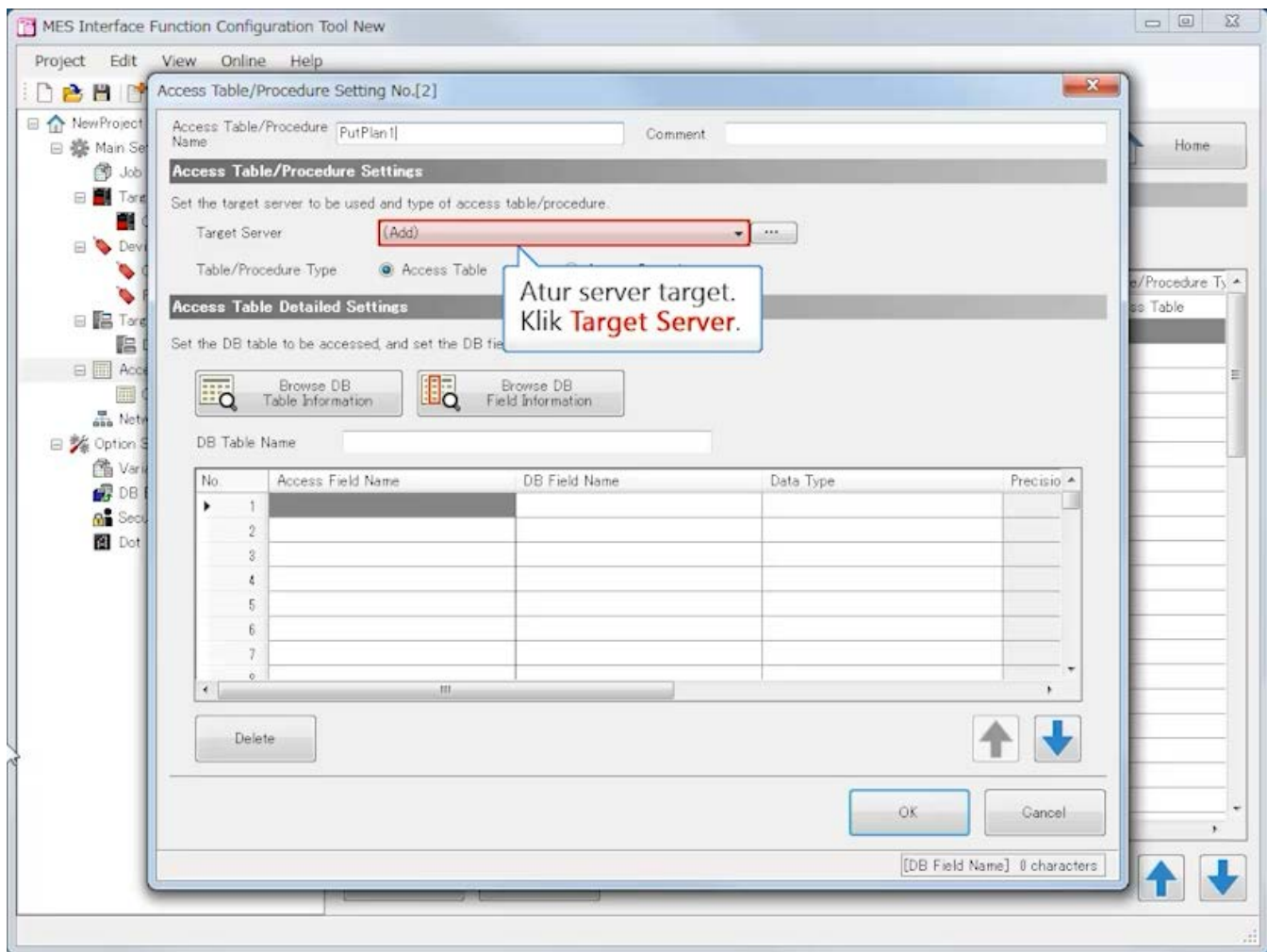
Kembali

Berikutnya



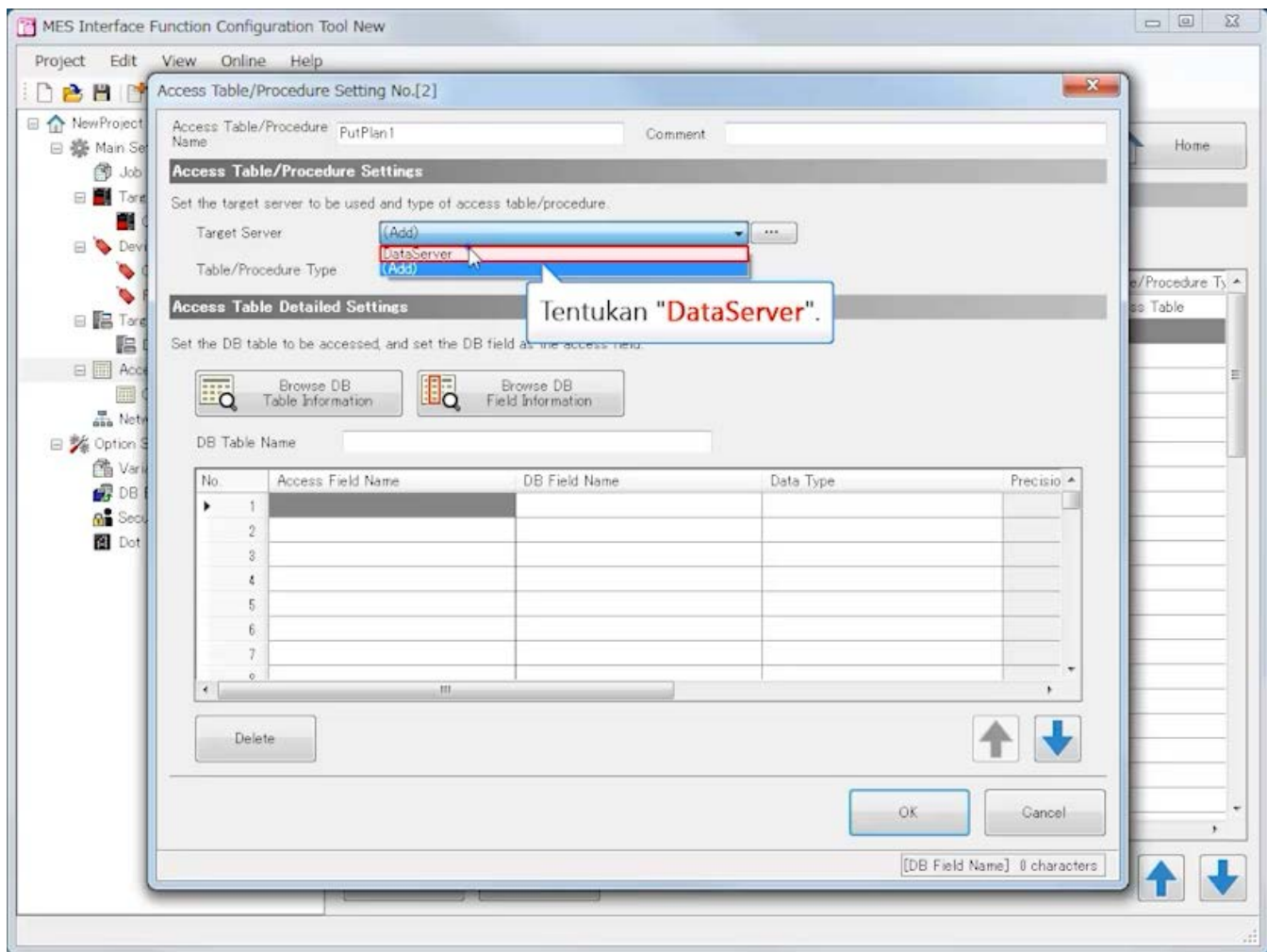
Kembali

Berikutnya



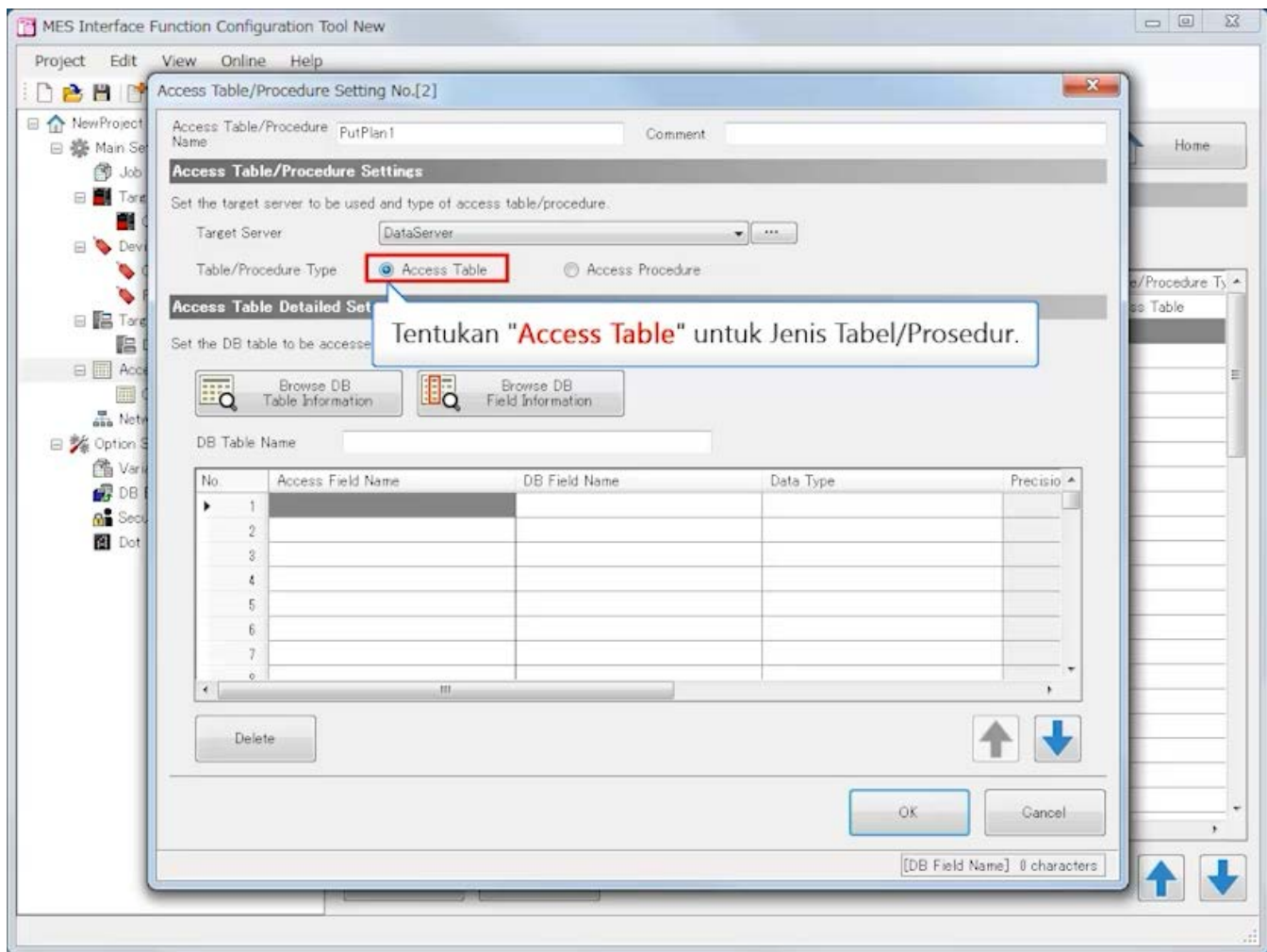
Kembali

Berikutnya



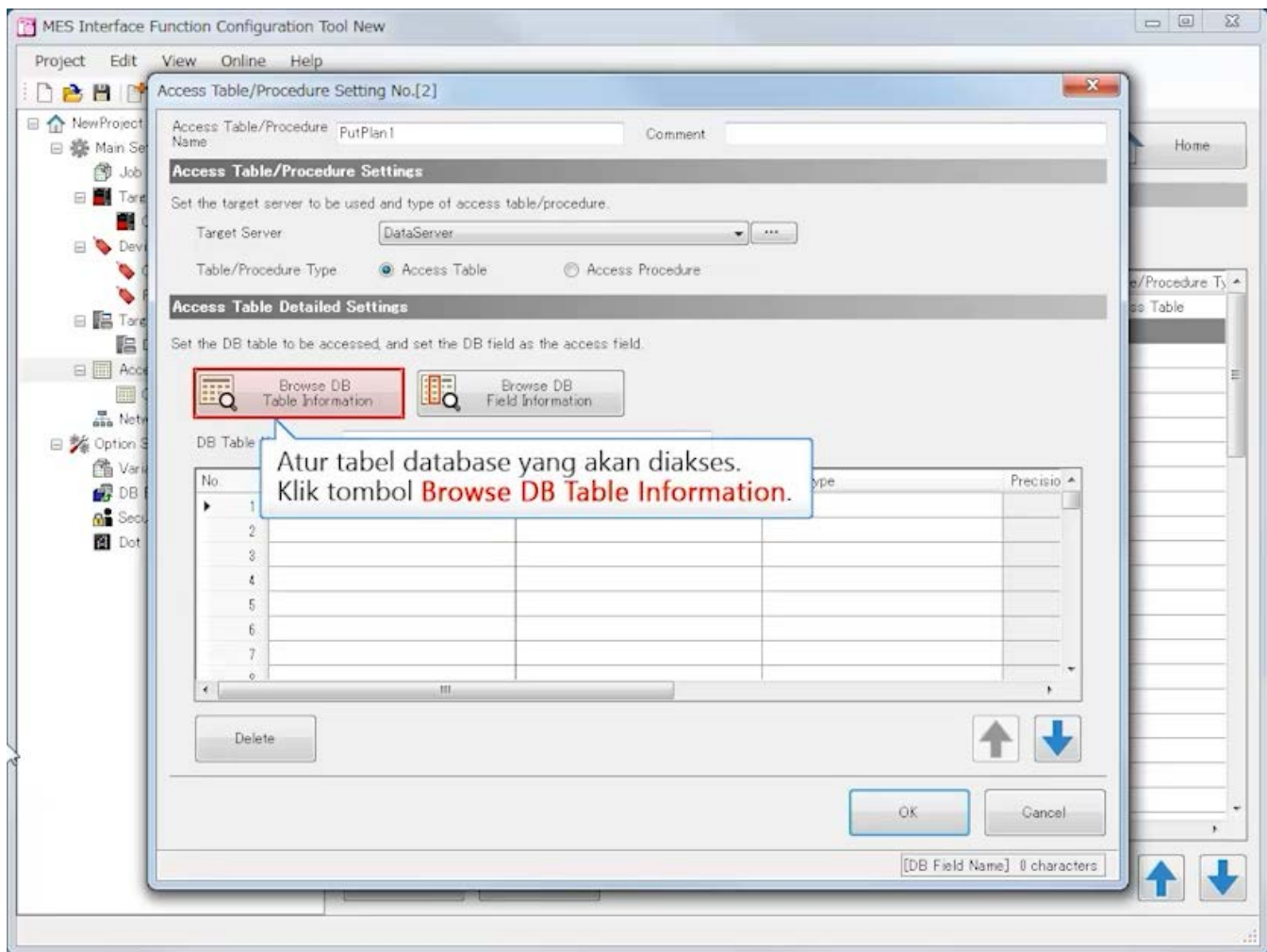
Kembali

Berikutnya



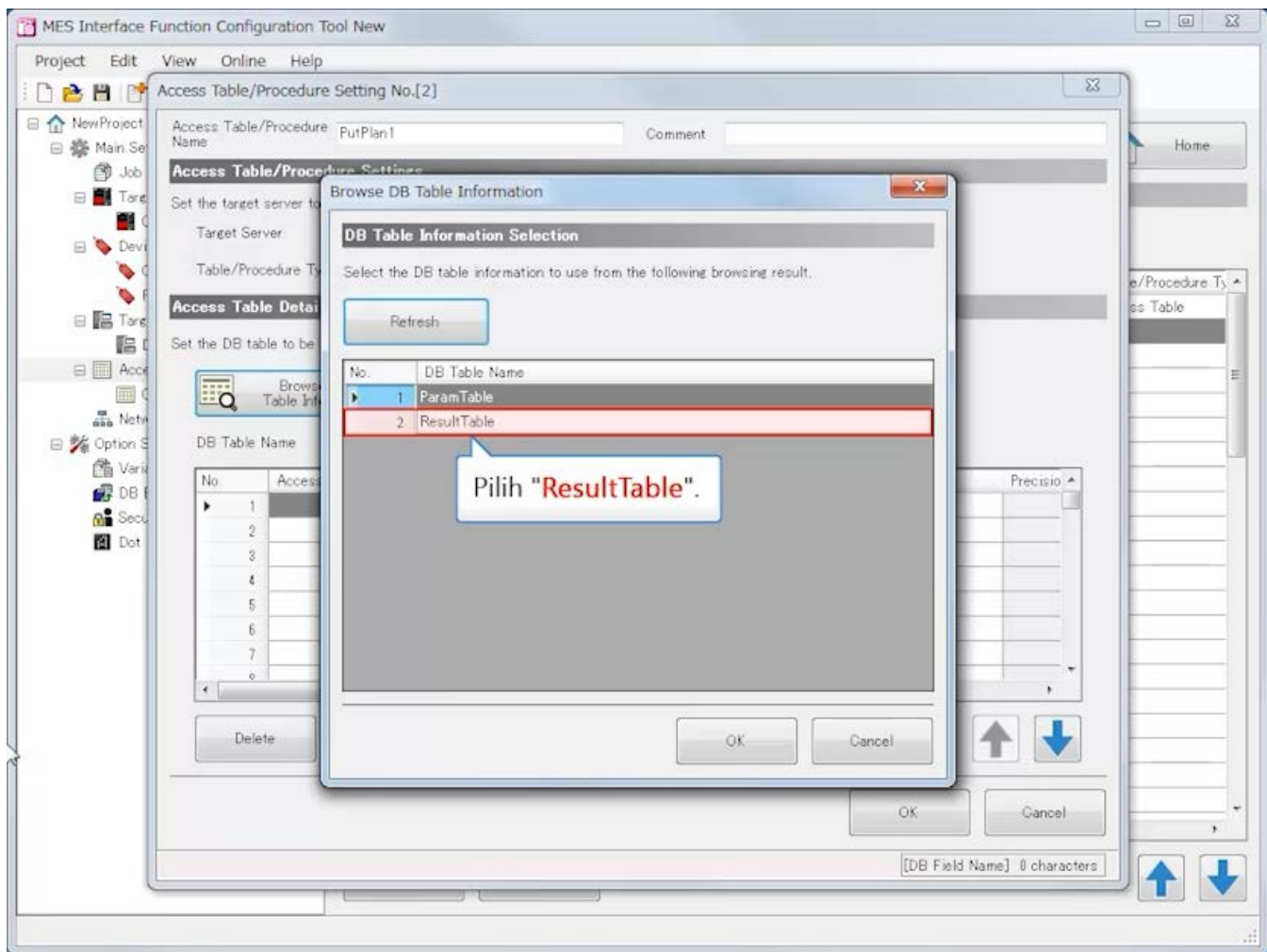
Kembali

Berikutnya



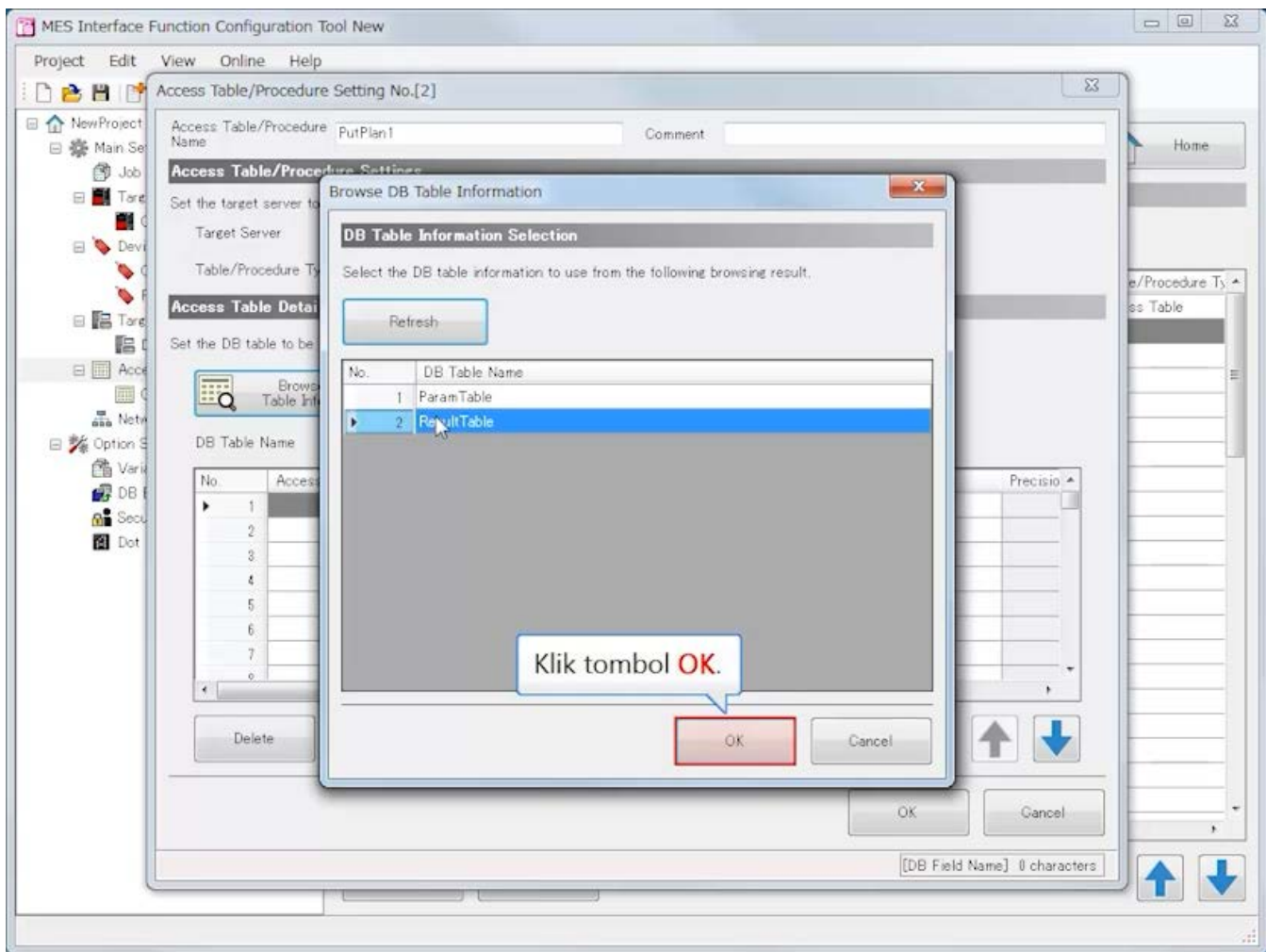
Kembali

Berikutnya



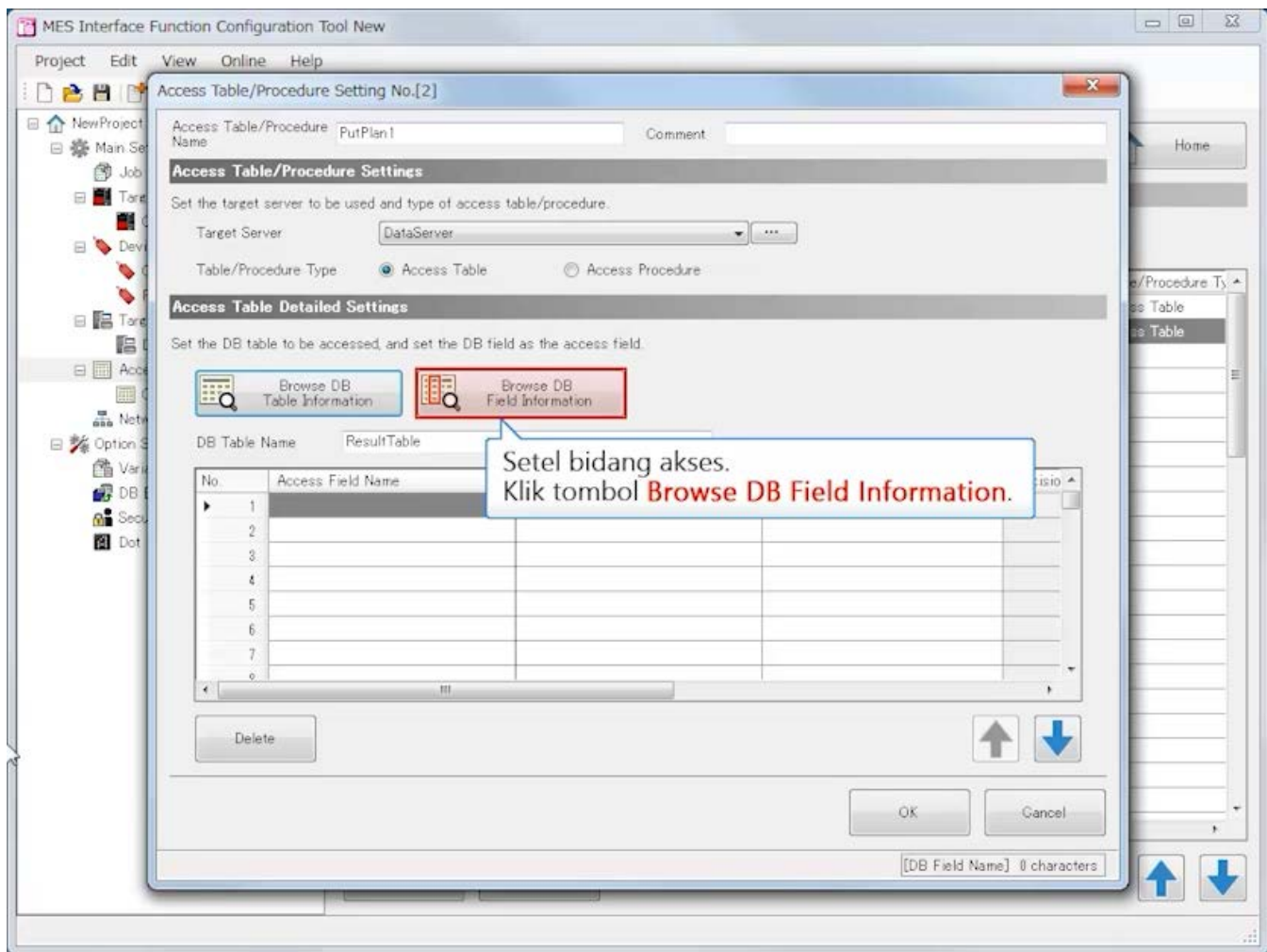
Kembali

Berikutnya



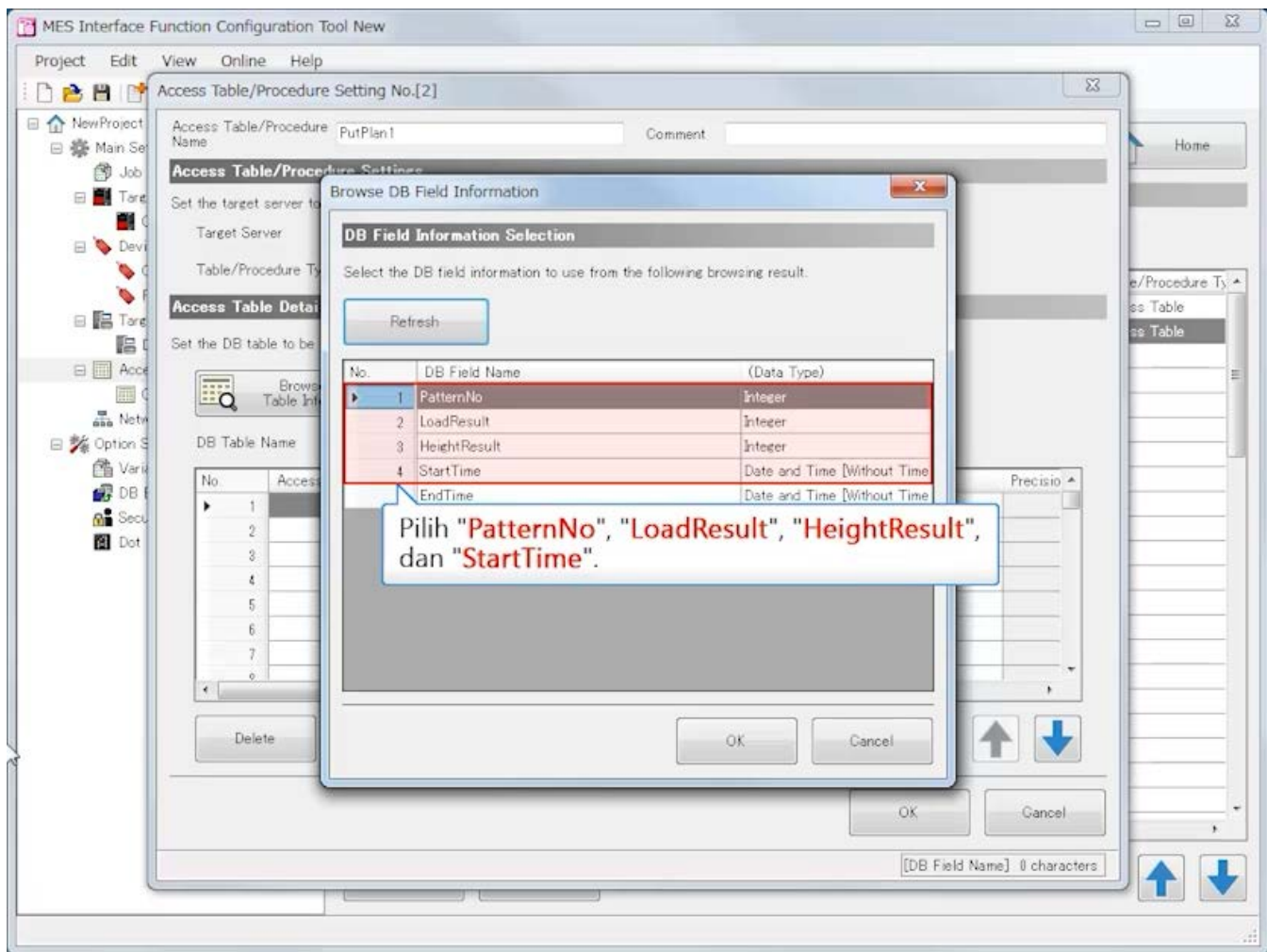
Kembali

Berikutnya



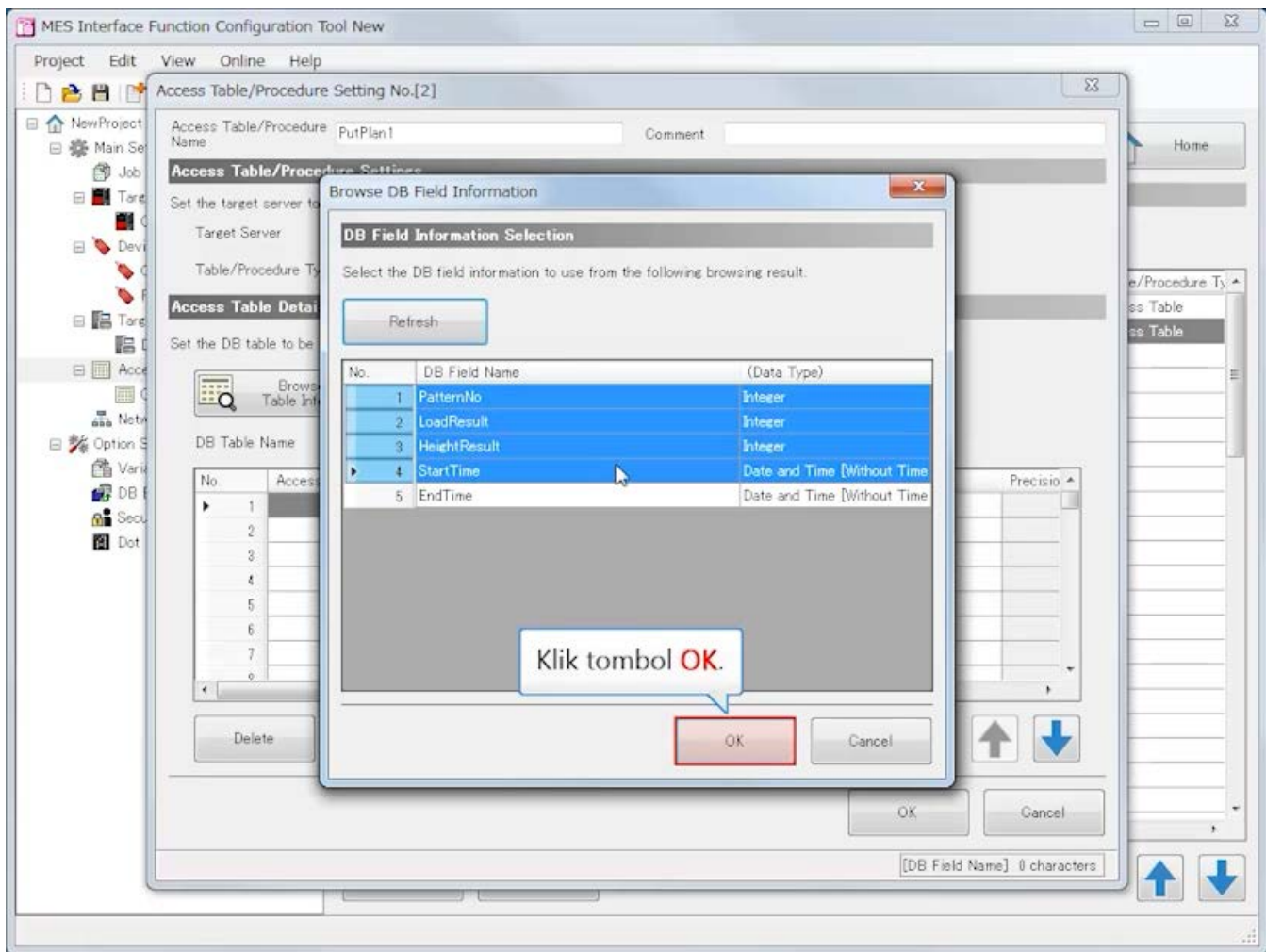
Kembali

Berikutnya



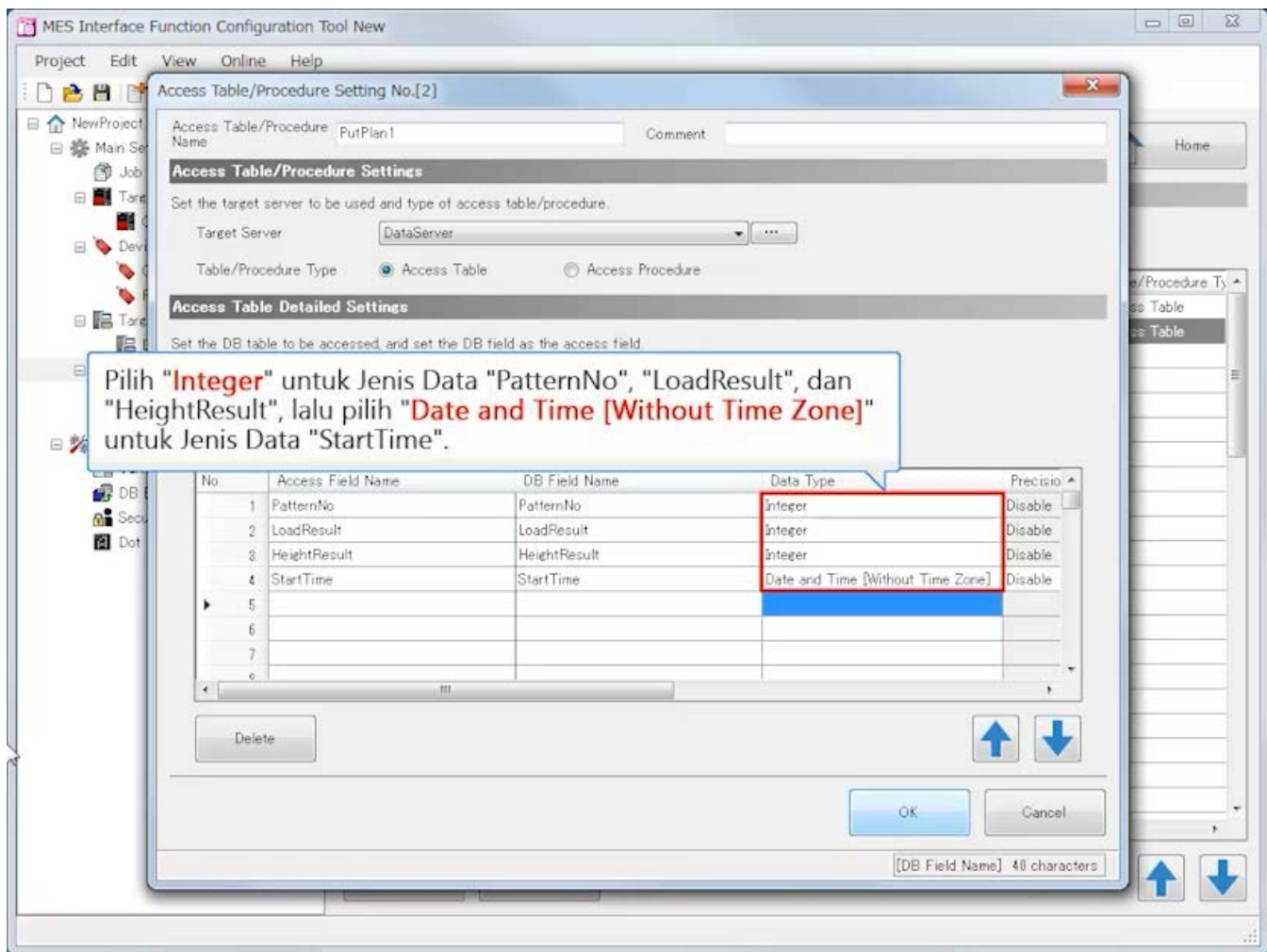
Kembali

Berikutnya



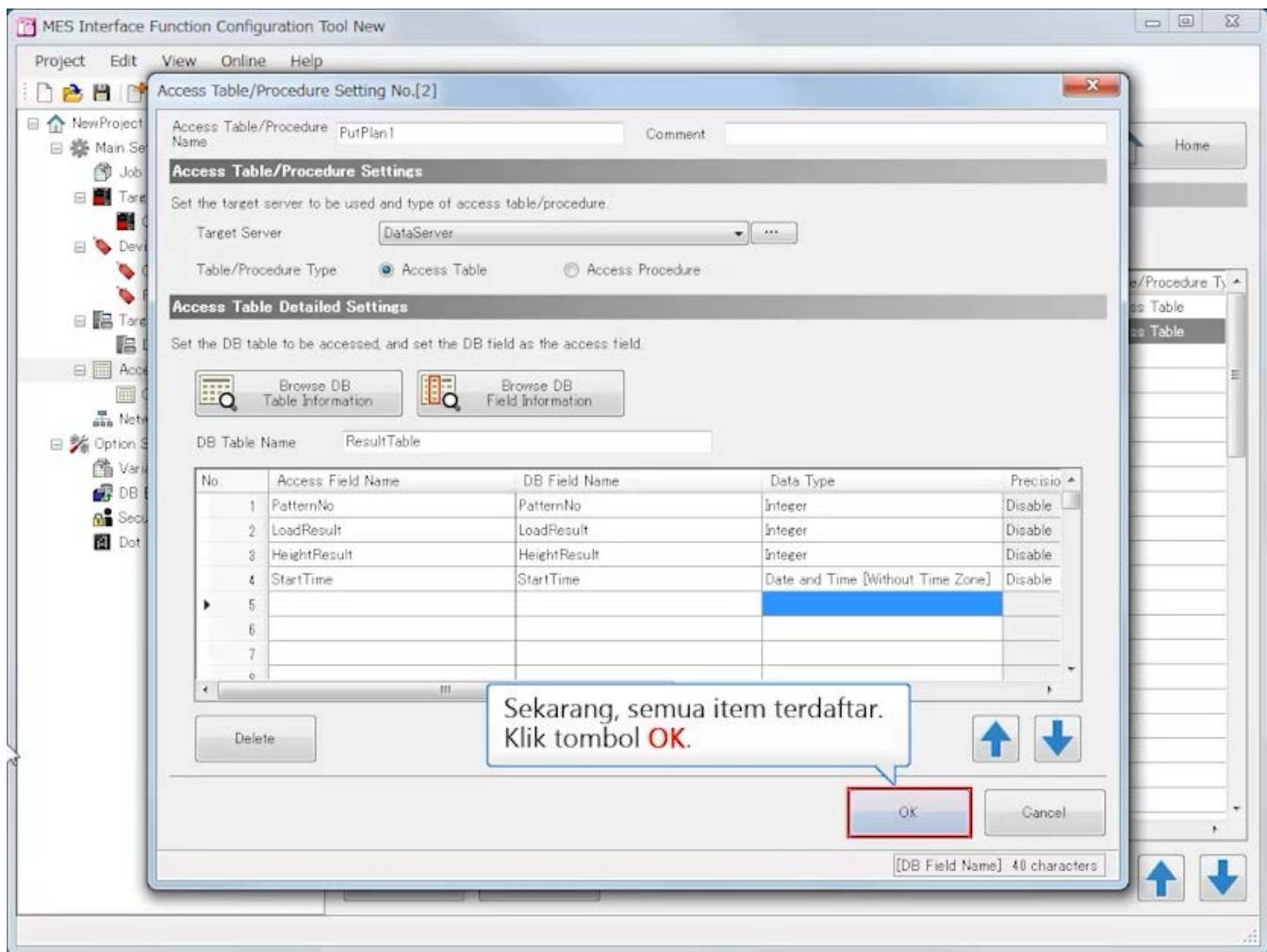
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

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 Ty
1	GetPlan		DataSource	Access Table
2	PutPlan1		DataSource	Access Table
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

Pengaturan tabel/prosedur akses, "PutPlan1" selesai.
Klik > untuk melanjutkan ke halaman berikutnya.

Kembali

Berikutnya

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

Project Edit View Online Help

NewProject

- Main Settings
 - Job Settings
 - ControlCPU
 - Device Tag Settings
 - GettingData
 - PuttingData
 - Target Device Settings
 - ControlCPU
 - Target Server Settings
 - DataSetter
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlanI
- 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	PutPlanI	DataSetter	Access Table
3			
4			
5			
6			
7			
8			
9			
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19			
20			
21			

Klik tombol Putar.

Edit Delete

Up Down

Kembali

Berikutnya

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
 - DataSeter
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlan1
 - 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		DataSeter	Access Table
2	PutPlan1		DataSeter	Access Table
3				
4				
5				
6				
7				
8				
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21				

Selanjutnya, atur tabel/prosedur akses ketiga.
Klik kanan **baris No. 3** pada Access Table/Procedure Setting List.

Edit Delete

Up Down

Kembali

Berikutnya

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
 - DataSetter
 - Access Table/Proc. Settings
 - GetPlan
 - PutPlanI
 - 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		DataSetter	Access Table
2	PutPlanI		DataSetter	Access Table
3				
4				
5				
6				
7				
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9				
10				
11				
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18				
19				
20				
21				

Edit
Delete
Add C

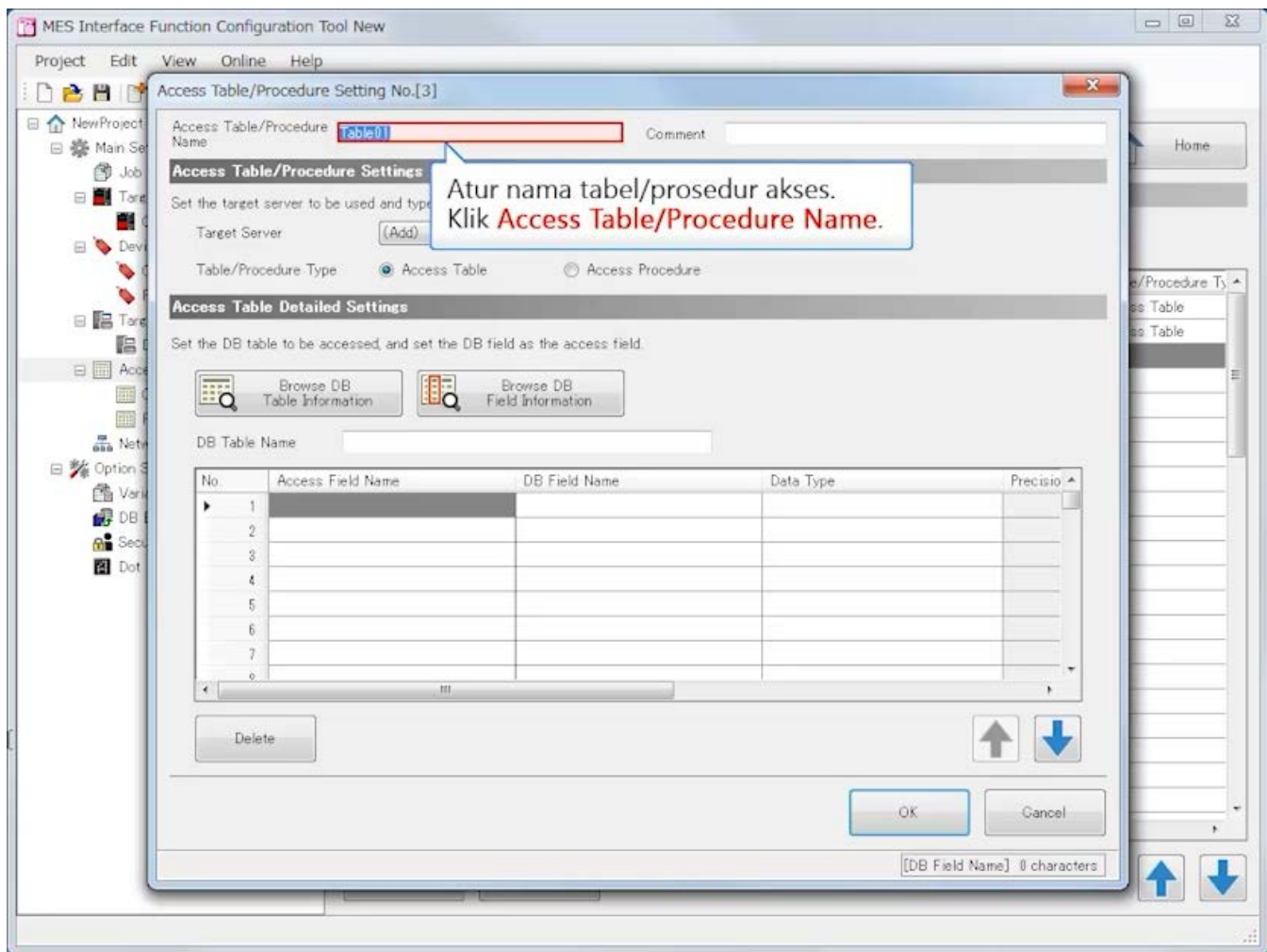
Pilih Edit, lalu atur tabel dan prosedur akses.
Klik **Edit** dari menu.

Edit Delete

Up Down

Kembali

Berikutnya



Kembali

Berikutnya

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[3]

Access Table/Procedure Name: PutPlan2 Comment:

Set the target server to be used.

Target Server: (Add) ...

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:

No.	Access Field Name	DB Field Name	Data Type	Precision
1				
2				
3				
4				
5				
6				
7				
8				

Delete

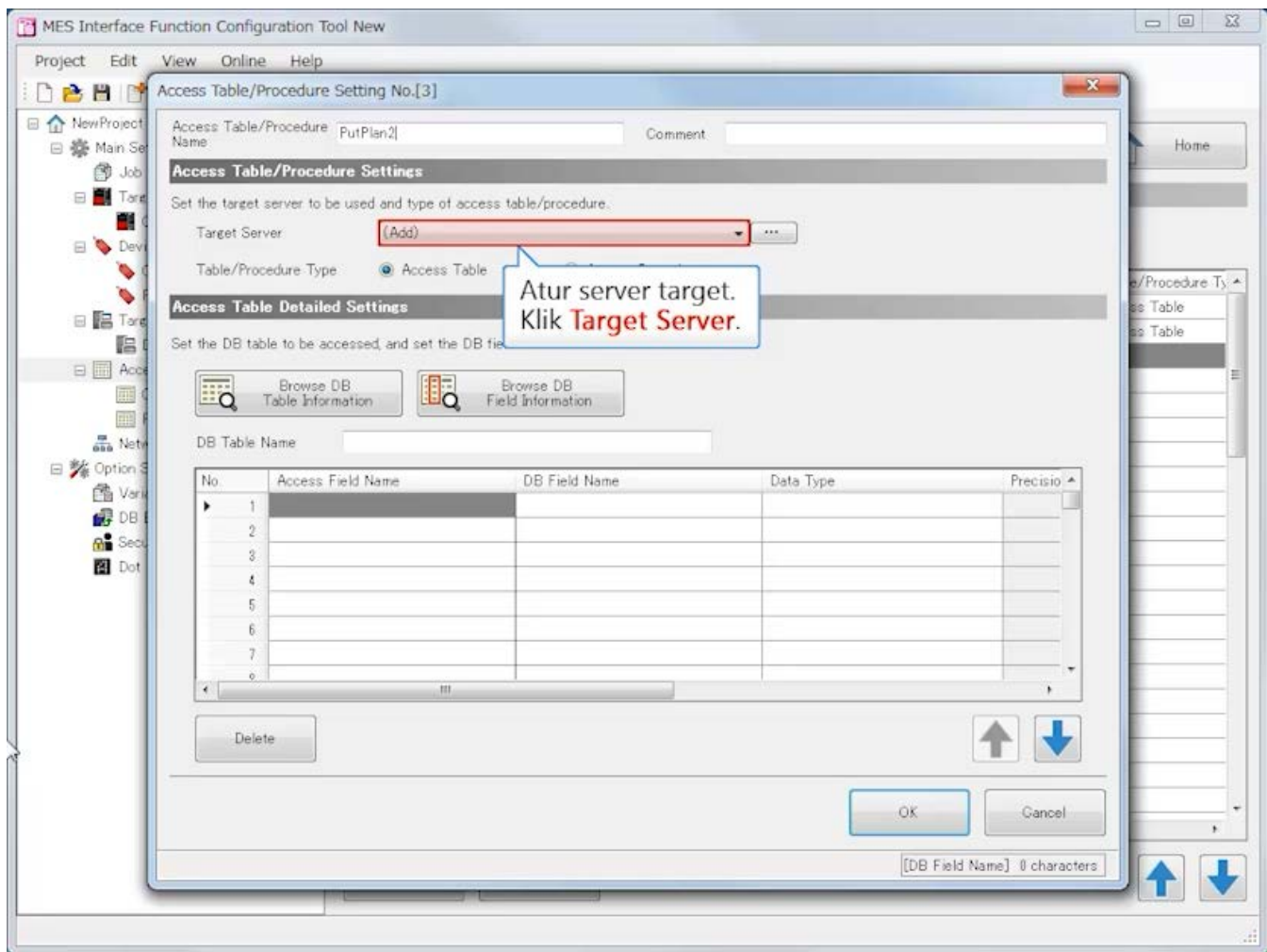
OK Cancel

[DB Field Name] 0 characters

Masukkan "PutPlan2" ke bidang input.

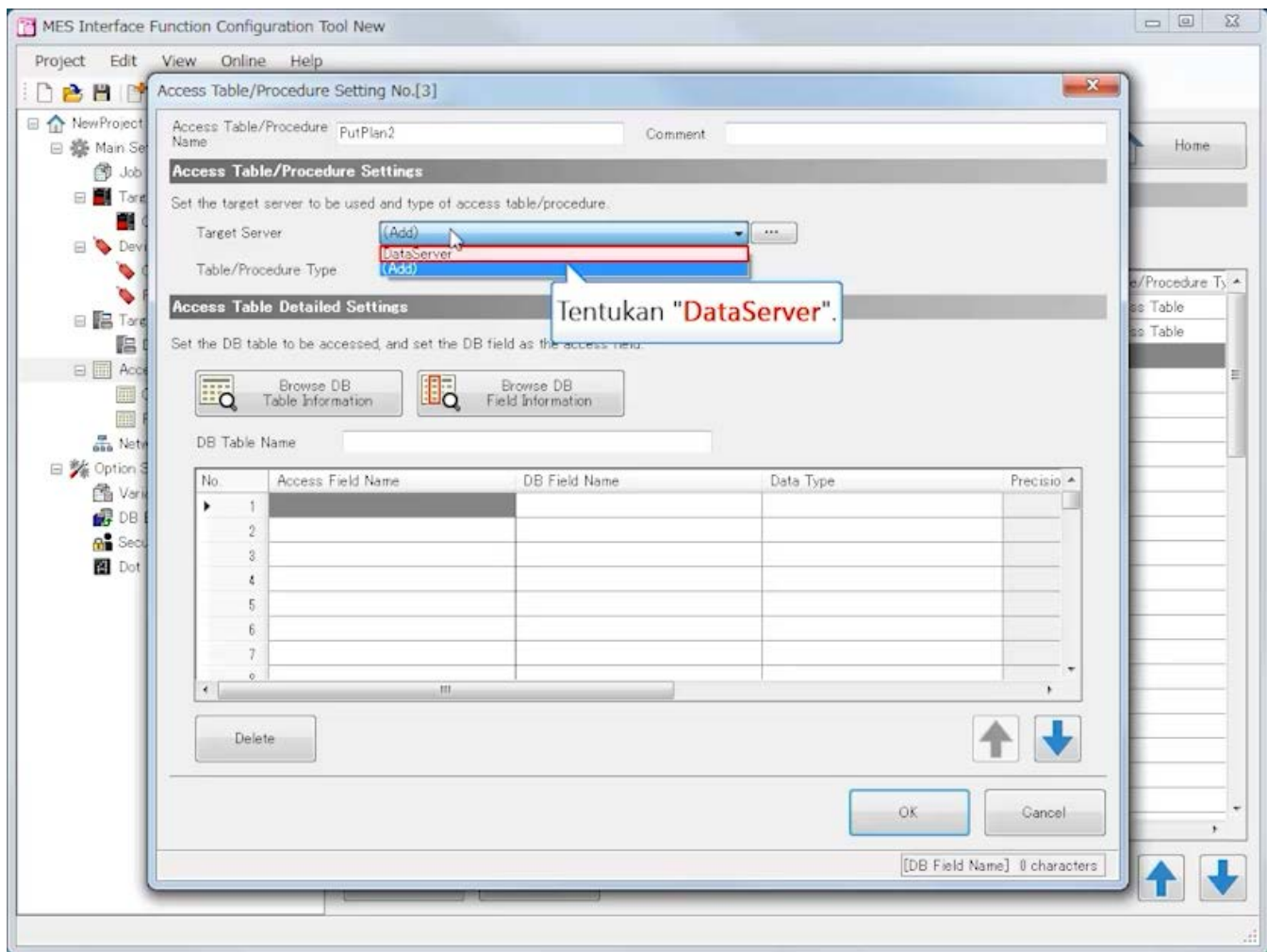
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

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 Set

Set the DB table to be accessed

Browse DB Table Information Browse DB Field Information

DB Table Name:

No.	Access Field Name	DB Field Name	Data Type	Precision
1				
2				
3				
4				
5				
6				
7				
8				

Delete

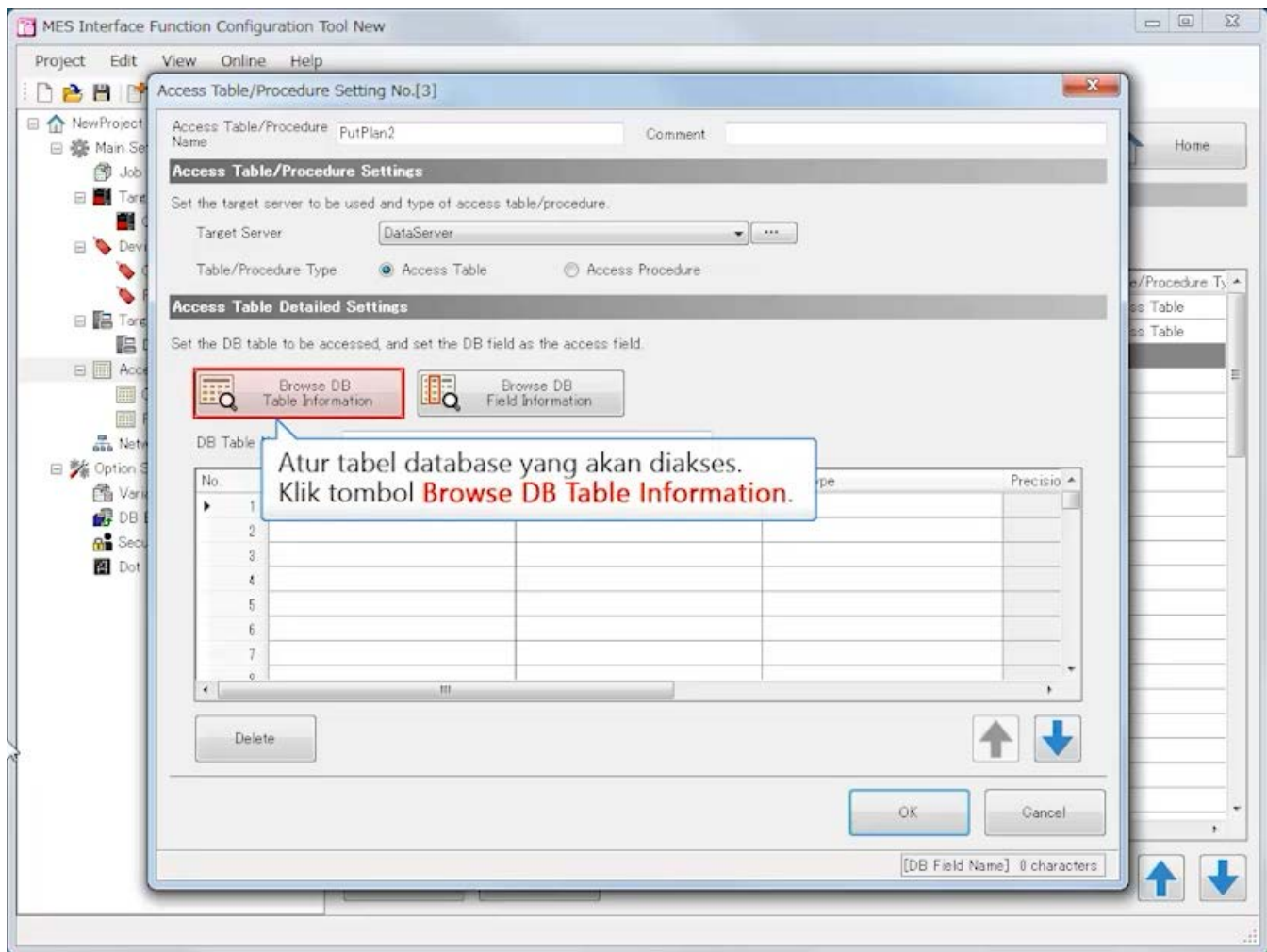
OK Cancel

[DB Field Name] 8 characters

Tentukan "Access Table" untuk Jenis Tabel/Prosedur.

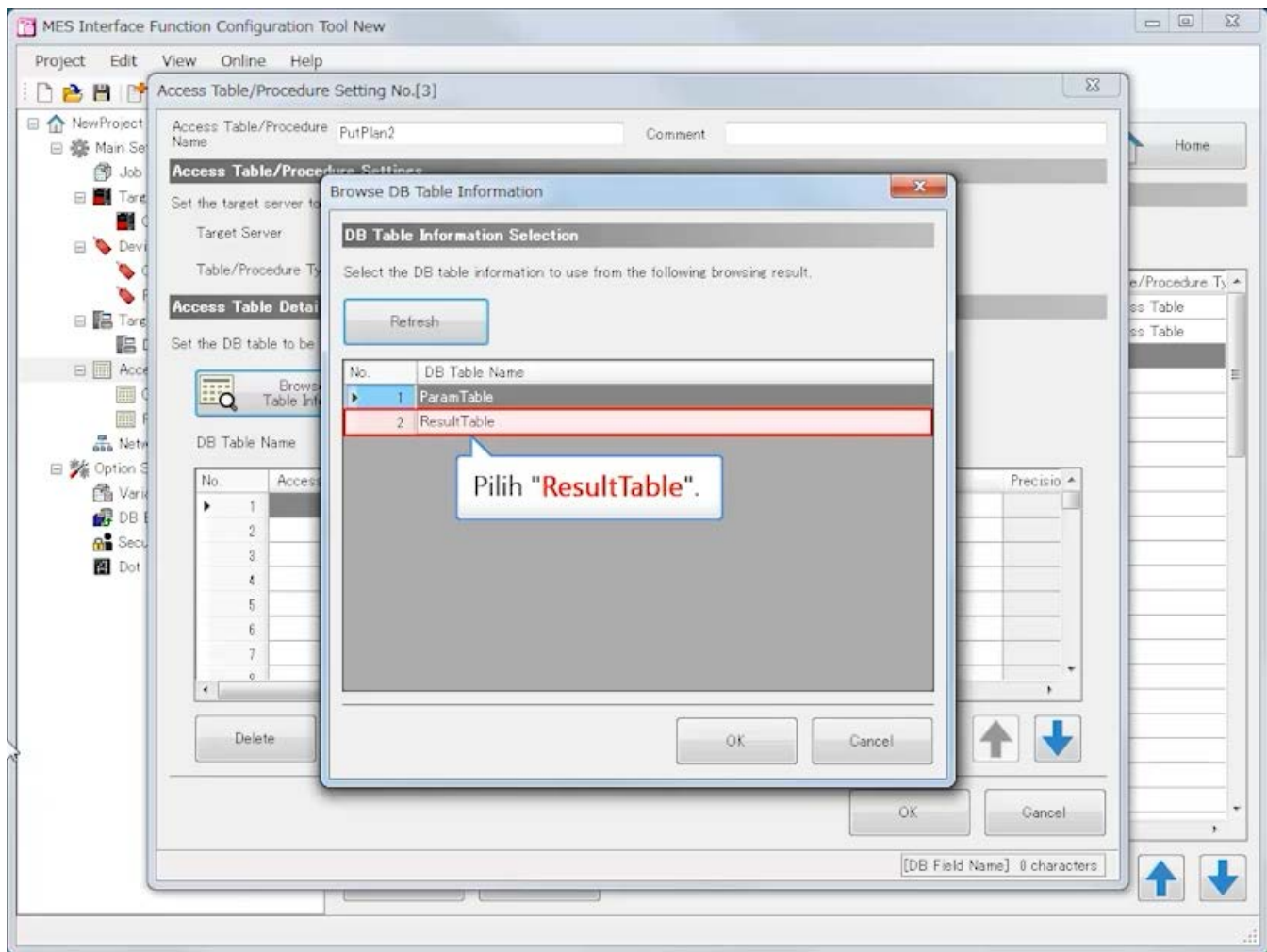
Kembali

Berikutnya



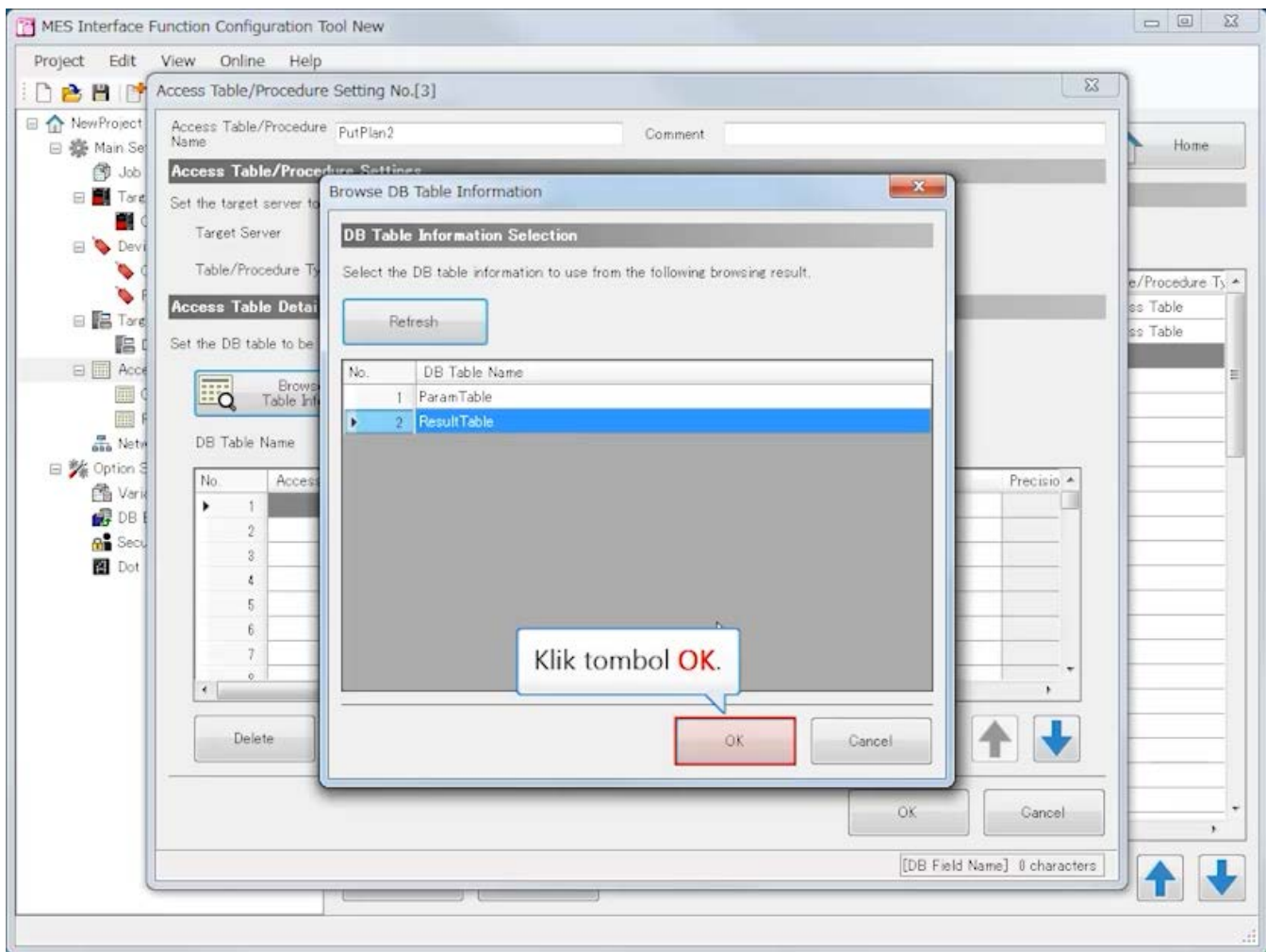
Kembali

Berikutnya



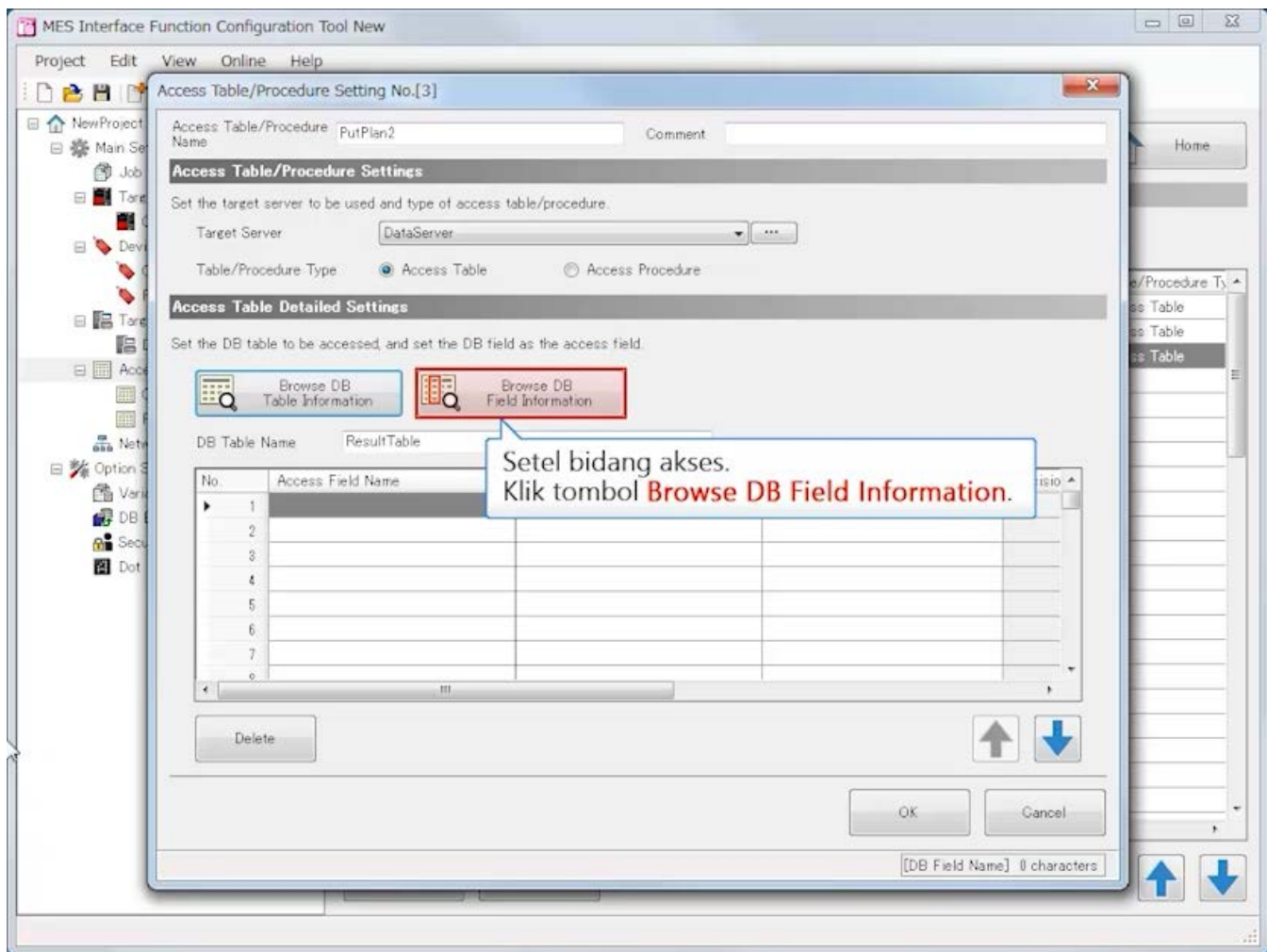
Kembali

Berikutnya



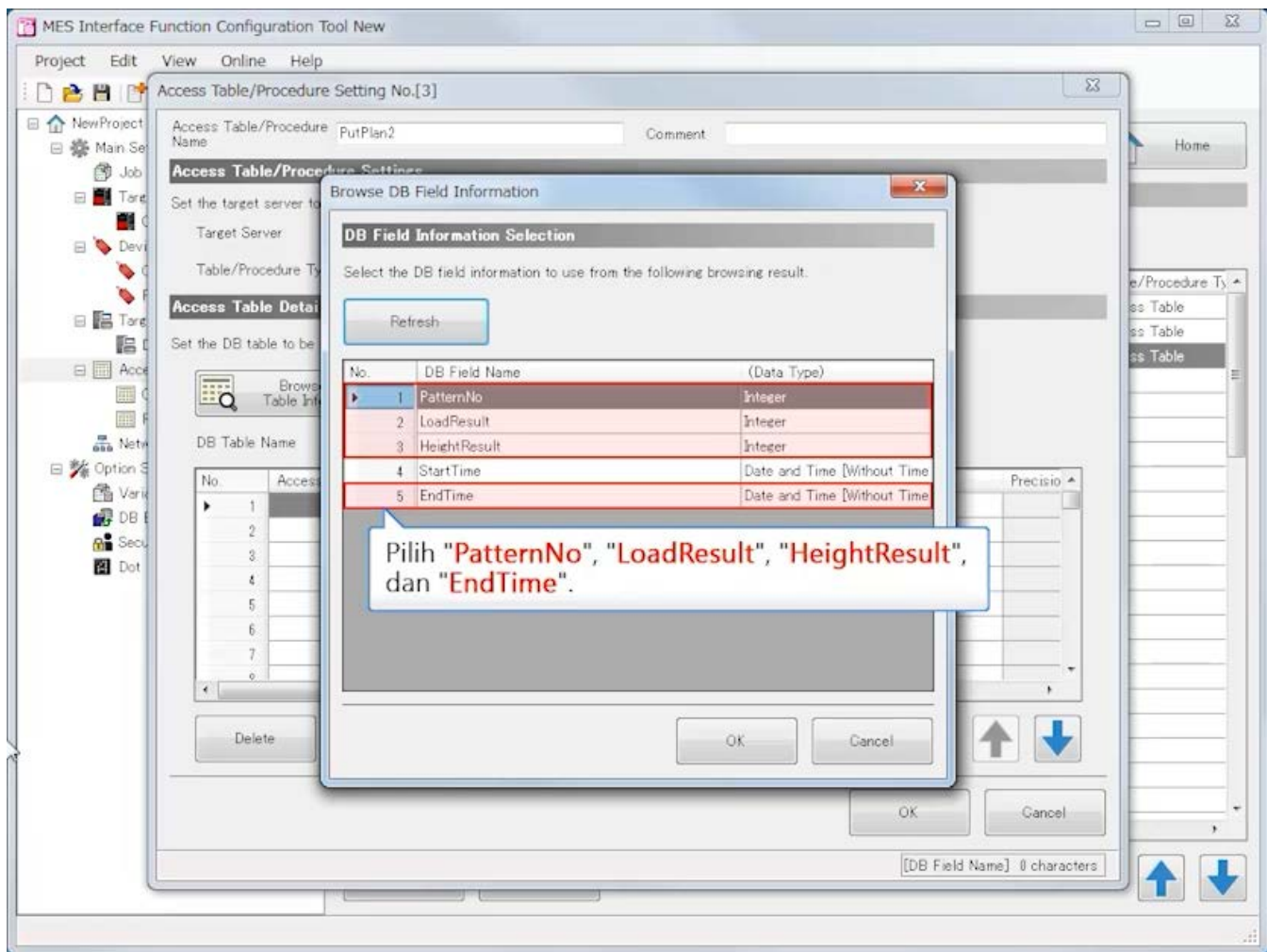
Kembali

Berikutnya



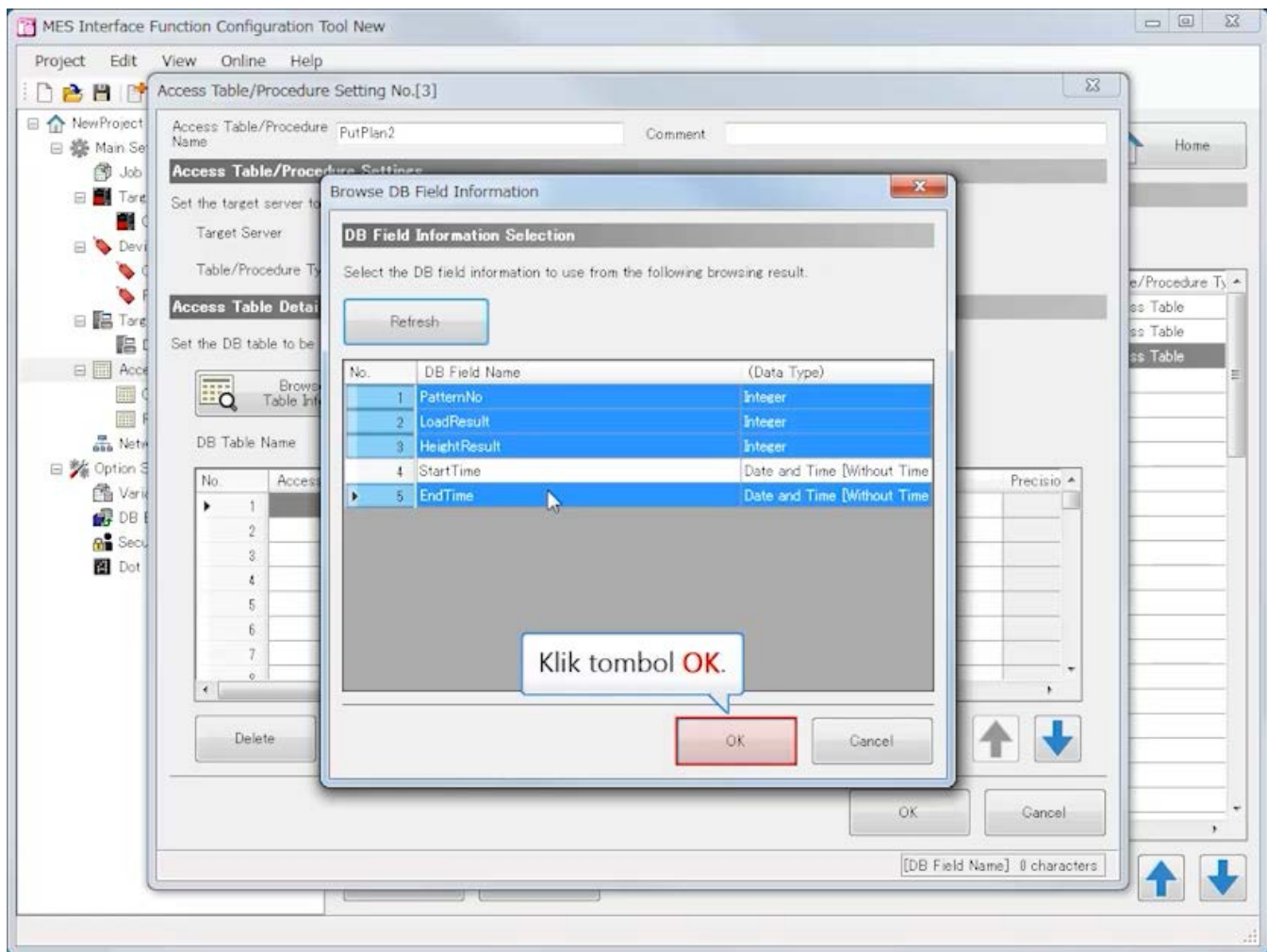
Kembali

Berikutnya



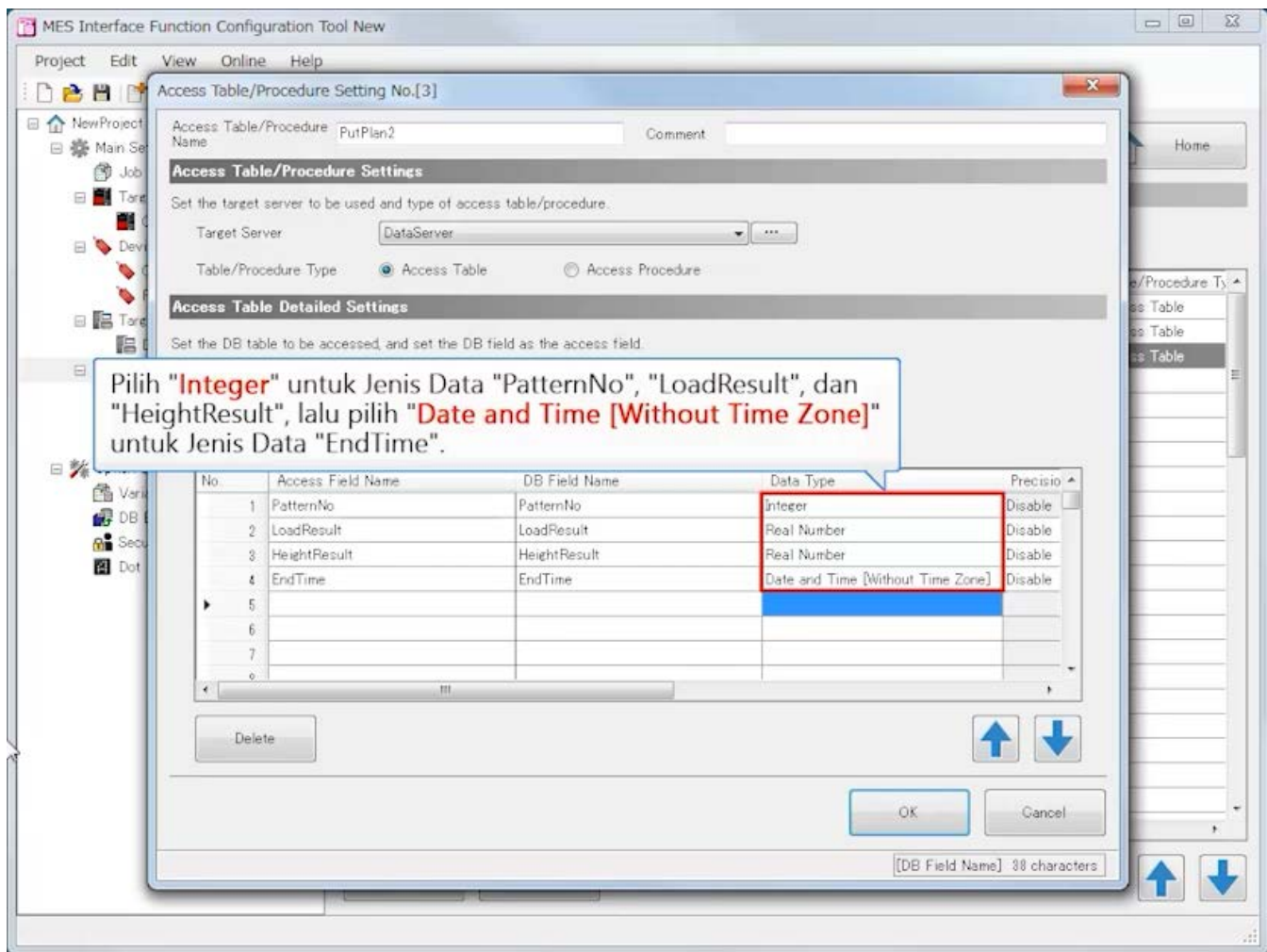
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

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.

