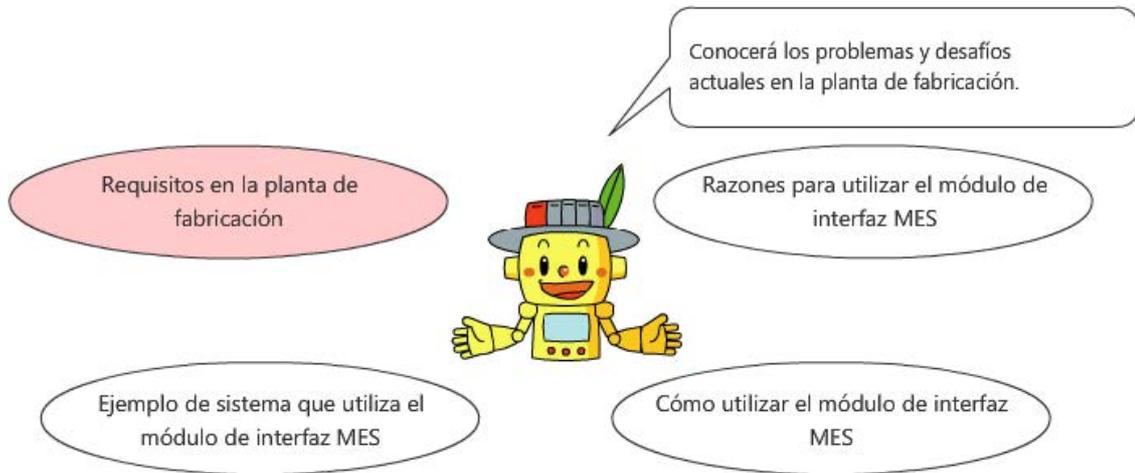


PLC

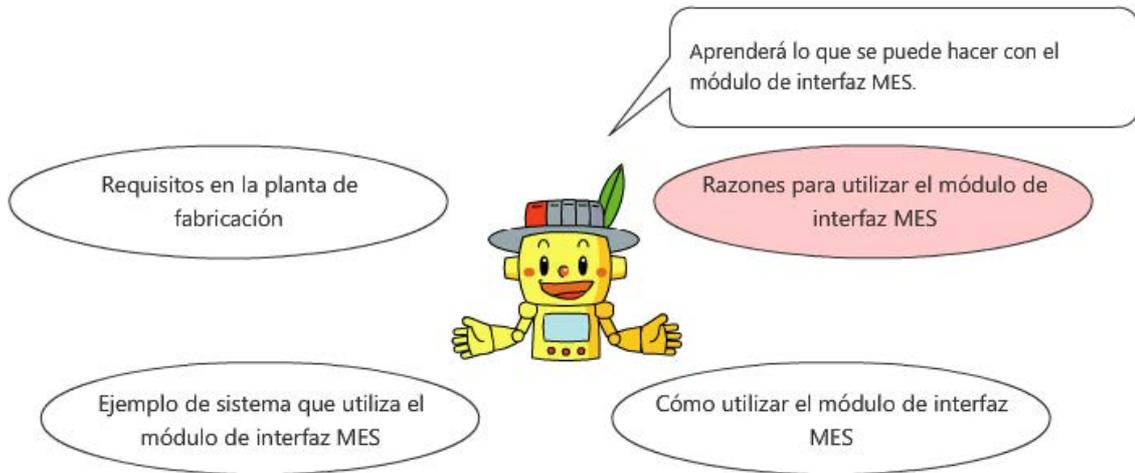
**Información básica de
visualización de fabricación
(módulo de interfaz MES de la
serie MELSEC iQ-R)**

Este curso de capacitación es para participantes que implementarán la base de datos o configurarán un sistema usando un módulo de interfaz MES (RD81MES96), o lo propondrán.

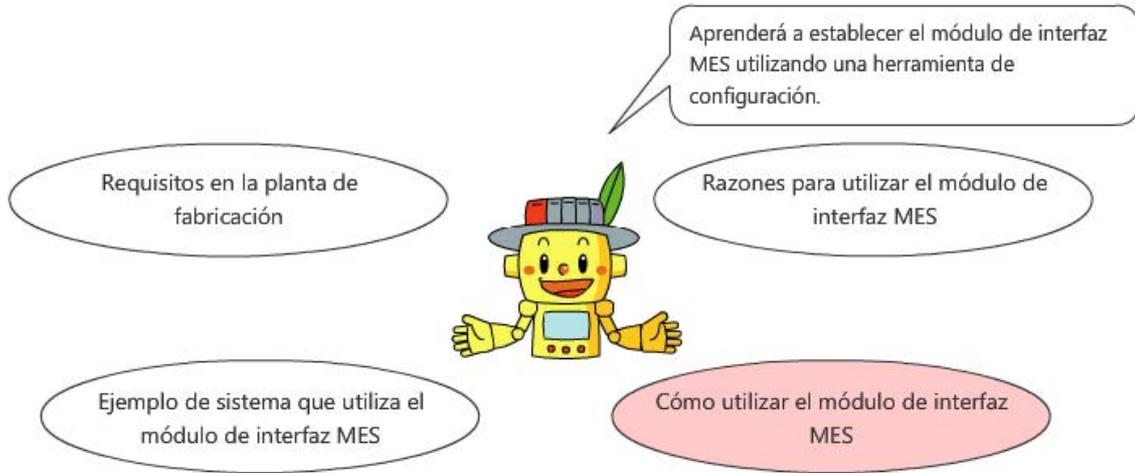
Este curso es para que comprenda los problemas y desafíos actuales en la planta de fabricación, y que el módulo de interfaz MES se puede utilizar para resolverlos. También puede aprender las funciones y cómo utilizar el módulo de interfaz MES, y los ejemplos del sistema usándolo.



Este curso es para que comprenda los problemas y desafíos actuales en la planta de fabricación, y que el módulo de interfaz MES se puede utilizar para resolverlos. También puede aprender las funciones y cómo utilizar el módulo de interfaz MES, y los ejemplos del sistema usándolo.



Este curso es para que comprenda los problemas y desafíos actuales en la planta de fabricación, y que el módulo de interfaz MES se puede utilizar para resolverlos. También puede aprender las funciones y cómo utilizar el módulo de interfaz MES, y los ejemplos del sistema usándolo.



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El contenido de este curso es el siguiente.
Le recomendamos que comience desde el Capítulo 1.

Capítulo 1 Requisitos en la industria manufacturera

Conozca qué se requiere para reducir el costo total en la planta de fabricación de la industria manufacturera actual y qué tipo de sistema puede lograrlo.

Capítulo 2 Razones para seleccionar el módulo de interfaz MES

Conozca las ventajas de utilizar la base de datos y el módulo de interfaz MES.

Capítulo 3 Cómo utilizar el módulo de interfaz MES

Aprenda a configurar los ajustes utilizando la MES interface function configuration tool mientras sigue los puntos.

Prueba final

5 secciones en total (5 preguntas) Nota aprobatoria: 60 % o un porcentaje mayor

Ir a la página siguiente		Ir a la página siguiente.
Regresar a la página anterior		Regresar a la página anterior.
Ir a la página deseada		Se visualizará el "Índice", lo que le permitirá navegar a la página deseada.
Salir del aprendizaje		Salir del aprendizaje. El aprendizaje y las ventanas como la pantalla de "Contenidos" se cerrarán.

Precauciones de seguridad

Si aprende utilizando productos reales, lea todas las precauciones de seguridad incluidas en los manuales correspondientes.

Precauciones en este curso

- Es posible que las ventanas de la versión del software que usted usa sean diferentes a las que se muestran en este curso. A continuación se muestra el software utilizado en este curso y cada versión del software.
 - MELSOFT MX MESInterface-R Version1 Ver.1.07H
(MES interface function configuration tool)

Referencia

La siguiente es una referencia relacionada con los temas que se tocan en este curso. (Tenga en cuenta que este material de referencia no es absolutamente necesario, ya que aún puede completar este curso sin utilizarlo).

Haga clic en el nombre del archivo de referencia para descargar.

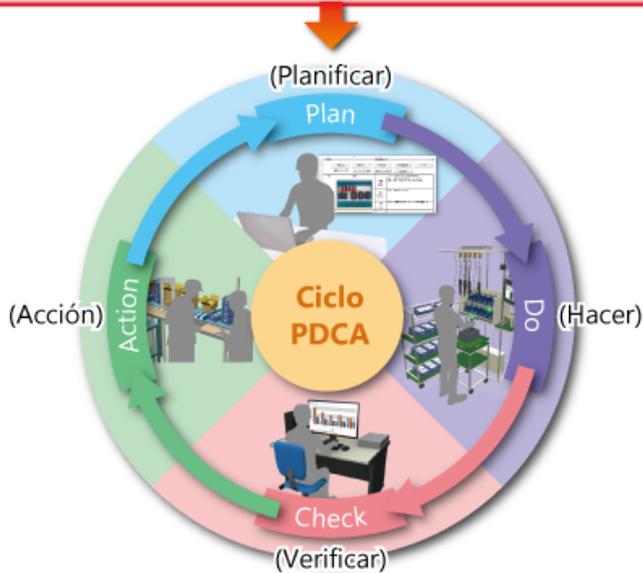
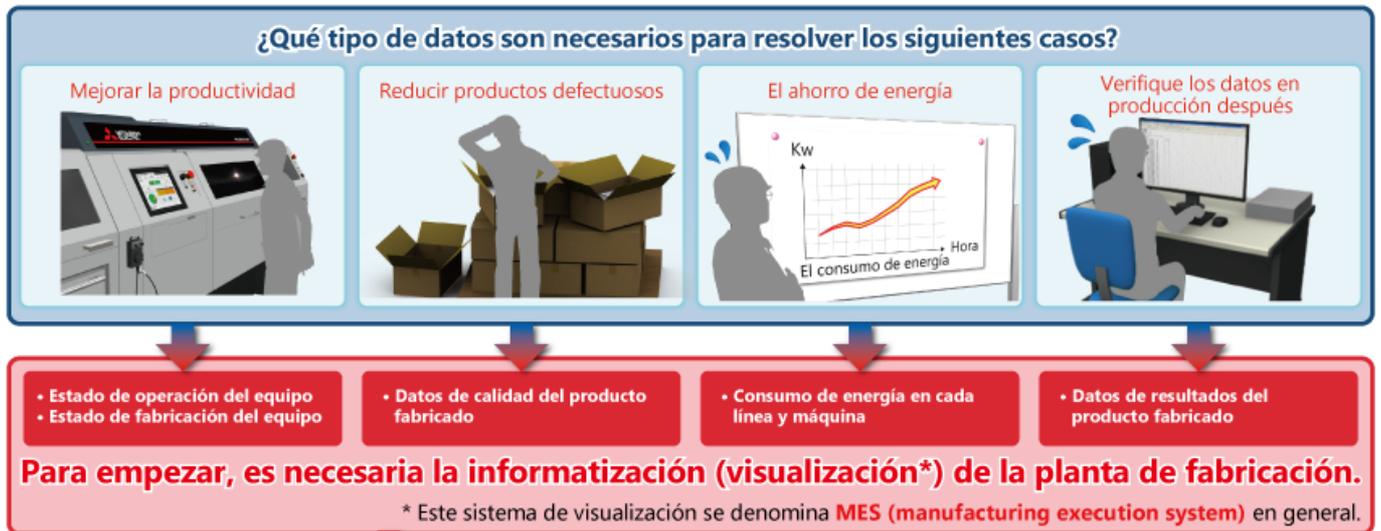
Nombre de referencia	Formato del archivo	Tamaño del archivo
Hoja de registro	Archivo comprimido	5,80 kB

En este capítulo, conocerá qué se requiere para reducir el costo total en la planta de fabricación de la industria manufacturera actual y qué tipo de sistema puede lograrlo.

Contenido del Capítulo 1

- 1.1 Problemas en la planta de fabricación
- 1.2 "Visualización" y Recopilación de datos de la planta de fabricación
- 1.3 Resumen

La industria manufacturera se encuentra actualmente en una competencia extrema de precios. En tales situaciones, la planta de fabricación se enfrenta a varios requisitos para reducir el costo total. Entonces, ¿cómo pueden las plantas de fabricación satisfacer esas demandas?

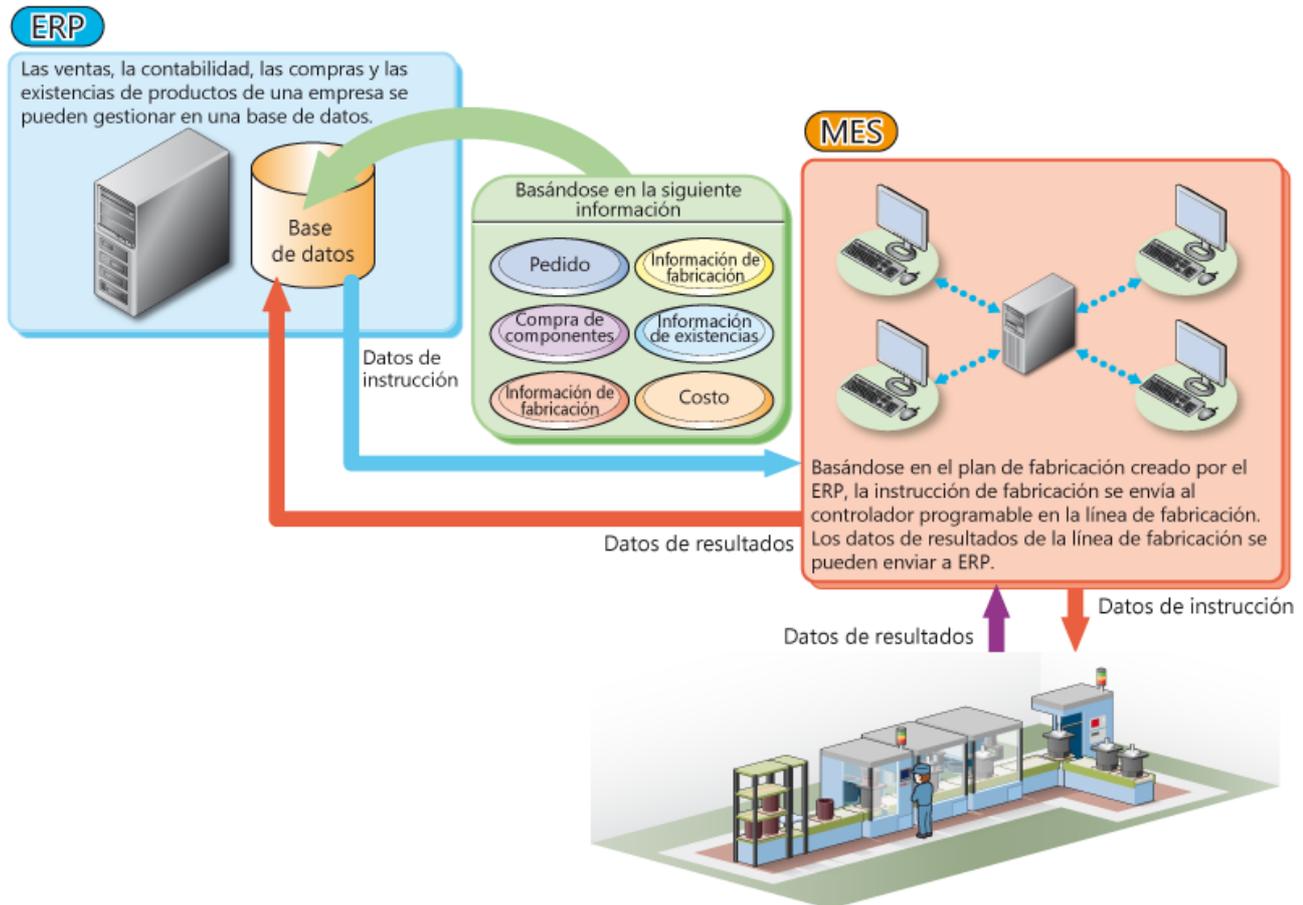


Es importante extraer los datos recopilados, ejecutar el ciclo PDCA para mejorar la fabricación y continuar con estas acciones.

En general, el sistema que administra la planta de fabricación para llevar a cabo el plan de fabricación de manera eficiente en función de la información recopilada de la planta se denomina **MES (Sistema de ejecución de fabricación)**.

El sistema MES se utiliza a menudo con el software **ERP**, que administra los pedidos, las ventas, las existencias, los costos y el plan de fabricación.

Al conectarse con un sistema superior, se pueden captar el plan y el resultado, que se pueden utilizar para una gestión empresarial eficiente.



En la planta de fabricación, se ha implementado el ciclo PDCA (planificar, hacer, revisar y actuar) mediante la recopilación de datos en las plantas para mejorar la fabricación.

Ahora, ¿cuáles son las ventajas de utilizar el módulo de interfaz MES?

En esta sección se describe cómo se ha desarrollado el sistema informático junto con la tecnología informática (IT) avanzada.



En el primer sistema, la información de la planta de fabricación se recopila registrando la información en papel. Luego, los datos registrados en papel eran ingresados a la computadora personal. ¿Cuáles eran los problemas?

- Tomaba tiempo recopilar la información.
- No se podía recopilar toda la información debido al proceso manual.
- Se ingresaban datos inexactos porque los humanos volvían a contar los datos medidos.

En la planta de fabricación, se ha implementado el ciclo PDCA (planificar, hacer, revisar y actuar) mediante la recopilación de datos en las plantas para mejorar la fabricación.

Ahora, ¿cuáles son las ventajas de utilizar el módulo de interfaz MES?

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En la planta de fabricación, se ha implementado el ciclo PDCA (planificar, hacer, revisar y actuar) mediante la recopilación de datos en las plantas para mejorar la fabricación.

Ahora, ¿cuáles son las ventajas de utilizar el módulo de interfaz MES?

En esta sección se describe cómo se ha desarrollado el sistema informático junto con la tecnología informática (IT) avanzada.



¿Qué ocurre si se utiliza el módulo de interfaz MES?

Al reunir las funciones en el lado del equipo, los datos son transferidos automáticamente por el equipo.

Por lo tanto, se recopilan todos los datos y se puede crear un sistema sin una computadora personal con puertos de enlace.

Al utilizar el módulo de interfaz MES, los datos se pueden recopilar en tiempo real y se puede crear un sistema de alta fiabilidad.

Aprenderá otras funciones en el Capítulo 2.

En este capítulo, usted ha aprendido lo siguiente:

- Problemas en la planta de fabricación
- "Visualización" y recopilación de datos de la planta de fabricación

Puntos

Problemas en la planta de fabricación	<ul style="list-style-type: none"> • Para atender las diversas necesidades de la industria manufacturera, es necesaria la implementación del ciclo PDCA mediante la informatización (visualización) de la planta de fabricación. • El sistema que administra la planta de fabricación para llevar a cabo el plan de fabricación de manera eficiente en función de la información recopilada de la planta se denomina MES (Sistema de ejecución de fabricación). • Al conectarse con un sistema superior (ERP), se pueden captar el plan y el resultado, que se pueden utilizar para una gestión empresarial eficiente.
"Visualización" y recopilación de datos de la planta de fabricación	Existen muchos sistemas MES en los que se utilizan computadoras con puertas de enlace. Sin embargo, un sistema que puede recopilar todos los datos en tiempo real se puede implementar fácilmente utilizando el módulo de interfaz MES.

[Prueba de comprensión]

¿Ha comprendido todo el contenido del Capítulo 1?

Tome la prueba de comprensión para verificar y revisar el contenido.

(3 secciones, 3 preguntas)

Seleccione la aplicación correcta para administrar la planta de fabricación y realizar la fabricación de manera eficiente. (Seleccione una opción)

ERP

PDM

MES

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar el módulo de interfaz MES para recopilar los datos en la planta de fabricación. (Seleccione una opción)

- Los datos se envían/reciben en/desde la base de datos automáticamente mediante la instalación del módulo de interfaz MES en el controlador programable del equipo.
- La base de datos y el módulo de CPU se pueden conectar creando un programa de comunicación y registrándolo en el módulo de interfaz MES.
- Los datos se pueden recopilar en tiempo real en el sistema que utiliza el módulo de interfaz MES, y la fiabilidad de ese sistema es alta.

Seleccione la descripción correcta para el ciclo PDCA que se implementa para mejorar la fabricación en la planta. (Seleccione una opción)

- Una ejecución del ciclo PDCA es suficiente para mejorar la fabricación.
- Ejecutar el ciclo PDCA continuamente es importante para mejorar la fabricación.
- En Planificar, el primer paso del ciclo PDCA, se realiza un plan aproximado en base a la suposición sin utilizar los datos reales.

Seleccione la aplicación correcta para administrar la planta de fabricación y realizar la fabricación de manera eficiente. (Seleccione una opción)

ERP

PDM

MES

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar el módulo de interfaz MES para recopilar los datos en la planta de fabricación. (Seleccione una opción)

- Los datos se envían/reciben en/desde la base de datos automáticamente mediante la instalación del módulo de interfaz MES en el controlador programable del equipo.
- La base de datos y el módulo de CPU se pueden conectar creando un programa de comunicación y registrándolo en el módulo de interfaz MES.
- Los datos se pueden recopilar en tiempo real en el sistema que utiliza el módulo de interfaz MES, y la fiabilidad de ese sistema es alta.

Seleccione la descripción correcta para el ciclo PDCA que se implementa para mejorar la fabricación en la planta. (Seleccione una opción)

- Una ejecución del ciclo PDCA es suficiente para mejorar la fabricación.
- Ejecutar el ciclo PDCA continuamente es importante para mejorar la fabricación.
- En Planificar, el primer paso del ciclo PDCA, se realiza un plan aproximado en base a la suposición sin utilizar los datos reales.

Usted ha completado la prueba de comprensión del Capítulo 1.
El siguiente es el resultado de su prueba.

¿Cuál fue su resultado?

Se recomienda volver a intentar con las preguntas que respondió incorrectamente.

	1	2	3	4	5	6	7	8	9	10
Prueba de comprensión 1	✓									
Prueba de comprensión 2	✓									
Prueba de comprensión 3	✓									

Preguntas totales: **3**

Respuestas correctas: **3**

Porcentaje: **100 %**

Borrar

En el capítulo anterior, se describió el concepto de MES y las ventajas de utilizar el módulo de interfaz MES para "visualizar" y recopilar datos en la planta de fabricación.

De hecho, hay más ventajas en la implementación del sistema MES.

Las ventajas de utilizar la base de datos y el módulo de interfaz MES se describen en este capítulo.

Contenido del Capítulo 2

- 2.1 ¿Por qué se utiliza la base de datos?
- 2.2 Funciones del módulo de interfaz MES
- 2.3 Resumen

En primer lugar, pensemos por qué se utiliza la base de datos para la recopilación de datos.

¿Cómo se utilizan los datos recopilados?

Se utilizan para mostrar el estado actual, comparar la situación antes y después de tomar medidas, extraer datos en condiciones específicas, etc.

Por lo tanto, se requiere acumular datos.

Además, es importante que los datos se puedan utilizar fácilmente.

Por estas razones, los datos a menudo se acumulan de dos maneras: Almacenándolos en archivos como Excel, o almacenándolos en la base de datos.

A continuación se muestran las diferencias entre esas dos maneras.

	Base de datos	Archivo (Excel, etc.)	Descripción
Cantidad de datos	○	△	No se pueden almacenar muchos datos en un archivo. 1048576 filas × 16384 columnas (en 1 hoja) * En el caso de Excel 2016
Los datos no se pueden buscar fácilmente en un archivo.	○	△	No se puede editar de manera simultánea en un archivo.
Procesamiento exclusivo	○	×	Sin embargo, al usar el módulo de interfaz MES, esos datos se pueden usar fácilmente.

Como se describió anteriormente, usar la base de datos ofrece varias ventajas. Aunque se puede usar fácilmente con aplicaciones que se operan en el sistema de IT, tiende a evitarse porque el uso de los datos requiere conocimientos de programación.

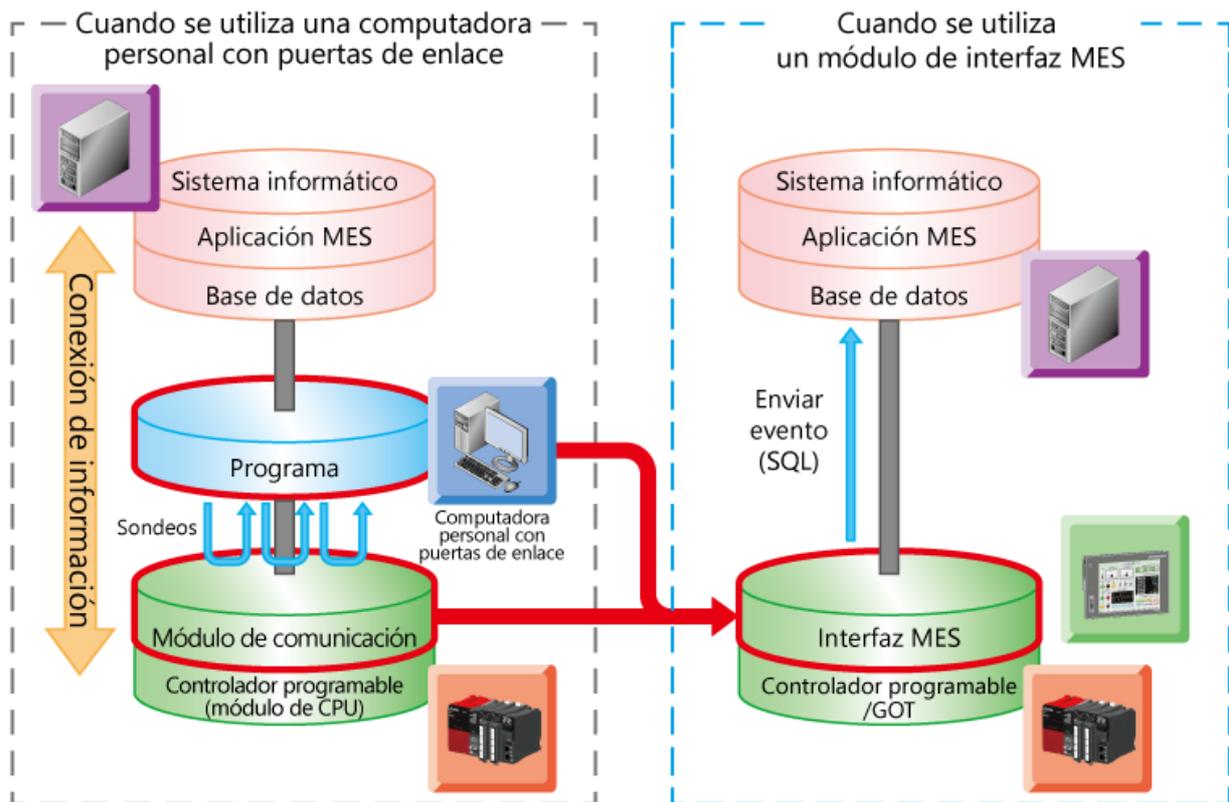
Sin embargo, al usar el módulo de interfaz MES, esos datos se pueden usar fácilmente.

El módulo de interfaz MES es un módulo que facilita la conexión con la base de datos. Existen más funciones además de las que ha aprendido en la sección 1.2. En esta sección, se describen aquellas funciones.

<1. Sin computadora personal/sin programa>

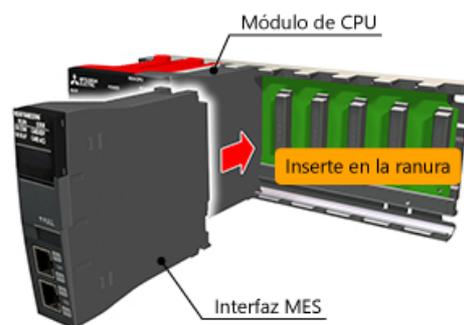
Cuando se conecta con la base de datos utilizando una computadora personal con puertos de enlace, se requiere crear un programa de comunicación para recopilar los datos del equipo y un programa para acceder a la base de datos.

Al utilizar el módulo de interfaz MES, no será necesario un programa o computadora personal con puertos de enlace, y la base de datos se puede conectar fácilmente a bajo costo.



<2. Implementación sencilla>

El módulo de interfaz MES se puede implementar simplemente instalándolo en el controlador programable, y no es necesario cambiar el ladder del programa de control.

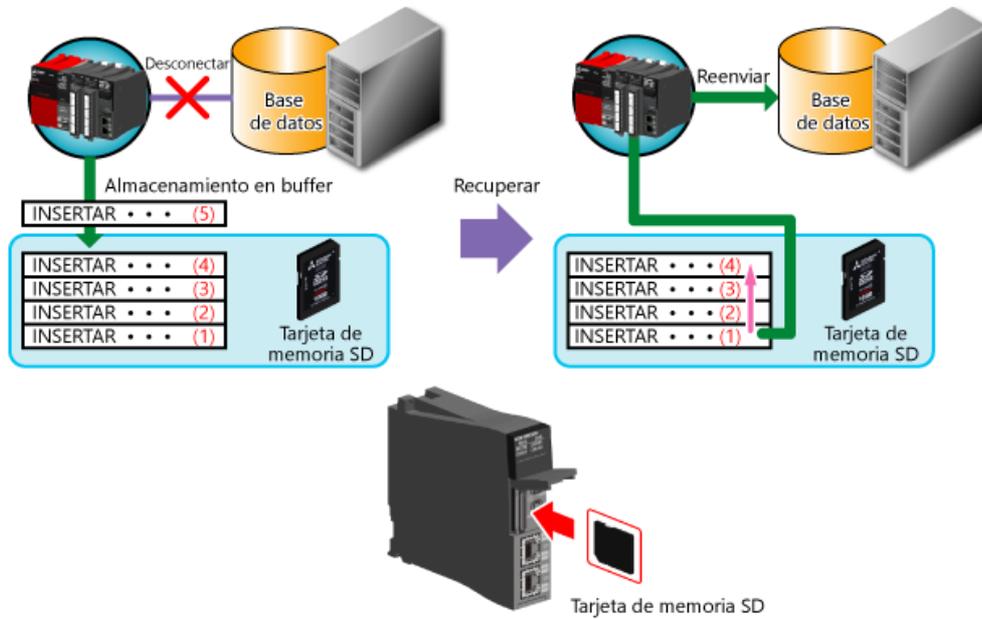


<3. Prevención de omisión de recopilación de datos mediante función de almacenamiento en buffer de base de datos>

Cuando se utiliza una computadora personal con puertos de enlace, ¿qué sucede si la red se desconecta o si el servidor de la base de datos deja de funcionar?

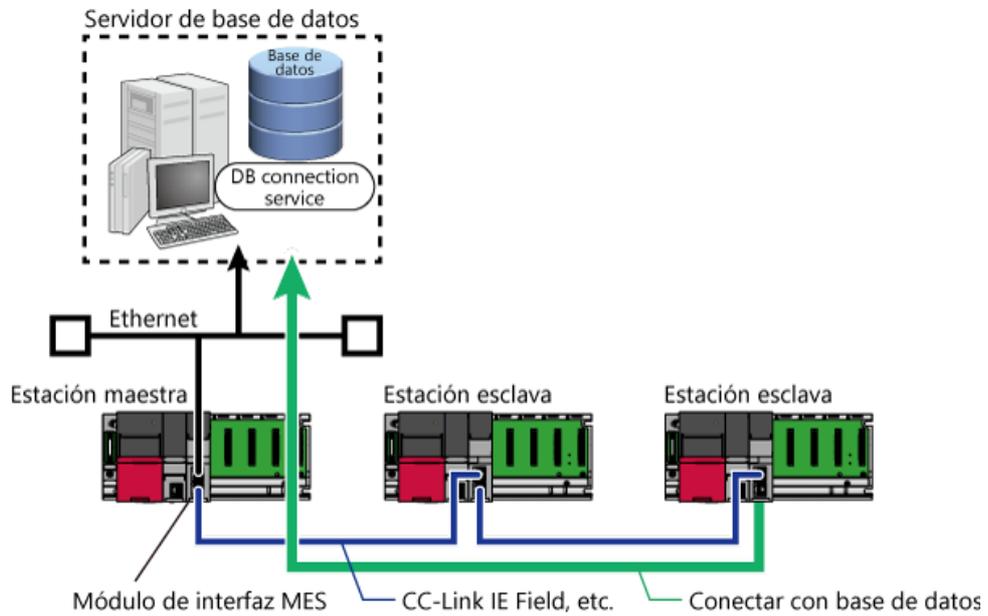
Los datos no se pueden enviar y se produce una omisión de recopilación de datos.

Con el módulo de interfaz MES, los datos se almacenan en la tarjeta de memoria SD insertada y se reenvían automáticamente después de la recuperación.



<5. La información de las otras estaciones PLC es conectable>

Dado que es compatible con otras redes como CC-Link IE Field, la información de las otras estaciones PLC se puede conectar a través de una red.



En este capítulo, usted ha aprendido lo siguiente:

- ¿Por qué se utiliza la base de datos?
- Funciones del módulo de interfaz MES

Puntos

¿Por qué se utiliza la base de datos?	<ul style="list-style-type: none"> • Mediante el uso de la base de datos, la información recopilada simultáneamente por varias personas se puede verificar y la información recopilada se puede clasificar y extraer fácilmente. • Debido a que el estado de fabricación se verifica simultáneamente desde varios dispositivos en la planta, y el progreso de toda la fábrica se verifica desde la oficina, el uso de la base de datos es óptimo.
Funciones del módulo de interfaz MES	<p>Las siguientes cinco funciones son las funciones principales del módulo de interfaz MES.</p> <ol style="list-style-type: none"> 1) La base de datos se puede conectar sin una computadora personal y un programa. 2) Es posible una instalación sencilla simplemente instalando el módulo de interfaz MES en el PLC. 3) La omisión de la recopilación de datos no se produce incluso en caso de error de comunicación, ya que los datos se reenvían automáticamente después de la recuperación. 4) La hora se puede sincronizar con el servidor utilizando la función de ajuste de sincronización de hora del módulo de CPU. 5) La información de otras estaciones PLC se puede conectar con la base de datos a través de una red.

[Prueba de comprensión]

¿Ha comprendido todo el contenido del Capítulo 2?

Tome la prueba de comprensión para verificar y revisar el contenido.

(3 secciones, 3 preguntas)

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar la base de datos en comparación con la gestión de datos utilizando archivos. (Seleccione una opción)

- Se pueden gestionar muchos datos y la capacidad de búsqueda de datos es alta.
- Se pueden gestionar menos datos, pero la capacidad de búsqueda de datos es alta.
- Se admite el acceso simultáneo múltiple ya que tiene un alto rendimiento en el procesamiento exclusivo.

Seleccione la descripción correcta para la función de almacenamiento en buffer de base de datos, que es la función del módulo de interfaz MES. (Seleccione una opción)

- La omisión de recopilación de datos se puede prevenir incluso en caso de falla de red, ya que los datos se pueden almacenar en la tarjeta de memoria SD y se pueden volver a enviar automáticamente después de la recuperación.**
- Los datos en la base de datos se pueden guardar en la tarjeta SD en cualquier momento ajustando la MES interface function configuration tool con anticipación.**
- La función de almacenamiento en buffer de base de datos almacena los datos en la memoria interna en el módulo de interfaz MES en caso de falla de red.**

Seleccione la descripción correcta para la función de sincronización horaria del módulo de interfaz MES.
(Seleccione una opción)

Solo se puede sincronizar la hora del módulo de CPU.

Solo se puede sincronizar la hora del servidor.

No se puede sincronizar la hora.

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar la base de datos en comparación con la gestión de datos utilizando archivos. (Seleccione una opción)

- Se pueden gestionar muchos datos y la capacidad de búsqueda de datos es alta.
- Se pueden gestionar menos datos, pero la capacidad de búsqueda de datos es alta.
- Se admite el acceso simultáneo múltiple ya que tiene un alto rendimiento en el procesamiento exclusivo.

Seleccione la descripción correcta para la función de almacenamiento en buffer de base de datos, que es la función del módulo de interfaz MES. (Seleccione una opción)

- La omisión de recopilación de datos se puede prevenir incluso en caso de falla de red, ya que los datos se pueden almacenar en la tarjeta de memoria SD y se pueden volver a enviar automáticamente después de la recuperación.**
- Los datos en la base de datos se pueden guardar en la tarjeta SD en cualquier momento ajustando la MES interface function configuration tool con anticipación.**
- La función de almacenamiento en buffer de base de datos almacena los datos en la memoria interna en el módulo de interfaz MES en caso de falla de red.**

Seleccione la descripción correcta para la función de sincronización horaria del módulo de interfaz MES.
(Seleccione una opción)

Solo se puede sincronizar la hora del módulo de CPU.

Solo se puede sincronizar la hora del servidor.

No se puede sincronizar la hora.

Usted ha completado la prueba de comprensión del Capítulo 2.
El siguiente es el resultado de su prueba.

¿Cuál fue su resultado?

Se recomienda volver a intentar con las preguntas que respondió incorrectamente.

	1	2	3	4	5	6	7	8	9	10
Prueba de comprensión 1	✓									
Prueba de comprensión 2	✓									
Prueba de comprensión 3	✓									

Preguntas totales: **3**

Respuestas correctas: **3**

Porcentaje: **100 %**

Borrar

En el capítulo anterior, se explicó la efectividad de la base de datos y varias funciones del módulo de interfaz MES. En este capítulo, se describe cómo configurar los ajustes utilizando la MES interface function configuration tool con los puntos explicados.

Al instalar el módulo de interfaz MES, es necesario lo siguiente.

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

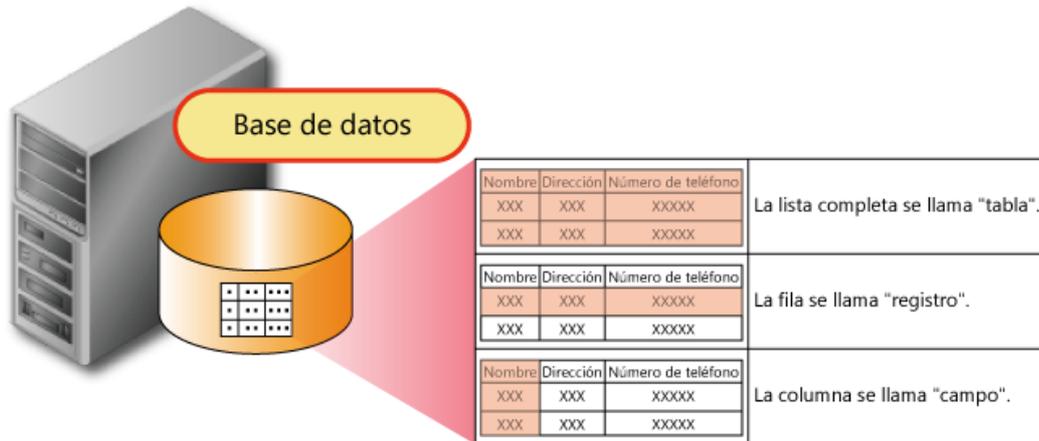
El siguiente software está almacenado en MX MESInterface-R.

- MES interface function configuration tool
 - Servicio de conexión con la base de datos y herramienta de ajustes
 - Herramienta de conversión de archivos de proyectos * No se utiliza en este capítulo.
- Tarjeta de memoria SD

Contenido del Capítulo 3

- 3.1 Estructura de la base de datos
- 3.2 Configuración del sistema
- 3.3 Inicio de la MES interface function configuration tool
- 3.4 Ajuste con la MES interface function configuration tool
- 3.5 Ejemplo de sistema de módulo de interfaz MES
- 3.6 Resumen

Antes de la explicación del método de ajuste, se explica cómo se gestionan los datos en la base de datos.

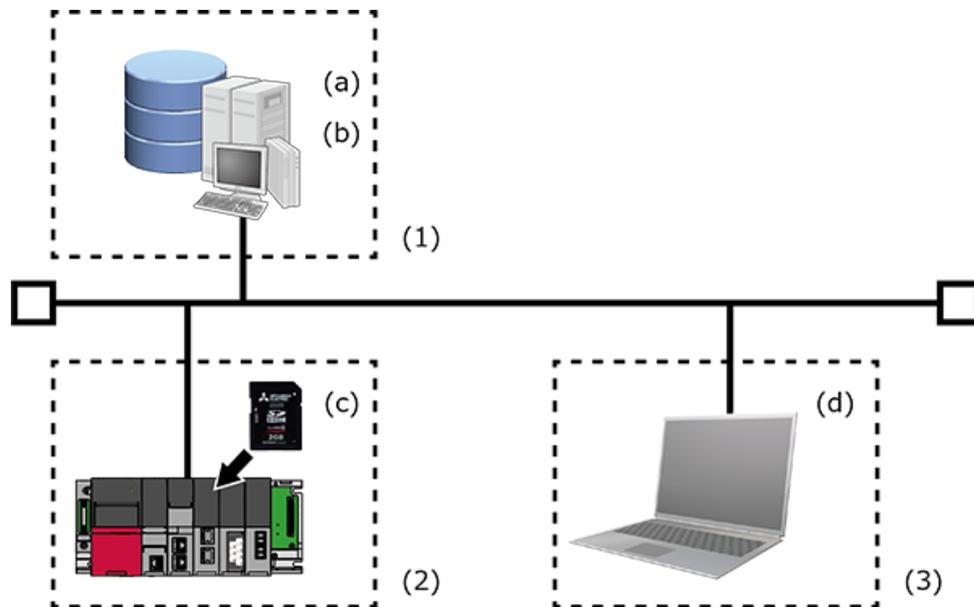


A continuación se muestra la configuración del sistema del módulo de interfaz MES.

En la configuración del sistema, hay un controlador programable que controla el servidor de base de datos y la máquina, y el módulo de interfaz MES está instalado en el controlador programable.

El servidor de base de datos y el módulo de interfaz MES están conectados a través de Ethernet.

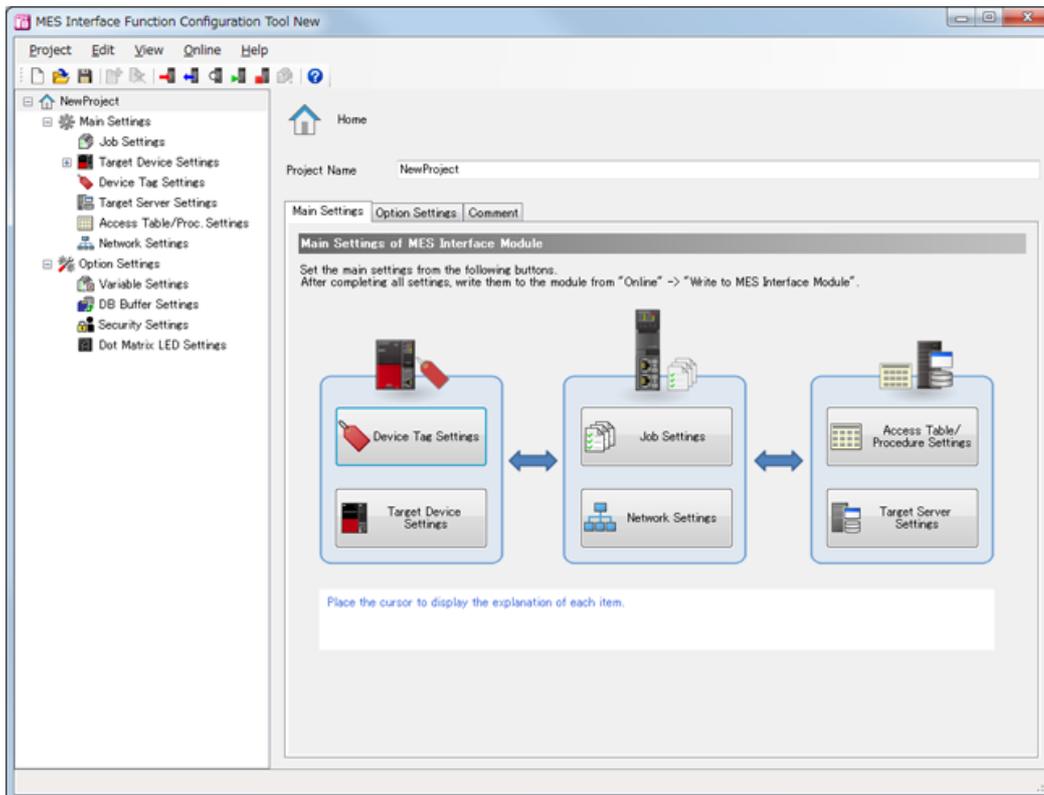
En este capítulo, se asume que se ha completado la instalación de la MES interface function configuration tool, el servicio de conexión con la base de datos y la herramienta de ajuste.



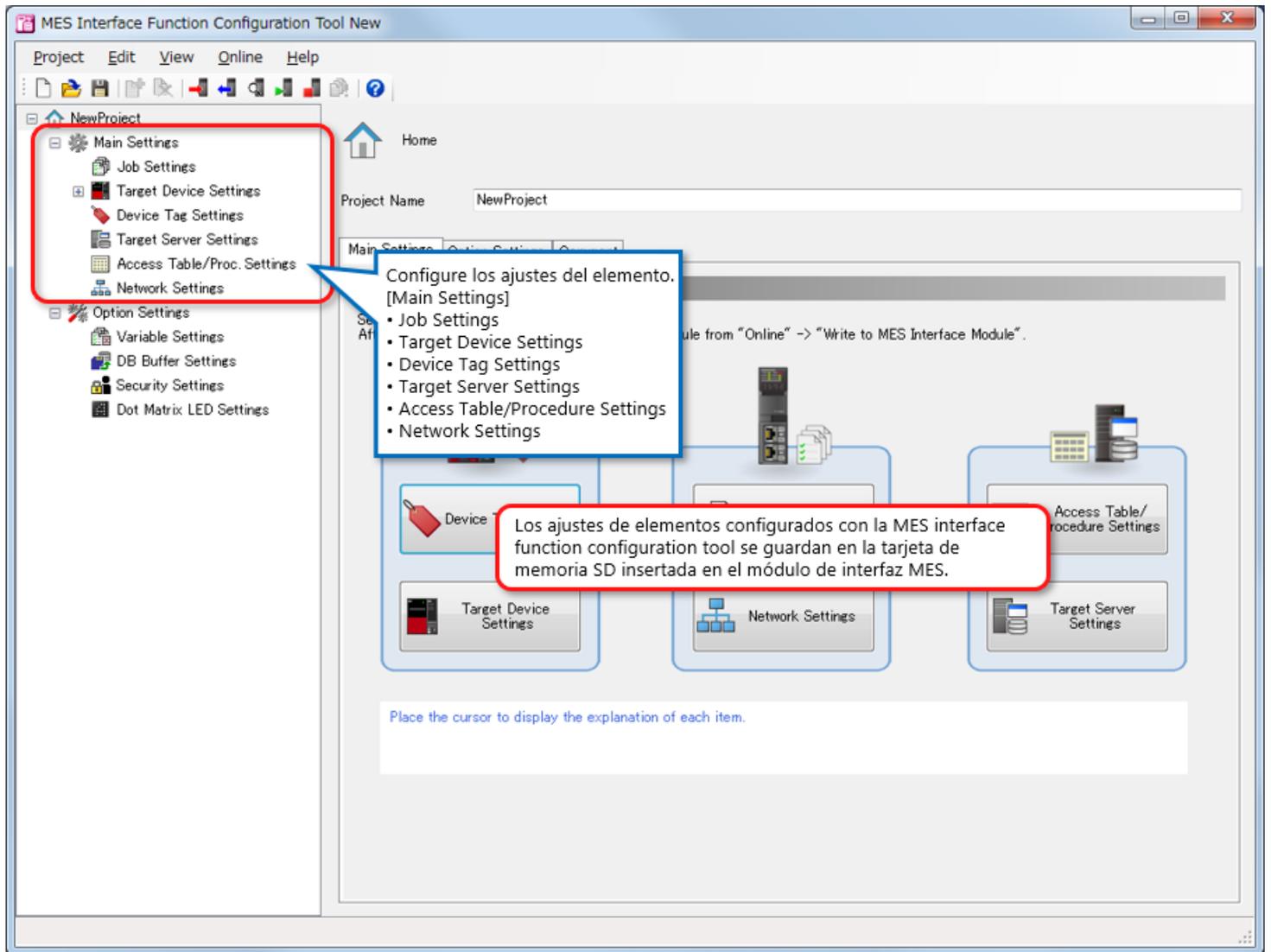
Configuración del sistema

(1)	Servidor de base de datos	(a)	<ul style="list-style-type: none"> • Servicio de conexión con base de datos • Herramienta de ajuste de servidor de conexión con base de datos
		(b)	<ul style="list-style-type: none"> • Microsoft Access
(2)	Módulo de interfaz MES	(c)	<ul style="list-style-type: none"> • Tarjeta de memoria SD (obligatorio)
(3)	Computadora personal para configuración	(d)	<ul style="list-style-type: none"> • MES interface function configuration tool

La MES interface function configuration tool es para configurar los ajustes del módulo de interfaz MES que se requieren para operarlo.



Cuando se inicia la herramienta de configuración de la función de interfaz MES, se muestra la siguiente ventana. En la ventana del lado izquierdo de la pantalla, los elementos a configurar se muestran como elementos principales bajo "NewProject".



Los ajustes usando la pantalla real se describen en la Sección 3.3. Cada elemento de ajuste se explica brevemente en la siguiente página.

A continuación se muestra "Job Settings" and "Network Settings" que se establecen en la MES interface function configuration tool.

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

Set the main settings from the following buttons.
After completing all set

<Job Settings>
Establecen el tiempo de inicio y el procesamiento (contenidos que se conectarán) de la conexión de información con la condición y acción de activación.

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

Target Server Settings

Place the cursor to display the explanation of each item.

<Network Settings>
Establecen los dos puertos Ethernet y el nombre de host común.

A continuación se muestra "Target Device Settings" y "Device Tag Settings" que se establecen en la MES interface function configuration tool.

<Device Tag Settings>
 Establecen el nombre lógico en la memoria de dispositivo de destino como el componente de la etiqueta del dispositivo.
 Además, el grupo de componentes de la etiqueta está establecido como la etiqueta del dispositivo. La etiqueta global y el comentario común del dispositivo establecido en el proyecto de la herramienta de ingeniería se pueden importar al componente de la etiqueta del dispositivo.

<Target Device Settings>
 Establecen el tipo de unidad, el n.º de CPU múltiple y la ruta de comunicación de red para el acceso desde el módulo de interfaz MES, etc.

3.3 Elementos de ajuste de la MES interface function configuration tool

A continuación se muestra "Target Server Settings" y "Access Table/Procedure Settings" que se establecen en la MES interface function configuration tool.

The screenshot displays the 'MES Interface Function Configuration Tool New' window. On the left is a tree view of settings categories: Main Settings, Job Settings, Target Device Settings, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area shows a 'Main Settings' tab with a diagram of interconnected settings boxes: Device Tag Settings, Target Device Settings, Job Settings, Network Settings, Access Table/Procedure Settings, and Target Server Settings. Two callout boxes provide instructions: one for 'Access Table/Procedure Settings' and another for 'Target Server Settings'. A text box at the bottom prompts the user to place the cursor over items for explanations.

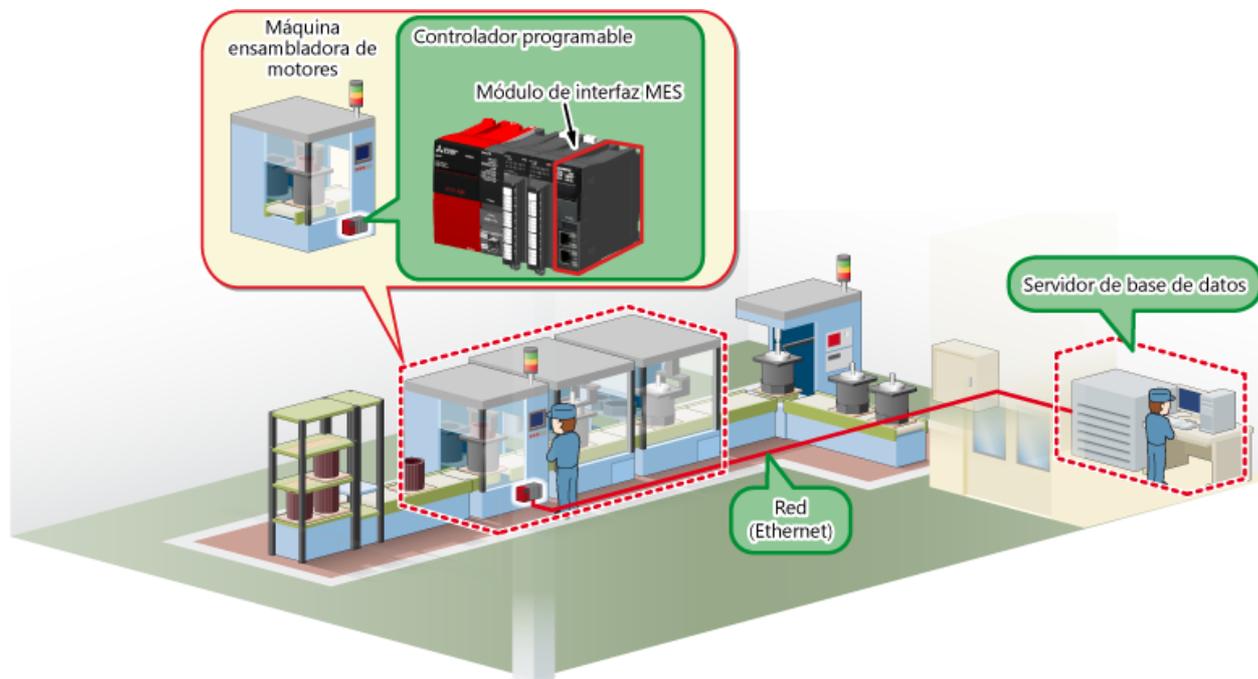
<Access Table/Procedure Settings>
Establecen el nombre lógico en los argumentos de procedimiento/tabla y procedimiento/campo de la base de datos.

<Target Server Settings>
Establecen el tipo de servidor, la información de la red y la información de la autenticación de usuario.

Place the cursor to display the explanation of each item.

Ahora que entiende los elementos principales, configuremos los detalles.
Se explica la operación del equipo de fabricación establecido en esta ocasión.

La máquina ensambladora de motores se utiliza como ejemplo para la configuración de los ajustes.



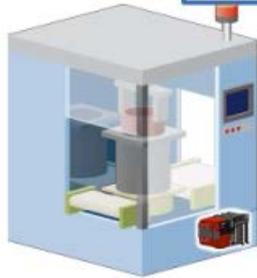
El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

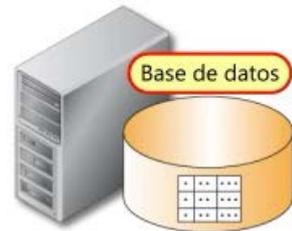
Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.

Haga clic en el botón Reproducir.



Máquina de fabricación



Servidor de base de datos

Siguiente

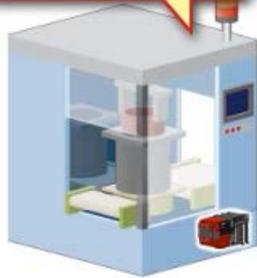
El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

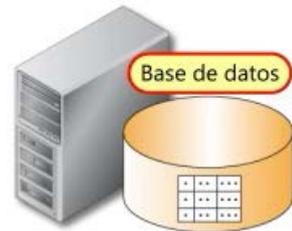
Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.

Solicitud del valor estándar del patrón 2



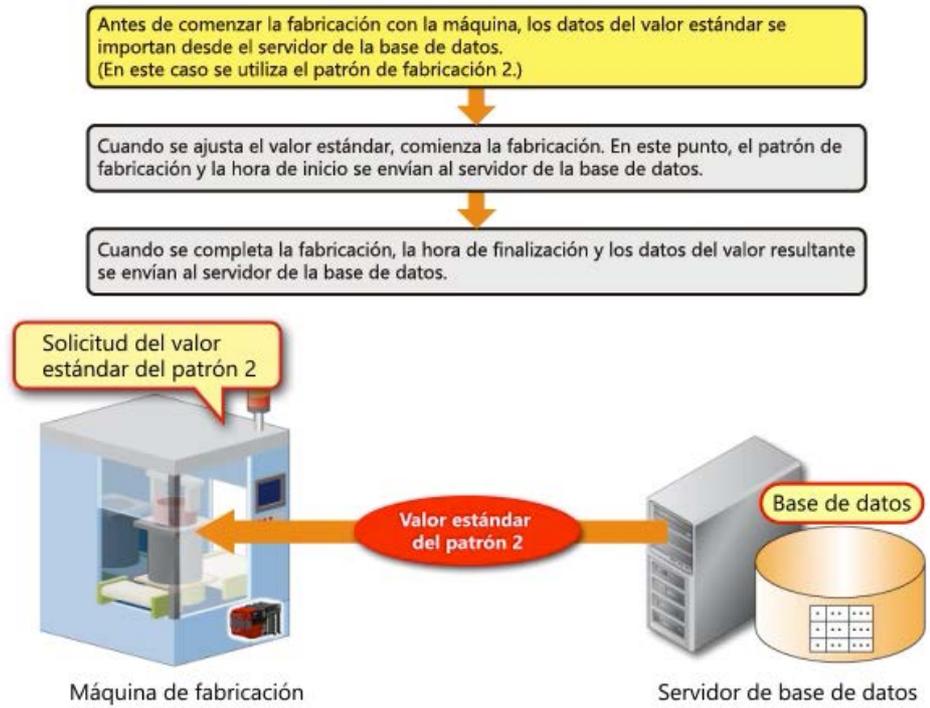
Máquina de fabricación



Servidor de base de datos

Siguiente

El equipo de fabricación opera como se muestra a continuación.