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	Real Number	Disable
3	HeightResult	HeightResult	Real Number	Disable
4	EndTime	EndTime	Date and Time [Without Time Zone]	Disable
5				
6				
7				
8				

Delete

Sekarang, semua item terdaftar. Klik tombol OK.

OK Cancel

[DB Field Name] 38 characters

Kembali

Berikutnya

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

DataSetter

Access Table/Proc. Settings

GetPlan

PutPlan1

PutPlan2

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		DataSetter	Access Table
2	PutPlan1		DataSetter	Access Table
3	PutPlan2		DataSetter	Access Table
4				
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Edit

Delete

Pengaturan tabel/prosedur akses, "PutPlan2" selesai.

Klik

>

 untuk melanjutkan ke halaman berikutnya.

[Job Settings]

Buat pekerjaan yang mengekstrak data dalam database saat manufaktur siap.

(1) Job Name: GetPlan

[Job Configuration]

Job Configuration: Main Configuration

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: 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

[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
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 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] 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: 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

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 : Select

Access Table : GetPlan.Database

Tab Data Assignment

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]

Tab Narrowing-Down Condition

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: 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]GettingData.SettingValueofPressFittingLoad...
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"
 DB Buffering No Buffering

DB Buffer Use Size [byte] -

Back
 Next

[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 : Jangan dipilih
Inhibit the data output to the target server : Jangan dipilih
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: Jangan dipilih

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

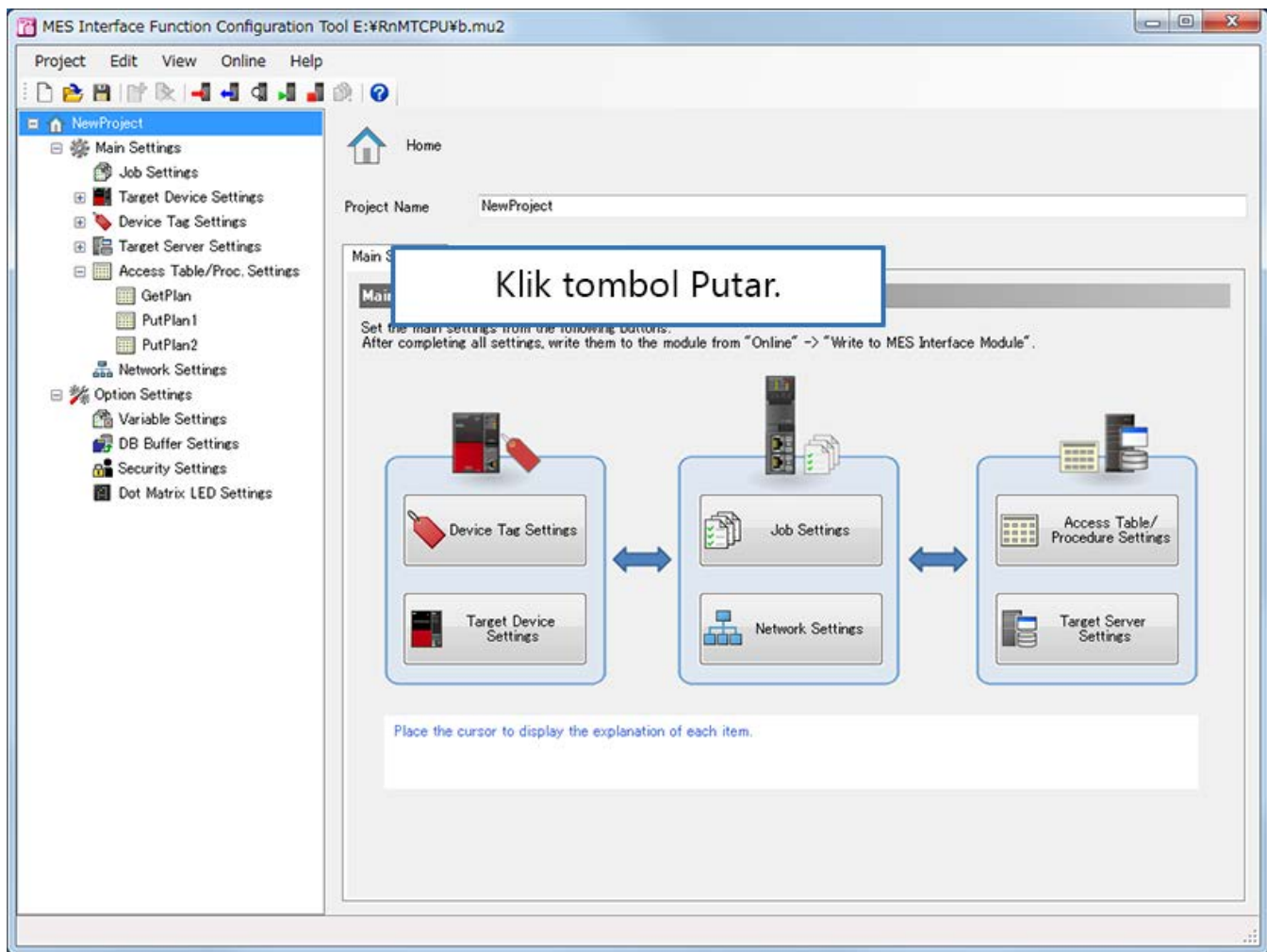
Job Execution Inhibition Necessity Settings (optional)

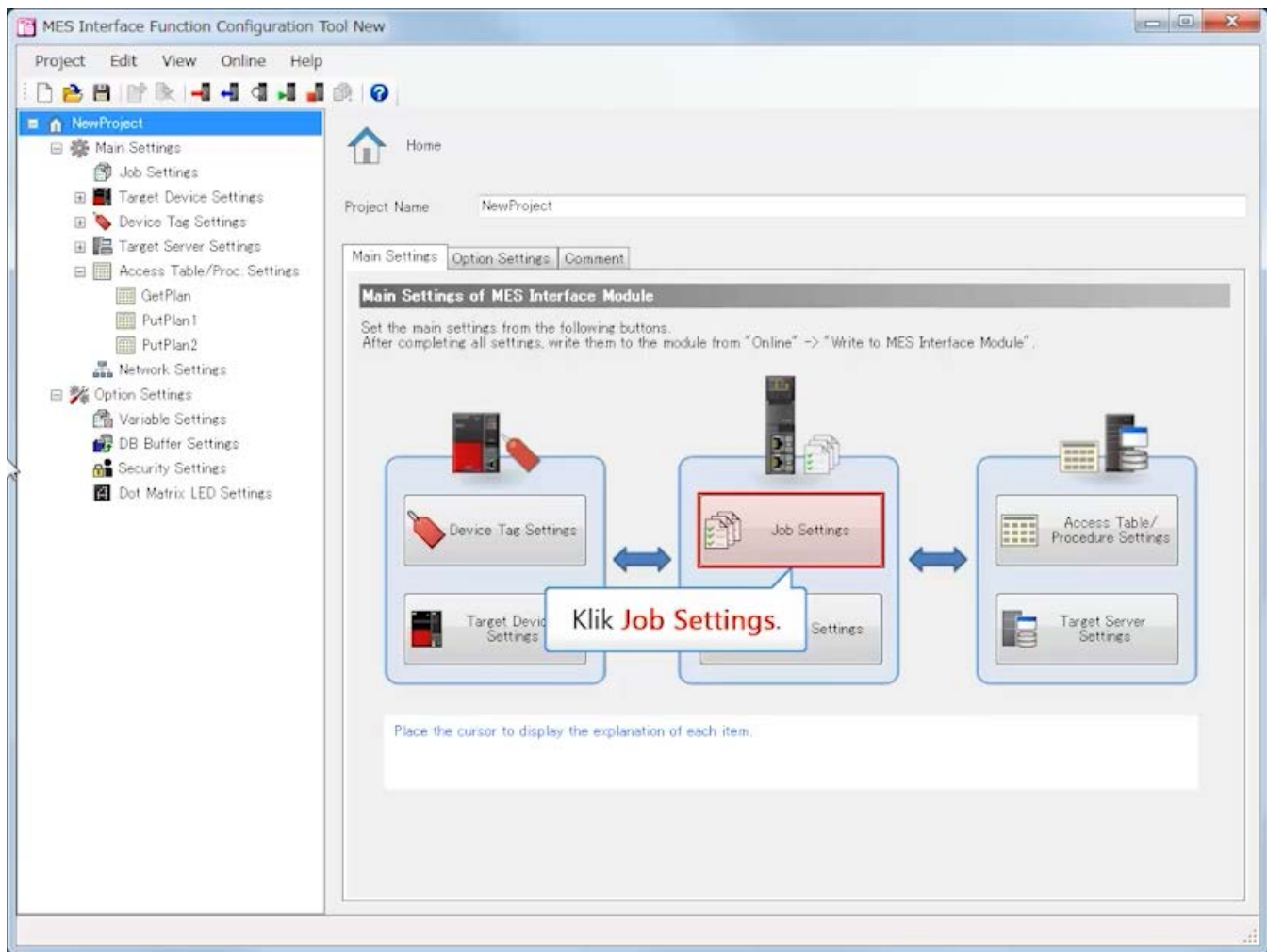
Set the necessity of the job execution inhibition.

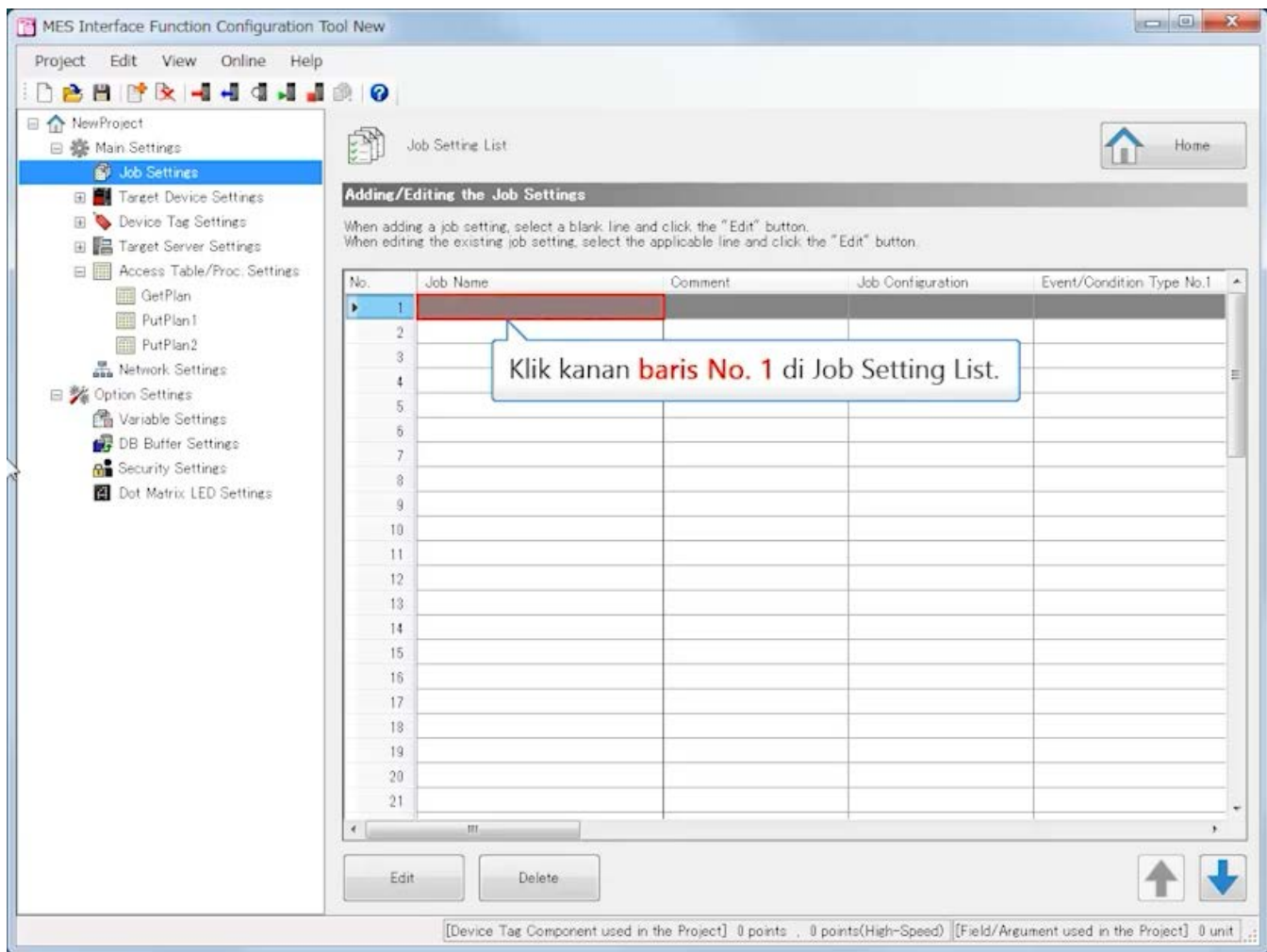
☐ Inhibit the job execution even when the trigger condition is satisfied.

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

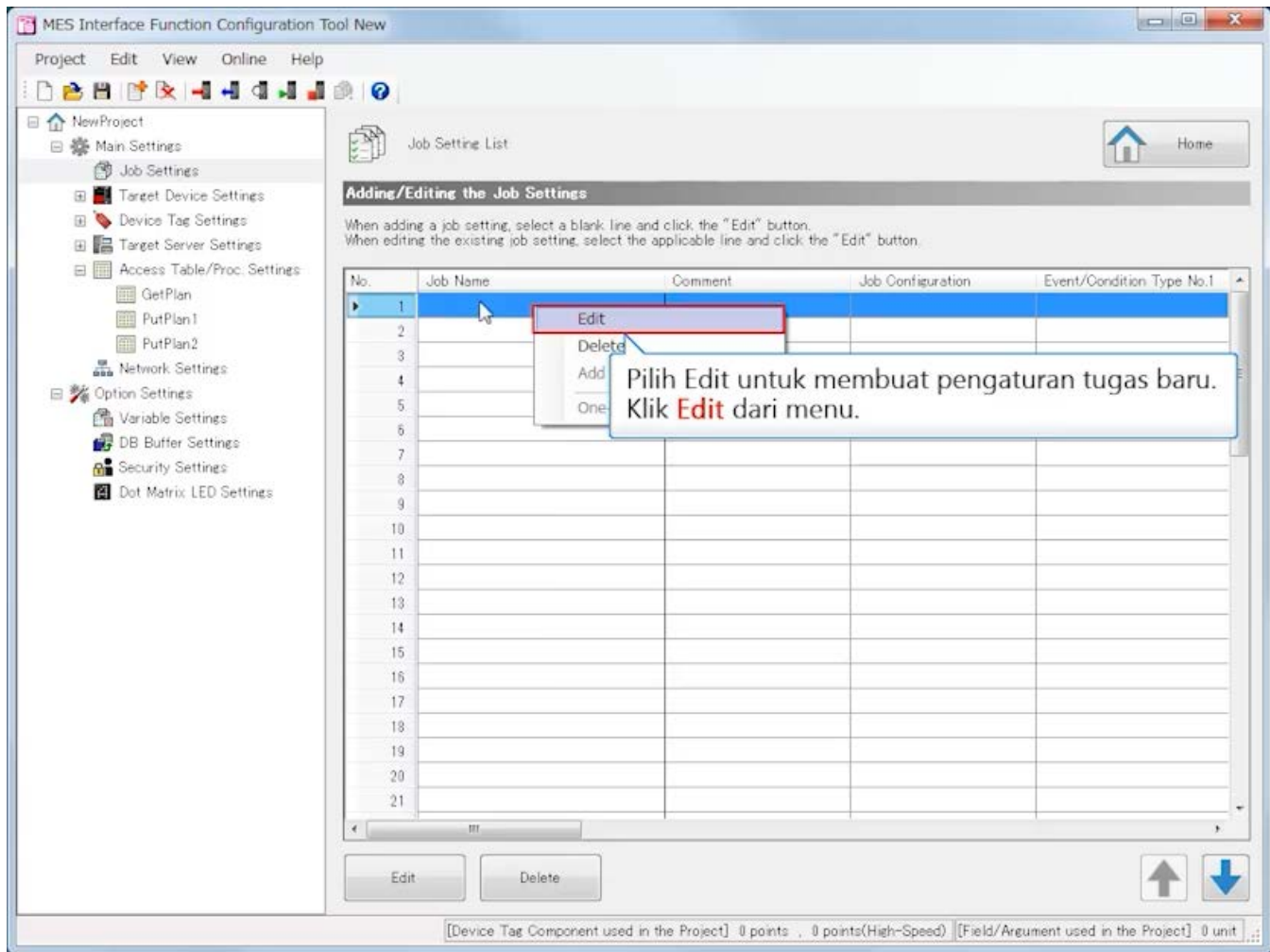
[Kembali](#)[Berikutnya](#)

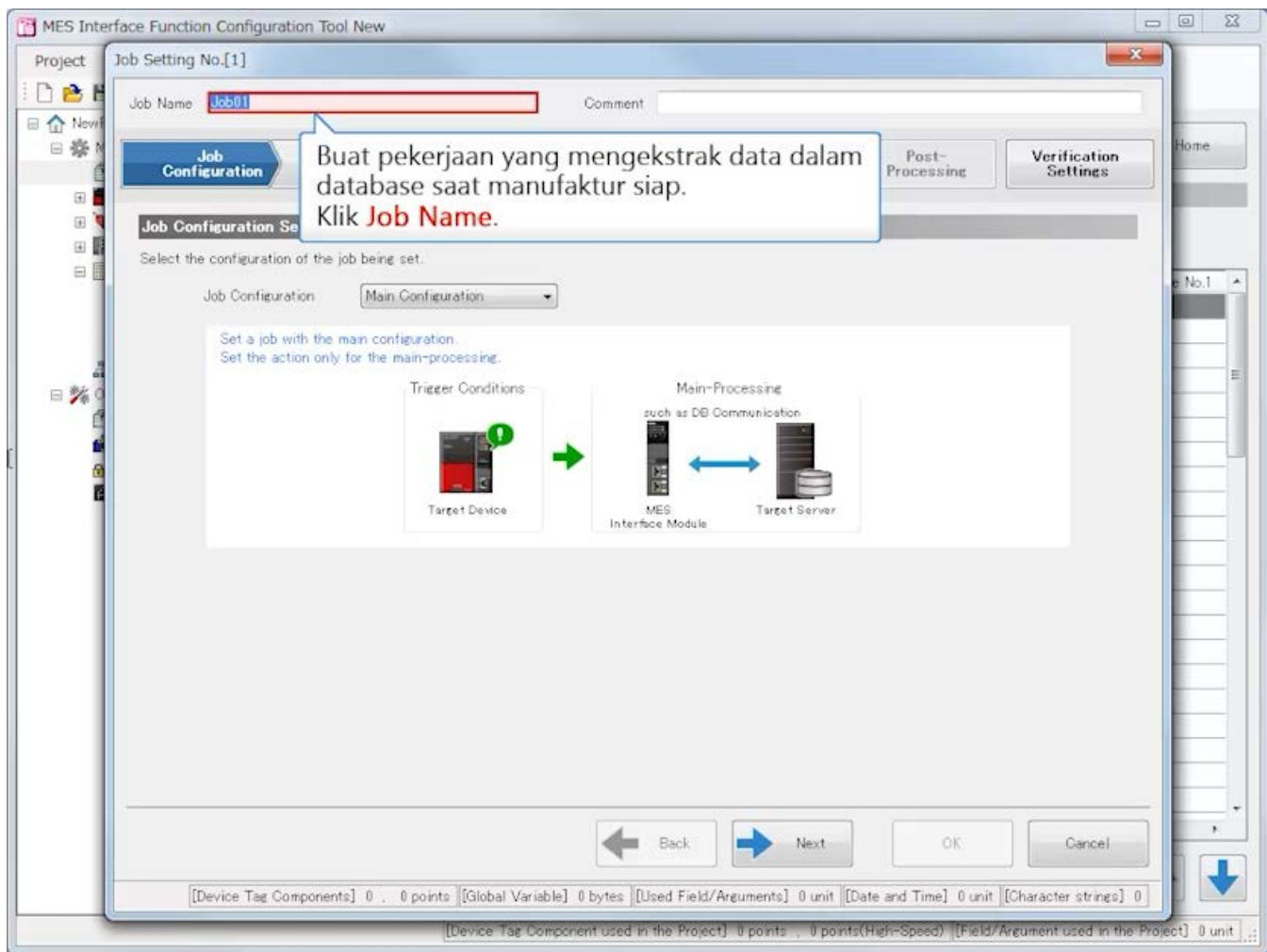
[Kembali](#)[Berikutnya](#)

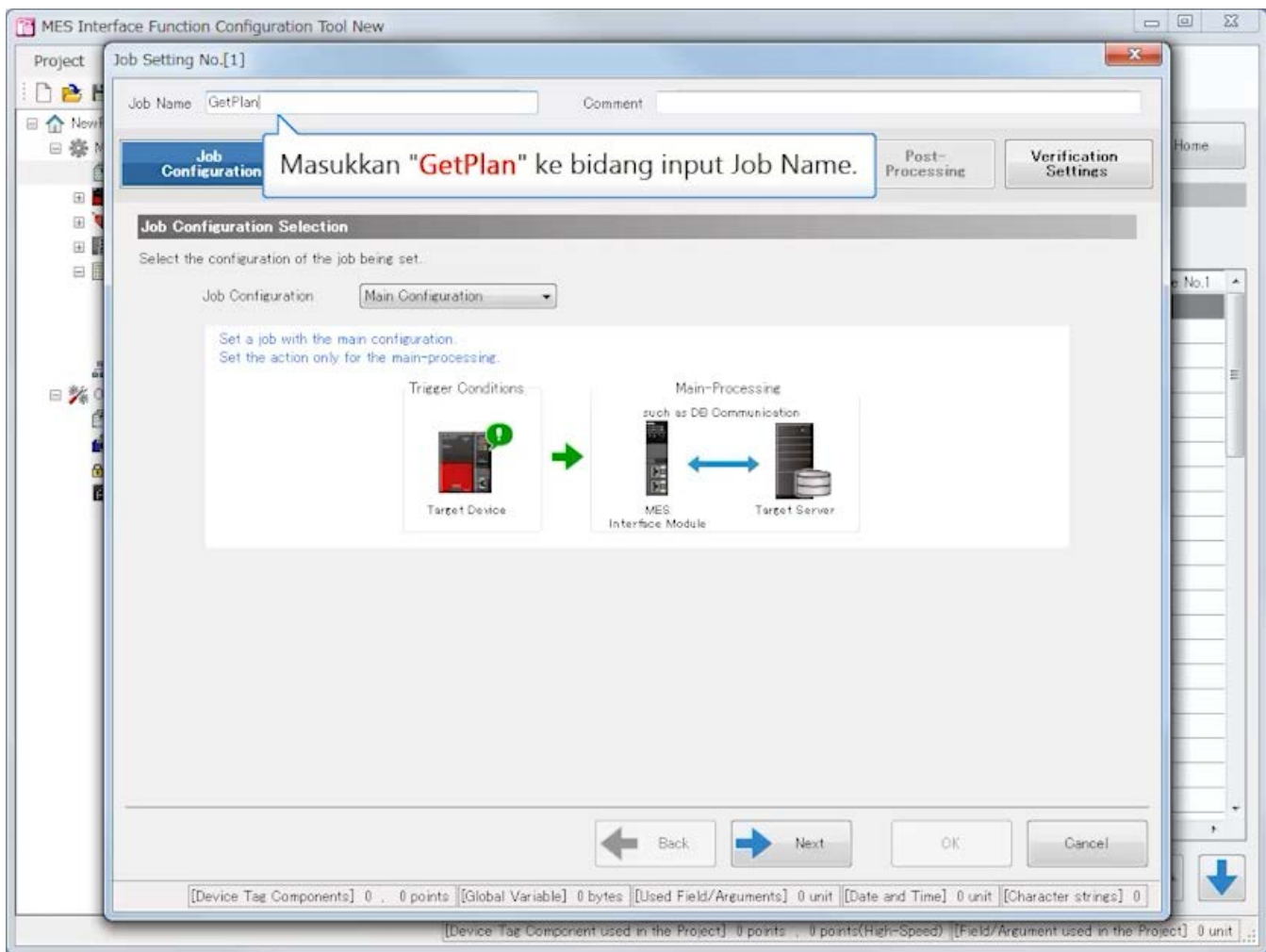
[Kembali](#)[Berikutnya](#)

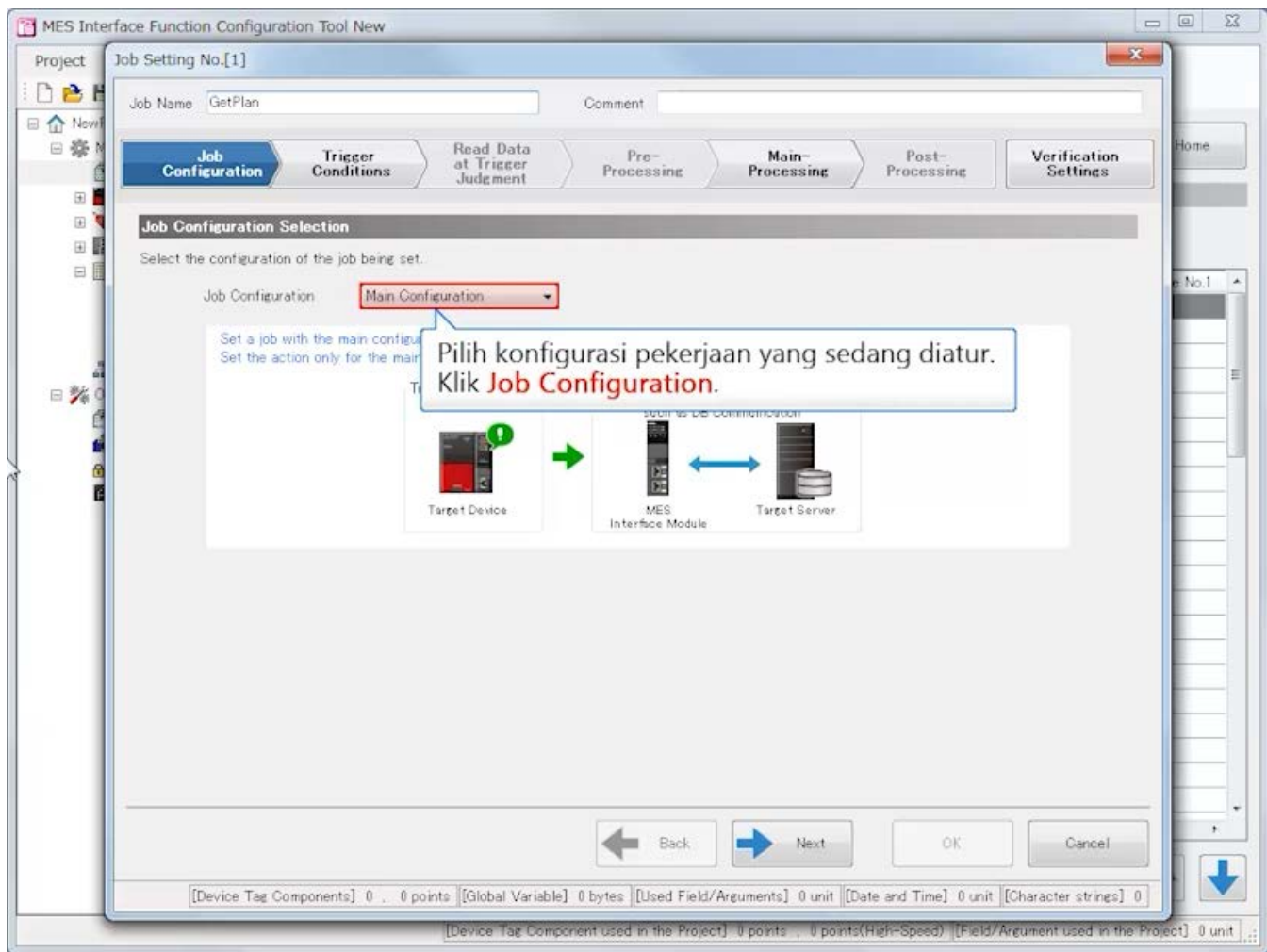
Kembali

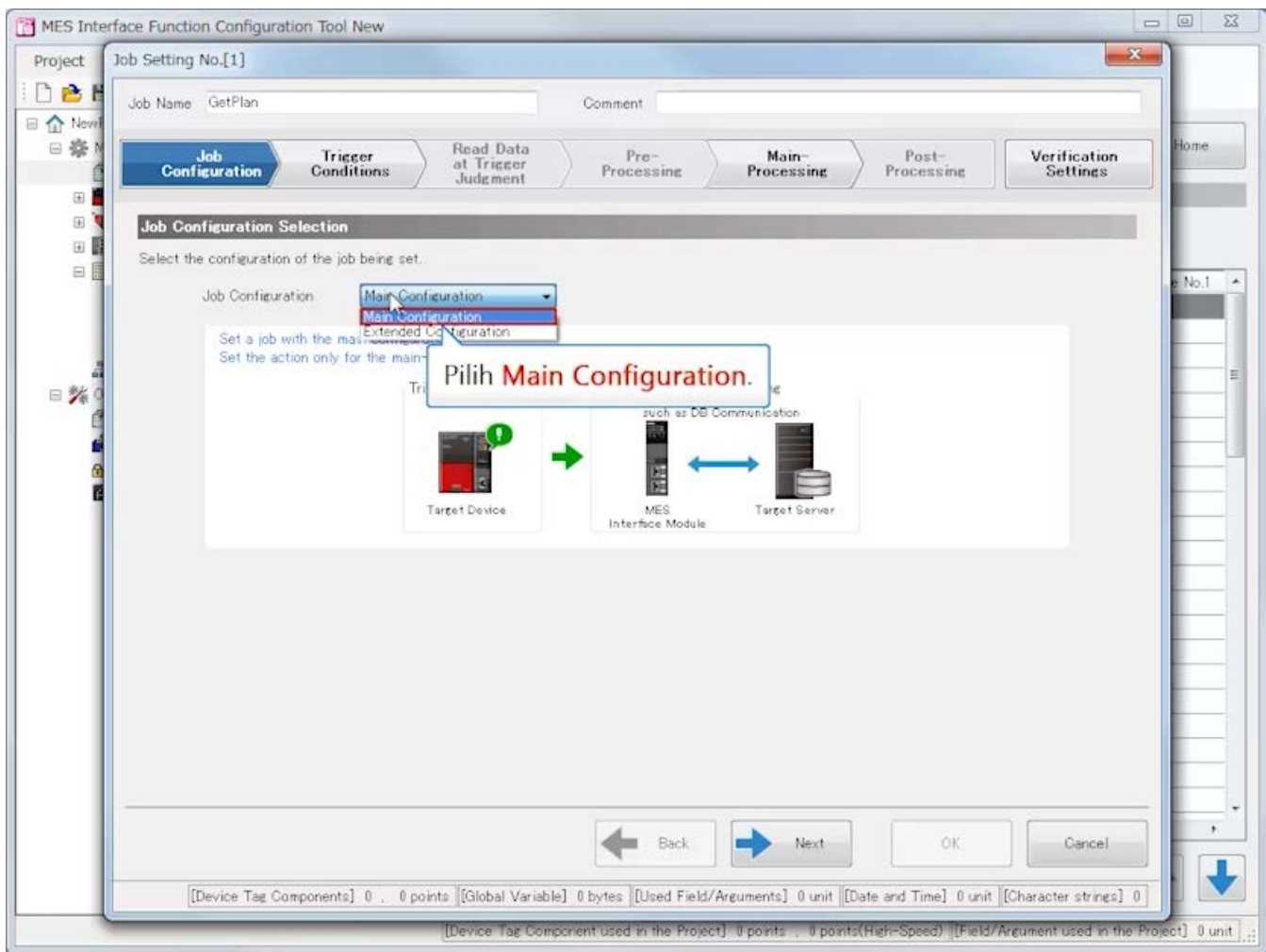
Berikutnya

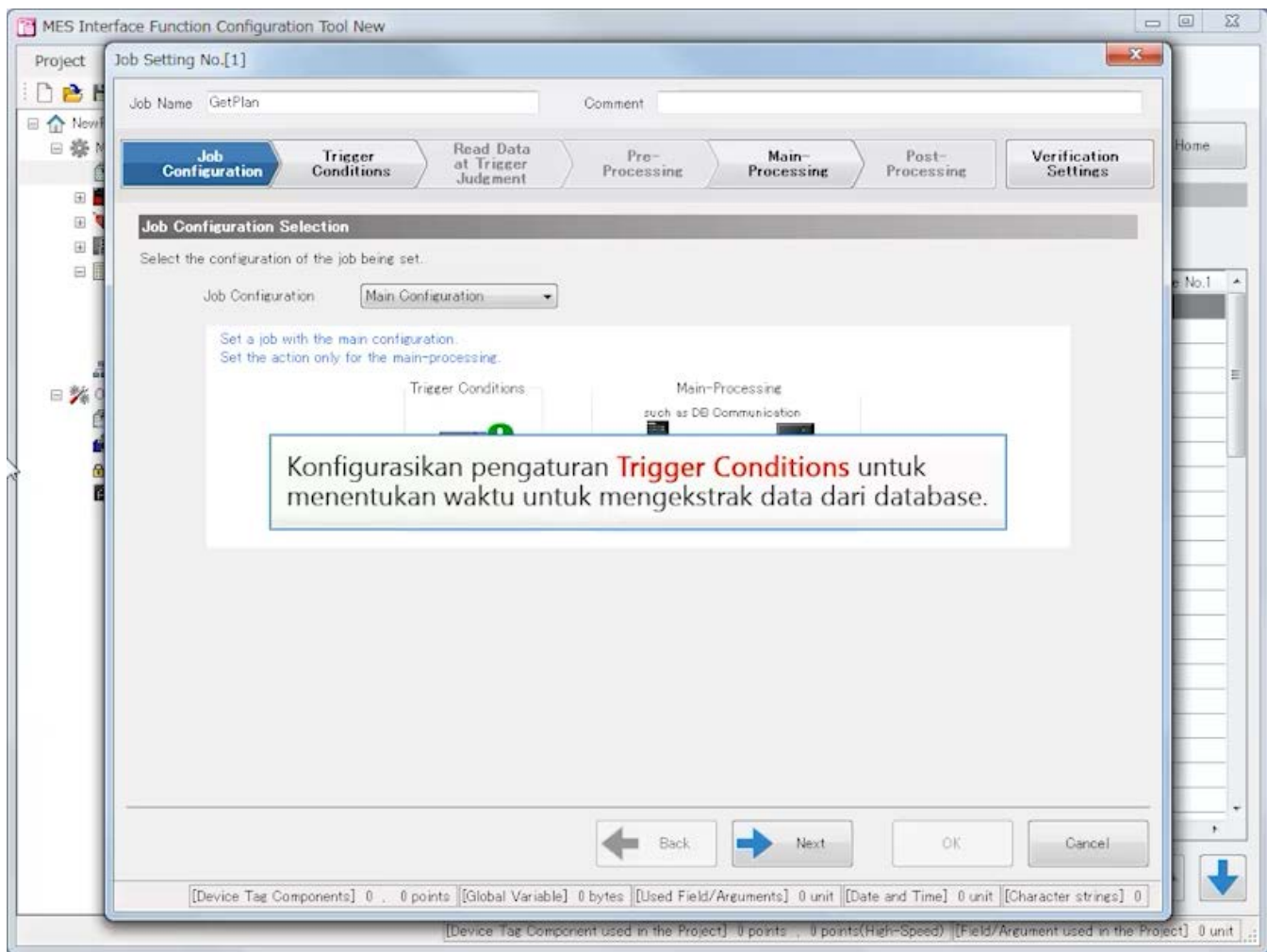


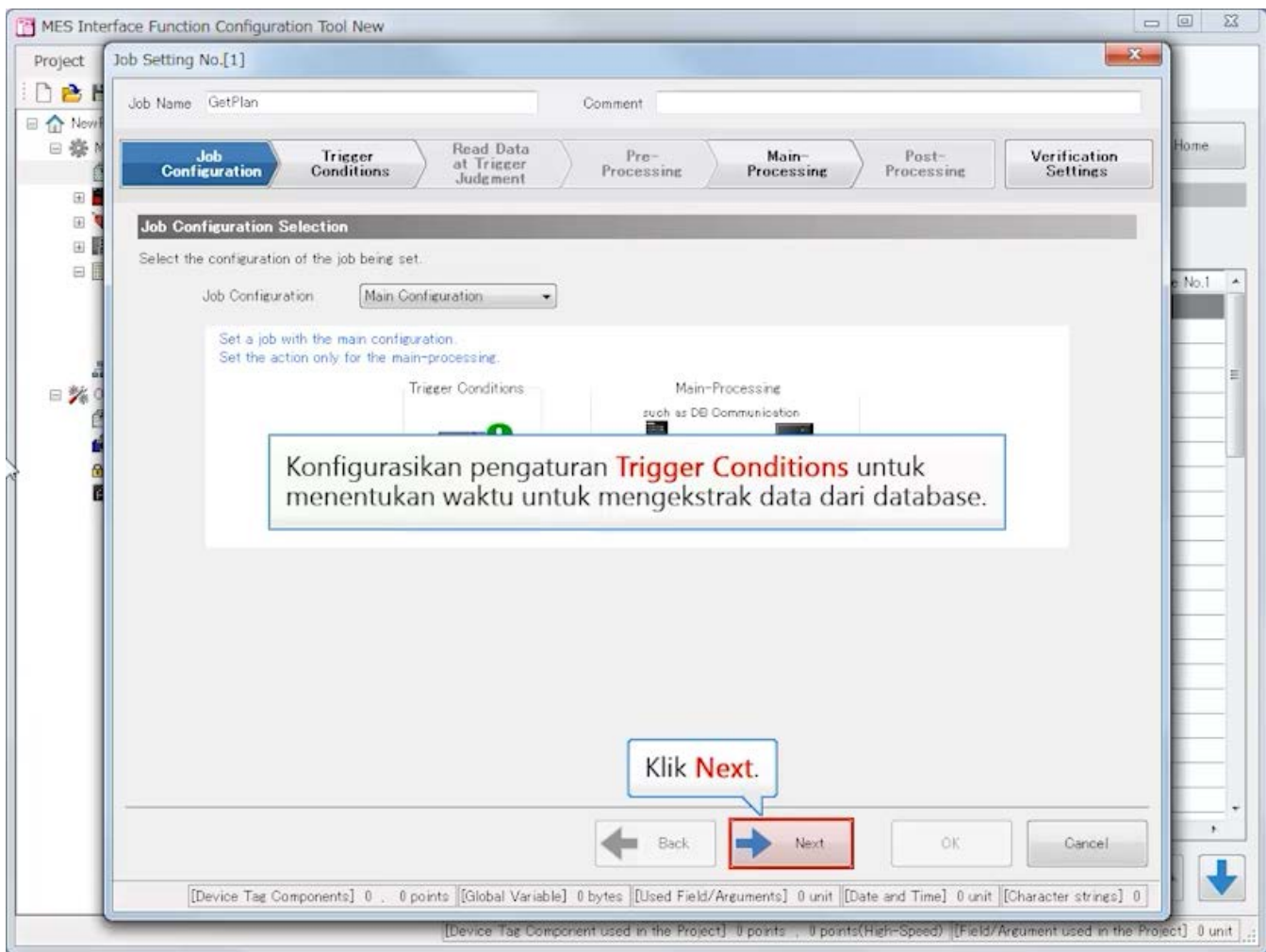
[Kembali](#)[Berikutnya](#)

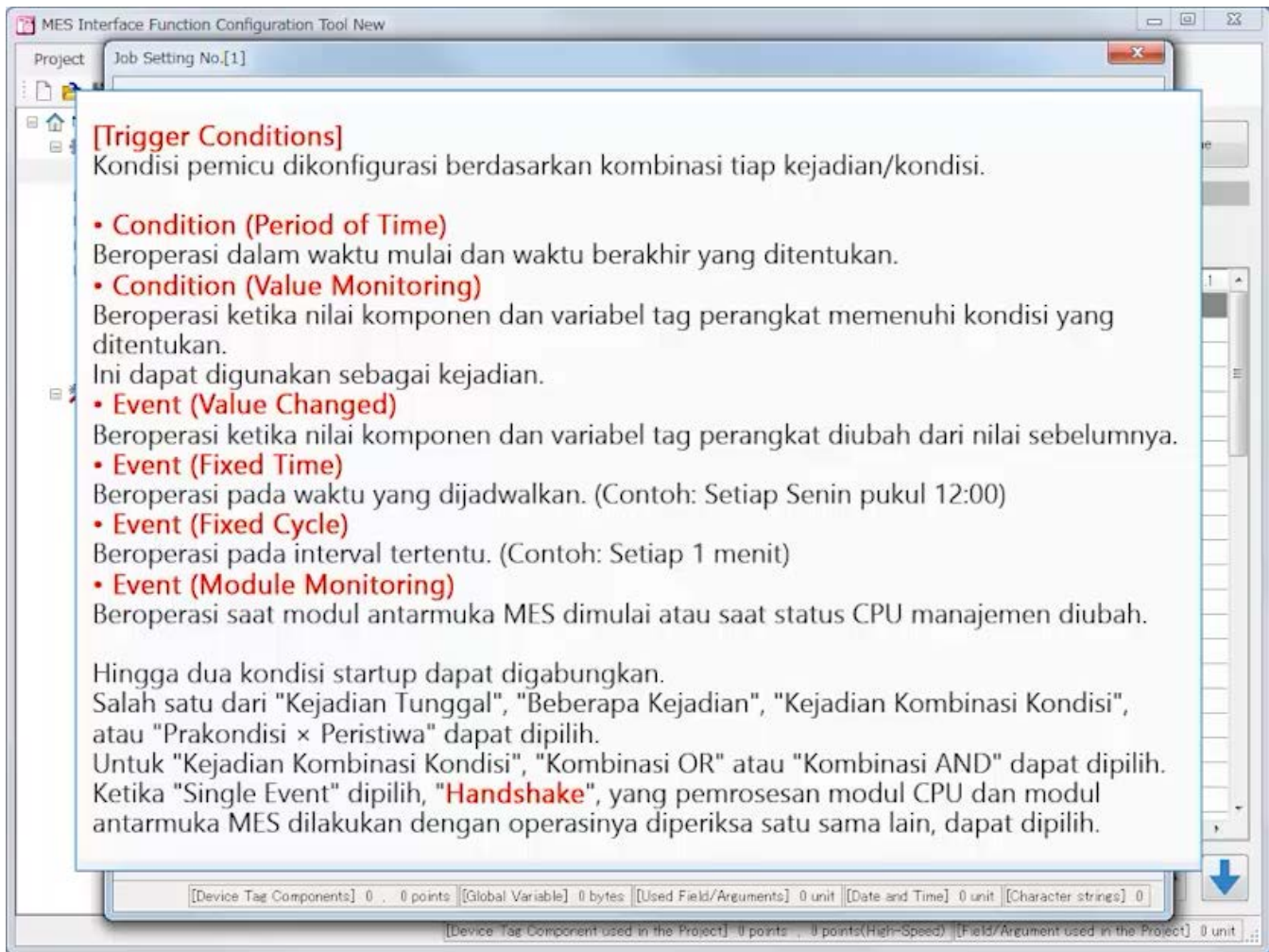
[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

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[Kembali](#)[Berikutnya](#)

[Kembali](#)
[Berikutnya](#)


Kembali

Berikutnya

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 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

Kembali

Berikutnya

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 Multiple Events Condition Combination Precondition

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

Pilih **Single Event** untuk mengatur terjadinya peristiwa tertentu sebagai pemicu.

No.1 Event
Trigger Condition is Satisfied

OR

No.1 Event
Trigger Condition is Satisfied

Kembali

Berikutnya

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			

Mengatur kejadian/kondisi.
Klik tombol **Edit**.

Edit Delete

Trigger Buffering Setting (optional)

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

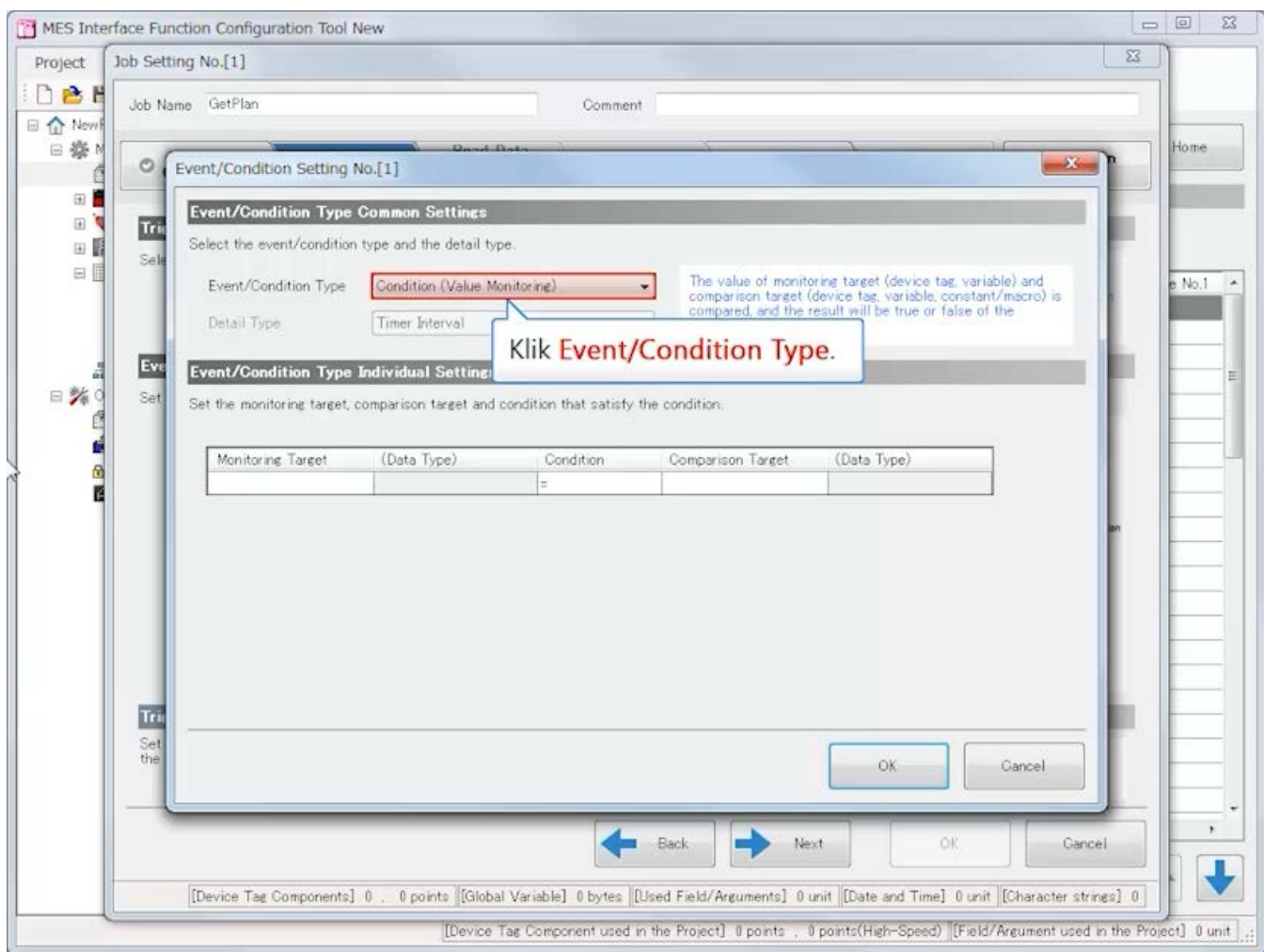
Trigger Buffering Disable

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

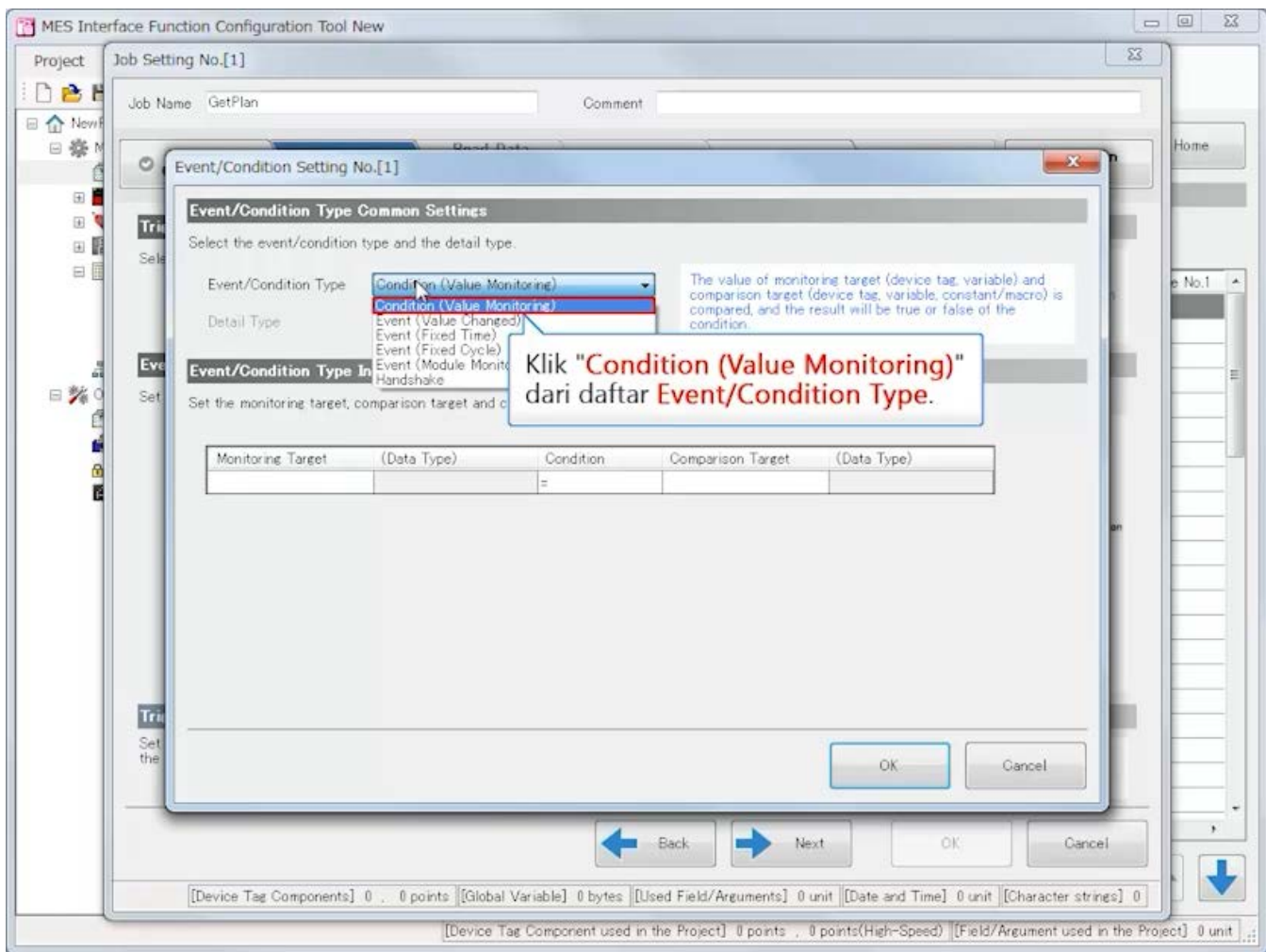
[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

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

[Kembali](#)[Berikutnya](#)

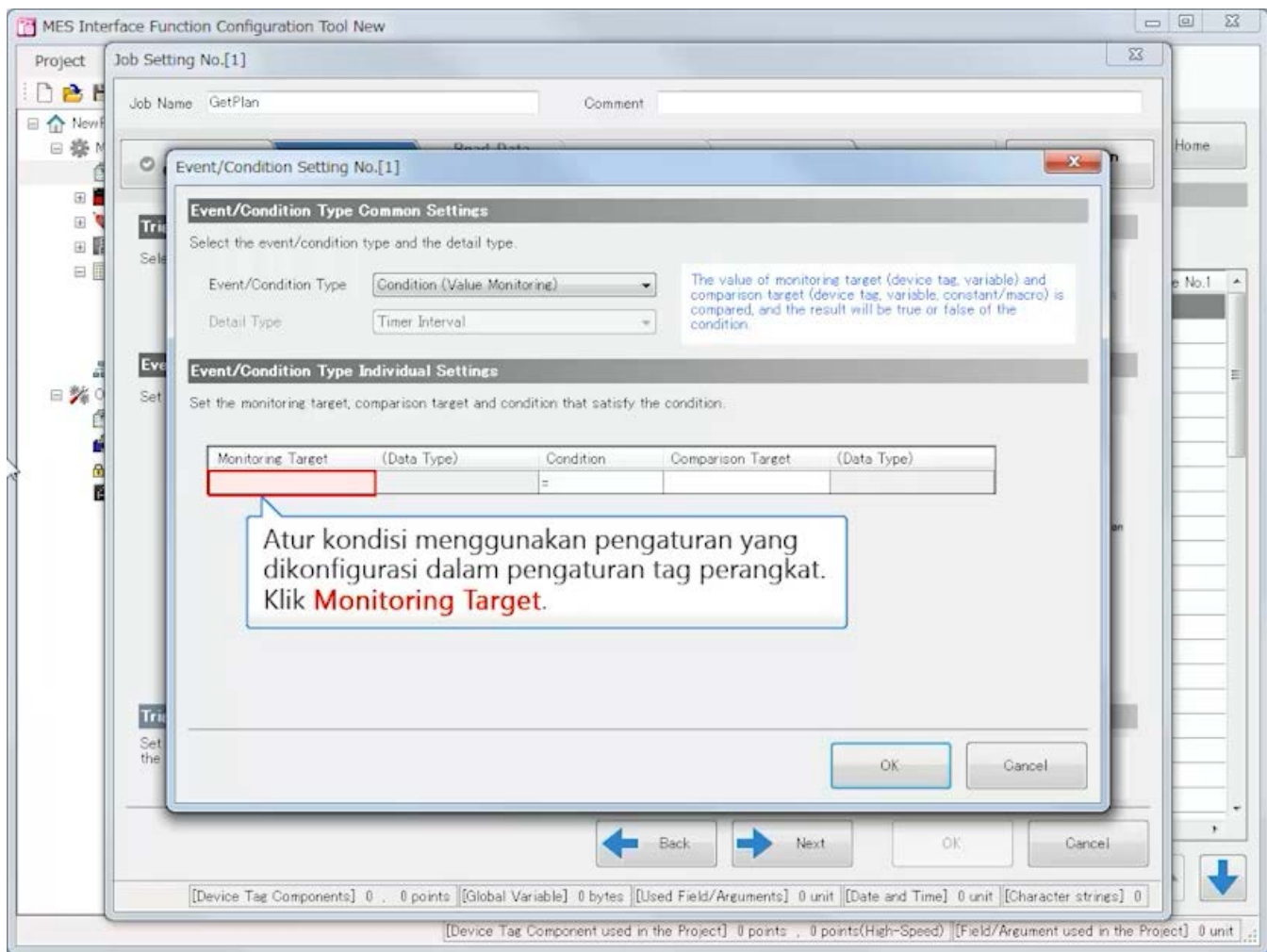
Kembali

Berikutnya



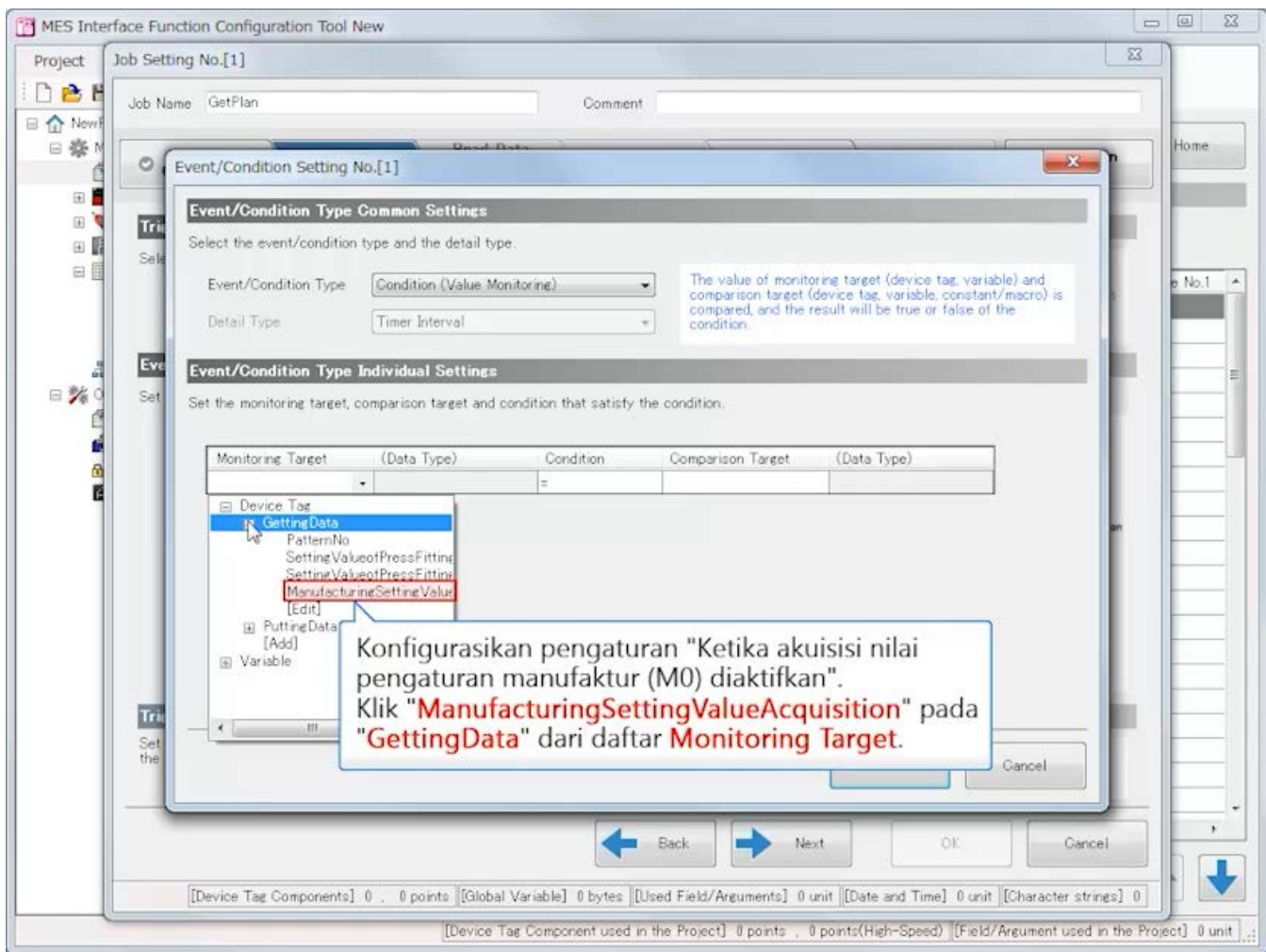
Kembali

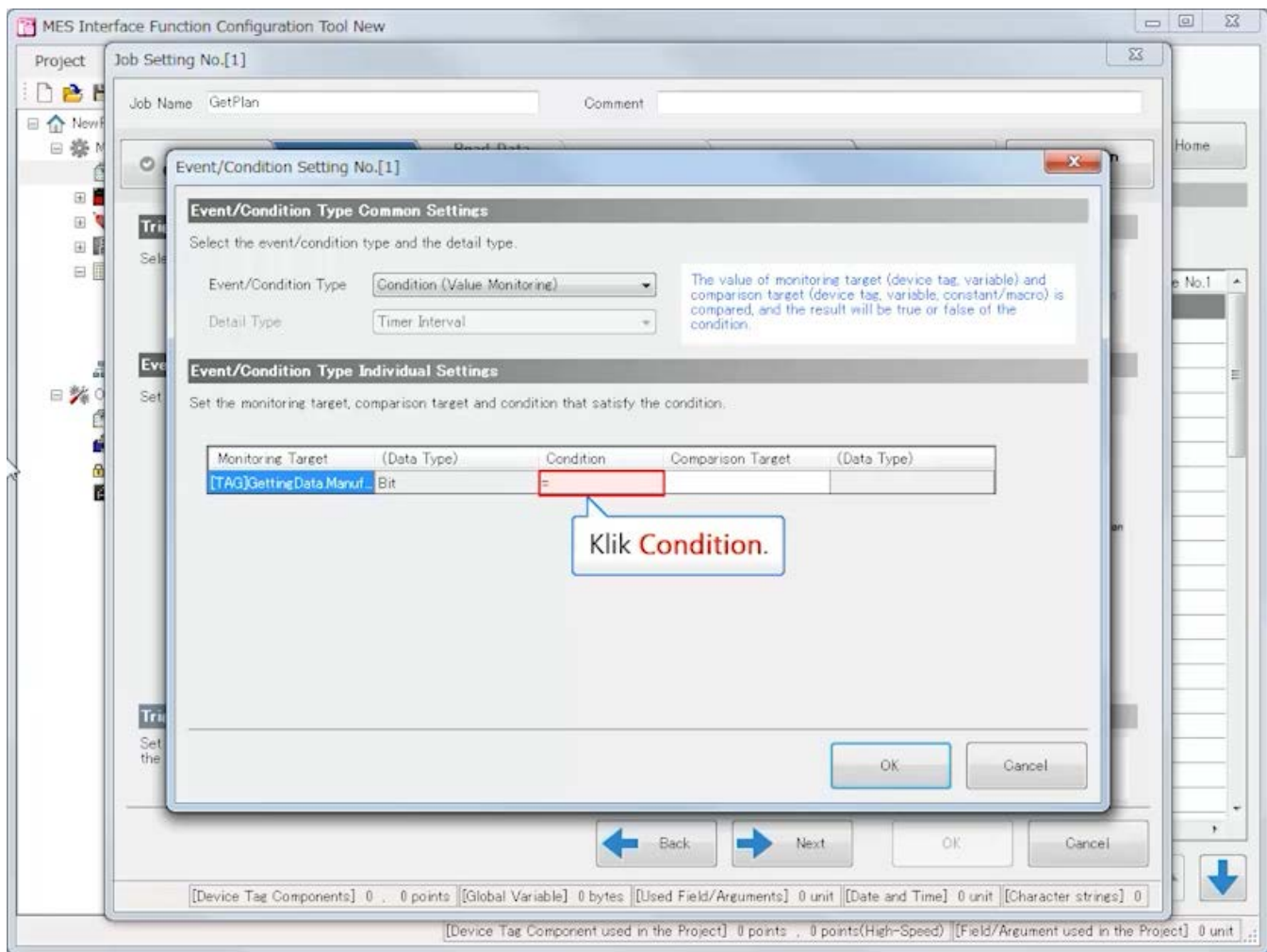
Berikutnya

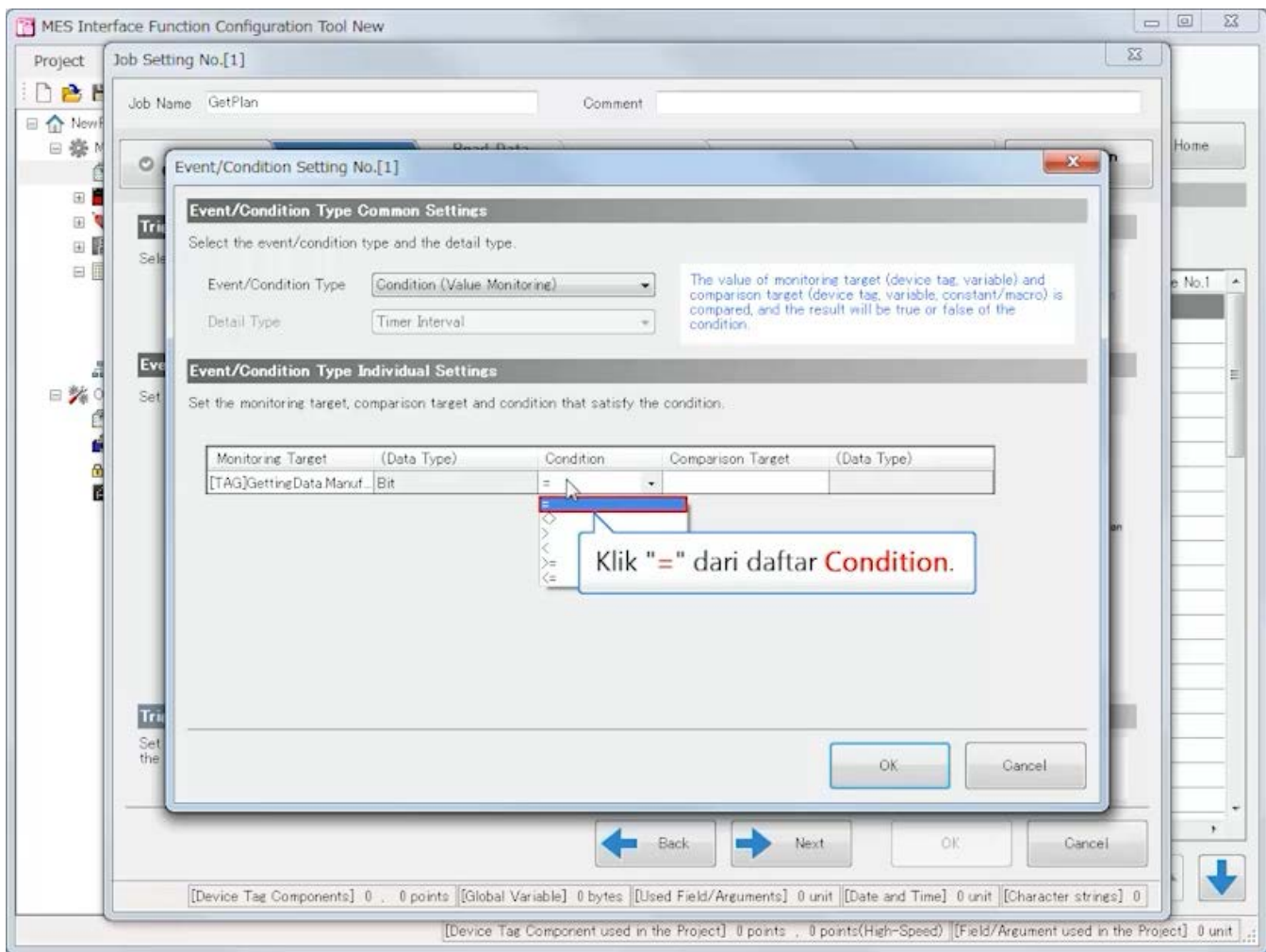


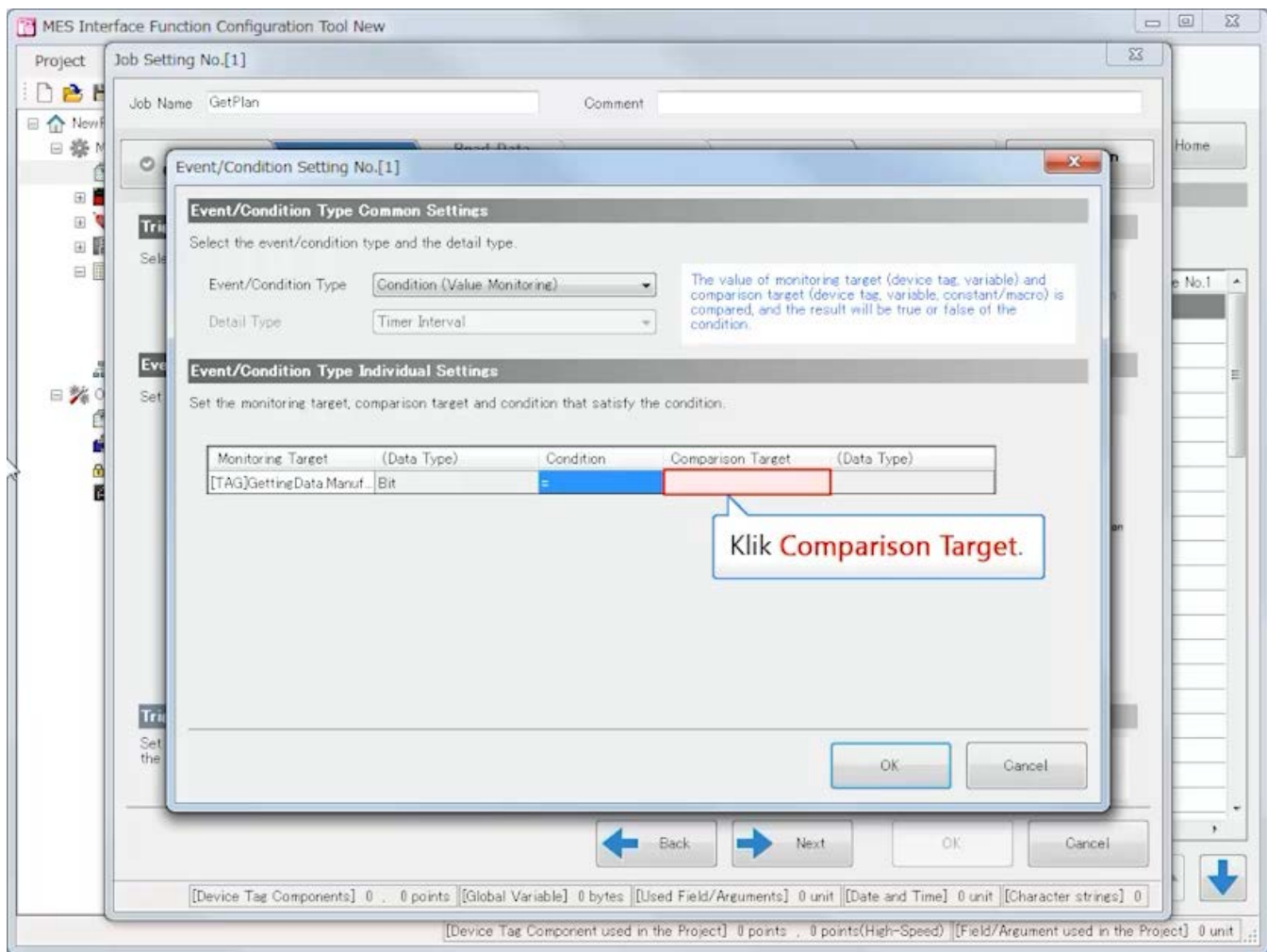
Kembali

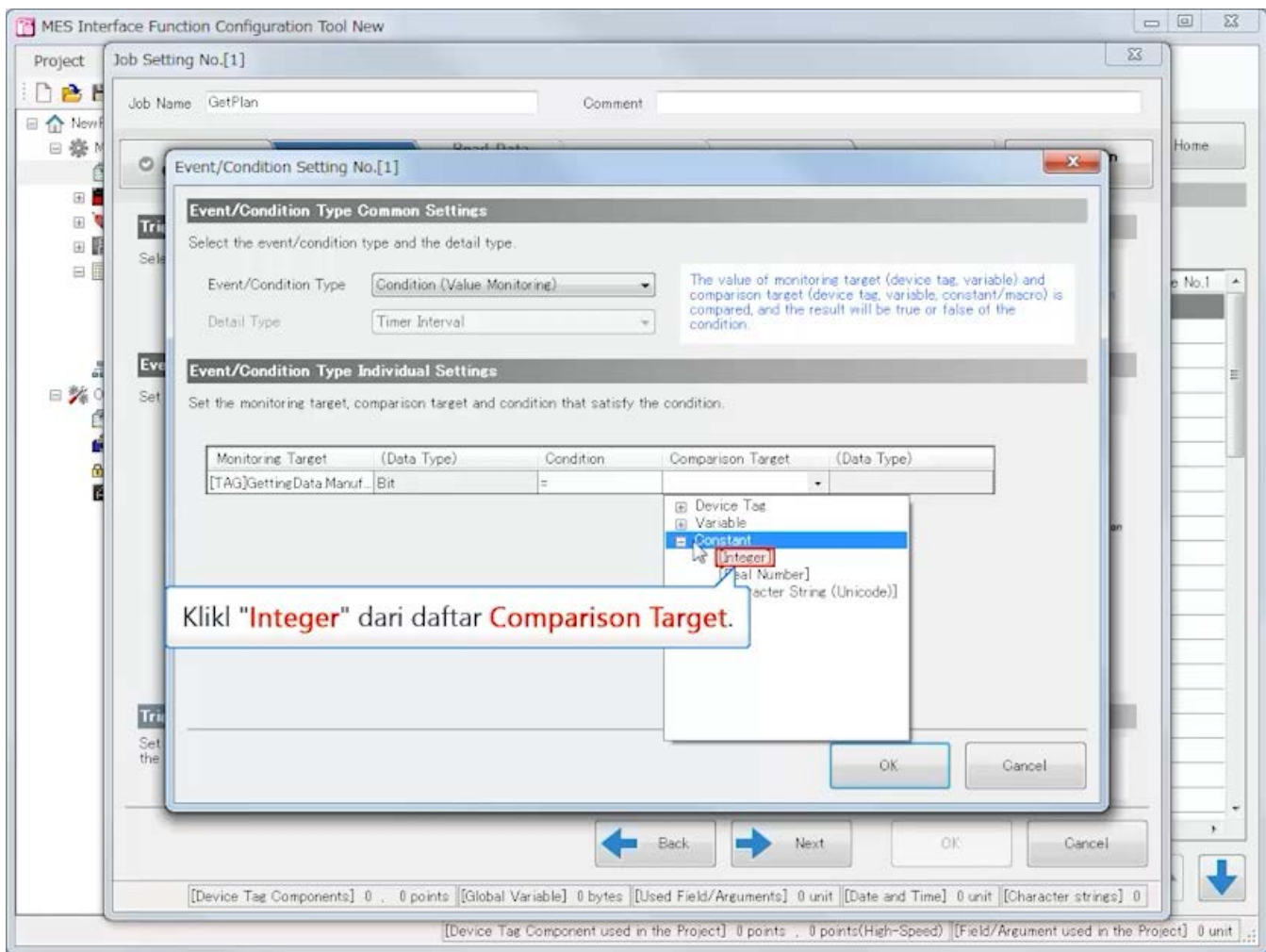
Berikutnya

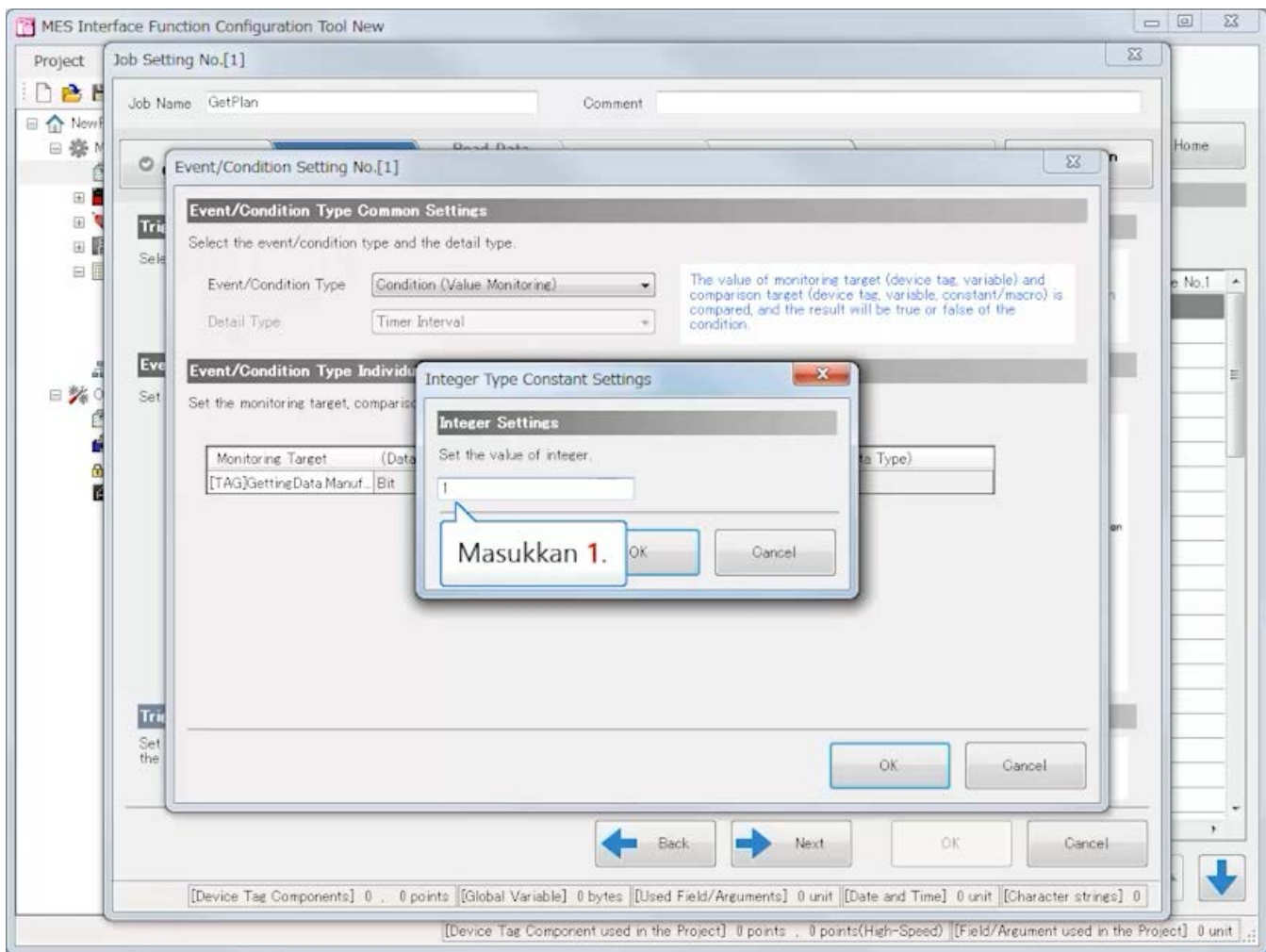


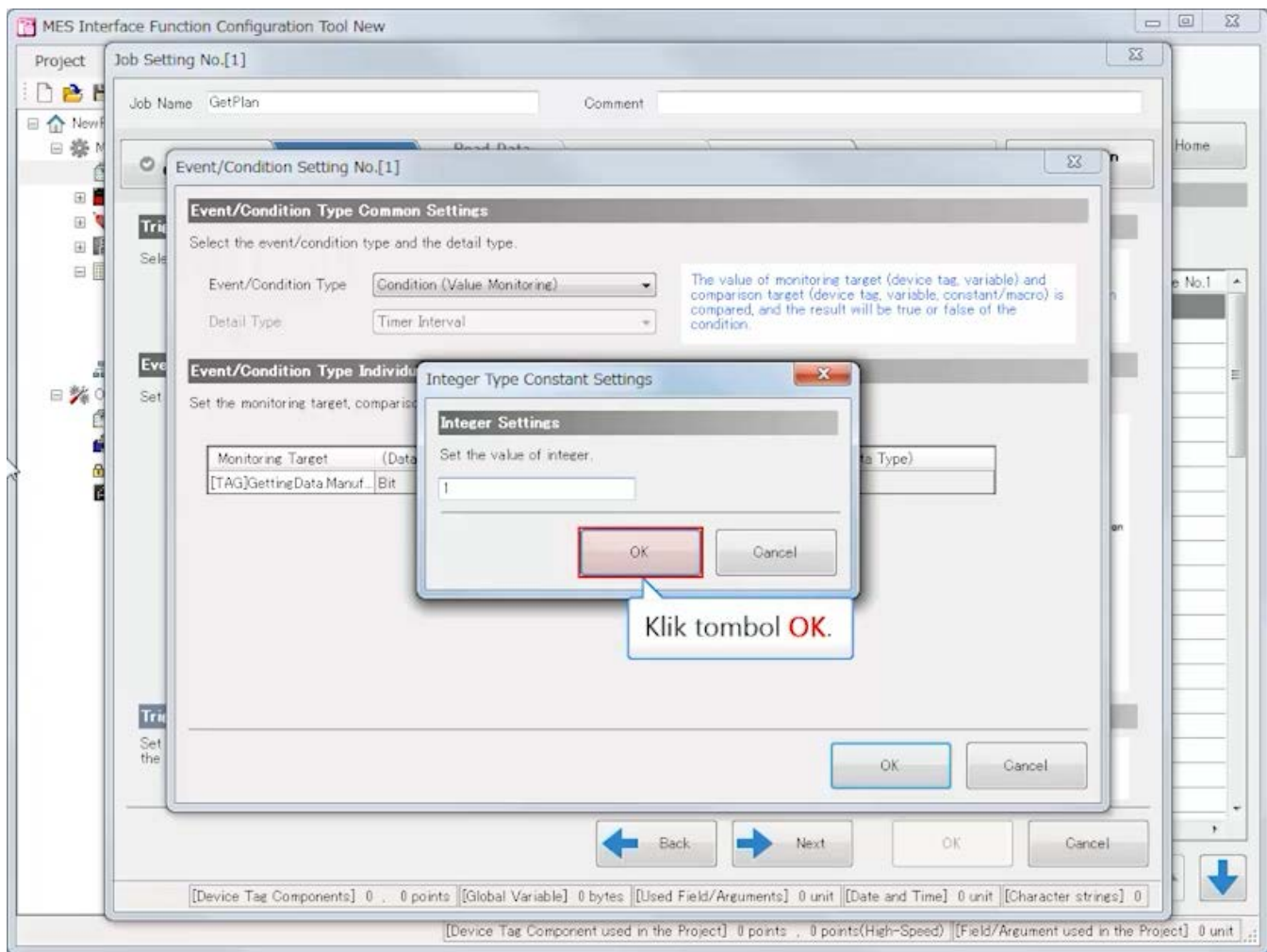
[Kembali](#)[Berikutnya](#)

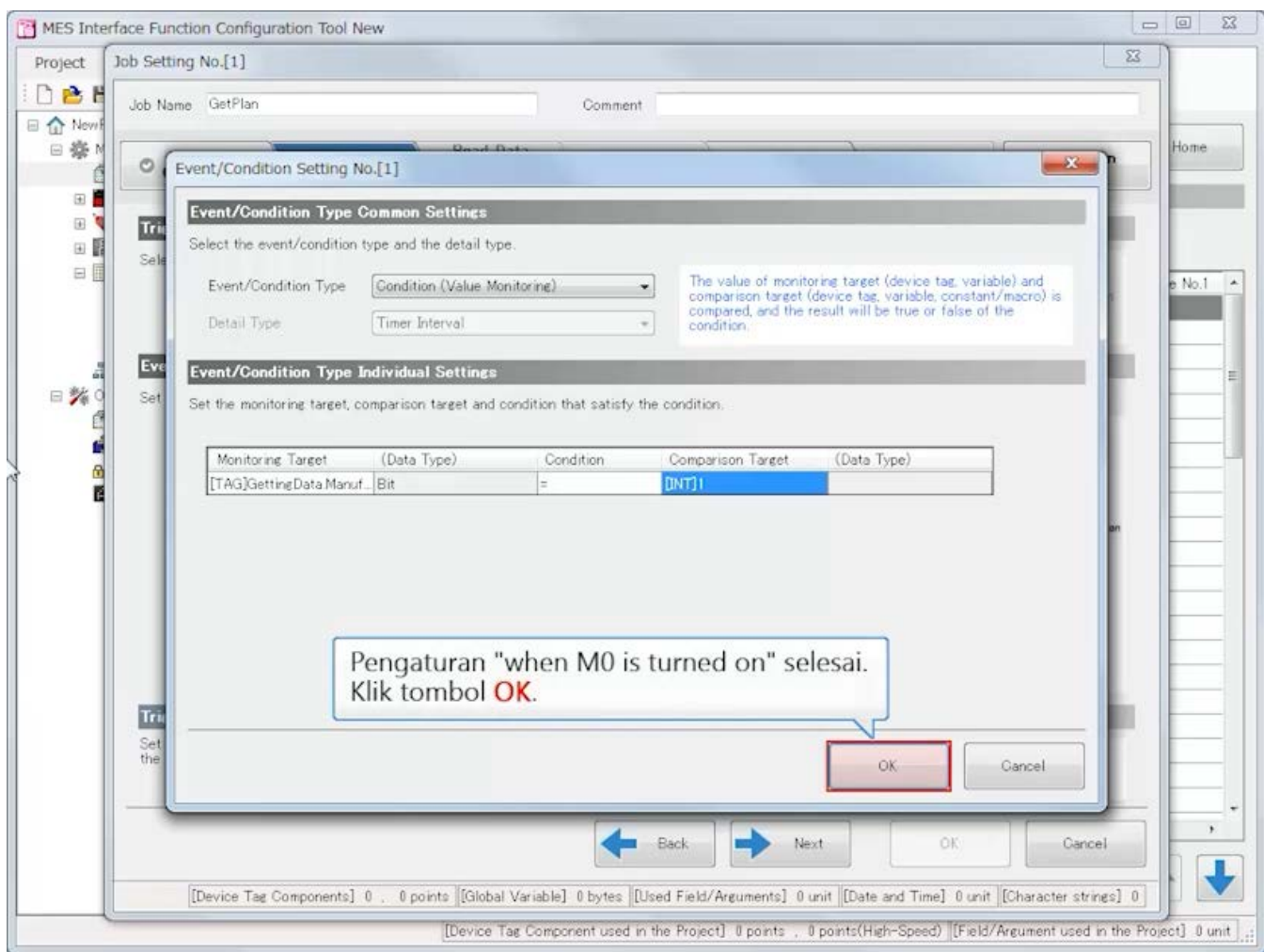
[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

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	Condition (Value Monit...	-	[TAG]GettingData Manufacturing...