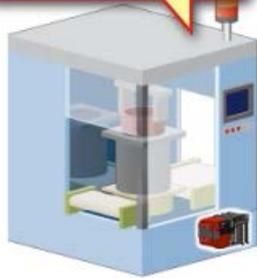
El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

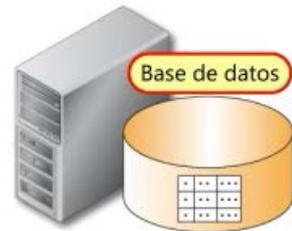
Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.

Iniciar fabricación



Máquina de fabricación



Servidor de base de datos

Siguiente

El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.



Siguiente

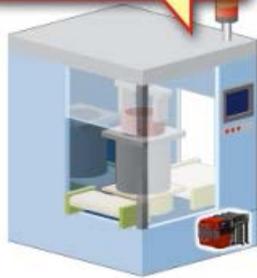
El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

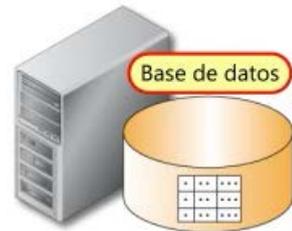
Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.

Finalizar fabricación



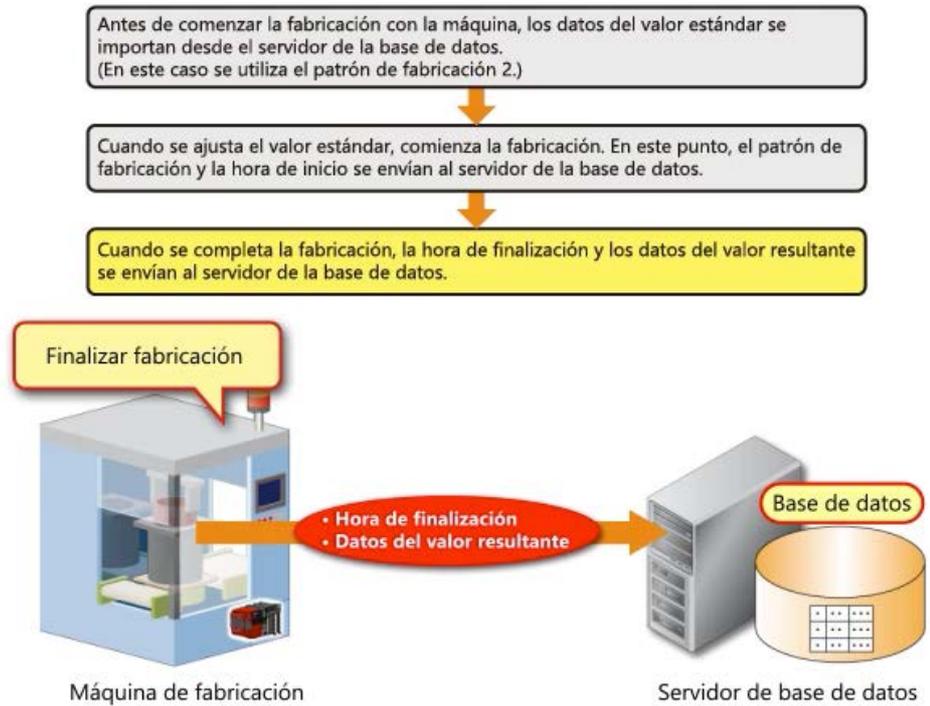
Máquina de fabricación



Servidor de base de datos

Siguiente

El equipo de fabricación opera como se muestra a continuación.



Siguiente

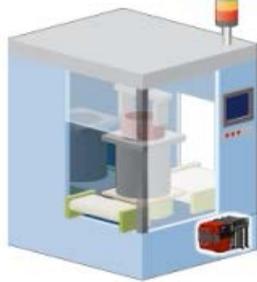
El equipo de fabricación opera como se muestra a continuación.

Antes de comenzar la fabricación con la máquina, los datos del valor estándar se importan desde el servidor de la base de datos.
(En este caso se utiliza el patrón de fabricación 2.)

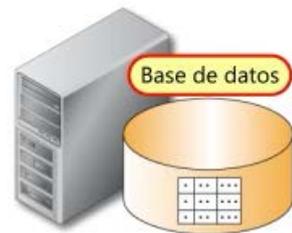
Cuando se ajusta el valor estándar, comienza la fabricación. En este punto, el patrón de fabricación y la hora de inicio se envían al servidor de la base de datos.

Cuando se completa la fabricación, la hora de finalización y los datos del valor resultante se envían al servidor de la base de datos.

Haga clic en



Máquina de fabricación



Servidor de base de datos

Siguiente

En este curso, se utiliza Access 2016 como base de datos.

Se asume que las dos tablas siguientes, ParamTable y ResultTable, se preparan en el servidor de base de datos.

Los valores estándar (parámetros) del equipo que se utilizará para la fabricación se registran en ParamTable con anticipación. Hay tres campos en la tabla:

- N.º de patrón (PatterNo)
- Carga del ajuste a presión (Load)
- Altura del ajuste a presión (Height)

El controlador programable controla la máquina de acuerdo con la carga y la altura del ajuste a presión.

<Nombre de la tabla: ParamTable>

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

ResultTable se utiliza para almacenar datos de resultados después de que se completa la fabricación.

Hay cinco campos en la tabla:

- N.º de patrón fabricado (PatternNo)
- Valor resultante de la carga del ajuste a presión (LoadResult)
- Valor resultante de la altura del ajuste a presión (HeightResult)
- Hora de inicio de fabricación (StartTime)
- Hora de finalización de fabricación (EndTime)

Cree un registro y establezca PatternNo y StartTime cuando se inicie el ensamblaje de motores. Establezca los datos en los campos restantes después de finalizado el ensamblaje.

<Nombre de la tabla: ResultTable>

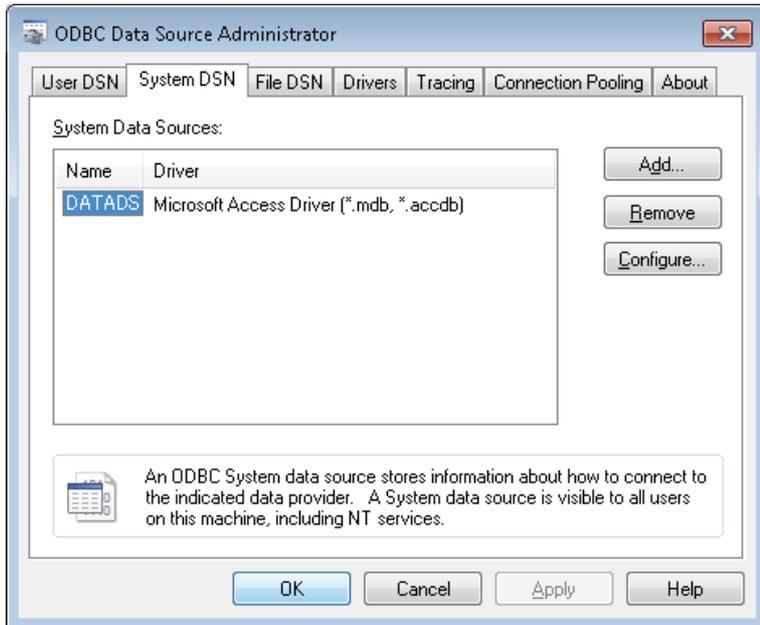
PatternNo	LoadResult	HeightResult	StartTime	EndTime

El módulo de interfaz MES accede a la base de datos a través del sistema ODBC.

Para utilizar la función de ODBC, es necesario establecer el tipo de base de datos, el nombre de la fuente de datos y el nombre de la base de datos que se utilizarán en el ajuste de ODBC de Windows.

El nombre de la fuente de datos se utiliza en el ajuste del servidor de destino de la MES interface function configuration tool.

En este curso, se asume que el ajuste de ODBC se completa con anticipación.



<Mapa de dispositivos del módulo de CPU>

A continuación se muestran las listas de las memorias del dispositivo que se utilizan en este ajuste.

<Dispositivo de bit>

Memoria del dispositivo	Significado de la memoria del dispositivo
M0	Fabricación lista
M1	Iniciar fabricación
M2	Fabricación completa

<Dispositivo de Word>

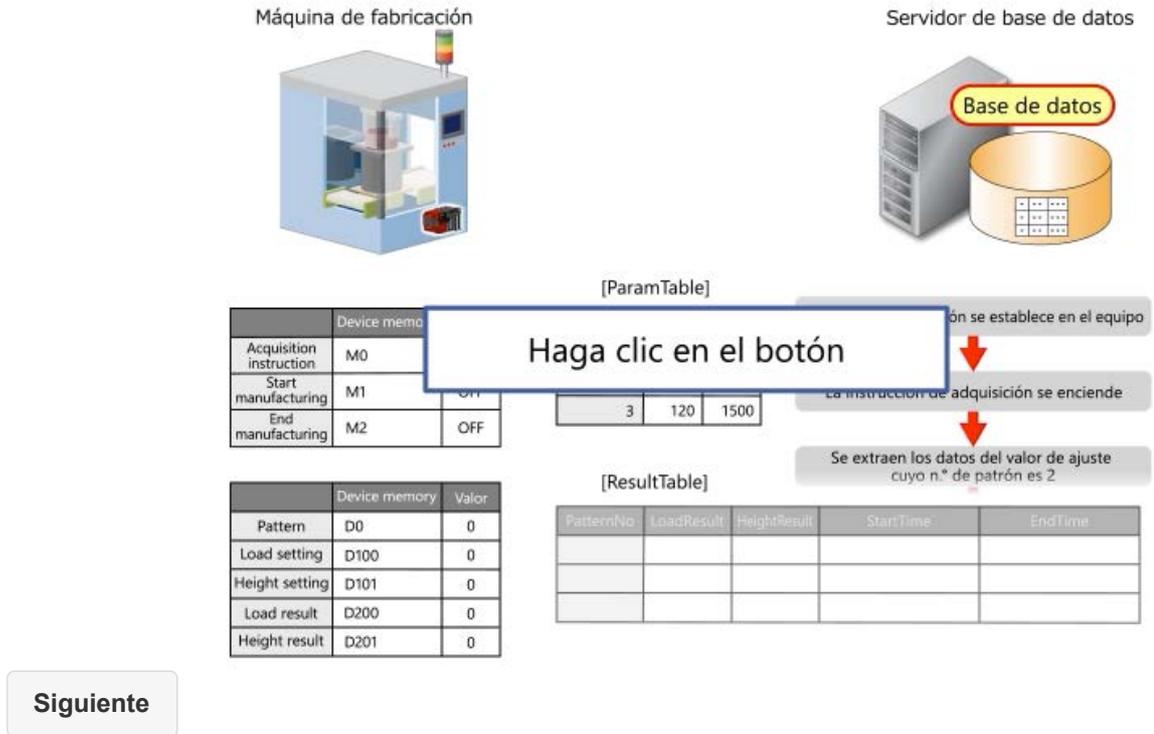
Memoria del dispositivo	Significado de la memoria del dispositivo
D0	N.º de patrón
D100	Valor de ajuste de la carga del ajuste a presión
D101	Valor de ajuste de la altura del ajuste a presión
D200	Valor resultante de la carga del ajuste a presión
D201	Valor resultante de la altura del ajuste a presión

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>



3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>

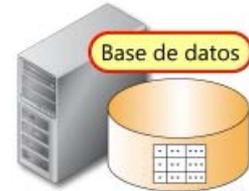
Máquina de fabricación



	Device memory	Valor
Acquisition instruction	M0	OFF
Start manufacturing	M1	OFF
End manufacturing	M2	OFF

	Device memory	Valor
Pattern	D0	2
Load setting	D100	0
Height setting	D101	0
Load result	D200	0
Height result	D201	0

Servidor de base de datos



[ParamTable]

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

[ResultTable]

PatternNo	LoadResult	HeightResult	StartTime	EndTime

El patrón de fabricación se establece en el equipo

La instrucción de adquisición se enciende

Se extraen los datos del valor de ajuste cuyo n.º de patrón es 2

Siguiente

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

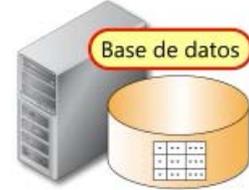
<Proceso de datos>

Máquina de fabricación



Solicitud del valor estándar del patrón 2

Servidor de base de datos

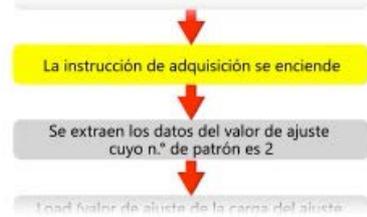


Base de datos

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

[ParamTable]

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



	Device memory	Valor
Pattern	D0	2
Load setting	D100	0
Height setting	D101	0
Load result	D200	0
Height result	D201	0

[ResultTable]

PatternNo	LoadResult	HeightResult	StartTime	EndTime

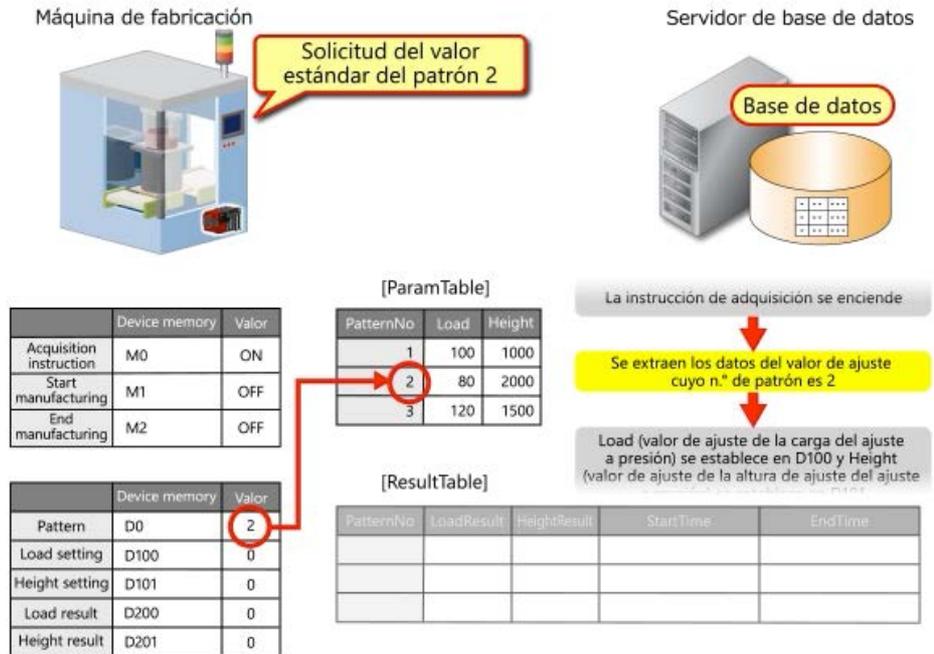
Siguiente

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>



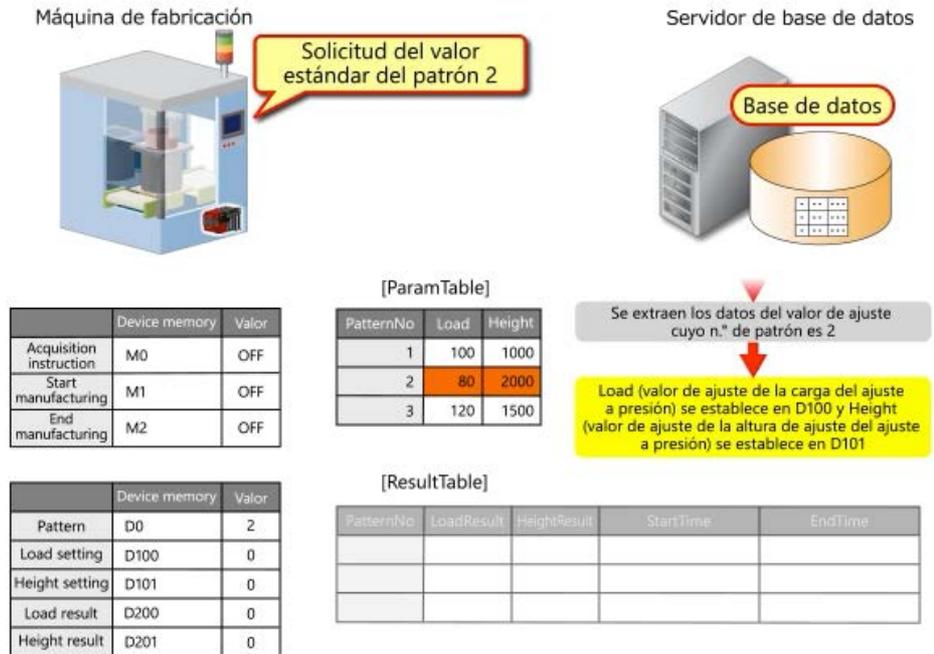
Siguiente

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>



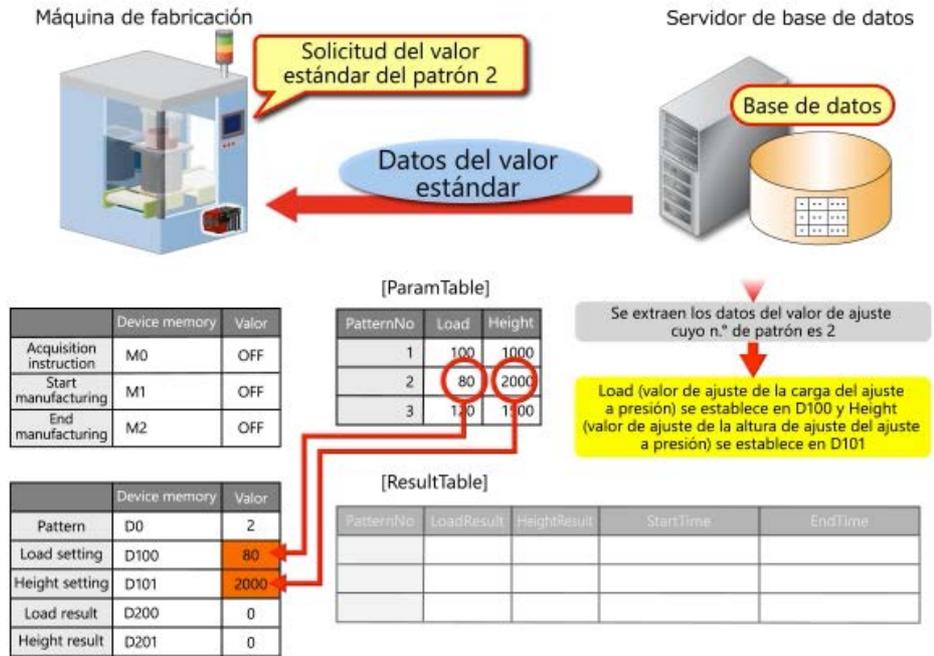
Siguiente

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>



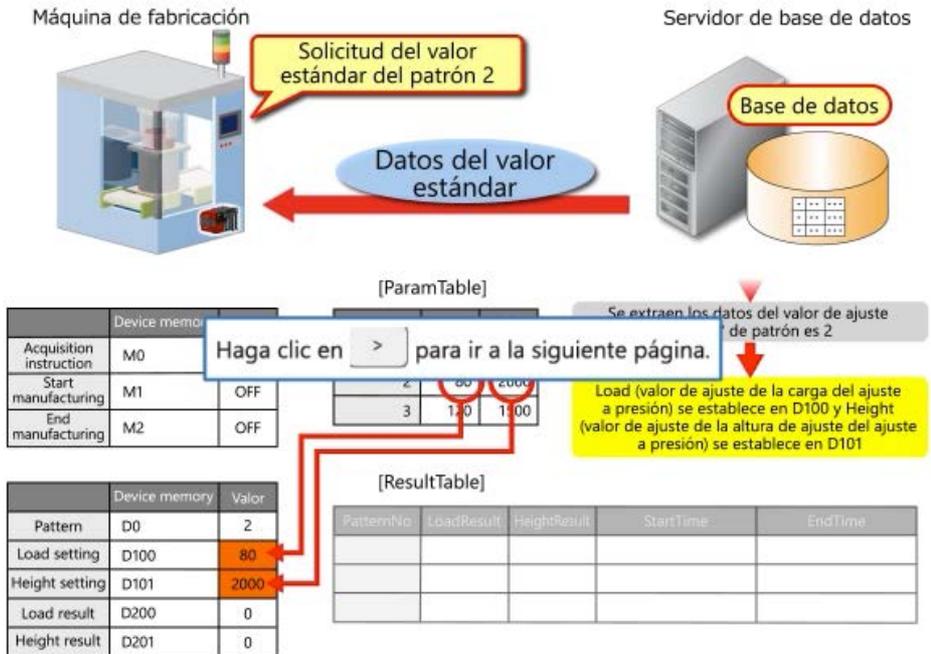
Siguiente

3.4 Ajuste con la MES interface function configuration tool (Adquisición de datos)

<Proceso de adquisición de datos de la base de datos>

Cuando la instrucción de adquisición (M0) se enciende mientras el patrón de fabricación (D0 = 2) está establecido en el equipo, el módulo de interfaz MES extrae los datos del valor de ajuste de PatternNo = 2 en ParamTable, Load (valor de ajuste de la carga del ajuste a presión) establecido en D100 y Height (valor de ajuste de la altura del ajuste a presión) establecido en D101.

<Proceso de datos>

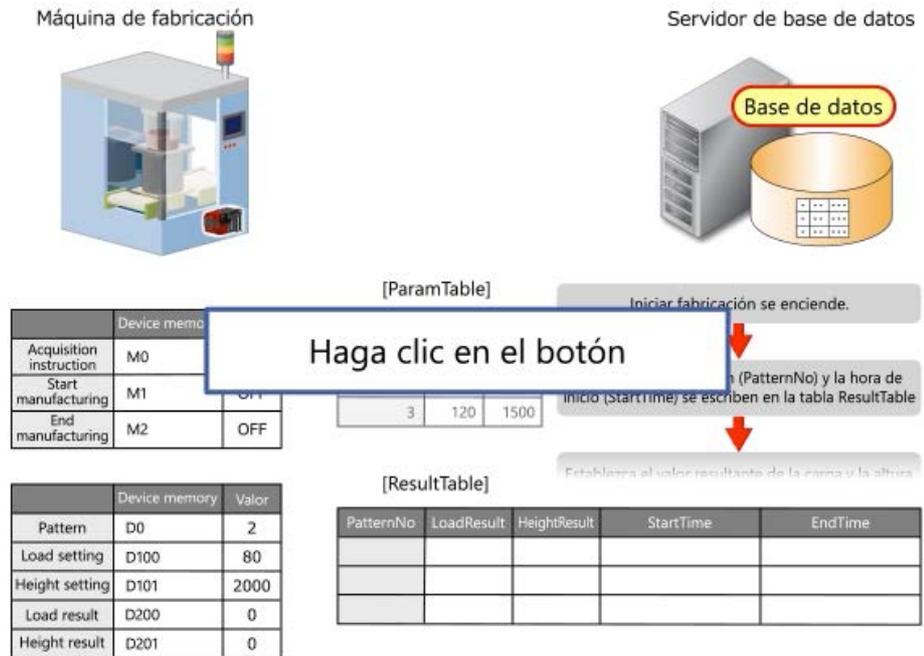


Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
 - 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).
- * Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>



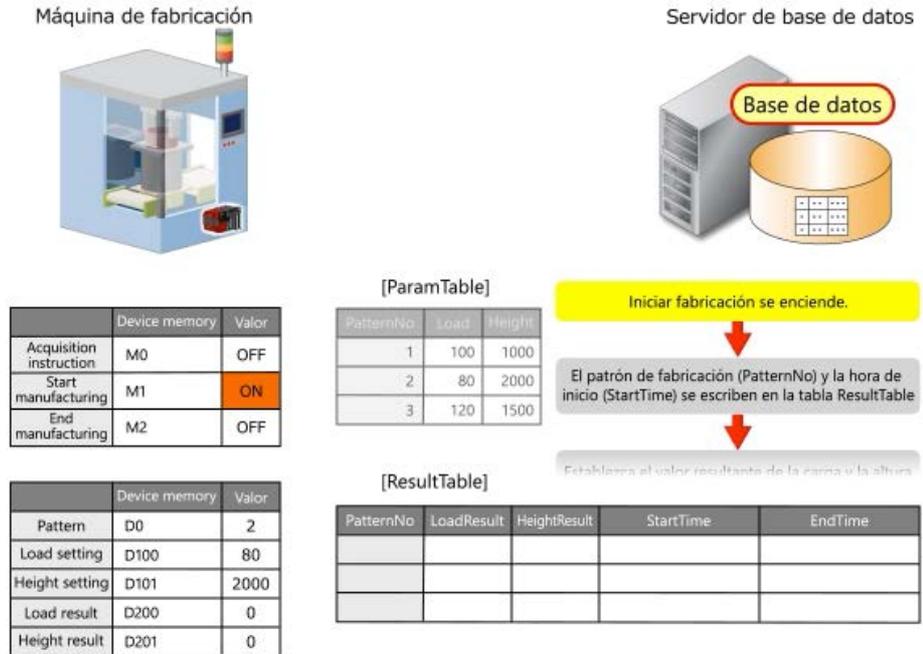
Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
- 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).

* Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>



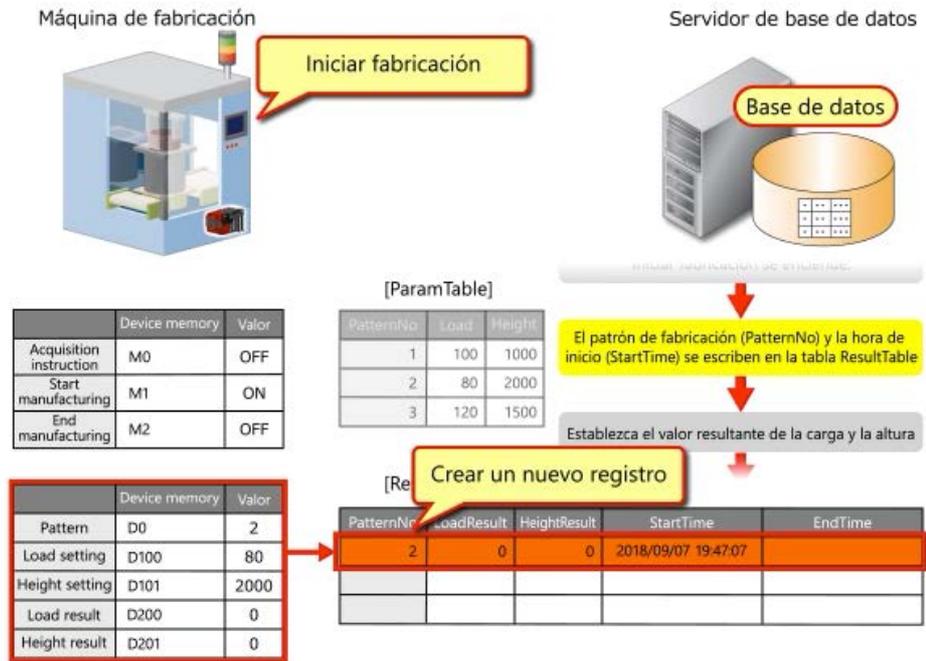
Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
- 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).

* Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>



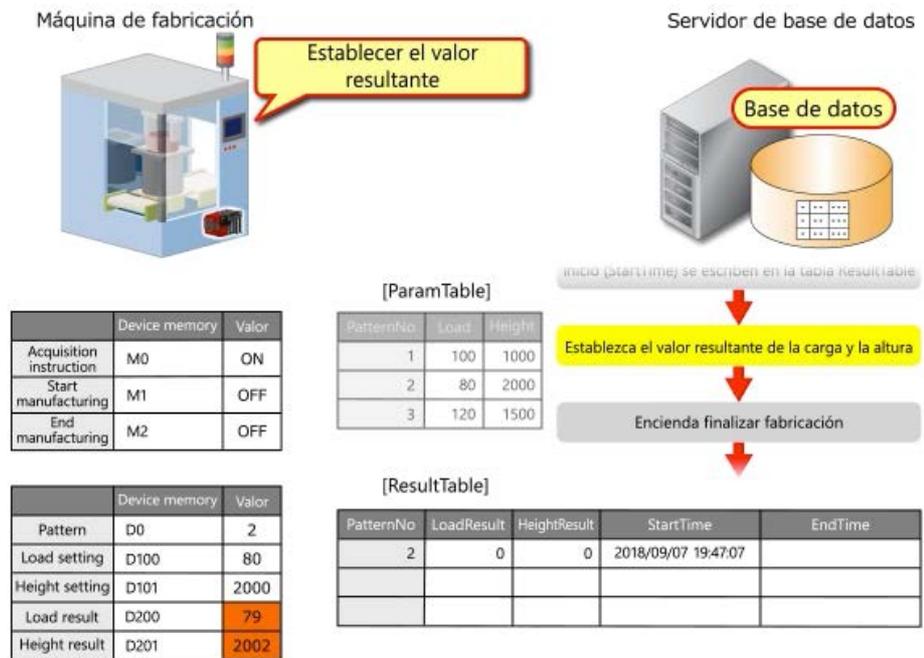
Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
- 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).

* Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>

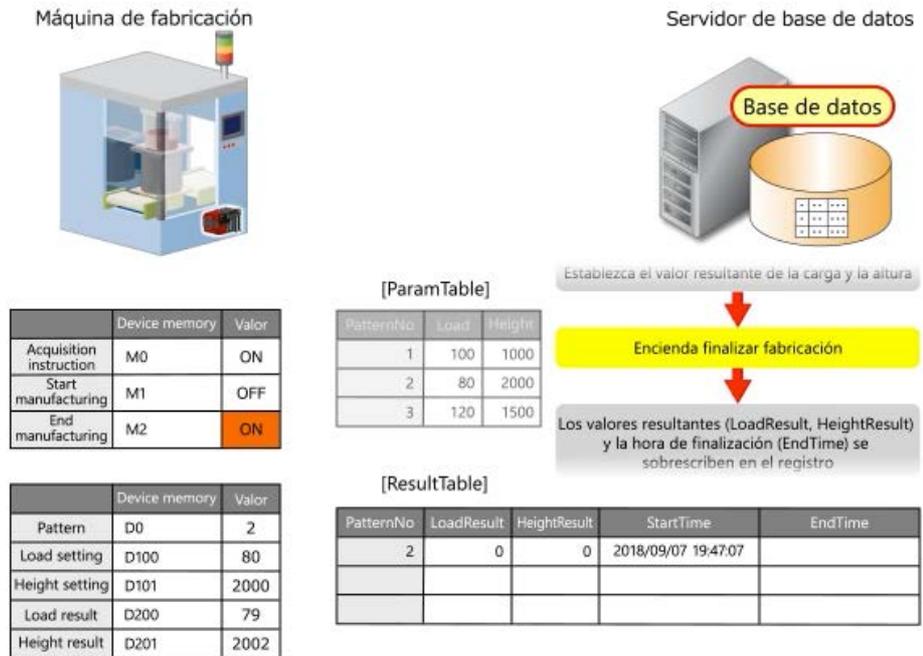


Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
 - 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).
- * Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>



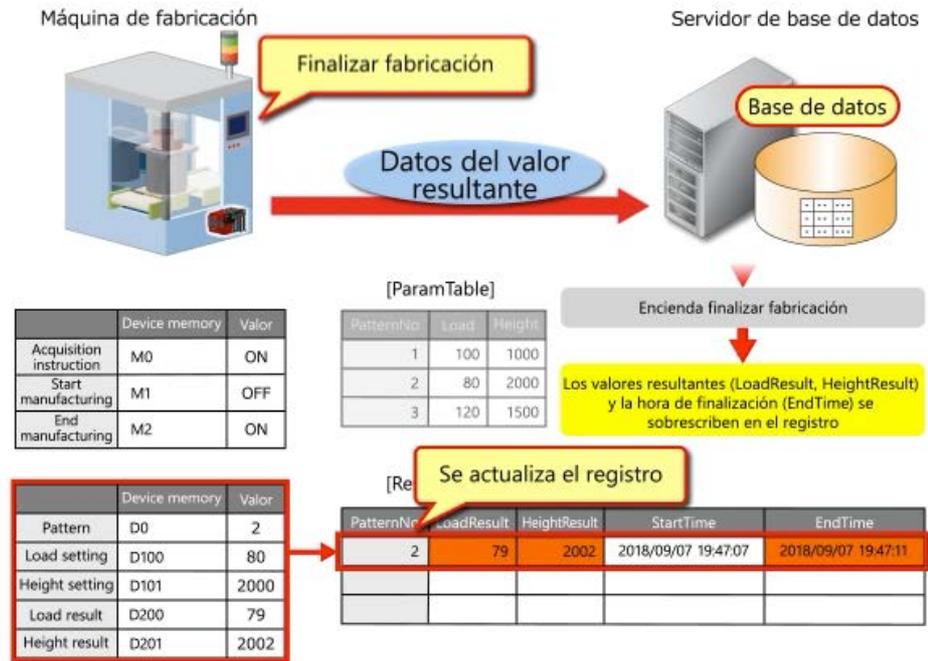
Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
- 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).

* Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>

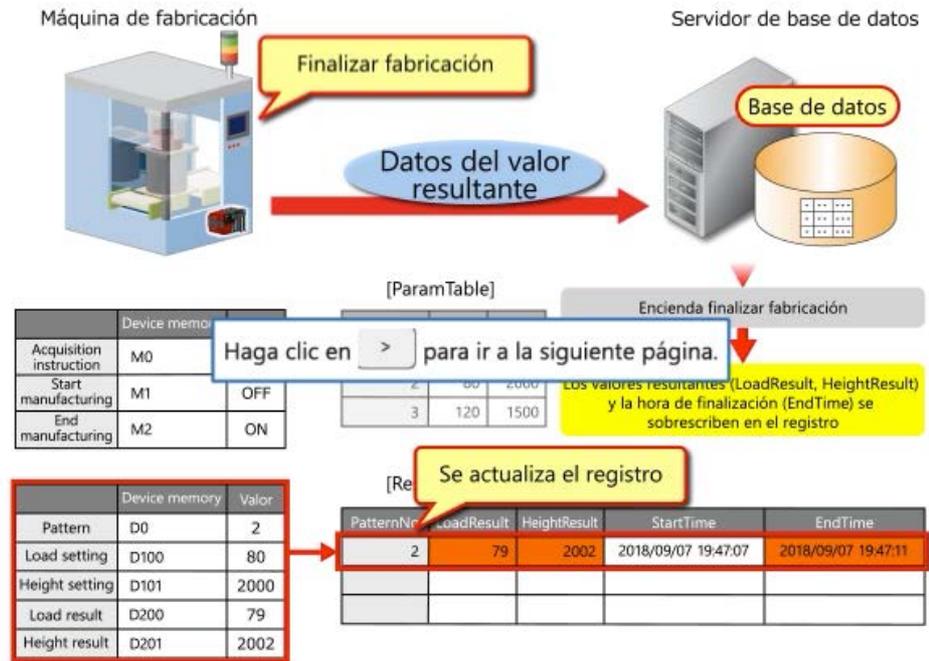


Siguiente

<Proceso de ajuste de datos del controlador programable en la base de datos>

- 1) Al iniciar la fabricación (M1 = ON), escriba el patrón de fabricación (PatternNo) y la hora de inicio (StartTime) en ResultTable.
 - 2) Cuando la fabricación finaliza (M2 = ON), los registros de 1) se sobrescriben con los valores resultantes (LoadResult y HeightResult) y la hora de finalización (EndTime).
- * Para la hora se utilizan los datos horarios del módulo de interfaz MES.

<Proceso de datos>



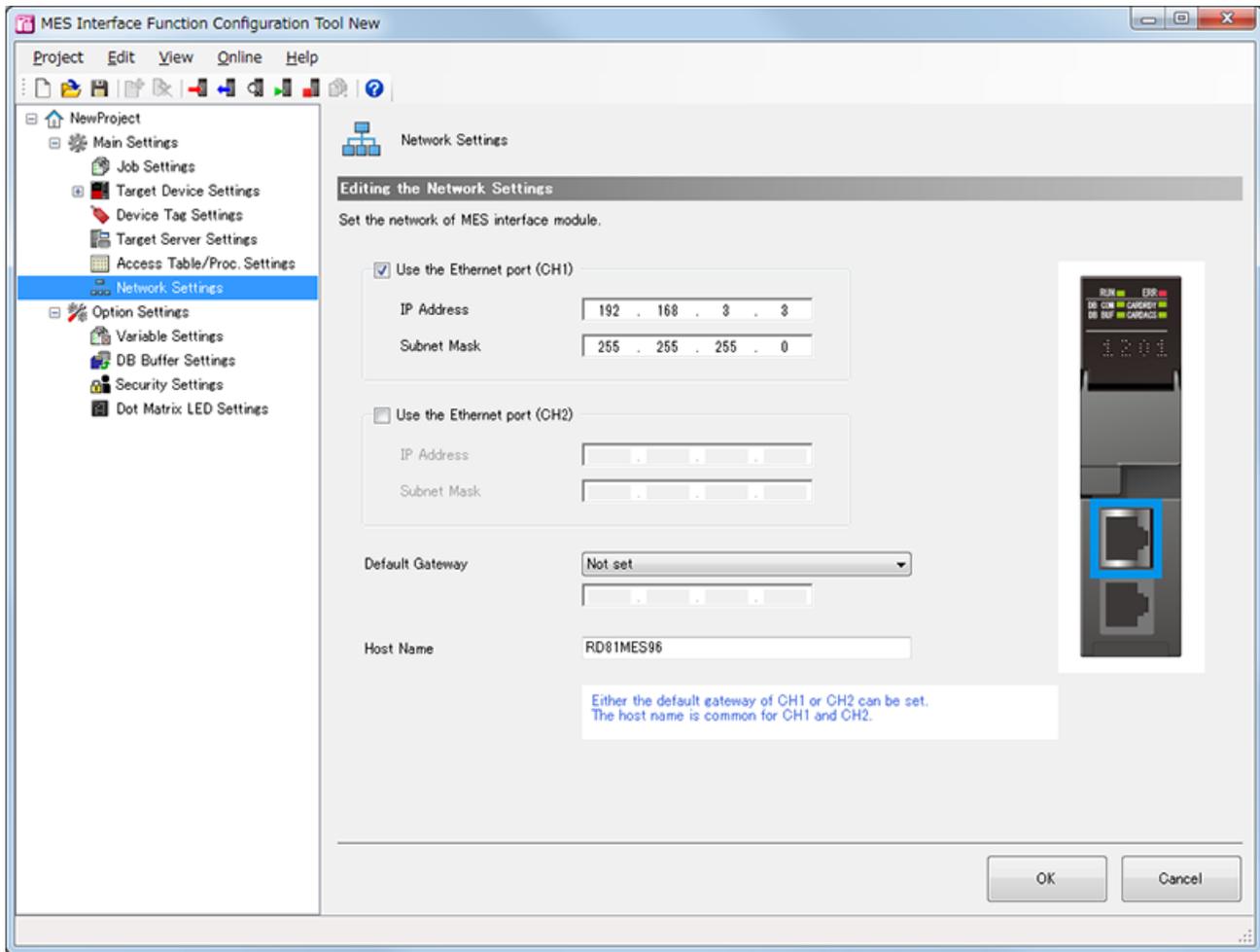
Siguiete

<Ajustes del módulo de interfaz MES>

Configure los ajustes para extraer los datos de la base de datos y escribirlos en la memoria del dispositivo del módulo de CPU. A continuación se describen los ajustes necesarios en la MES interface function configuration tool.

[Network Settings]

En este curso se utiliza el ajuste predeterminado.



Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' application window. On the left is a tree view menu with categories like 'Main Settings', 'Job Settings', 'Device Tag Settings', 'Target Device Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The 'Main Settings' category is selected. The main workspace has a 'Project Name' field containing 'NewProject'. A central box contains the text 'Haga clic en el botón Reproducir.' and instructions: 'Set the main settings from the following buttons. After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".' Below this is a diagram with three main boxes connected by double-headed arrows. The first box contains 'Device Tag Settings' and 'Target Device Settings'. The second box contains 'Job Settings' and 'Network Settings'. The third box contains 'Access Table/Procedure Settings' and 'Target Server Settings'. At the bottom, there is a text box with the instruction: 'Place the cursor to display the explanation of each item.'

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Home

Project Name: NewProject

Main Settings | Option Settings | Comment

Main Settings of MES Interface Module

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

Diagram showing settings boxes: Device Tag Settings, Target Device Settings, Job Settings, Network Settings, Access Table/Procedure Settings, Target Server Settings.

Haga clic en **Network Settings.**

...ess of Ethernet port of MES interface module.

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Network Settings

Editing the Network Settings

Set the network of MES interface module.

Use the Ethernet port (CH1)

IP Address: 192 . 168 . 3 . 3

Subnet Mask: 255 . 255 . 255 . 0

Use the Ethernet port (CH2)

Default Gateway: Not set

Host Name: RD81MES96

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

OK Cancel

No se cambia ningún ajuste del ajuste predeterminado.

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar lists various settings categories, with 'Network Settings' selected. The main area is titled 'Editing the Network Settings' and contains the following fields:

- Use the Ethernet port (CH1):
 - IP Address: 192 . 168 . 3 . 3
 - Subnet Mask: 255 . 255 . 255 . 0
- Use the Ethernet port (CH2):
 - IP Address: [empty]
 - Subnet Mask: [empty]
- Default Gateway: Not set (dropdown menu)
- Host Name: RD81MES96

Below the fields, a note states: 'Either the default gateway of CH1 or CH2 can be set. The host name is common for CH1 and CH2.' At the bottom right, there are 'OK' and 'Cancel' buttons. A red box highlights the 'OK' button, and a callout bubble points to it with the text 'Haga clic en el botón OK.' To the right of the configuration area is a vertical image of a device with a blue square highlighting the top Ethernet port.

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar lists various settings categories, with 'Main Settings' selected. The main area displays 'Main Settings of MES Interface Module' with instructions to set main settings from buttons and write them to the module. A diagram shows three interconnected boxes: the first contains 'Device Tag Settings' and 'Target Device Settings'; the second contains 'Job Settings' and 'Network Settings'; the third contains 'Access Table/ Procedure Settings' and 'Target Server Settings'. A text box at the bottom right states: 'Se completó el ajuste de red. Haga clic en > para ir a la siguiente página.'

3.4 Ajuste con la MES interface function configuration tool (Target Device Settings)

[Target Device Settings]

En este curso se utiliza el ajuste predeterminado.

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

Network No.

Station No.

Global Label/Common Device Comment Settings (optional)

Use the global label/common device comment

Global Label/Common Device Comment Import Source Setting

Communication Test

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' application window. On the left is a tree view of settings categories: Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area features a 'Project Name' field with 'NewProject' entered. A central diagram illustrates a three-step configuration process: 1. Device Tag Settings and Target Device Settings; 2. Job Settings and Network Settings; 3. Access Table/Procedure Settings and Target Server Settings. A text box above the diagram says 'Haga clic en el botón Reproducir.' and another below says 'Place the cursor to display the explanation of each item.'

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' application window. On the left is a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', 'ControlCPU', 'Device Tag Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The 'Target Device Settings' item is selected. The main area displays 'Main Settings of MES Interface Module' with a 'Project Name' field set to 'NewProject'. Below this are three tabs: 'Main Settings', 'Option Settings', and 'Comment'. The 'Main Settings' tab contains a diagram of three interconnected boxes. The left box contains 'Device Tag Settings' and 'Target Device Settings' (highlighted with a red border). The middle box contains 'Job Settings' and 'Network Settings'. The right box contains 'Access Table/Procedure Settings' and 'Target Server Settings'. Double-headed arrows connect the boxes. A callout bubble points to the 'Target Device Settings' button with the text 'Haga clic en Target Device Settings.'

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with 'Target Device Settings' selected. The main area displays the 'Target Device Setting List' table. A callout box points to the first row of the table, containing the following text:

En este ajuste, se utiliza la información del dispositivo del módulo de CPU de PLC en el que está instalado el módulo de interfaz MES. Haga clic derecho en **ControlCPU** desde **Target Device Settings List**.

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Target Device Setting List

Home

Adding/Editing the Target Device Settings

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

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

Edit Delete Add Co Comm

Haga clic en Edit desde el menú.

Edit Delete

↑ ↓

Anterior

Siguiente

The screenshot shows the 'Target Device Setting No.[1]' dialog box. At the top, the 'Target Device Name' is 'ControlCPU'. Below this, the 'Target Device Settings' section includes a 'Device Type' dropdown set to 'MELSEC (RCPU)' and a 'Multiple CPU Setting' dropdown set to 'No Specification'. The 'Network Communication Route' is set to 'Co-Existence Network Route'. A checkbox for 'Set the network communication route to a device existing over a single network.' is unchecked. The 'Source System Settings' section has 'Module Type' as 'CC-Link IE Controller Network Module' and 'Route' as 'Direct access to Ethernet Port'. The 'Target (Relay Station) System Settings' section lists four options: 'CC-Link IE Controller Network Module', 'CC-Link IE Field Network Module', 'MELSECNET/H Network Module', and 'Ethernet Interface Module'. A central text box contains the instruction: 'No se cambia ningún ajuste predeterminado. Al conectar la información de otras estaciones PLC con la base de datos a través de una red, agregue el ajuste del dispositivo de destino.' Below this is a small image of a PLC rack. At the bottom, there is a 'Global Label/Common Device Comment Settings (optional)' section with an unchecked checkbox and a text field. The 'Communication Test' button is on the left, and 'OK' and 'Cancel' buttons are on the right.

3.4 Ajuste con la MES interface function configuration tool (Target Device Settings)

Anterior

Siguiente

Target Device Name Comment

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

Device Type Multiple CPU Setting

Network Communication Route

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

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

Module Type Module Type

Route

Network No.

Station No.

Global Label/Common Device Comment Settings (optional)

Use the global label/common device comment

Global Label/Common Device Comment Import Source Setting

Communication Test

Haga clic en el botón **OK**.

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with categories like 'NewProject', 'Main Settings', 'Job Settings', 'Target Device Settings', 'ControlCPU', 'Device Tag Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The main area is titled 'Target Device Setting List' and includes a 'Home' button. Below the title is a section 'Adding/Editing the Target Device Settings' with instructions: 'When adding a target device setting, select a blank line and click the "Edit" button. When editing the existing target device setting, select the applicable line and click the "Edit" button.' A table with 5 columns is displayed: 'No.', 'Target Device Name', 'Comment', 'Device Type', and 'Multiple CPU Setting'. The first row is highlighted in blue and contains the values: '1', 'ControlCPU', an empty cell, 'MELSEC (RCPU)', and 'No Specification'. Below the table are 'Edit' and 'Delete' buttons. A text box at the bottom right of the window contains the text: 'Los ajustes del dispositivo de destino se completaron. Haga clic en > para ir a la siguiente página.'

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

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

[Device Tag Settings]

Configure el ajuste que extrae los datos de la base de datos y los escribe en la memoria del dispositivo del módulo de CPU como "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 Name: GettingData

Comment:

Device Tag Settings

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

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

Delete

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 4

Configure el ajuste que escribe los datos en la memoria del dispositivo del módulo de CPU en la base de datos como "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: Comment:

Device Tag Settings

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 9

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help), a toolbar, and a left-hand navigation tree under 'NewProject' with categories like Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area features a 'Home' button, a 'Project Name' field containing 'NewProject', and a large central box with the text 'Haga clic en el botón Reproducir.' (Click on the Play button). Below this text, there is a diagram showing three interconnected boxes representing configuration modules: 'Device Tag Settings' (containing 'Device Tag Settings' and 'Target Device Settings'), 'Job Settings' (containing 'Job Settings' and 'Network Settings'), and 'Access Table/Procedure Settings' (containing 'Access Table/Procedure Settings' and 'Target Server Settings'). A note below the diagram reads: 'Set the main settings from the following buttons. After completing all settings, write them to the module from "Online" -> "Write to MES Interface Module".' At the bottom, there is a text box with the instruction: 'Place the cursor to display the explanation of each item.'

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

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

Device Tag Settings

Job Settings

Access Table/
Procedure Settings

Target Server
Settings

Haga clic en Device Tag Settings.

Place the cursor to display the explanation of each item.

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with 'Device Tag Settings' selected. The main area is titled 'Device Tag Setting List' and contains a table with the following columns: 'No.', 'Device Tag Name', 'Comment', 'Data Writing', and 'Array Size'. The first row (No. 1) is highlighted in red. A callout box points to this row with the text: 'Haga clic derecho en la fila no. 1 en la device tag setting list.' Below the table are 'Edit' and 'Delete' buttons, and a status bar at the bottom right shows '[Device Tag Components in the Project] 0'.

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

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with 'Device Tag Settings' selected. The main area is titled 'Device Tag Setting List' and contains a table with the following columns: 'No.', 'Device Tag Name', 'Comment', 'Data Writing', and 'Array Size'. The table has 21 rows, with row 1 selected. A context menu is open over row 1, showing 'Edit', 'Delete', and 'Add' options. A callout box points to the 'Edit' option with the text: 'Seleccione Editar para crear una nueva etiqueta del dispositivo. Haga clic en **Edit** desde el menú.' Below the table are 'Edit' and 'Delete' buttons, and a status bar at the bottom right shows '[Device Tag Components in the Project] 0'.

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Device Tag Setting List

Home

Adding/Editing the Device Tag Settings

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

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

Edit Delete Add

Seleccione Editar para crear una nueva etiqueta del dispositivo.
Haga clic en **Edit** desde el menú.

Edit Delete

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: Comment:

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

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

Delete

Data Write-Protect Setting (optional) Protect data writing

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

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: GettingData

Comment:

Device Tag Settings

Set the device tag as the job. Further, set a component name.

Ingrese "GettingData" en el campo de entrada de Device Tag Name.

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

Delete

Up

Down

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

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

Array Tag Setting: Change

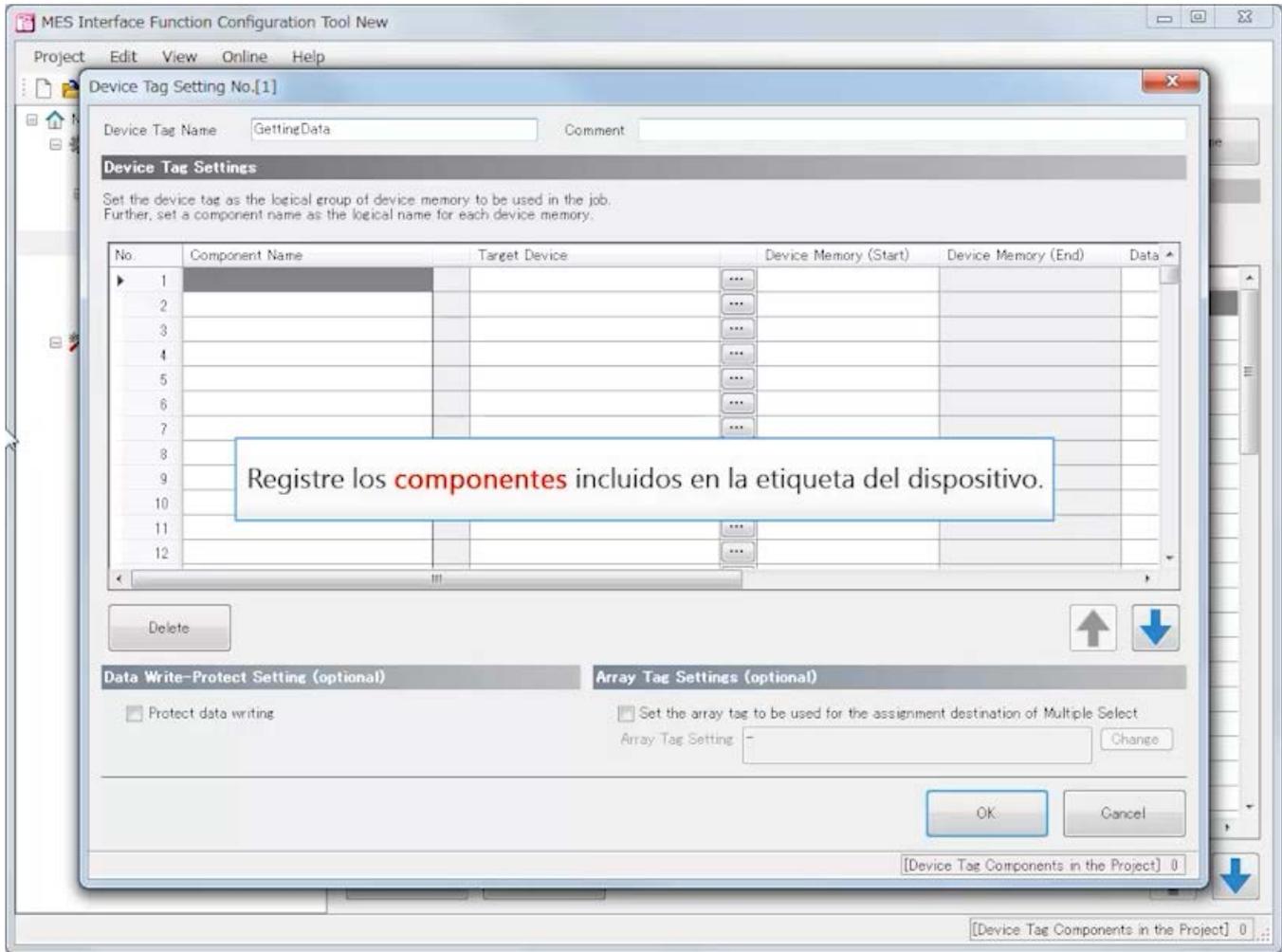
OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

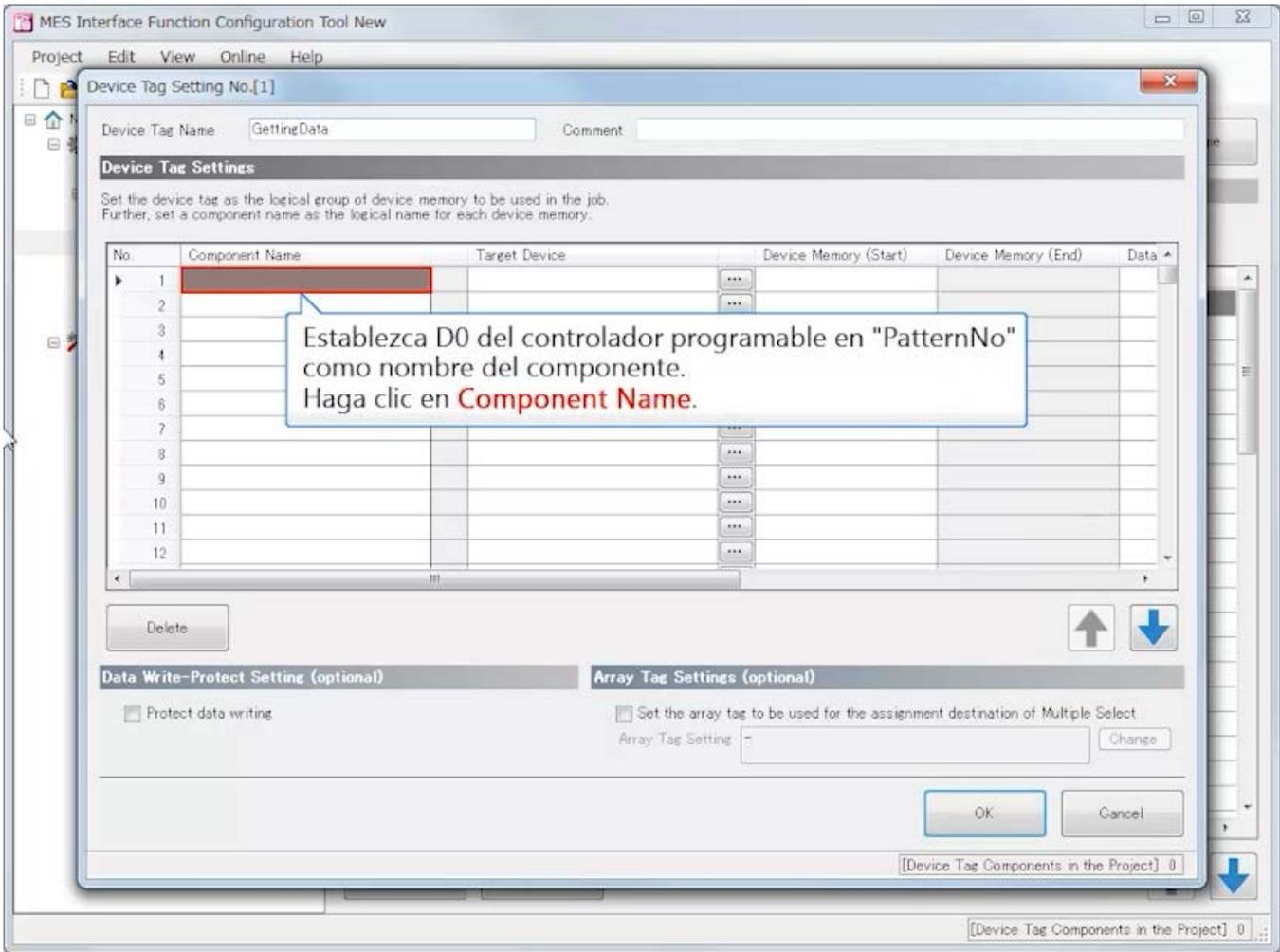
Anterior

Siguiente



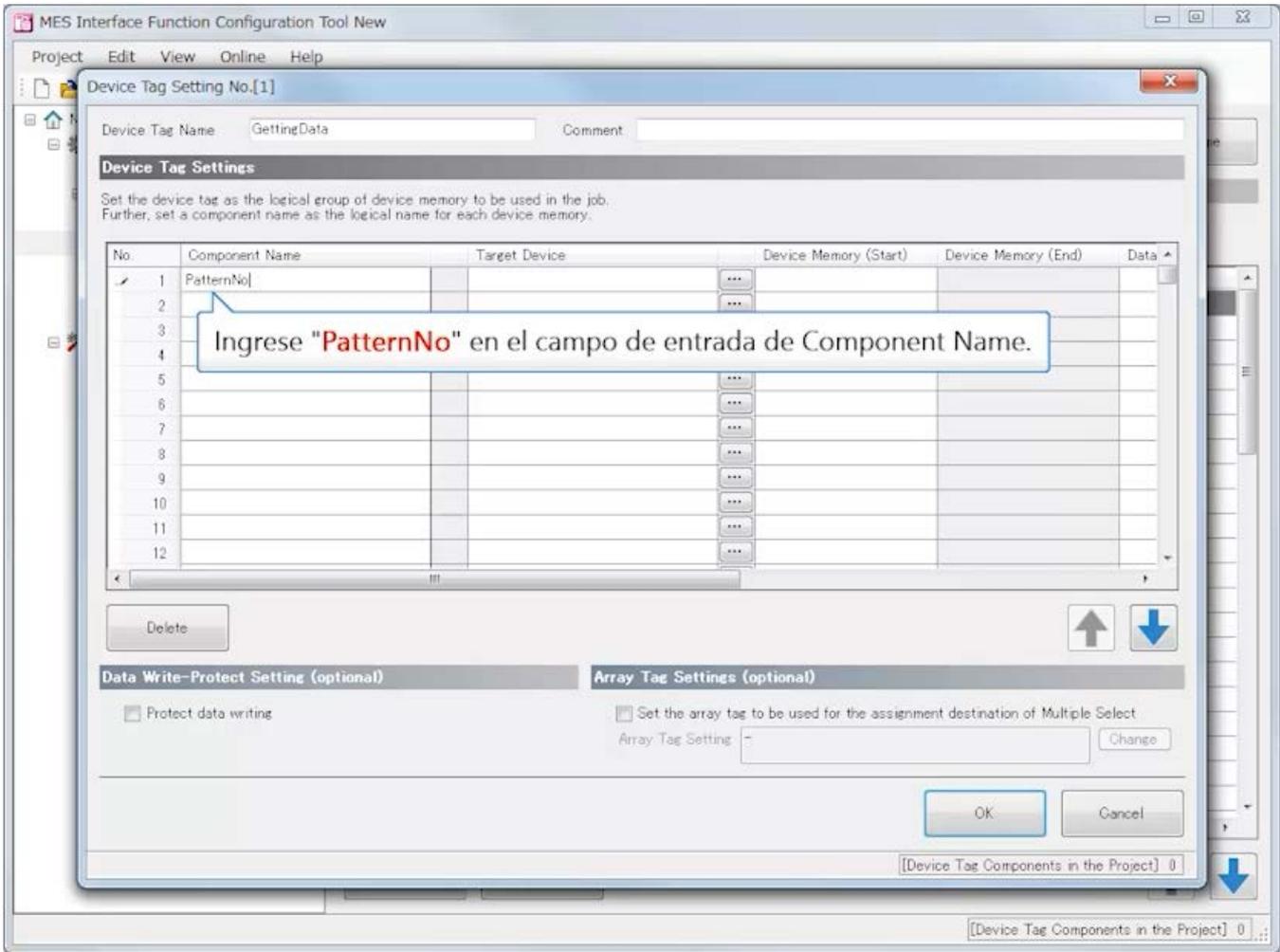
Anterior

Siguiente



Anterior

Siguiente



3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: GettingData Comment:

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 0

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: GettingData Comment:

Device Tag Settings

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

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	ControlCPU	...	D0	Word
2			...		
3			...		
4			...		
5			...		
6			...		
7			...		
8			...		
9			...		
10			...		
11			...		
12			...		

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 1

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

The screenshot shows the 'Device Tag Setting No.[1]' dialog box in the MES Interface Function Configuration Tool. The dialog box has a menu bar (Project, Edit, View, Online, Help) and a toolbar. The main area is titled 'Device Tag Settings' and contains a table with the following columns: No., Component Name, Device Memory (Start), Device Memory (End), and Data Type. The first row is selected, showing '1', 'PatternNo', 'D0', 'D0', and 'Word [Signed]'. A callout box points to the 'Data Type' dropdown menu, which is open and shows options: 'Bit', 'Word [Unsigned/Bit String (16-bit)]', 'Double Word [Unsigned/Bit String (32-bit)]', 'Integer [Signed]', and 'Integer [Unsigned]'. The callout box contains the text: 'Dado que el n.º de patrón es un dato numérico (tipo de palabra), especifique "Word [Unsigned]/Bit String [16-bit]" para Tipo de datos.' Below the table are buttons for 'Delete', 'Up', and 'Down'. At the bottom, there are sections for 'Data Write-Protect Setting (optional)' with a checkbox 'Protect data writing', and 'Array Tag Settings (optional)' with a checkbox 'Set the array tag to be used for the assignment destination of Multiple Select' and an 'Array Tag Setting' field with a 'Change' button. 'OK' and 'Cancel' buttons are at the bottom right. A status bar at the bottom right shows '[Device Tag Components in the Project] 0'.

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

Anterior

Siguiente

Device Tag Setting No.[1]

Device Tag Name: GettingData Comment:

Device Tag Settings

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

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

Registre los tres componentes que se muestran en la siguiente tabla con el mismo procedimiento que "PatternNo".
El ajuste de operación se omite en este curso.

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 1

[Device Tag Components in the Project] 0

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Setting No.[1]

Device Tag Name: GettingData Comment:

Device Tag Settings

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

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

Delete ↑ ↓

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

Protect data writing Destination of Multiple Select Change

Una vez registrados todos los componentes, haga clic en el botón **OK**.

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 0

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with 'Device Tag Settings' selected. The main area displays the 'Device Tag Setting List' table. The table has columns for 'No.', 'Device Tag Name', 'Comment', 'Data Writing', and 'Array Size'. Row 1 is highlighted and contains 'GettingData'. Below the table, a text box contains the instruction: 'Se completó el ajuste de la etiqueta del dispositivo "GettingData". Haga clic en > para ir a la siguiente página.' The status bar at the bottom right shows '[Device Tag Components in the Project] 4'.

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				

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', 'ControlCPU', 'Device Tag Settings', 'GettingData', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The 'Device Tag Settings' category is selected. The main area is titled 'Device Tag Setting List' and contains a table with 21 rows and 4 columns. The columns are labeled 'Writing' and 'Array Size'. A callout box with the text 'Haga clic en el botón Reproducir.' points to a button in the table. Below the table are 'Edit' and 'Delete' buttons. The status bar at the bottom right shows '[Device Tag Components in the Project] 4'.

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
- Target Device Settings
- ControlCPU
- Device Tag Settings
- GettingData
- 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.

Haga clic en el botón Reproducir.

	Writing	Array Size
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

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', 'ControlCPU', 'Device Tag Settings', 'GettingData', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The 'Device Tag Settings' category is selected, and the 'GettingData' sub-item is highlighted. The main area is titled 'Device Tag Setting List' and contains a table with the following columns: 'No.', 'Device Tag Name', 'Comment', 'Data Writing', and 'Array Size'. The table has 21 rows. Row 1 is selected and contains 'GettingData' in the 'Device Tag Name' column. Row 2 is highlighted in red. A callout box points to row 2 with the text: 'Luego, establezca la segunda etiqueta del dispositivo. Haga clic derecho en la fila no. 2 en la device tag setting list.' Below the table are 'Edit' and 'Delete' buttons, and navigation arrows. The status bar at the bottom right shows '[Device Tag Components in the Project] 4'.

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				

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with 'Device Tag Settings' selected. The main area is titled 'Device Tag Setting List' and contains a table with the following data:

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				

A callout box with a blue border and white background is positioned over the 'Edit' option in the context menu for row 2. The text inside the callout box reads: 'Seleccione Editar para crear una nueva etiqueta del dispositivo. Haga clic en **Edit** desde el menú.'

At the bottom of the window, there are 'Edit' and 'Delete' buttons, and a status bar showing '[Device Tag Components in the Project] 4'.

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: Tag[01] Comment:

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

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

Delete

Data Write-Protect Setting (optional) Protect data writing

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

OK Cancel

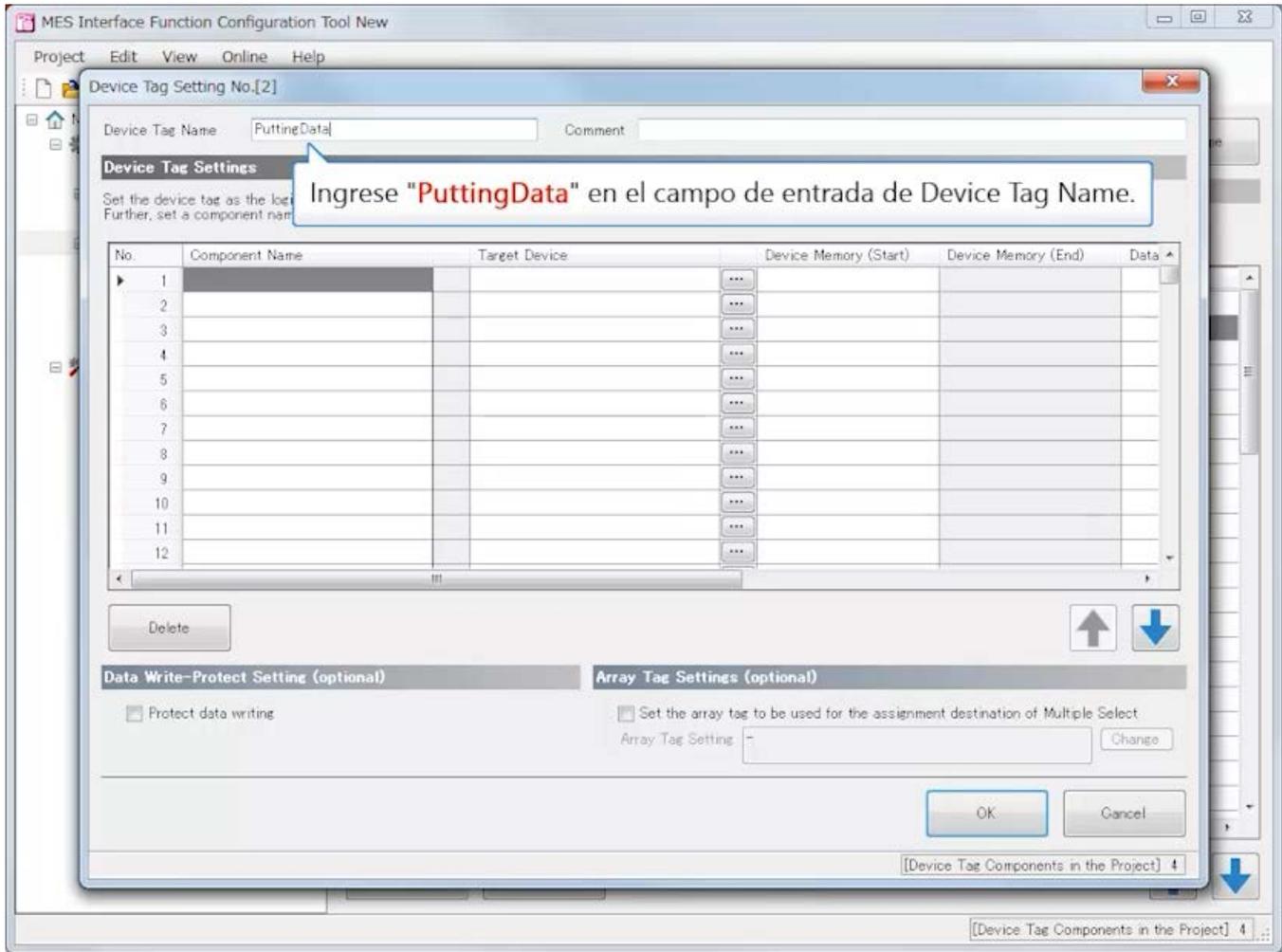
[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

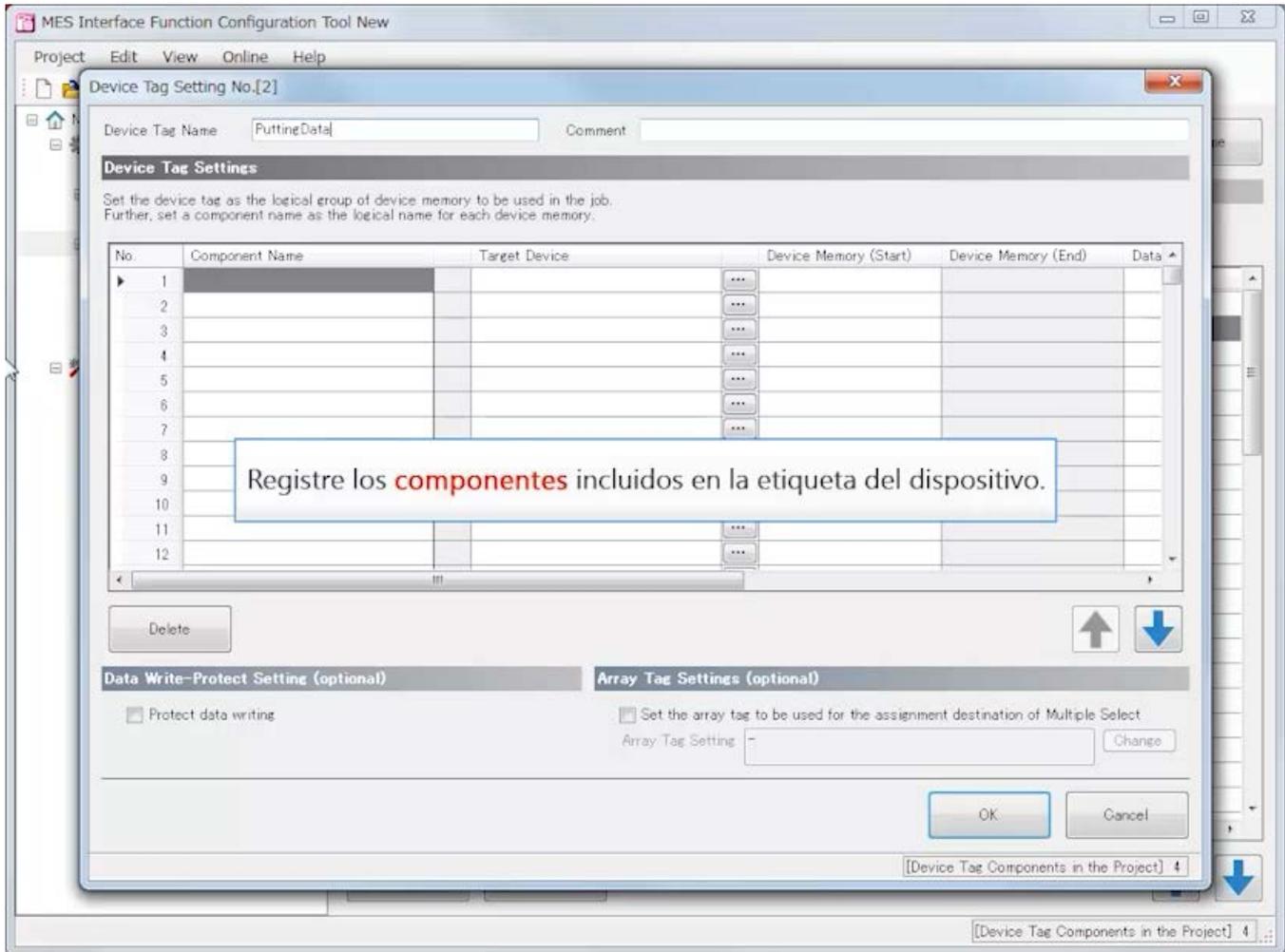
Siguiente



3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente



3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: PuttingData

Comment:

Device Tag Settings

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

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

Delete

Data Write-Protect Setting (optional)
 Protect data writing

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

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: PuttingData Comment:

Device Tag Settings

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 4

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: PuttingData Comment:

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

Device Tag Setting No.[2]

Device Tag Name: PuttingData Comment:

Device Tag Settings

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

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

Delete

Data Write-Protect Setting (optional)

Protect data writing

Array Tag Settings (optional)

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

Device Tag Name: PuttingData Comment:

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

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

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

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	Device Memory (Start)	Device Memory (End)	Data Type
1	PatternNo	D0	D0	Word [Signed]
2				Bit
3				Word [Unsigned]/Bit String [16-bit]
4				Double Word [Unsigned]/Bit String [32-bit]
5				Integer [Precision]
6				Real [Precision]
7				Character String [Unicode]
8				Character String [ASCII/SJIS]
9				
10				
11				
12				

Given that the n.º of pattern is a numerical data (word type), specify "Word [Unsigned]/Bit String [16-bit]" for Data Type.

Delete ↑ ↓

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

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

Array Tag Setting: Change

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

Anterior

Siguiente

Device Tag Name: PuttingData Comment:

Device Tag Settings

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

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

Registre los cuatro componentes que se muestran en la siguiente tabla con el mismo procedimiento que "PatternNo".
El ajuste de operación se omite en este curso.

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

OK Cancel

[Device Tag Components in the Project] 5

[Device Tag Components in the Project] 4

3.4 Ajuste con la MES interface function configuration tool (Device Tag Settings)

Anterior

Siguiente

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) **Array Tag Settings (optional)**

Protect data writing Destination of Multiple Select Change

Una vez registrados todos los componentes, haga clic en el botón **OK**.

OK Cancel

[Device Tag Components in the Project] 9

[Device Tag Components in the Project] 4

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like 'Main Settings', 'Job Settings', 'Device Tag Settings', etc. The 'Device Tag Settings' category is expanded, and 'PuttingData' is selected. The main area displays a table titled 'Device Tag Setting List' with the following data:

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				

Below the table, a text box contains the instruction: 'Se completó el ajuste de la etiqueta del dispositivo "PuttingData". Haga clic en > para ir a la siguiente página.' The status bar at the bottom right shows '[Device Tag Components in the Project] 9'.

[Target Server Settings]

Utilice el mismo nombre de fuente de datos que el configurado en los ajustes de ODBC.

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

Target Server Setting No.[1] X

Target Server Name Comment

Target Server Common Settings

Set the target server with which MES interface module communicates.

Server Type

IP Address

Port No.

Communication Timeout Time s



Target Server Individual Settings

Set the information to access the database.

Data Source Name

User Name

Password

Database Type

Access Error Notification Settings (optional)

Access Error Notification Setting

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Home

Project Name NewProject

Haga clic en el botón Reproducir.

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

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

Target Server Settings

Place the cursor to display the explanation of each item.

3.4 Ajuste con la MES interface function configuration tool (Target Server Settings)

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like Main Settings, Job Settings, Target Device Settings, ControlCPU, Device Tag Settings, GettingData, PuttingData, Target Server Settings, Access Table/Proc. Settings, Network Settings, Option Settings, Variable Settings, DB Buffer Settings, Security Settings, and Dot Matrix LED Settings. The main area is titled 'Main Settings of MES Interface Module' and contains a flow diagram of settings: Device Tag Settings, Target Device Settings, Job Settings, Network Settings, Access Table/Procedure Settings, and Target Server Settings. The 'Target Server Settings' button is highlighted with a red border. A callout box points to it with the text 'Haga clic en Target Server Settings.' Below the diagram is a text box that says 'Place the cursor to display the explanation.' The window also has a menu bar (Project, Edit, View, Online, Help) and a toolbar.

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view with 'Target Server Settings' selected. The main area displays a 'Target Server Setting List' table with columns: No., Target Server Name, Comment, Server Type, and IP Address. A callout box points to row 1 with the text: 'Haga clic derecho en la fila no. 1 de la device tag setting list.' Below the table are 'Edit' and 'Delete' buttons, and navigation arrows.

Adding/Editing the Target Server Settings
When adding a target server setting, select a blank line and click the "Edit" button.
When editing the existing target server setting, select the applicable line and click the "Edit" button.

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

Anterior

Siguiente

The screenshot shows the 'MES Interface Function Configuration Tool New' window. On the left is a tree view with categories like 'Main Settings', 'Job Settings', 'Target Device Settings', 'ControlCPU', 'Device Tag Settings', 'GettingData', 'PuttingData', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', 'Option Settings', 'Variable Settings', 'DB Buffer Settings', 'Security Settings', and 'Dot Matrix LED Settings'. The 'Target Server Settings' category is selected. The main area is titled 'Target Server Setting List' and contains a table with columns: 'No.', 'Target Server Name', 'Comment', 'Server Type', and 'IP Address'. The table has 16 rows, with row 1 highlighted in blue. A context menu is open over row 1, showing options: 'Edit', 'Delete', 'Add', and 'Com'. A tooltip box points to the 'Edit' option with the text: 'Seleccione Editar y establezca el servidor de destino. Haga clic en Edit desde el menú.' Below the table are 'Edit' and 'Delete' buttons, and navigation arrows.

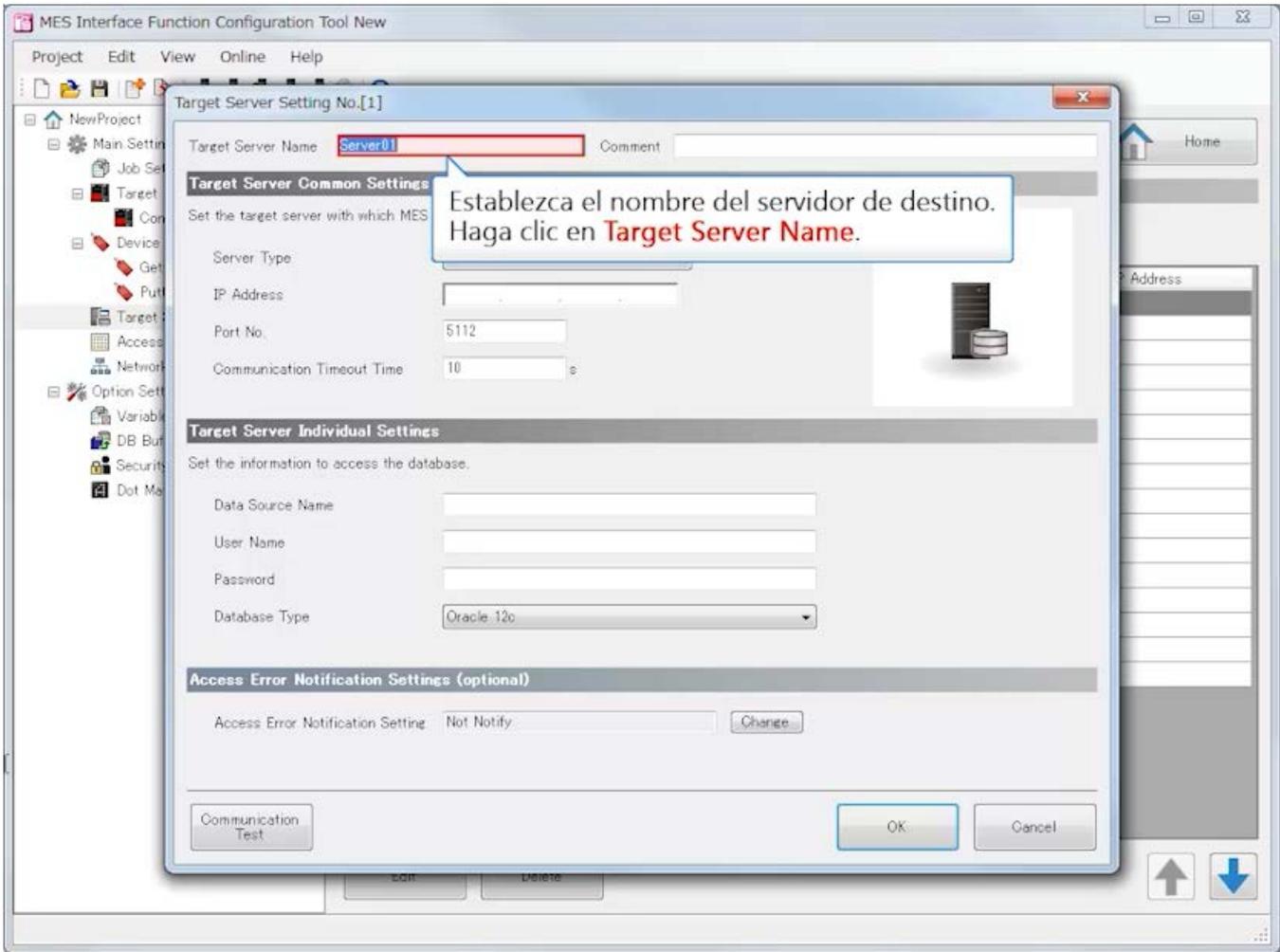
Adding/Editing the Target Server Settings