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

Klik Next.

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

[Kembali](#)[Berikutnya](#)

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

Reading Target Data Settings

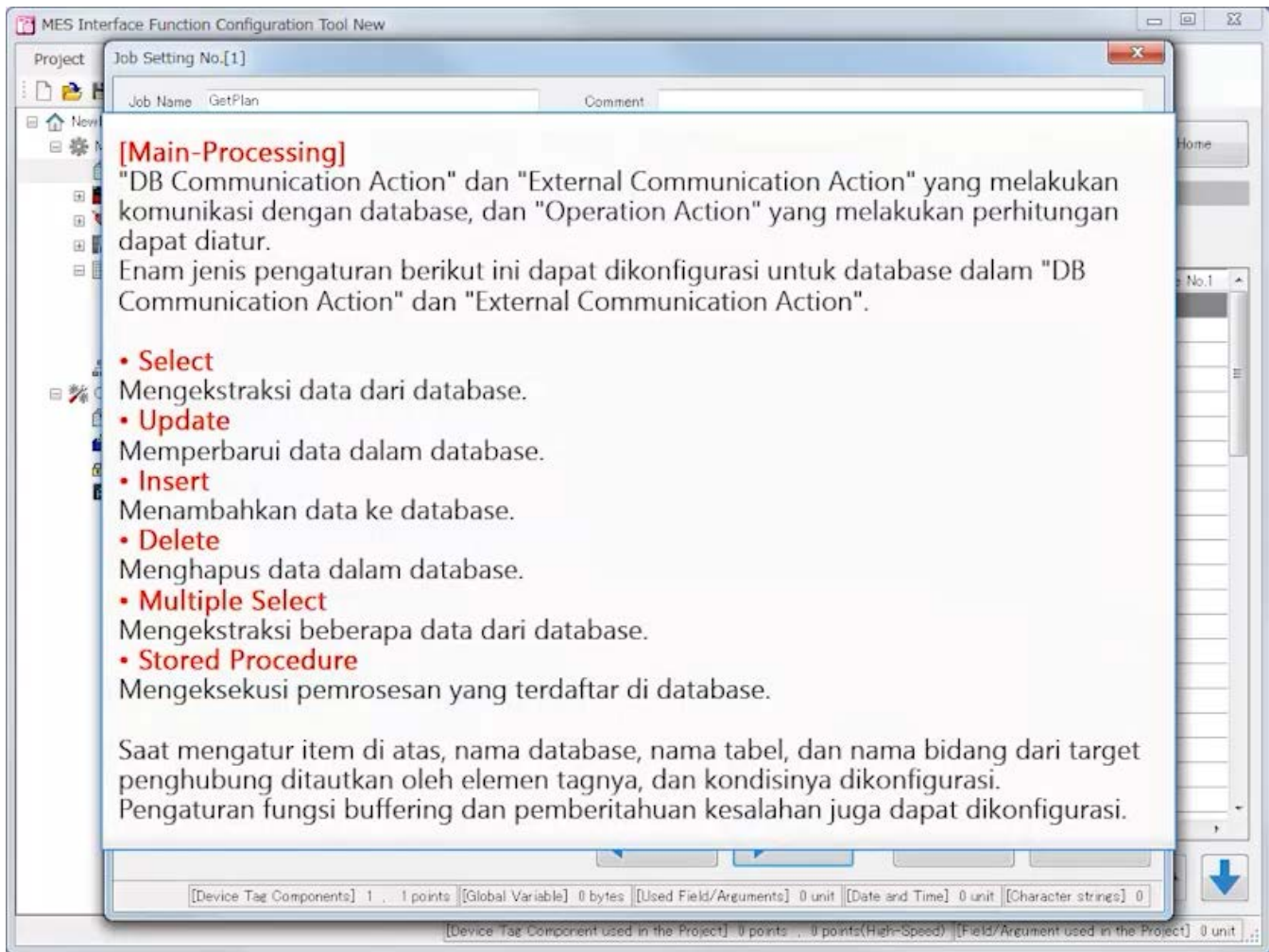
Reading Target Data

Gunakan pengaturan default untuk Read Data at Trigger
Klik tombol **Next**.

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

[Kembali](#)
[Berikutnya](#)


[Kembali](#)[Berikutnya](#)

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

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		

Konfigurasi pengaturan main-processing.
Klik tombol **Edit**.

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings (optional)

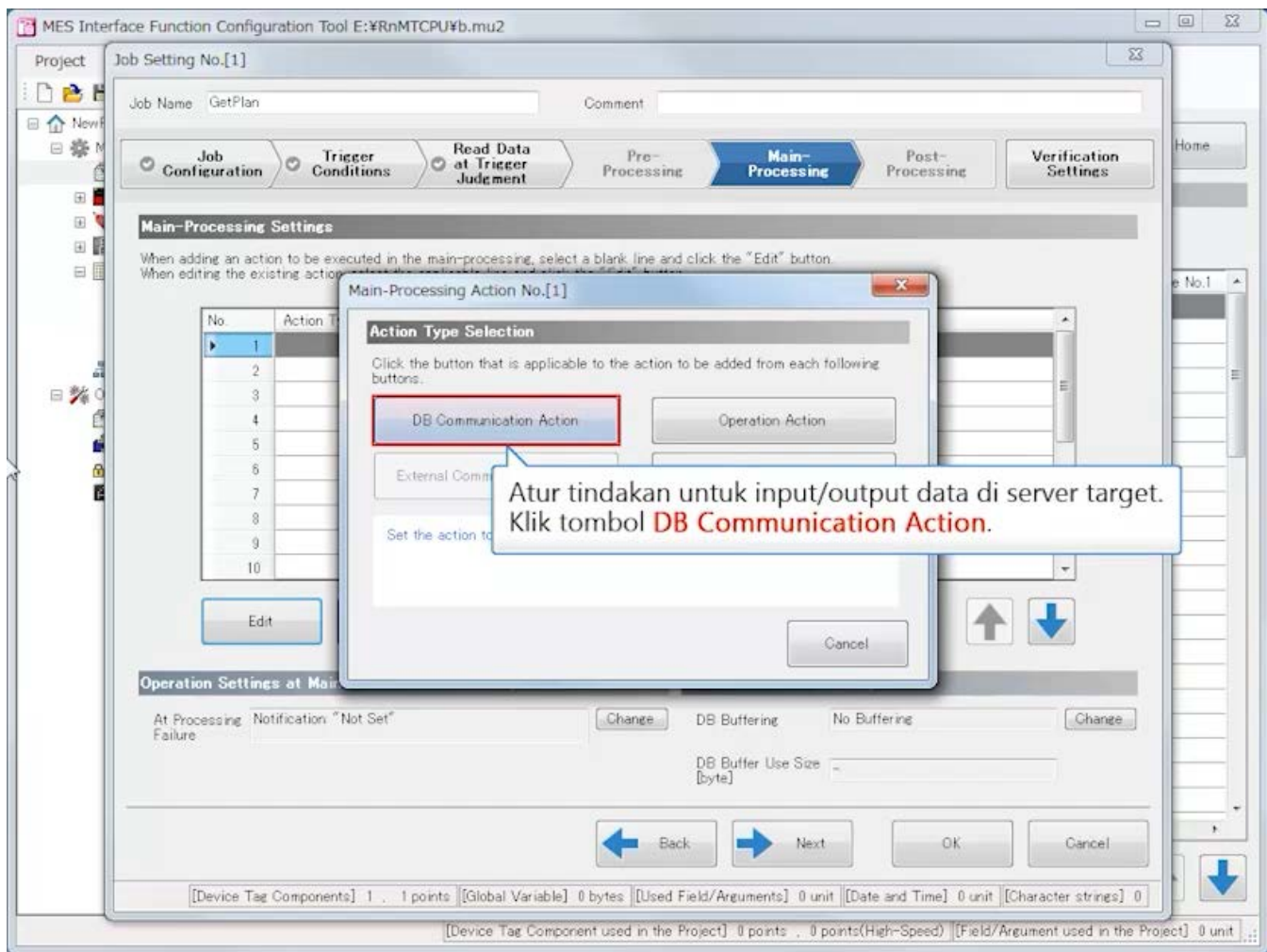
DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

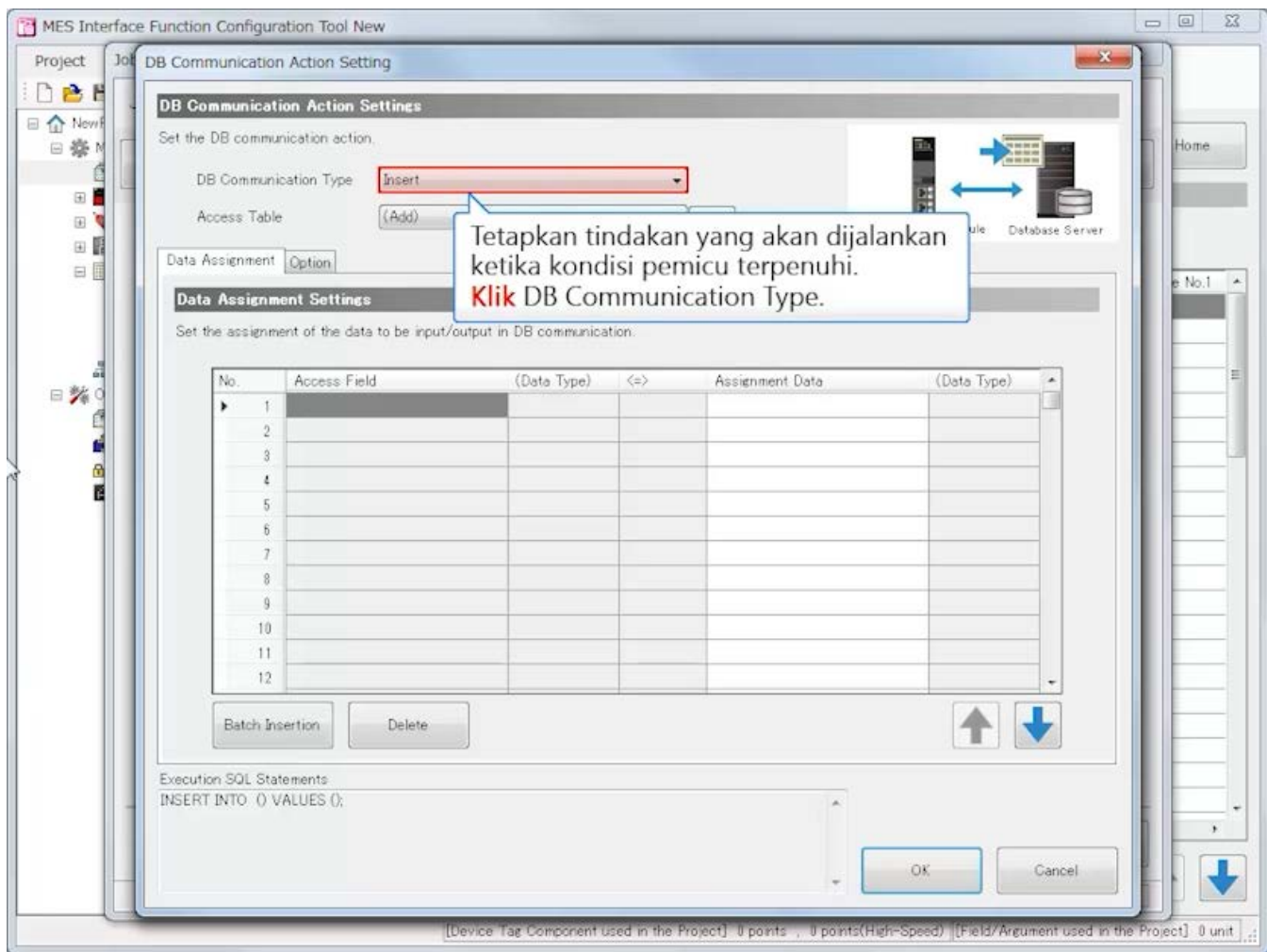
[Device Tag Components] 1 , 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

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

[Kembali](#)
[Berikutnya](#)


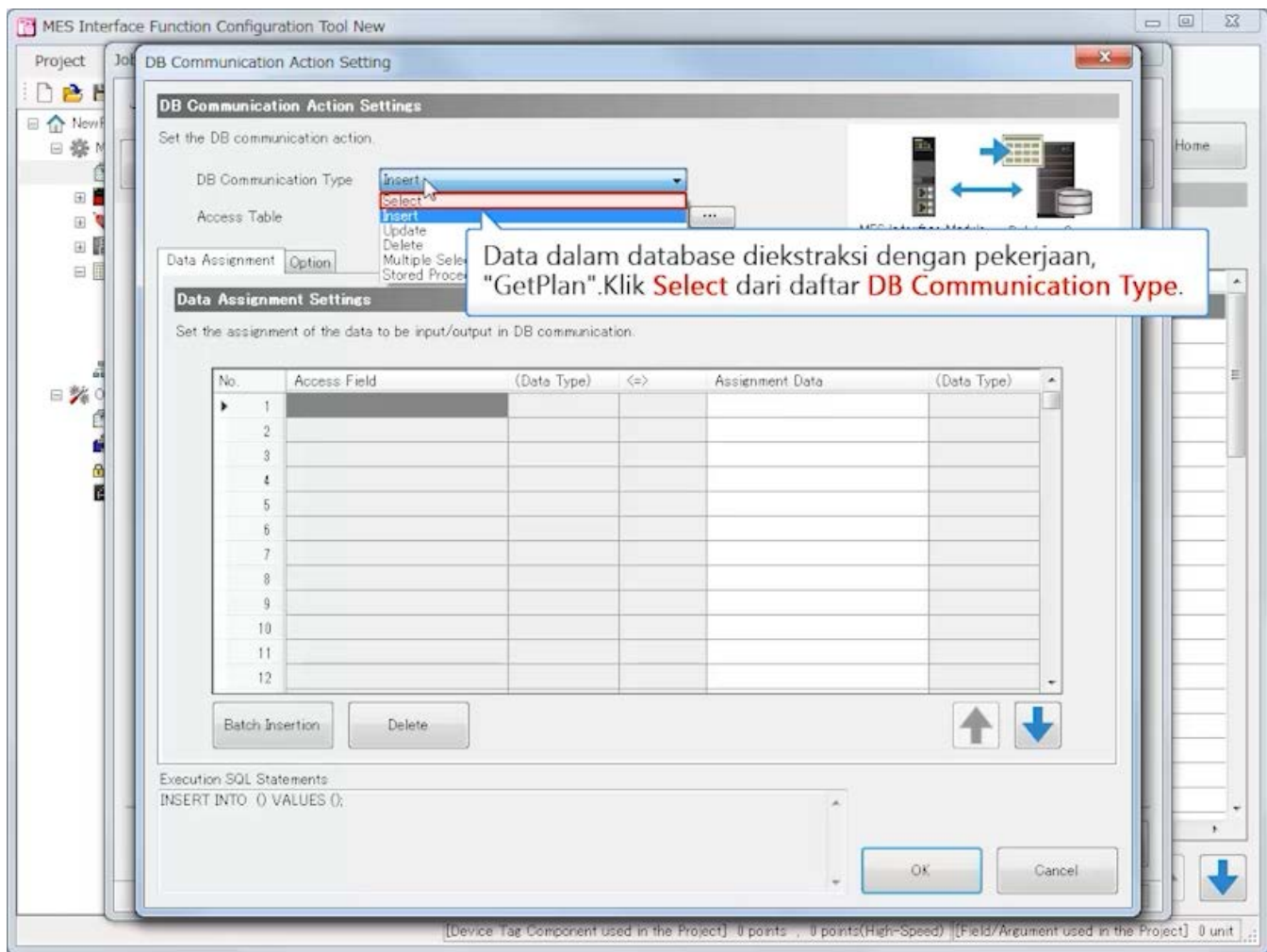
Kembali

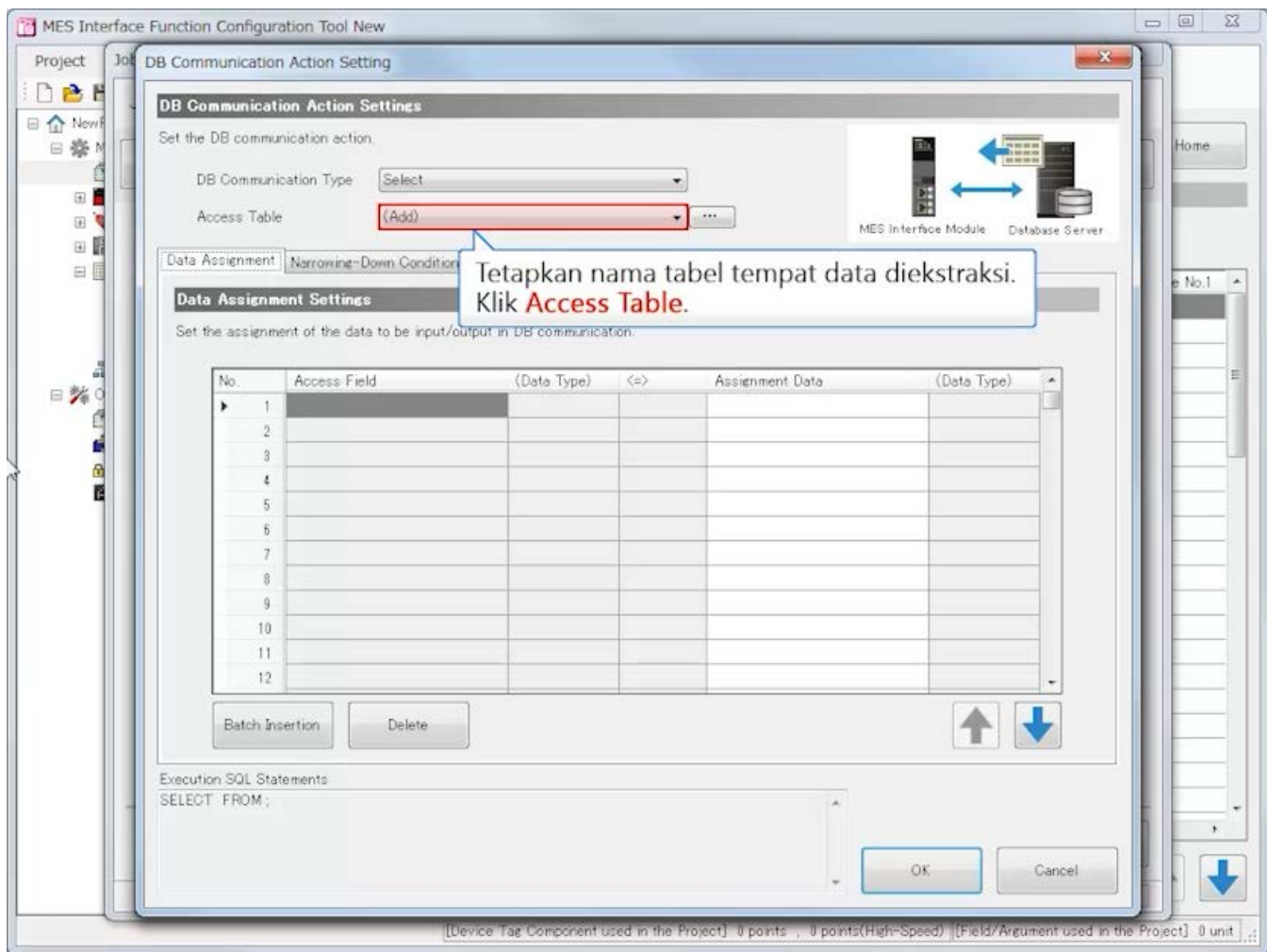
Berikutnya



Kembali

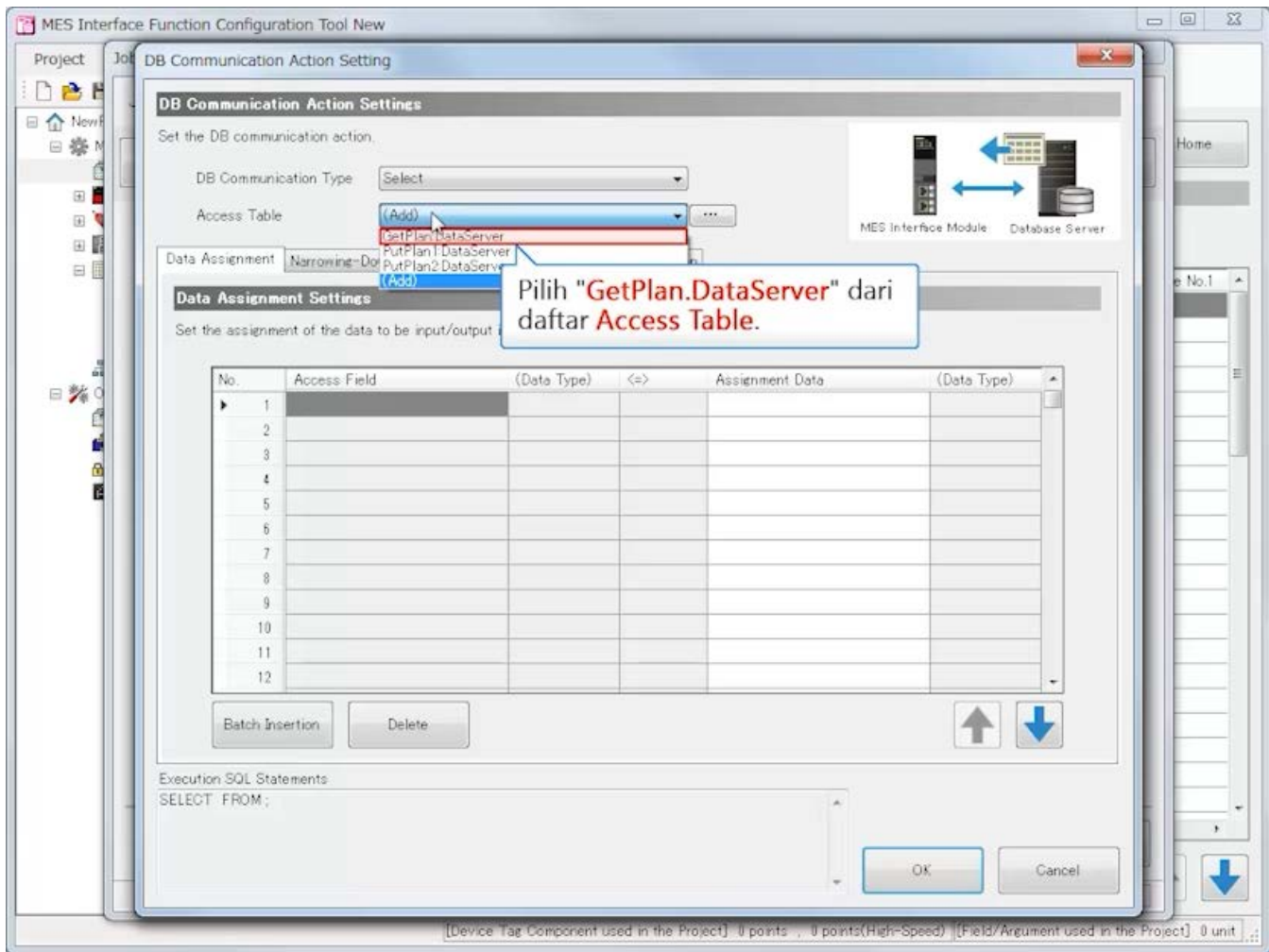
Berikutnya



[Kembali](#)[Berikutnya](#)

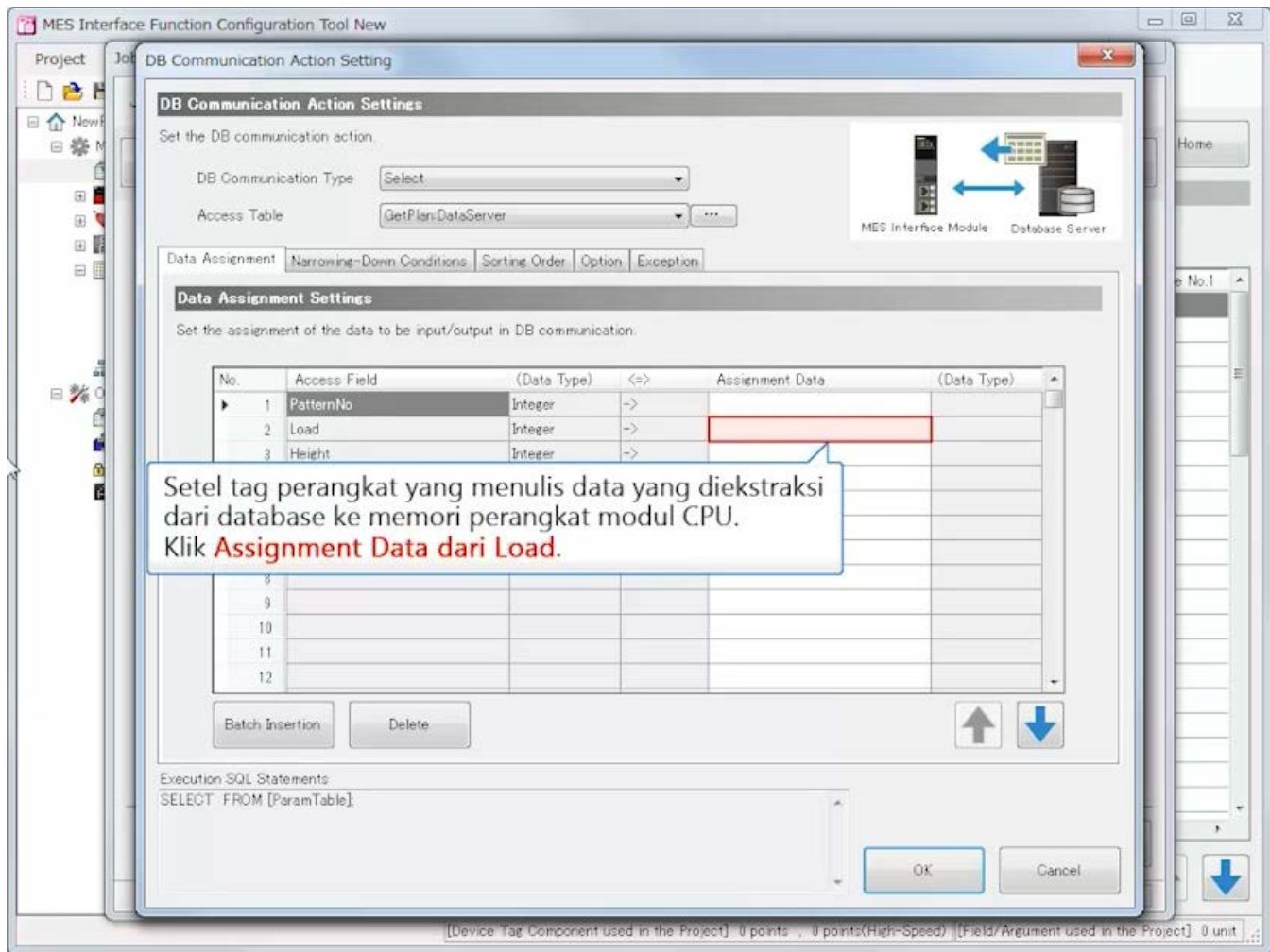
Kembali

Berikutnya



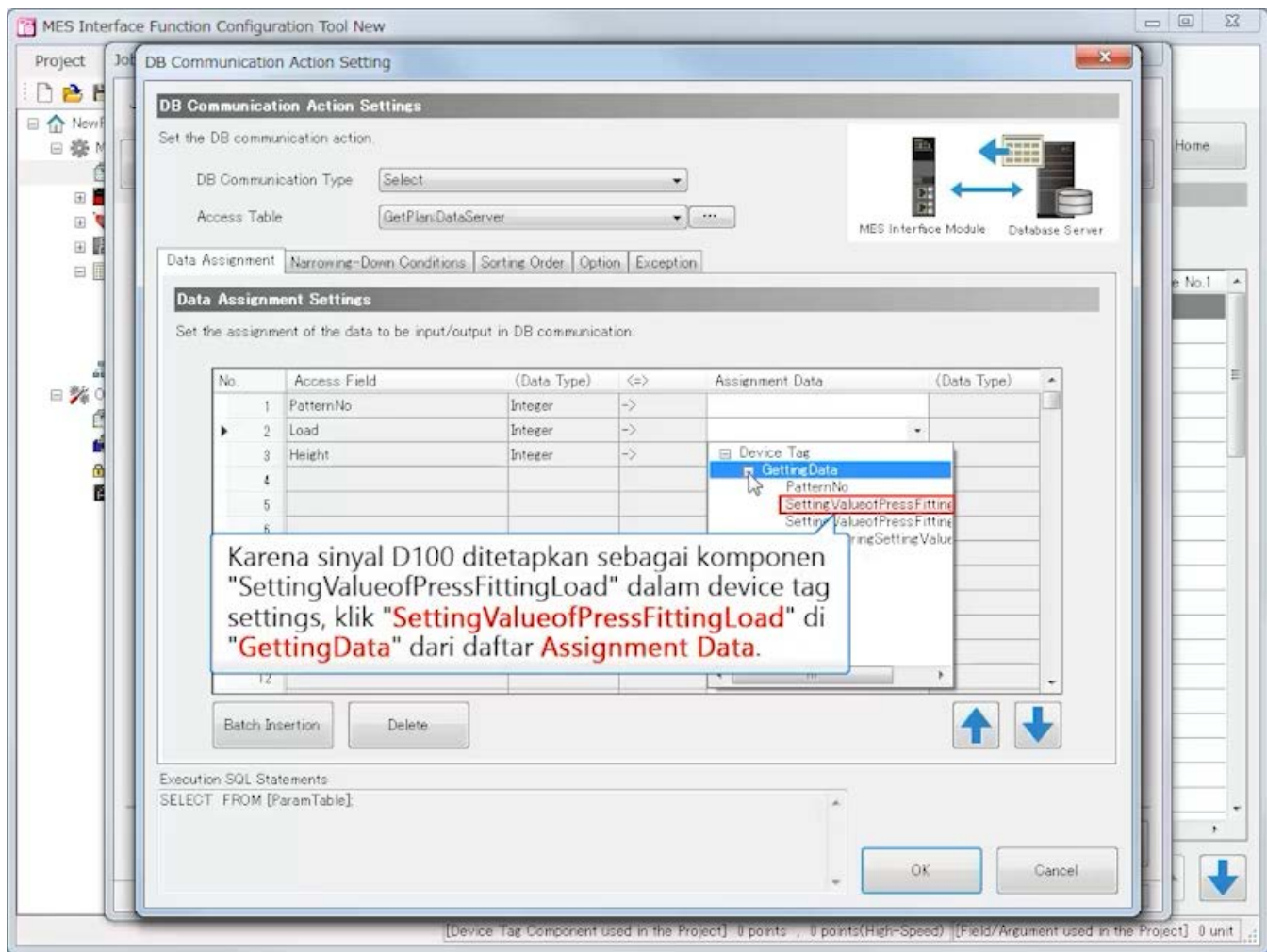
Kembali

Berikutnya



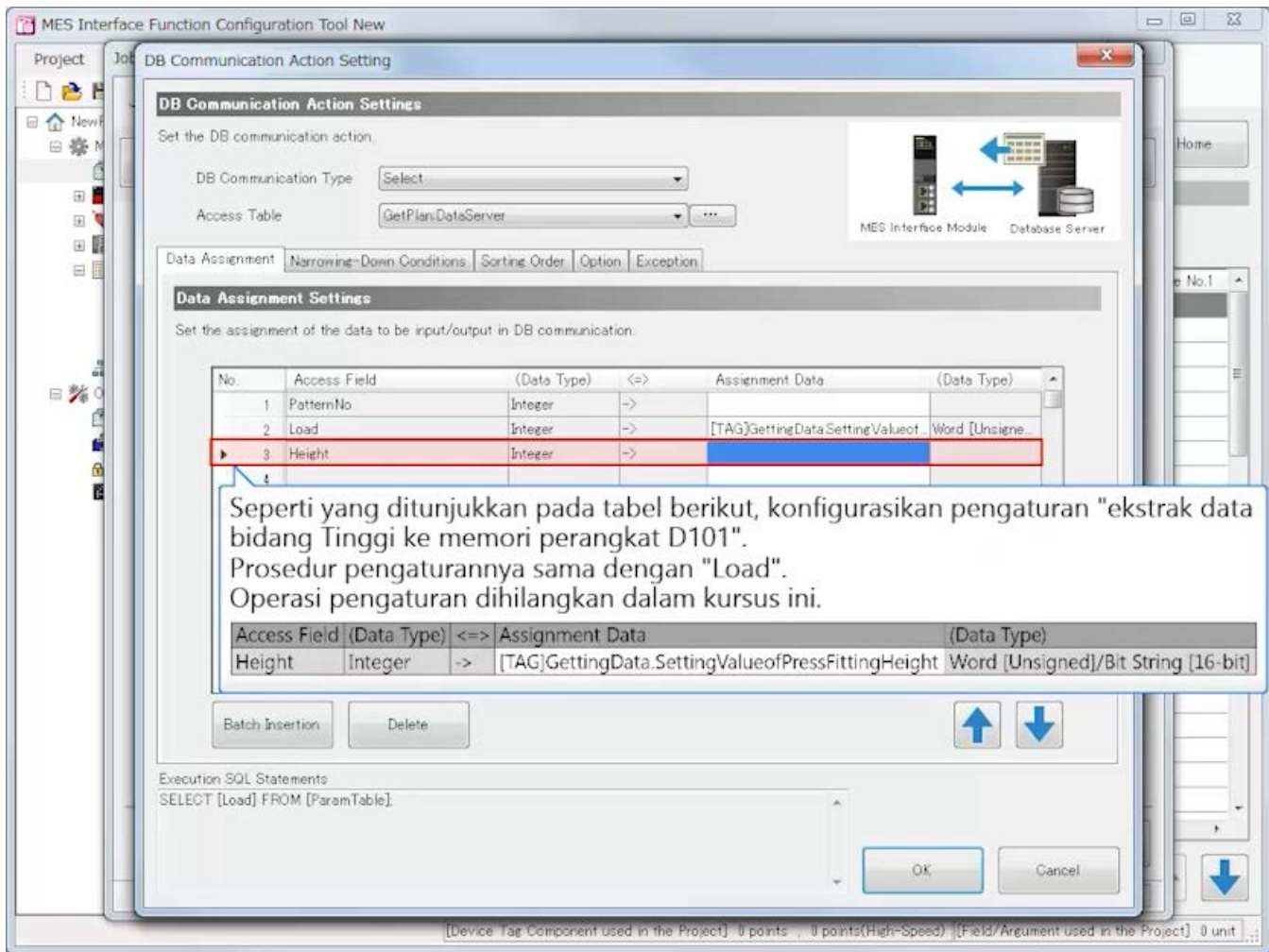
Kembali

Berikutnya



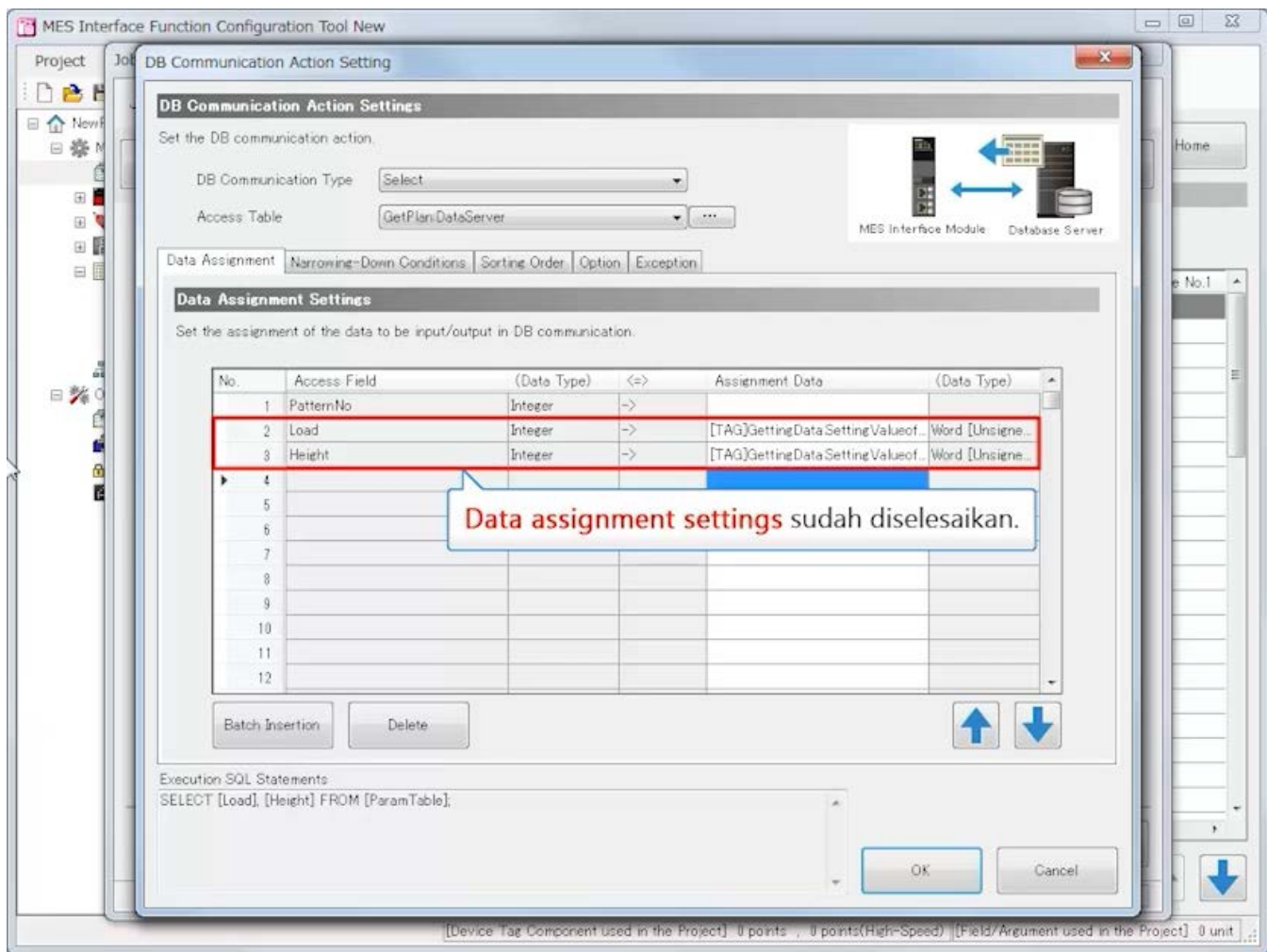
Kembali

Berikutnya



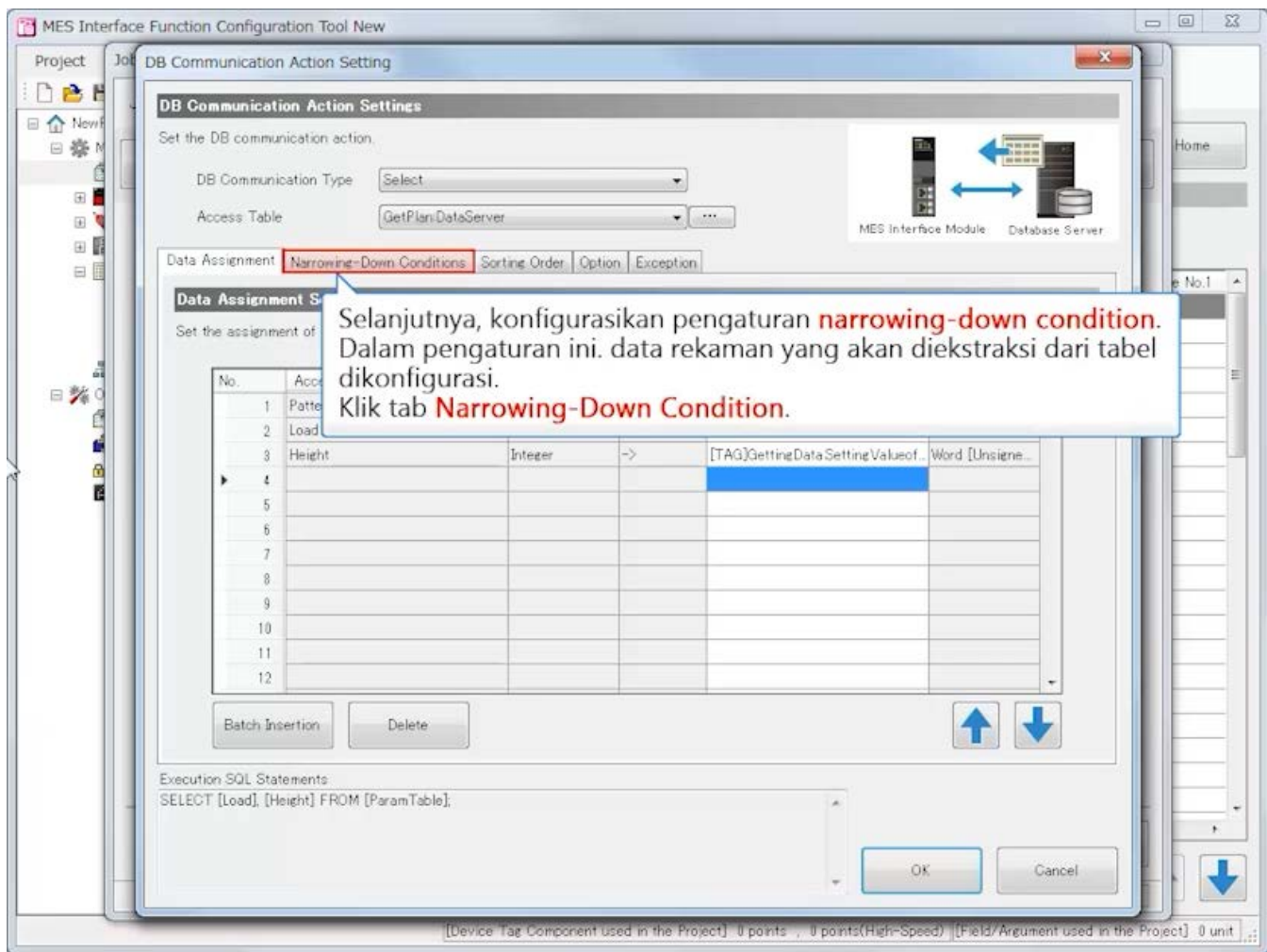
Kembali

Berikutnya



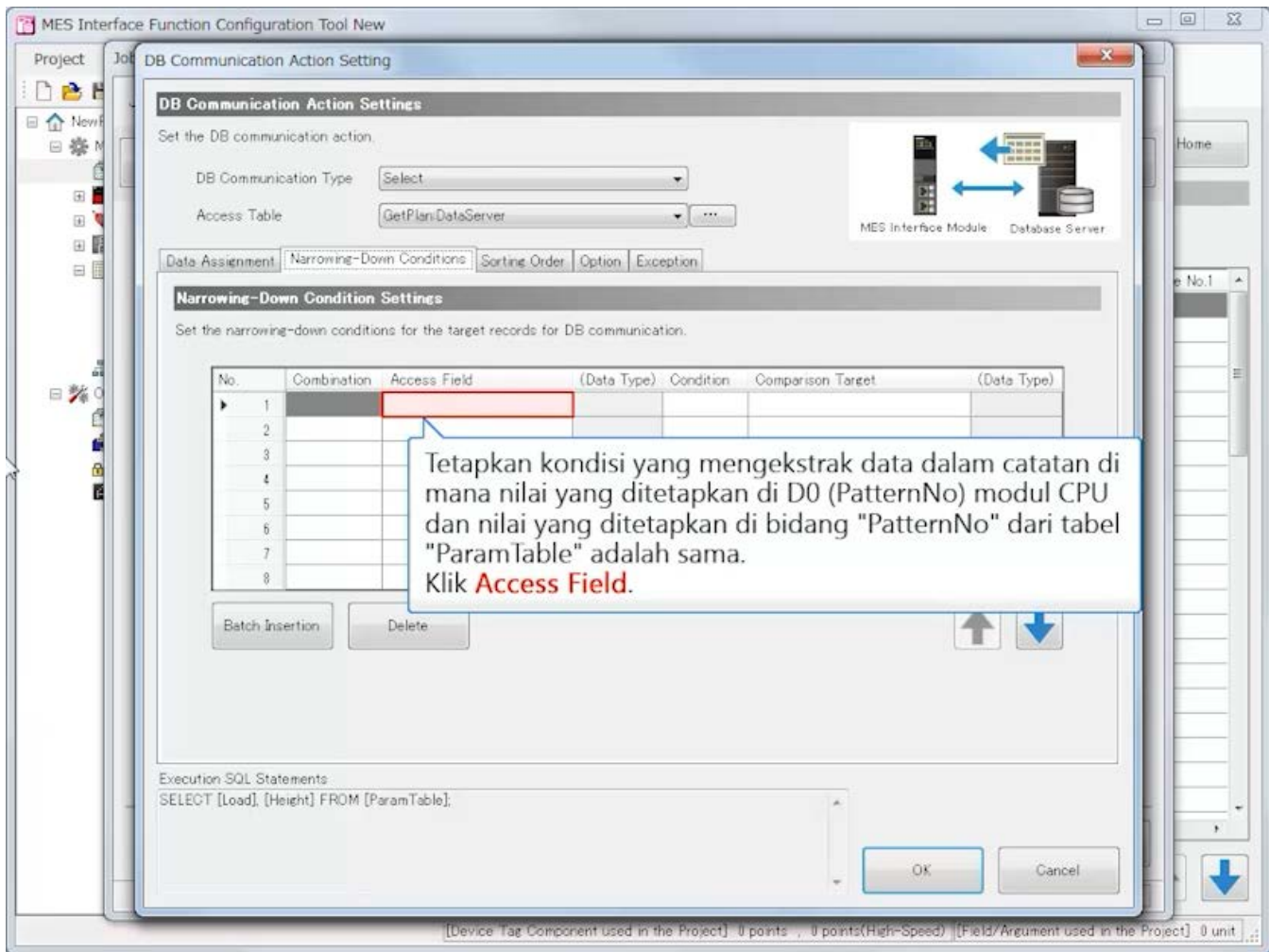
Kembali

Berikutnya



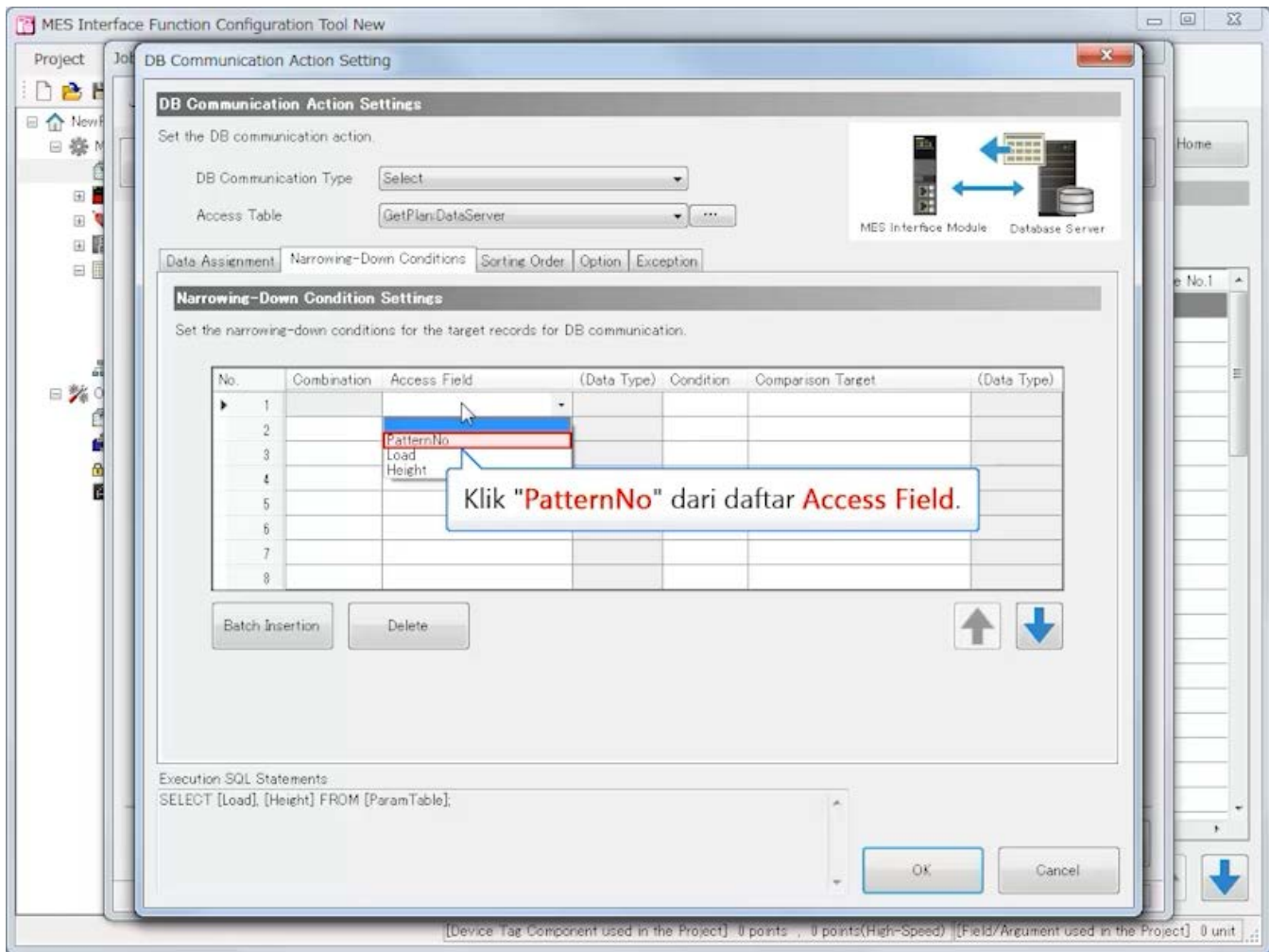
Kembali

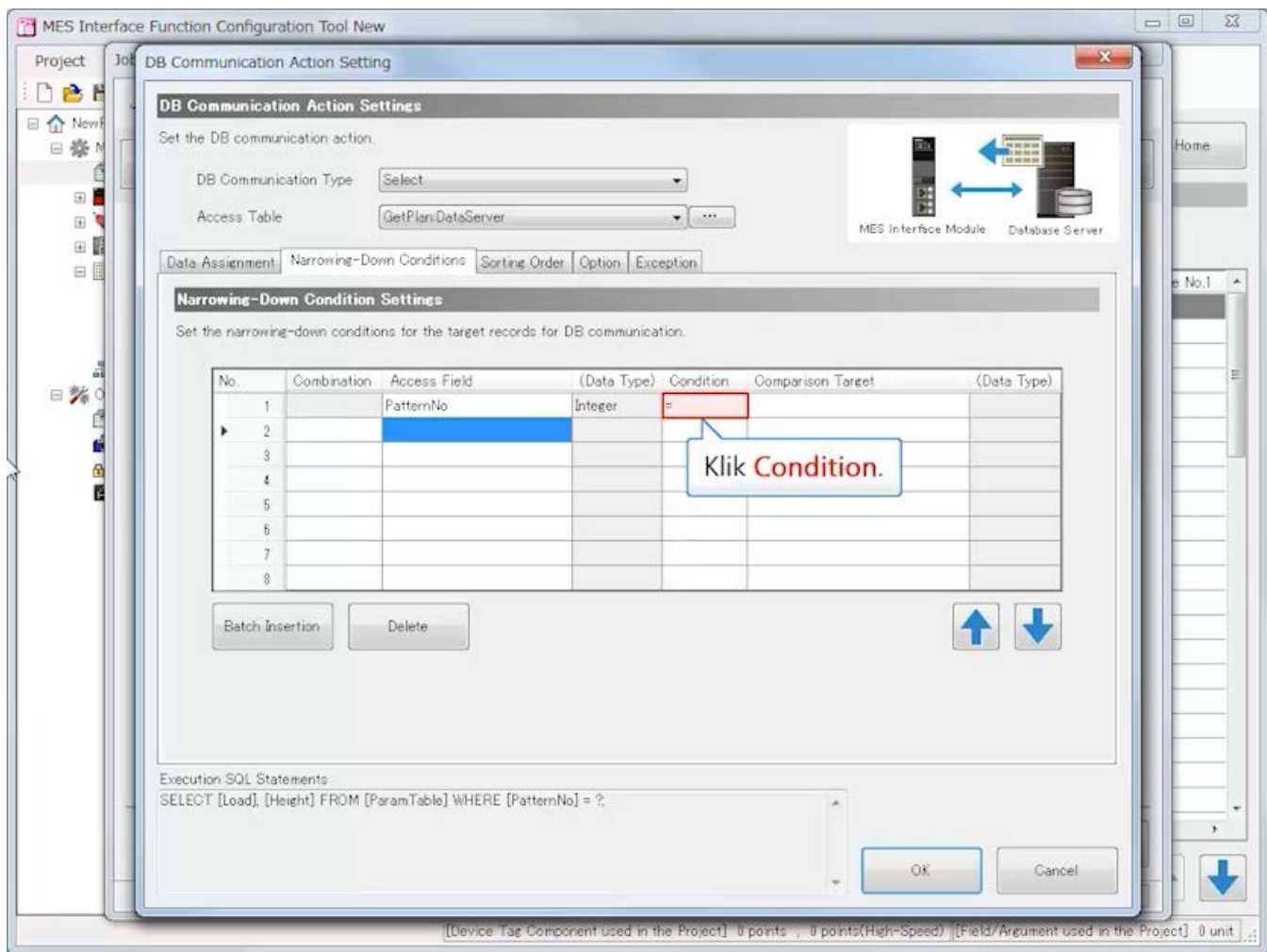
Berikutnya



Kembali

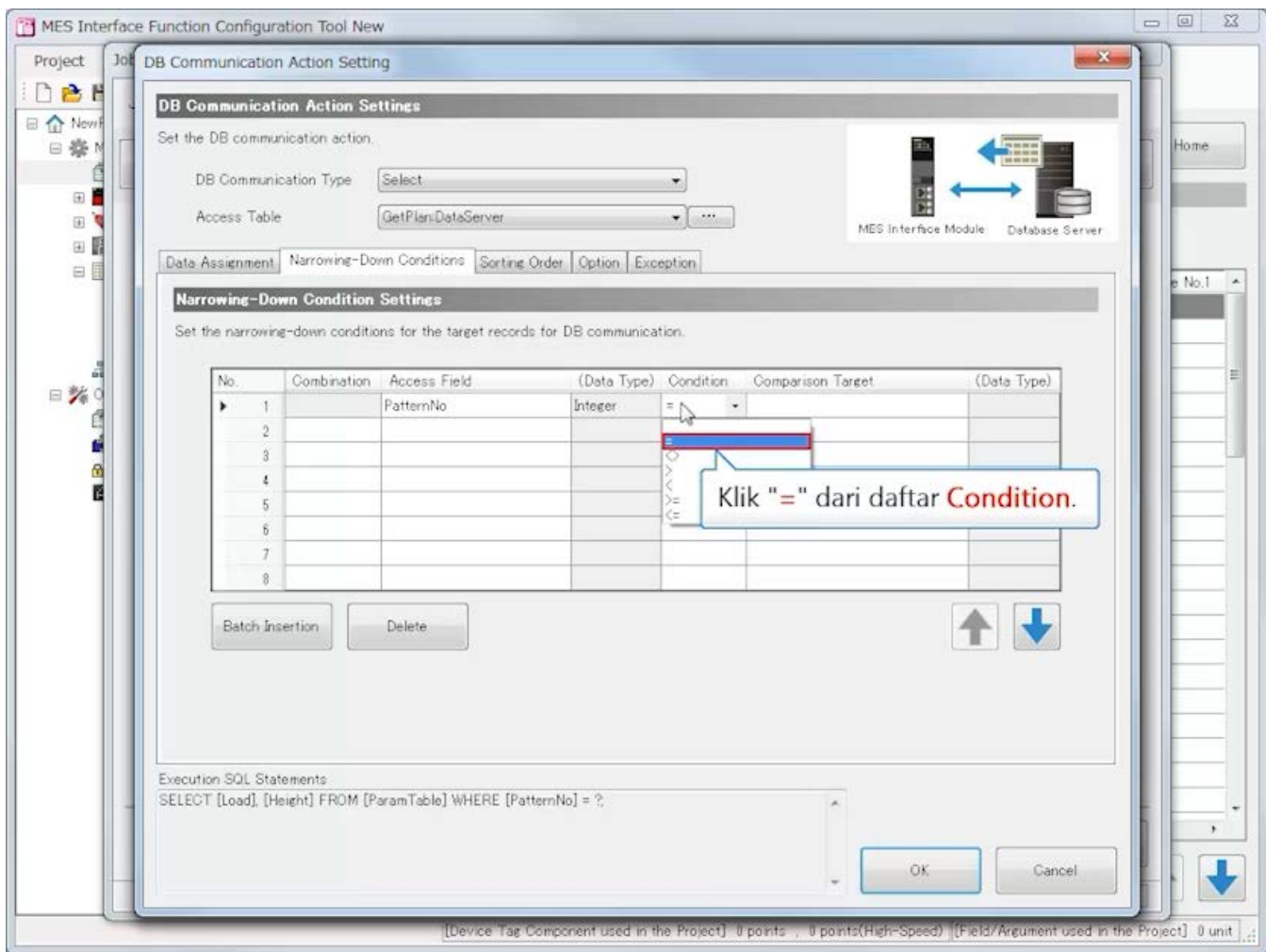
Berikutnya



[Kembali](#)
[Berikutnya](#)


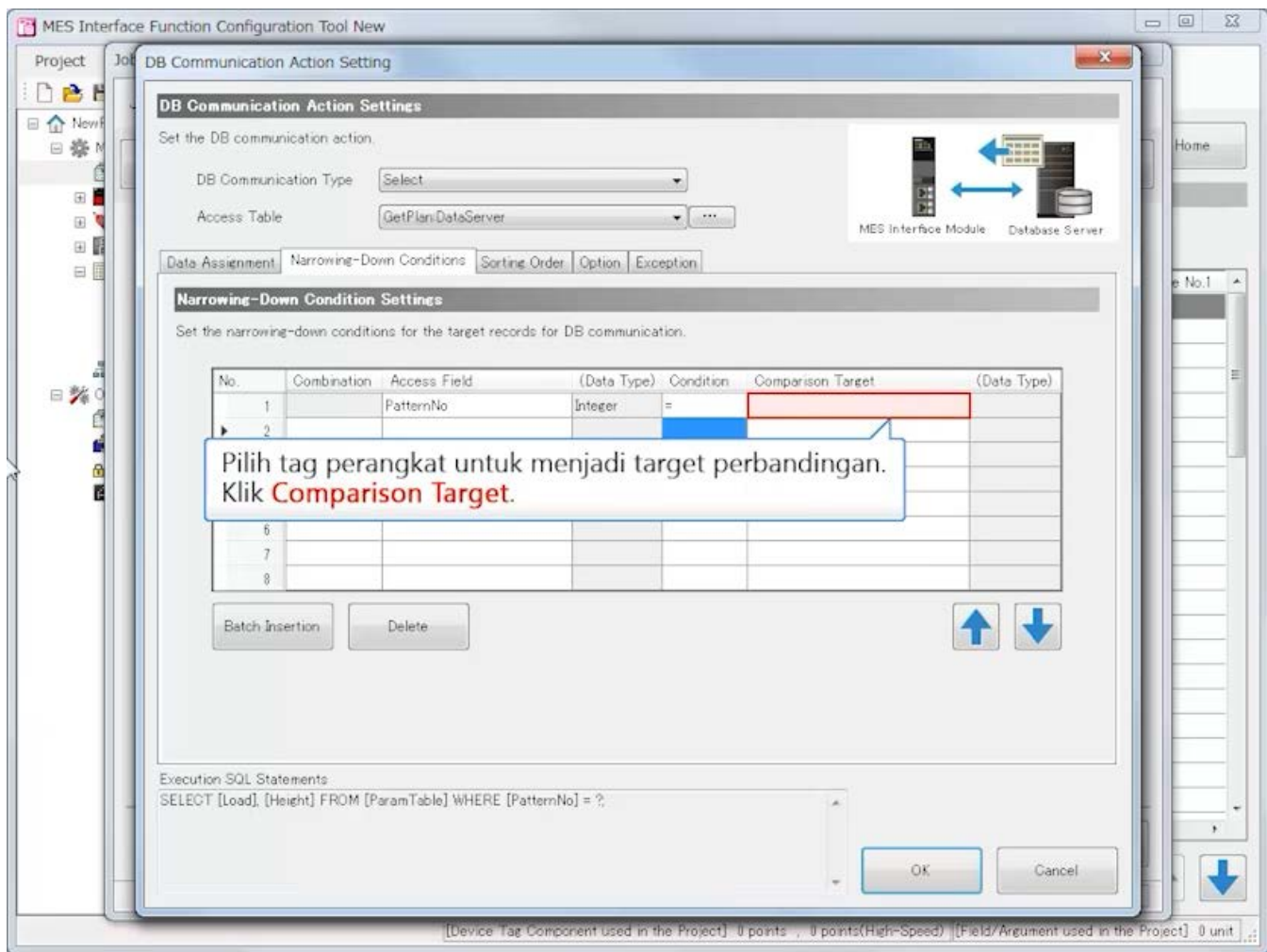
Kembali

Berikutnya



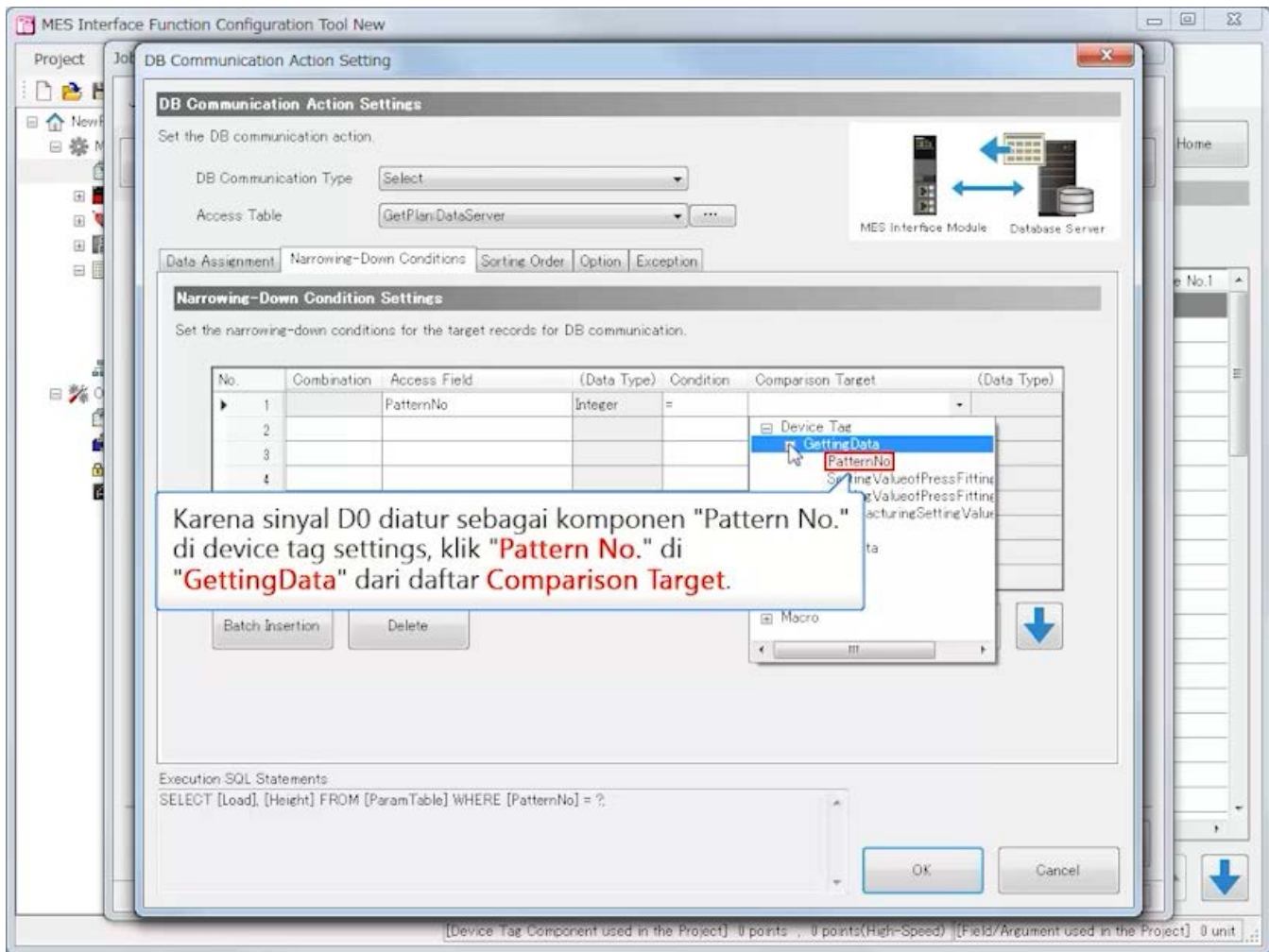
Kembali

Berikutnya



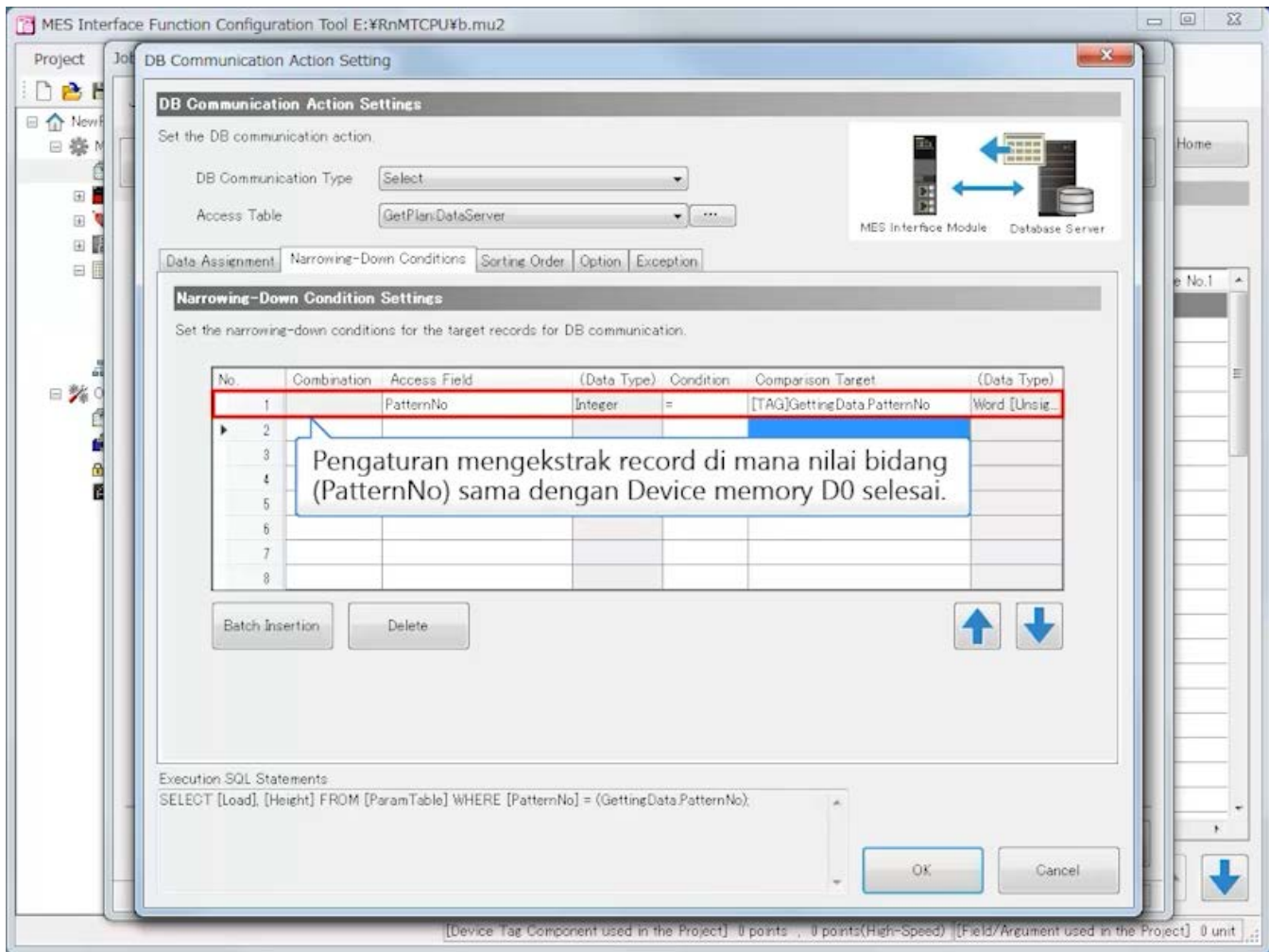
Kembali

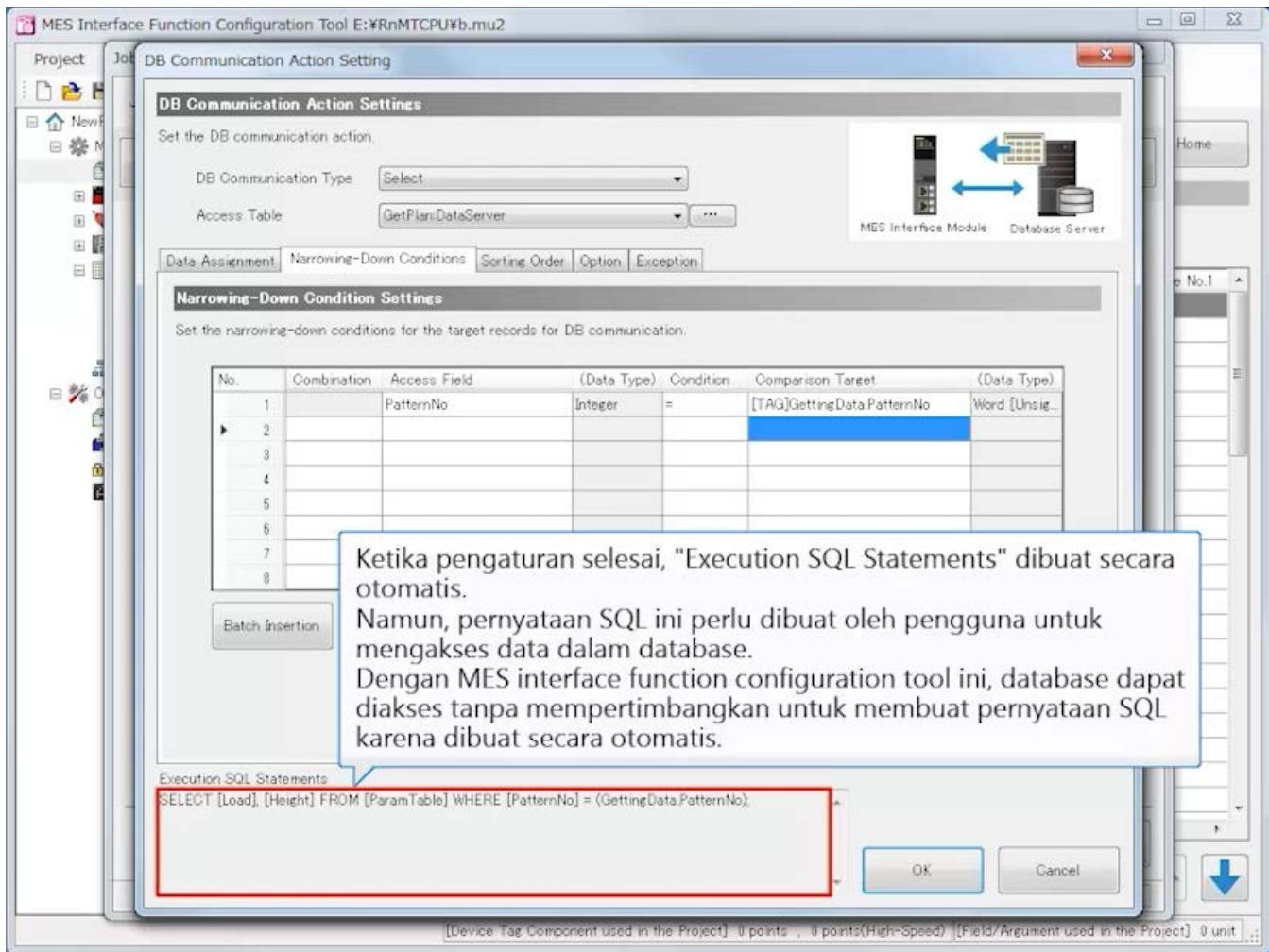
Berikutnya



Kembali

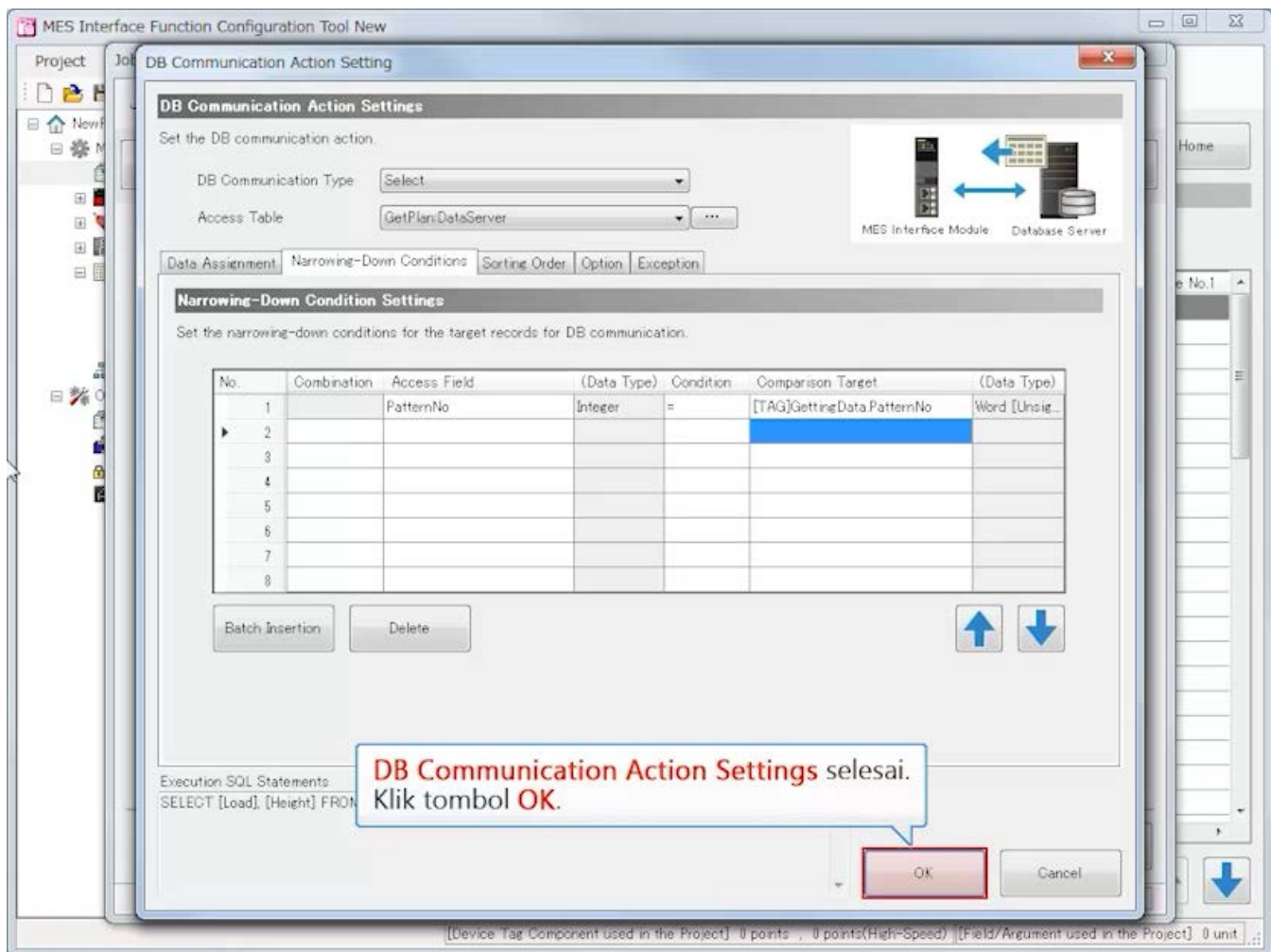
Berikutnya



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[Berikutnya](#)


Kembali

Berikutnya



Kembali

Berikutnya

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

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

Base Size

Klik Next.