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

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

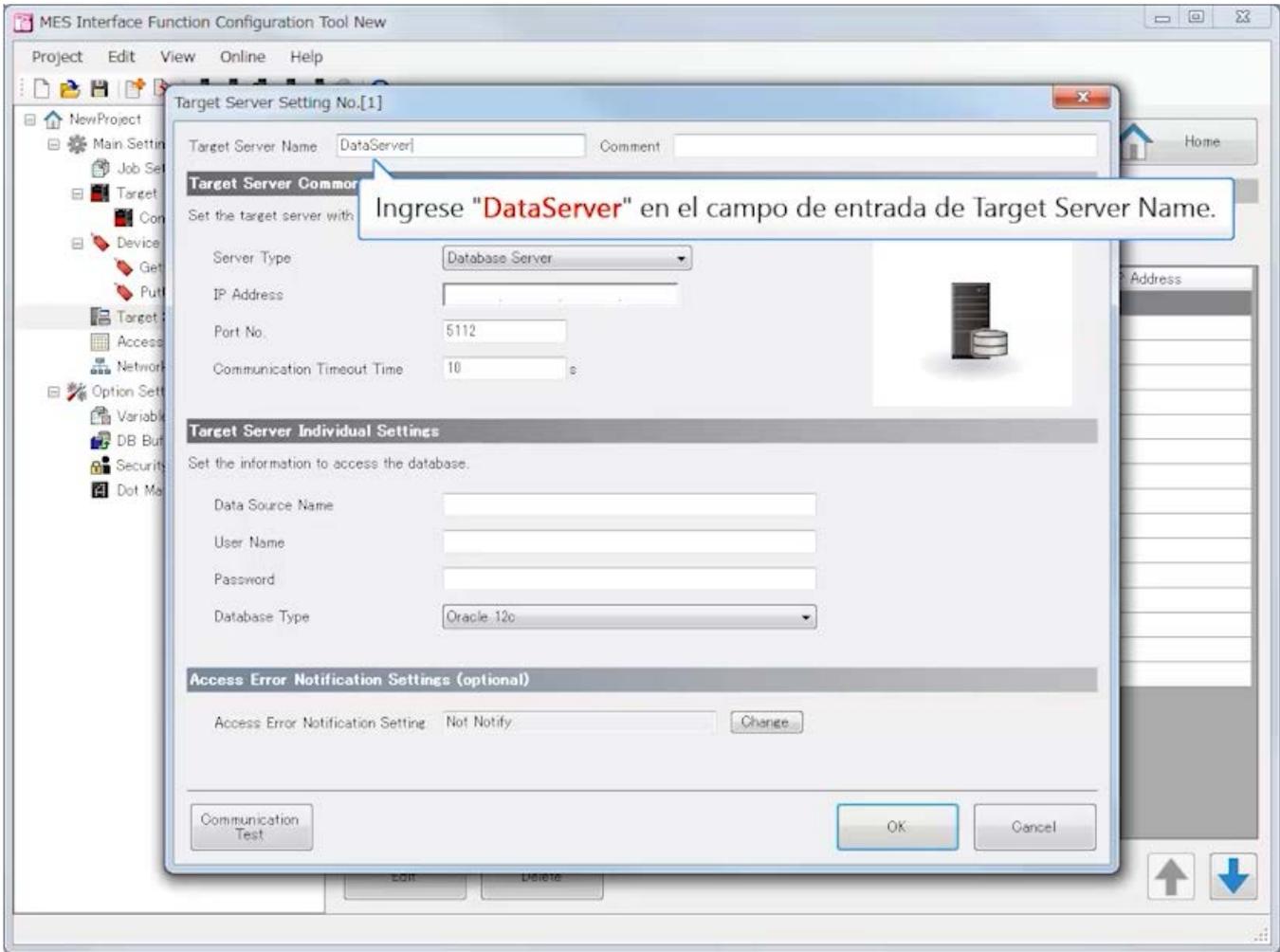
Anterior

Siguiente



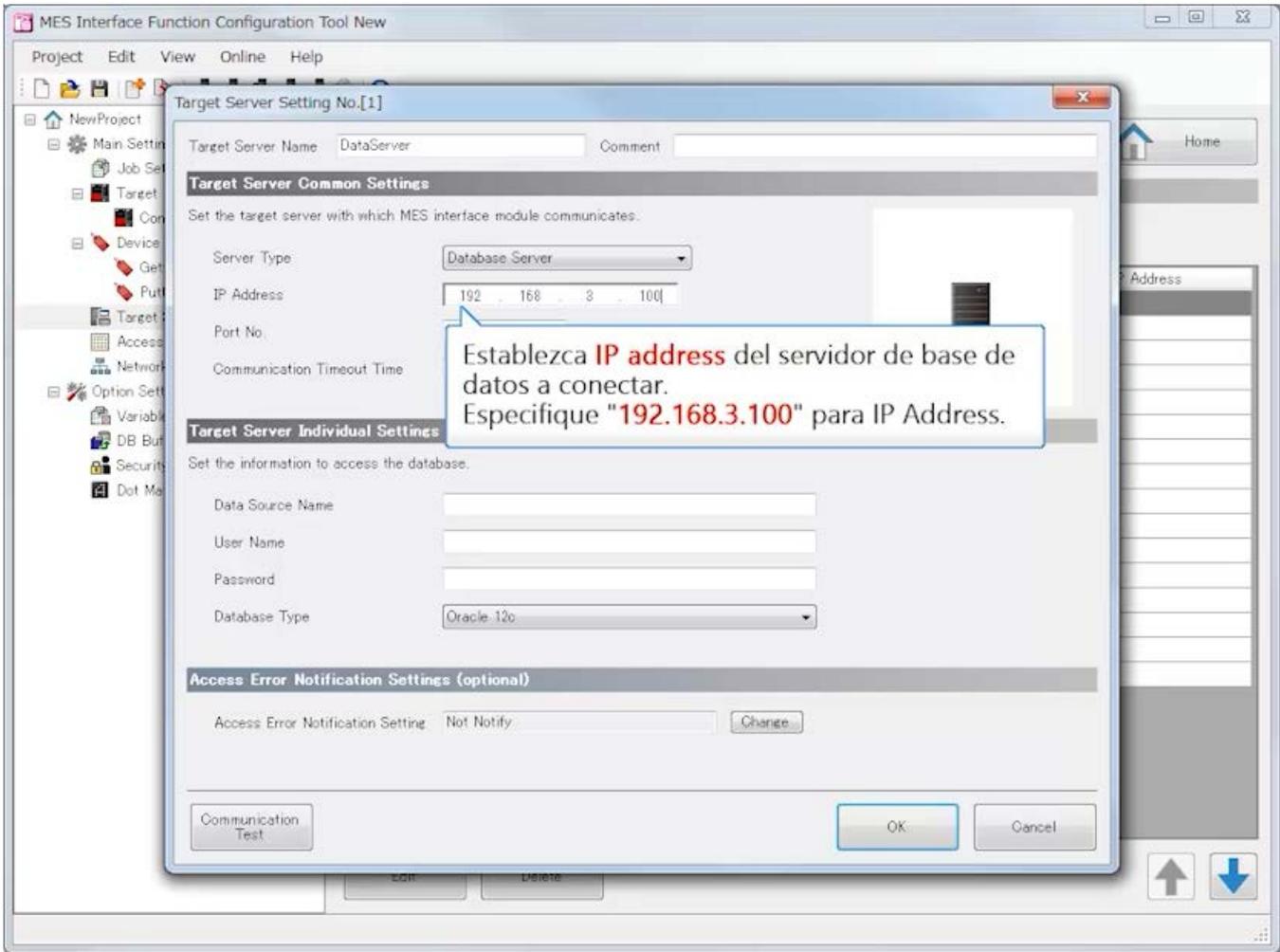
Anterior

Siguiente



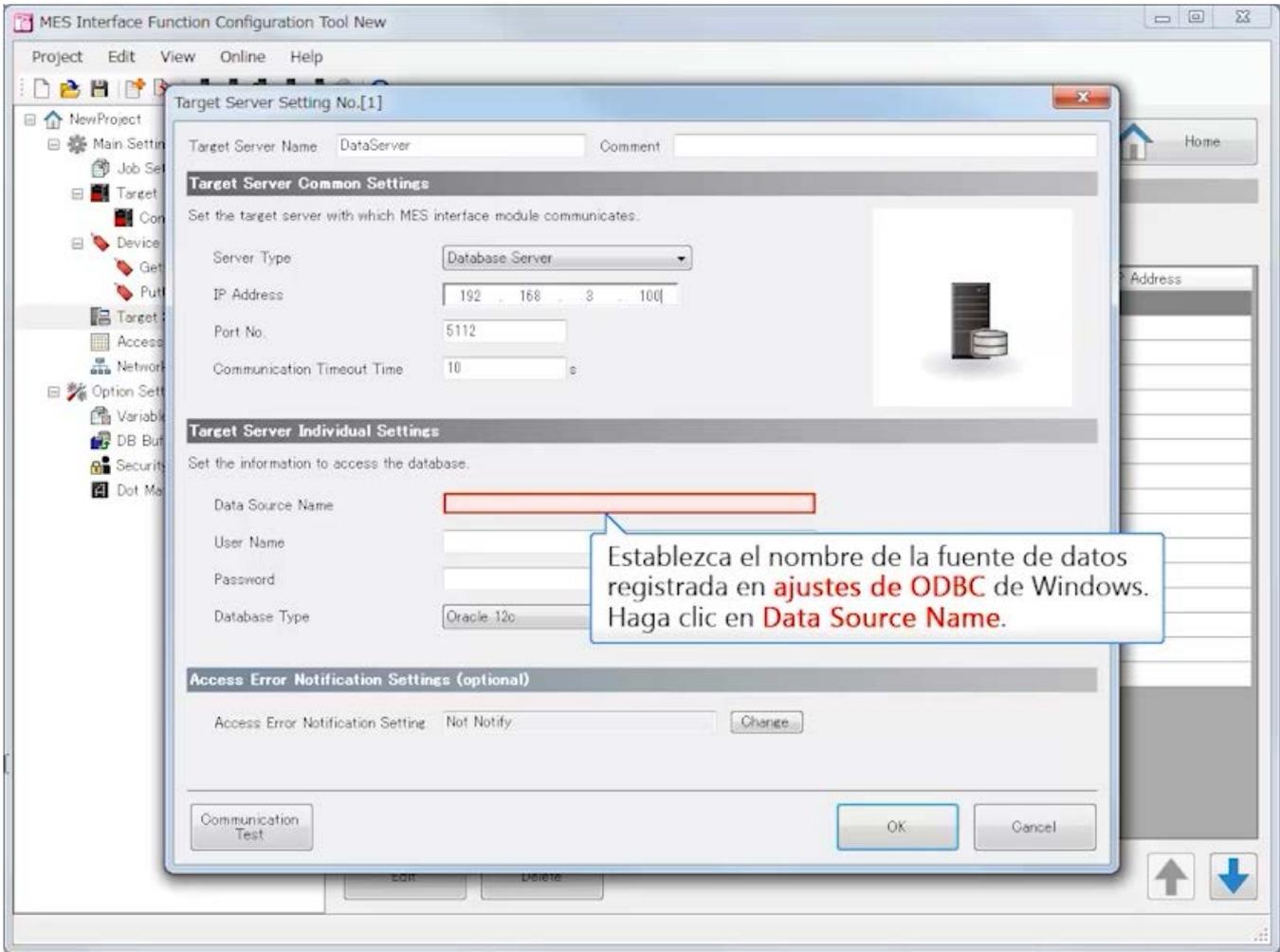
Anterior

Siguiente



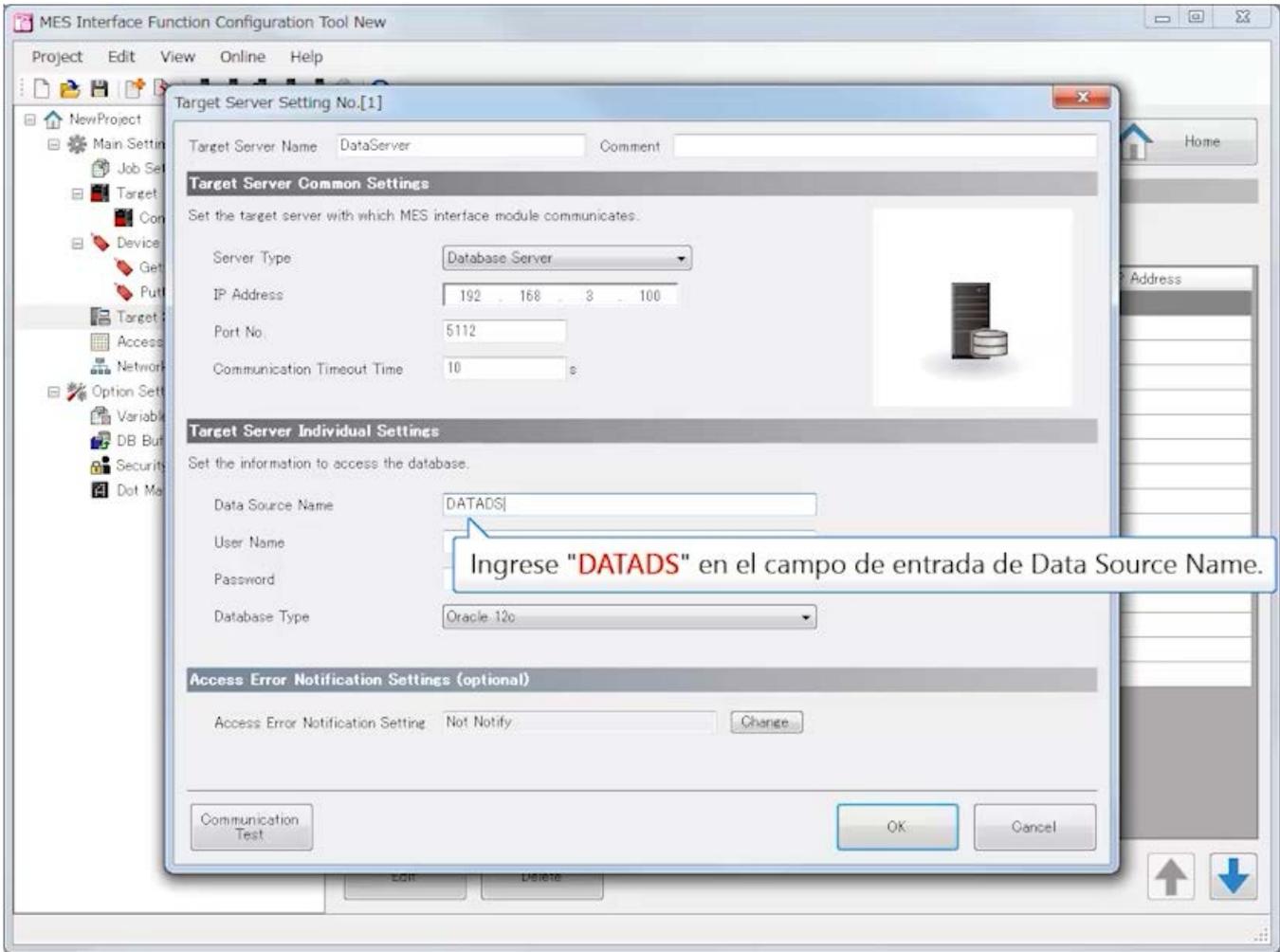
Anterior

Siguiente



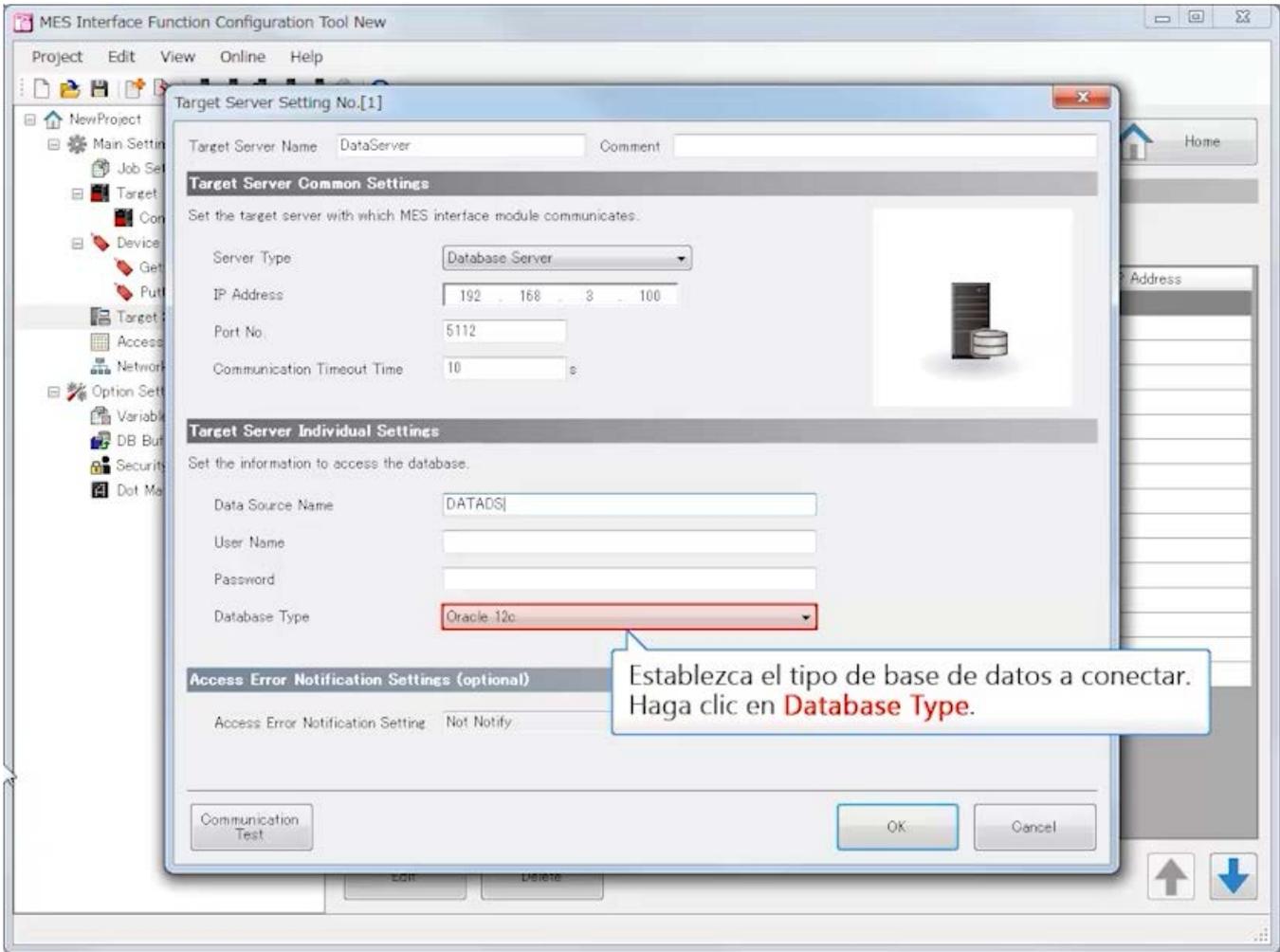
Anterior

Siguiente



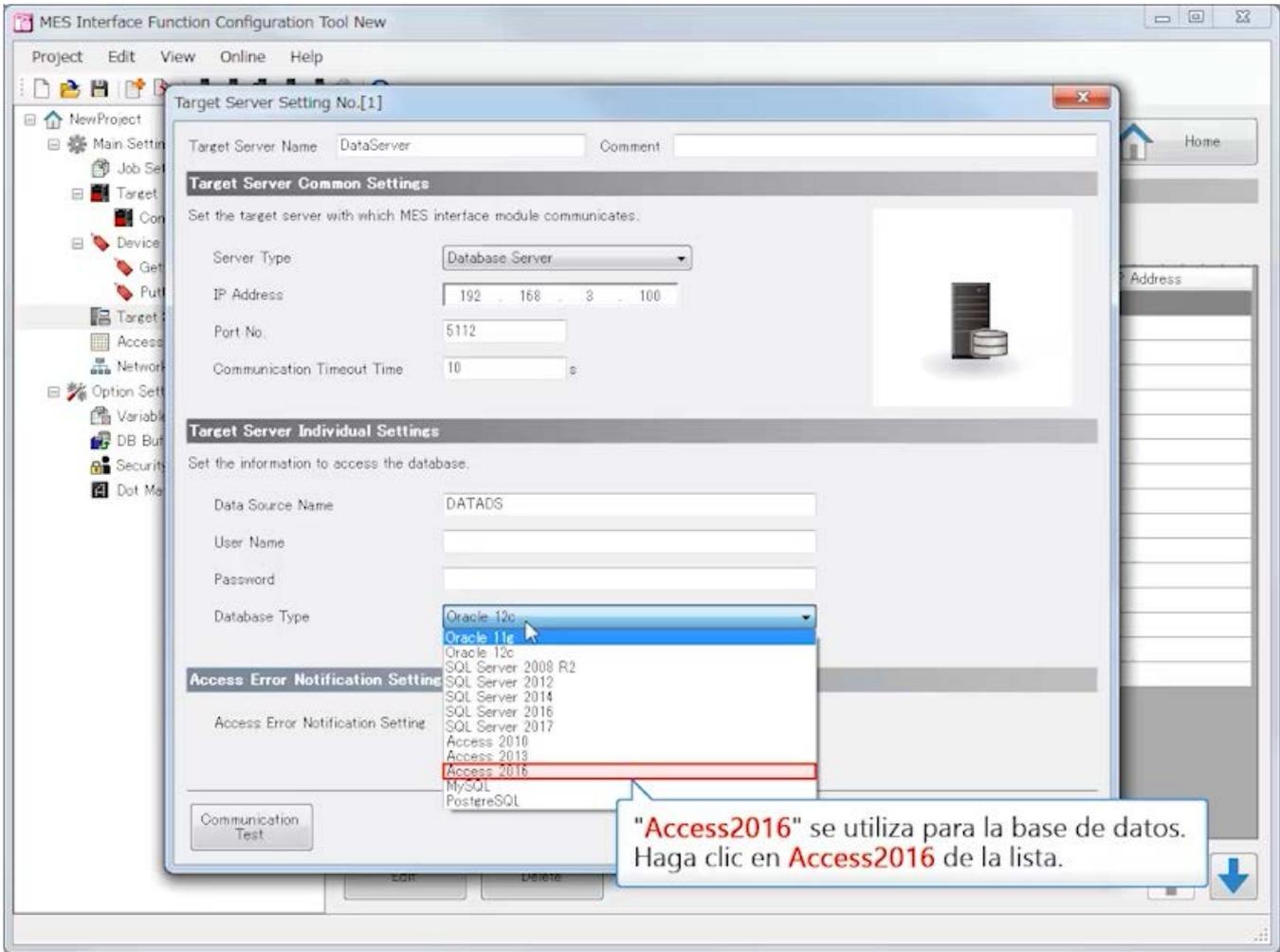
Anterior

Siguiente



Anterior

Siguiente



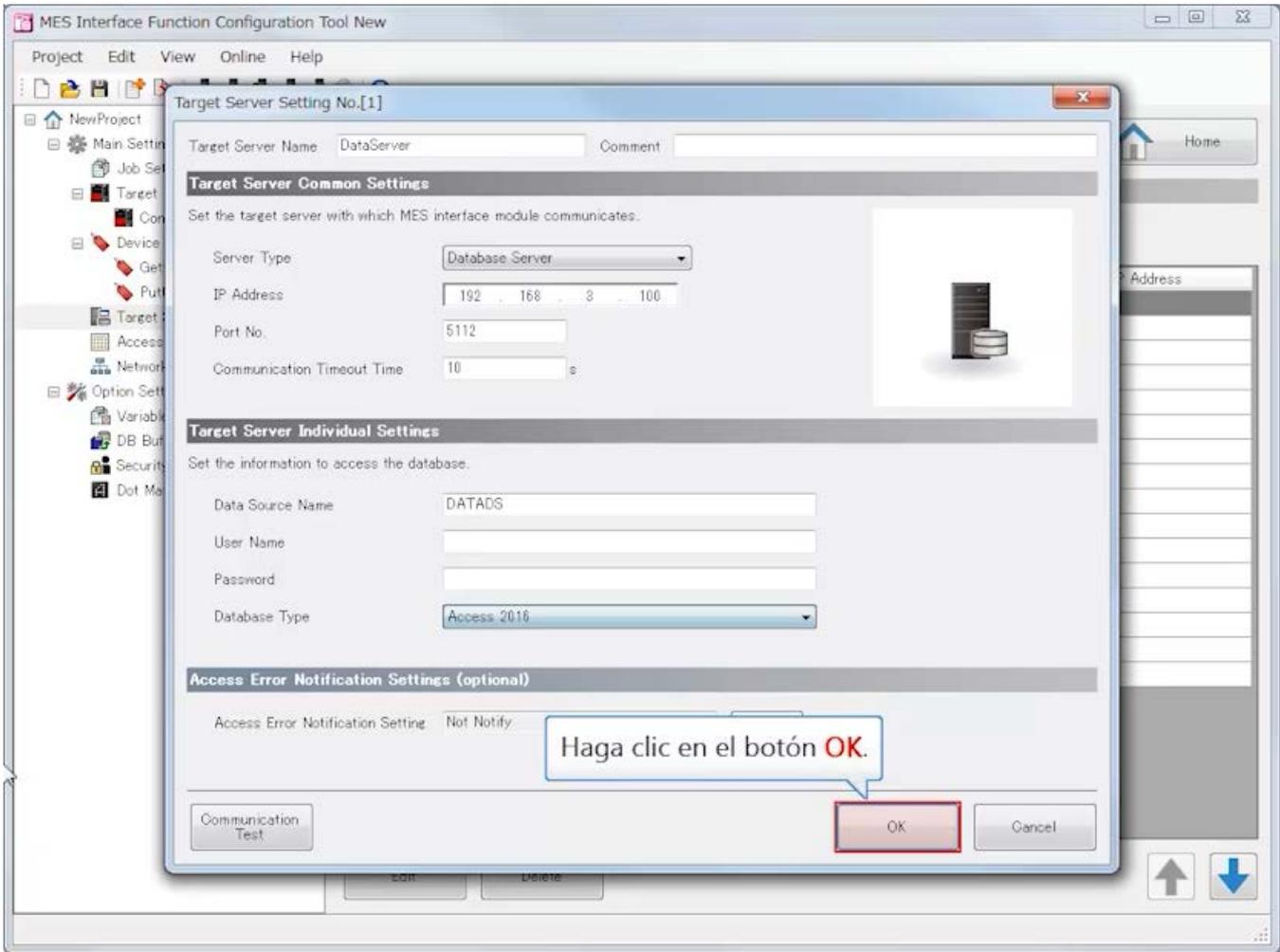
The screenshot displays the 'Target Server Setting No.[1]' dialog box within the 'MES Interface Function Configuration Tool New' application. The dialog is divided into three main sections:

- Target Server Common Settings:** Includes fields for 'Target Server Name' (DataServer), 'Comment', 'Server Type' (Database Server), 'IP Address' (192.168.3.100), 'Port No.' (5112), and 'Communication Timeout Time' (10 s).
- Target Server Individual Settings:** Includes 'Data Source Name' (DATADS), 'User Name', 'Password', and 'Database Type'. The 'Database Type' dropdown menu is open, showing a list of options: Oracle 12c, Oracle 11g, Oracle 10g, SQL Server 2008 R2, SQL Server 2012, SQL Server 2014, SQL Server 2016, SQL Server 2017, Access 2010, Access 2013, Access 2016, MySQL, and PostgreSQL. The 'Access 2016' option is highlighted with a red box.
- Access Error Notification Setting:** Includes an 'Access Error Notification Setting' checkbox.

A callout box at the bottom right of the dialog contains the text: "Access2016" se utiliza para la base de datos. Haga clic en Access2016 de la lista.

Anterior

Siguiente



Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Target Server Setting List

Home

Adding/Editing the Target Server Settings

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

No.	Target Server Name	Comment	Server Type	IP Address
1	DataServer		Database Server	182.168.3.100
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				

Edit Del

Se completó el ajuste del servidor de destino de acceso.
Haga clic en > para ir a la siguiente página.

[Access Table/Procedure Settings]

Configure el procedimiento/la tabla de acceso al que está conectado el módulo de interfaz 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

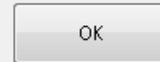
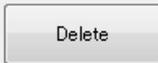
Access Table Detailed Settings

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



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					



[DB Field Name] 38 characters

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

Main Settings

Job Settings

Target Device Settings

ControlCPU

Device Tag Settings

GettingData

PuttingData

Target Server Settings

DataServer

Access Table/Proc. Settings

Network Settings

Option Settings

Variable Settings

DB Buffer Settings

Security Settings

Dot Matrix LED Settings

Home

Project Name NewProject

Haga clic en el botón Reproducir.

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

Device Tag Settings

Target Device Settings

Job Settings

Network Settings

Access Table/Procedure Settings

Target Server Settings

Place the cursor to display the explanation of each item.

[Anterior](#)[Siguiente](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Home

Project Name NewProject

Main Settings Option Settings Comment

Main Settings of MES Interface Module

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

Device Tag Settings Job Settings Access Table/Procedure Settings

Haga clic en Access Table/Procedure Settings.

Place the cursor to display the explanation of each item.

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

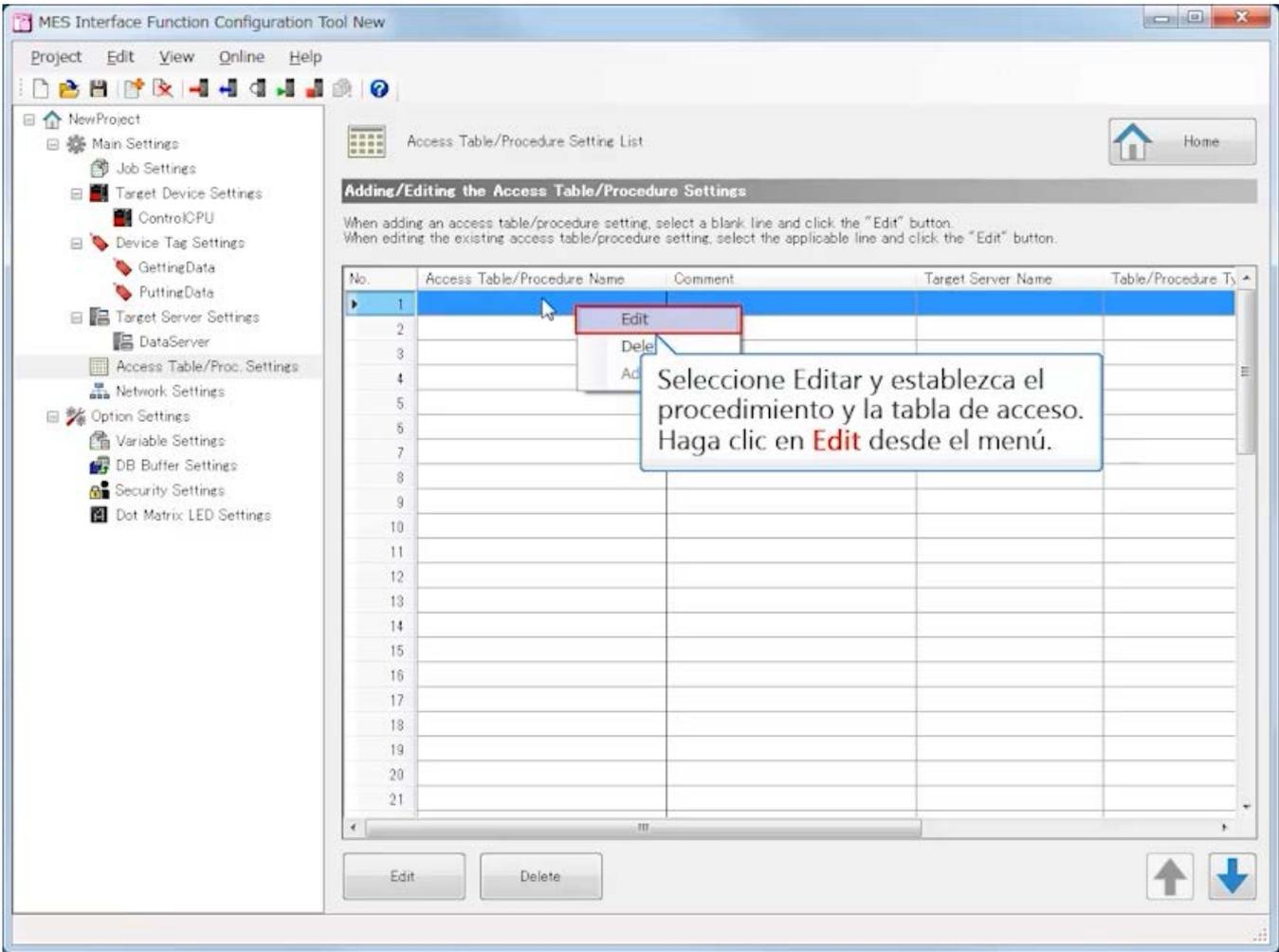
When adding an access table/procedure setting, select a blank line and click the "Edit" button.
When editing the existing access table/procedure setting, select the applicable line and click the "Edit" button.