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

[Kembali](#)[Berikutnya](#)

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.

Pengaturan default digunakan untuk Verification Settings.
Klik tombol **OK**.

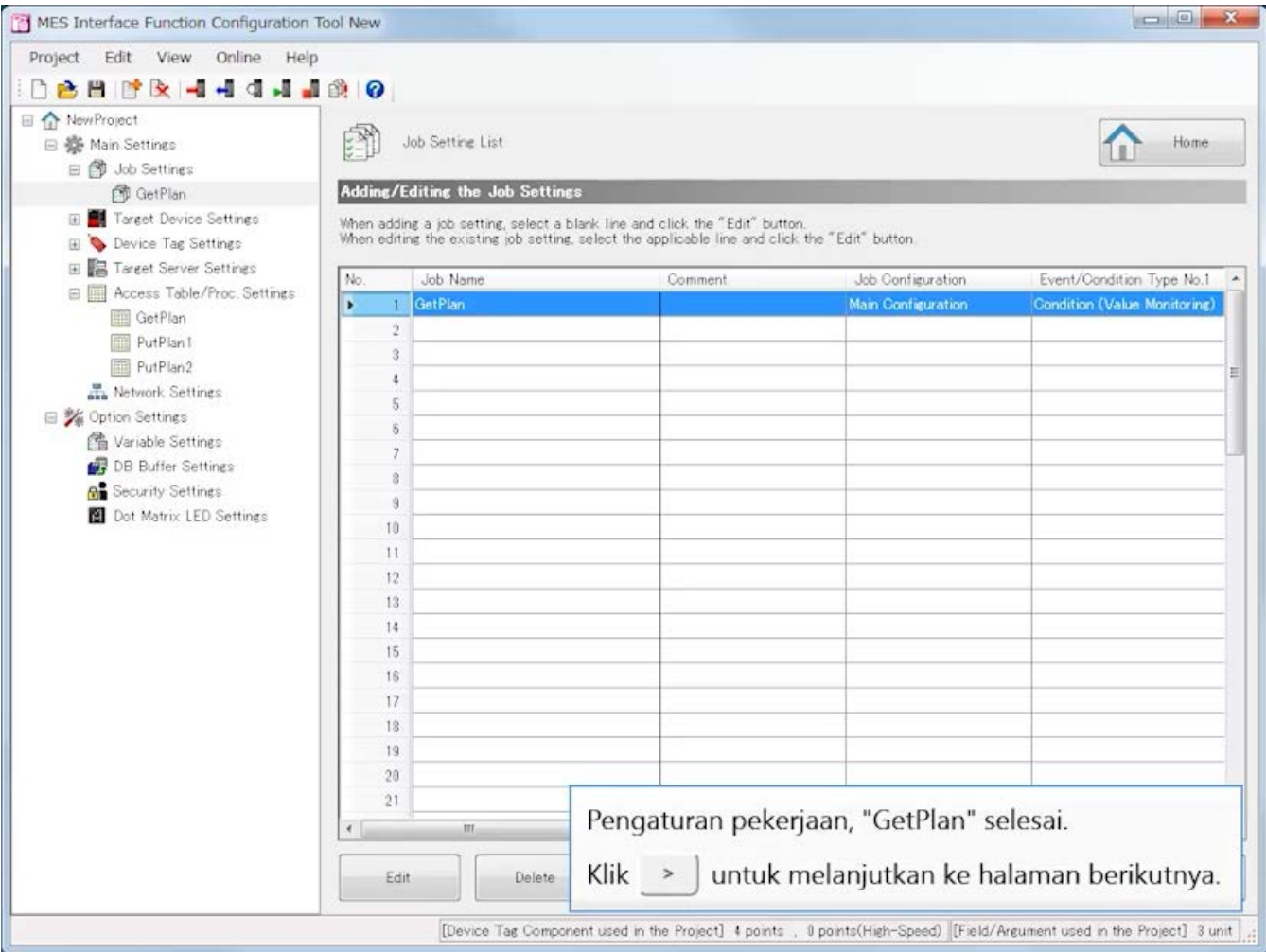
Back Next OK Cancel

[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

Kembali

Berikutnya



The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like '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 'Job Settings' category is selected, and the 'Job Setting List' table is displayed in the main area. The table has columns: 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. The first row is highlighted with '1' in the 'No.' column, 'GetPlan' in the 'Job Name' column, and 'Condition (Value Monitoring)' in the 'Event/Condition Type No.1' column. Below the table are 'Edit' and 'Delete' buttons. A text box at the bottom right contains the instruction: 'Pengaturan pekerjaan, "GetPlan" selesai. Klik > untuk melanjutkan ke halaman berikutnya.' The status bar at the bottom shows '[Device Tag Component used in the Project] 4 points , 0 points(High-Speed) [Field/Argument used in the Project] 3 unit'.

MES Interface Function Configuration Tool New

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				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

Pengaturan pekerjaan, "GetPlan" selesai.
Klik > untuk melanjutkan ke halaman berikutnya.

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

[Job Settings]

Membuat pekerjaan yang menulis catatan ke database saat memulai pembuatan.

(2) Job Name: PutPlan1

[Job Configuration]

Job Configuration: Main Configuration

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

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

[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 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 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] 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.

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 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

Tab Data Assignment

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

Untuk mengonfigurasi buffering DB, pilih "Gunakan buffer DB 1." di [Pengaturan Buffer DB] dari [Pengaturan Opsi] terlebih dahulu.

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

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 : Jangan dipilih
Inhibit the data output to the target server : Jangan dipilih
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: Jangan dipilih

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.

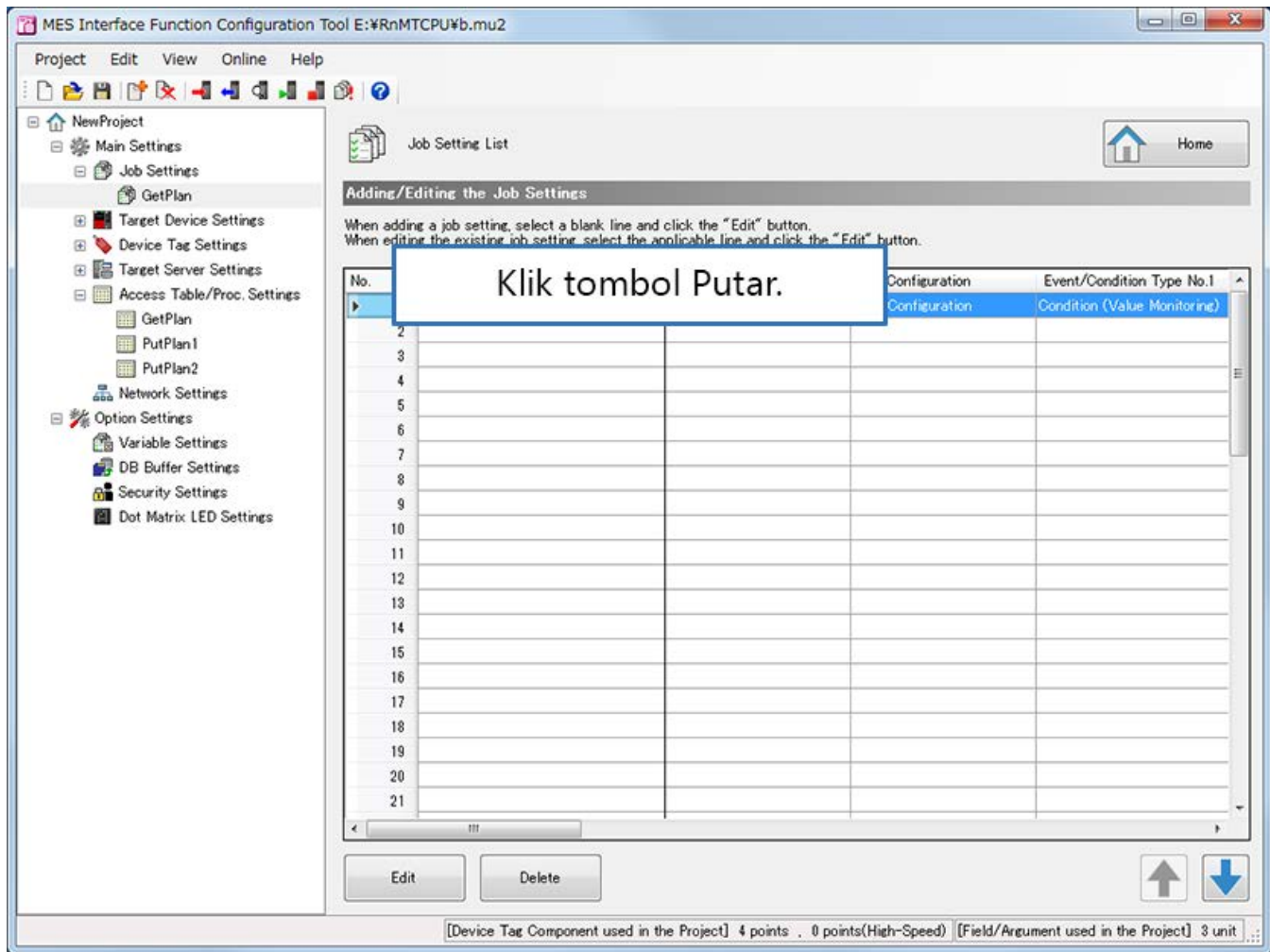
☐ Inhibit the job execution even when the trigger condition is satisfied.

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

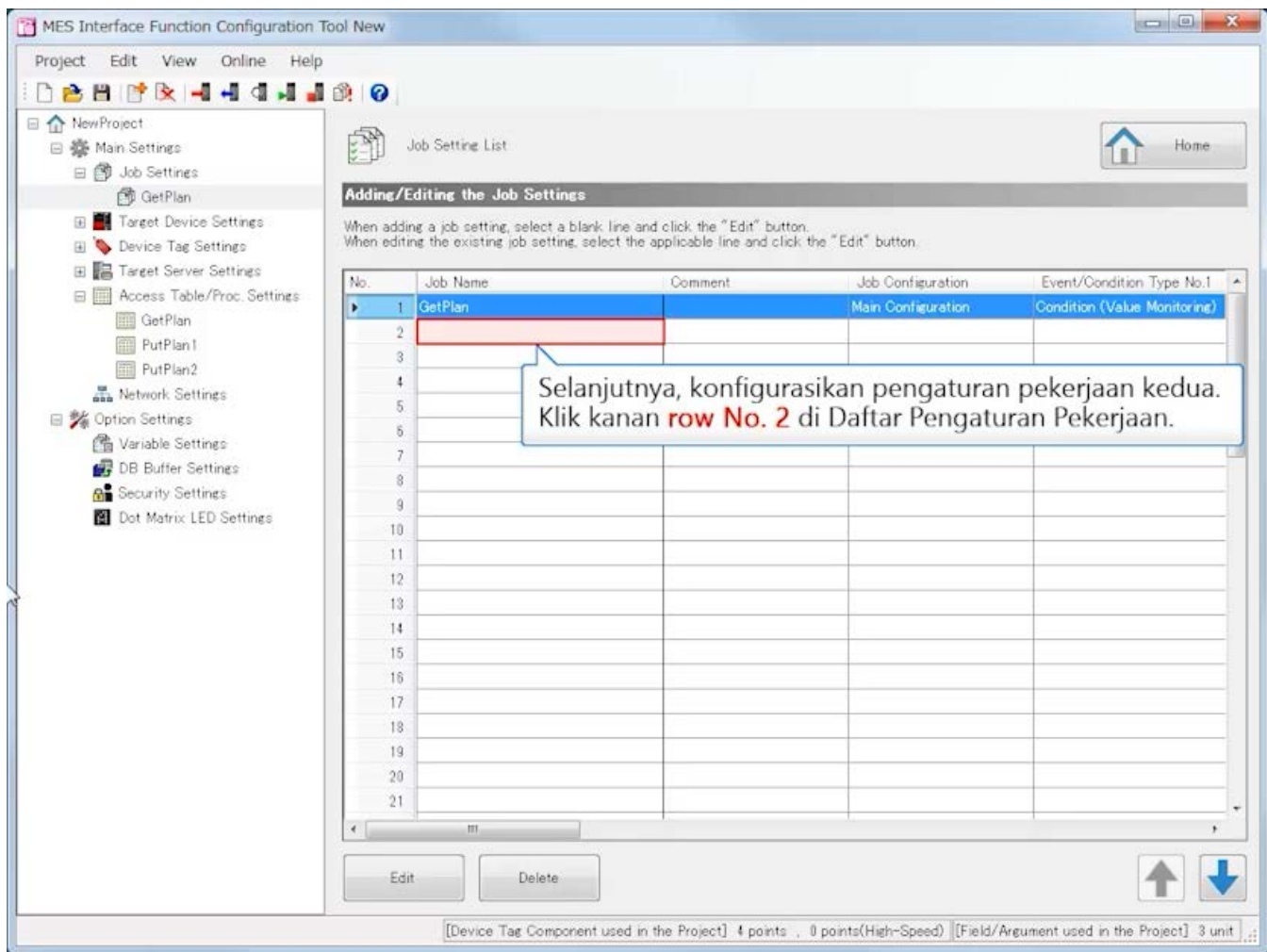
Kembali

Berikutnya



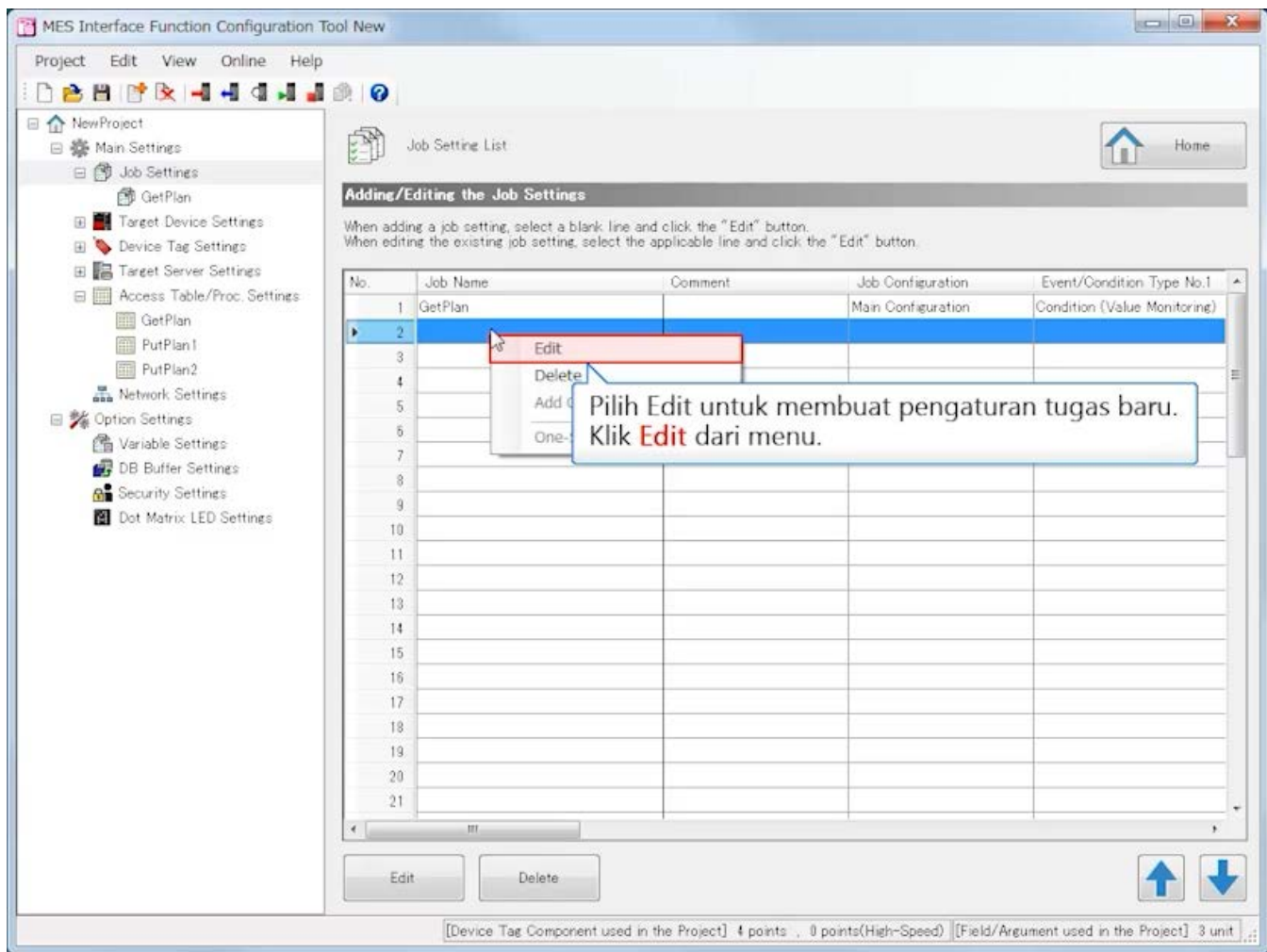
Kembali

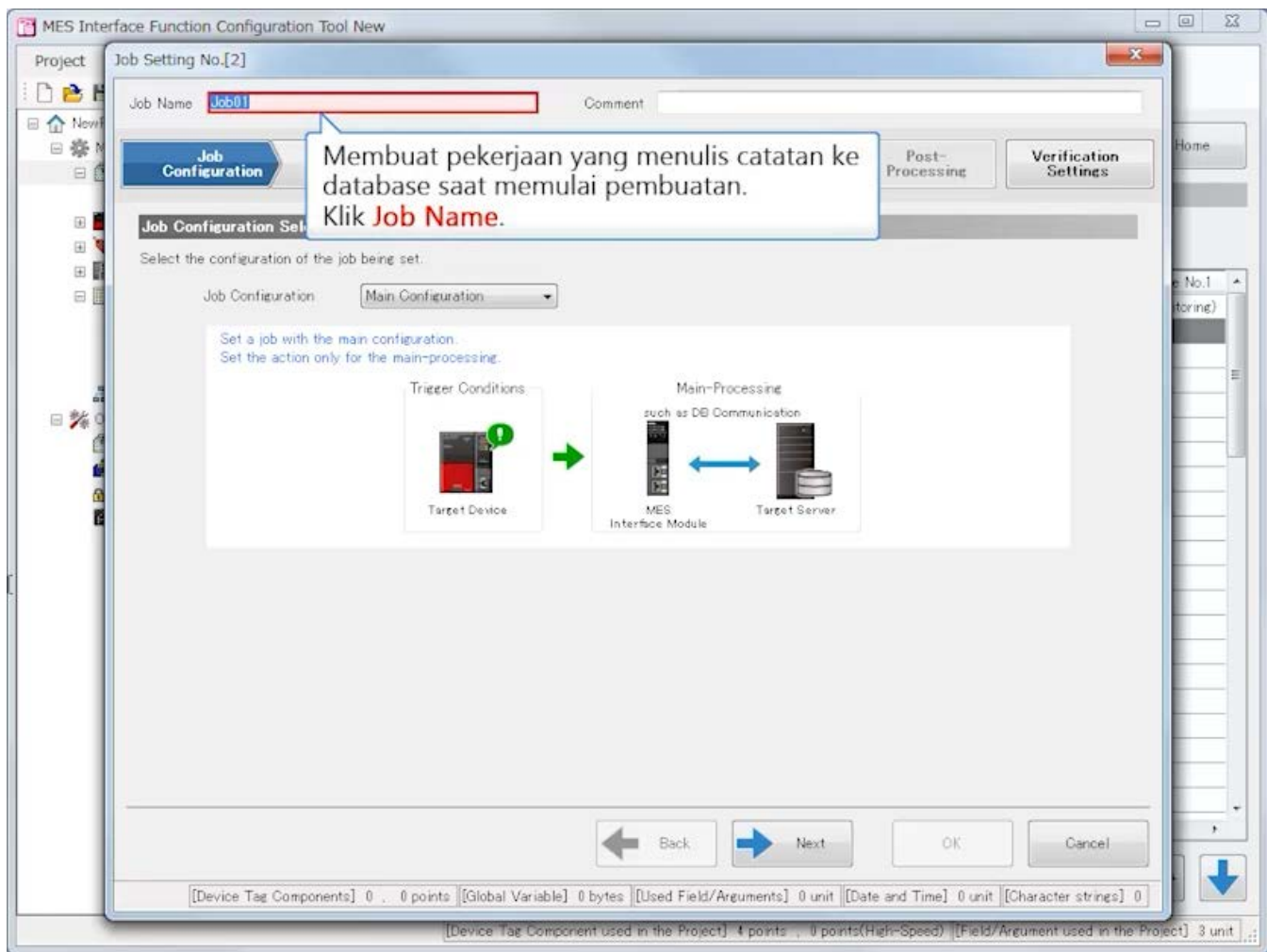
Berikutnya

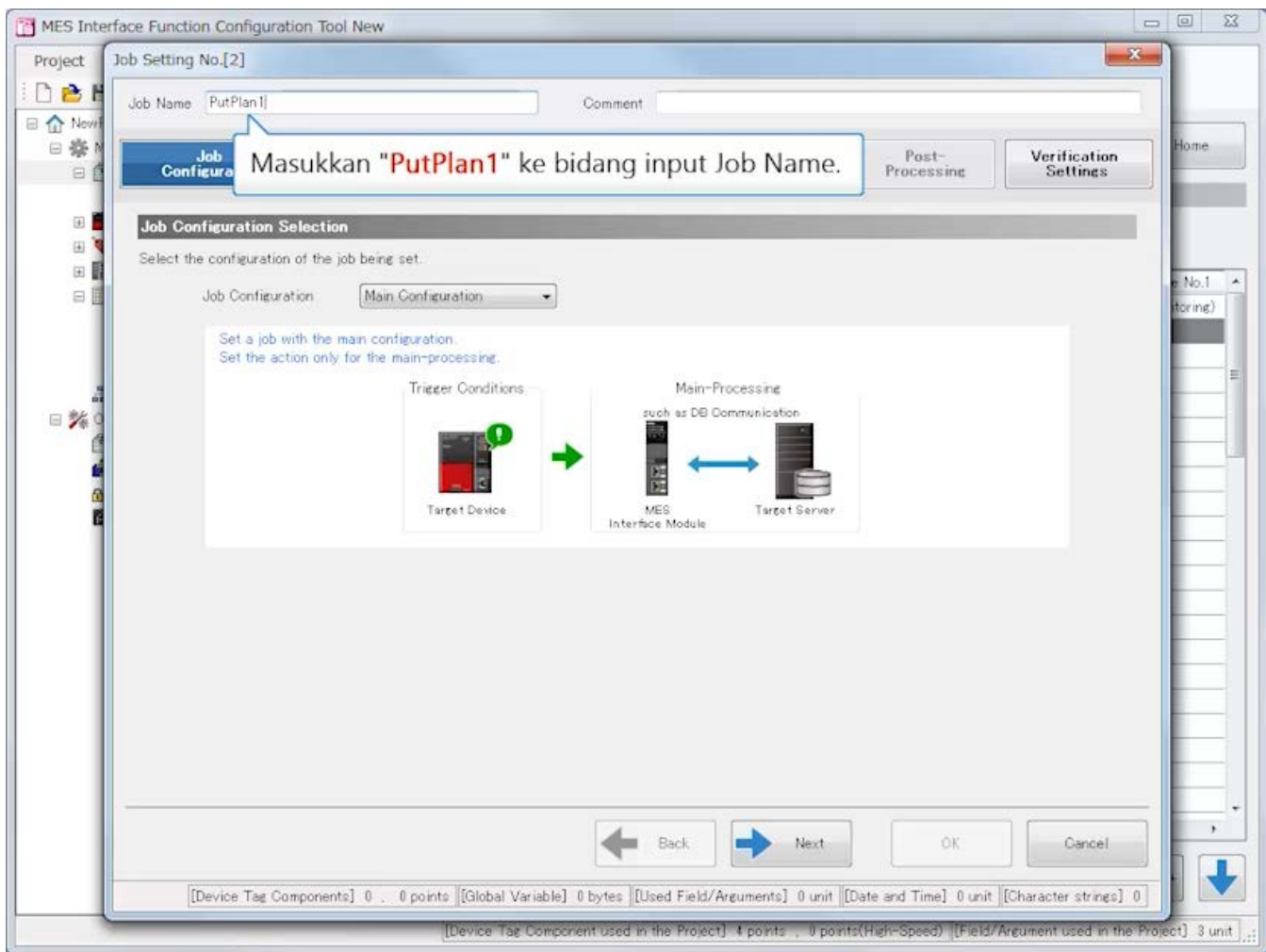


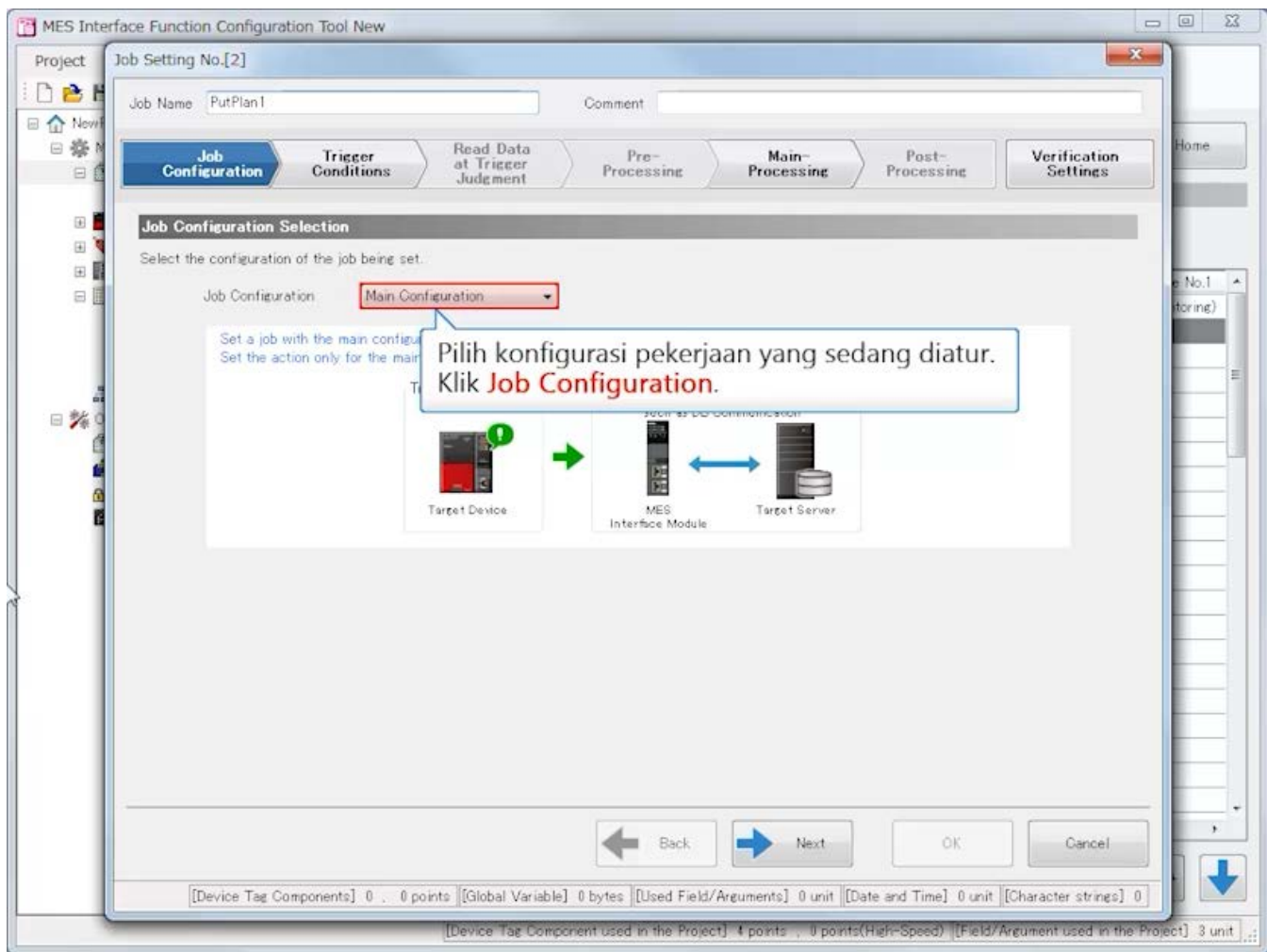
Kembali

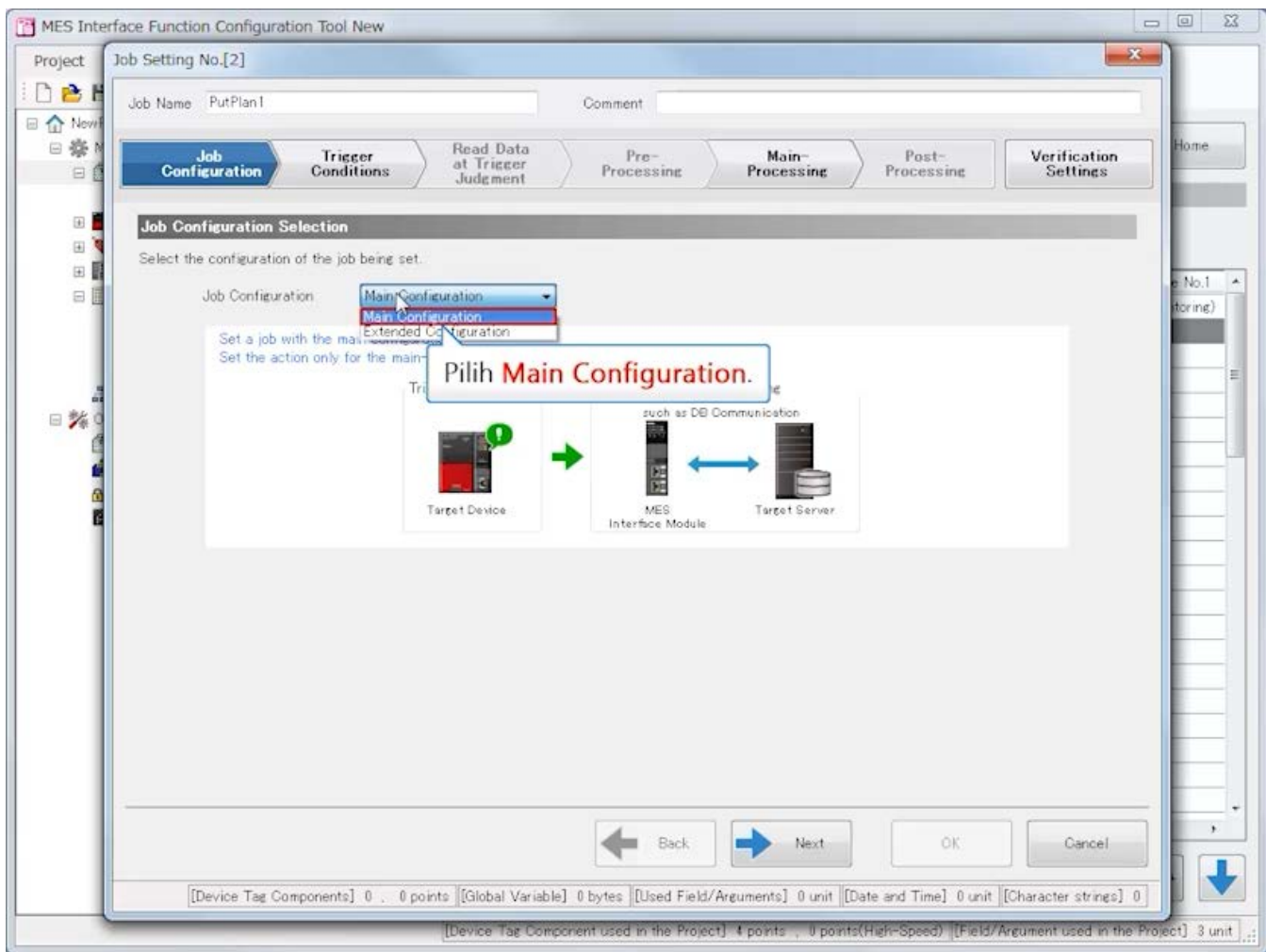
Berikutnya

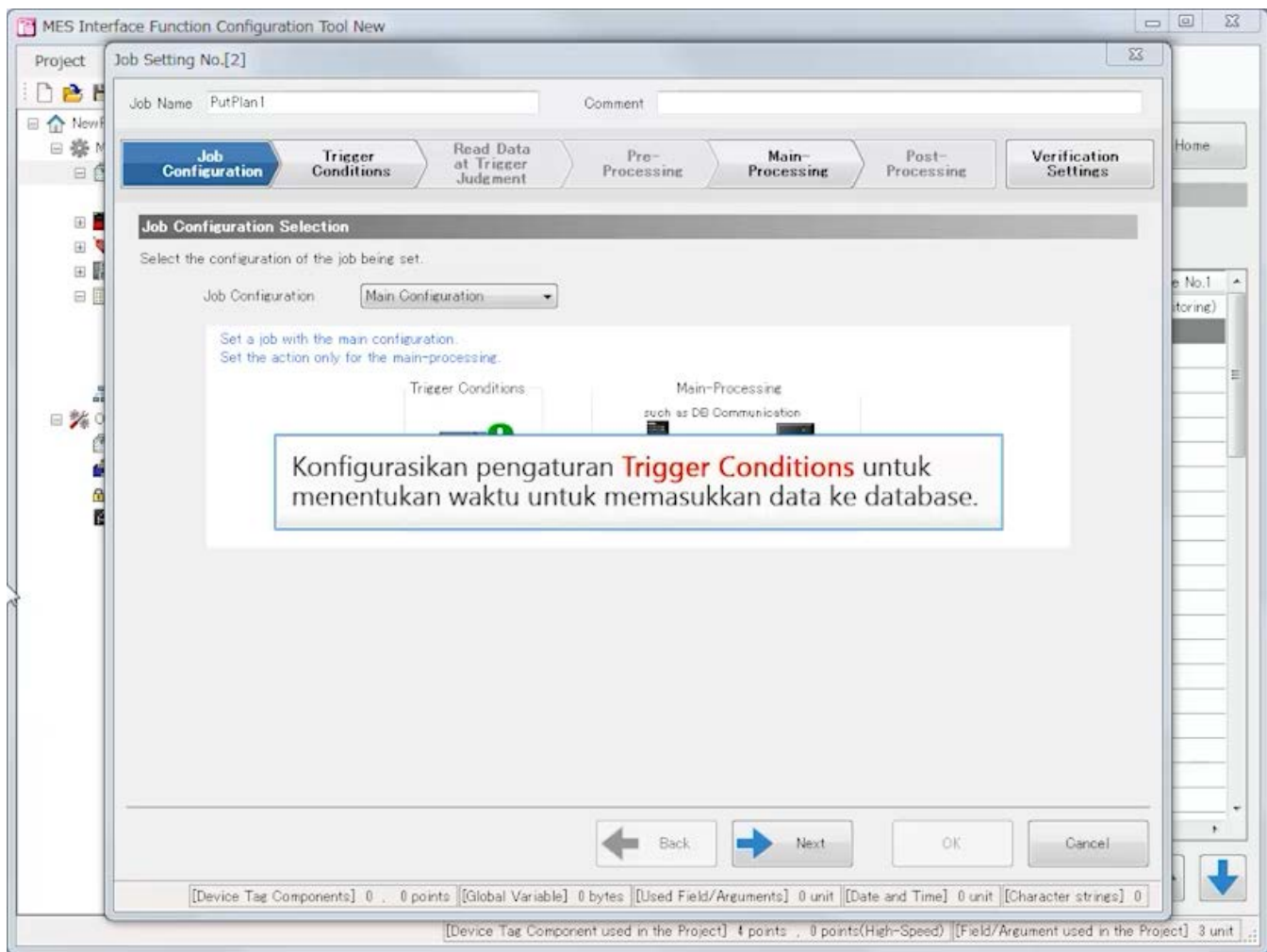


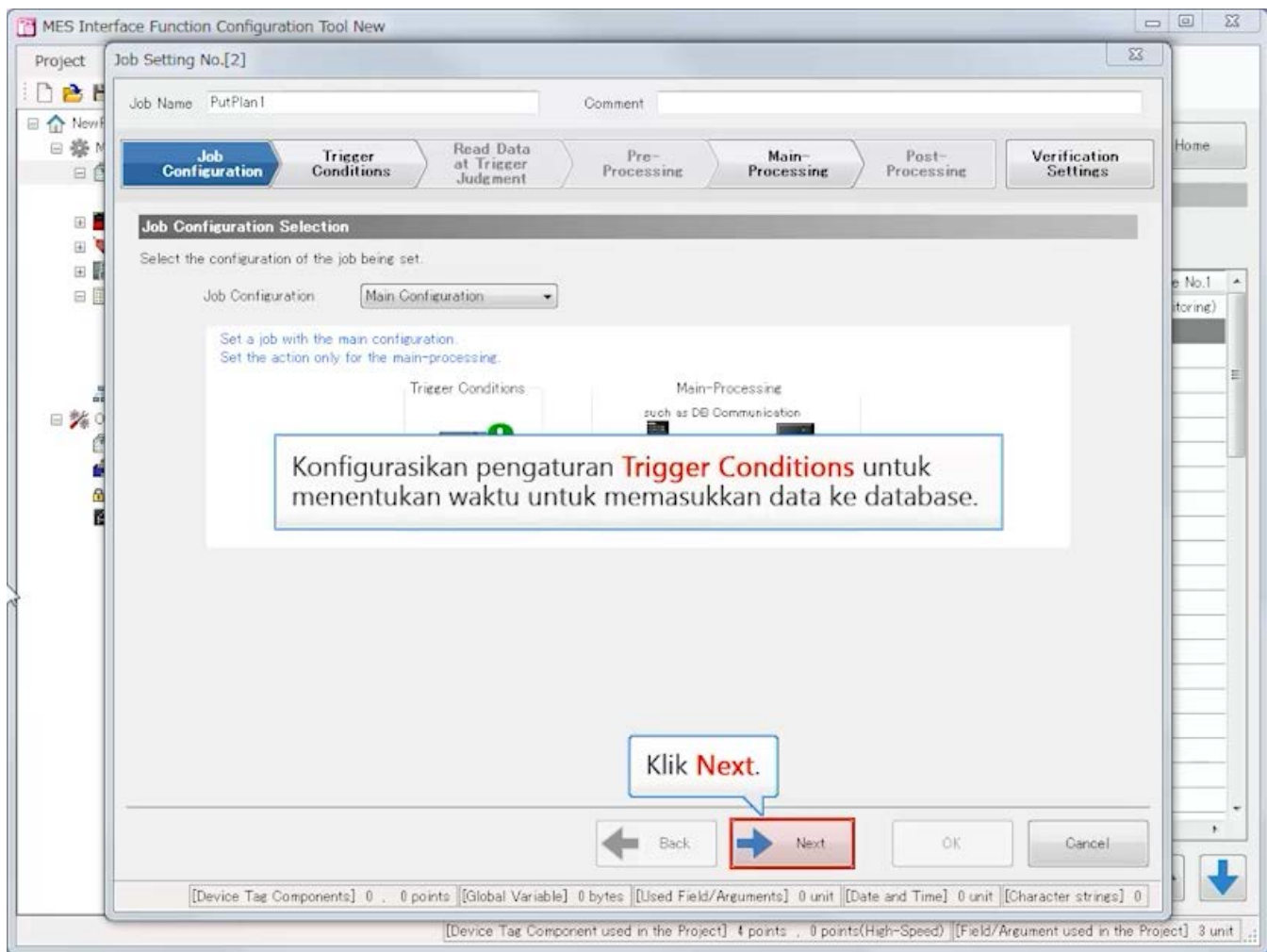
[Kembali](#)[Berikutnya](#)

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[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

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			

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

Kembali

Berikutnya

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 Multiple Events Condition Combination Precondition

Event/Condition Settings

Set each event/condition to be used at Trigger.

No.	Event/Condition Type	Detail type	Comment
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

Kembali

Berikutnya

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			

Mengatur kejadian/kondisi.
Klik tombol **Edit**.

Edit Delete

Trigger Buffering Setting (optional)

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

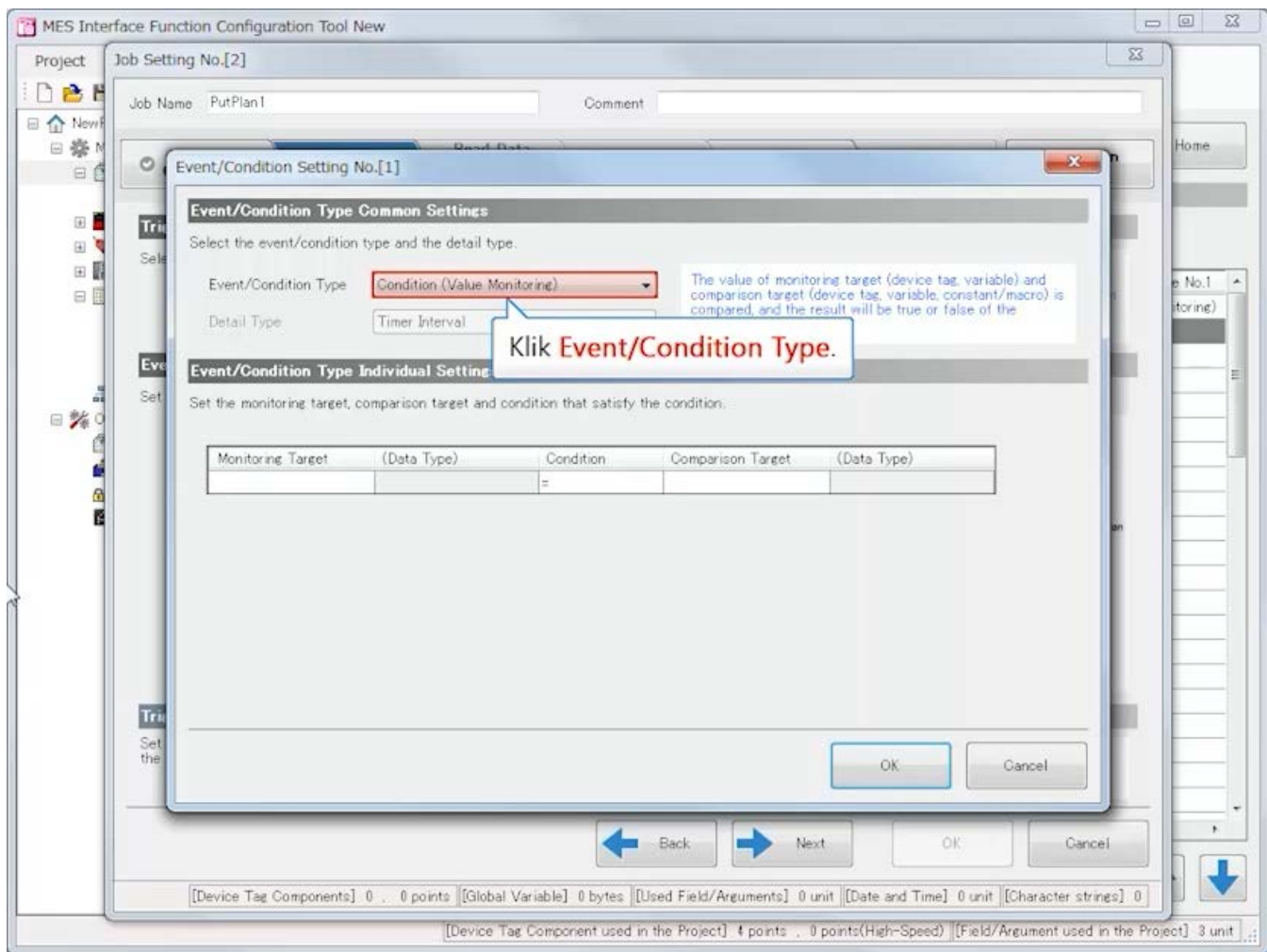
Trigger Buffering Disable

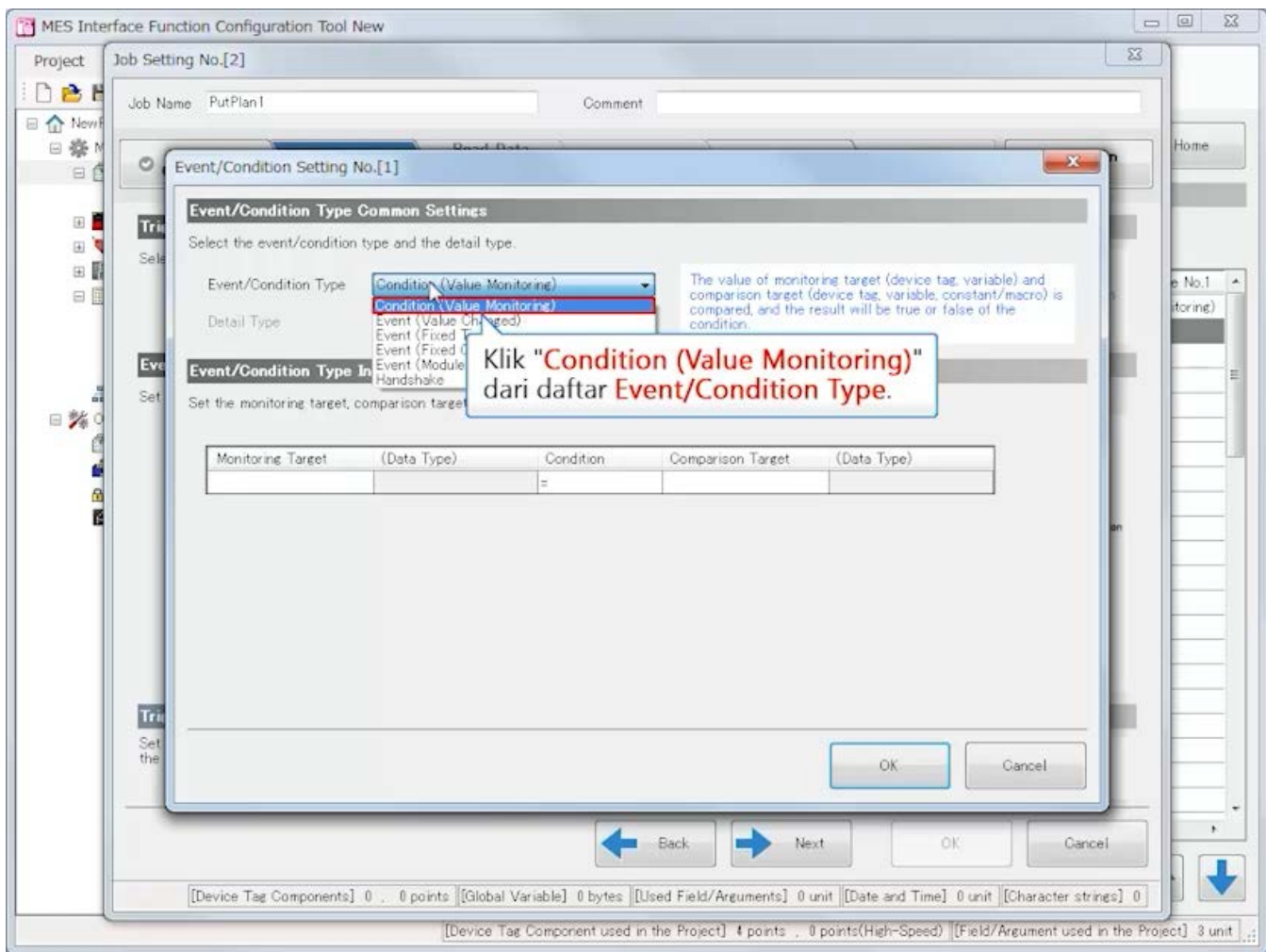
When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

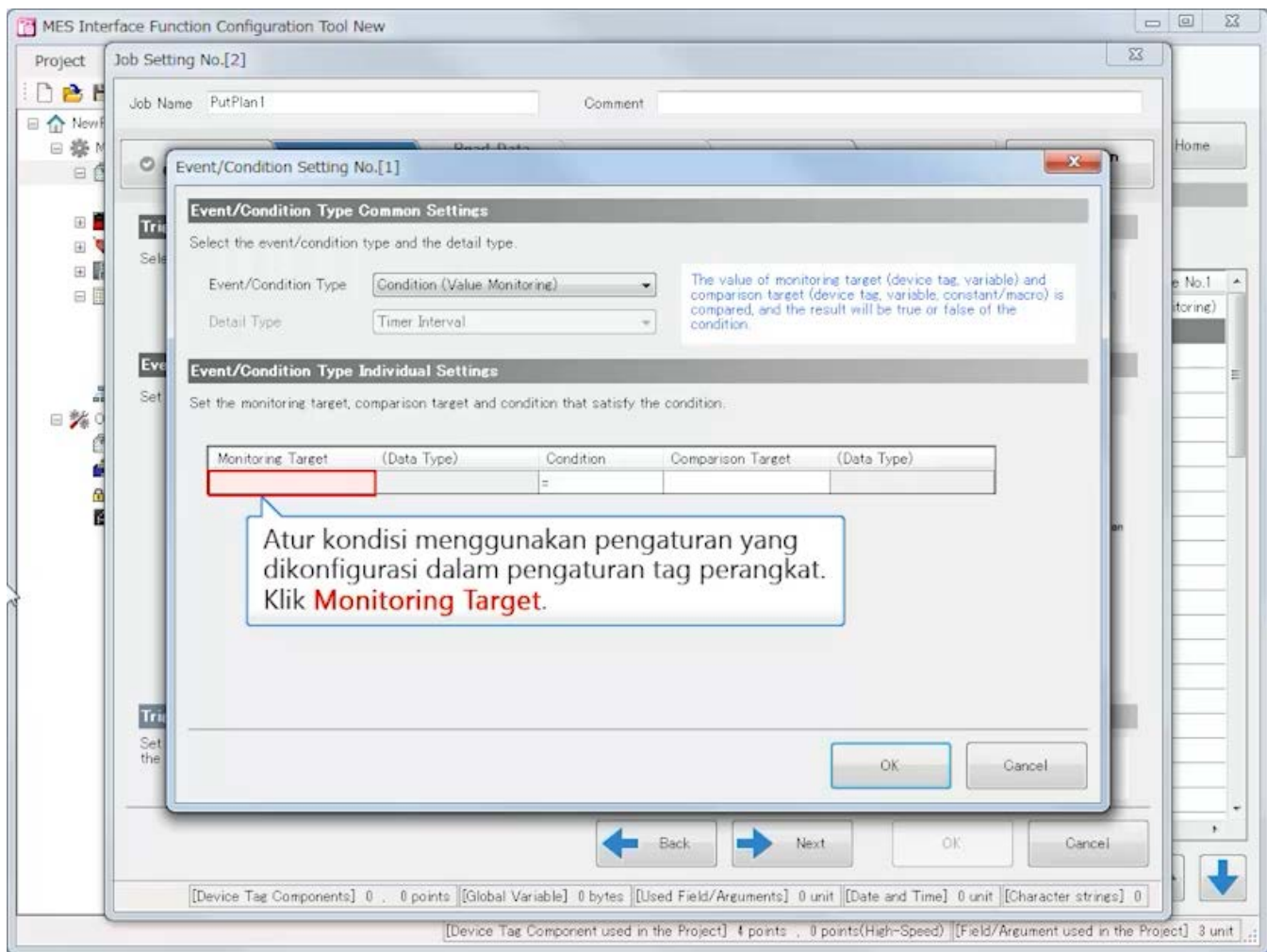
Back Next OK Cancel

[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

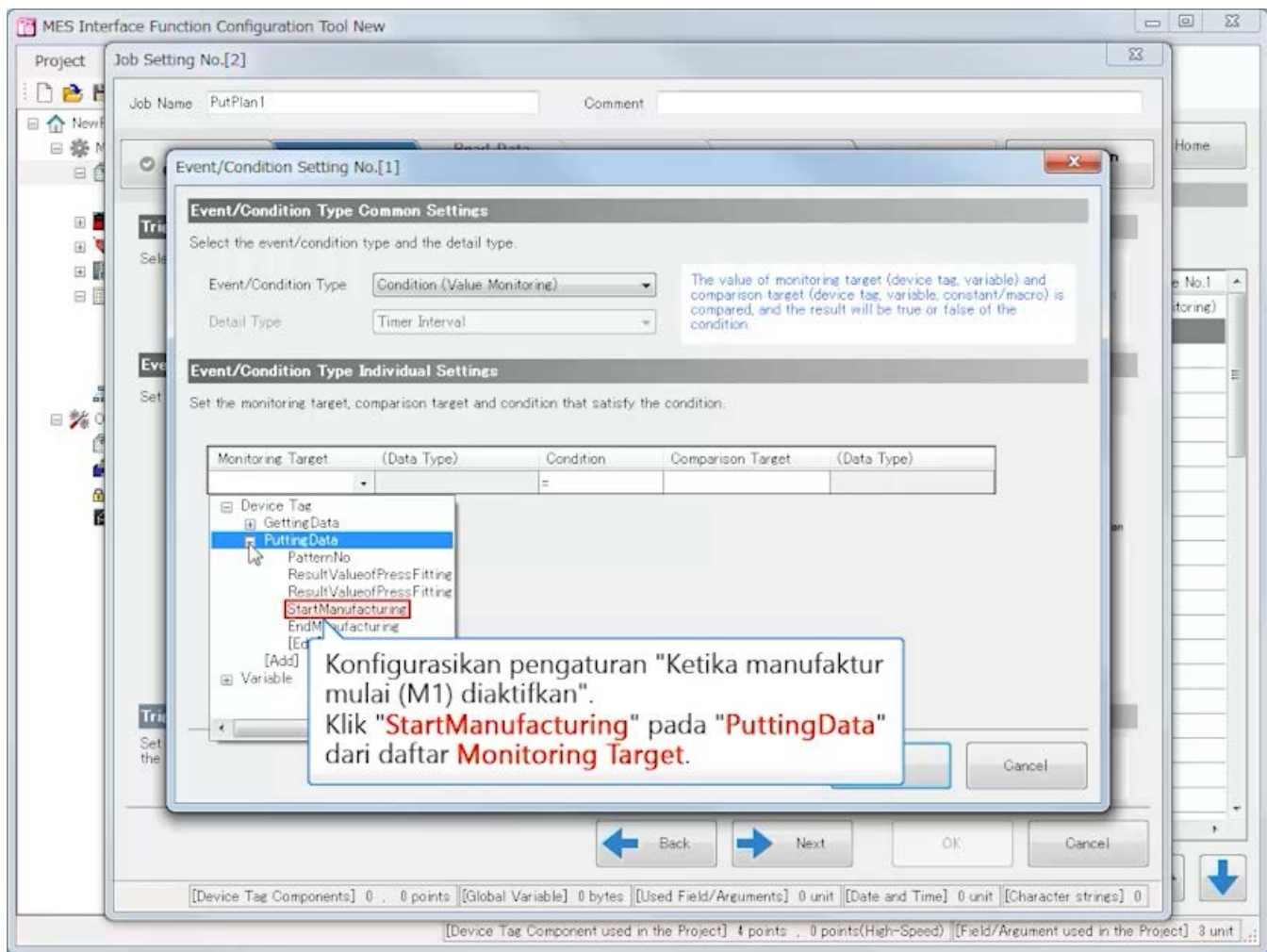
[Kembali](#)[Berikutnya](#)

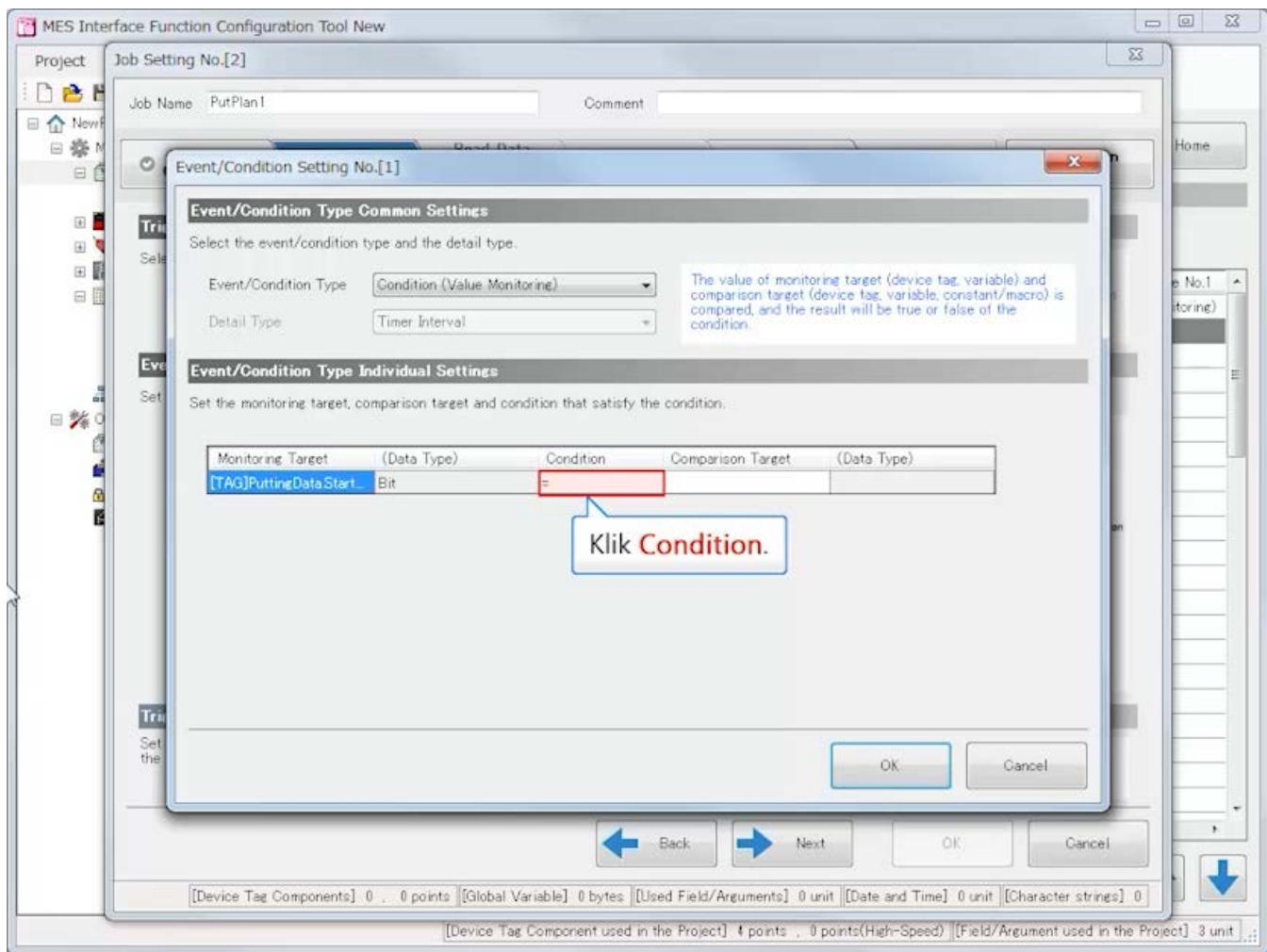
[Kembali](#)[Berikutnya](#)

[Kembali](#)
[Berikutnya](#)


Kembali

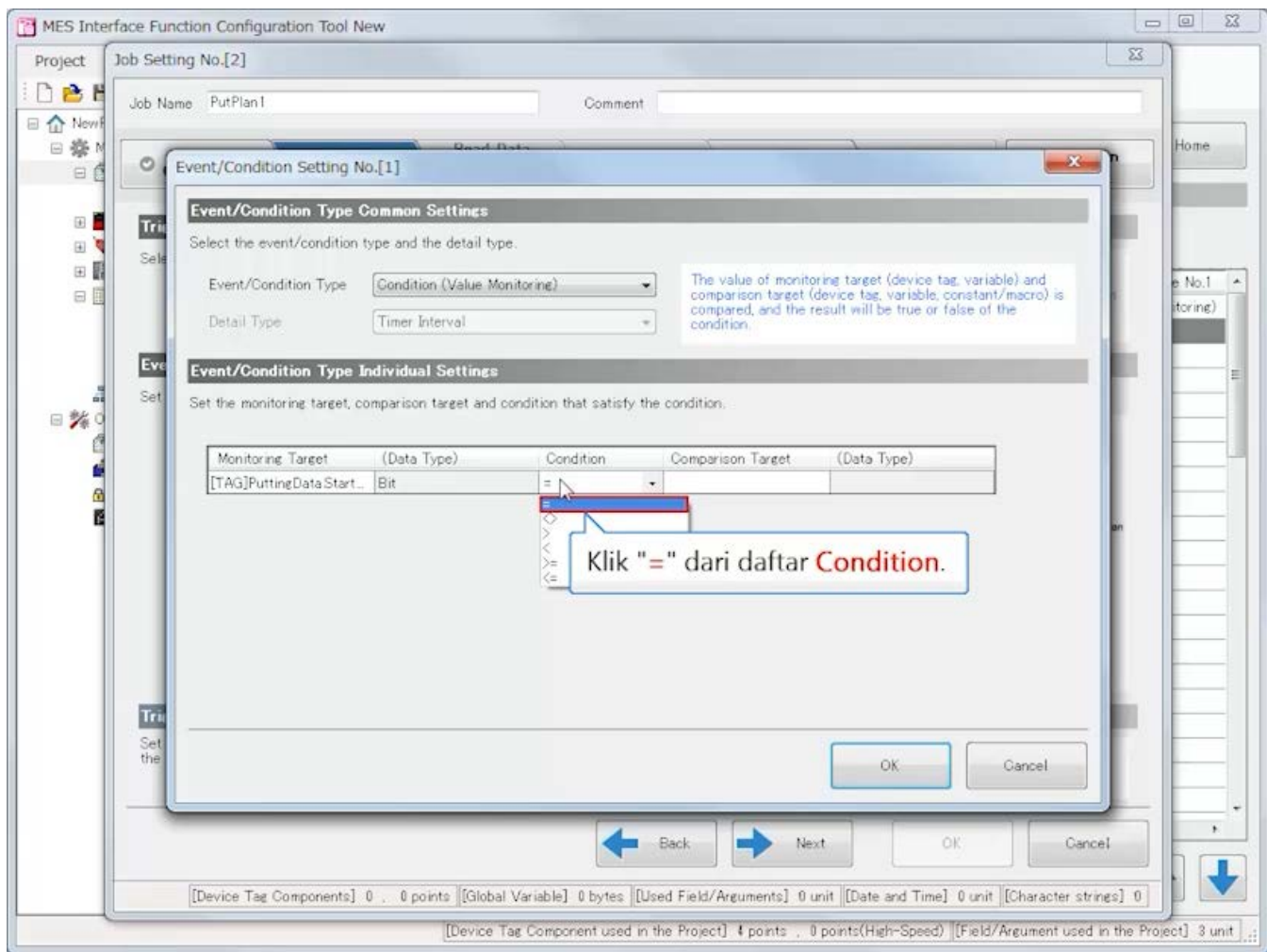
Berikutnya

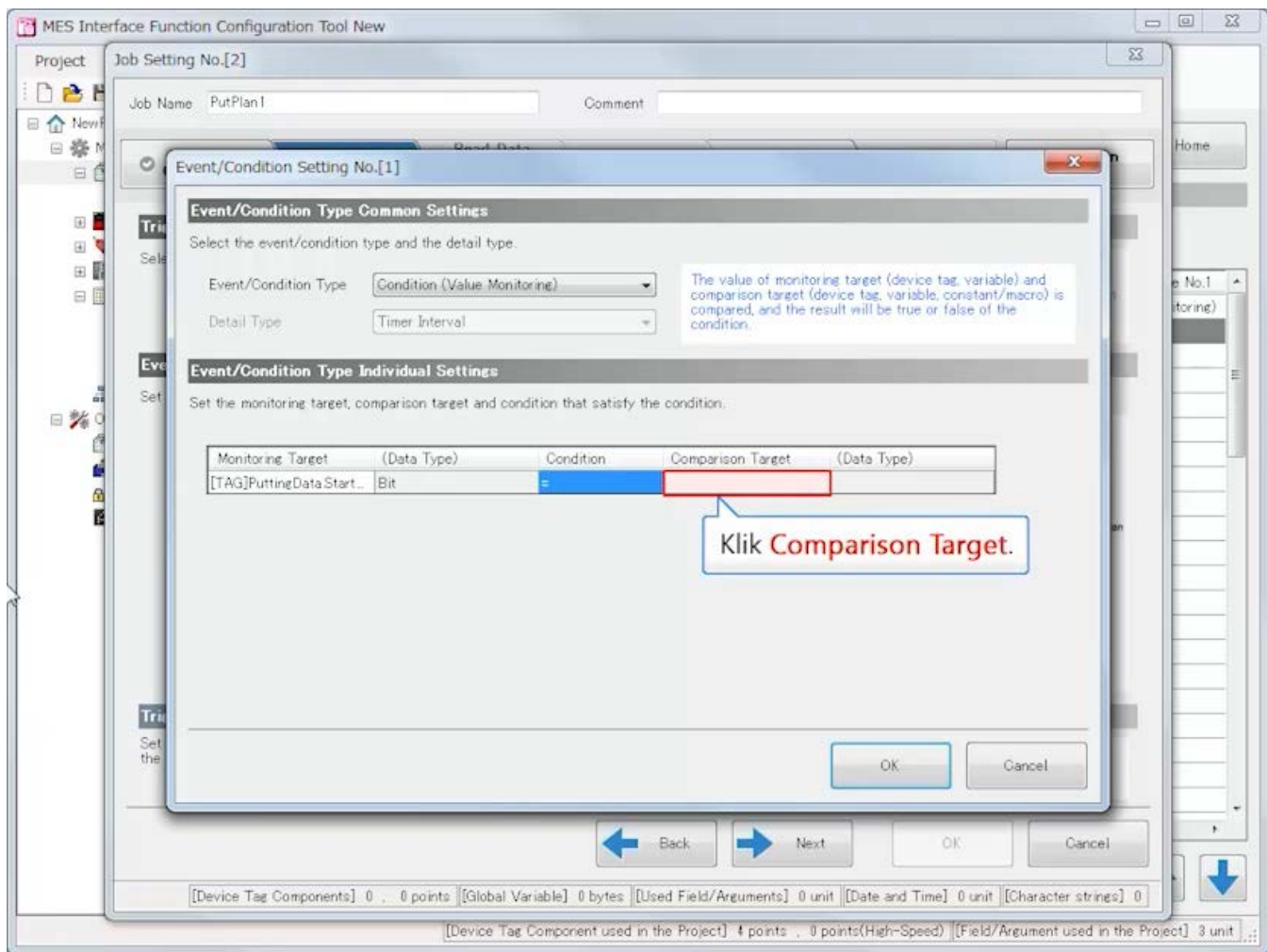


[Kembali](#)[Berikutnya](#)

Kembali

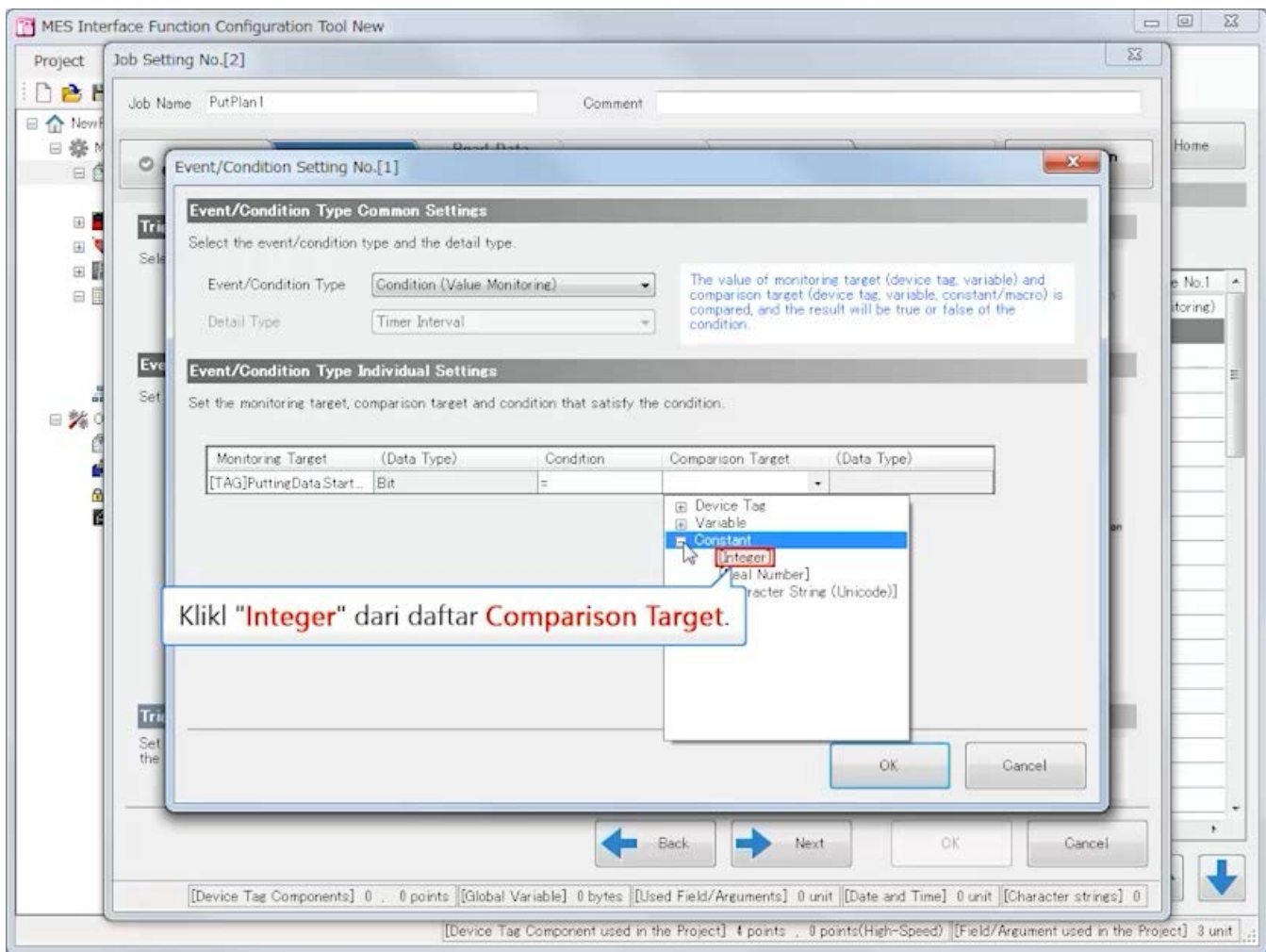
Berikutnya

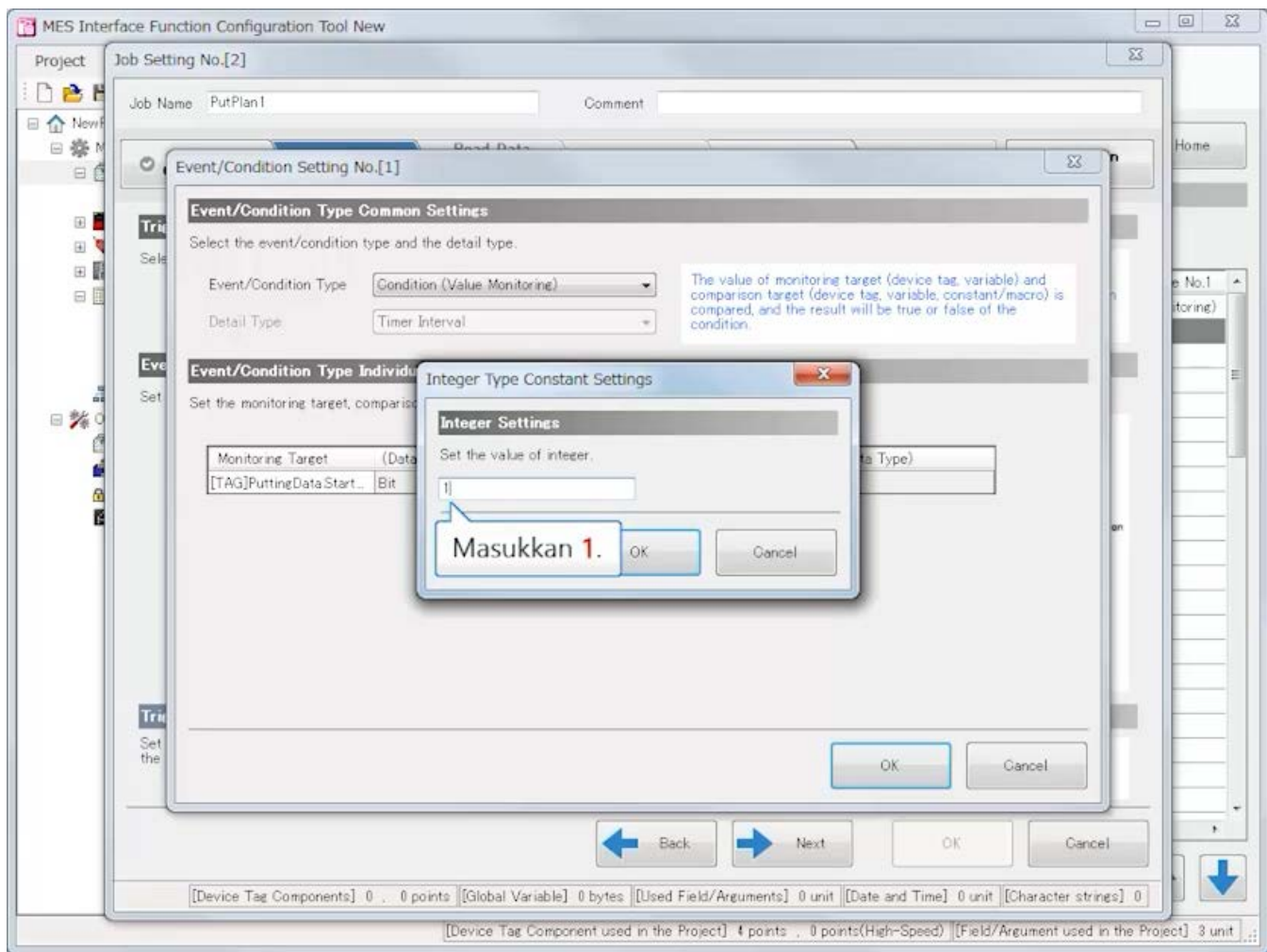


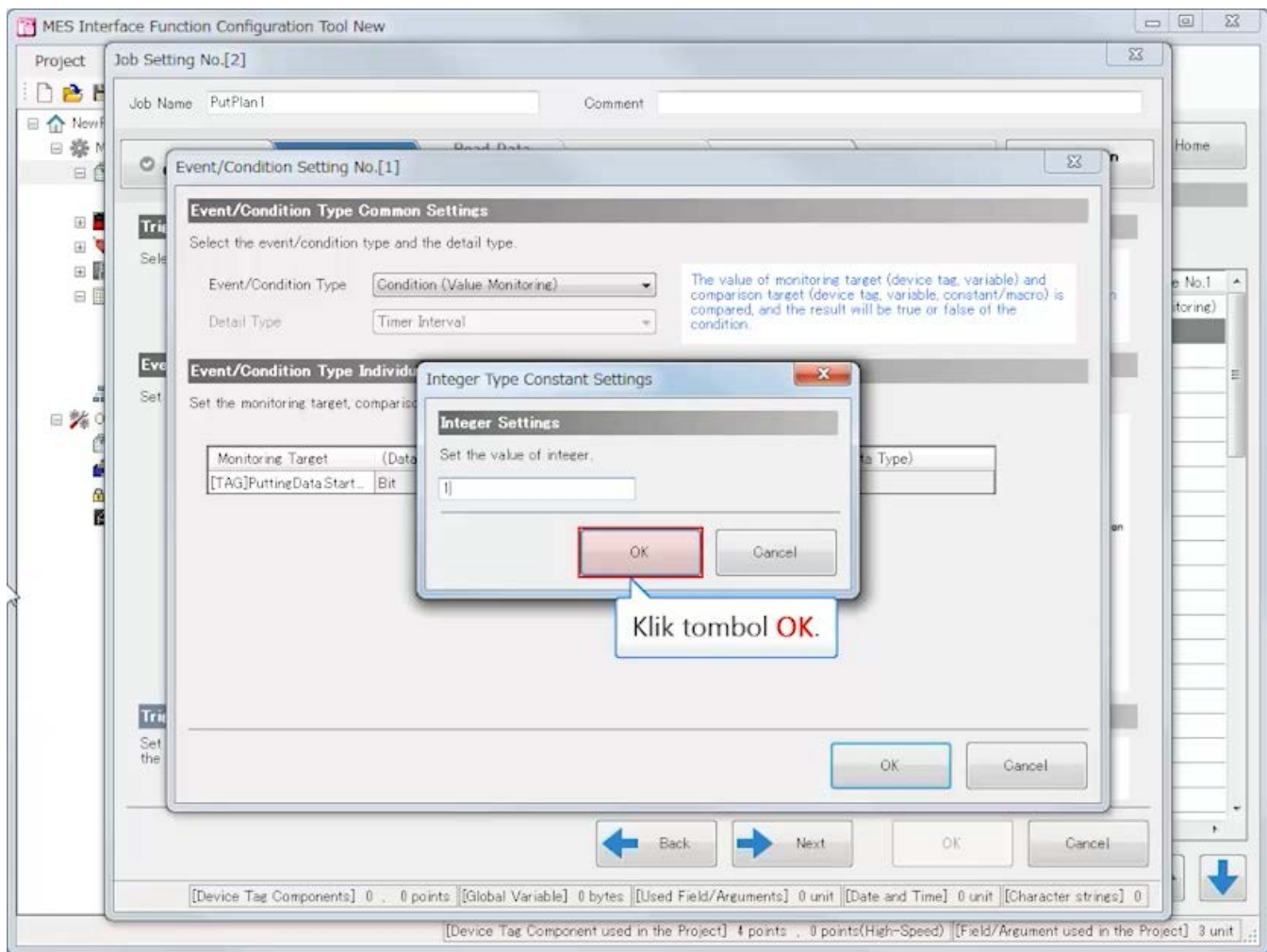
[Kembali](#)[Berikutnya](#)

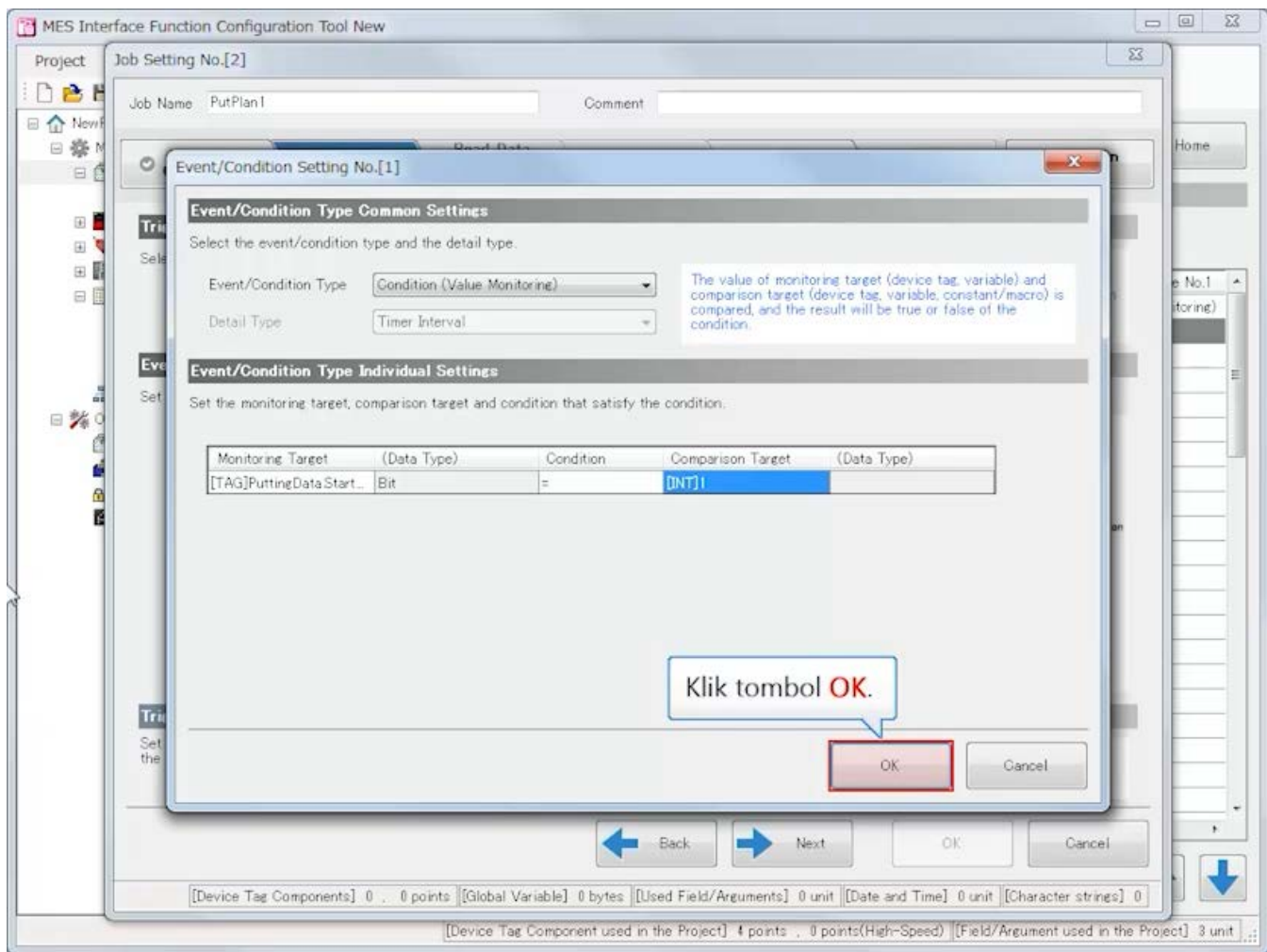
Kembali

Berikutnya



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Kembali

Berikutnya

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]PuttingDataStartManufact...

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.

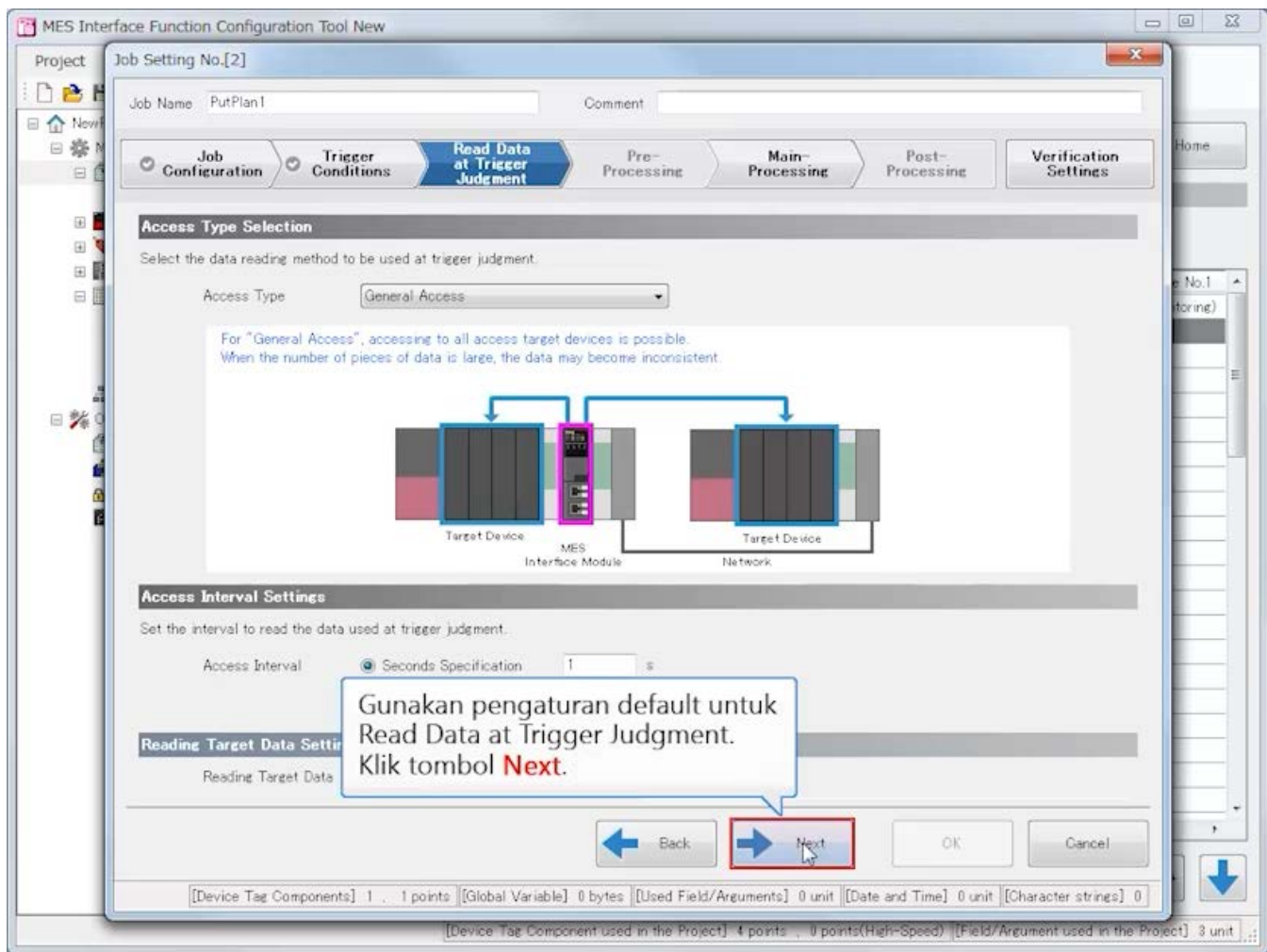
Trigger Buffering Disable

Klik Next.

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

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

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

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		

Konfigurasi pengaturan main-processing.
Klik tombol **Edit**.

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings (optional)

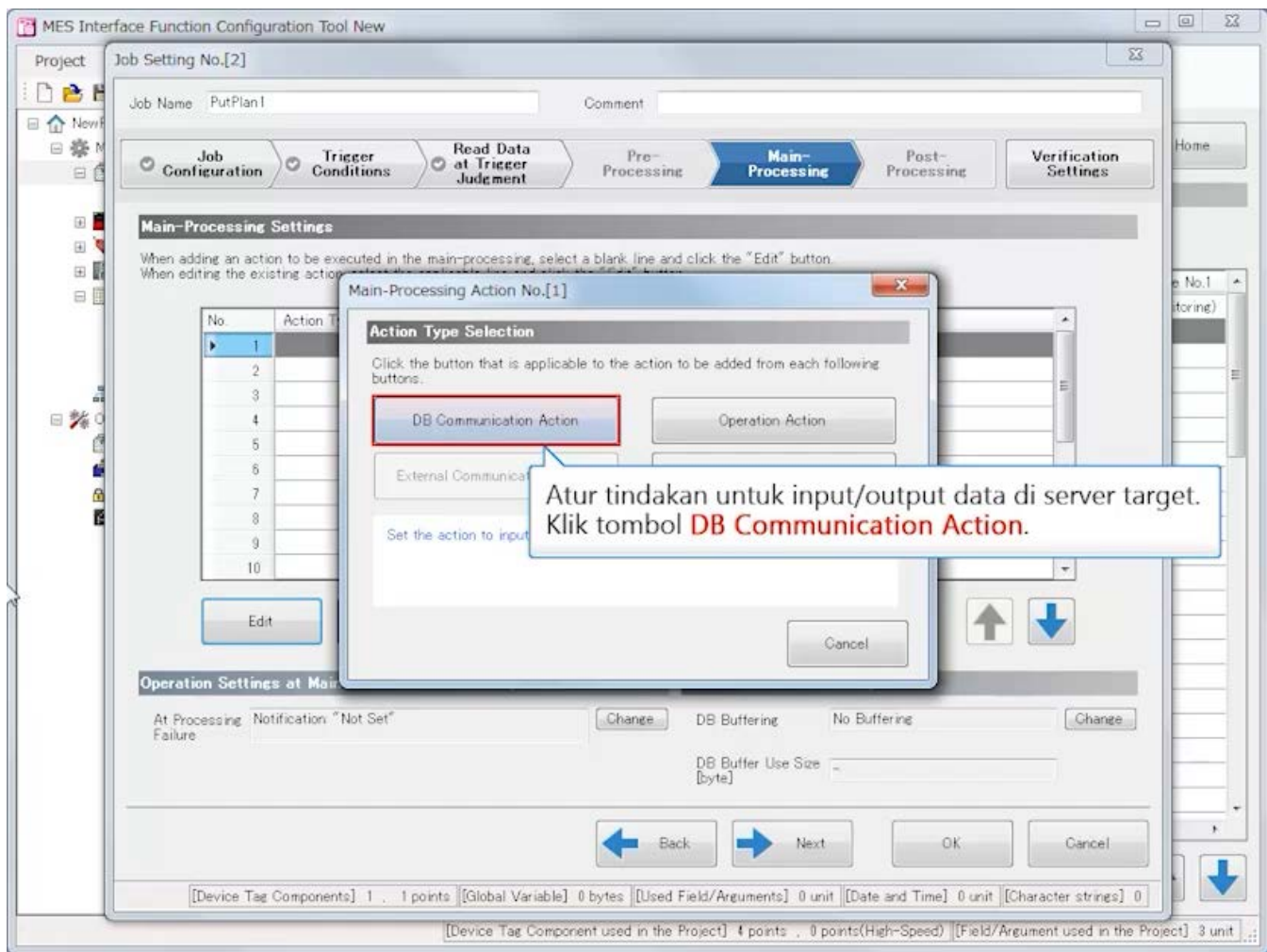
DB Buffering No Buffering Change

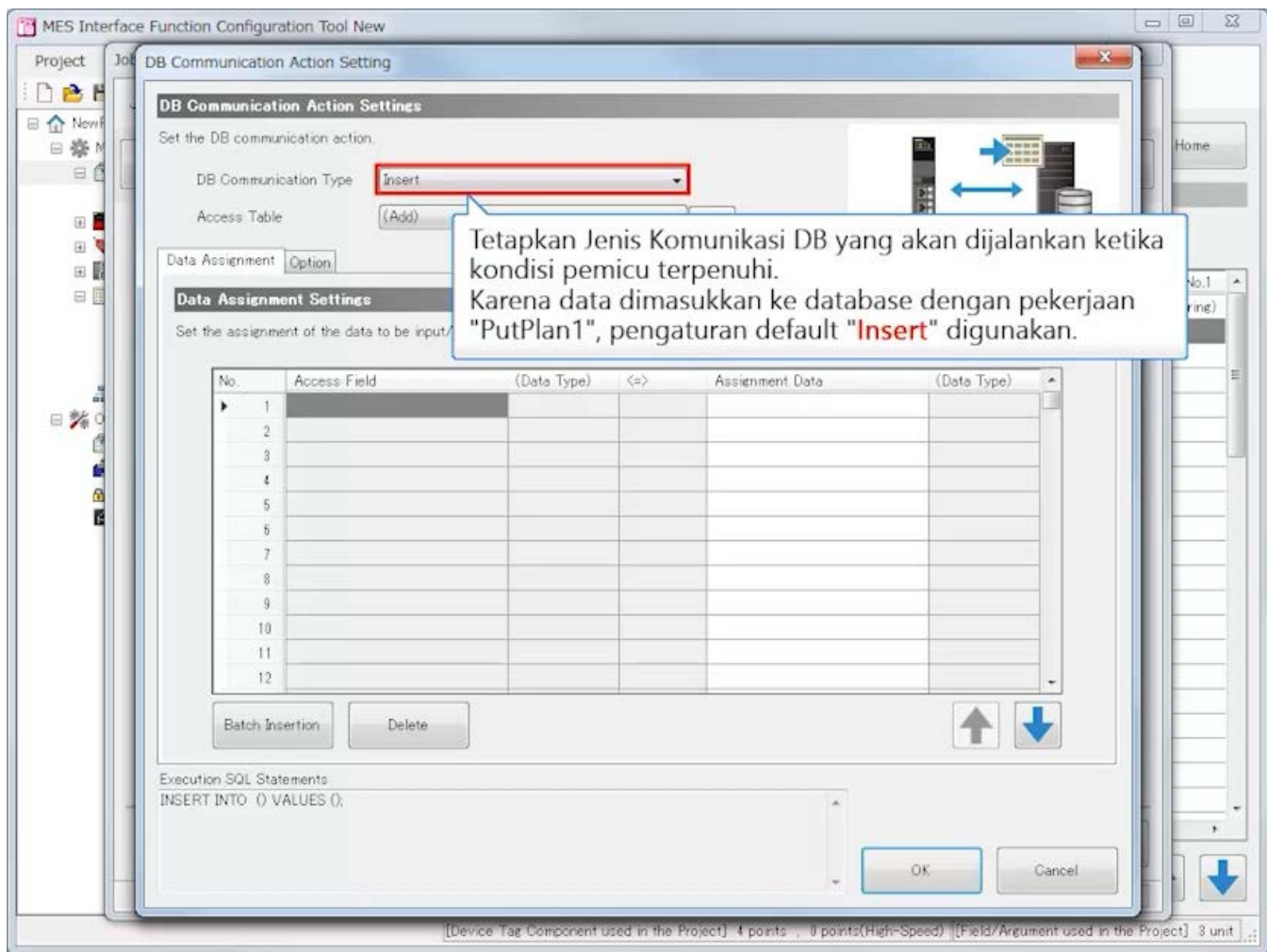
DB Buffer Use Size [byte]

Back Next OK Cancel

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

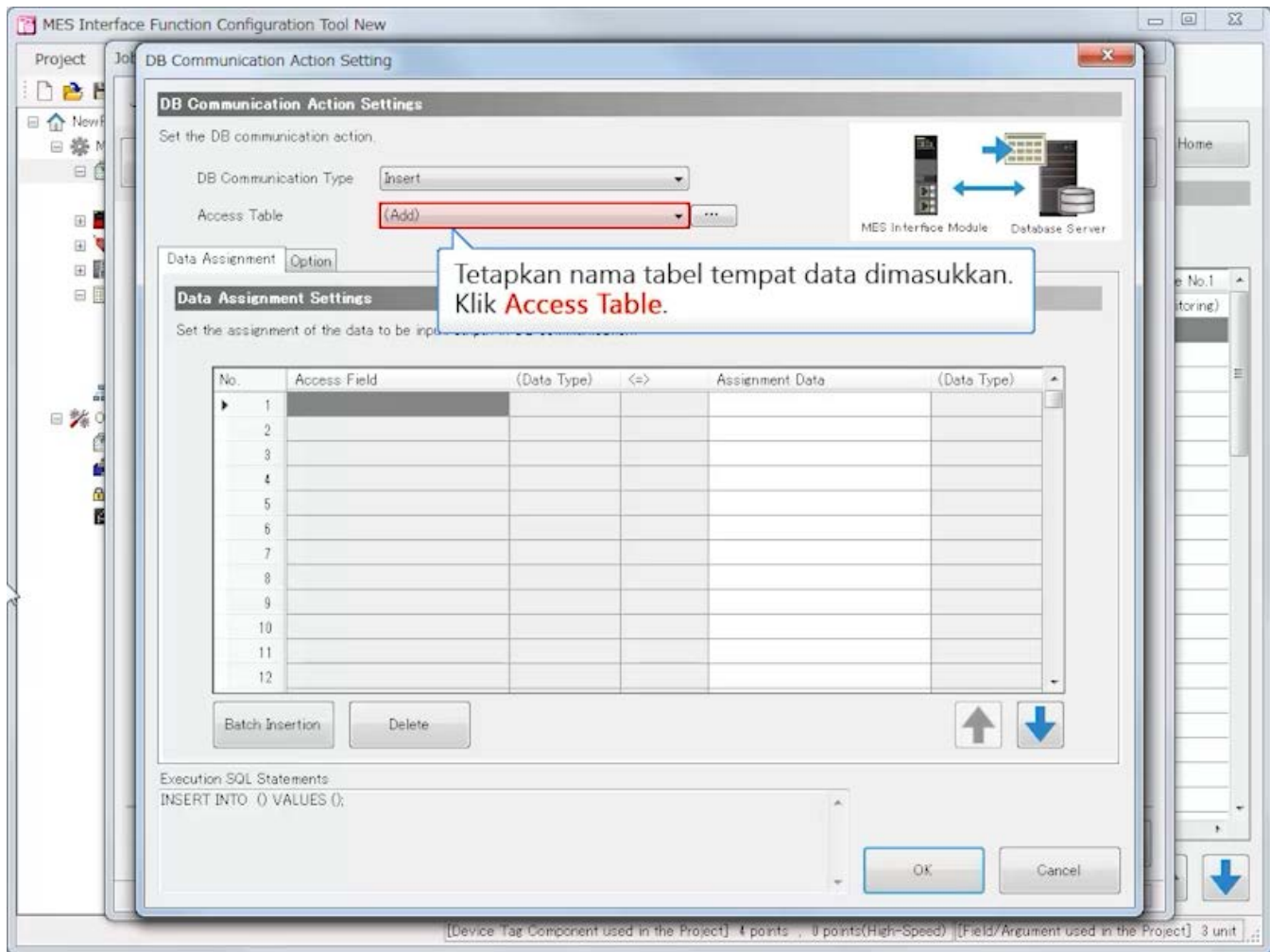
[Device Tag Component used in the Project] 4 points 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

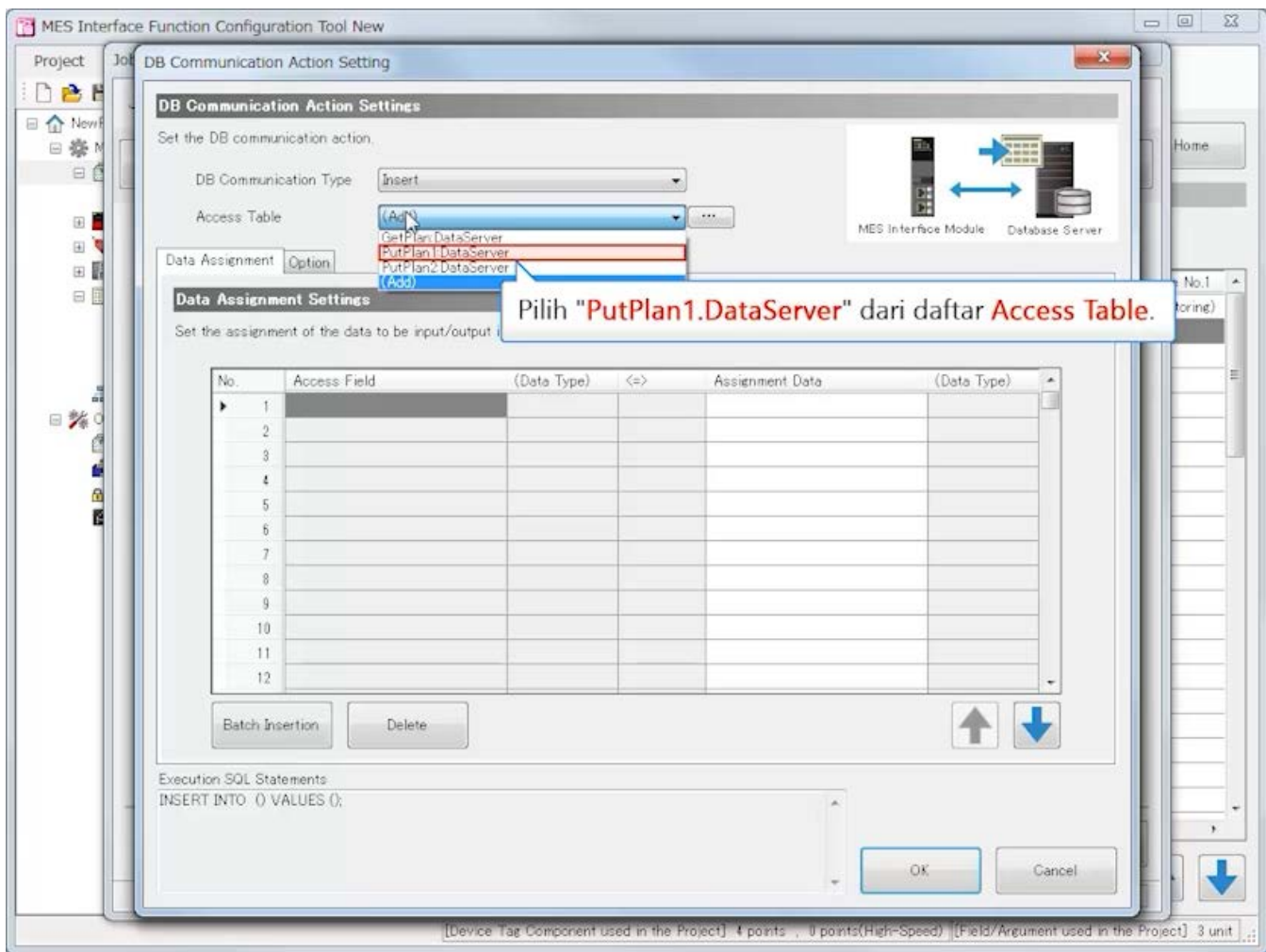
[Kembali](#)
[Berikutnya](#)


[Kembali](#)[Berikutnya](#)

Kembali

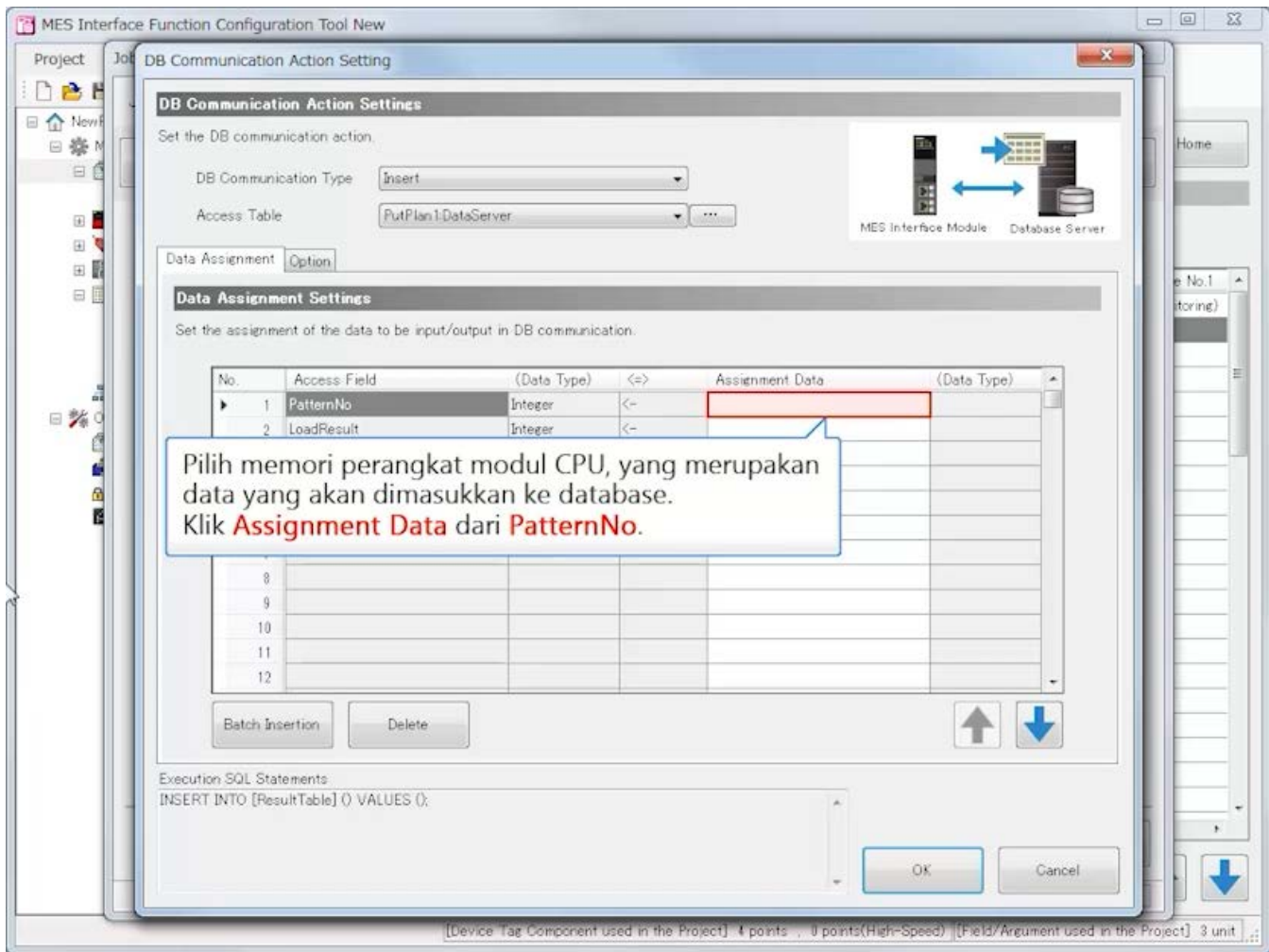
Berikutnya



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Kembali

Berikutnya



Kembali

Berikutnya

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

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	<-		

Selanjutnya, atur pengaturan tautan berikut ke baris No. 2 hingga 4.
Prosedur pengaturannya sama dengan "PatternNo".
Operasi pengaturan dihilangkan dalam kursus ini.

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

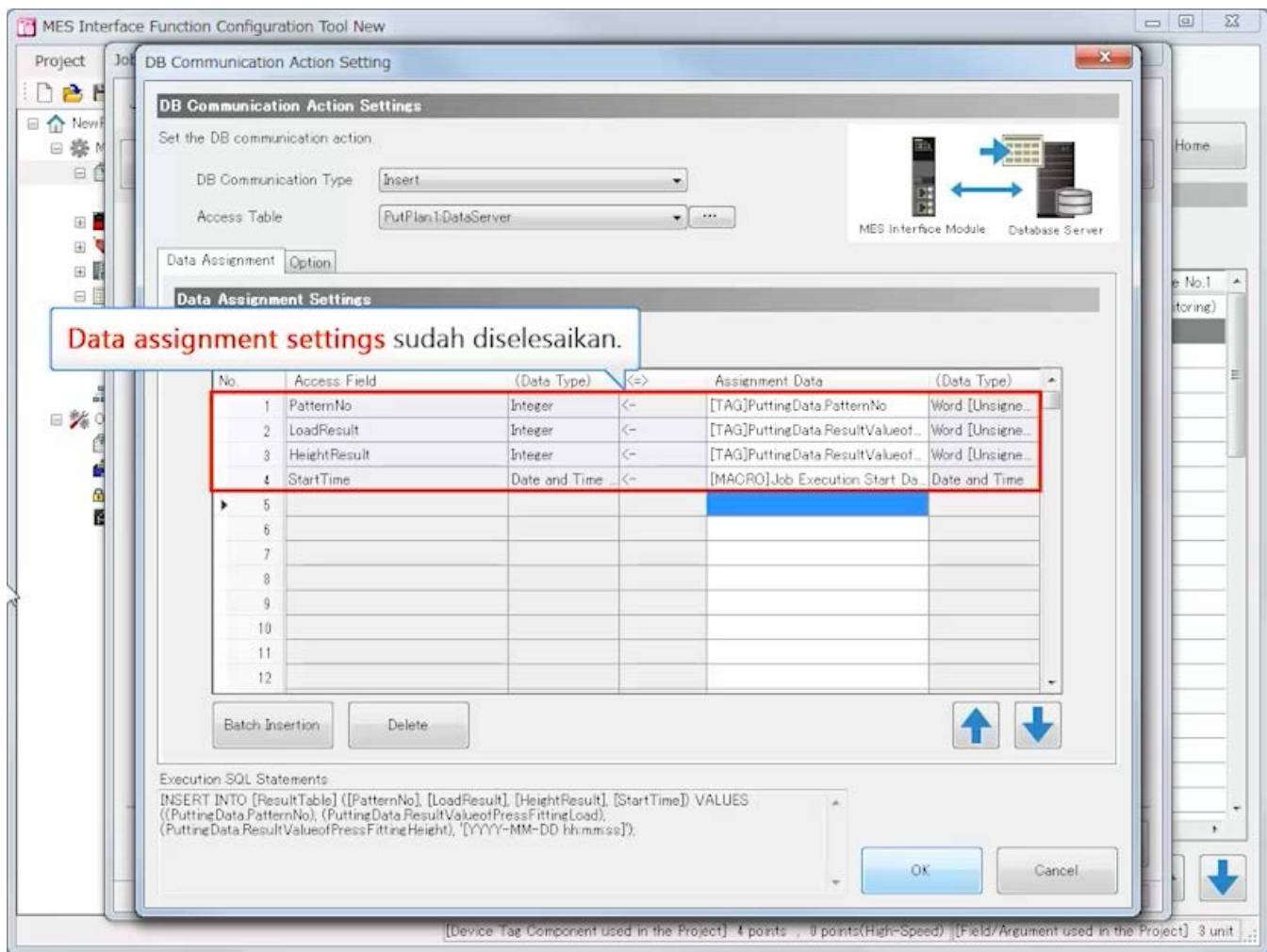
INSERT INTO [ResultTable] ([PatternNo]) VALUES ((PuttingData.PatternNo));

OK Cancel

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

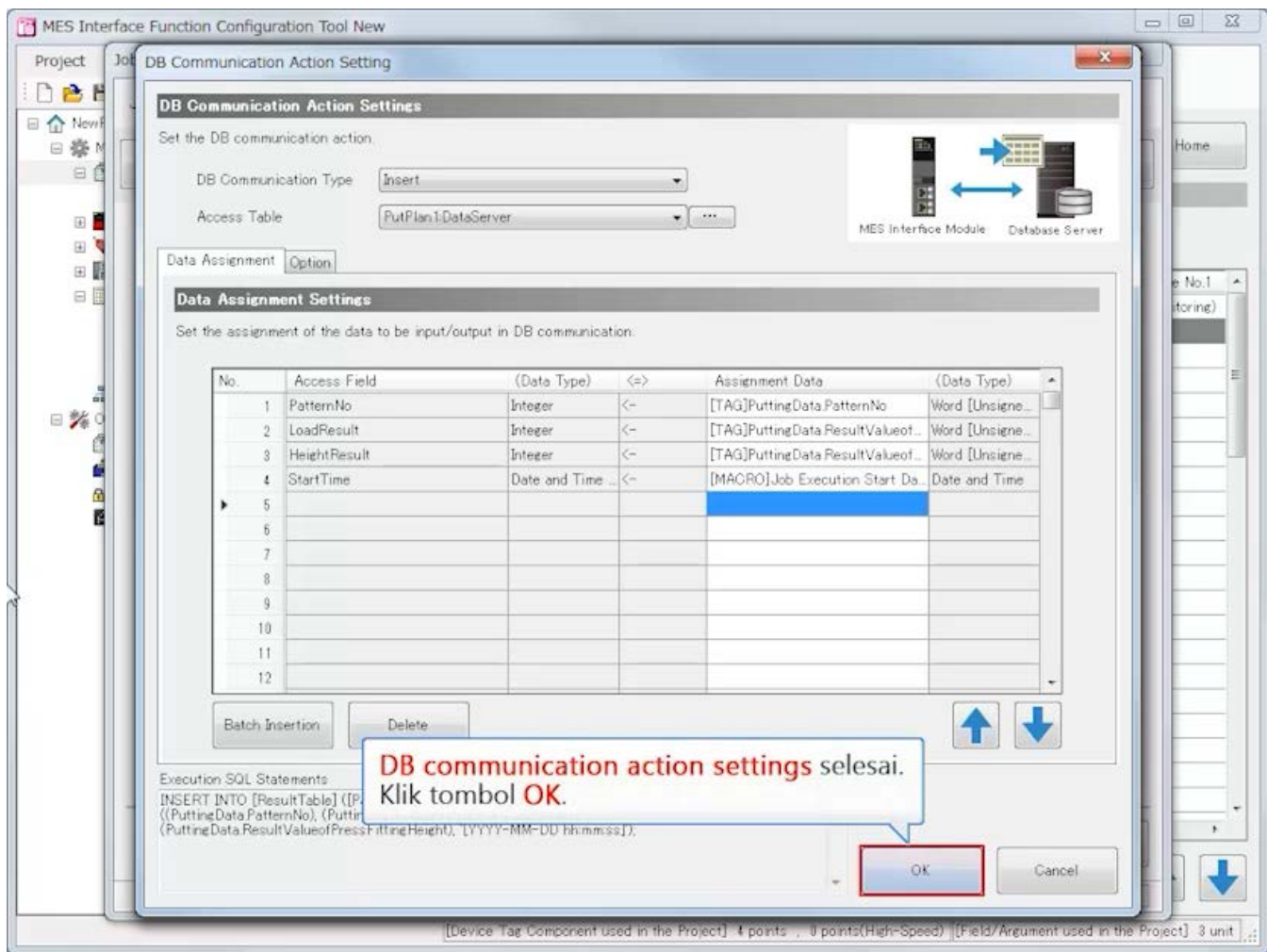
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

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

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)

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

Mengatur buffering DB. Klik tombol **Change**.

Kembali

Berikutnya

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

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		
9		
10		

Edit Delete

Untuk mengonfigurasi buffering DB, pilih "Use the DB buffer 1." di DB Buffer Settings pada Option Settings.

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings

DB Buffering No Buffering Change

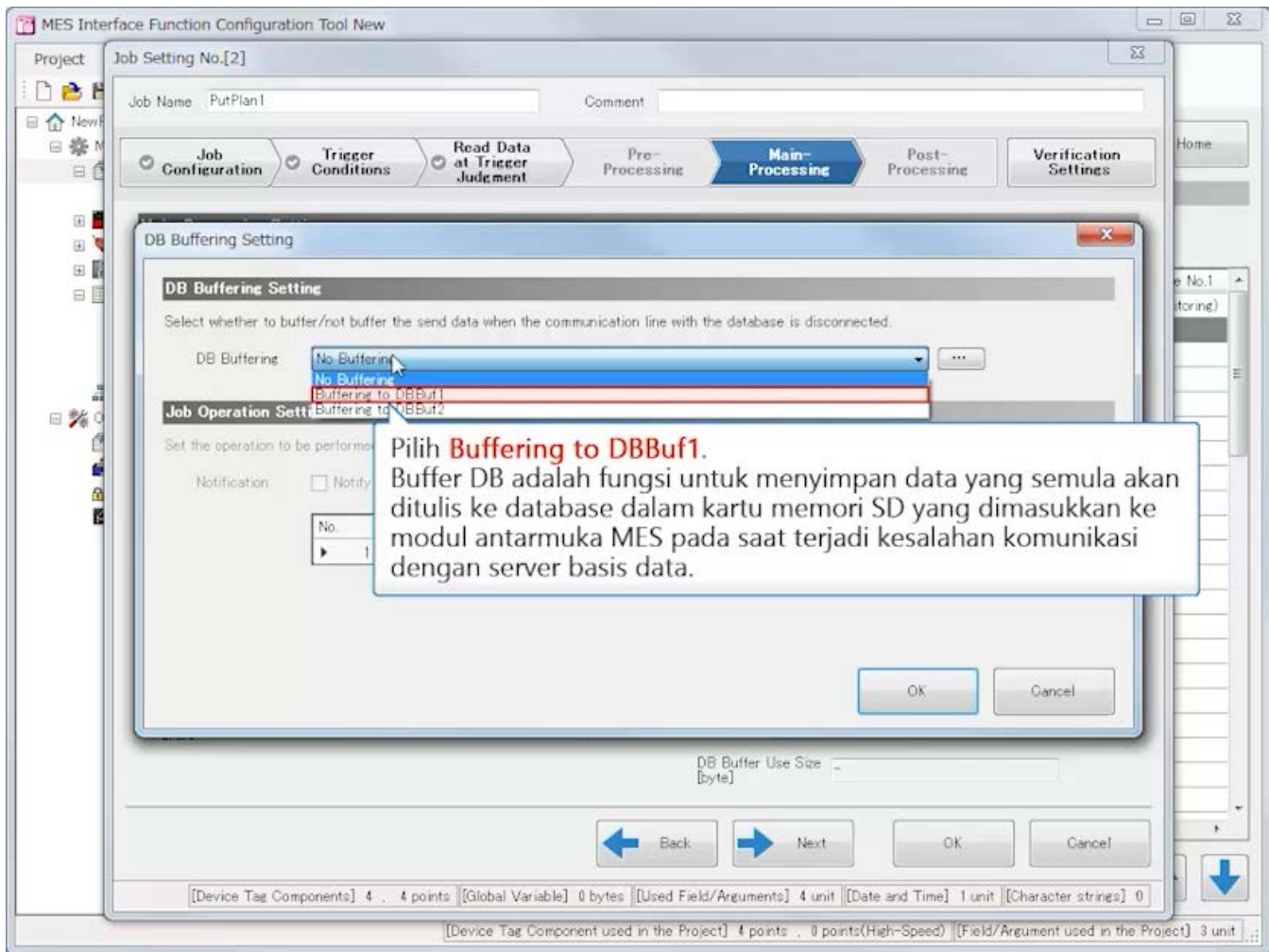
DB Buffer Use Size [byte]

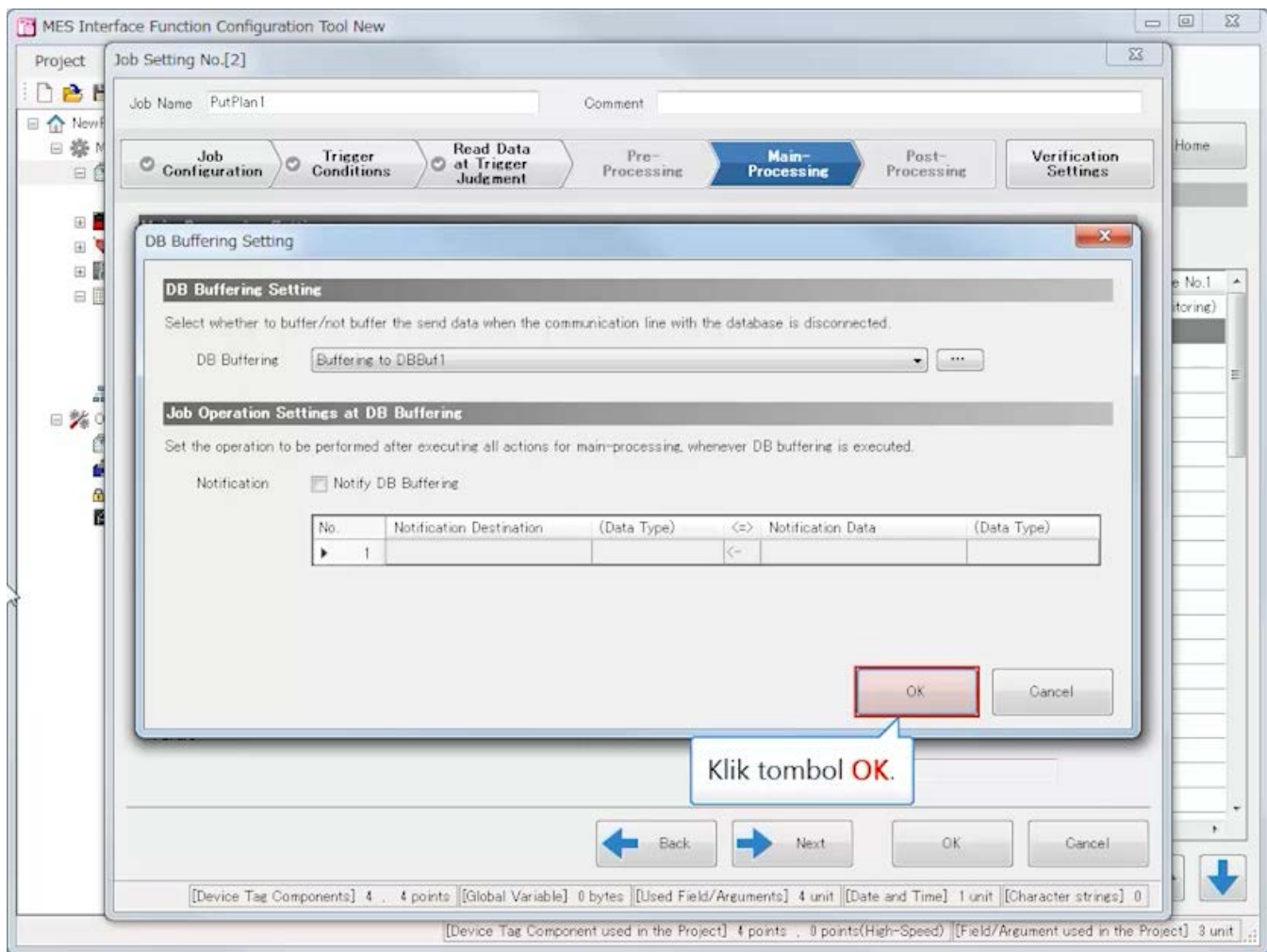
← Back Next → OK Cancel

[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

Mengatur buffering DB. Klik tombol **Change**.

[Kembali](#)[Berikutnya](#)

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

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

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

Size 270

Klik Next.

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

[Kembali](#)[Berikutnya](#)

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.

Pengaturan default digunakan untuk Verification Settings. Klik tombol OK.

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

[Kembali](#)
[Berikutnya](#)

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like 'NewProject', 'Main Settings', 'Job Settings', 'Target Device Settings', etc. The 'Job Settings' category is expanded, showing 'GetPlan' and 'PutPlan1'. The main area displays the 'Job Setting List' table. Below the table are 'Edit' and 'Delete' buttons. A status bar at the bottom shows 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	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

Pengaturan pekerjaan "PutPlan1" selesai.

Klik [>](#) untuk melanjutkan ke halaman berikutnya.

[Job Settings]

Buat pekerjaan yang memperbarui data dalam catatan database saat manufaktur selesai.

(3) Job Name: PutPlan2

[Job Configuration]

Job Configuration: Main Configuration

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

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

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

[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 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 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] 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.

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

Tab Data Assignment

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

Tab Narrowing-Down Condition

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

Untuk mengonfigurasi buffering DB, pilih "Use the DB buffer 2." di [DB Buffer Settings] dari [Option Settings] terlebih dahulu.

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 : Jangan dipilih
Inhibit the data output to the target server : Jangan dipilih
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: Jangan dipilih

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.

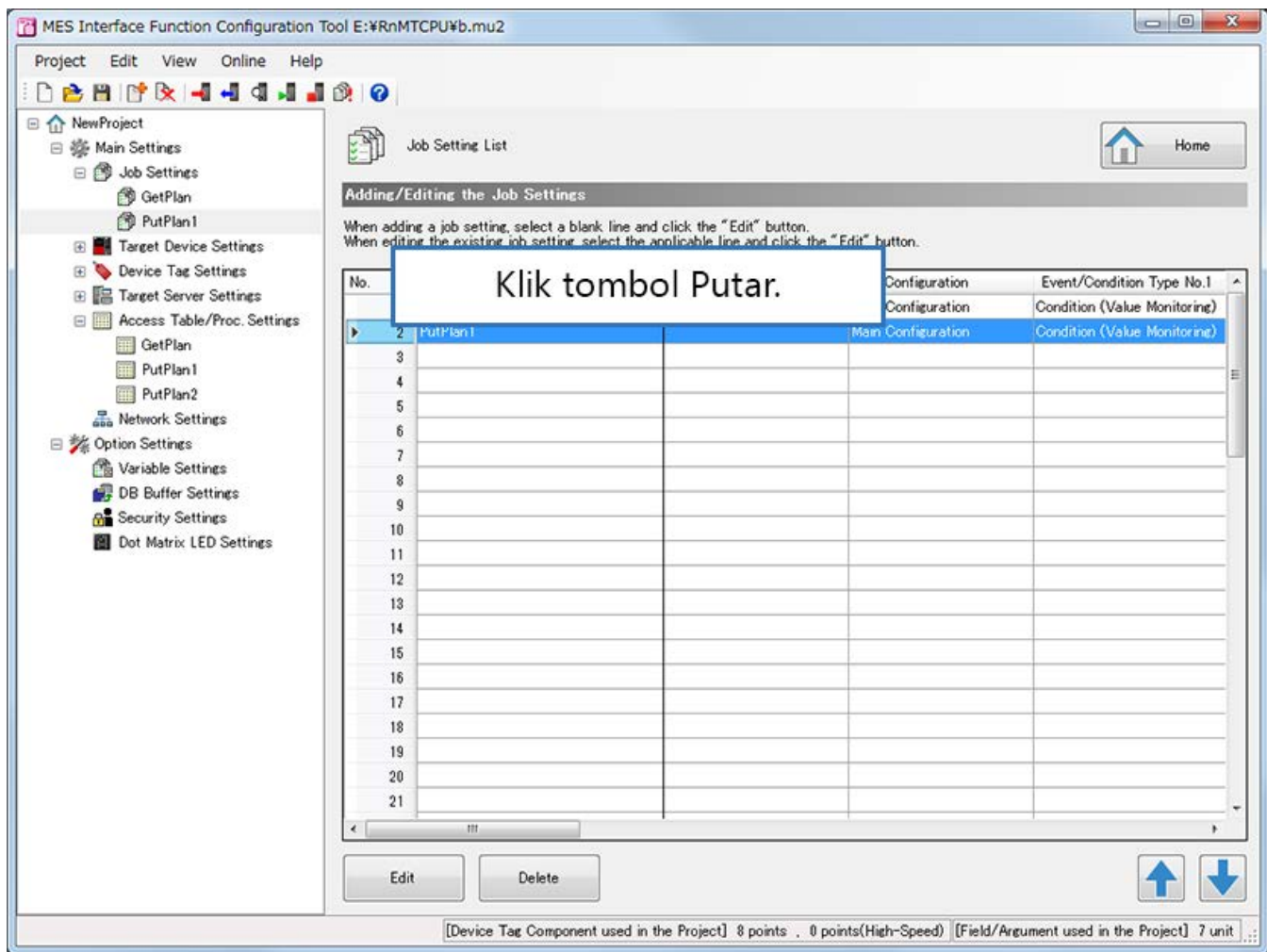
☐ Inhibit the job execution even when the trigger condition is satisfied.

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

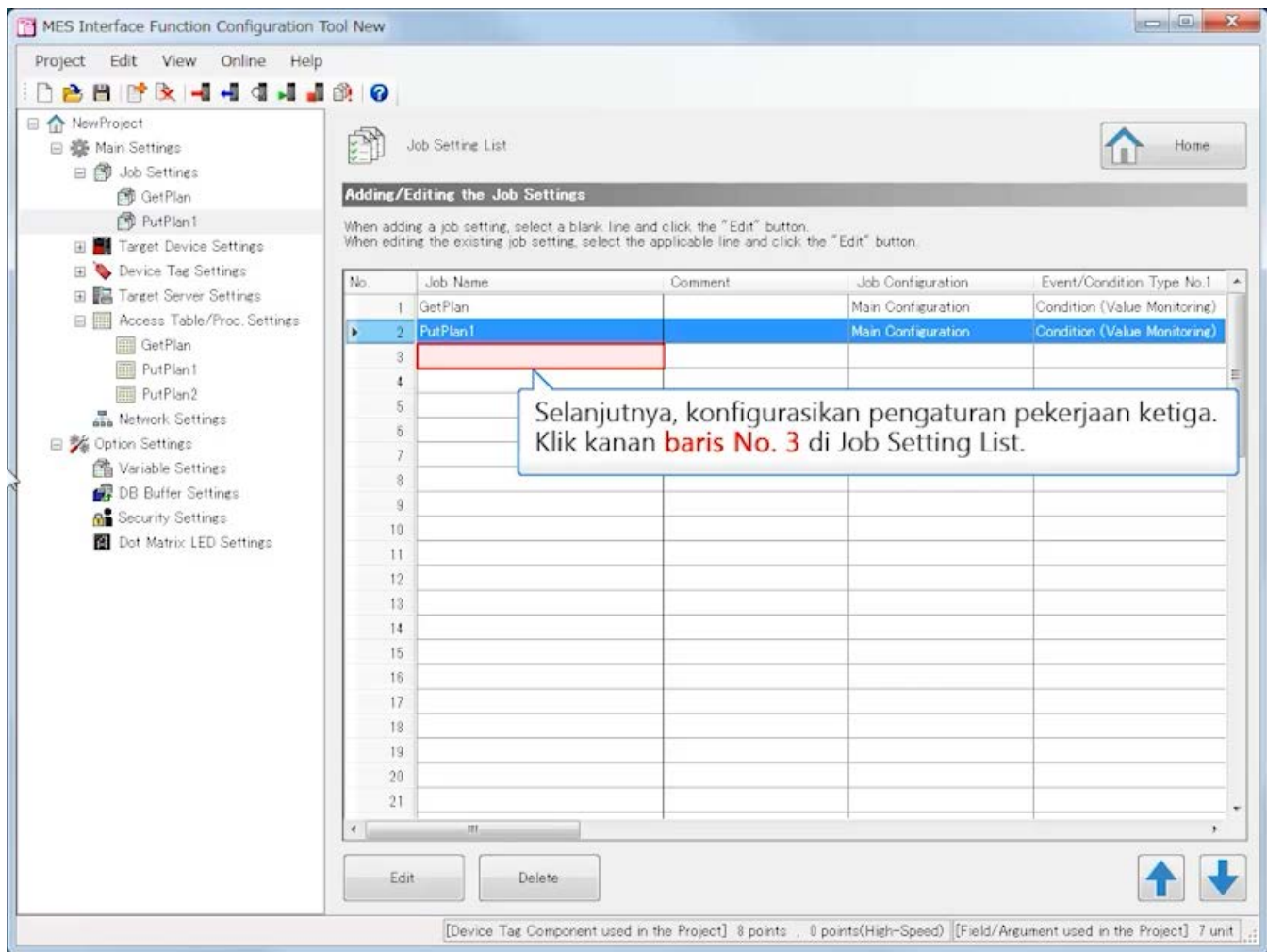
Kembali

Berikutnya



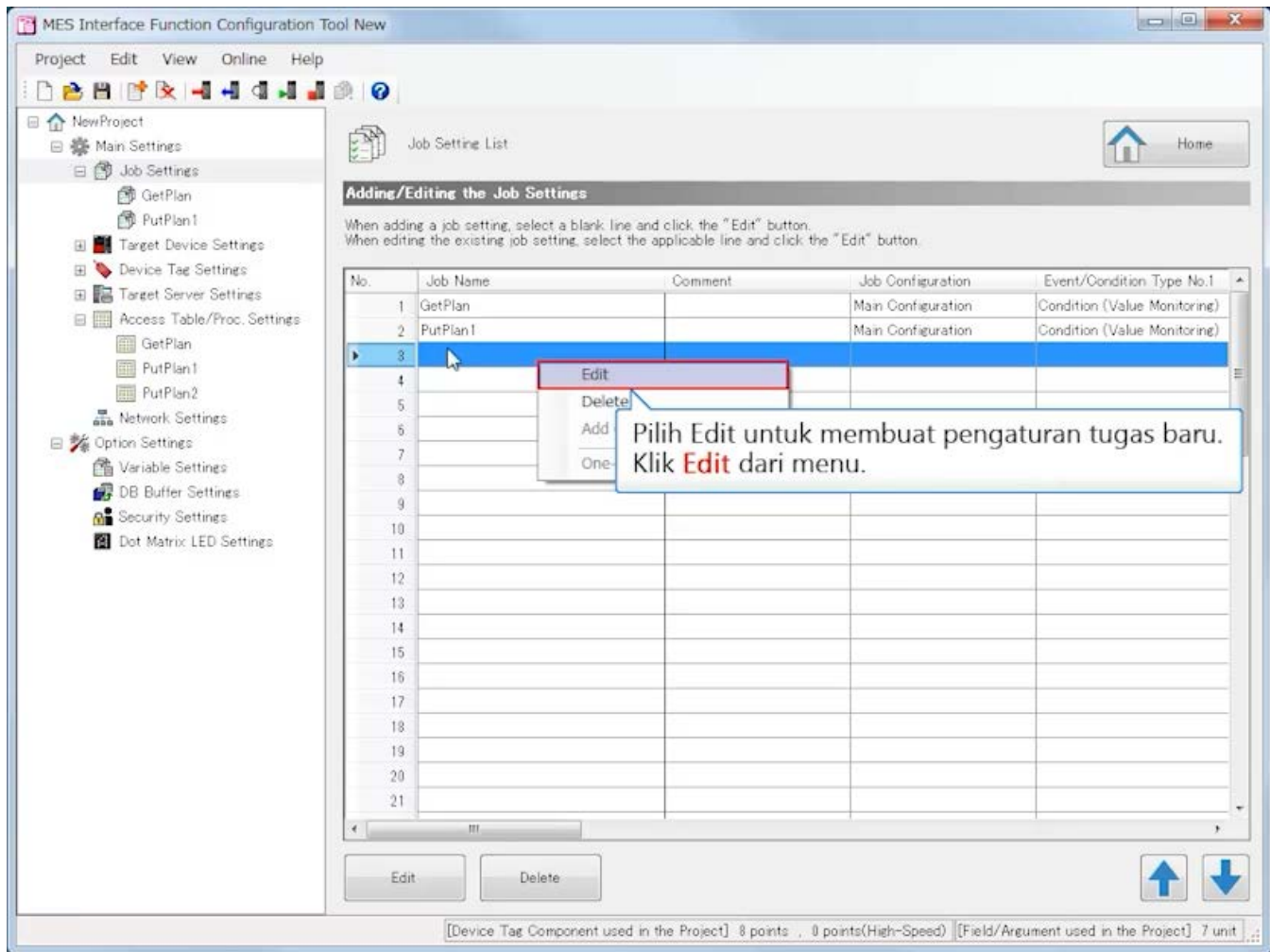
Kembali

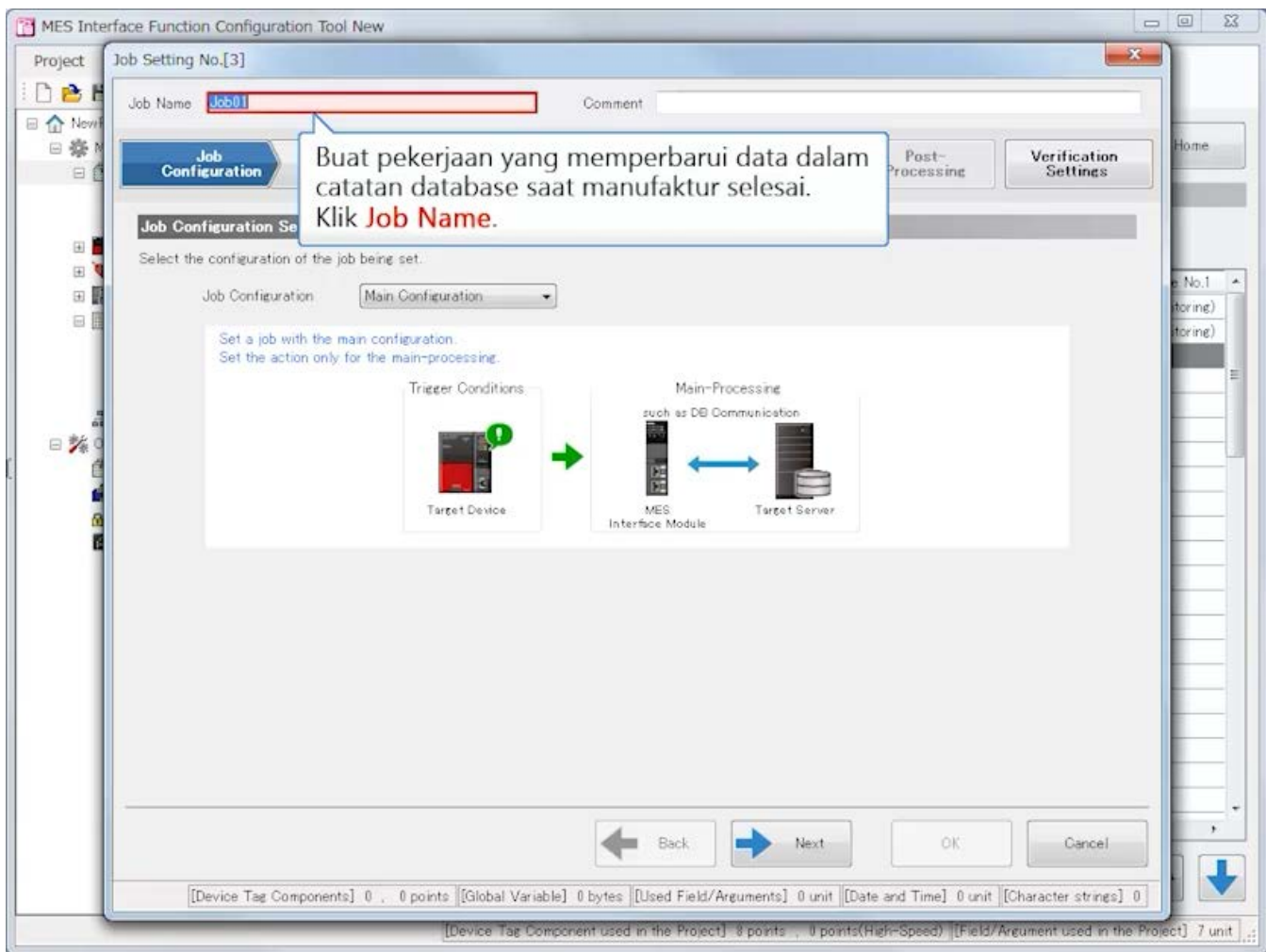
Berikutnya

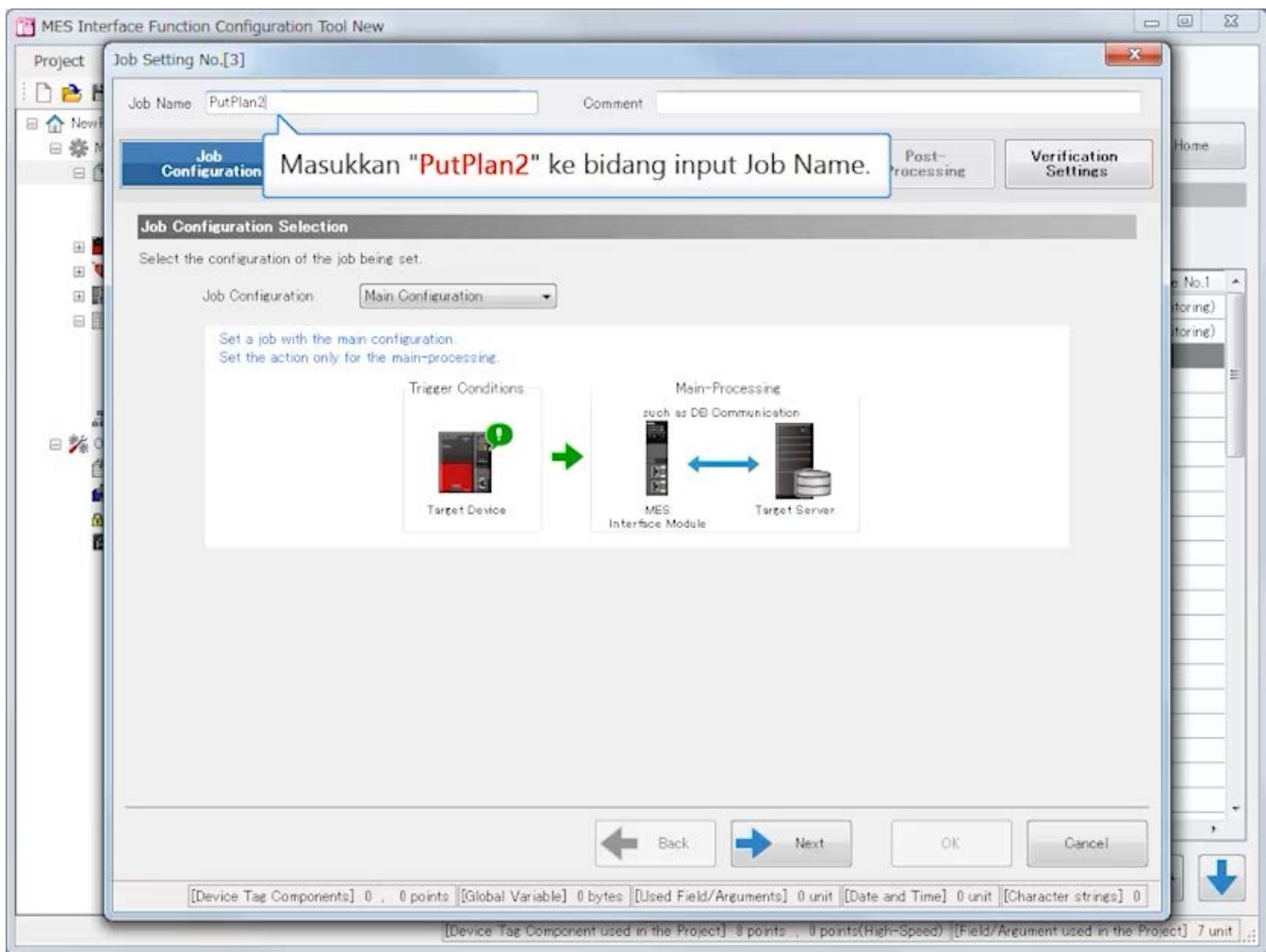


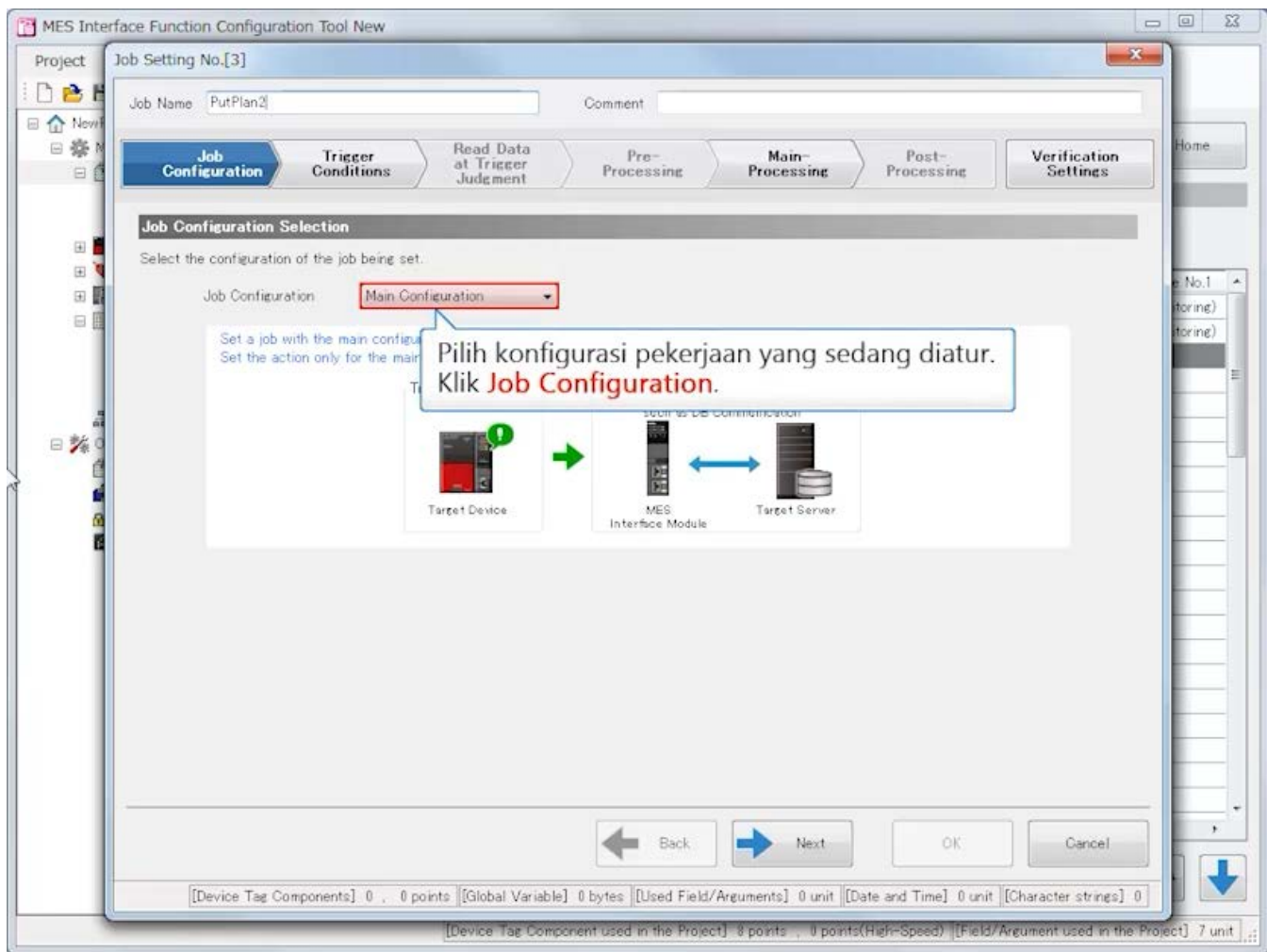
Kembali

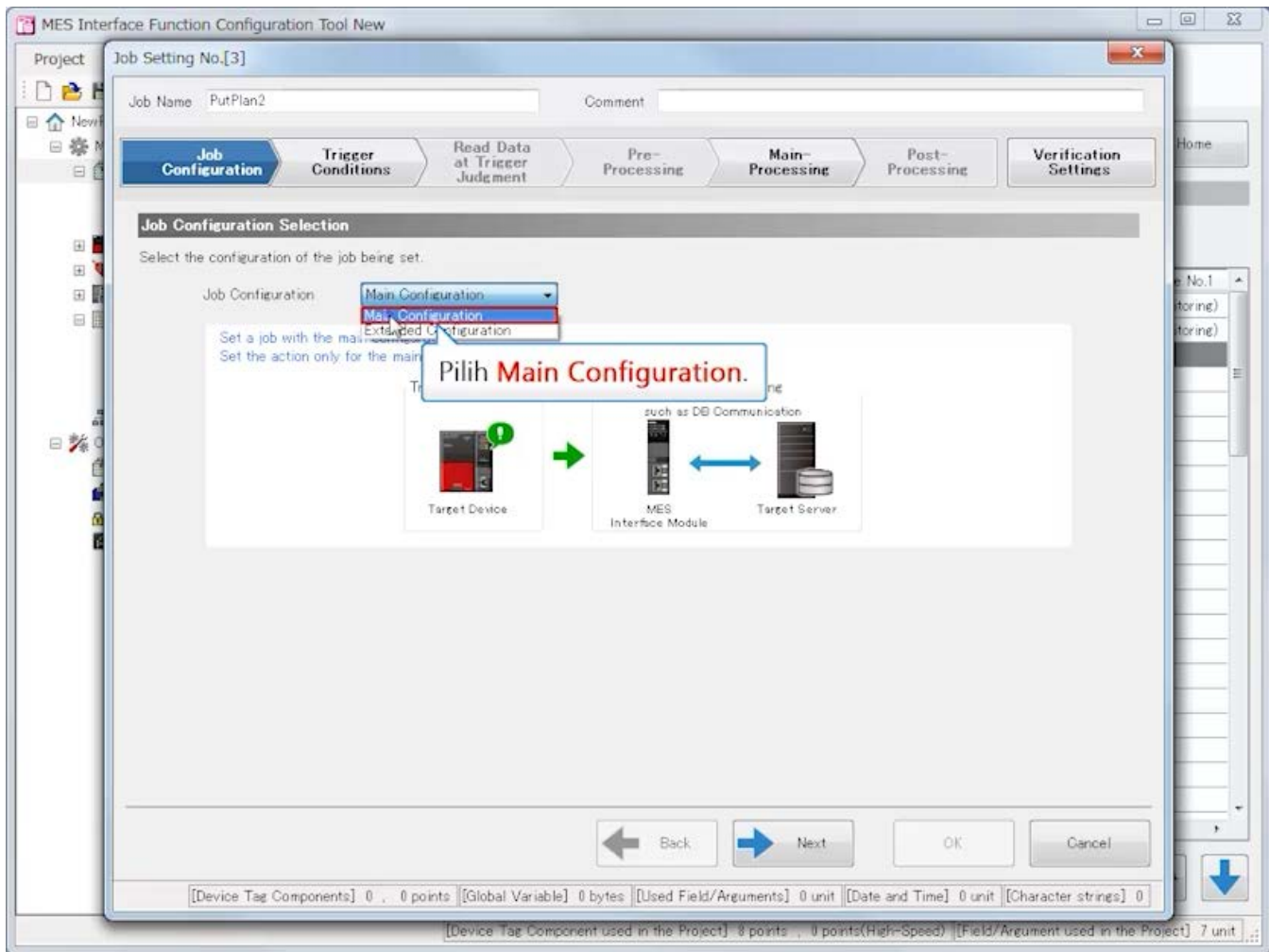
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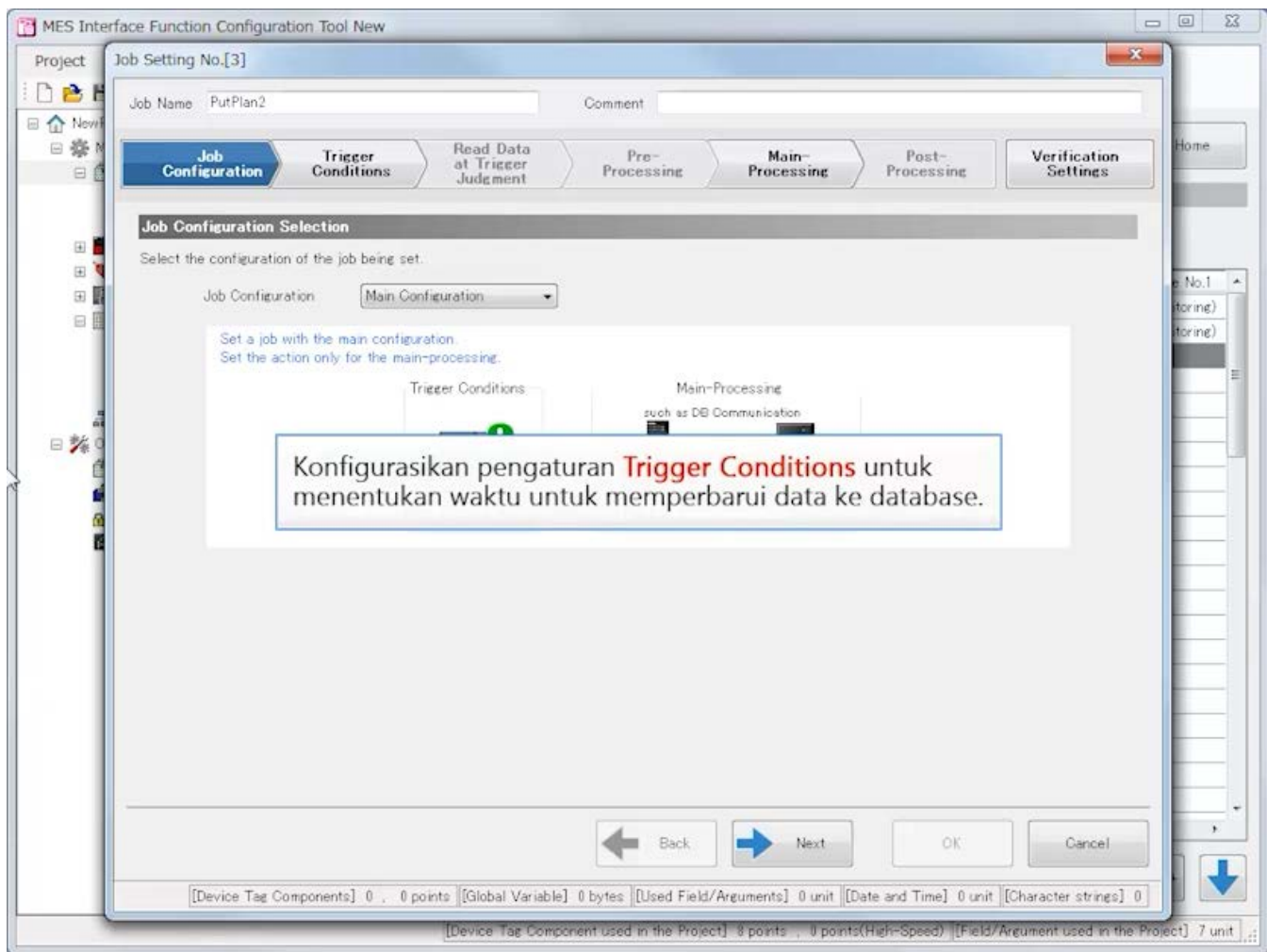


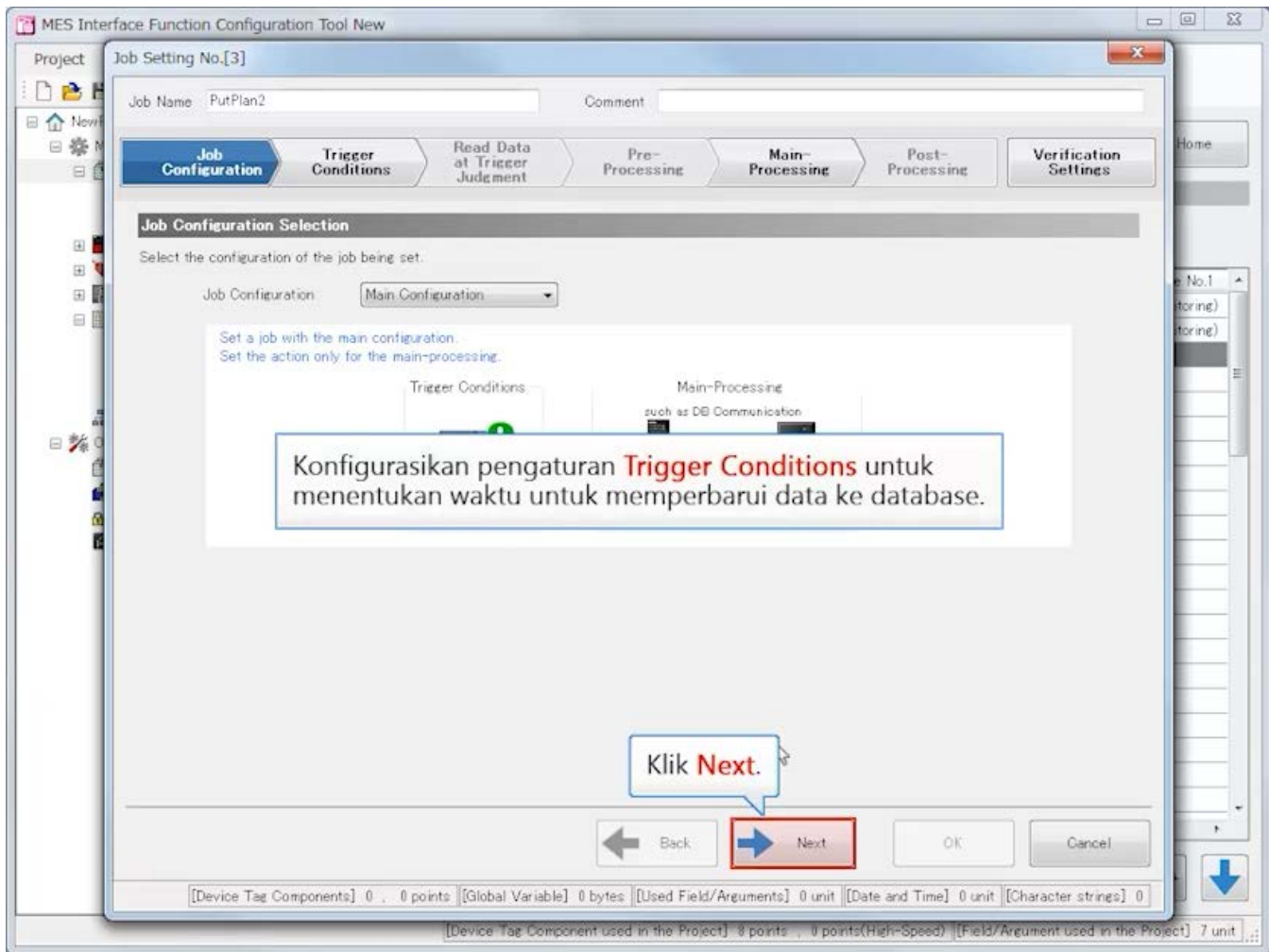
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MES Interface Function Configuration Tool New

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			

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

Kembali

Berikutnya

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 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

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

Pilih **Single Event** untuk mengatur terjadinya peristiwa tertentu sebagai pemicu.

Kembali

Berikutnya

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			

Mengatur kejadian/kondisi.
Klik tombol **Edit**.