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

Edit Delete

↑ ↓

Haga clic derecho en la fila no. 1 de la Access Table/Procedure Settings List.

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

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

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Ty
1				
2				
3				
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16				
17				
18				
19				
20				
21				

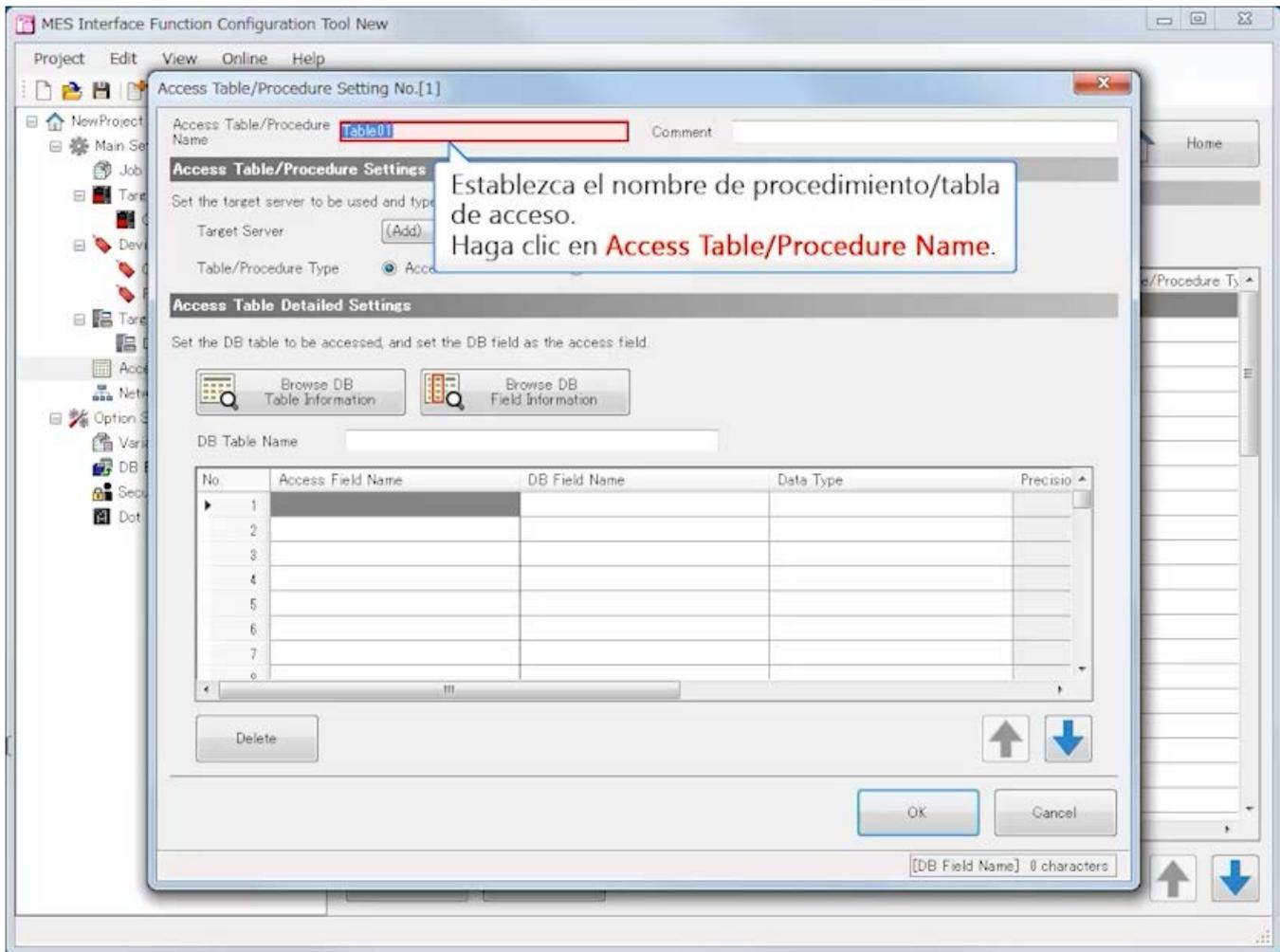
Selecione Editar y establezca el procedimiento y la tabla de acceso. Haga clic en **Edit** desde el menú.

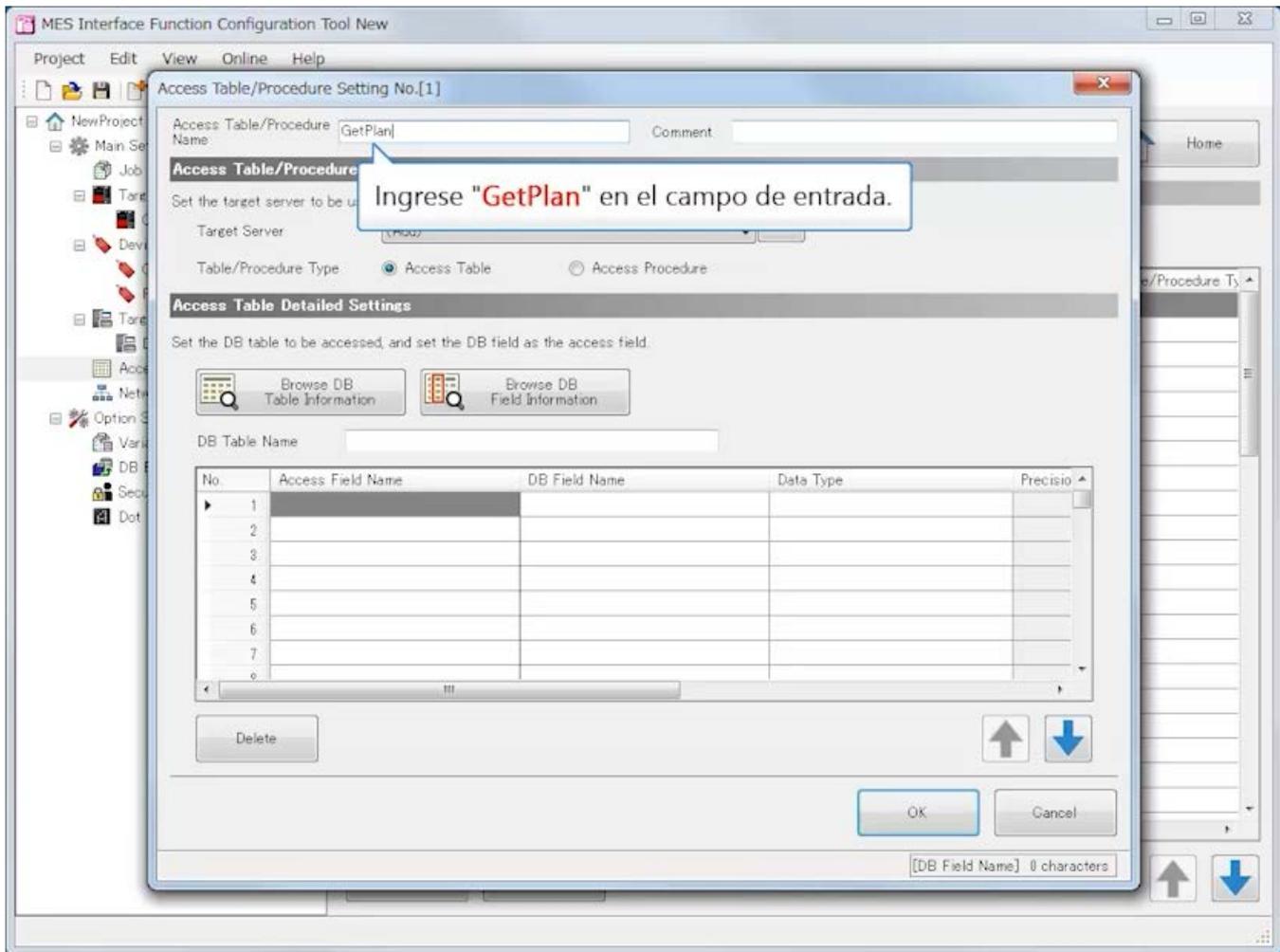
Edit Delete

↑ ↓

Anterior

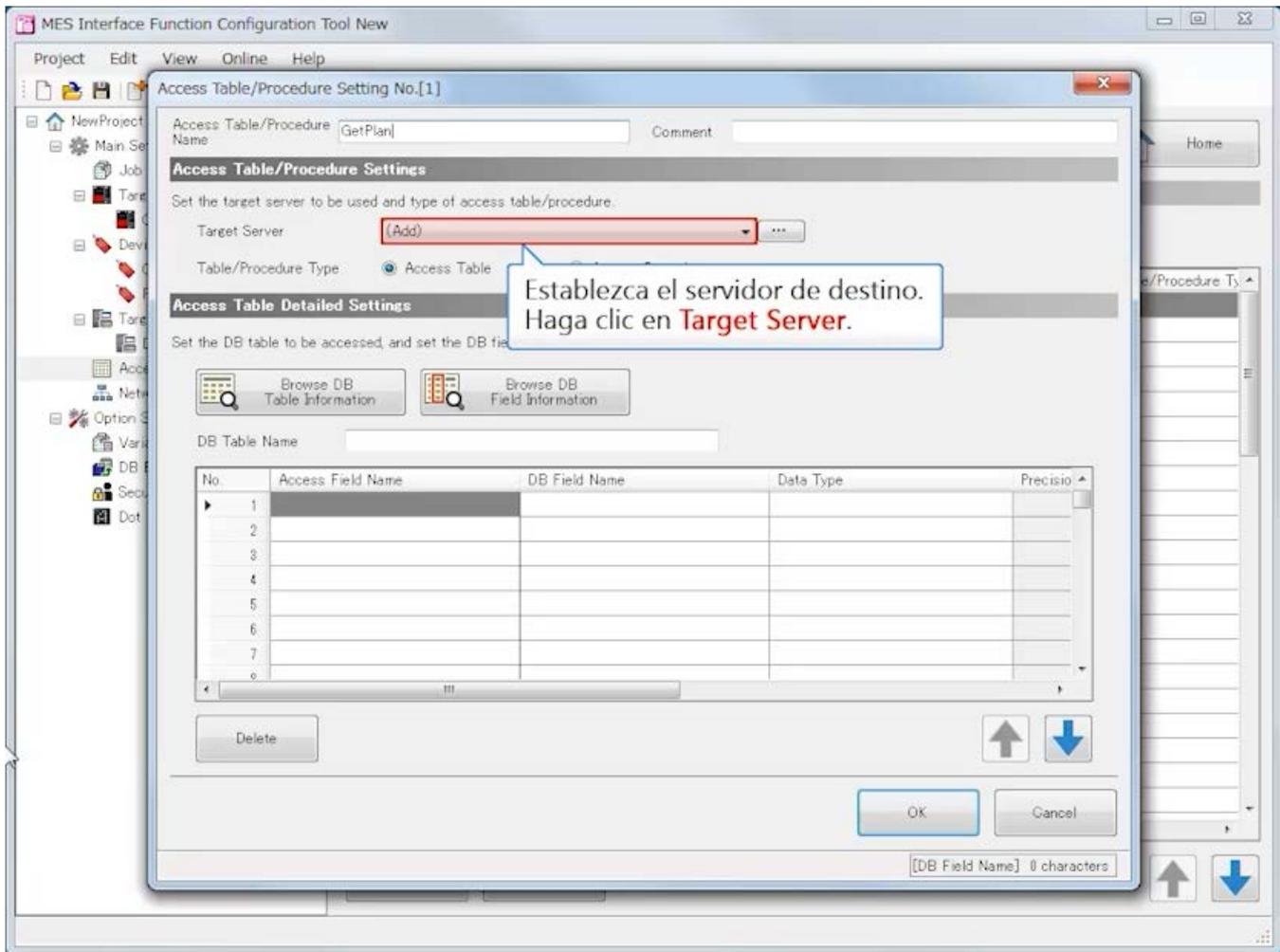
Siguiente



[Anterior](#)[Siguiete](#)