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

Kembali

Berikutnya

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)** 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

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)
		=		

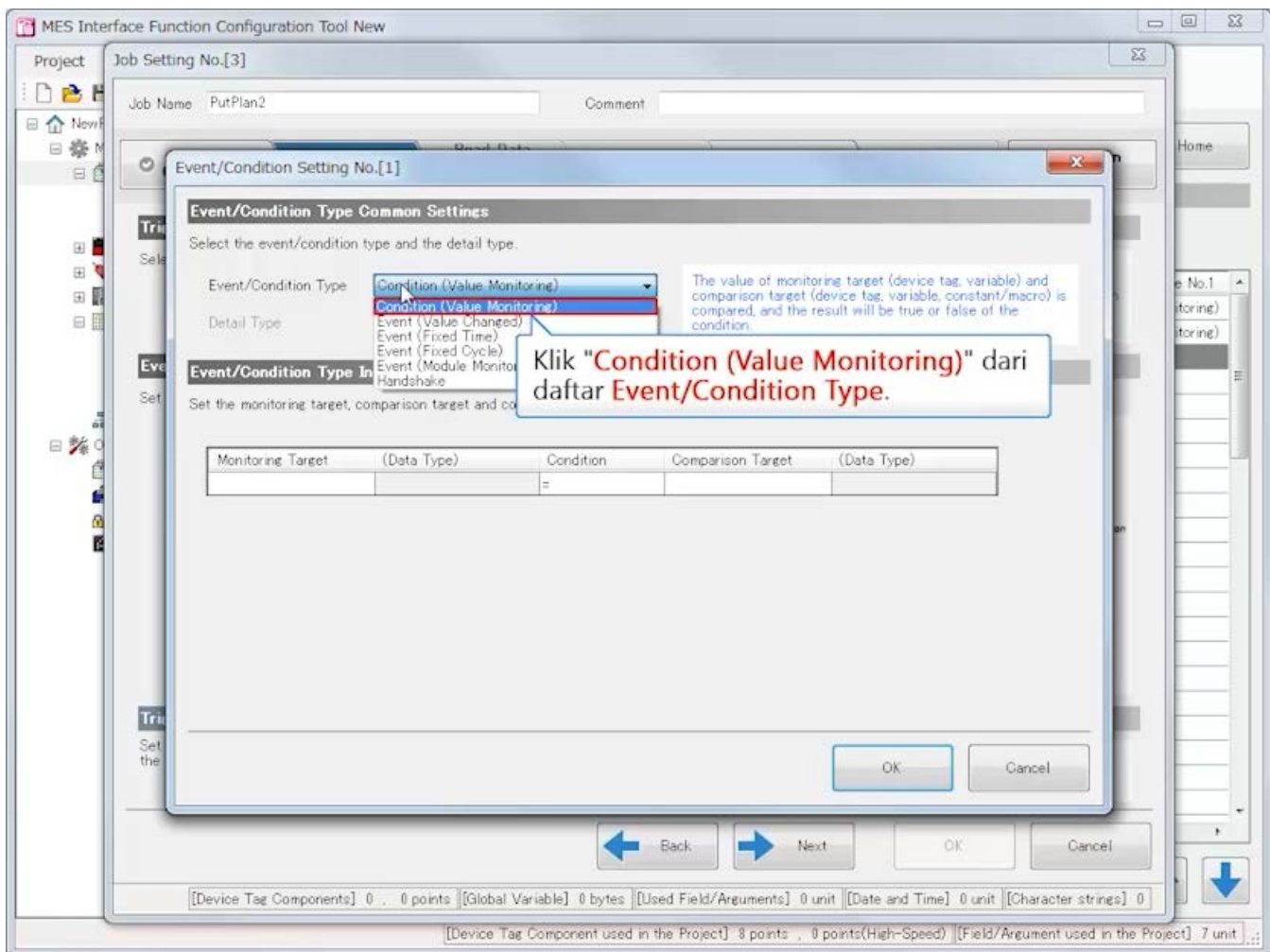
OK Cancel

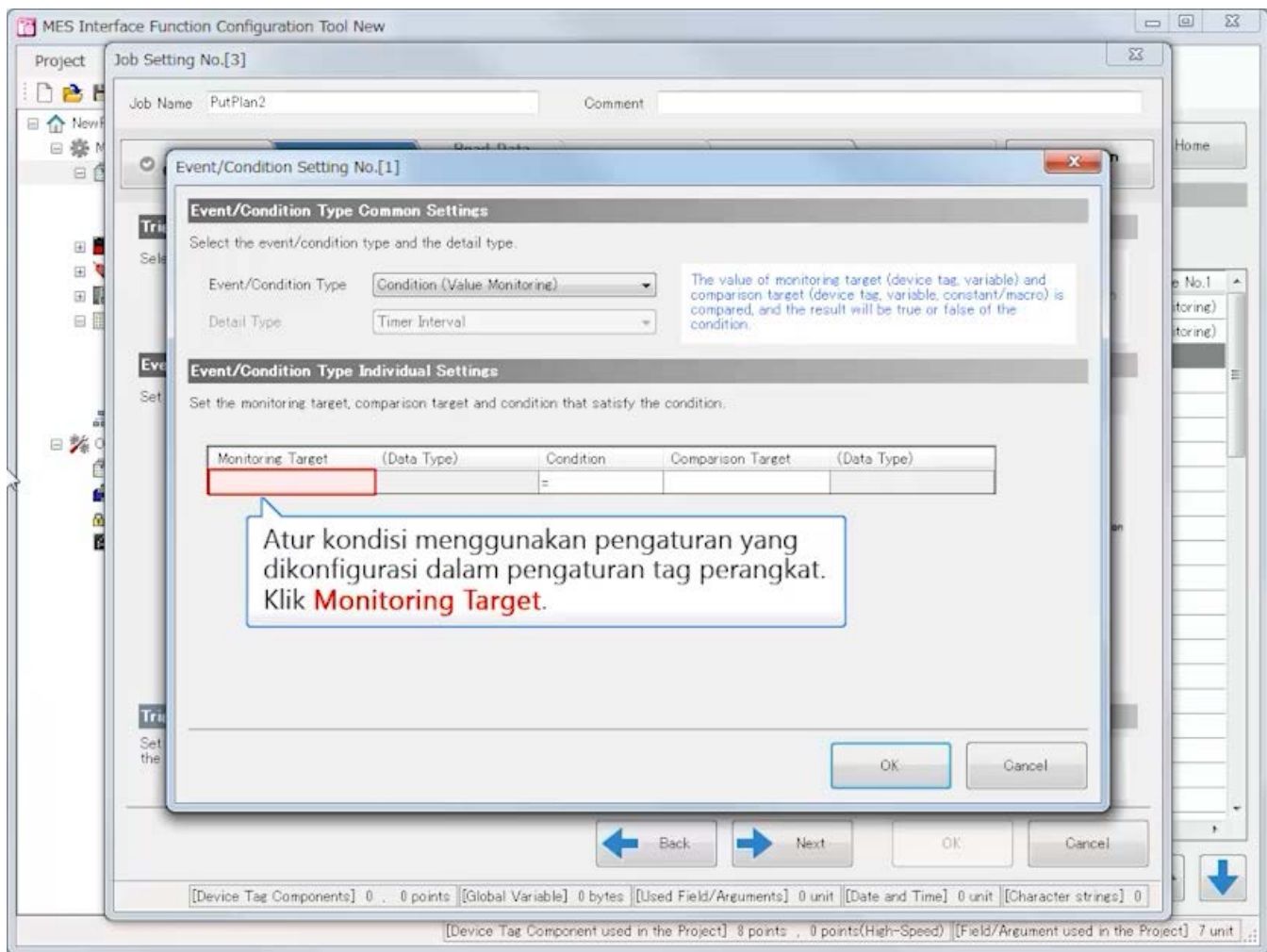
← Back → Next OK Cancel

[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

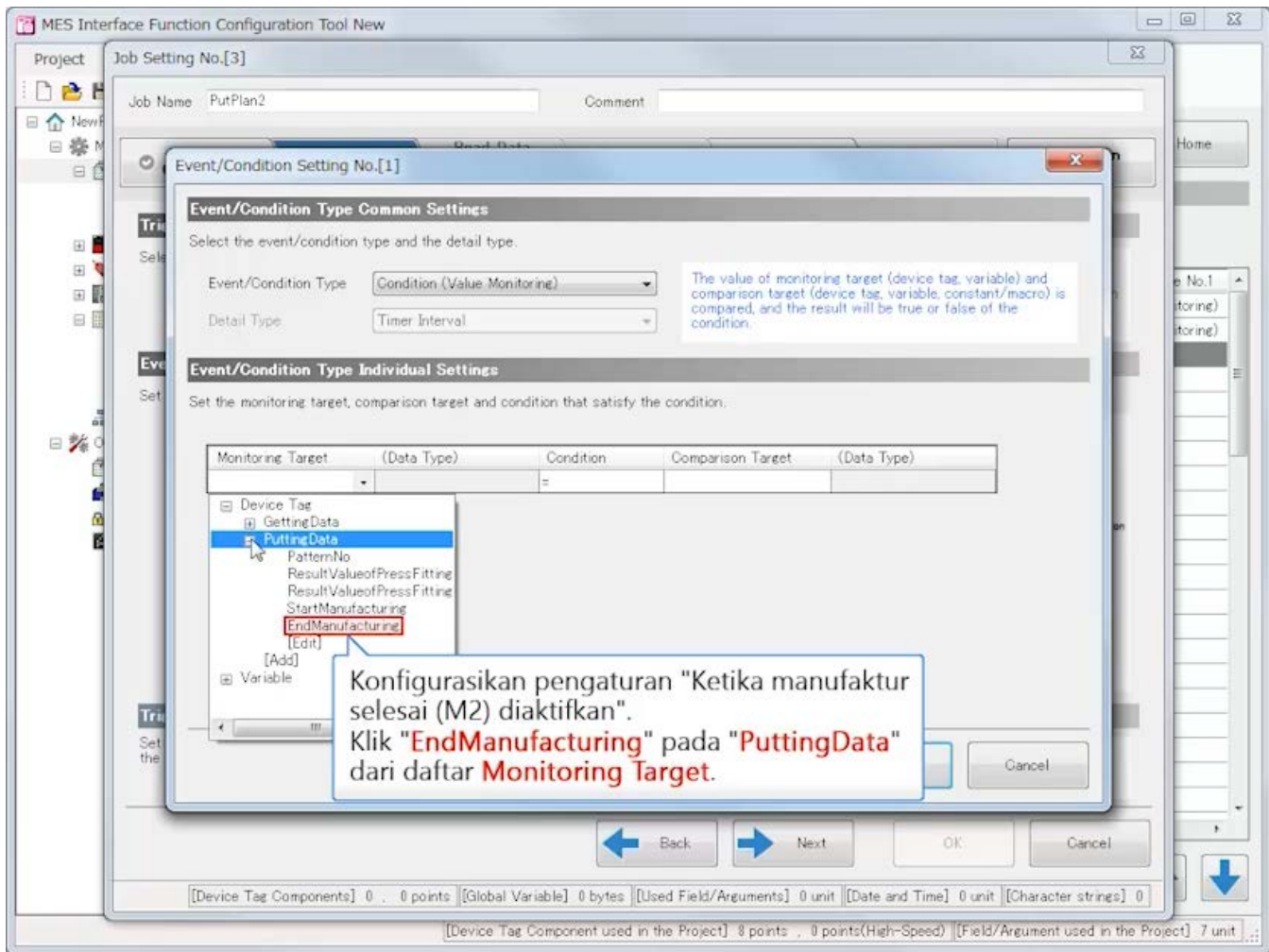
Klik Event/Condition Type.

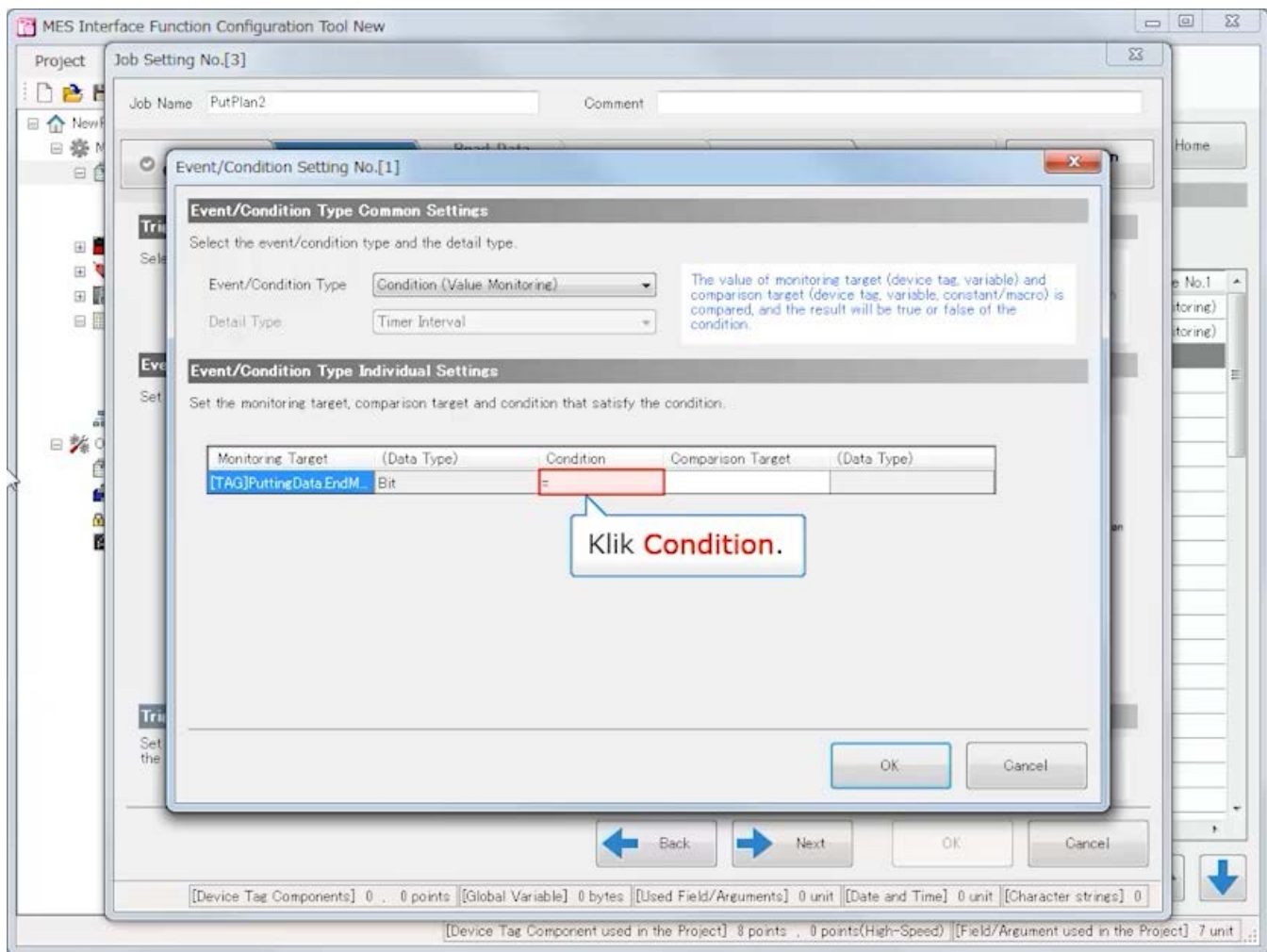
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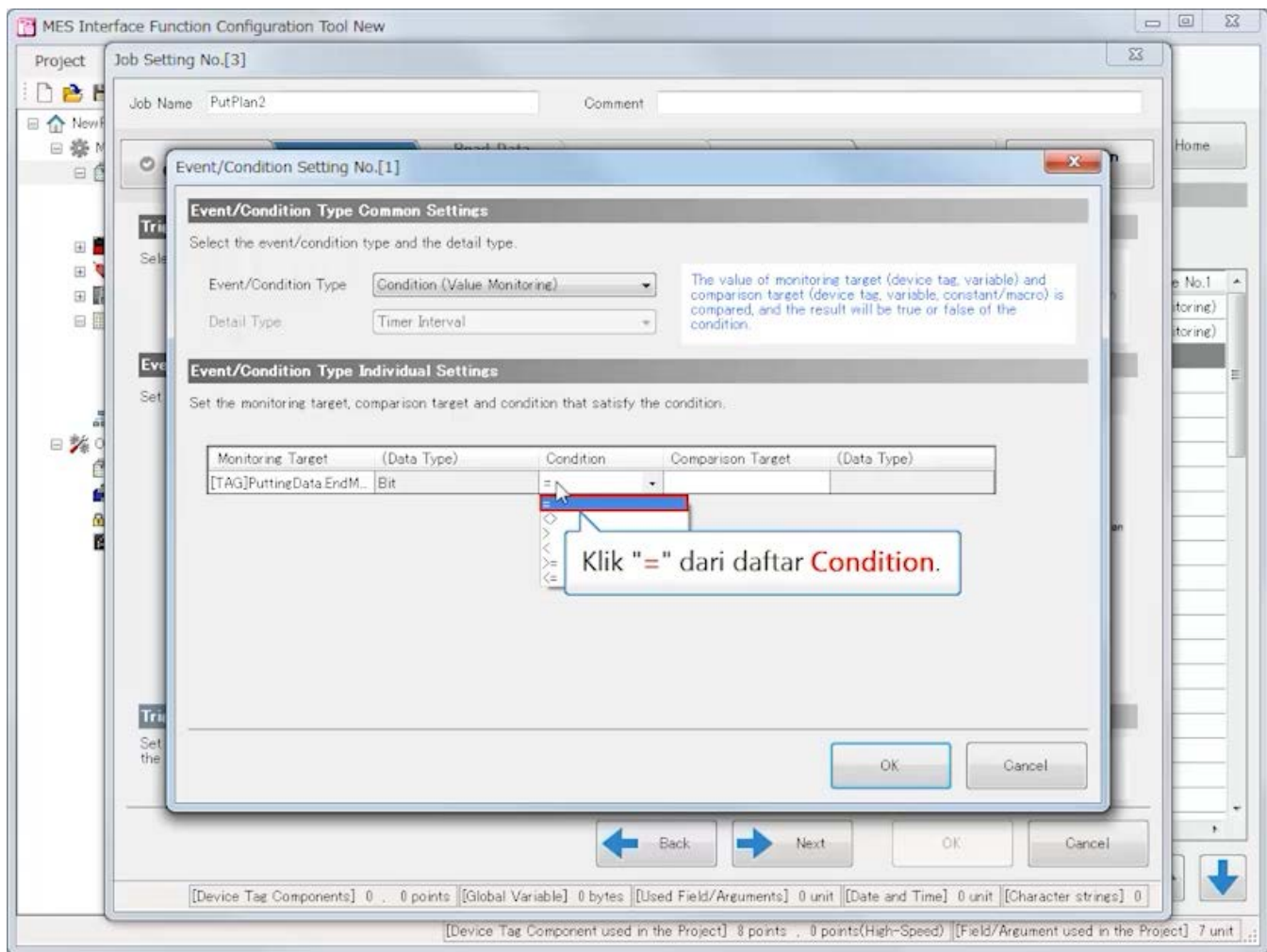
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MES Interface Function Configuration Tool New

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	=		

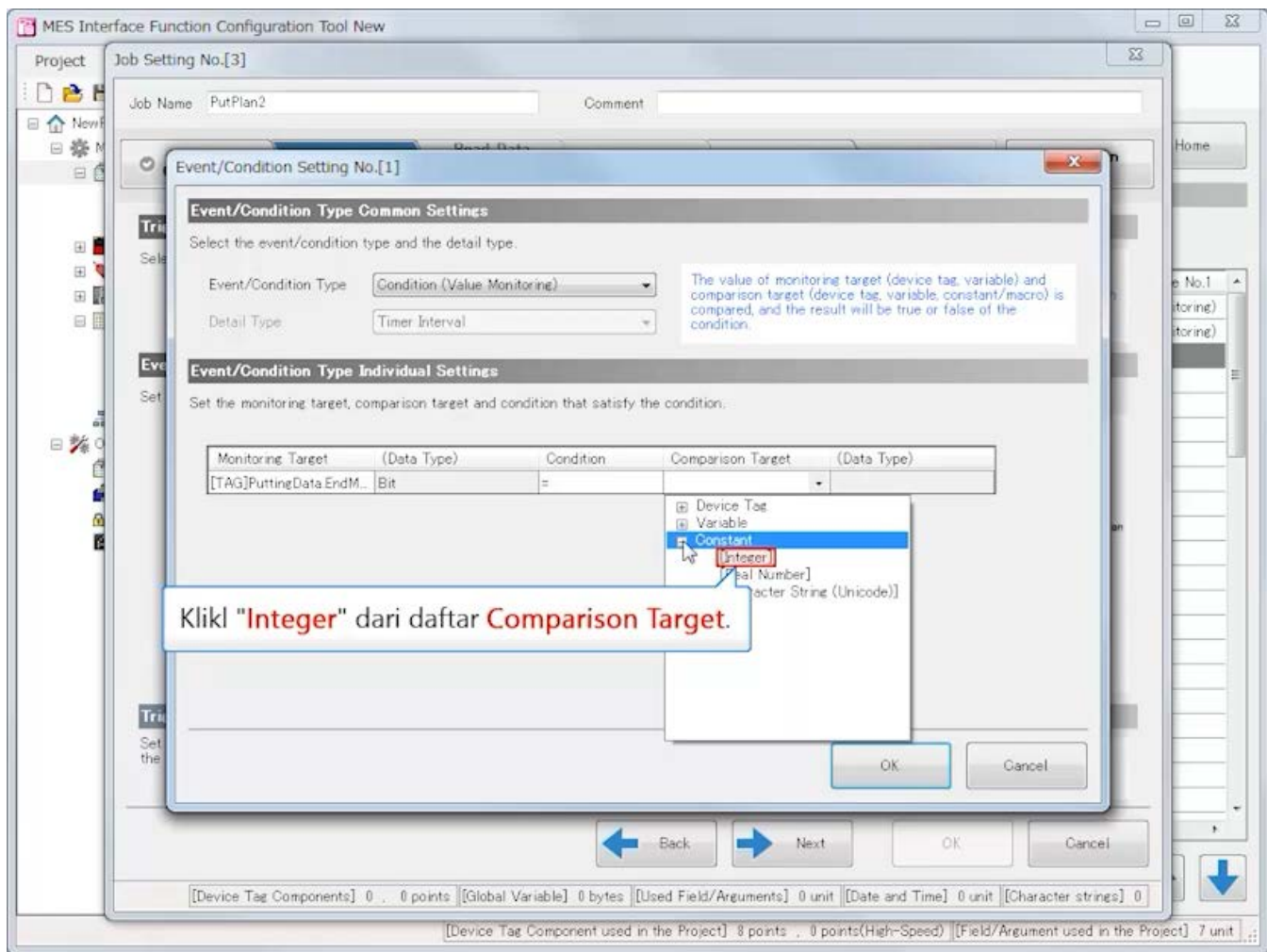
Klik **Comparison Target**.

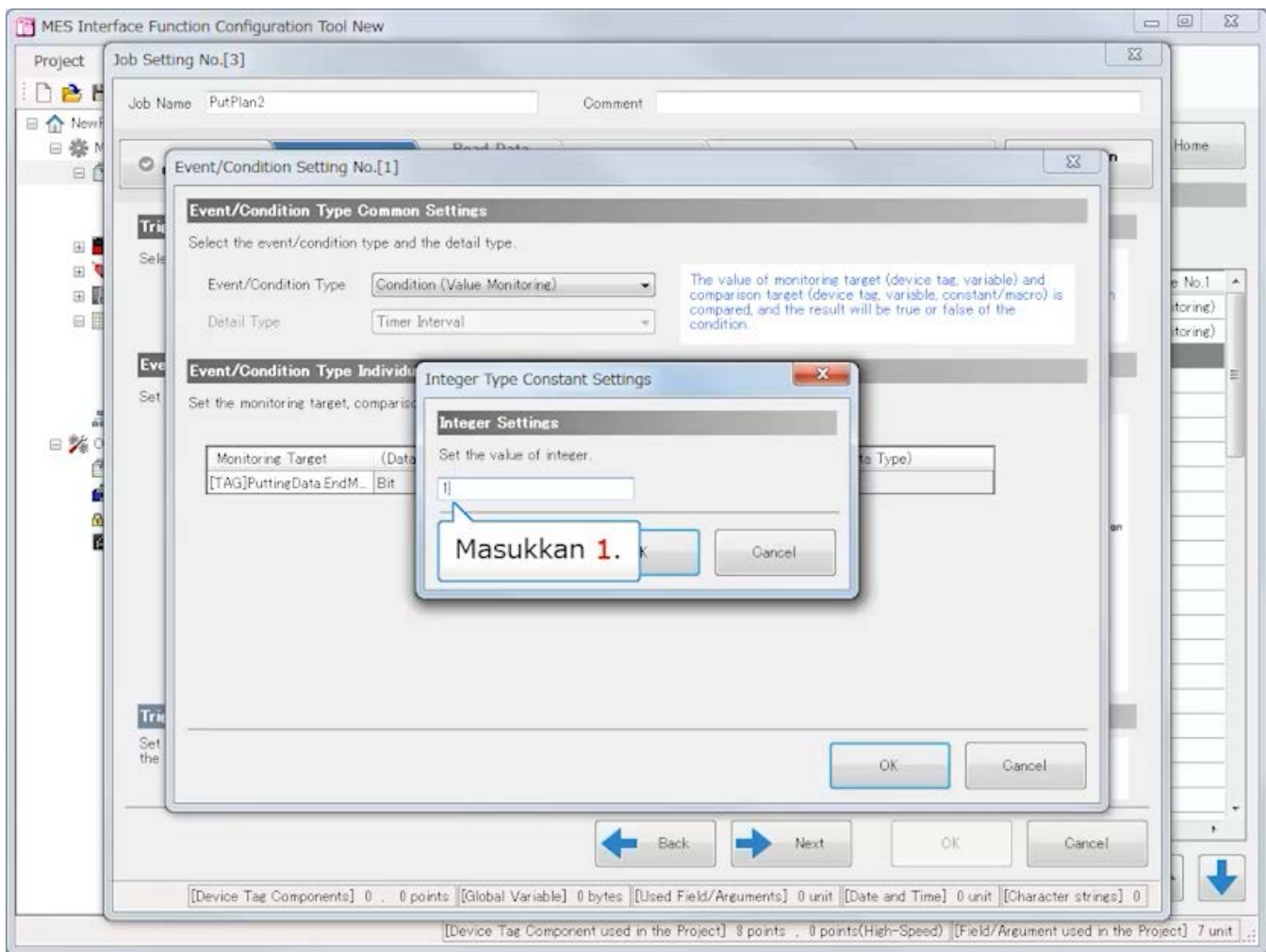
OK Cancel

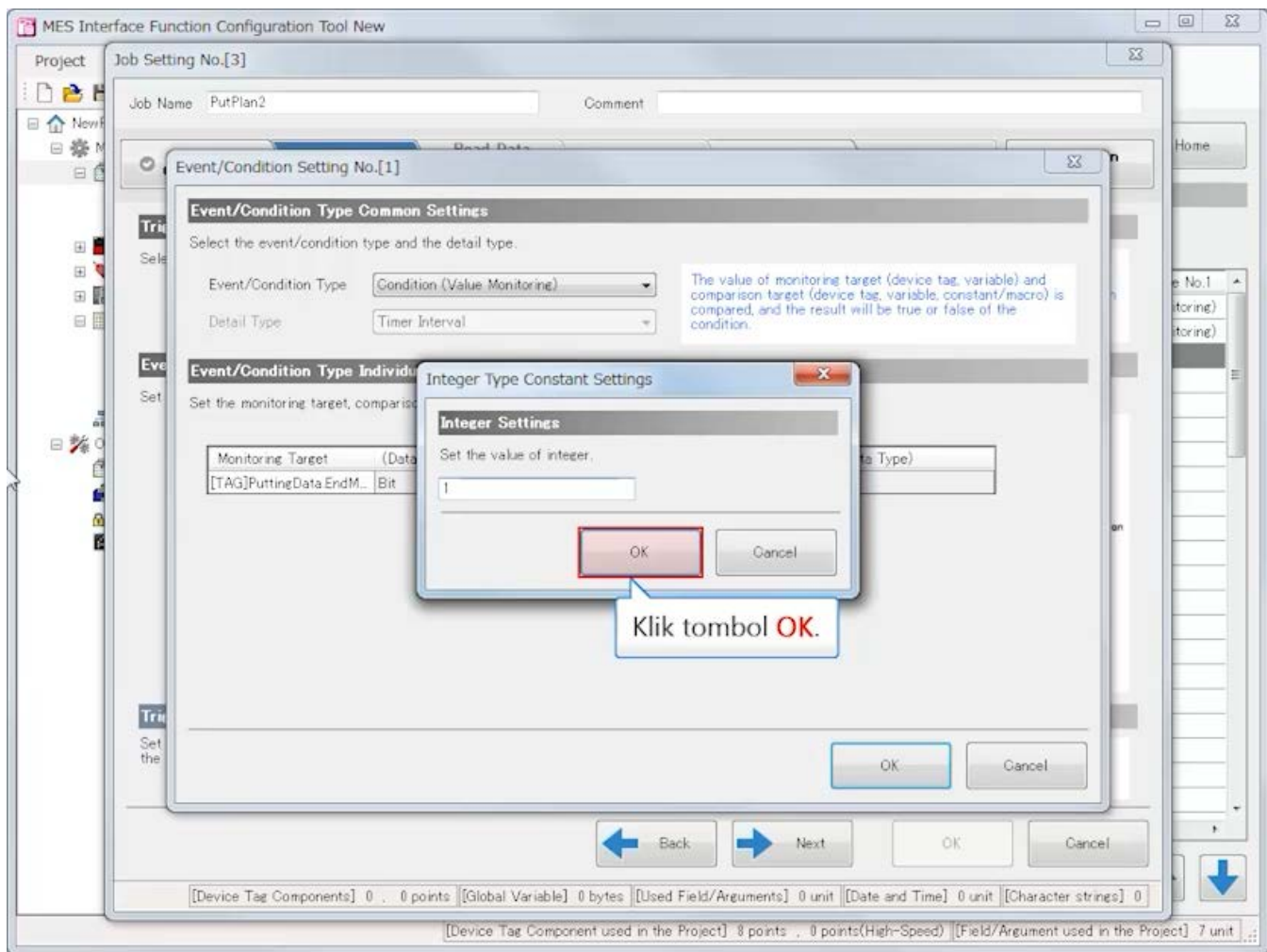
Back Next OK Cancel

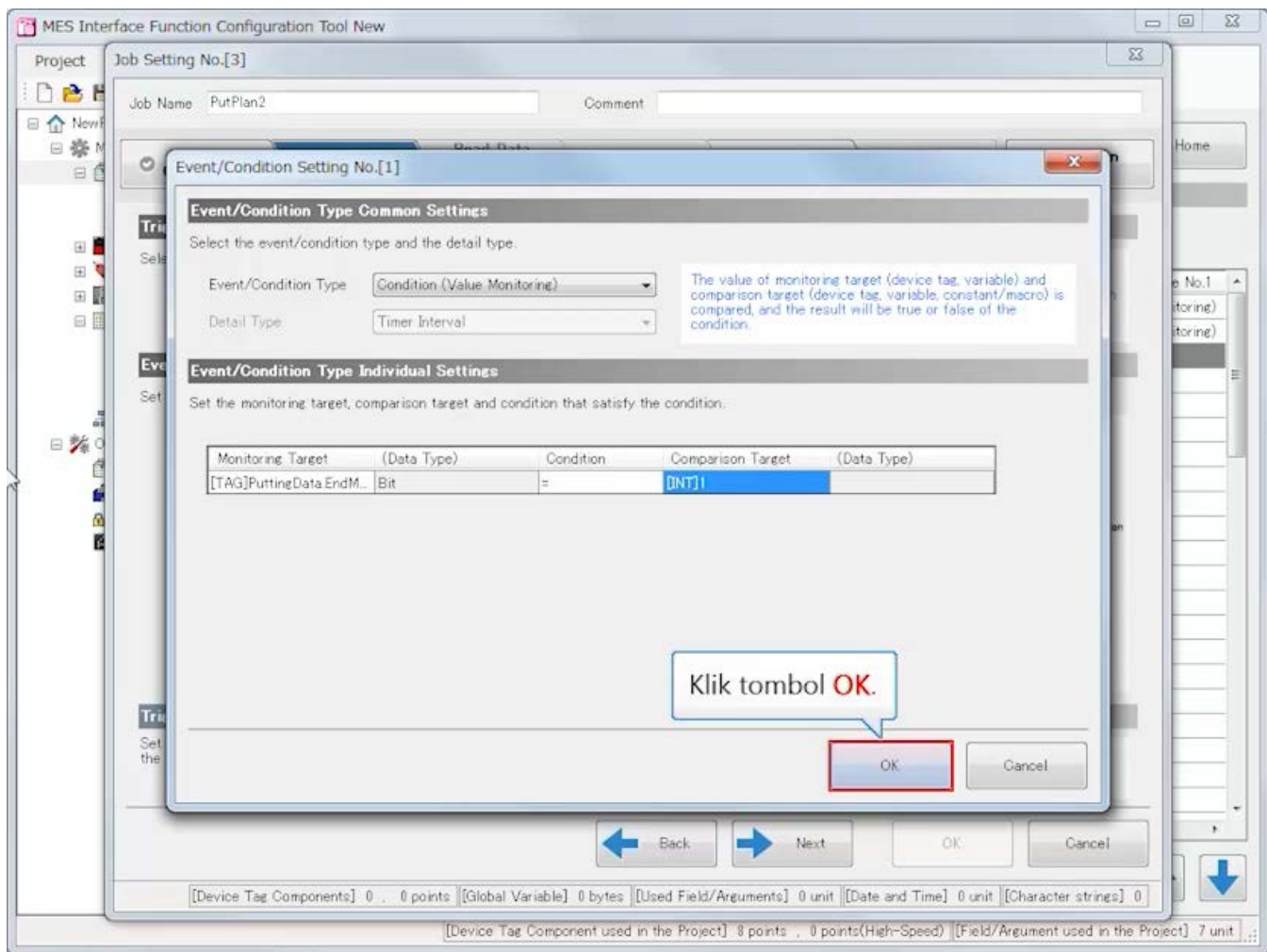
[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

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Kembali

Berikutnya

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 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.

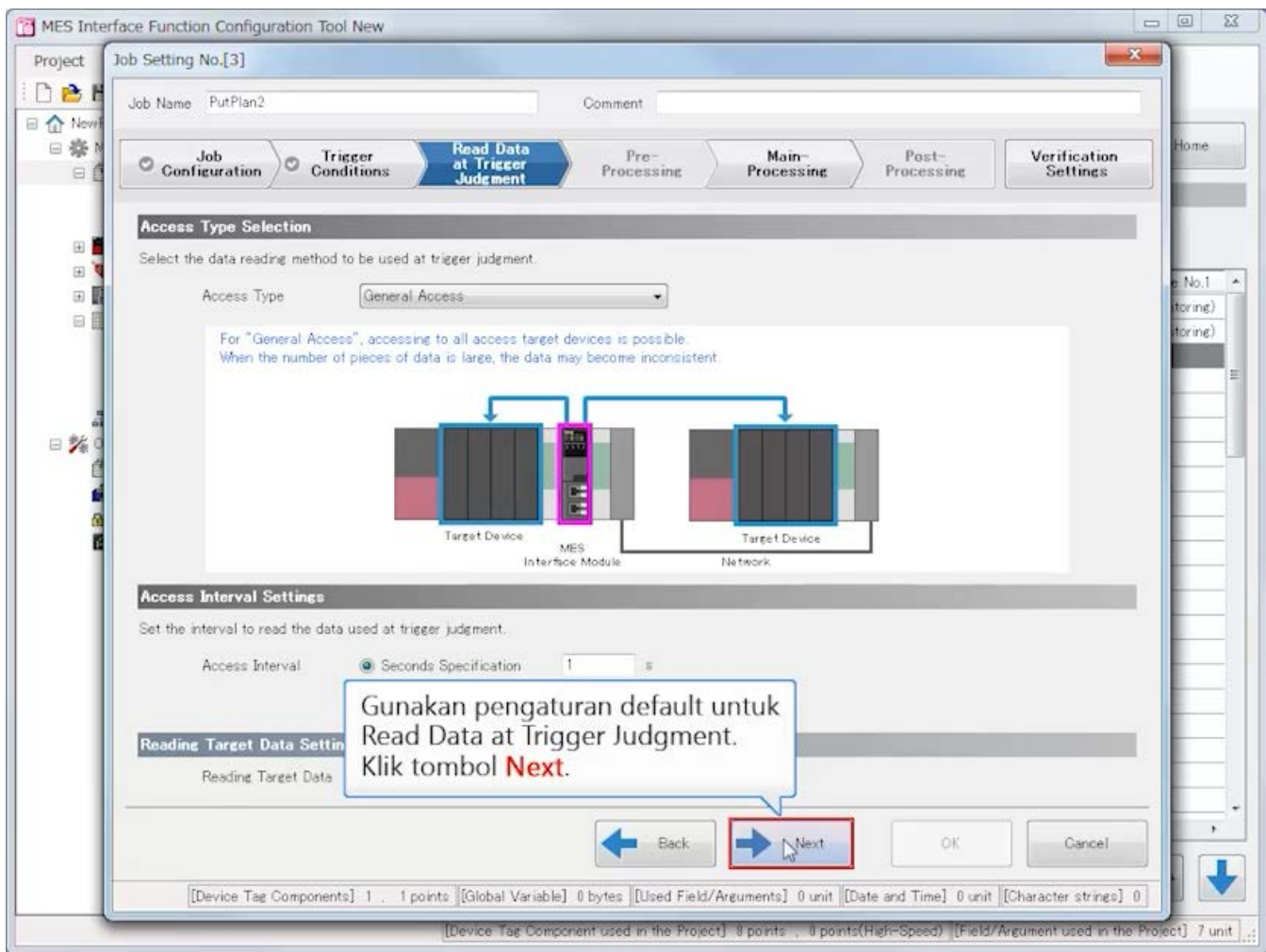
Trigger Buffering Disable

Klik Next.

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

[Kembali](#)[Berikutnya](#)

Kembali

Berikutnya

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		

Konfigurasi pengaturan main-processing.
Klik tombol **Edit**.

Edit Delete

Operation Settings at Main-Processing Failure (optional)

At Processing Failure Notification: "Not Set" Change

DB Buffering Settings (optional)

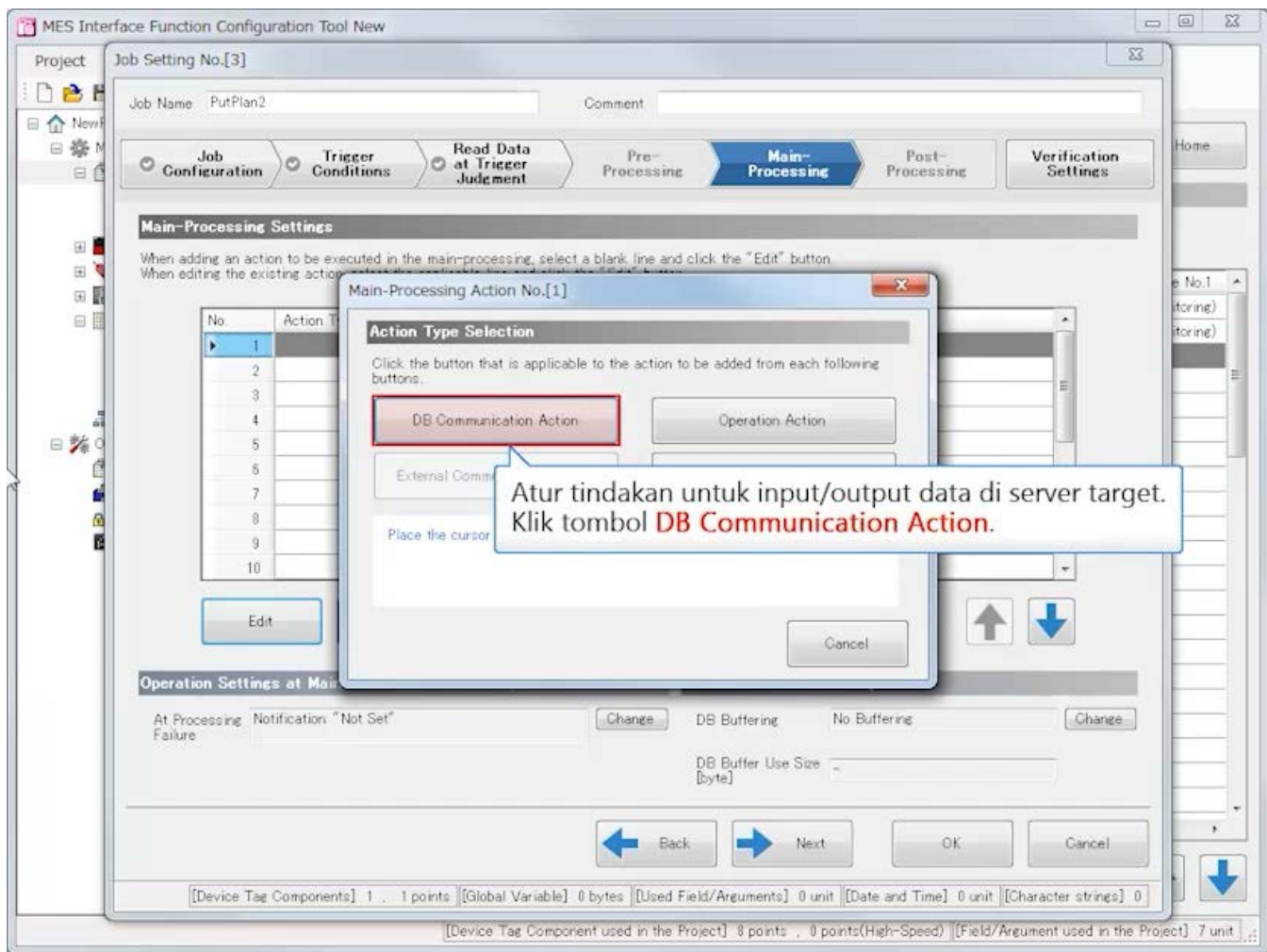
DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

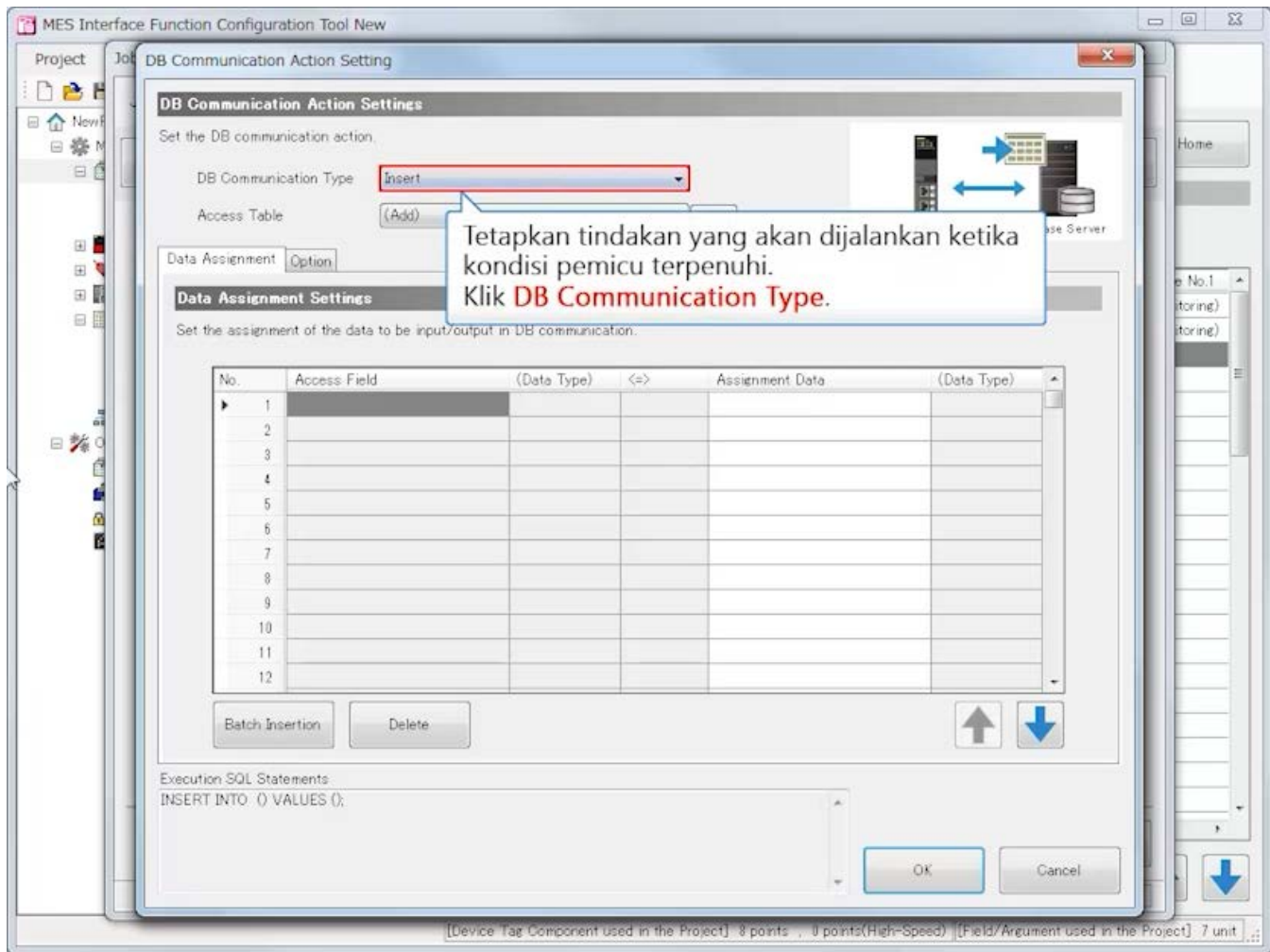
[Device Tag Components] 1 , 1 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

[Kembali](#)
[Berikutnya](#)


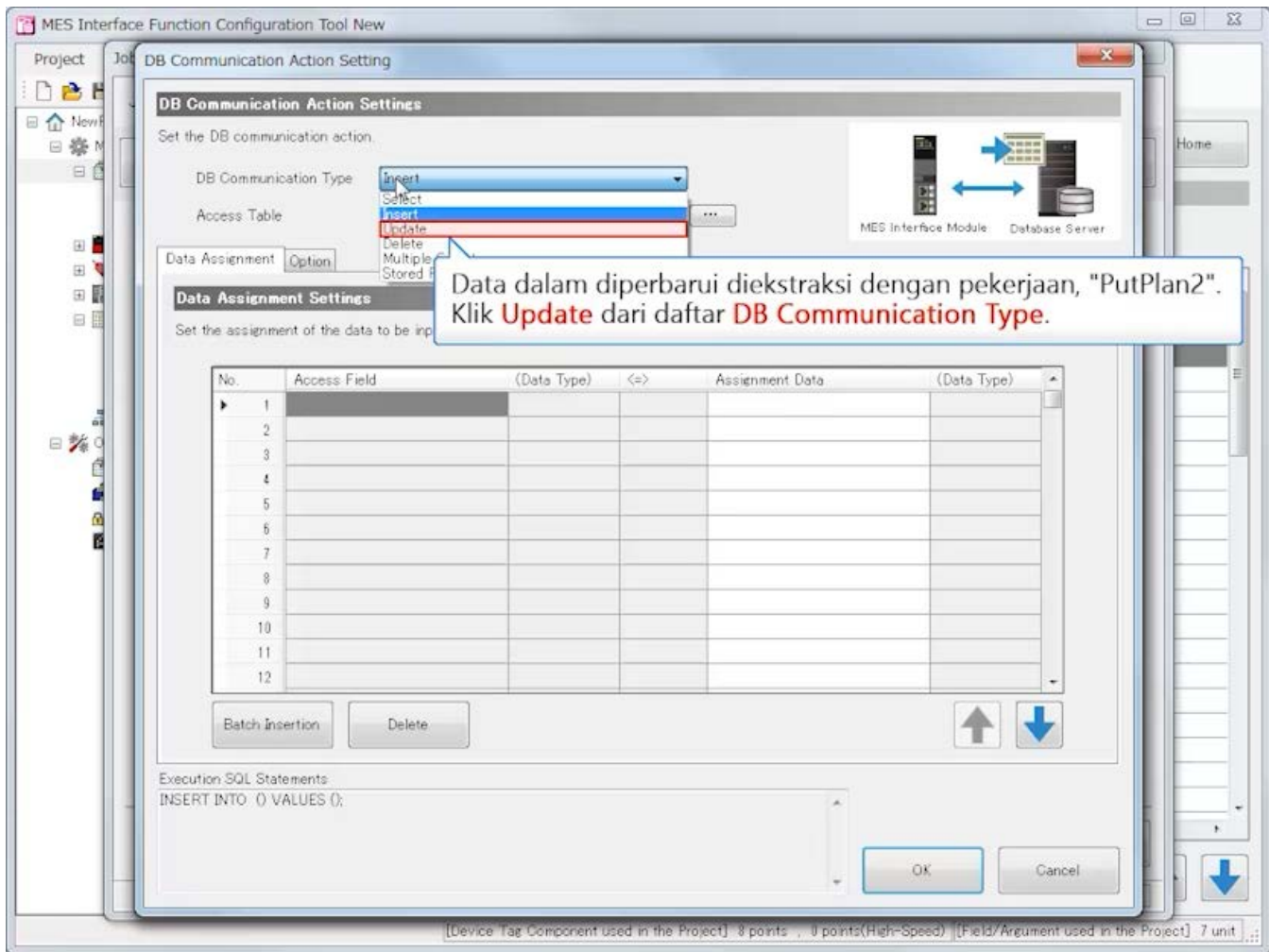
Kembali

Berikutnya



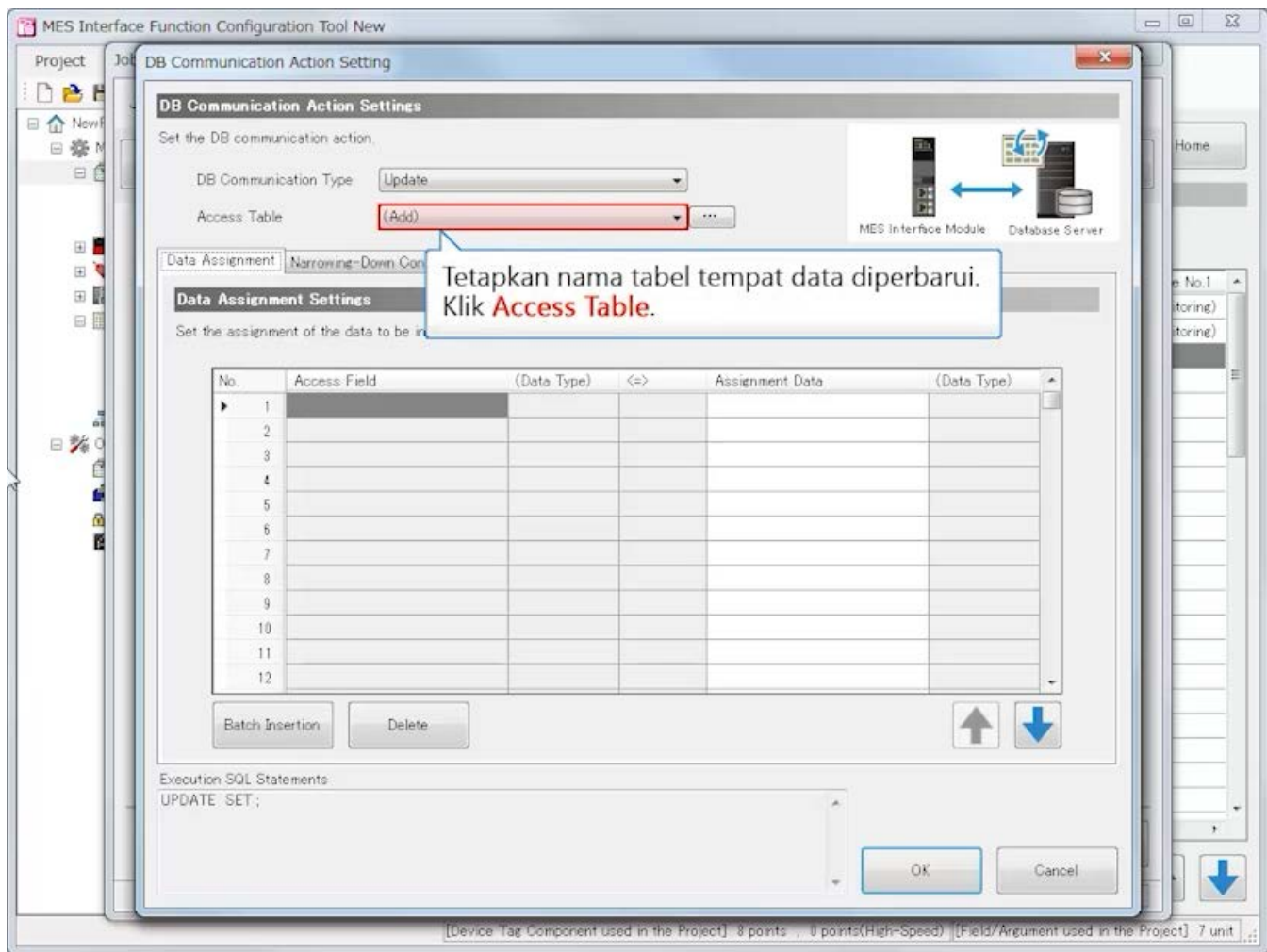
Kembali

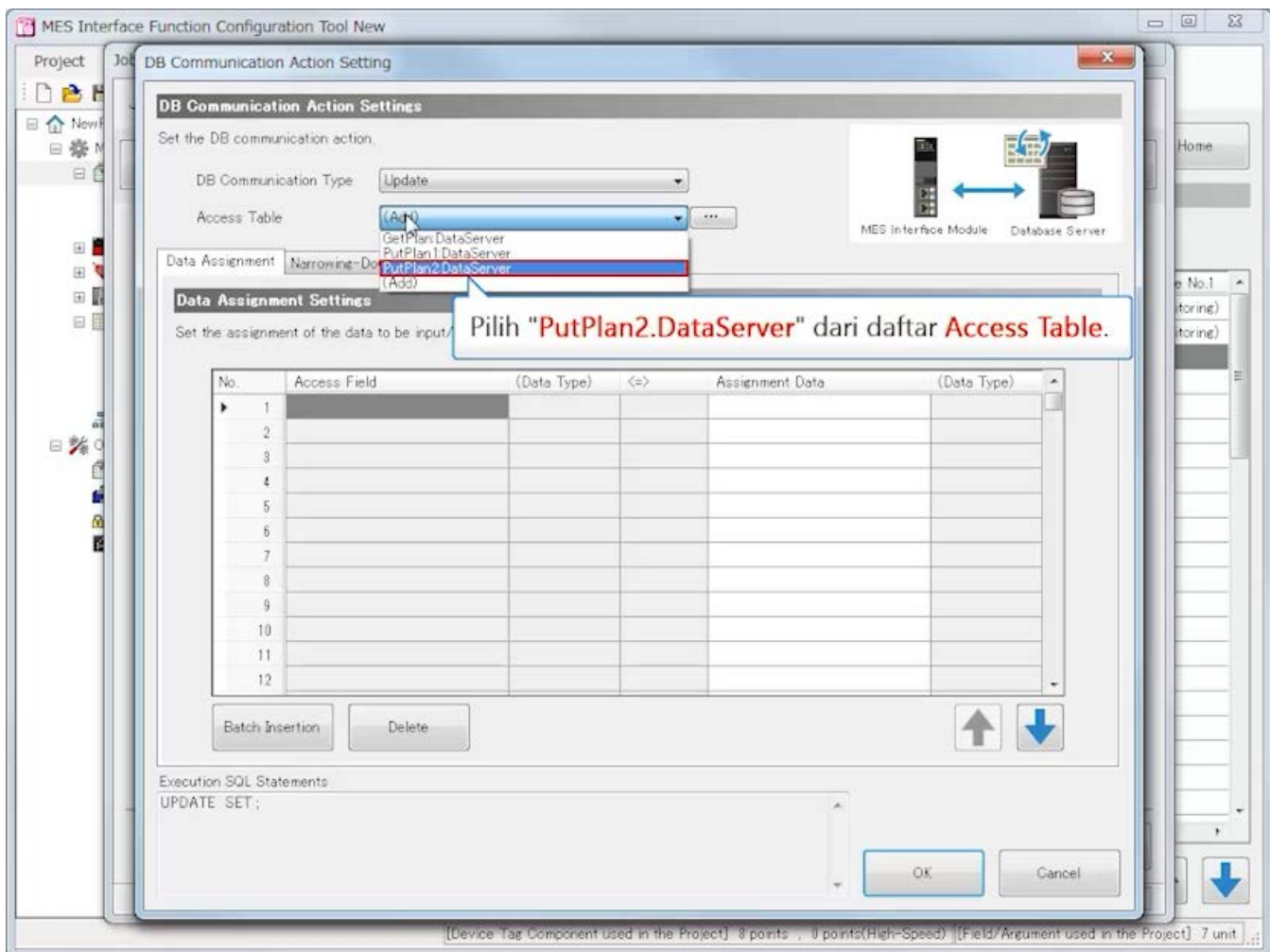
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Kembali

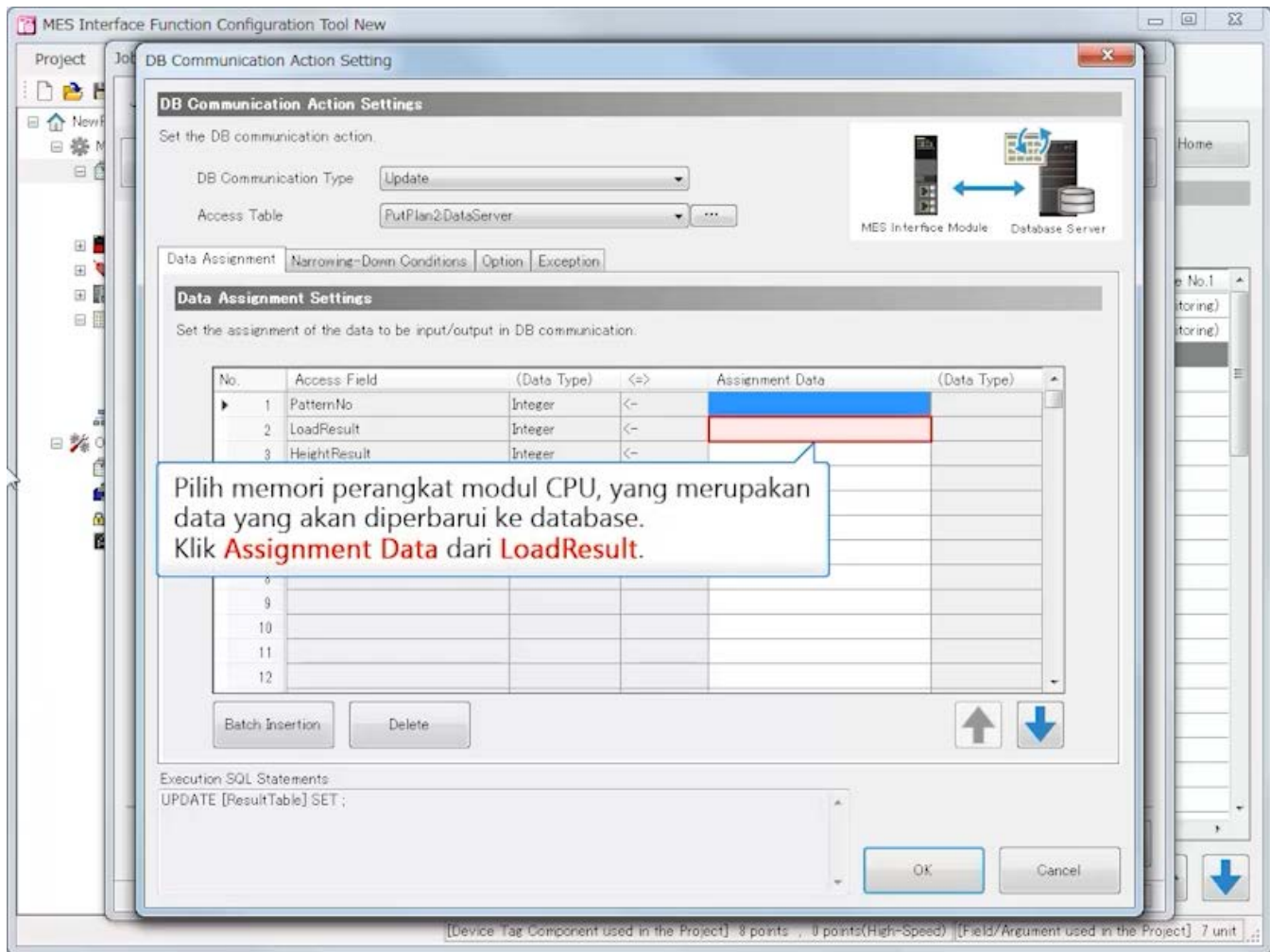
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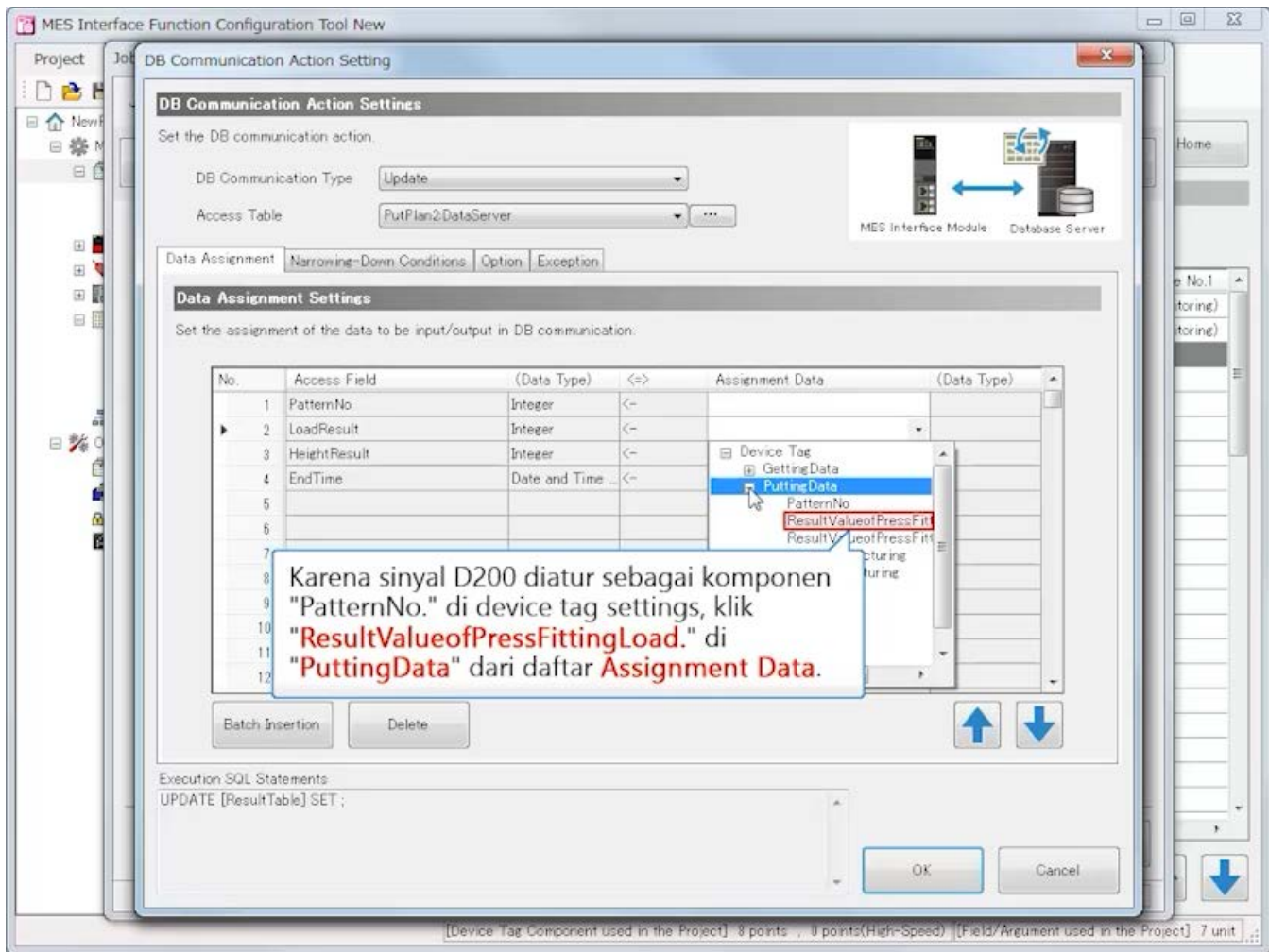
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

MES Interface Function Configuration Tool New

Project Job 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	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-		
4	EndTime	Date and Time ...	<-		
5					

Selanjutnya, atur pengaturan tautan berikut ke baris No. 3 hingga 4.
Prosedur pengaturannya sama dengan "LoadResult".
Operasi pengaturan dihilangkan dalam kursus ini.

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

Execution SQL Statements

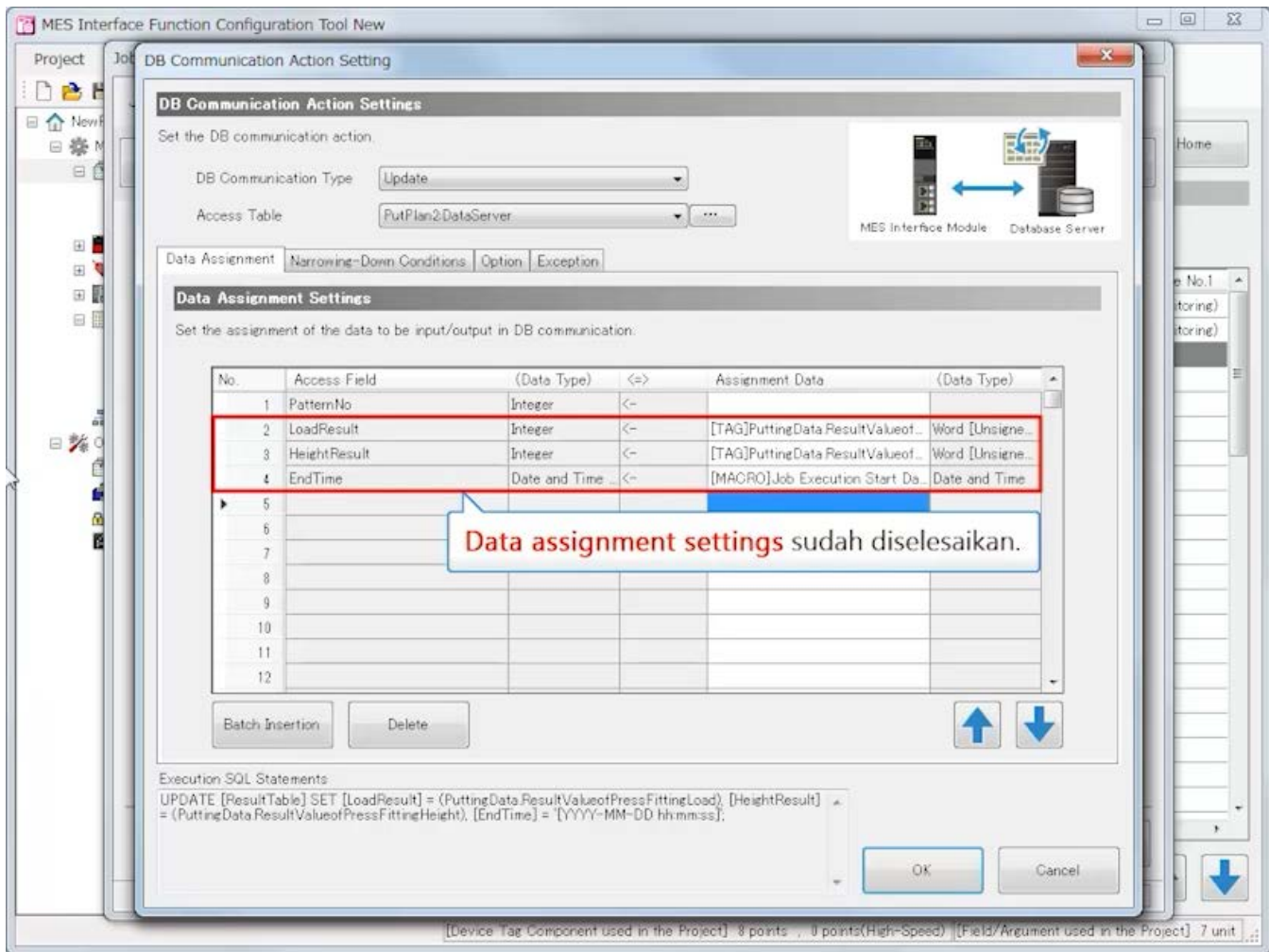
UPDATE [ResultTable] SET [LoadResult] = ([PuttingData.ResultValueofPressFittingLoad]);

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit ...

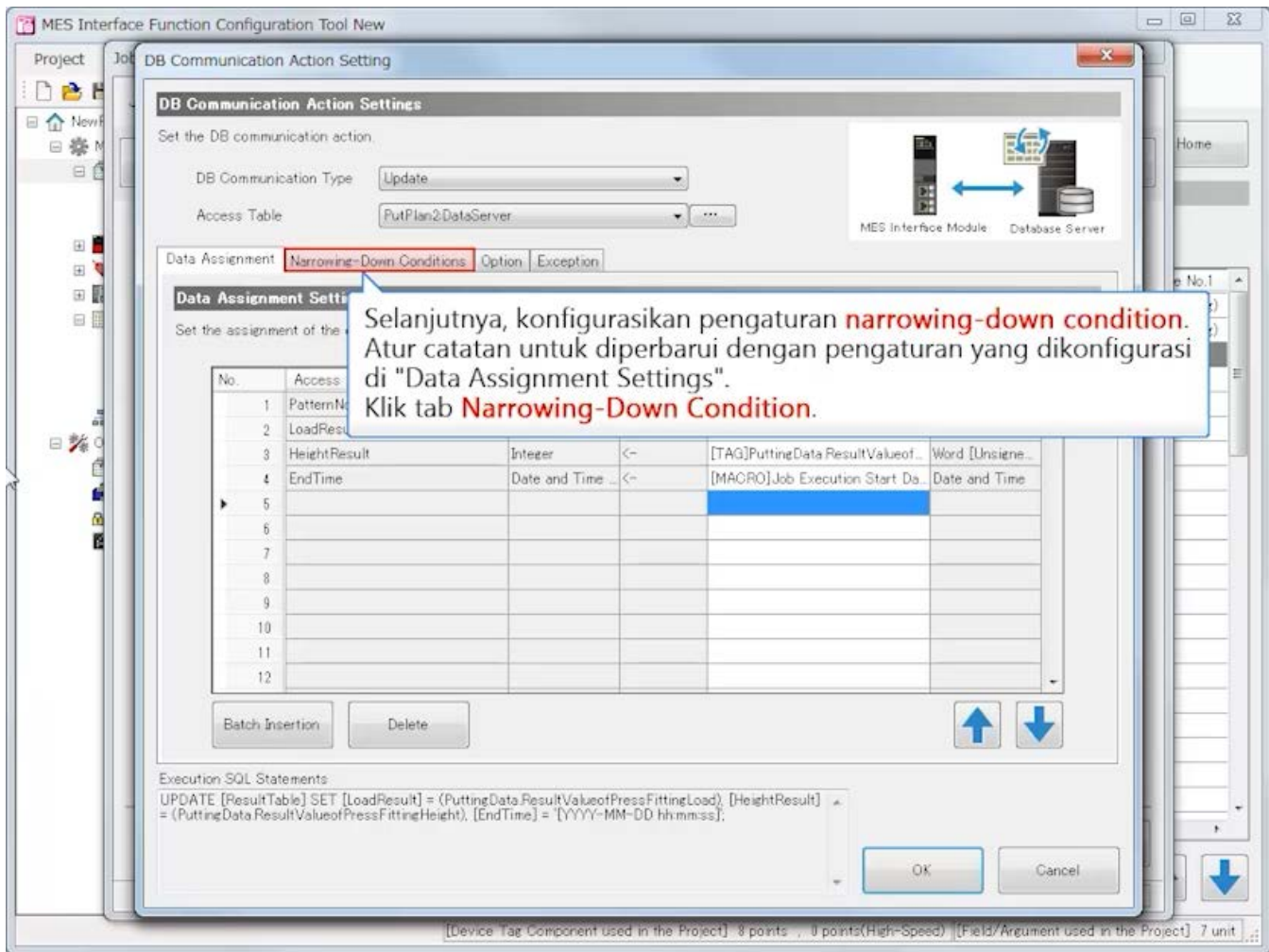
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Berikutnya



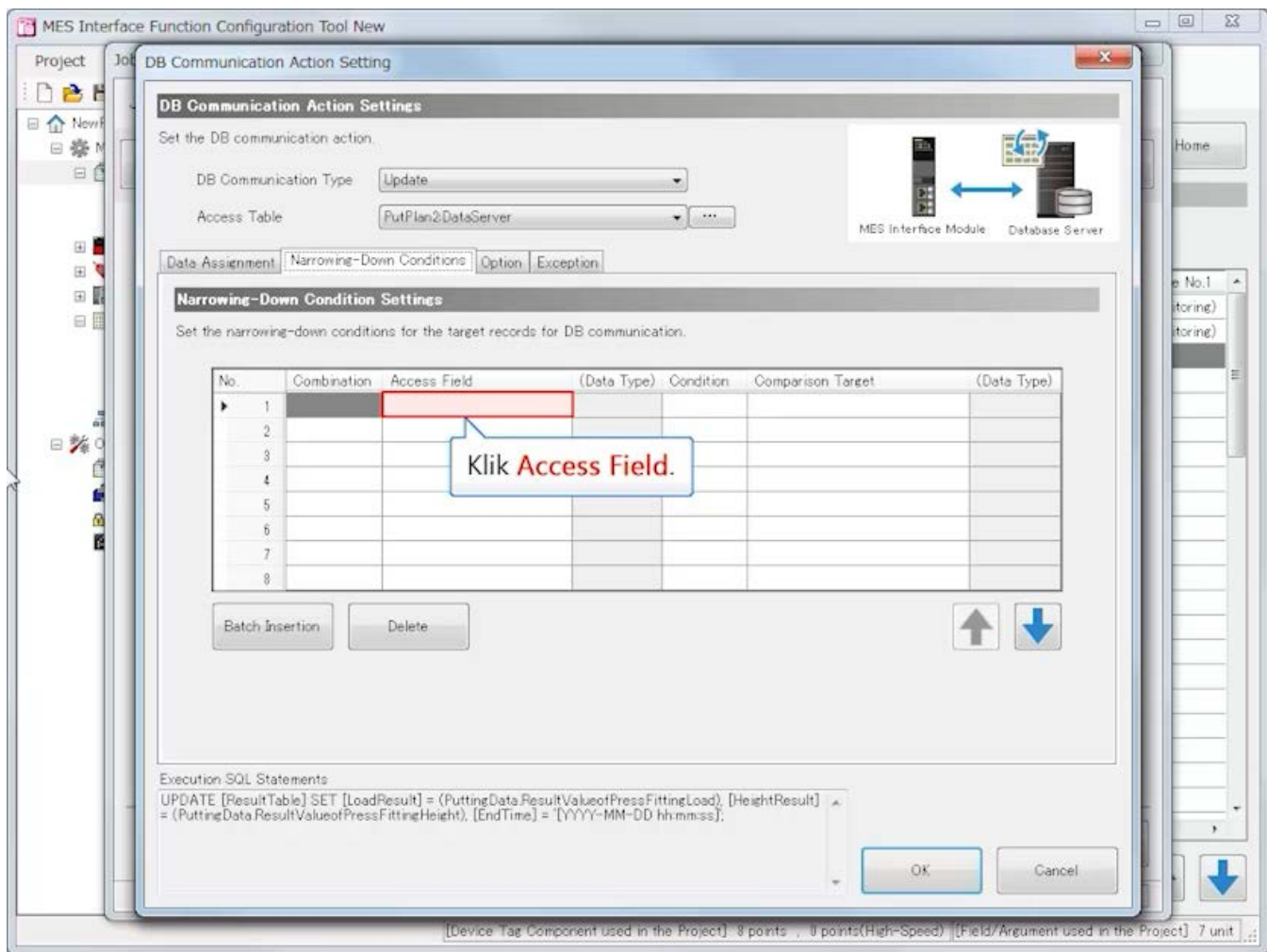
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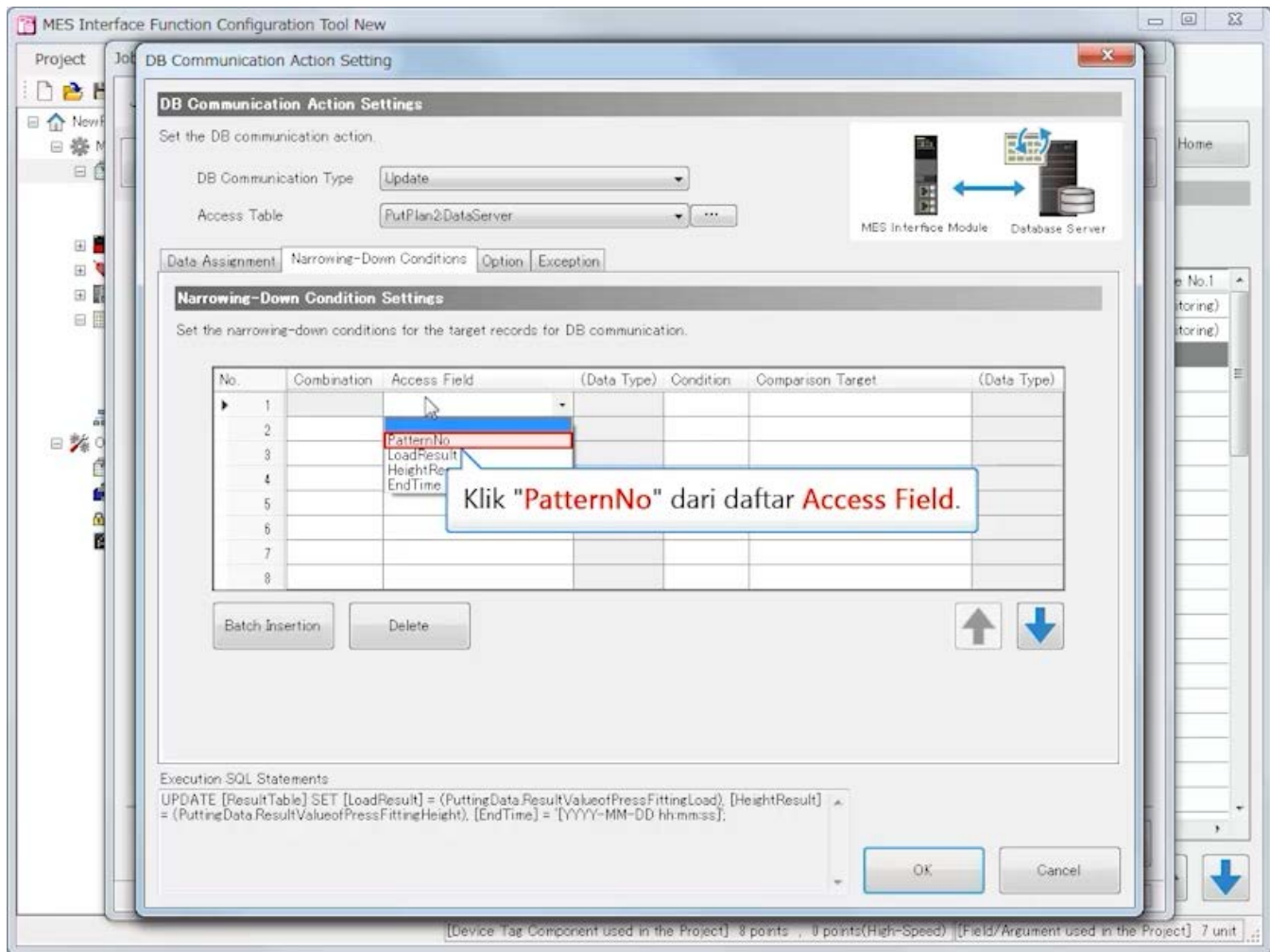
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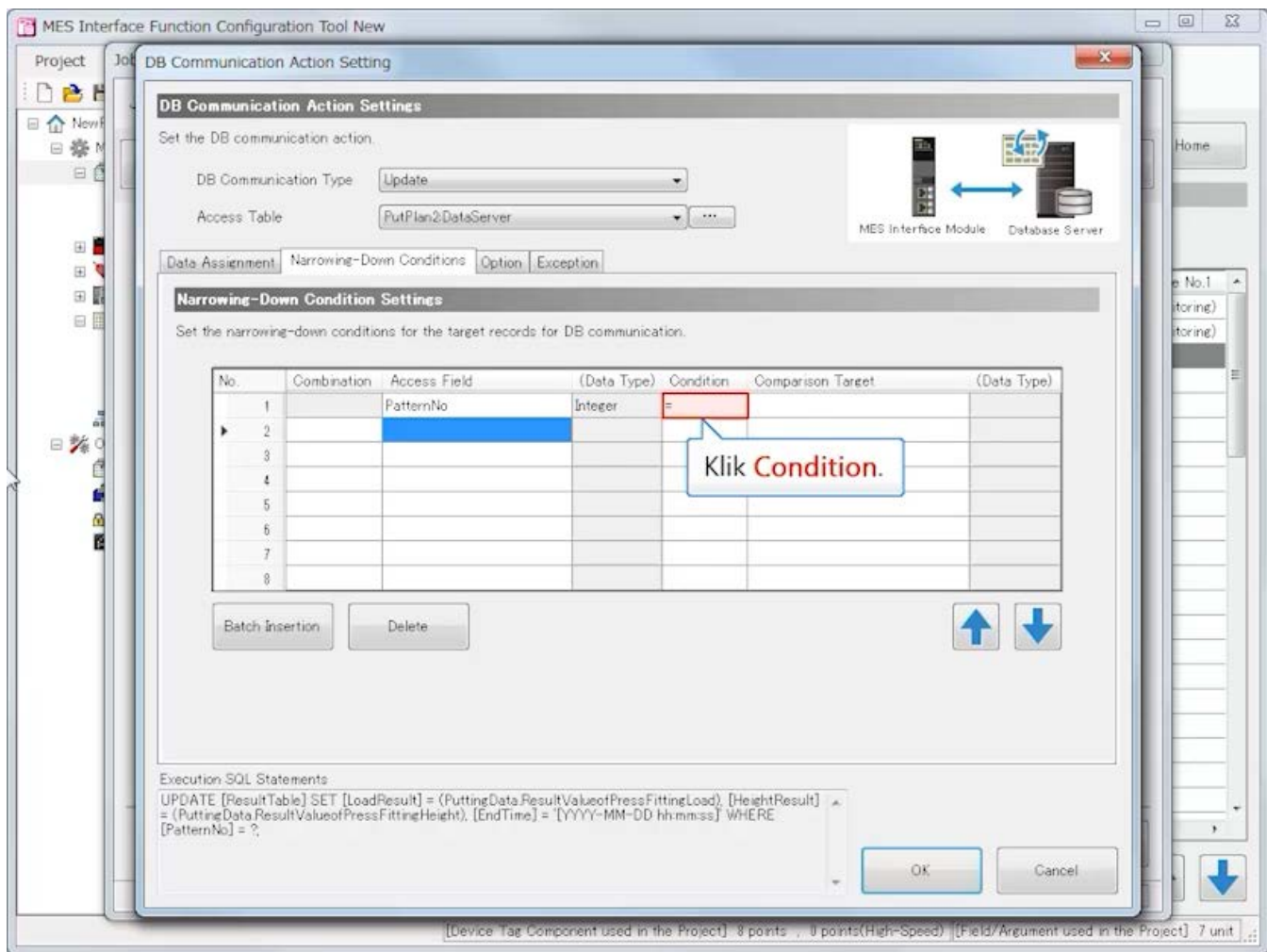
Kembali

Berikutnya



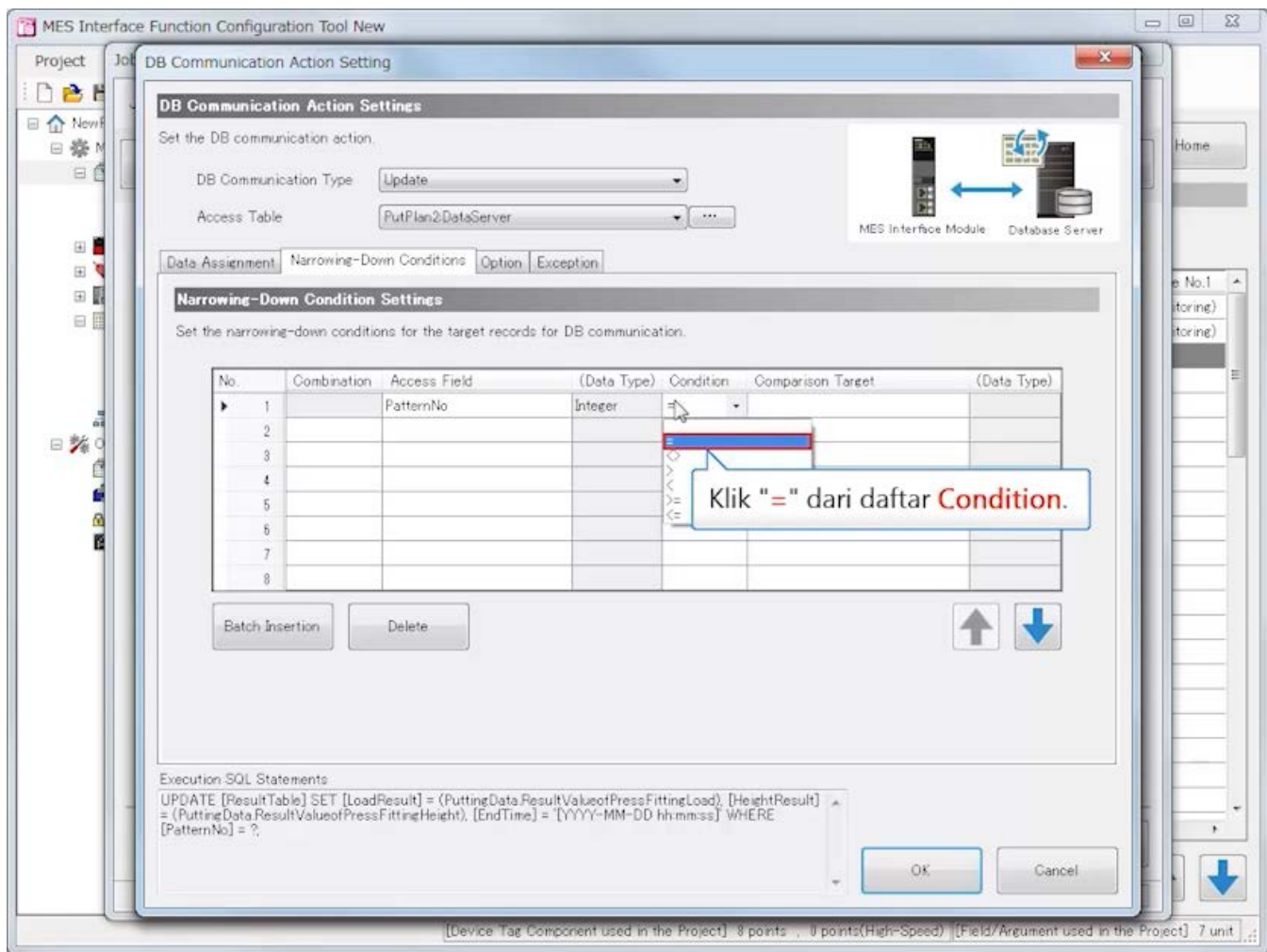
Kembali

Berikutnya



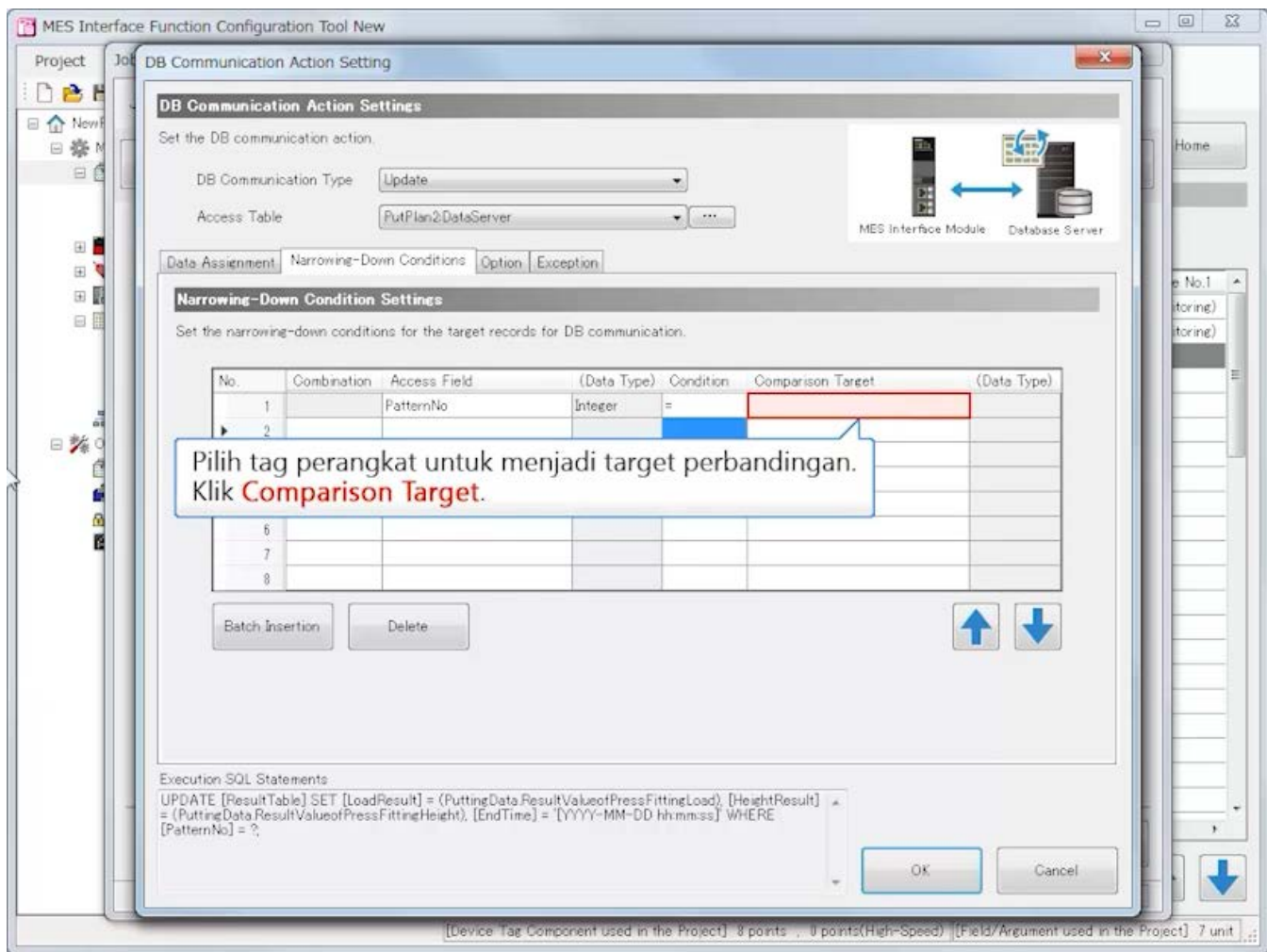
Kembali

Berikutnya



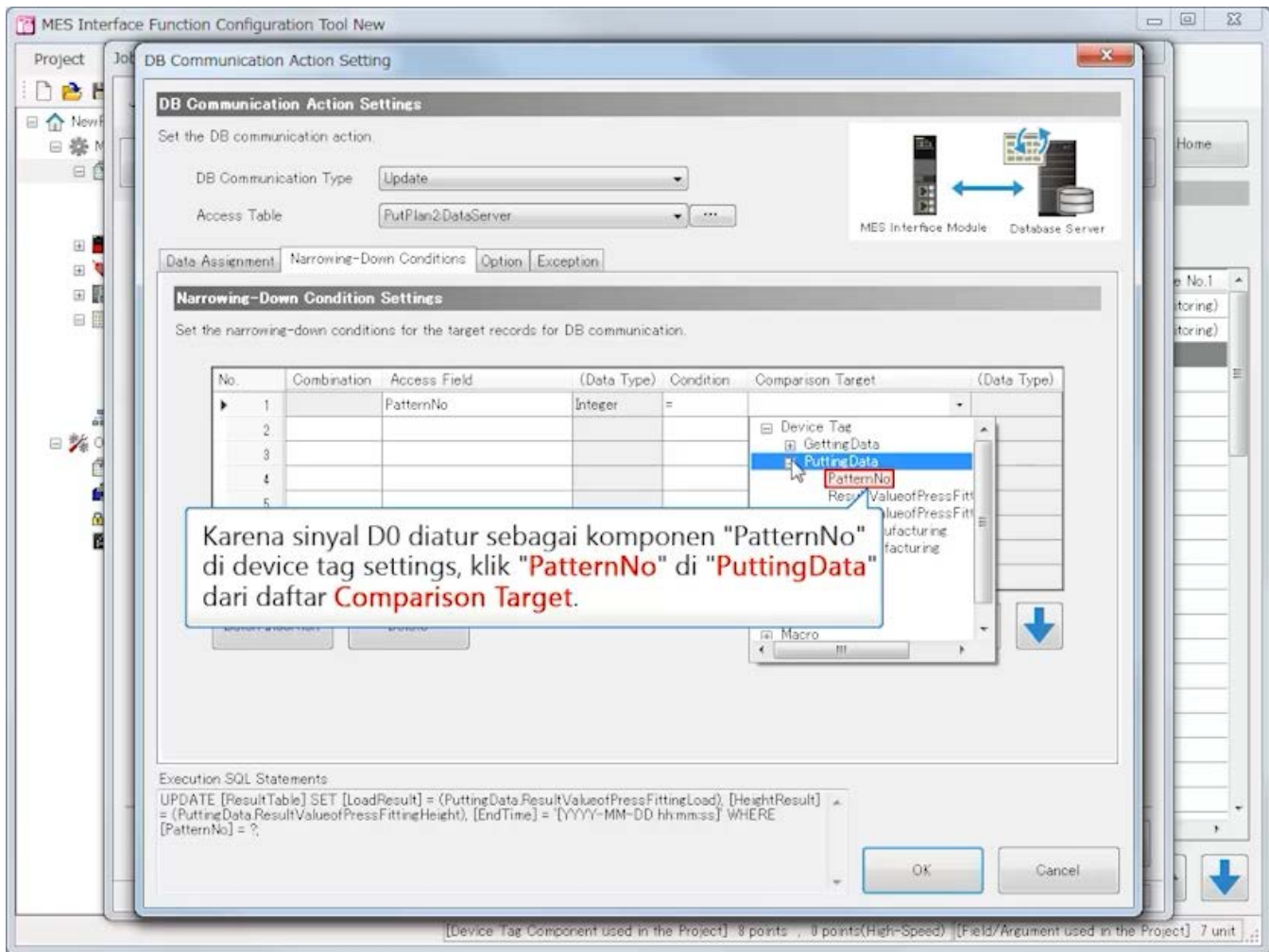
Kembali

Berikutnya



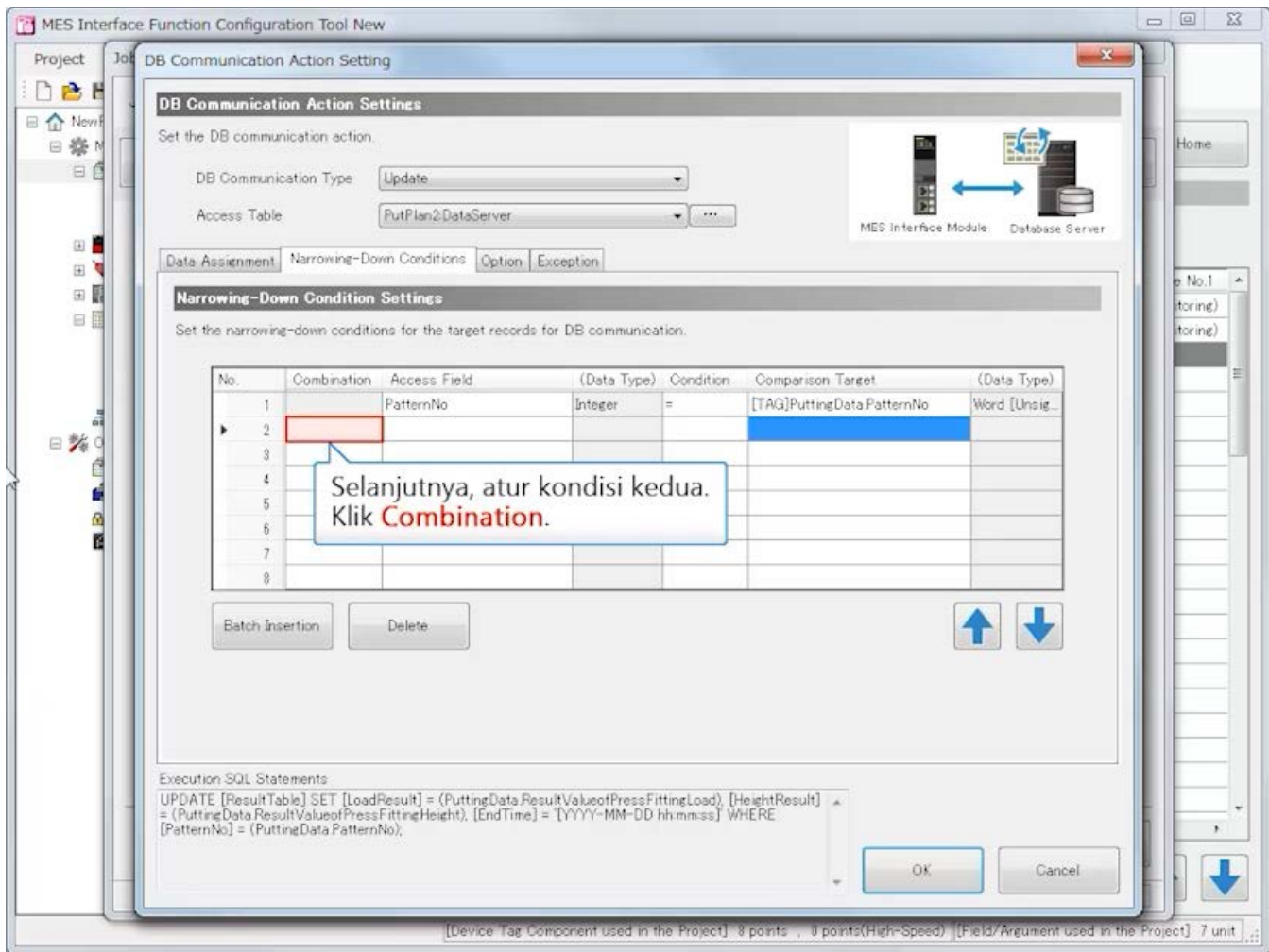
Kembali

Berikutnya



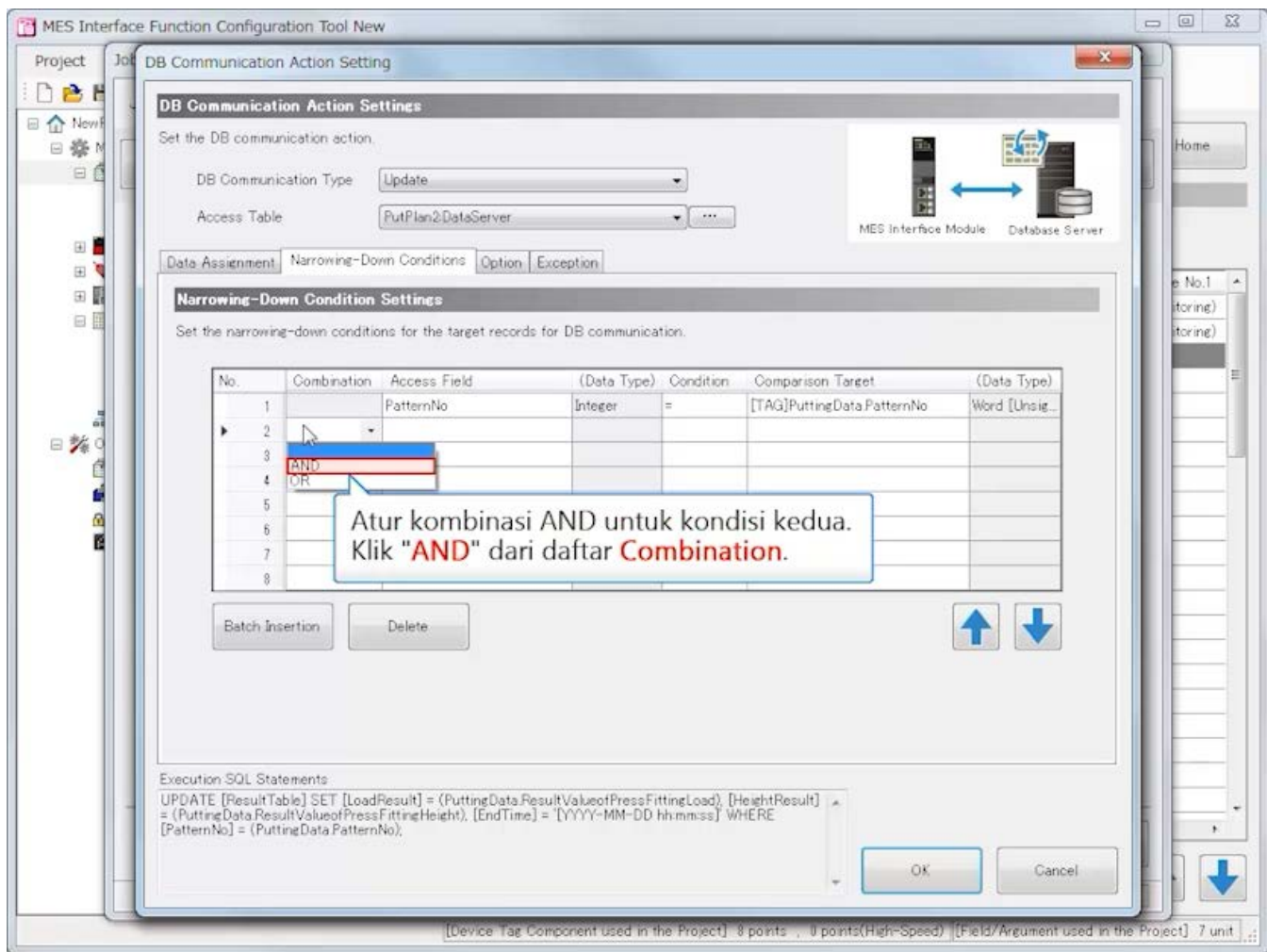
Kembali

Berikutnya



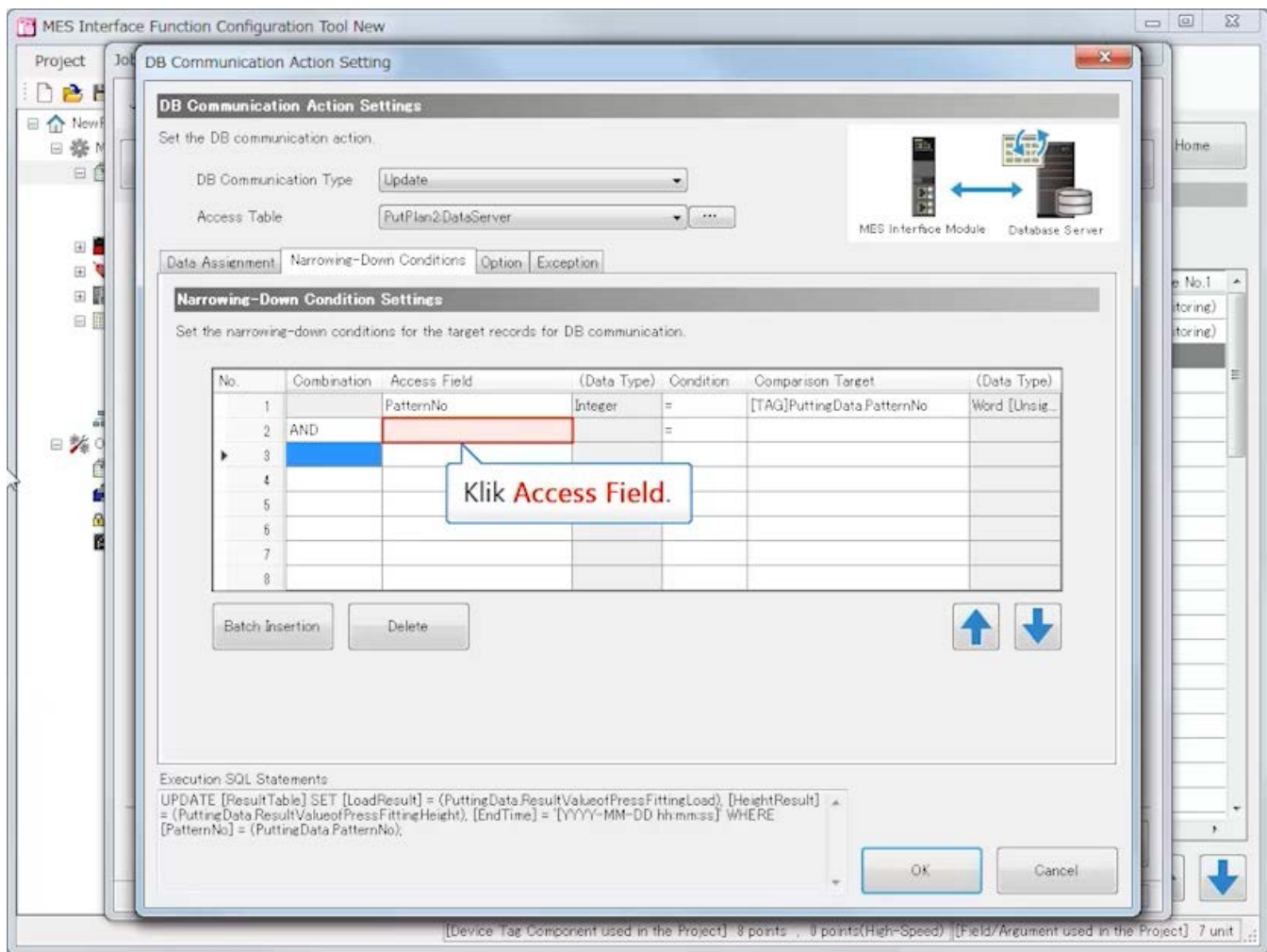
Kembali

Berikutnya



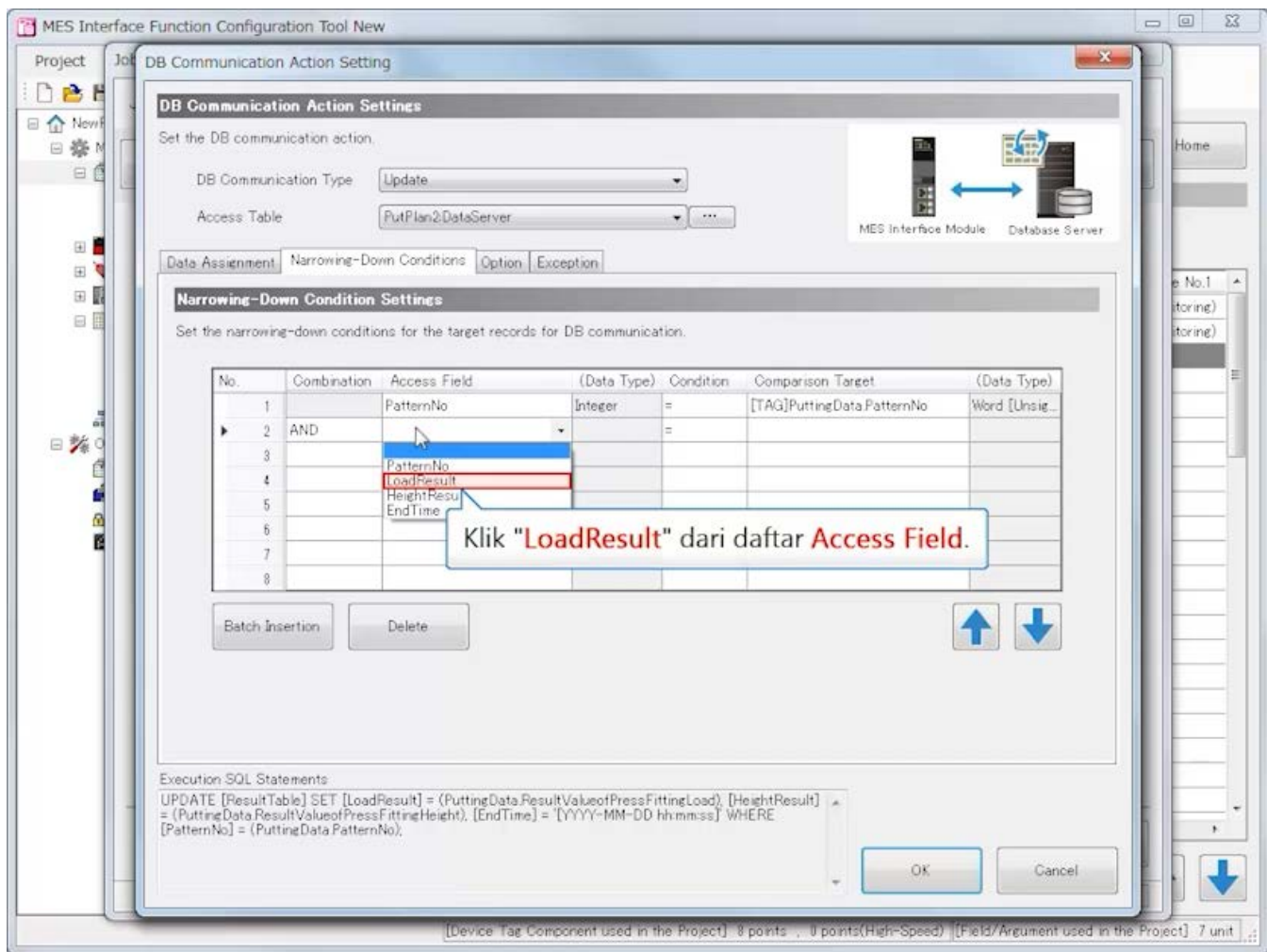
Kembali

Berikutnya



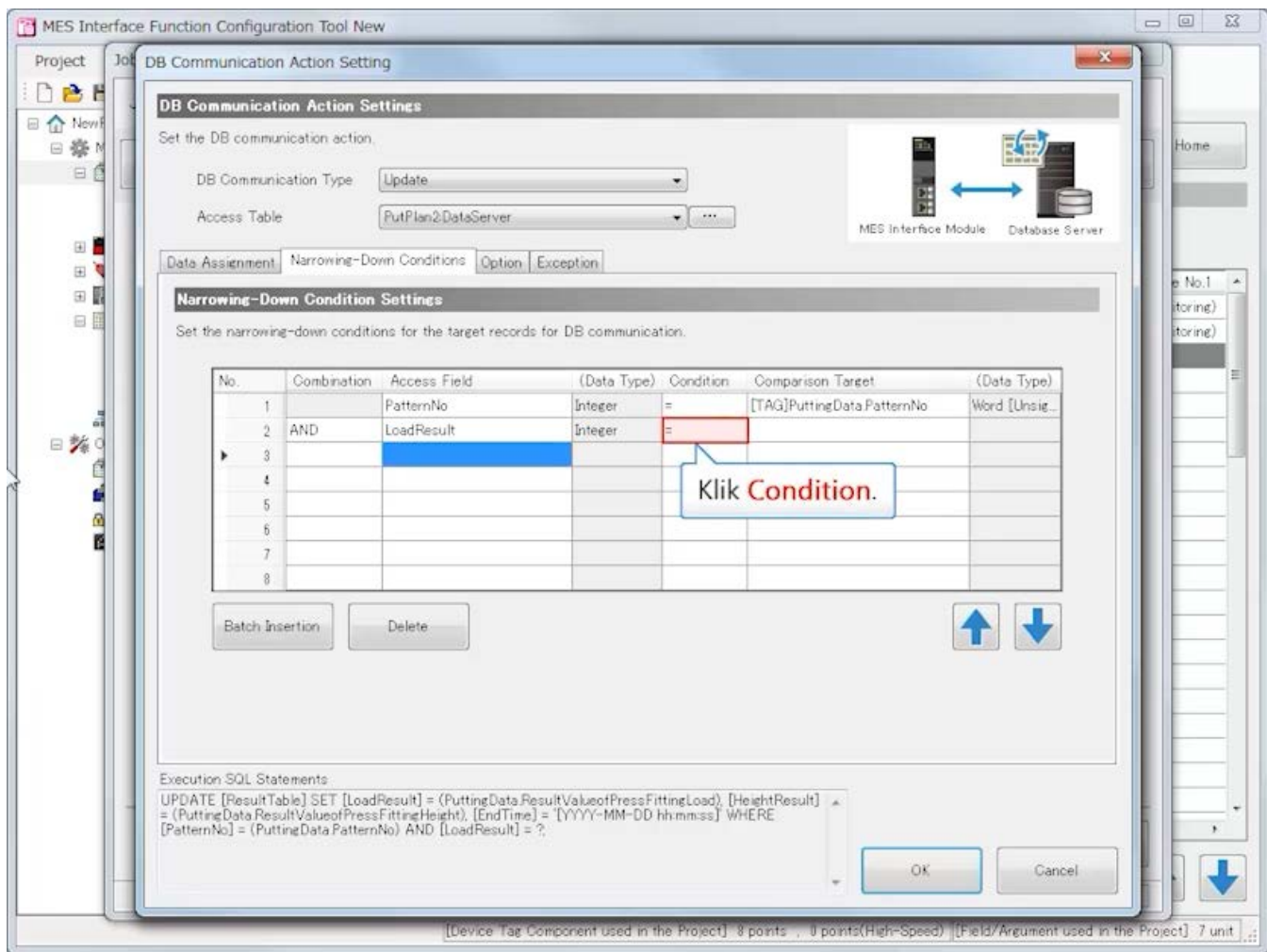
Kembali

Berikutnya



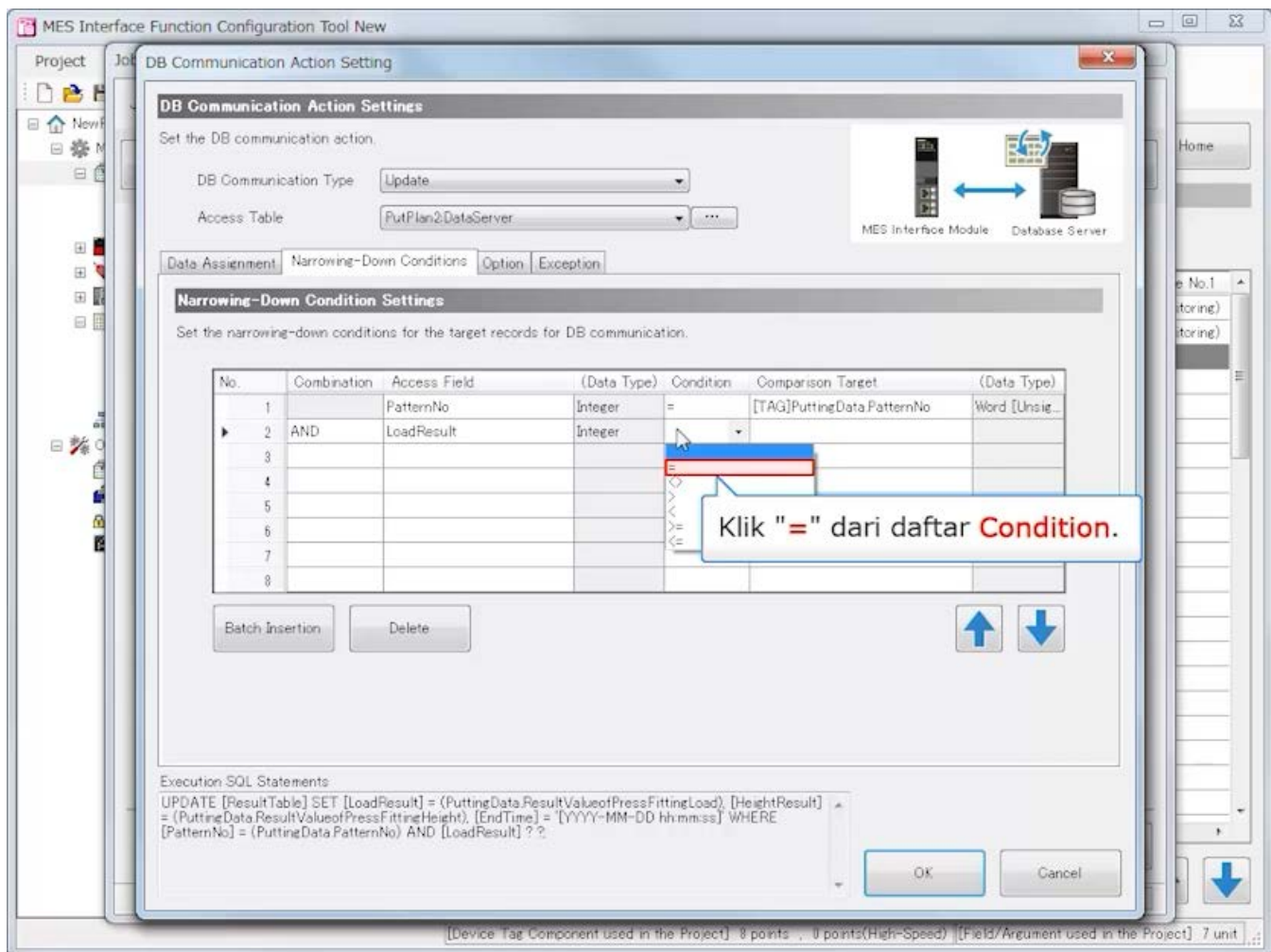
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

MES Interface Function Configuration Tool New

Project Job 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	=		
3						
4						
5						
6						
7						
8						

Alih-alih menentukan tag perangkat, tentukan langsung nilai numeriknya. Klik **Comparison Target**.

Batch Insertion Delete

Execution SQL Statements

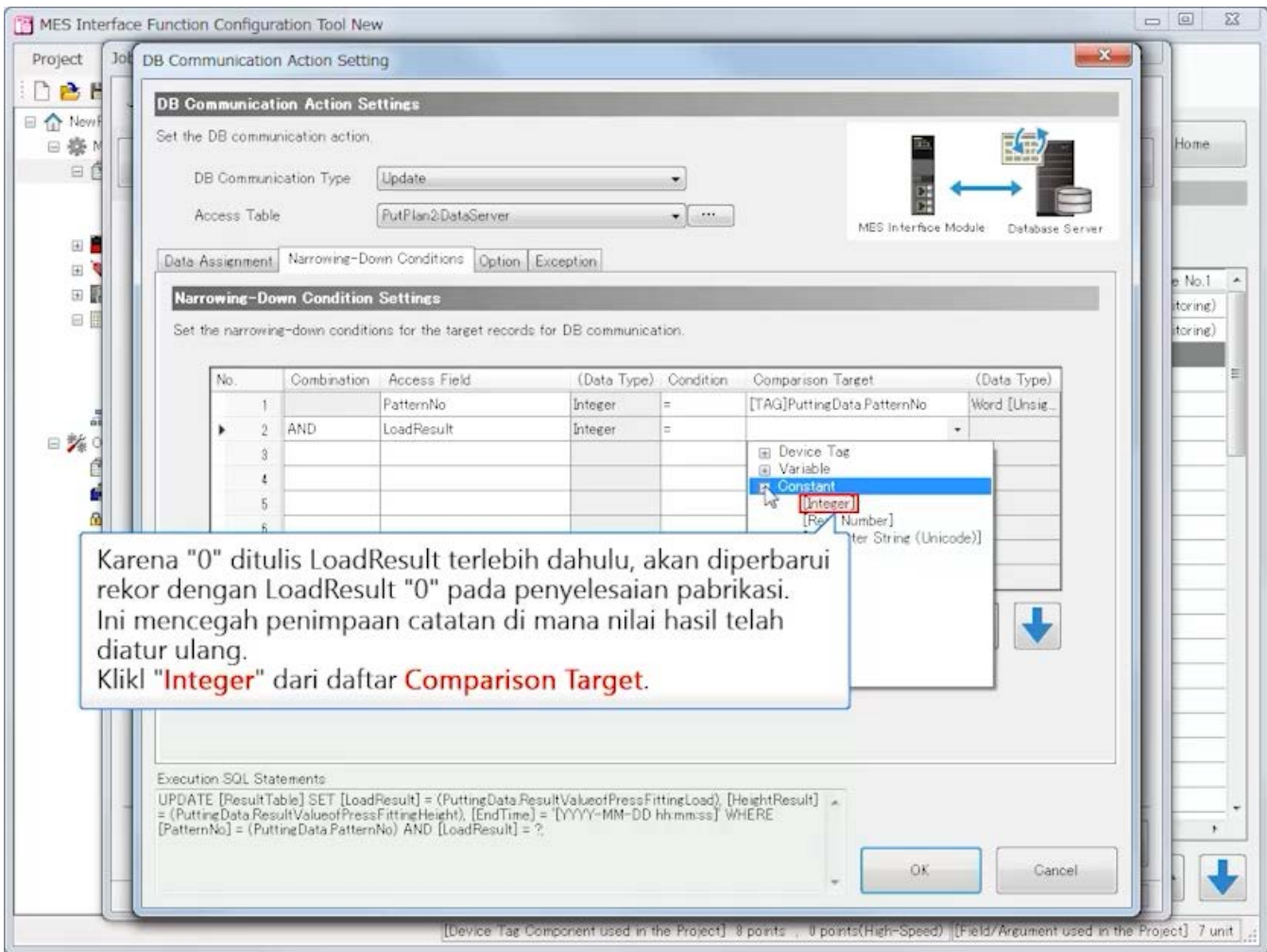
```
UPDATE [ResultTable] SET [LoadResult] = ([PuttingData.ResultValueofPressFittingLoad], [HeightResult] = ([PuttingData.ResultValueofPressFittingHeight], [EndTime] = '[YYYY-MM-DD hh:mm:ss]' WHERE [PatternNo] = ([PuttingData.PatternNo]) AND [LoadResult] = ?
```

OK Cancel

[Device Tag Component used in the Project] 8 points , 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

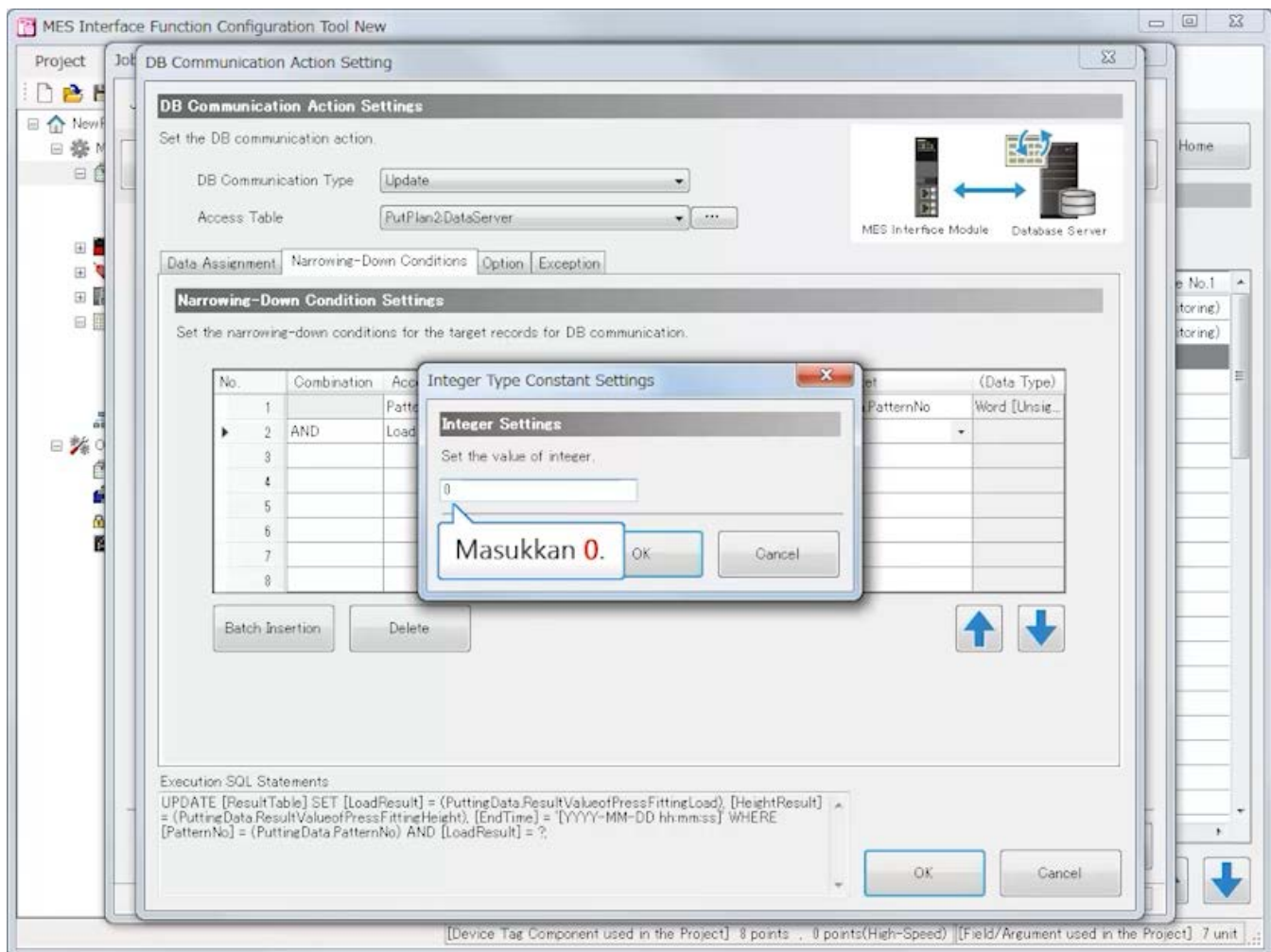
Kembali

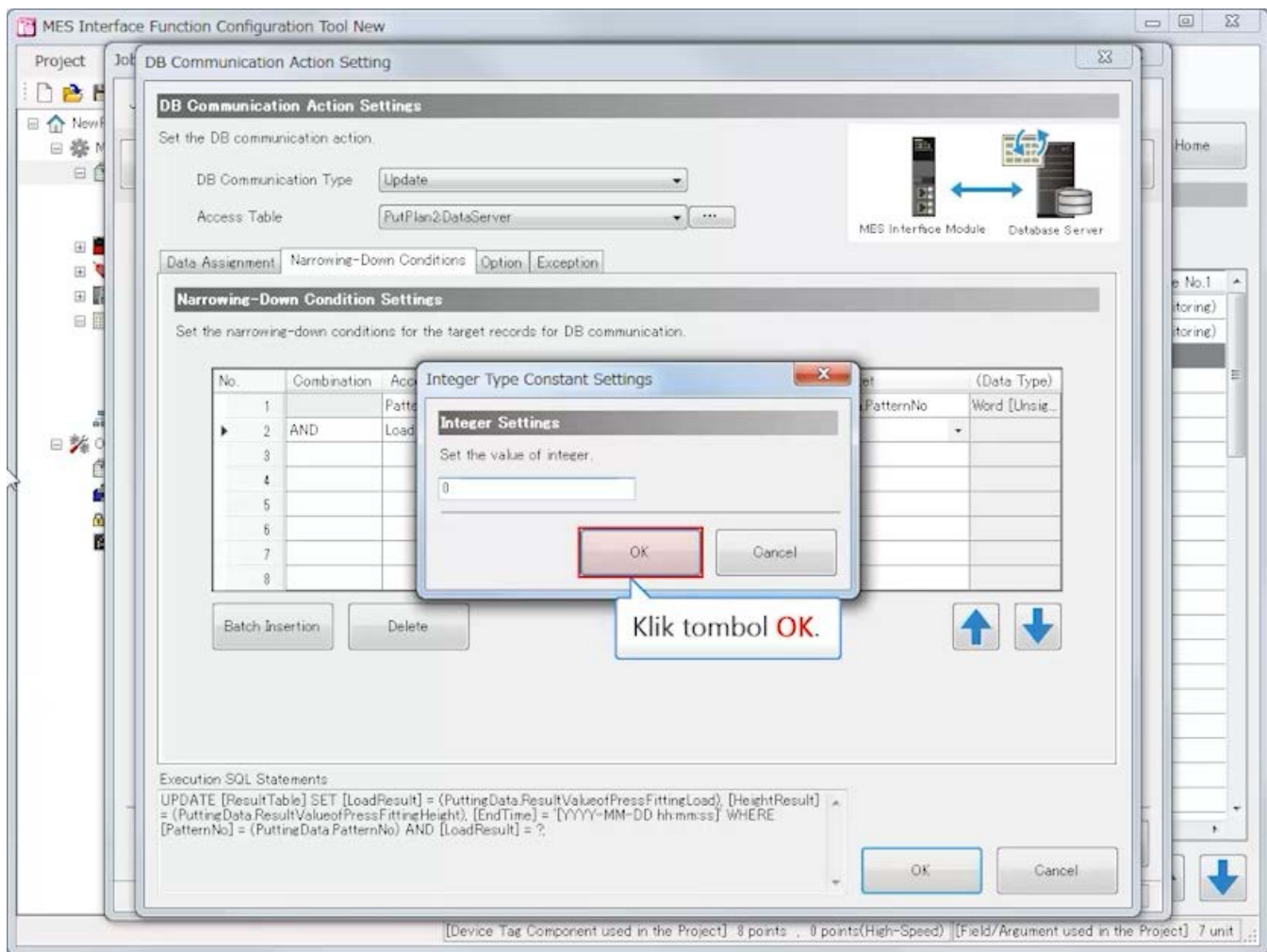
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Kembali

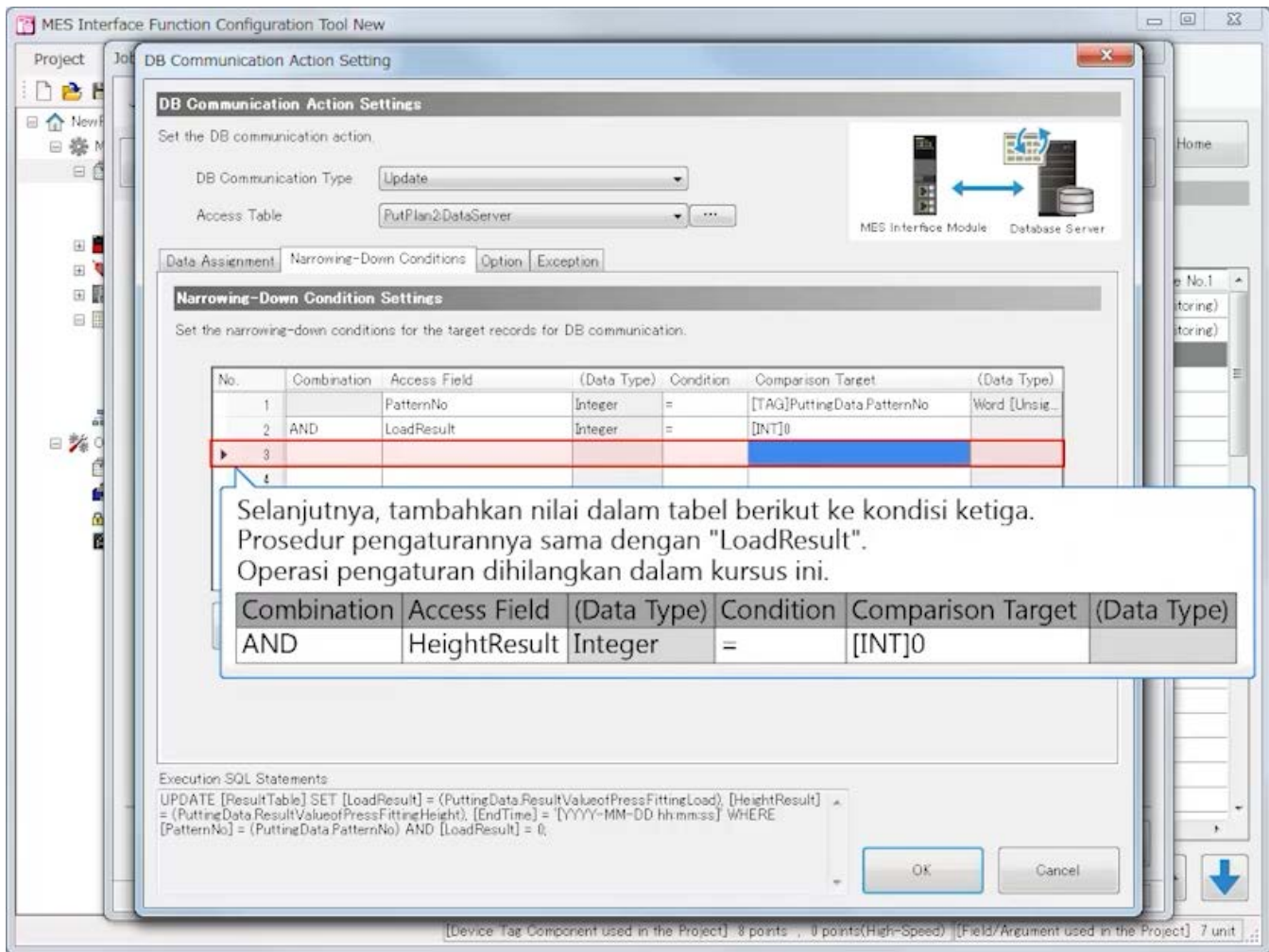
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[Berikutnya](#)


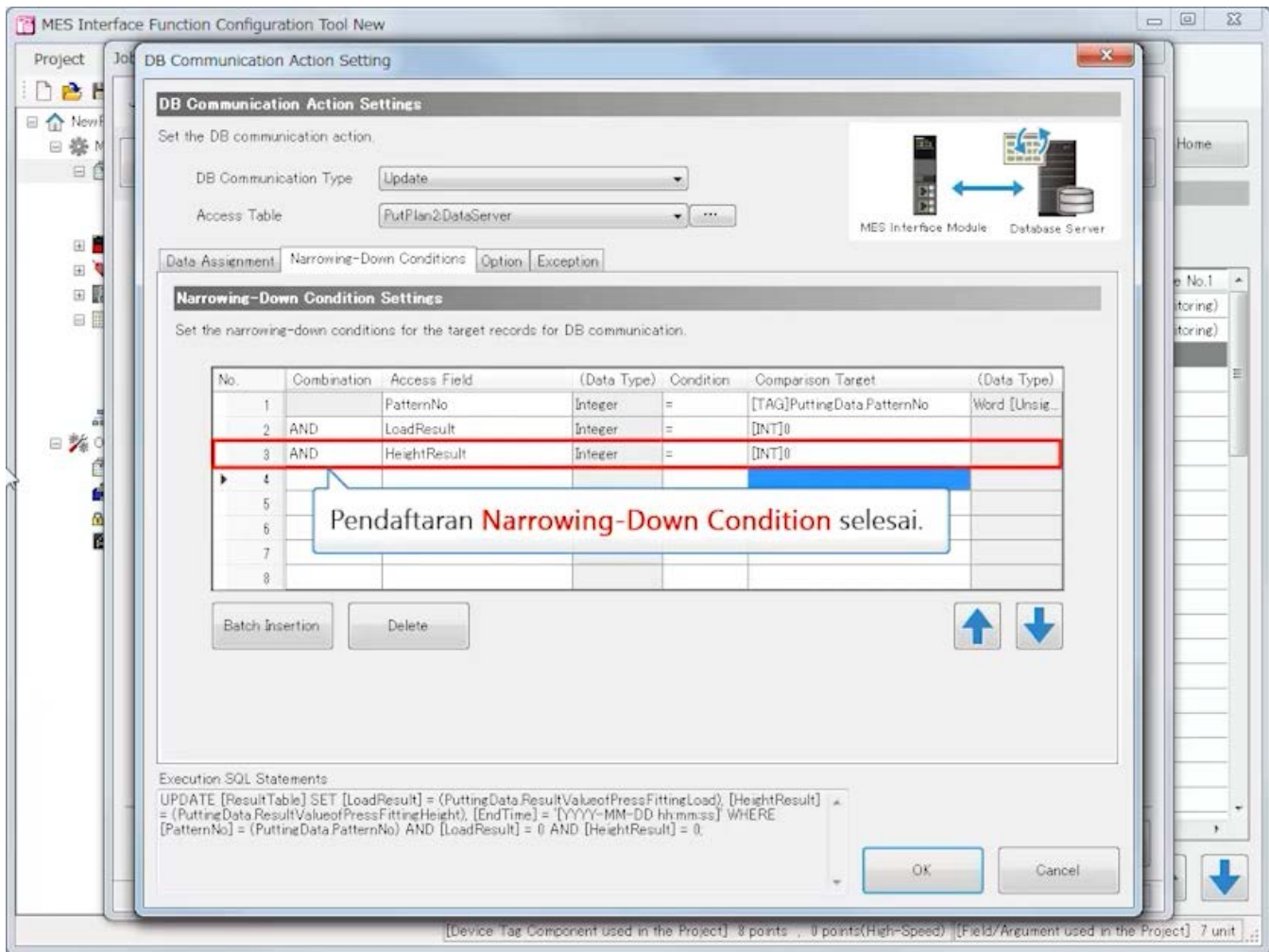
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Berikutnya



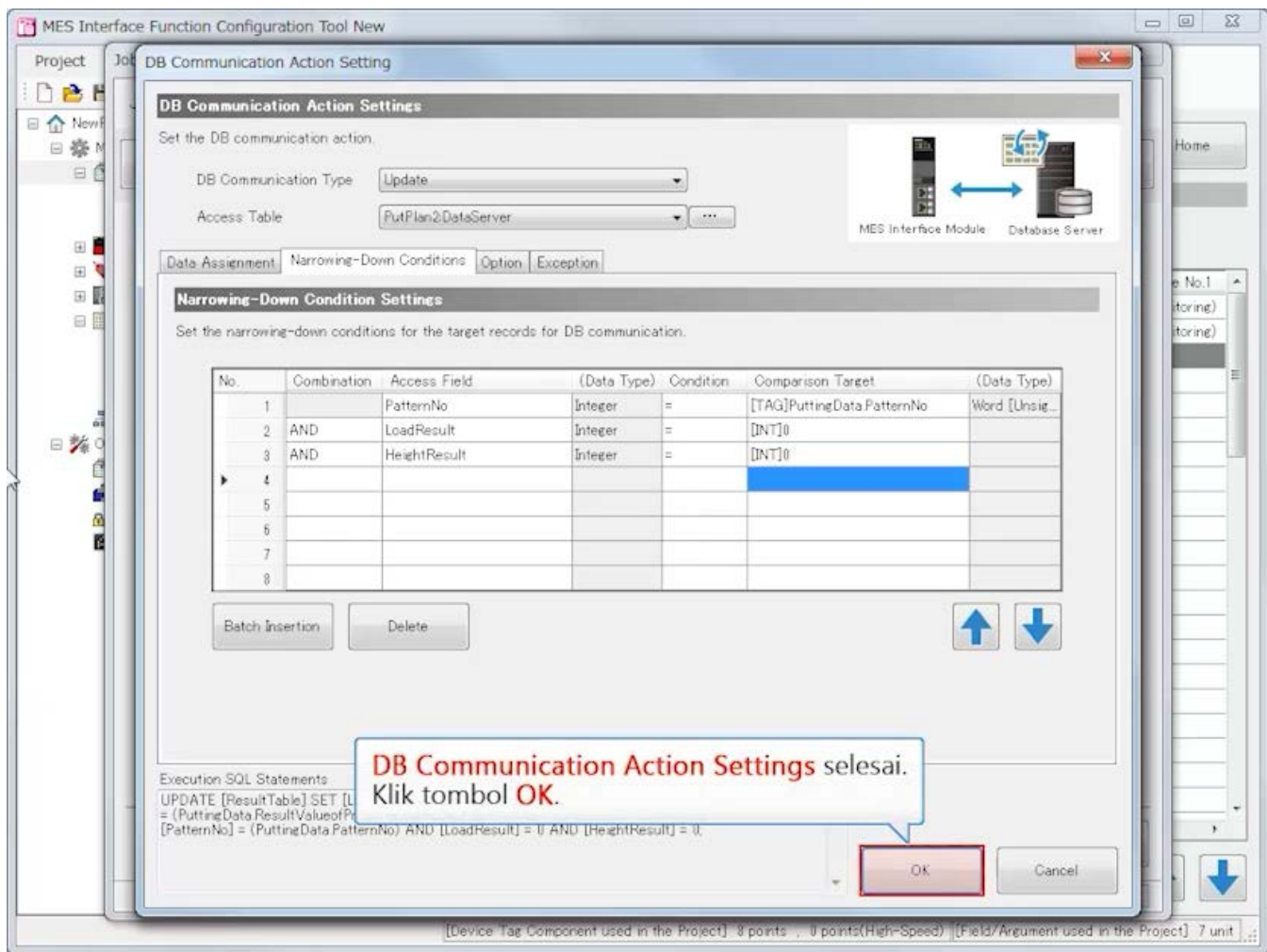
Kembali

Berikutnya



Kembali

Berikutnya



Kembali

Berikutnya

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 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] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Mengatur buffering DB. Klik tombol **Change**.

Kembali

Berikutnya

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

Untuk mengonfigurasi buffering DB, pilih "Use the DB buffer 2." di DB Buffer Settings pada Option Settings.

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

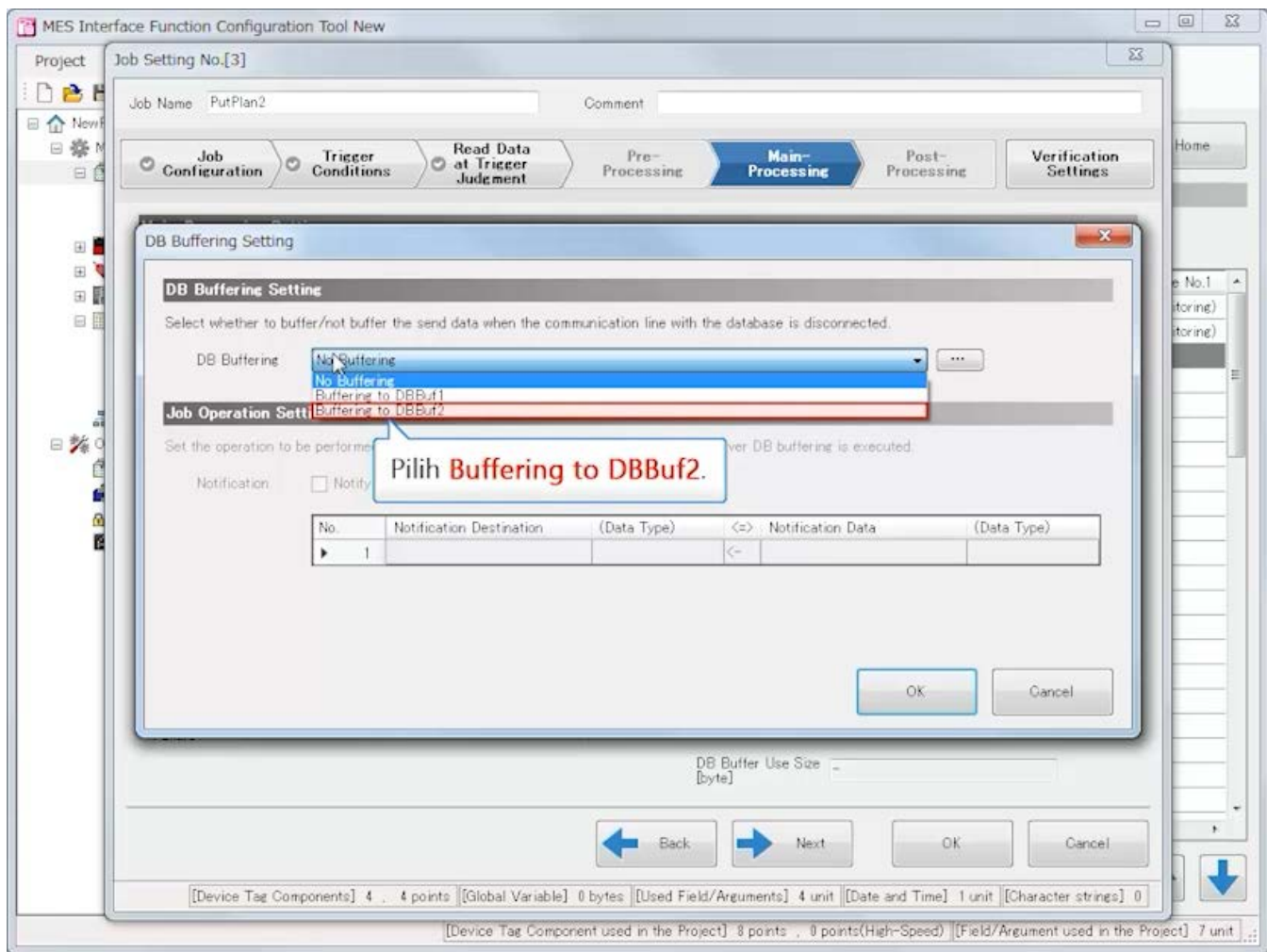
[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

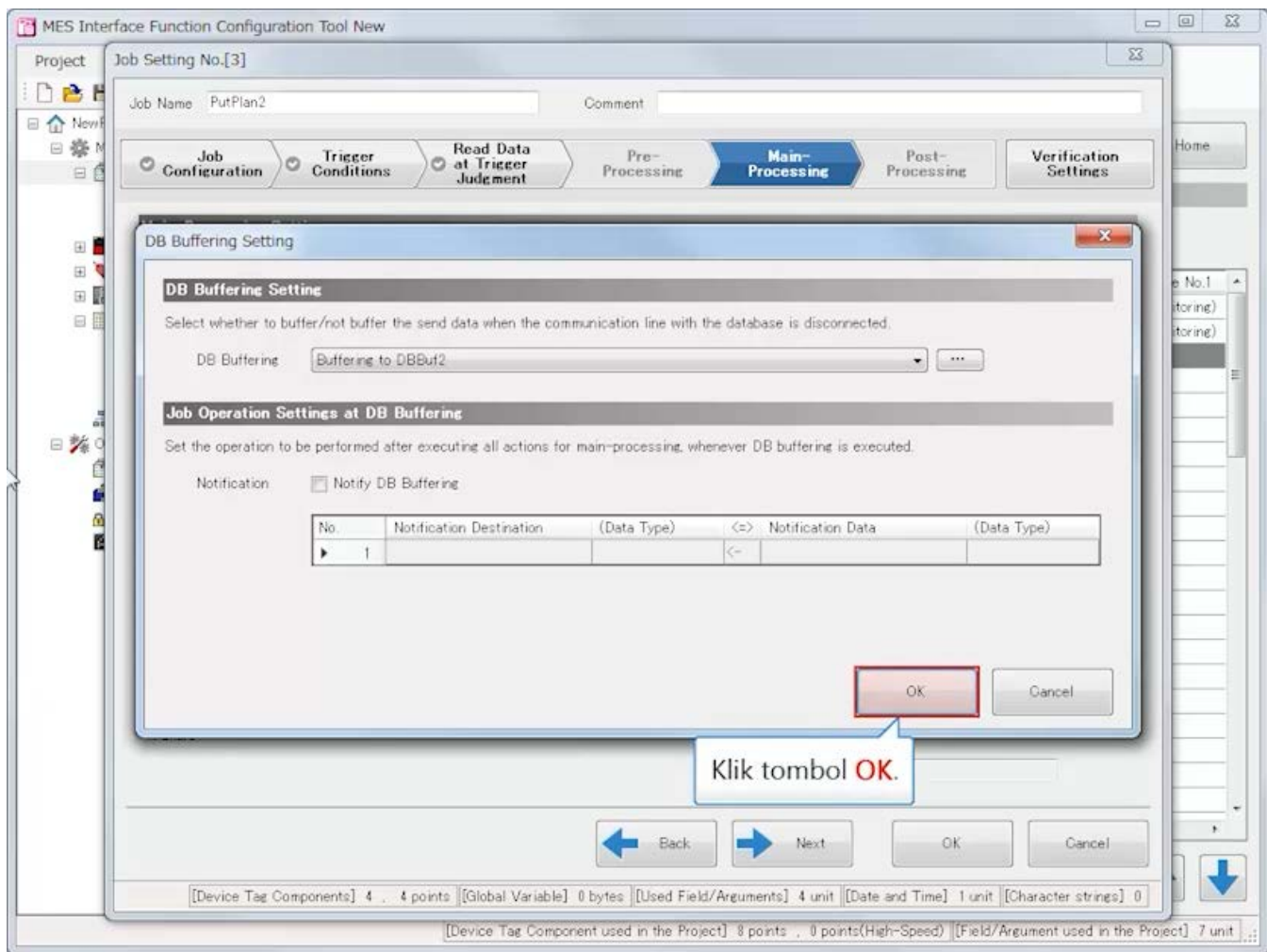
[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Mengatur buffering DB. Klik tombol **Change**.

Kembali

Berikutnya



[Kembali](#)
[Berikutnya](#)


Kembali

Berikutnya

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	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

Size 350

Klik Next.

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

[Kembali](#)[Berikutnya](#)

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.

Pengaturan default digunakan untuk Verification Settings.
Klik tombol OK.

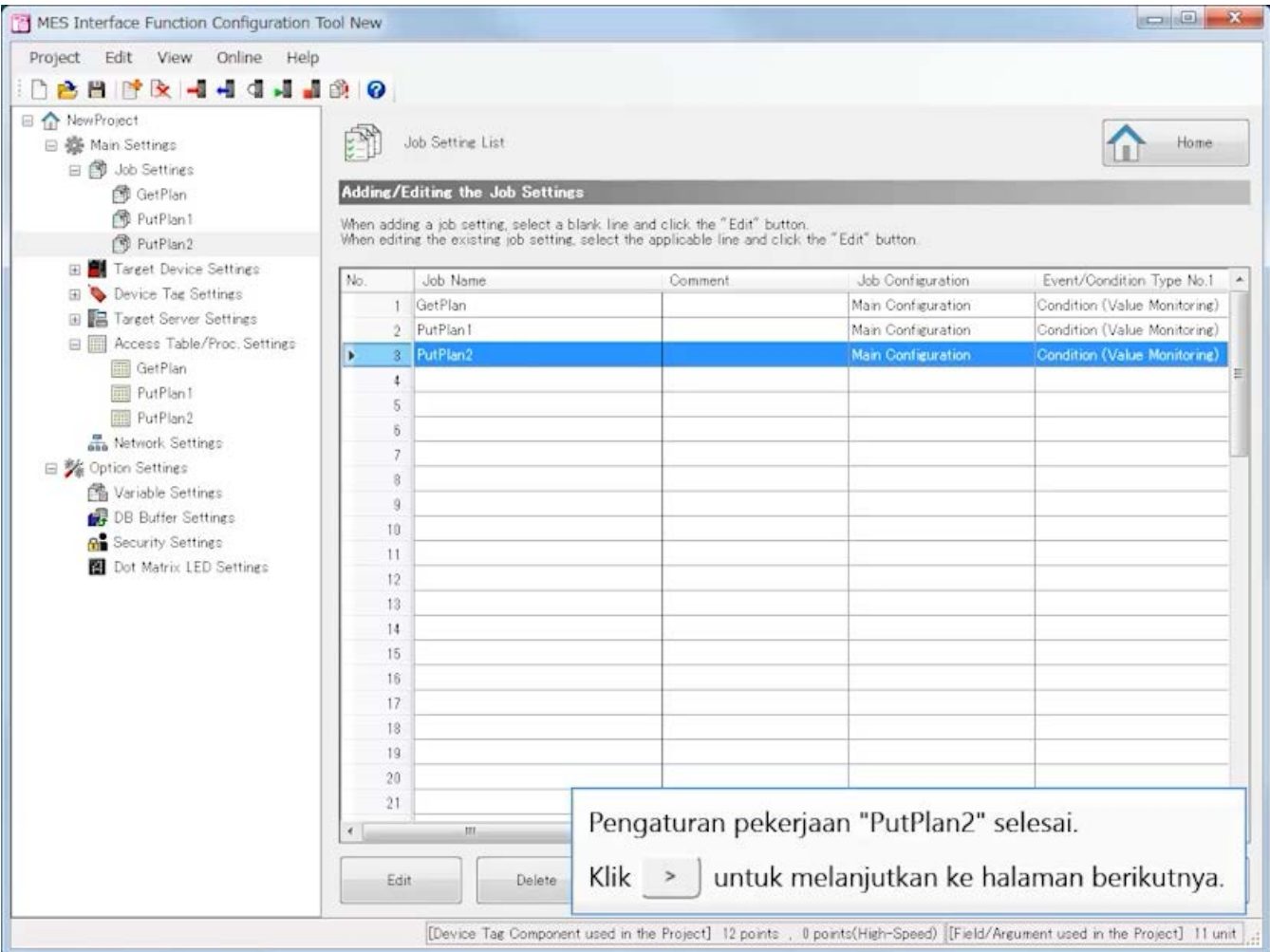
Back Next OK Cancel

[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

Kembali

Berikutnya



The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like 'NewProject', 'Main Settings', 'Job Settings', 'Target Device Settings', etc. The 'Job Settings' category is expanded, showing 'GetPlan', 'PutPlan1', and 'PutPlan2'. The main area displays a 'Job Setting List' table. The table has columns: 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. The row for 'PutPlan2' (No. 3) is highlighted in blue. Below the table are 'Edit' and 'Delete' buttons. A status bar at the bottom shows 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	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

[Device Tag Component used in the Project] 12 points , 0 points(High-Speed) [Field/Argument used in the Project] 11 unit

Pengaturan pekerjaan "PutPlan2" selesai.

Klik  untuk melanjutkan ke halaman berikutnya.

Anda telah menyelesaikan pengaturan sistem modul antarmuka MES untuk kursus ini.

Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**

Klik tombol Putar.

Anda telah menyelesaikan pengaturan sistem modul antarmuka MES untuk kursus ini.

Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**

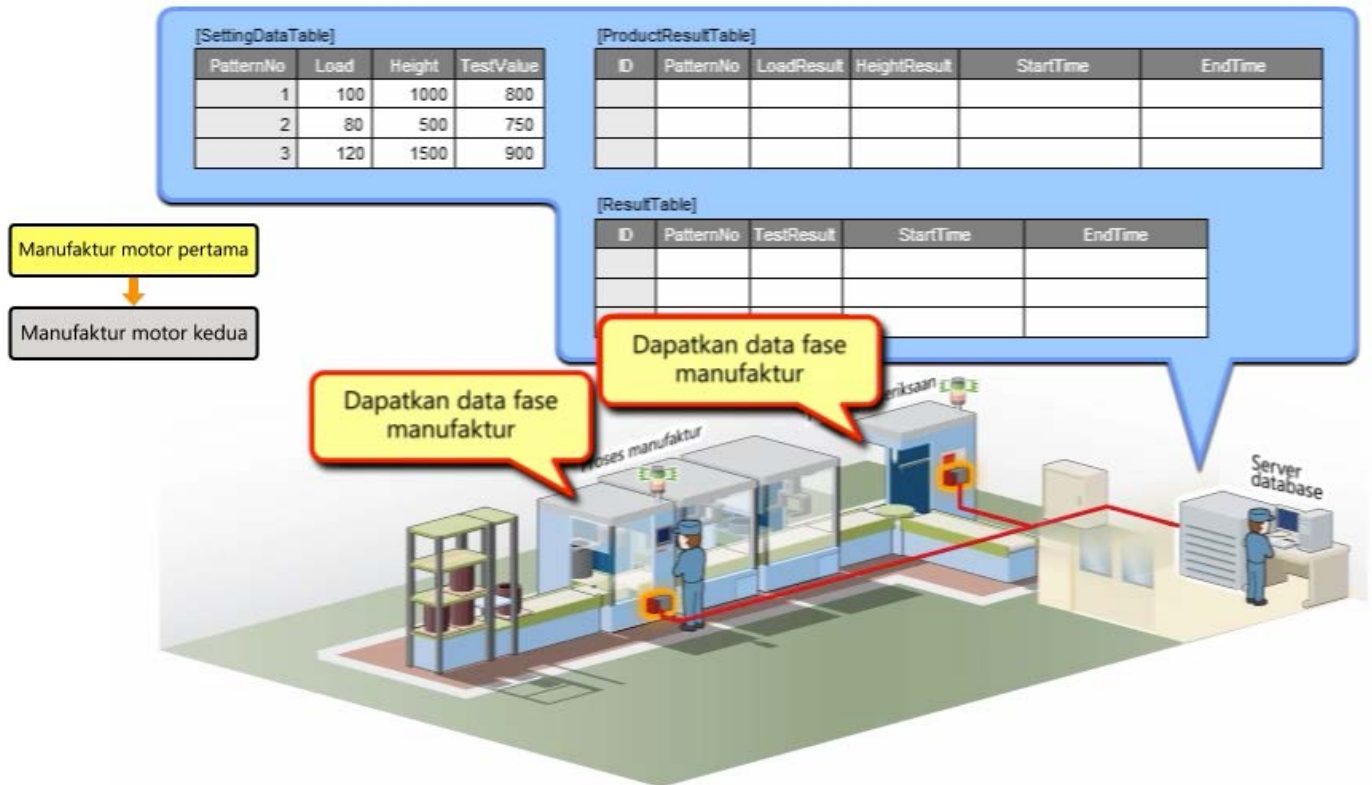
Anda telah mempelajari bagaimana menghubungkan memori perangkat modul CPU dan tabel database menggunakan modul antarmuka MES dengan mengambil sebuah peralatan sebagai contoh.

Di bagian ini, Anda akan melihat contoh sistem yang dioperasikan di banyak mesin.

Anda telah menyelesaikan pengaturan sistem modul antarmuka MES untuk kursus ini.

Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

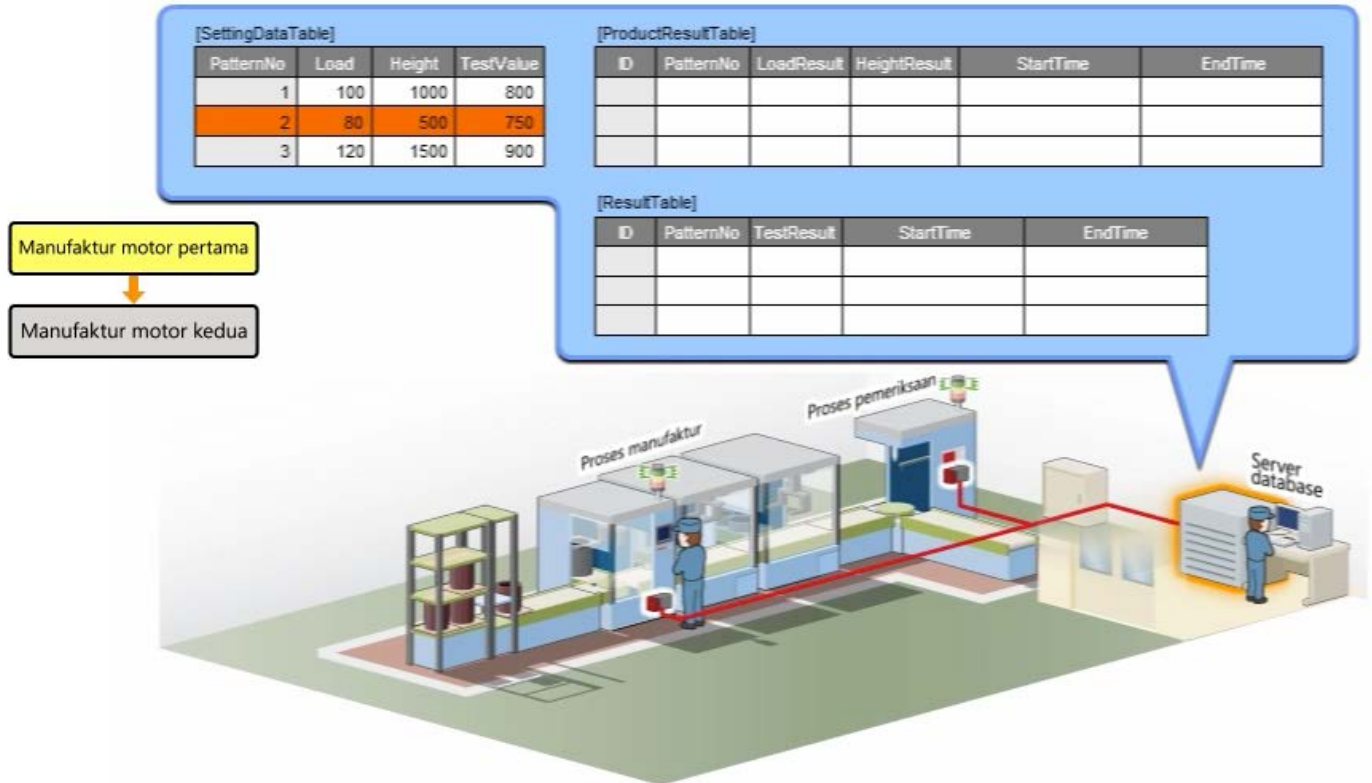
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



Anda telah menyelesaikan pengaturan sistem modul antarmuka MES untuk kursus ini.

Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

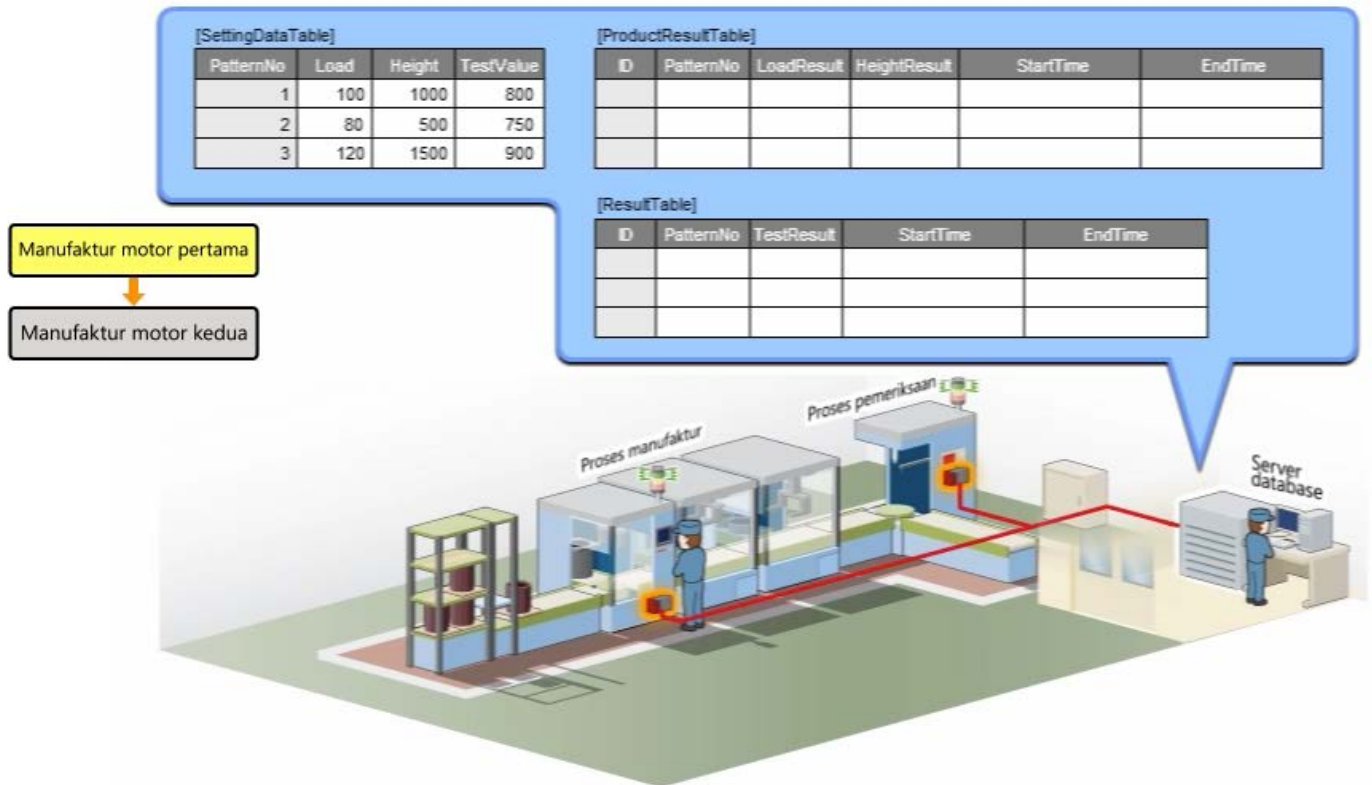
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



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Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

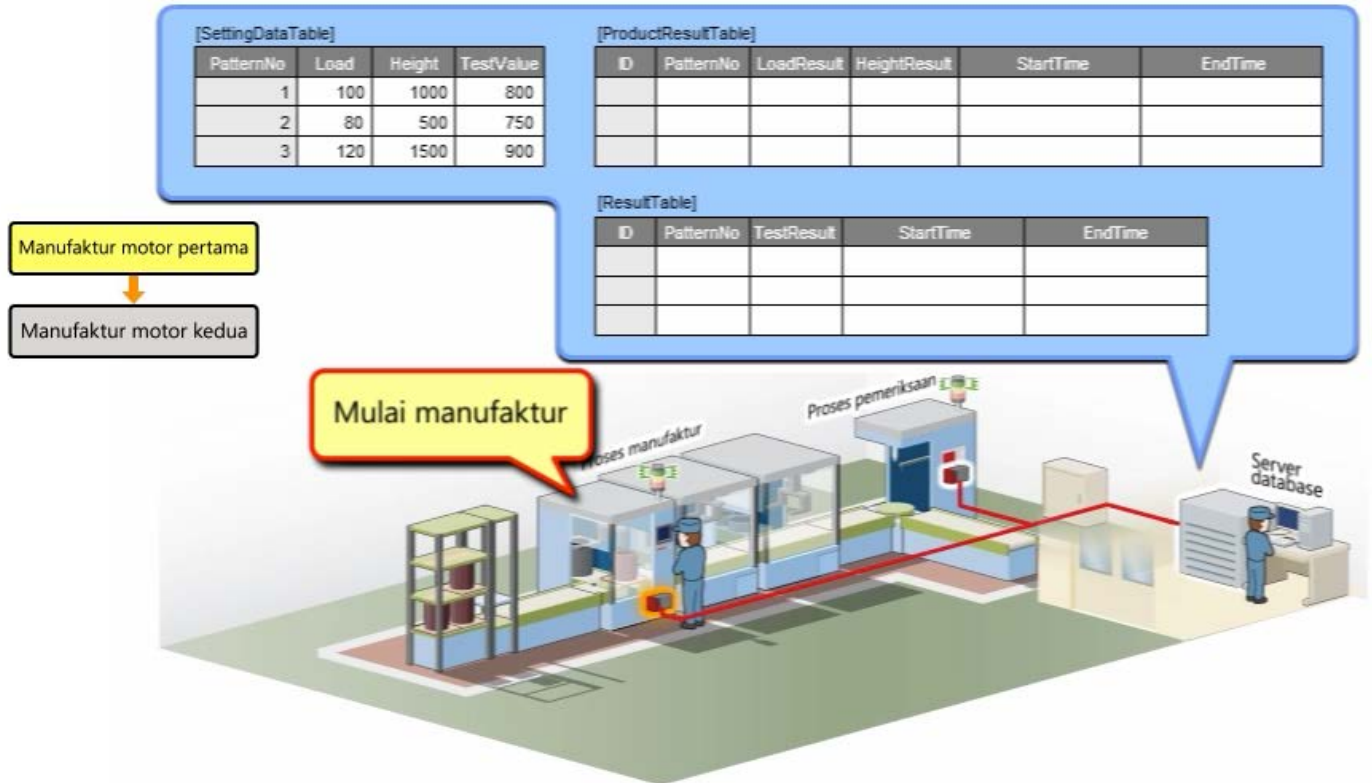
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



Anda telah menyelesaikan pengaturan sistem modul antarmuka MES untuk kursus ini.

Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

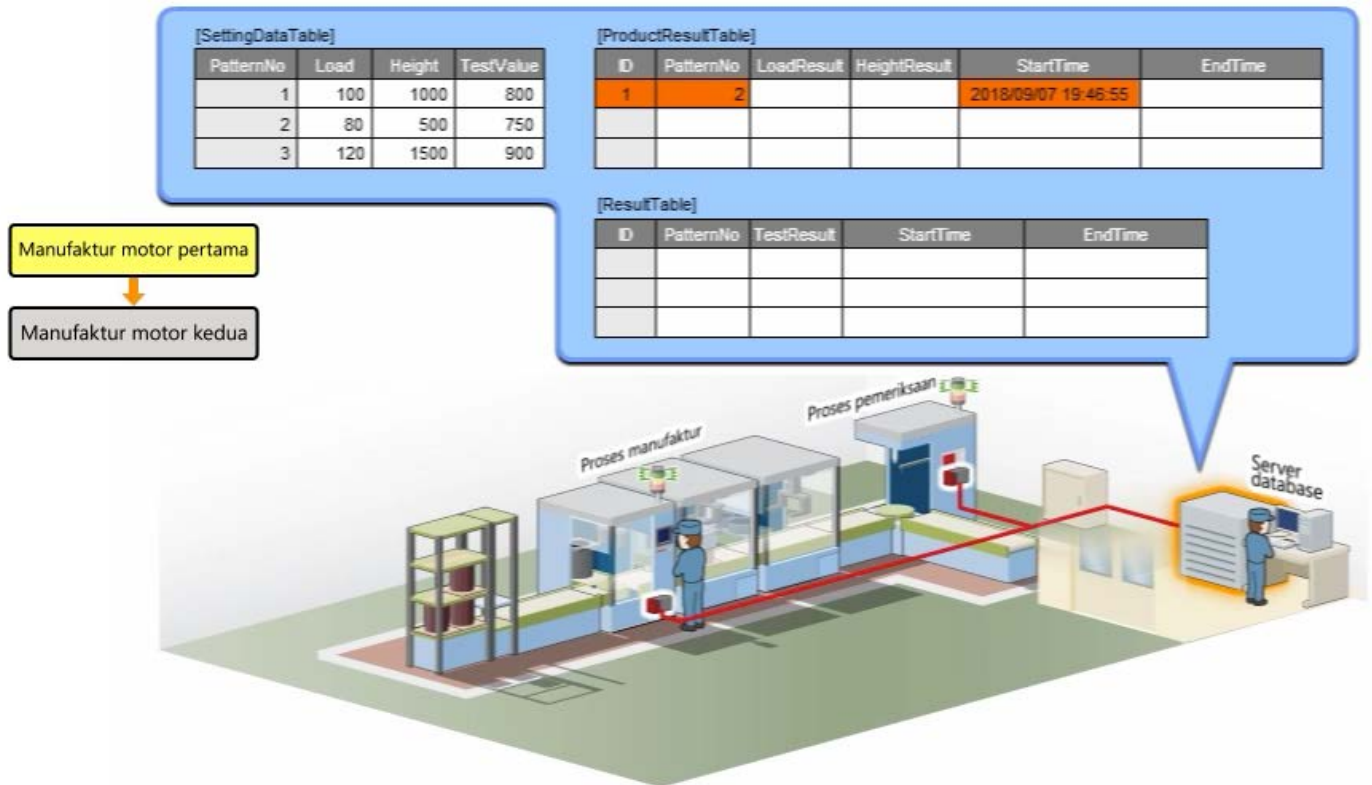
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



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Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

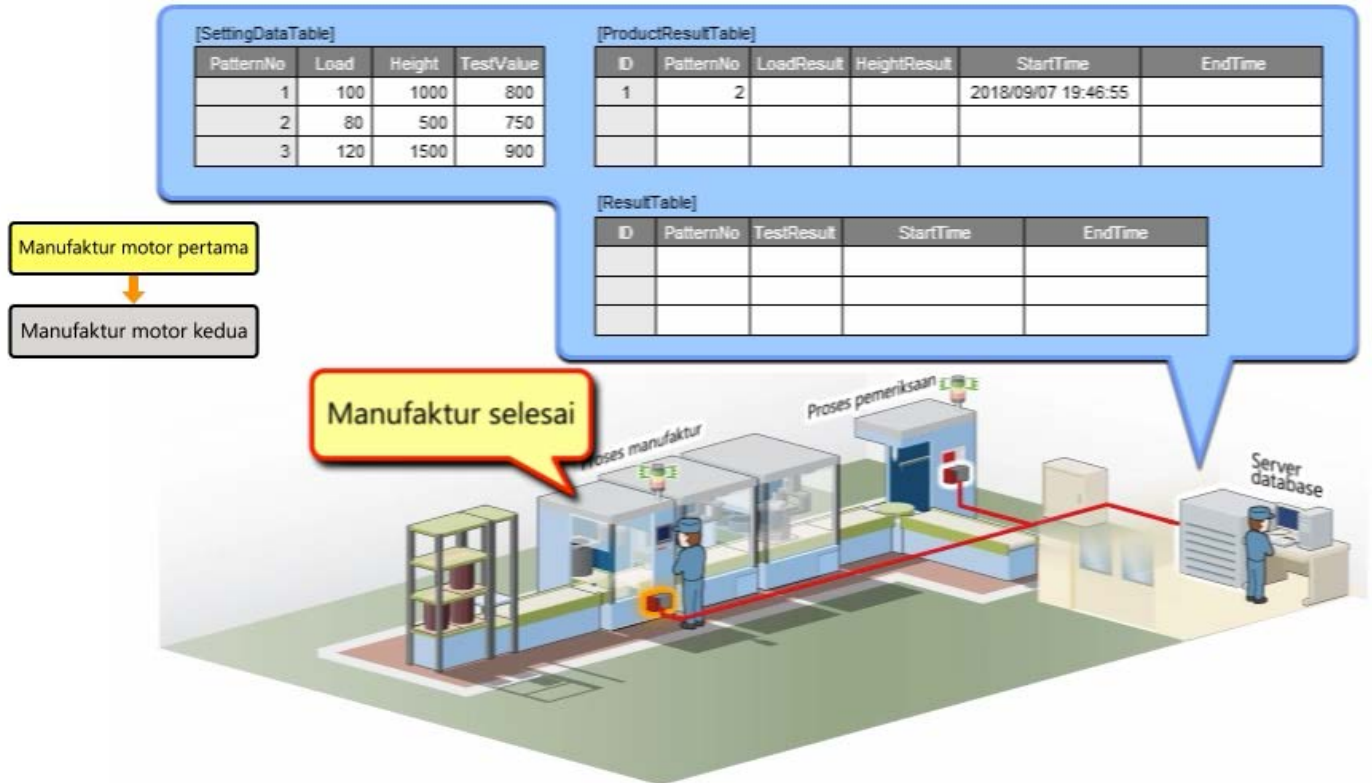
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



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Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

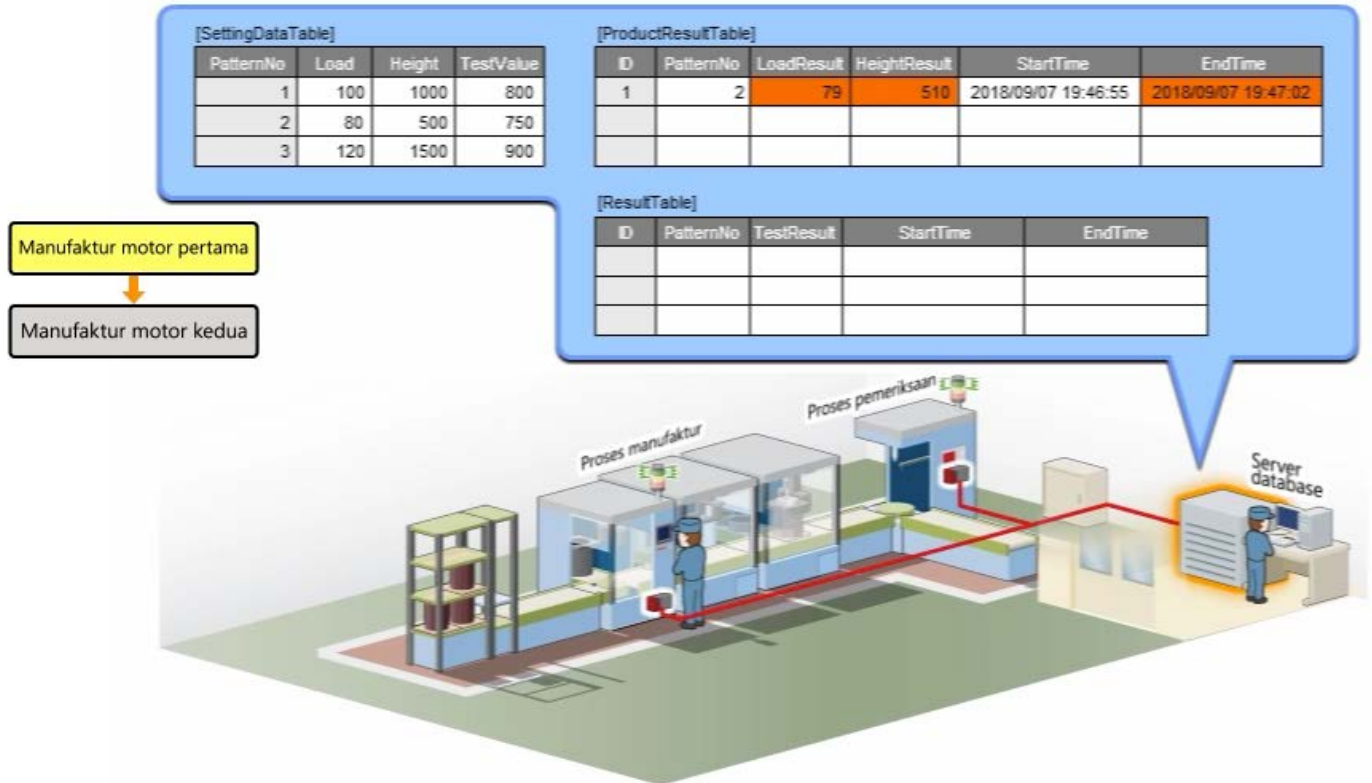
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



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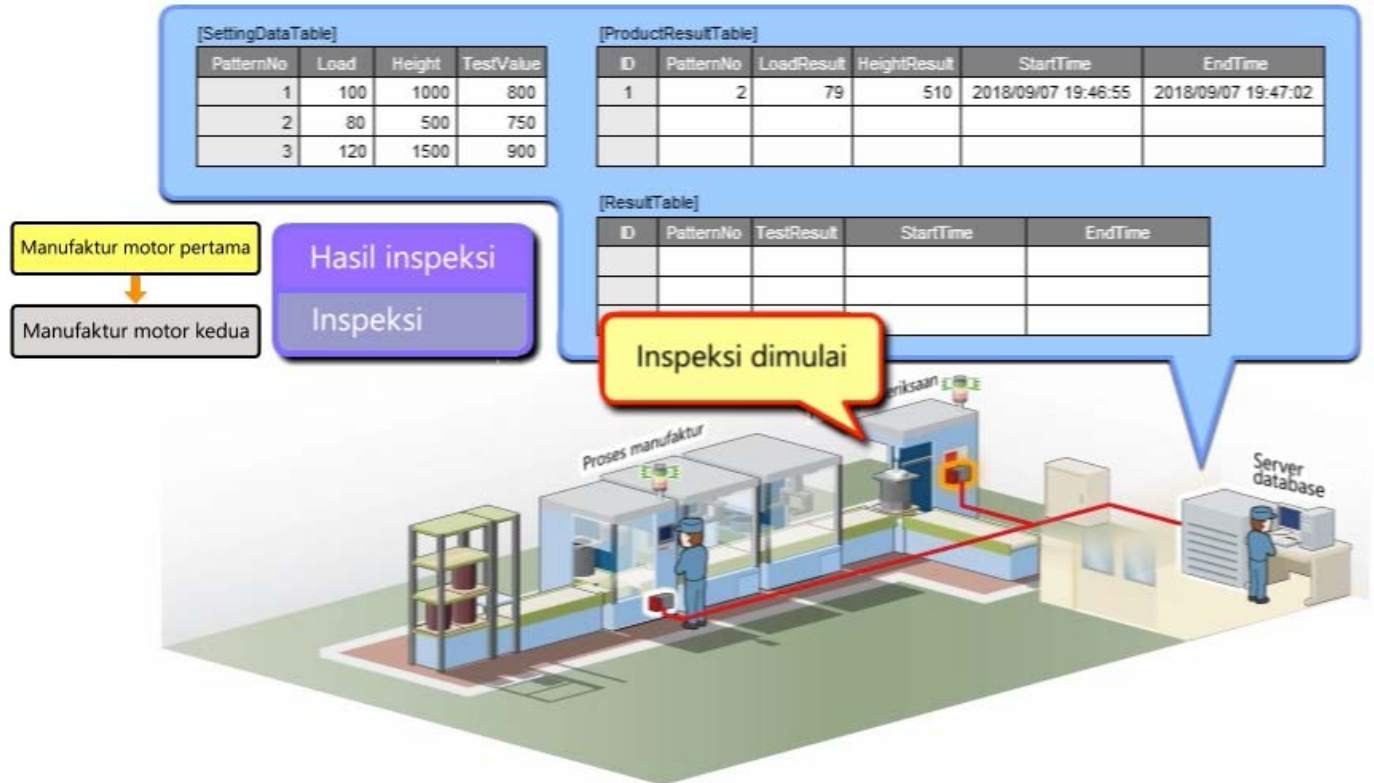
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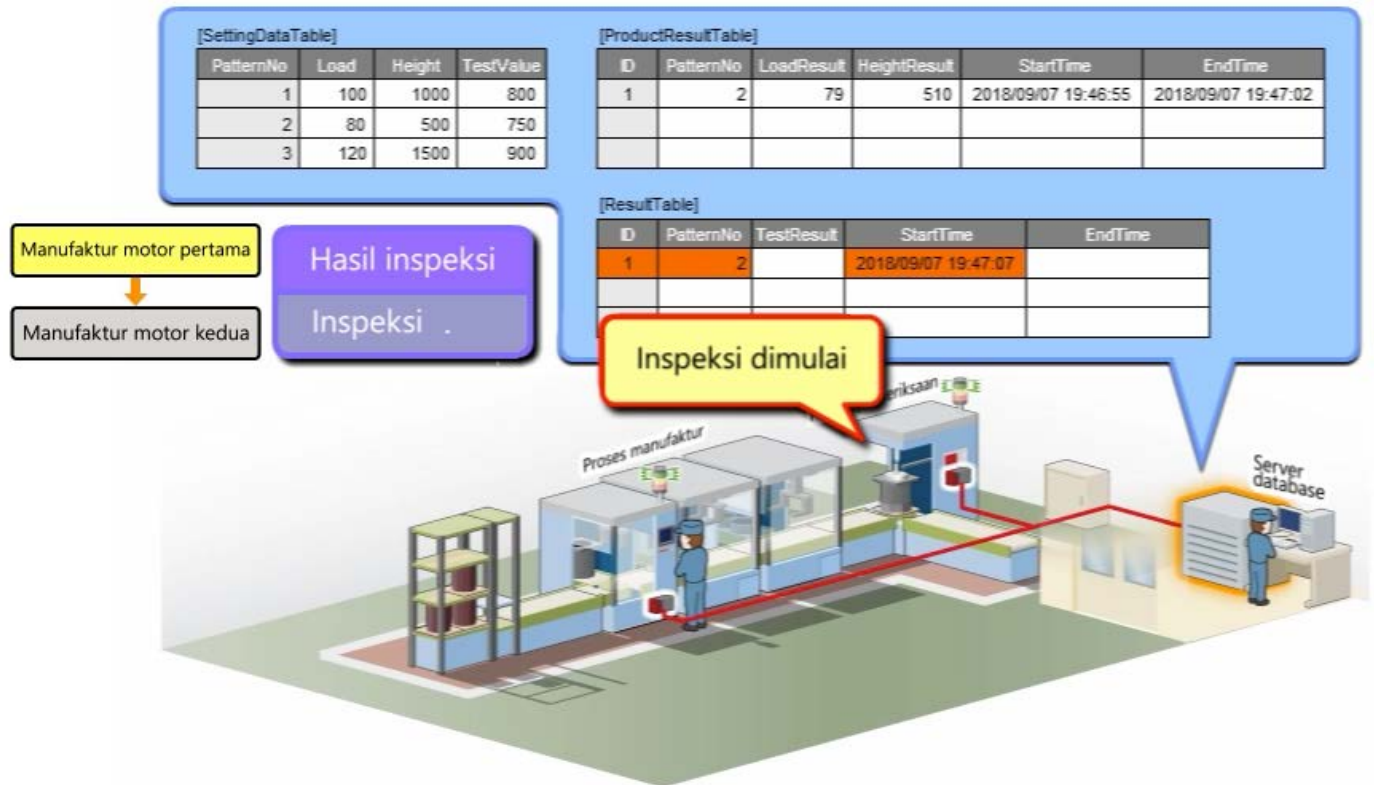
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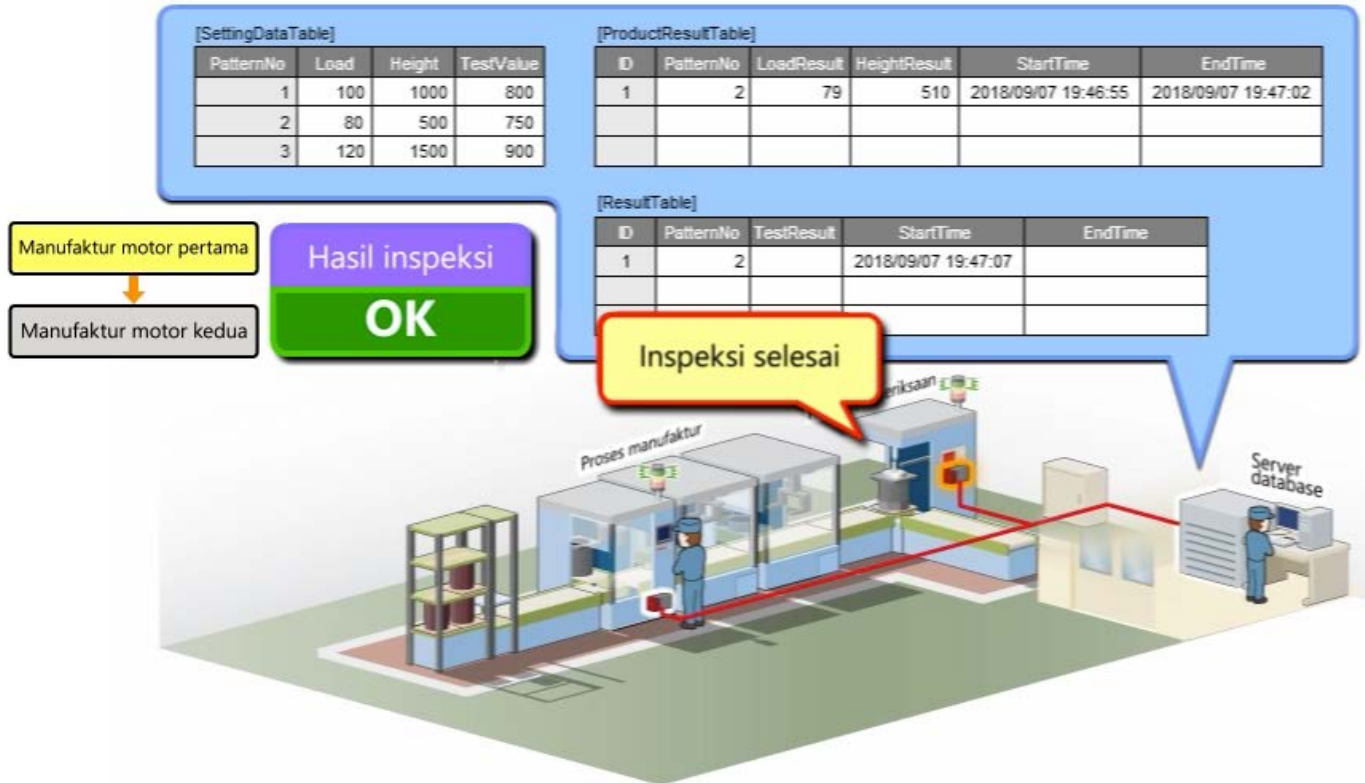
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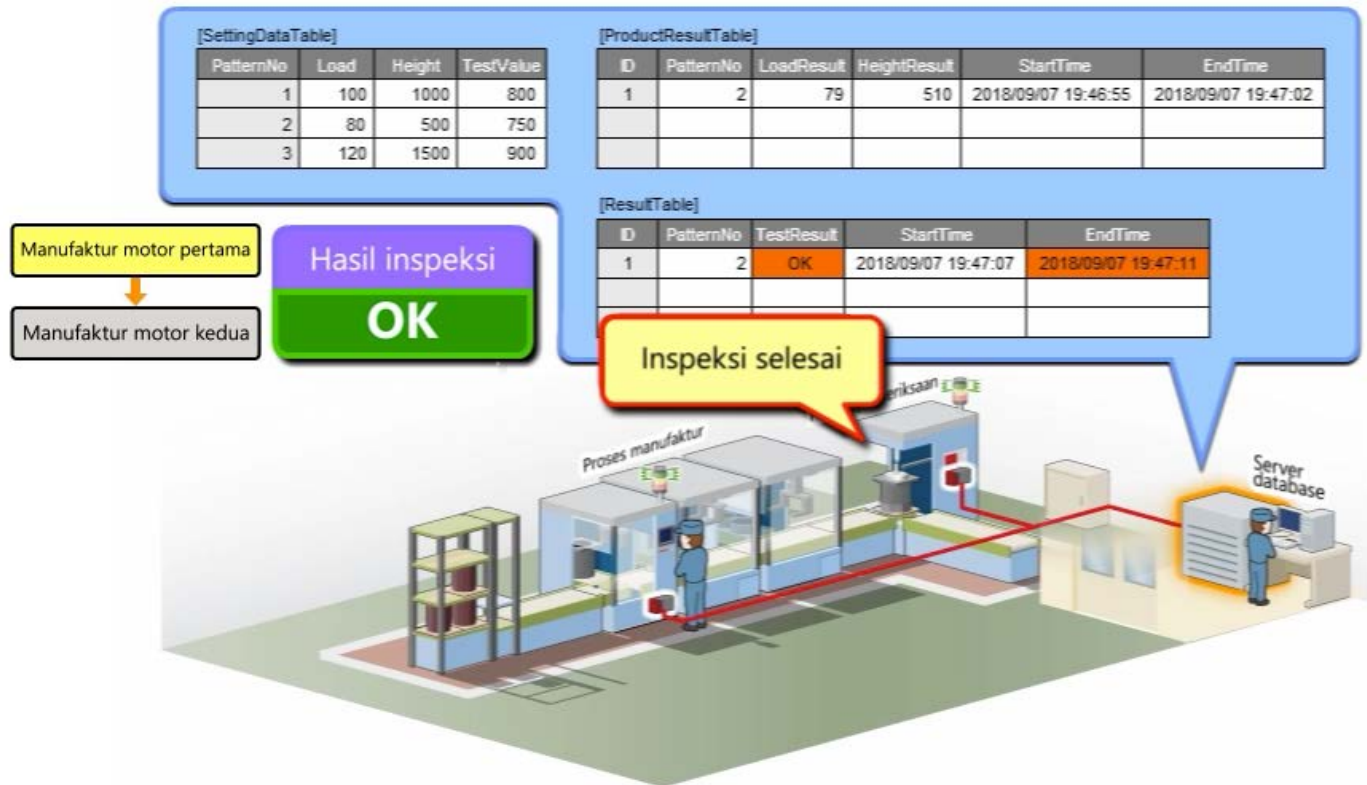
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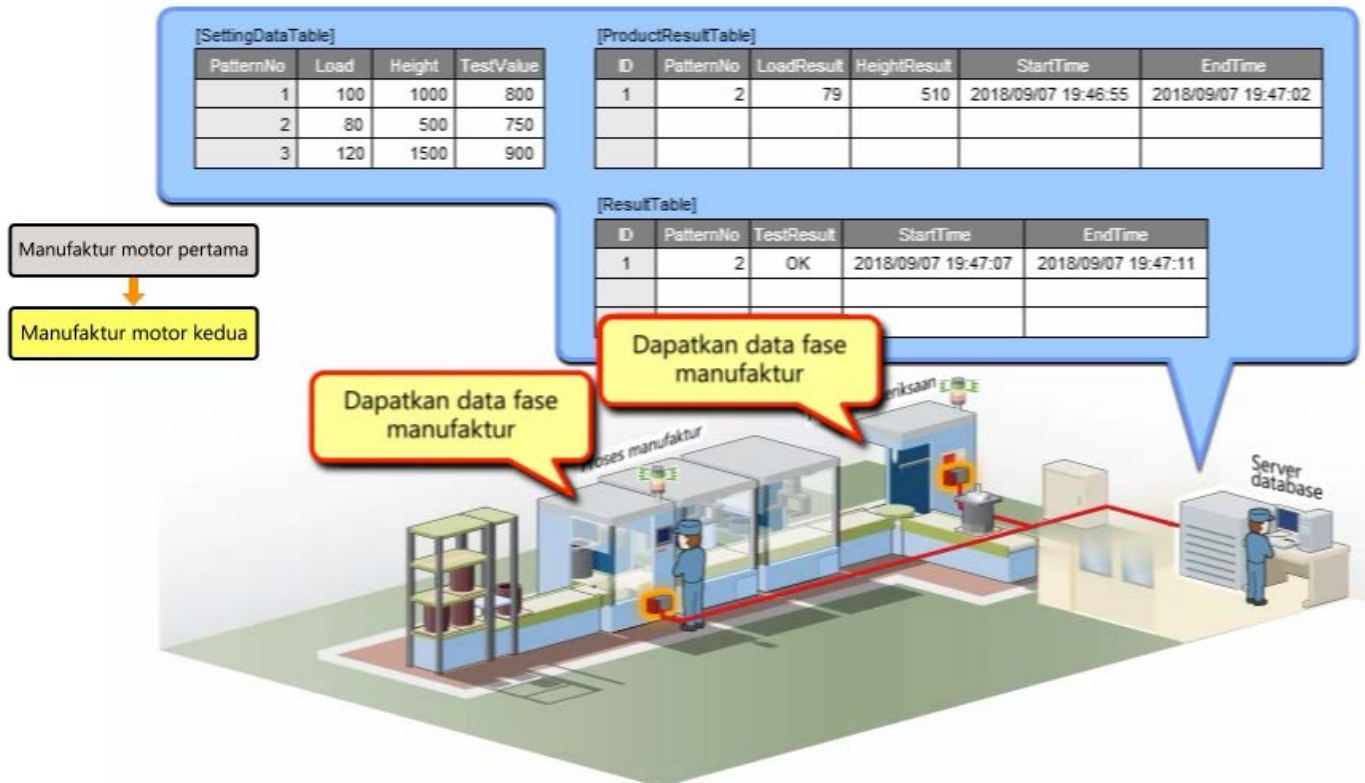
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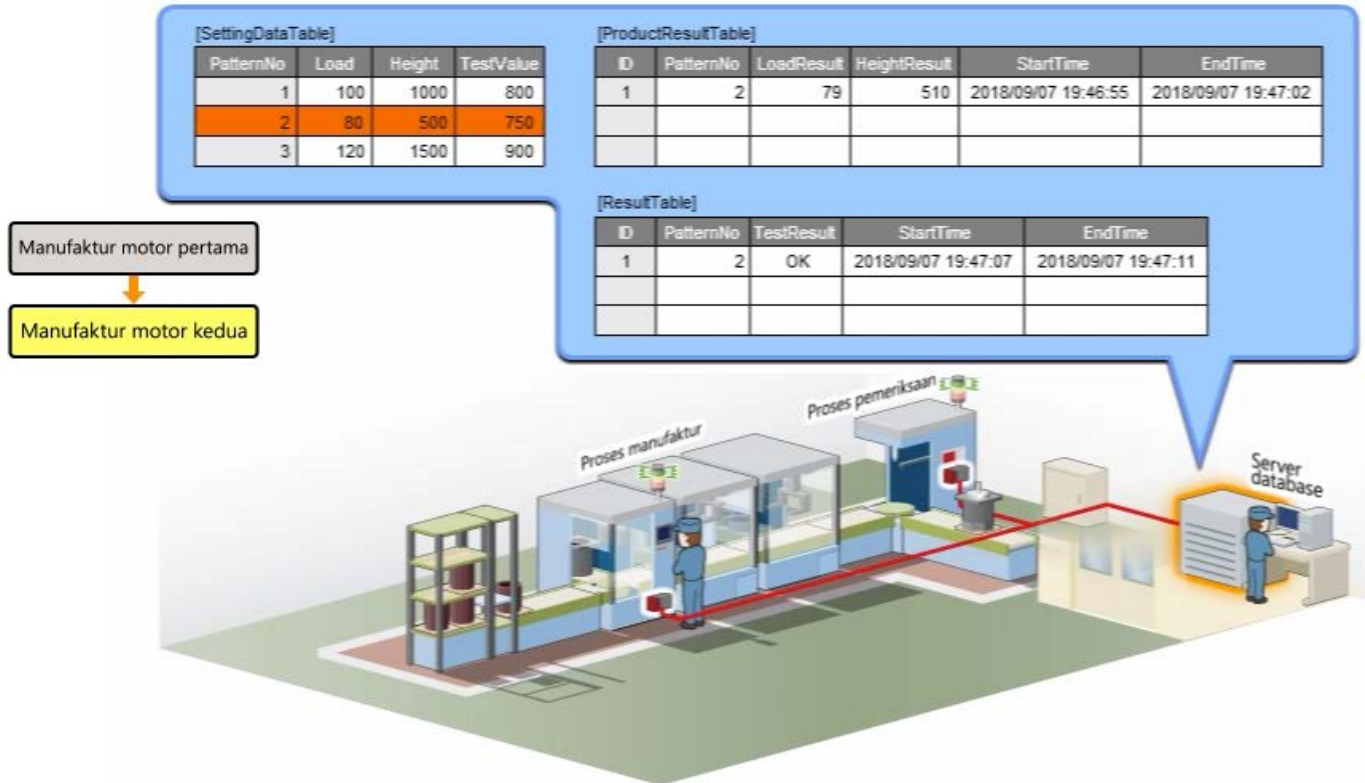
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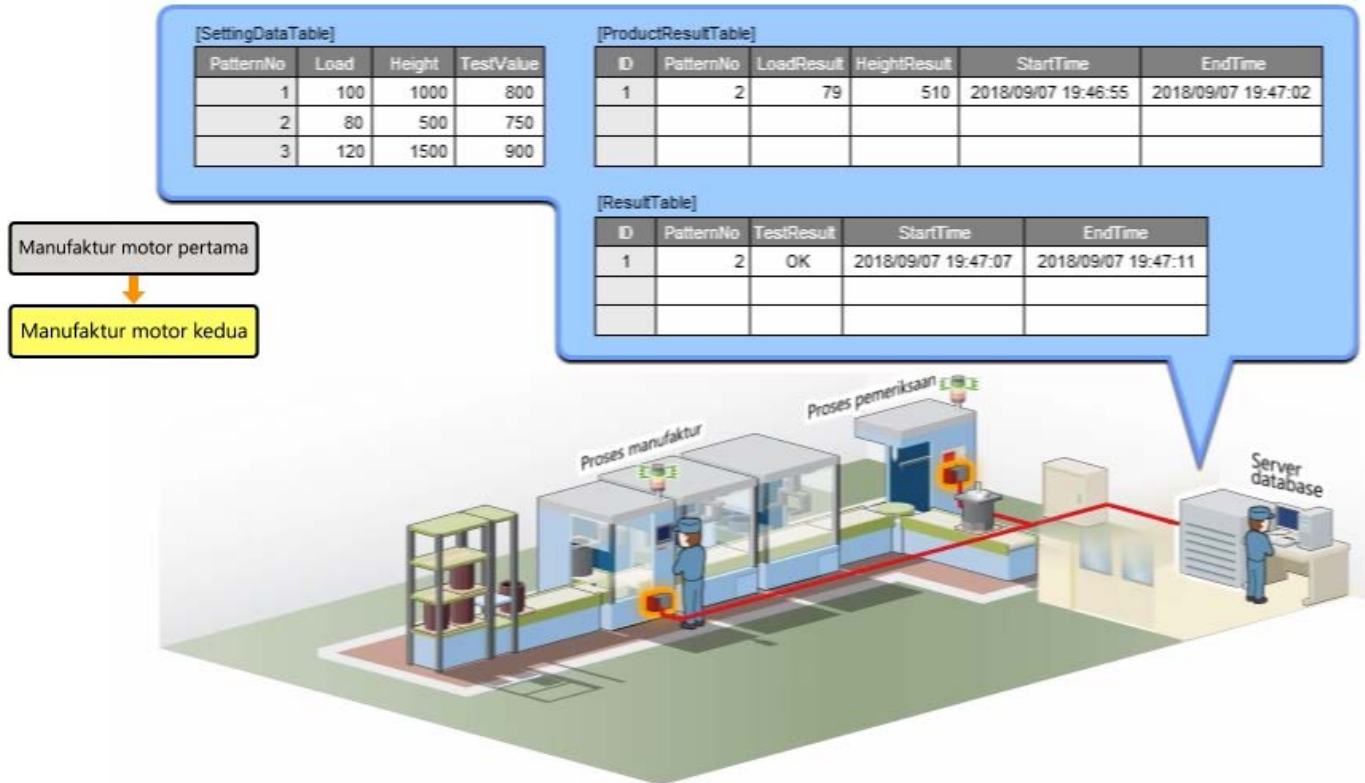
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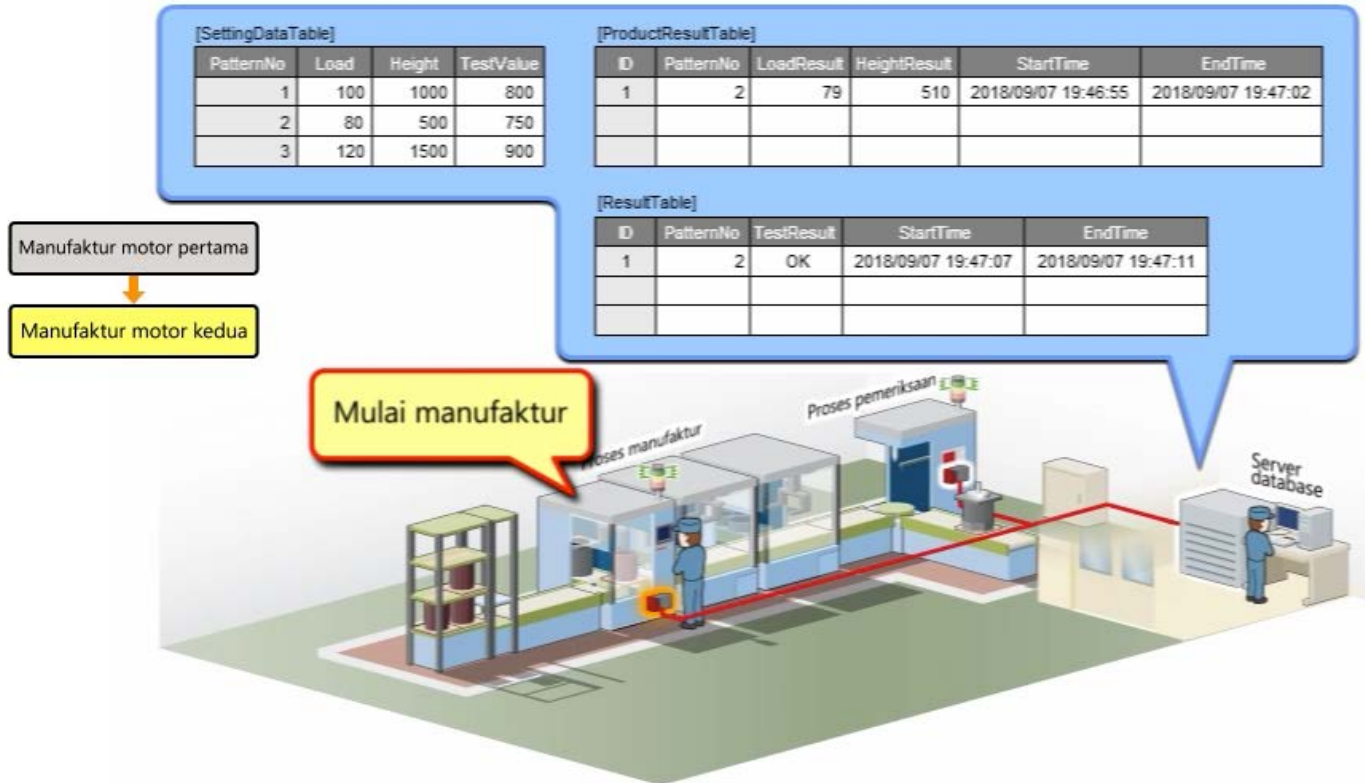
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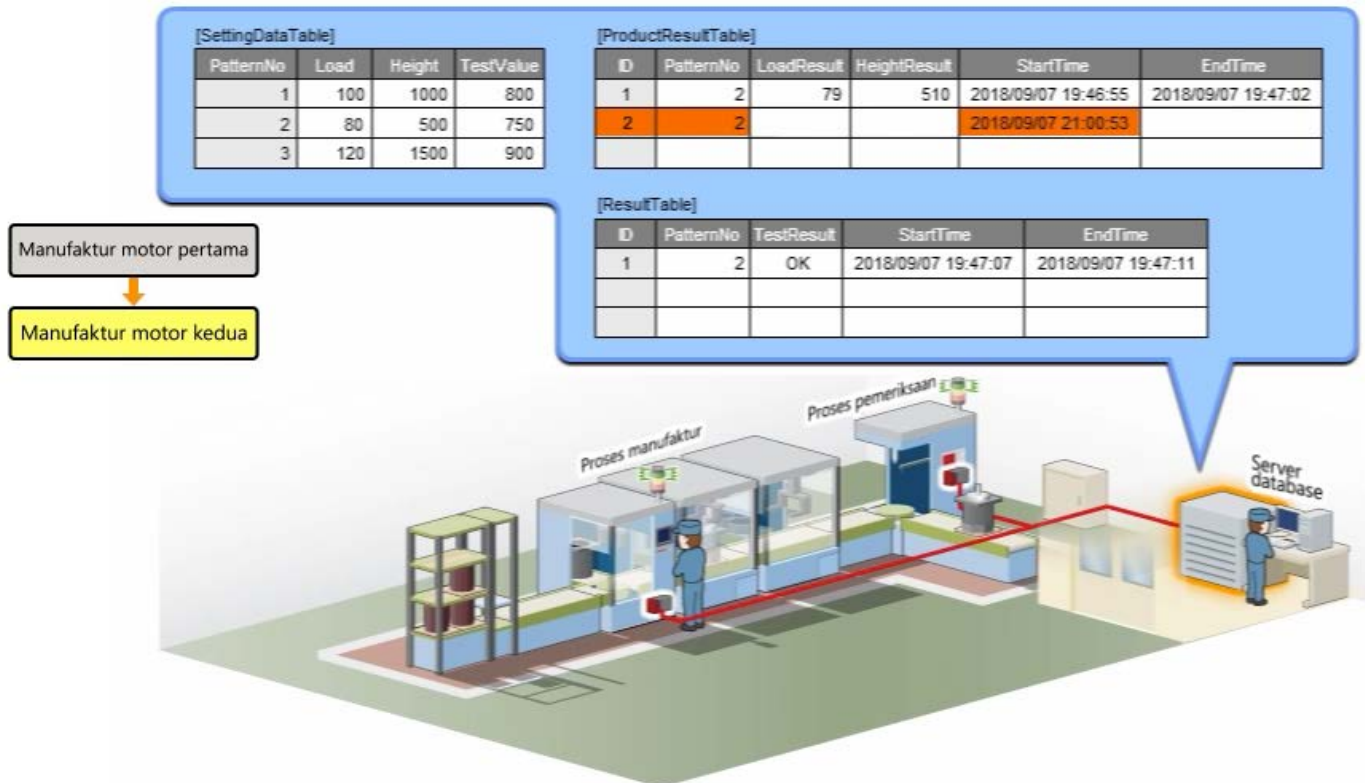
Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



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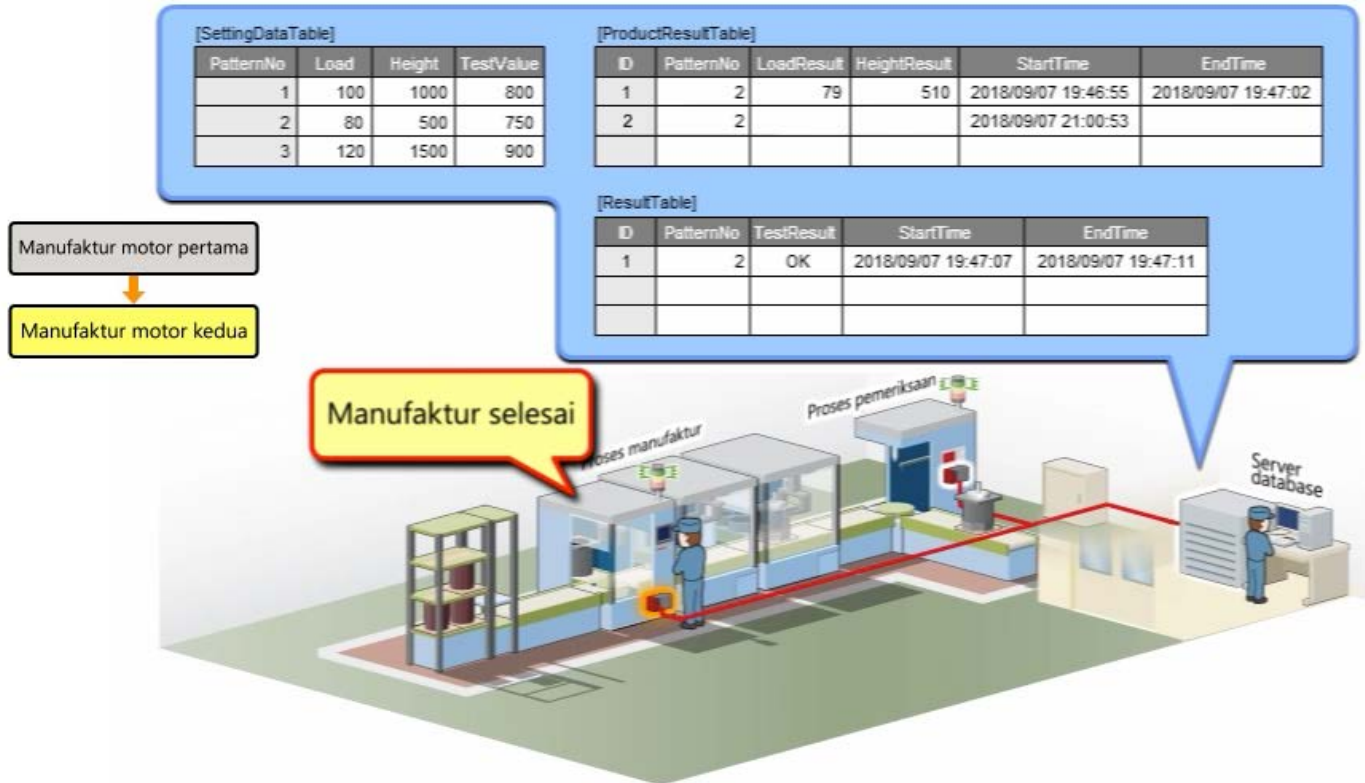
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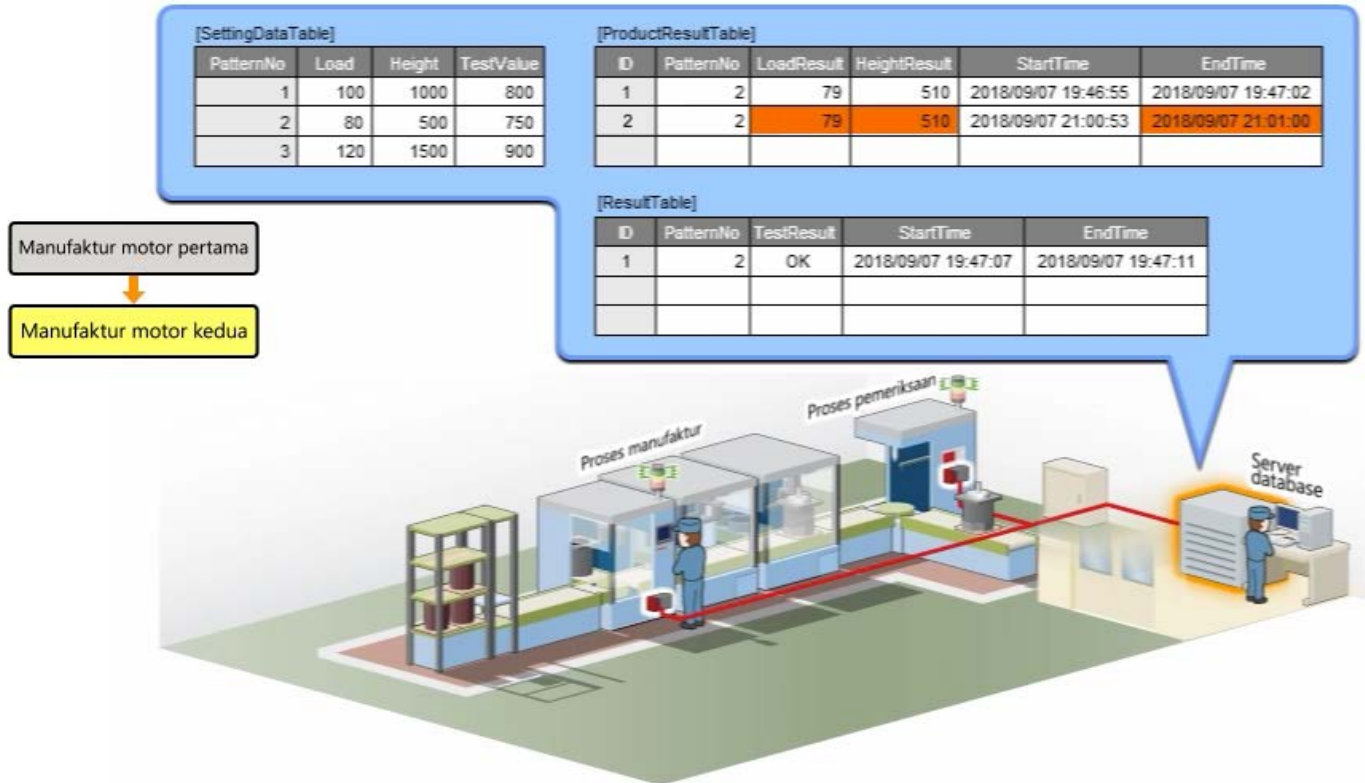
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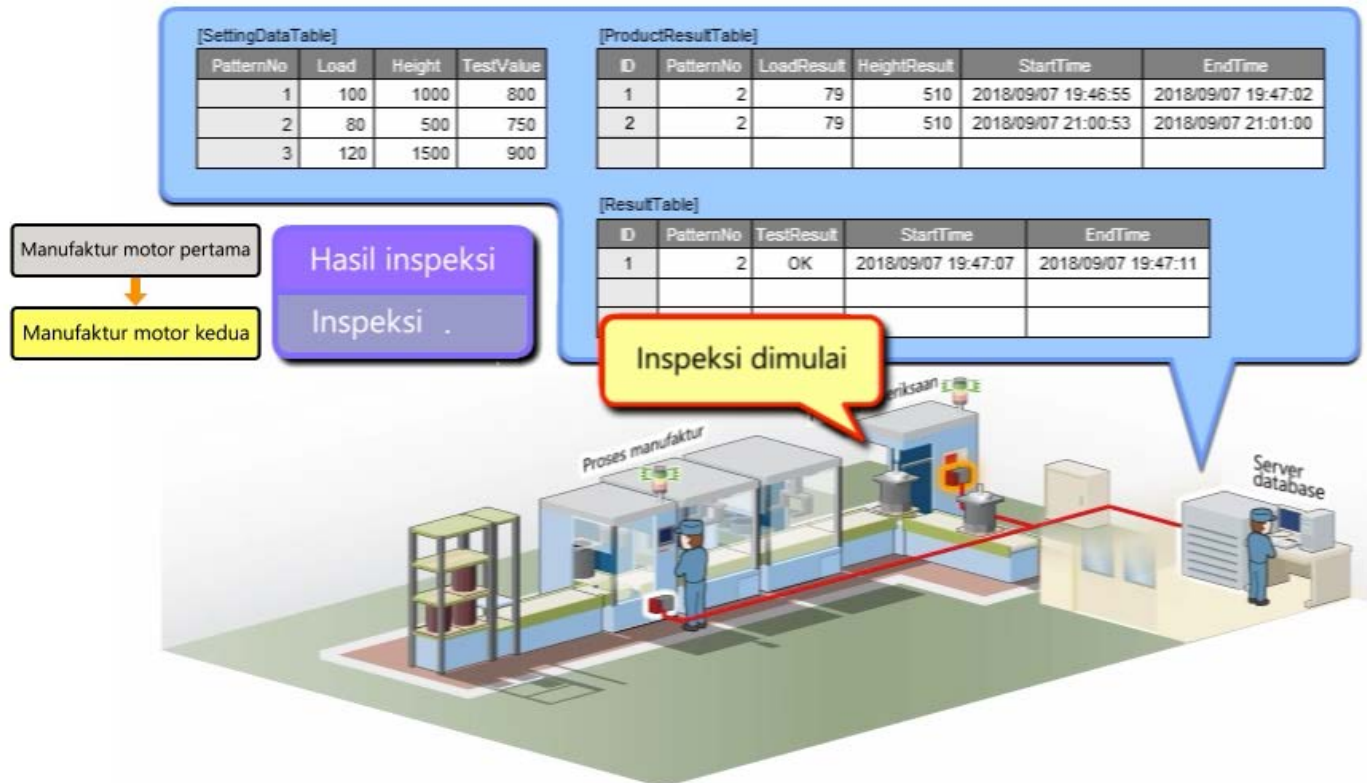
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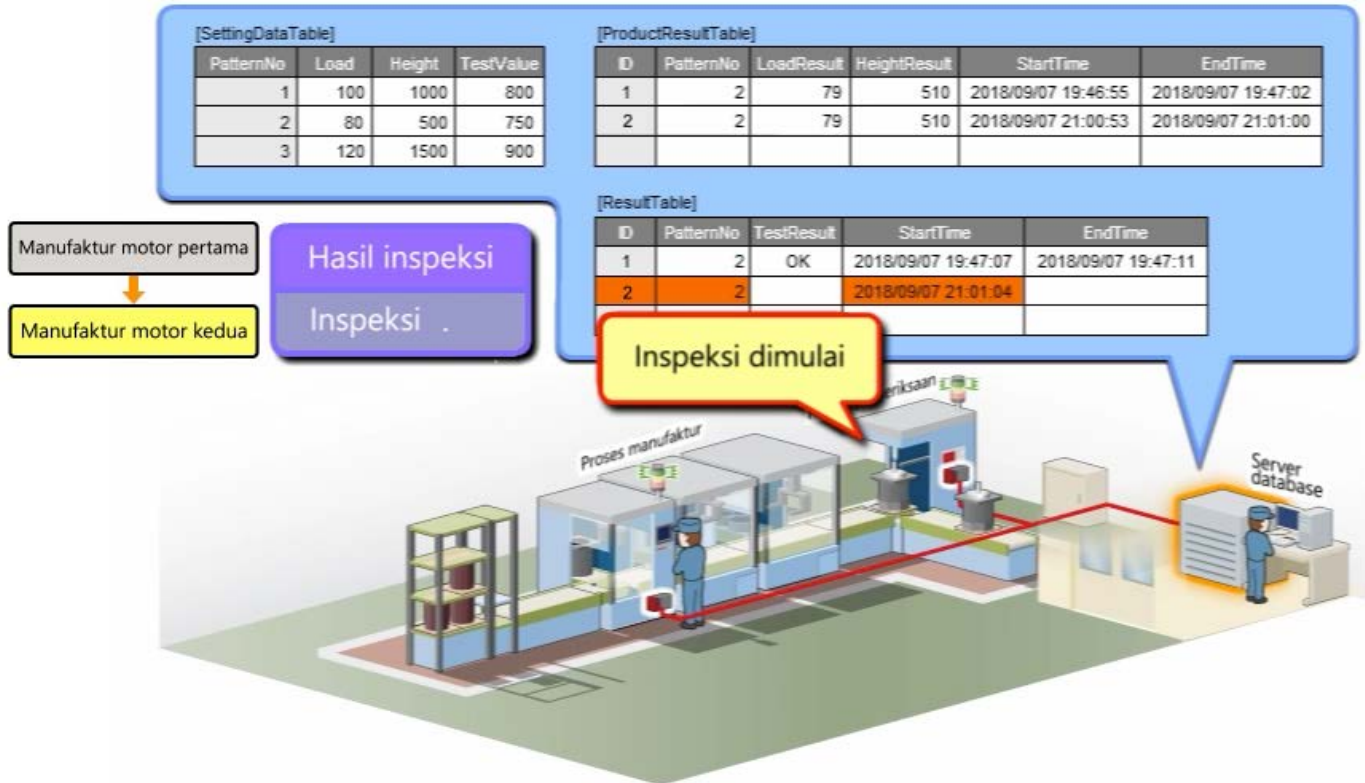
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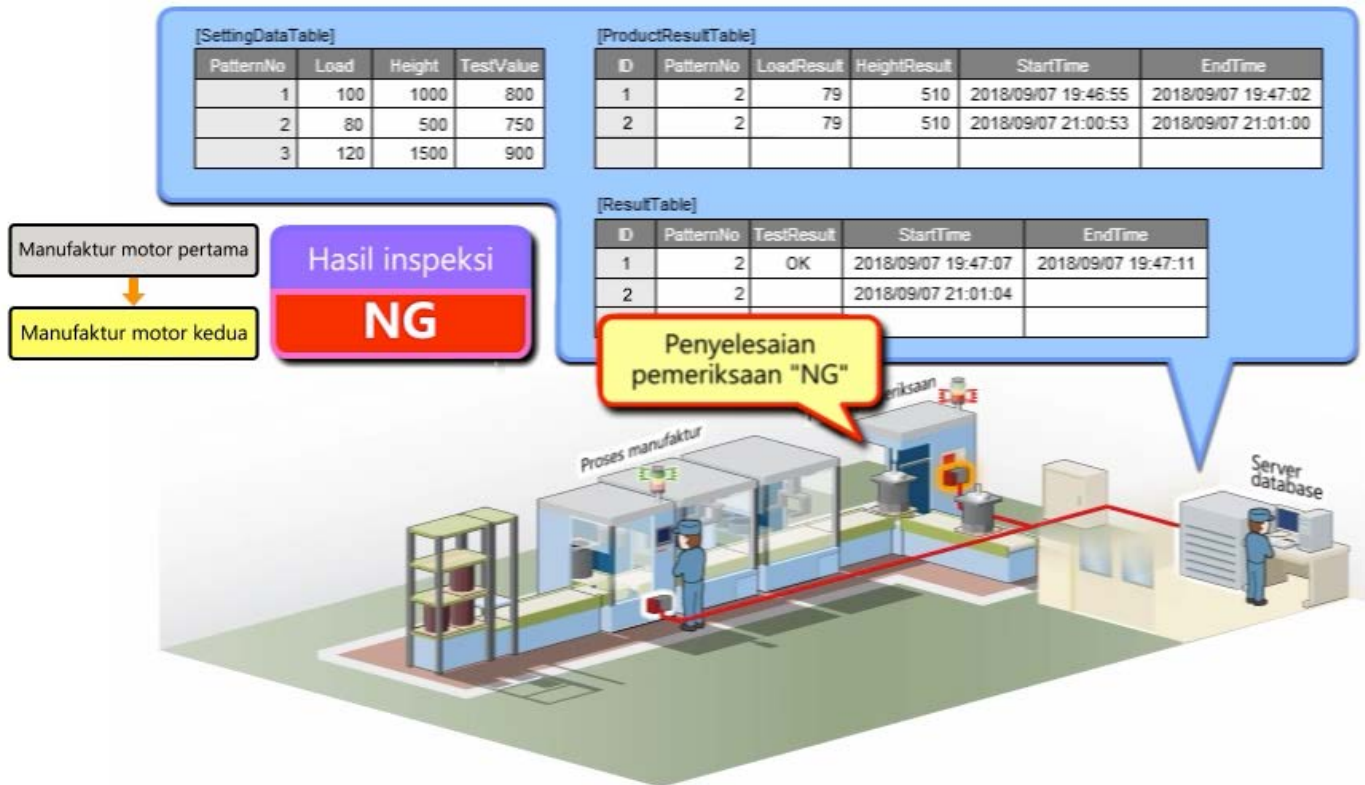
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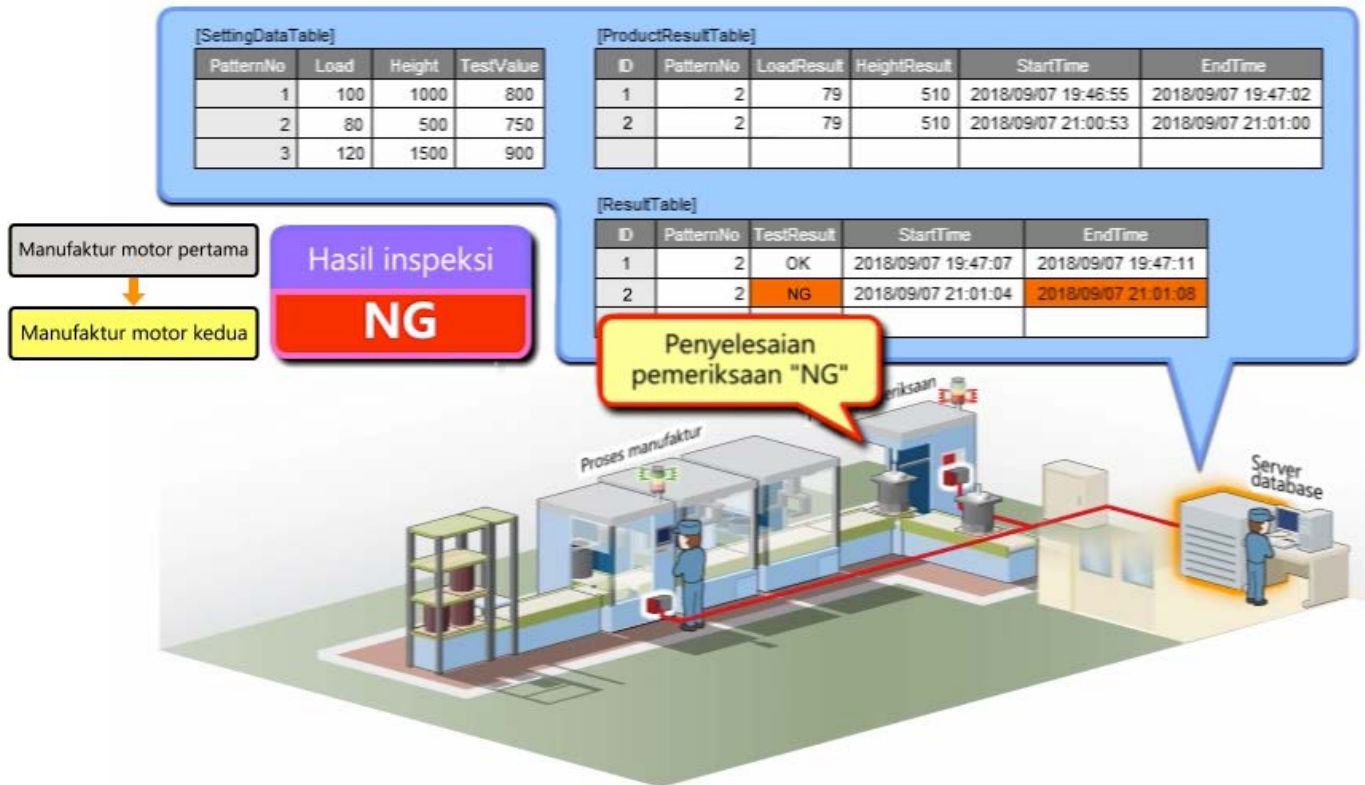
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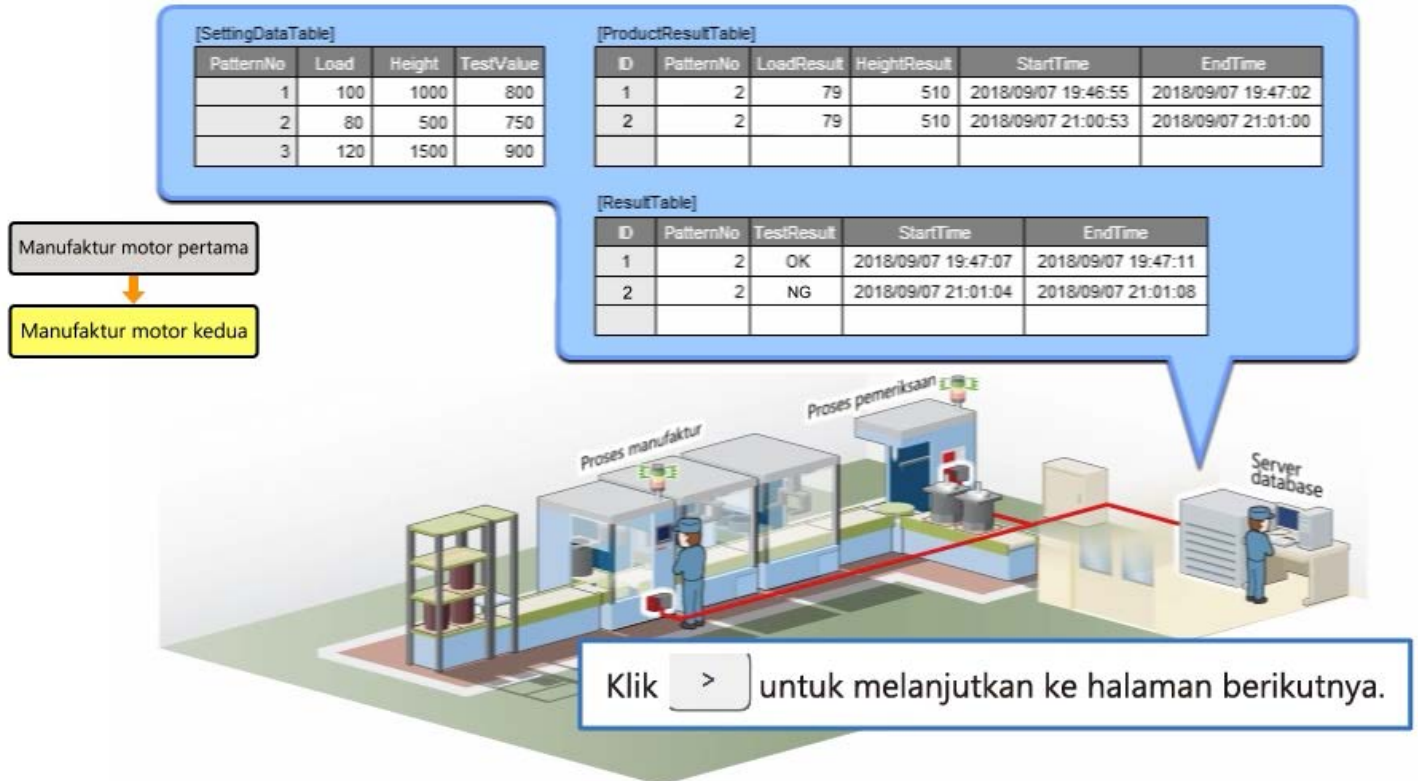
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Pengaturan sebenarnya diperlukan untuk ditulis ke modul antarmuka MES setelah selesai, prosedur tersebut dilewati dalam kursus ini.

Operasi dan aliran data dari sistem yang dikonfigurasi ditunjukkan di bawah ini. **(Periksa klip berikut.)**



Dalam bab ini, Anda telah mempelajari:

- Struktur database
- Peran MES interface function configuration tool
- Tipe pemicu
- Tipe tindakan

Poin-poin

Struktur database	Database adalah kumpulan data yang digunakan bersama oleh beberapa aplikasi atau pengguna. Pengumpulan data diwakili oleh tabel, dan kolomnya disebut bidang (kolom), dan barisnya disebut catatan.
Peran MES interface function configuration tool	Dengan modul antarmuka MES, atur nilai pengontrol yang dapat diprogram yang terhubung ke data dari database dan waktunya. Ketika pengaturan selesai ditulis ke modul antarmuka MES, pengaturan beroperasi dengan pengaturan yang dikonfigurasi.
Tipe pemicu	Waktu pengoperasian (kondisi pemicu) berbeda tergantung pada kombinasi enam tipe peristiwa dan kondisi, dan berbagai pola dapat dipilih. <Umum pada peristiwa/kondisi> • Condition (Value Monitoring): Kondisi ini digunakan untuk beroperasi ketika nilai komponen dan variabel tag perangkat memenuhi kondisi tertentu. <Kondisi> • Condition (Period of Time): Ini digunakan untuk beroperasi dalam waktu mulai yang ditentukan hingga waktu berakhir. <Peristiwa> • Event (Value Changed): Kondisi ini digunakan untuk beroperasi ketika nilai komponen dan variabel tag perangkat berubah dari nilai sebelumnya. • Event (Fixed Time): Peristiwa ini digunakan untuk beroperasi pada waktu tertentu. • Event (Fixed Cycle): Peristiwa ini digunakan untuk beroperasi pada interval waktu yang ditentukan, atau pada interval tertentu berdasarkan waktu yang ditentukan. • Event (Module Monitoring): Peristiwa ini digunakan untuk beroperasi ketika modul antarmuka MES dimulai, fungsi antarmuka dimulai ulang atau pengaturannya diperbarui, atau status CPU manajemen diubah. • Handshake: Peristiwa ini digunakan saat memulai atau menyelesaikan pekerjaan dalam sinkronisasi dengan peralatan pengontrol yang dapat diprogram.
Tipe tindakan	Enam tipe tindakan berikut adalah fungsi untuk berkomunikasi dengan database. • Select: Mengekstraksi data dari database. • Insert: Menambahkan data ke database. • Update: Memperbarui data dalam database. • Delete: Menghapus data dalam database. • Multiple Select: Mengekstraksi beberapa data dari database. • Stored Procedure: Mengeksekusi pemrosesan yang terdaftar di database.

[Tes pemahaman]

Sudahkah Anda memahami sepenuhnya isi Bab 3?

Ikuti tes pemahaman untuk memeriksa dan meninjau isinya.

(3 bagian, 3 pertanyaan)

Pilih benar atau salah untuk deskripsi database berikut ini.

Database disusun oleh daftar yang disebut tabel, dan barisnya disebut "bidang", dan kolomnya disebut "catatan".

☒ Benar

☐ Salah

Pilih benar atau salah untuk deskripsi pengaturan tag perangkat berikut.

Dalam "Pengaturan Tag Perangkat", konfigurasi pengaturan sehingga nama perangkat modul CPU (seperti D100) dan nama bidang database ditautkan secara langsung.

☐ **Benar**

☐ **Salah**

Pilih salah atau benar untuk deskripsi modul antarmuka MES berikut ini.
Modul antarmuka MES dapat digunakan tanpa kartu memori SD.

☐ Benar

☐ Salah

Pilih benar atau salah untuk deskripsi database berikut ini.

Database disusun oleh daftar yang disebut tabel, dan barisnya disebut "bidang", dan kolomnya disebut "catatan".

☐ Benar

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☐ Benar

☒ Salah

Pilih salah atau benar untuk deskripsi modul antarmuka MES berikut ini.
Modul antarmuka MES dapat digunakan tanpa kartu memori SD.

☐ Benar

☒ Salah

Anda telah menyelesaikan tes pemahaman Bab 3.
Berikut adalah hasil tes Anda.

Bagaimana hasil Anda?
Sebaiknya coba lagi pertanyaan yang Anda jawab dengan salah.

		1	2	3	4	5	6	7	8	9	10
	Tes pemahaman 1	✓									
	Tes pemahaman 2	✓									
	Tes pemahaman 3	✓									

Jumlah total pertanyaan: 3

Jawaban yang benar: 3

Persentase: 100 %

Hapus

Setelah menyelesaikan semua pelajaran dari **Dasar-Dasar Visualisasi Manufaktur (modul antarmuka MES seri MELSEC iQ-R)**, kini Anda siap mengikuti tes akhir. Jika Anda masih kurang memahami salah satu topik yang dibahas, gunakan kesempatan ini untuk mengulas topik tersebut.

Total terdapat 5 pertanyaan (5 pilihan) dalam Tes Akhir ini.

Anda dapat mengikuti tes akhir sesering mungkin.

Hasil penilaian

Jumlah jawaban yang benar, jumlah pertanyaan, persentase jawaban yang benar, dan hasil lulus/gagal akan ditampilkan pada halaman nilai.

		1	2	3	4	5	6	7	8	9	10	11	12	
Coba lagi	Tes 1	✓	✓	✓	✗									Jumlah total pertanyaan: 28
	Tes 2	✓	✓	✓	✓									Jawaban yang benar: 23
	Tes 3	✓												Persentase: 82 %
	Tes 4	✓	✓											
	Tes 5	✓	✓											
Coba lagi	Tes 6	✓	✗	✗	✗									
	Tes 7	✓	✓	✓	✓									
	Tes 8	✓	✓	✓	✓	✓								
	Tes 9	✓												
Coba lagi	Tes 10	✗												Untuk berhasil lulus tes, diperlukan jawaban yang benar sebanyak 60%.

Pilih aplikasi yang tepat untuk mengelola lokasi manufaktur dan melakukan manufaktur secara efisien. (Pilih satu.)

☐ ERP

☐ PDM

☐ MES

Pilih jawaban yang salah dari keuntungan menggunakan database dibandingkan dengan pengelolaan data menggunakan file. (Pilih satu.)

- ☐ Banyak data yang dapat dikelola dan kemampuan pencarian data yang tinggi.
- ☐ Lebih sedikit data yang dapat dikelola, tetapi kemampuan penelusuran datanya tinggi.
- ☐ Beberapa akses simultan didukung karena memiliki performa tinggi dalam pemrosesan eksklusif.

Pilih benar atau salah untuk deskripsi database berikut ini.
Database disusun oleh daftar yang disebut tabel, dan barisnya disebut "bidang", dan kolomnya disebut "catatan".

☐ Benar

☐ Salah

Pilih deskripsi yang benar untuk siklus PDCA yang diterapkan untuk meningkatkan manufaktur di lokasi manufaktur. (Pilih satu.)

- ☐ Satu eksekusi siklus PDCA sudah cukup untuk meningkatkan manufaktur.
- ☐ Menjalankan siklus PDCA secara terus menerus penting untuk meningkatkan manufaktur.
- ☐ Dalam perencanaan, langkah pertama dari siklus PDCA, rencana kasar berdasarkan asumsi dibuat tanpa menggunakan data aktual.

Pilih jawaban yang salah sebagai keuntungan menggunakan modul antarmuka MES untuk mengumpulkan data di lokasi manufaktur. (Pilih satu.)

- ☐ Data dikirim/diterima ke/dari database secara otomatis dengan menginstal modul antarmuka MES ke pengontrol terprogram yang mengontrol peralatan.
- ☐ Modul database dan CPU dapat dihubungkan dengan membuat program komunikasi dan mendaftarkannya ke modul antarmuka MES.
- ☐ Data dapat dikumpulkan secara real-time dalam sistem yang menggunakan modul antarmuka MES, dan keandalan sistemnya tinggi.

Pilih aplikasi yang tepat untuk mengelola lokasi manufaktur dan melakukan manufaktur secara efisien. (Pilih satu.)

☐ ERP

☐ PDM

☒ MES

Pilih jawaban yang salah dari keuntungan menggunakan database dibandingkan dengan pengelolaan data menggunakan file. (Pilih satu.)

- ☐ Banyak data yang dapat dikelola dan kemampuan pencarian data yang tinggi.
- ☒ Lebih sedikit data yang dapat dikelola, tetapi kemampuan penelusuran datanya tinggi.
- ☐ Beberapa akses simultan didukung karena memiliki operforma tinggi dalam pemrosesan eksklusif.

Pilih benar atau salah untuk deskripsi database berikut ini.
Database disusun oleh daftar yang disebut tabel, dan barisnya disebut "bidang", dan kolomnya disebut "catatan".

☐ Benar

☒ Salah

Pilih deskripsi yang benar untuk siklus PDCA yang diterapkan untuk meningkatkan manufaktur di lokasi manufaktur. (Pilih satu.)

- ☐ Satu eksekusi siklus PDCA sudah cukup untuk meningkatkan manufaktur.
- ☒ Menjalankan siklus PDCA secara terus menerus penting untuk meningkatkan manufaktur.
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- ☐ Data dikirim/diterima ke/dari database secara otomatis dengan menginstal modul antarmuka MES ke pengontrol terprogram yang mengontrol peralatan.
- ☒ Modul database dan CPU dapat dihubungkan dengan membuat program komunikasi dan mendaftarkannya ke modul antarmuka MES.
- ☐ Data dapat dikumpulkan secara real-time dalam sistem yang menggunakan modul antarmuka MES, dan keandalan sistemnya tinggi.

Anda telah menyelesaikan Tes Akhir. Hasil Anda adalah sebagai berikut.
Untuk mengakhiri Tes Akhir, lanjutkan ke halaman berikutnya.

		1	2	3	4	5	6	7	8	9	10
	Tes Akhir 1	✓									
	Tes Akhir 2	✓									
	Tes Akhir 3	✓									
	Tes Akhir 4	✓									
	Tes Akhir 5	✓									

Jumlah total pertanyaan: 5
Jawaban yang benar: 5
Persentase: 100 %

Hapus

Anda telah menyelesaikan Kursus Dasar-Dasar Visualisasi Manufaktur (modul antarmuka MES seri MELSEC iQ-R).

Terima kasih telah mengikuti kursus ini.

Kami harap Anda menikmati pelajaran, dan kami harap informasi yang diperoleh dalam kursus ini dapat bermanfaat di masa mendatang.

Anda dapat mengulas kursus ini kapanpun Anda mau.

Tinjau

Tutup