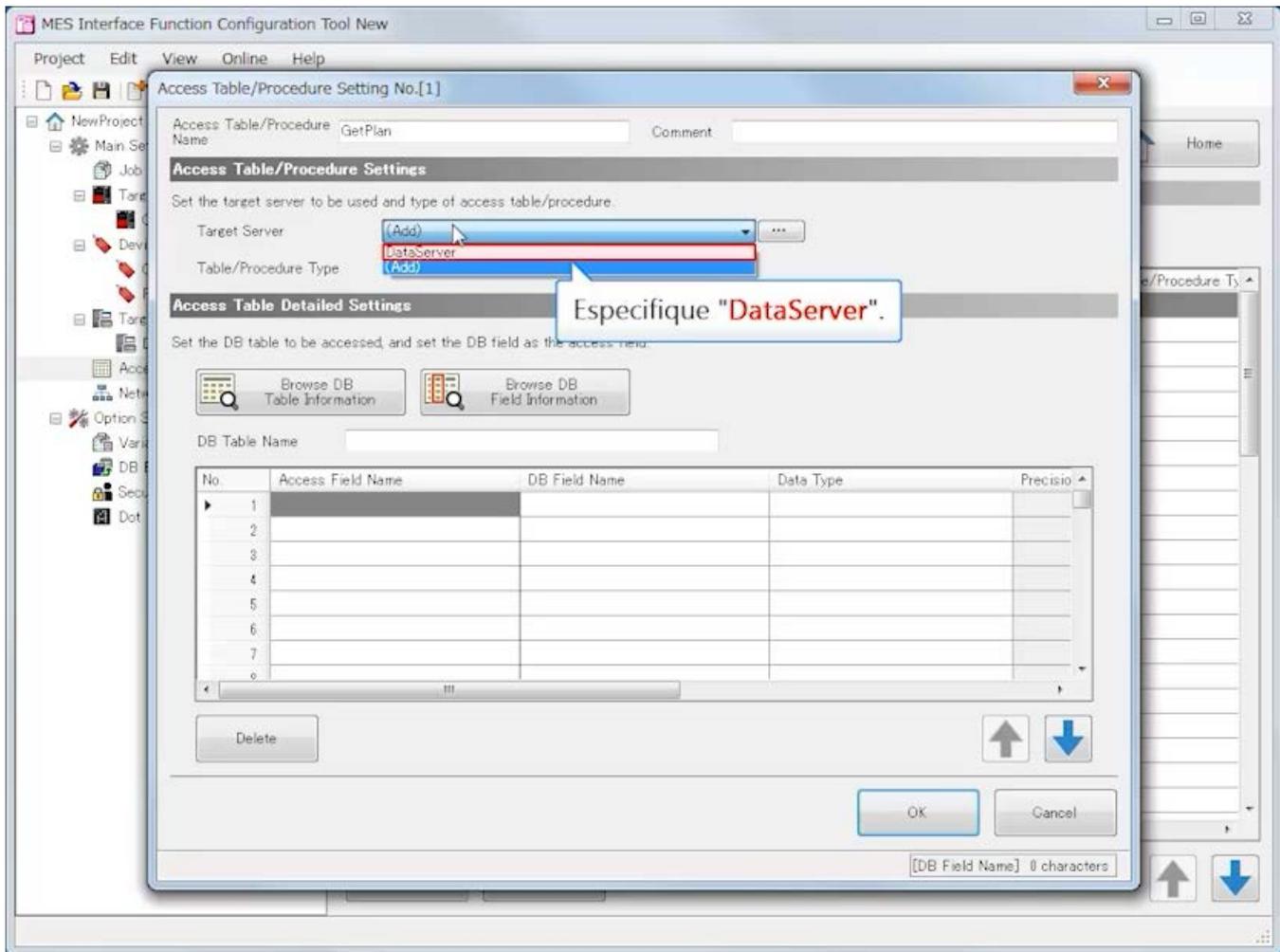
Anterior

Siguiente



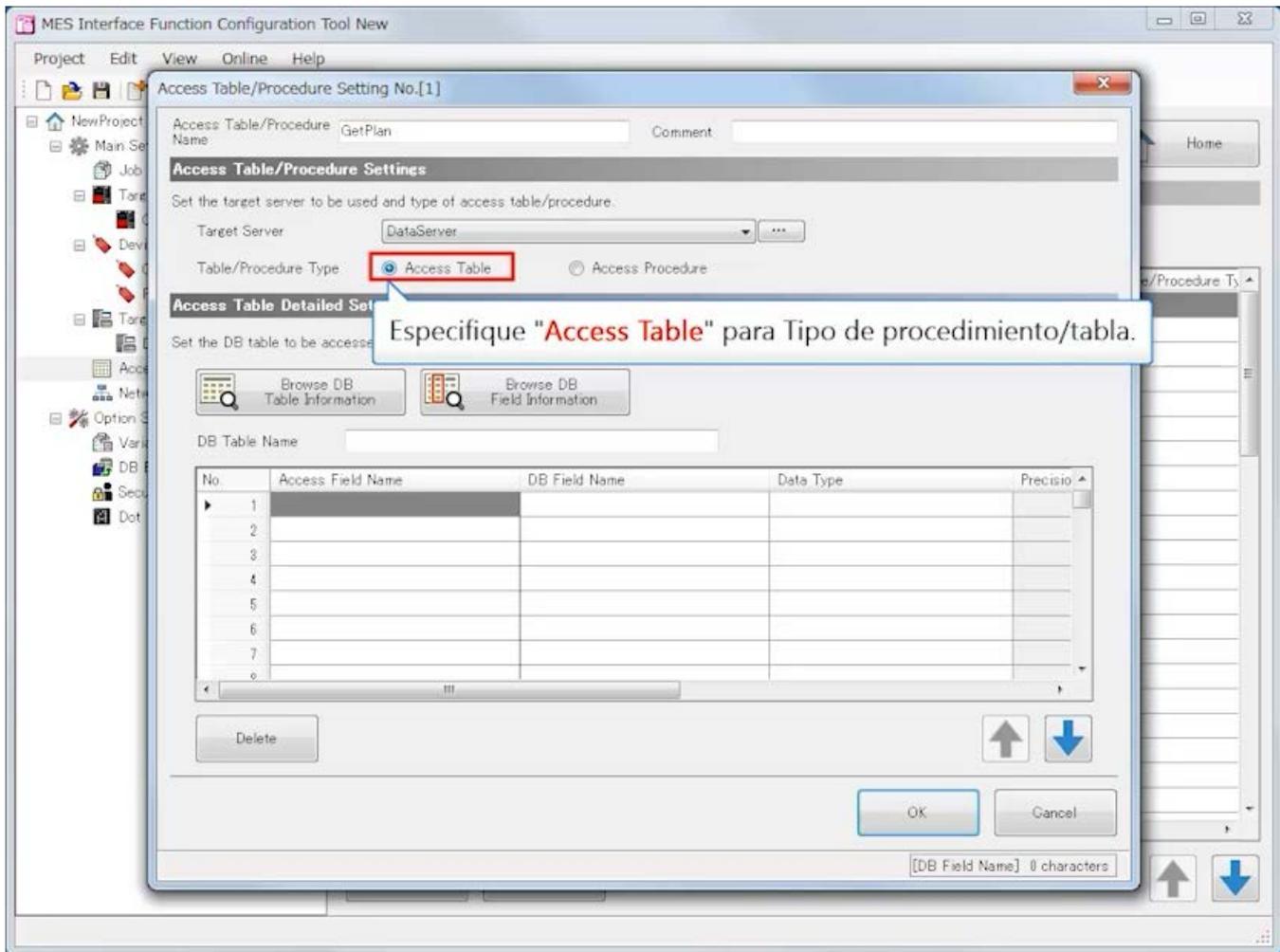
Anterior

Siguiente



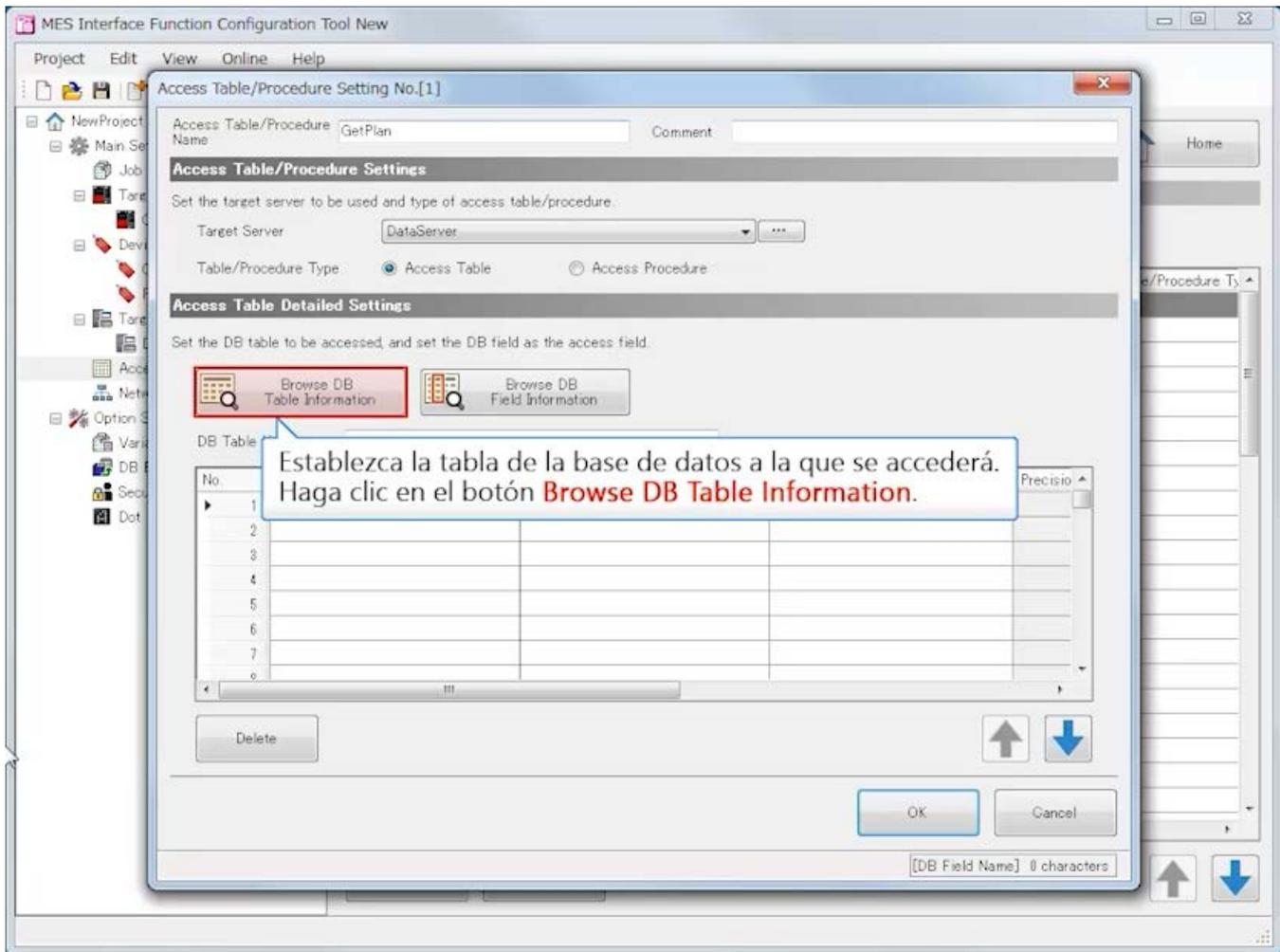
Anterior

Siguiente



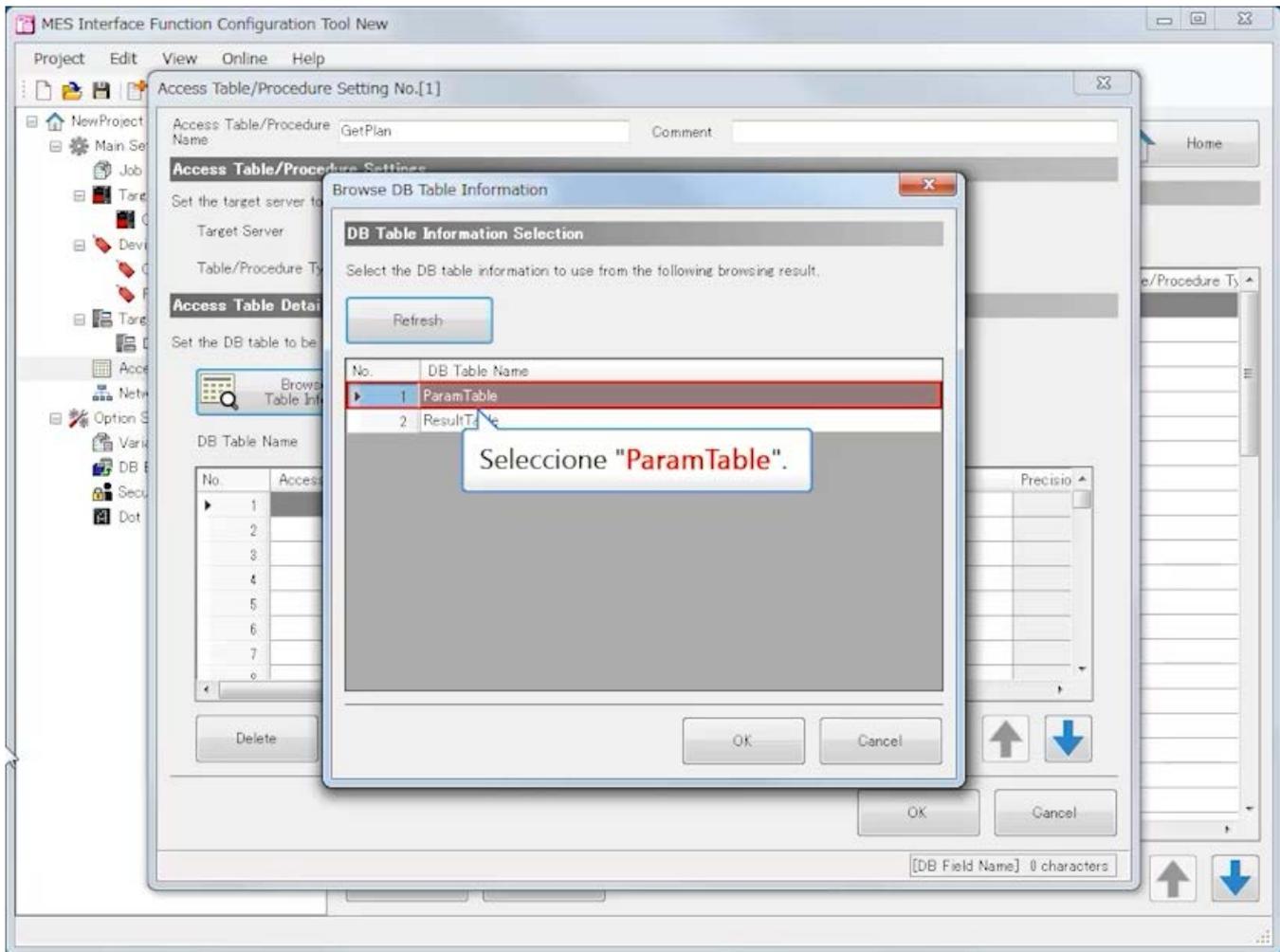
Anterior

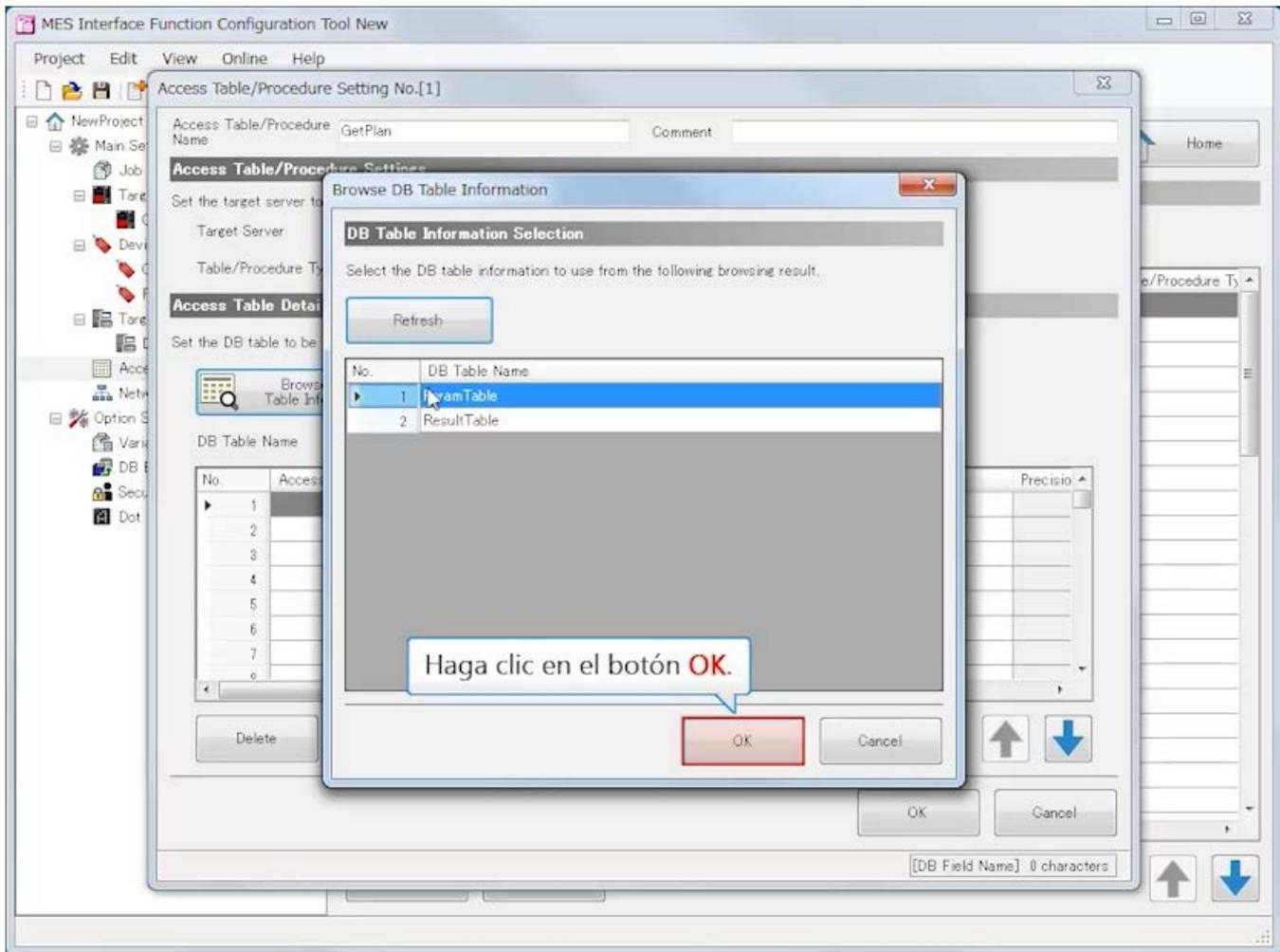
Siguiente



Anterior

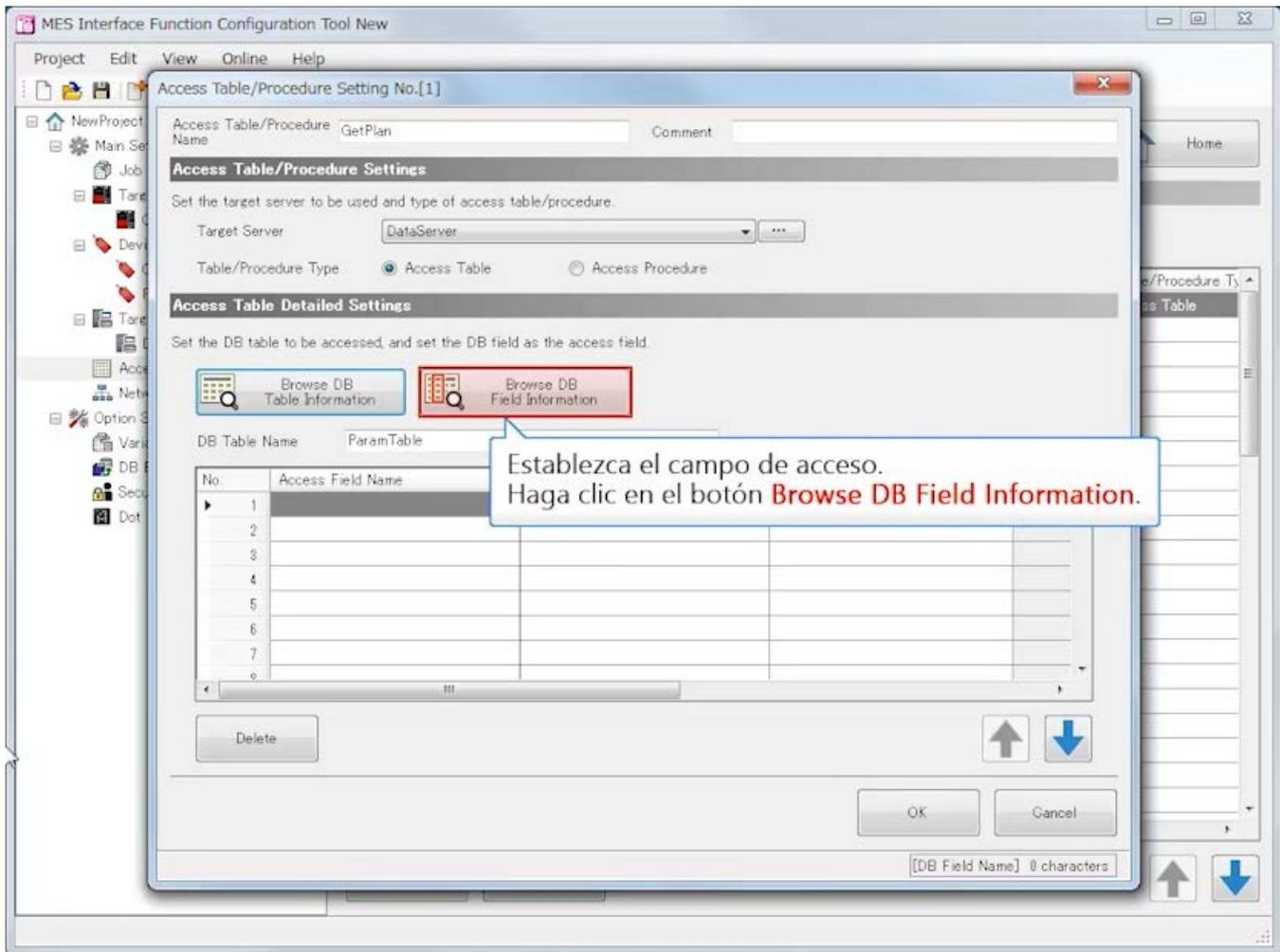
Siguiente



[Anterior](#)[Siguiete](#)

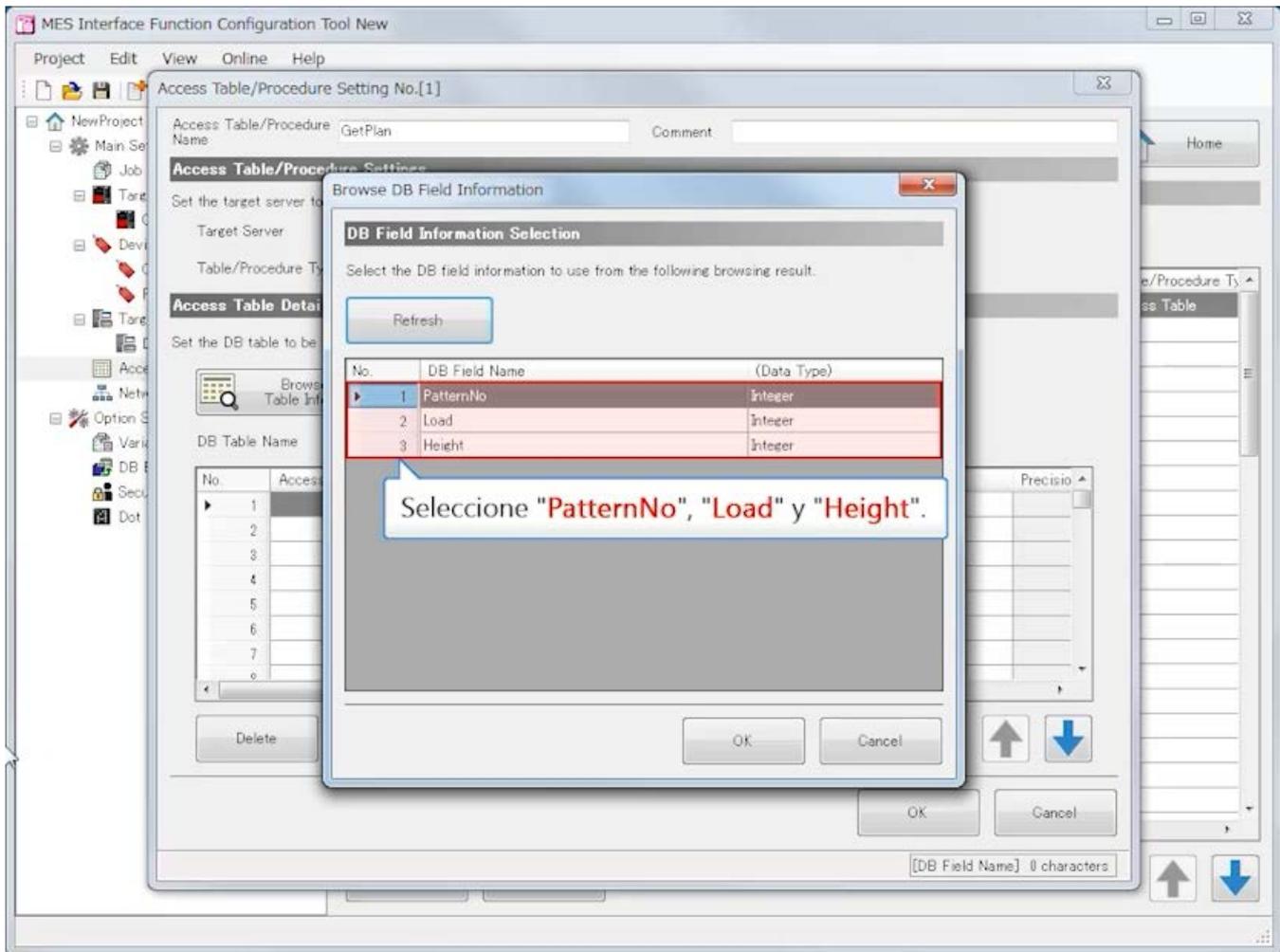
Anterior

Siguiente



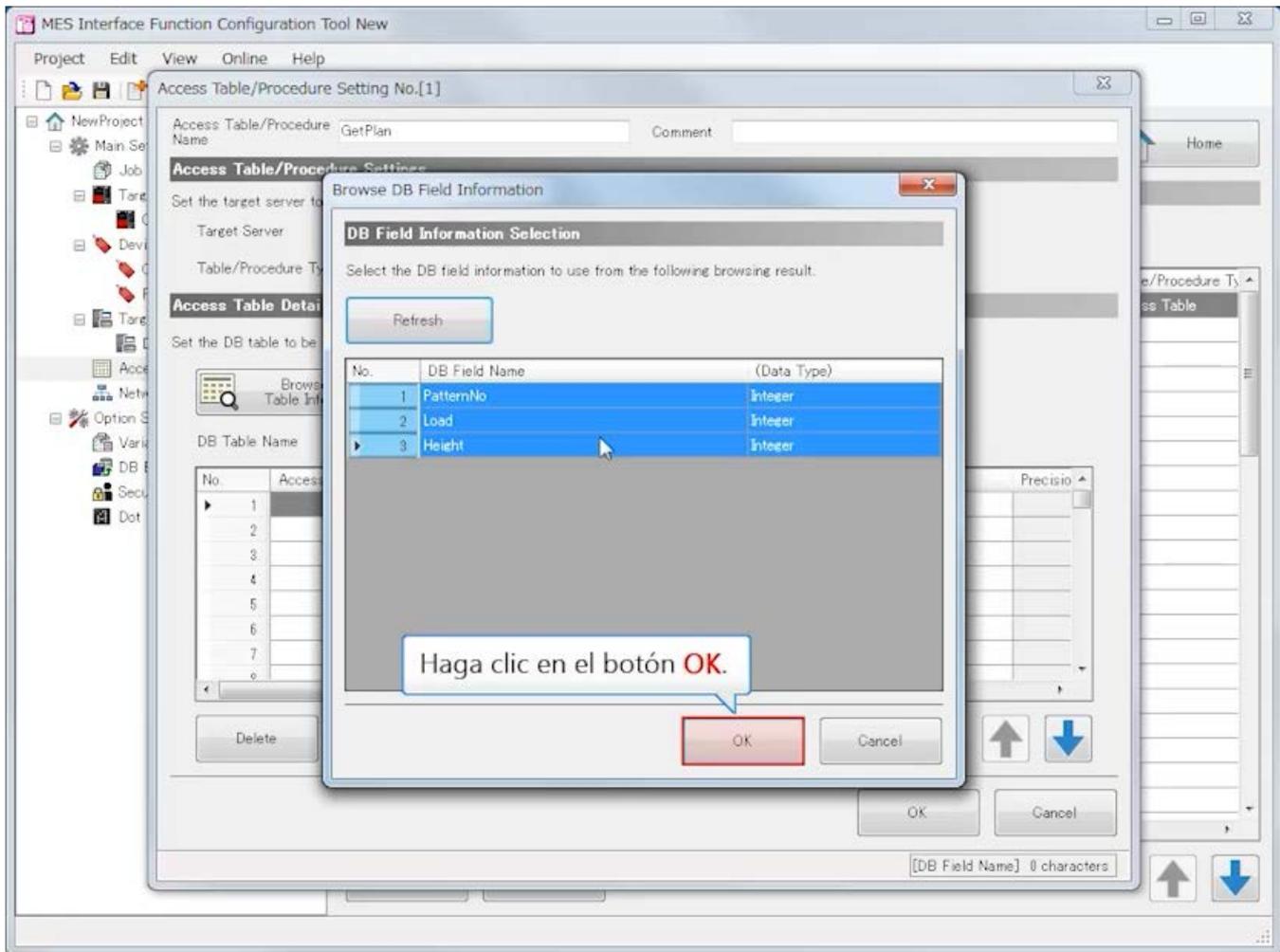
Anterior

Siguiente



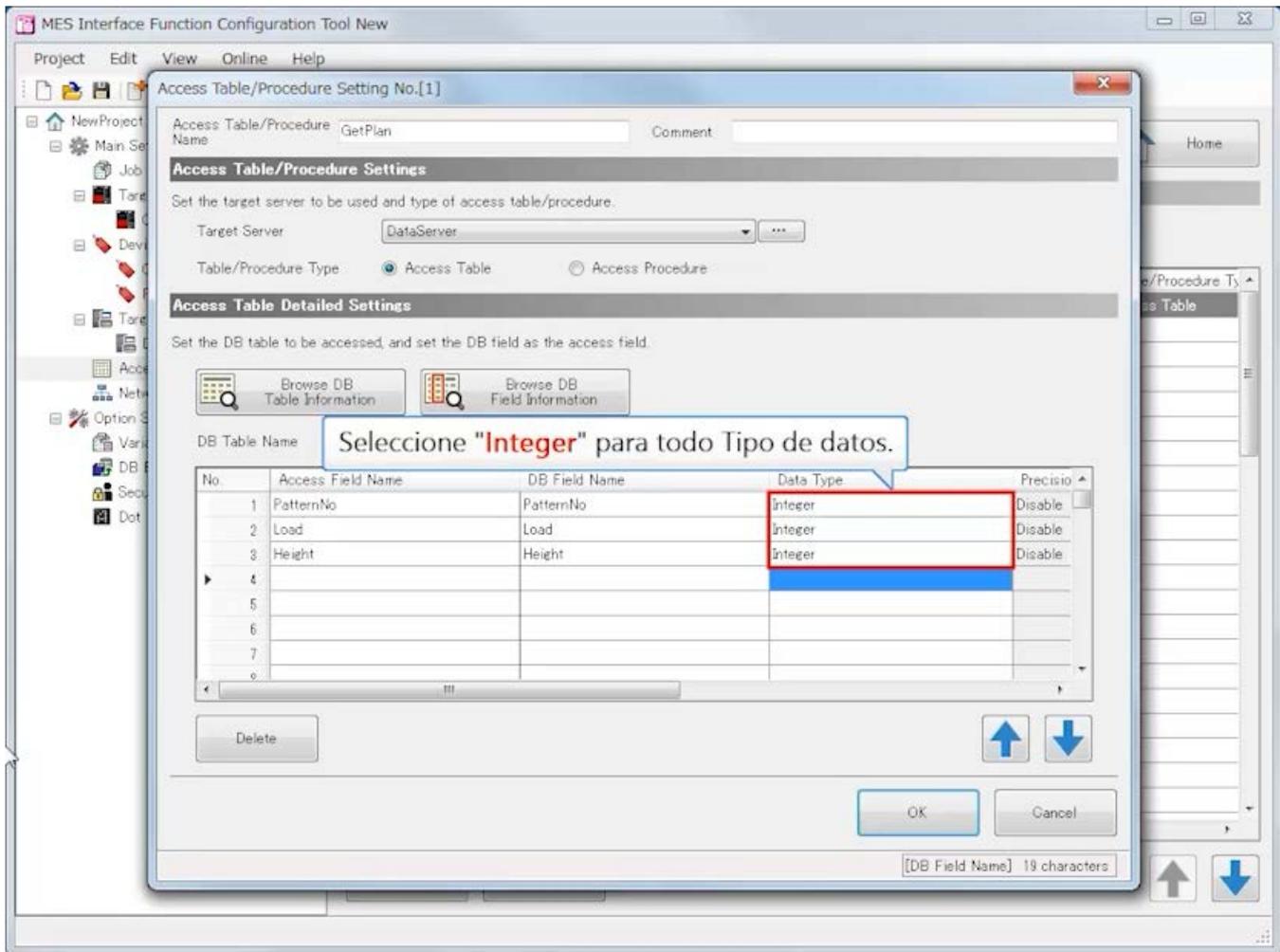
Anterior

Siguiente



Anterior

Siguiente



Anterior

Siguiente

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

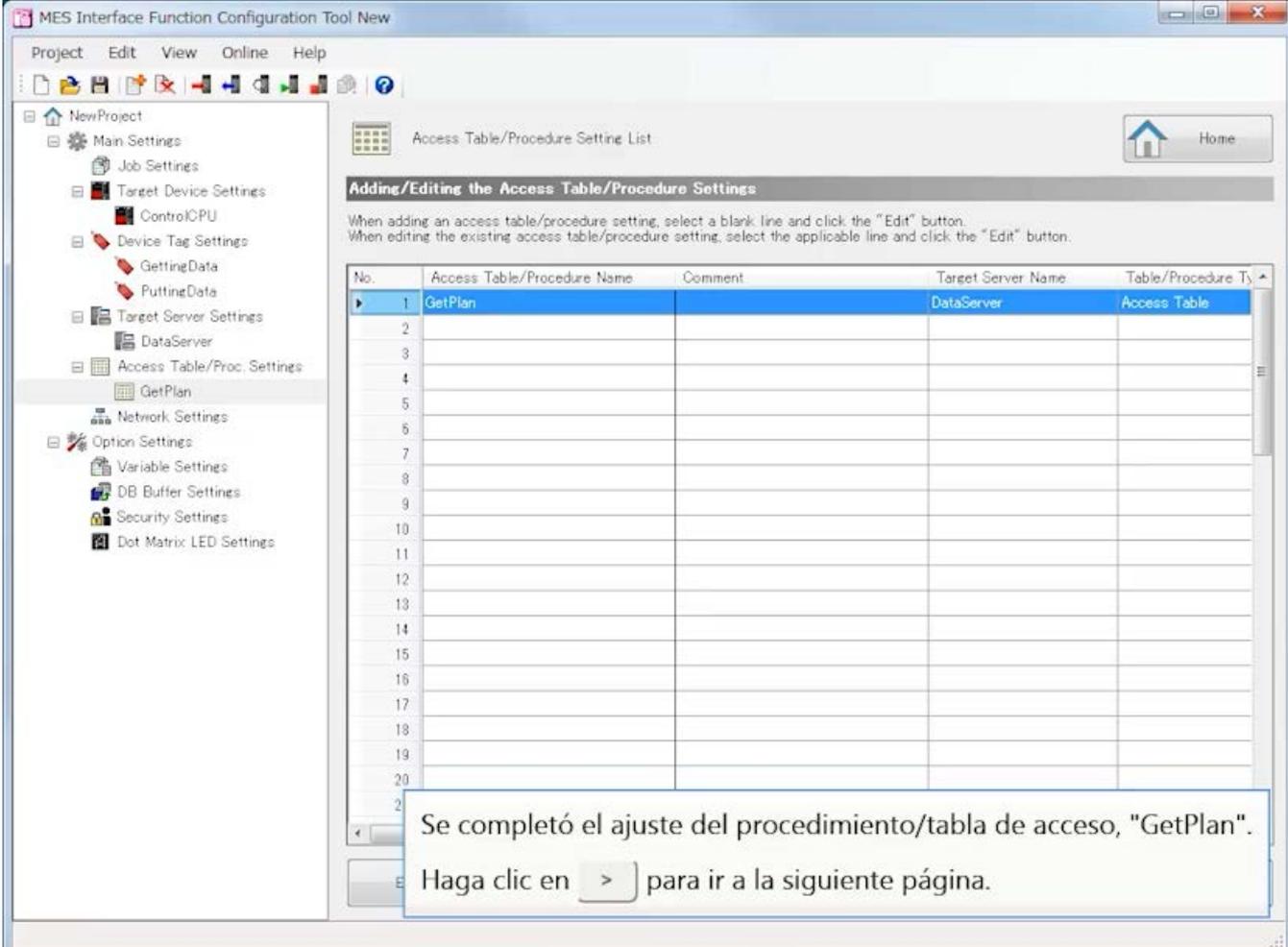
No.	Access Field Name	DB Field Name	Data Type	Precisio
1	PatternNo	PatternNo	Integer	Disable
2	Load	Load	Integer	Disable
3	Height	Height	Integer	Disable
4				
5				
6				
7				
8				

Delete

Ahora, todos los elementos están registrados.
Haga clic en el botón **OK**.

OK Cancel

[DB Field Name] 19 characters

[Anterior](#)[Siguiete](#)

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		DataServer	Access Table
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
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17				
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19				
20				
21				
22				

Se completó el ajuste del procedimiento/tabla de acceso, "GetPlan".
Haga clic en para ir a la siguiente página.

[Anterior](#)[Siguiete](#)

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

Project Edit View Online Help

NewProject

- Main Settings
- Job Settings
 - Target Device Settings
 - ControlCPU
- Device Tag Settings
 - GettingData
 - PuttingData
- Target Server Settings
 - DataServer
- Access Table/Proc. Settings
- GetPlan
- 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.

Haga clic en el botón Reproducir.

	Target Server Name	Table/Procedure Type
1	Server	Access Table
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		
13		
14		
15		
16		
17		
18		
19		
20		
21		

Edit Delete

↑ ↓

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

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

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

Luego, establezca el segundo procedimiento/tabla de acceso. Haga clic derecho en la fila no. 2 de la Access Table/Procedure Setting List.

Edit Delete

↑ ↓

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

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

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

Edit

Delete

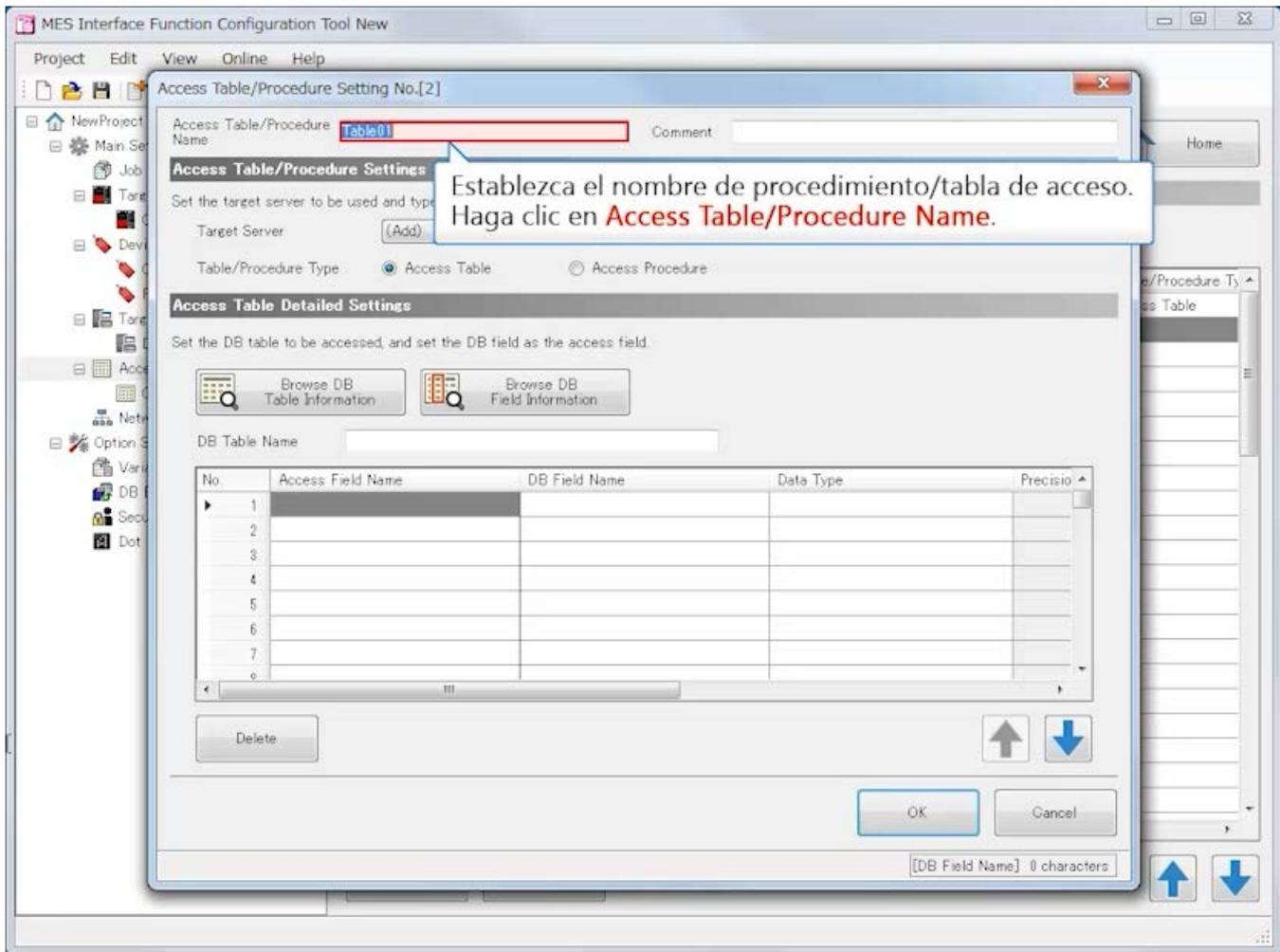
↑

↓

Seleccione Editar y establezca el procedimiento y la tabla de acceso.
Haga clic en **Edit** desde el menú.

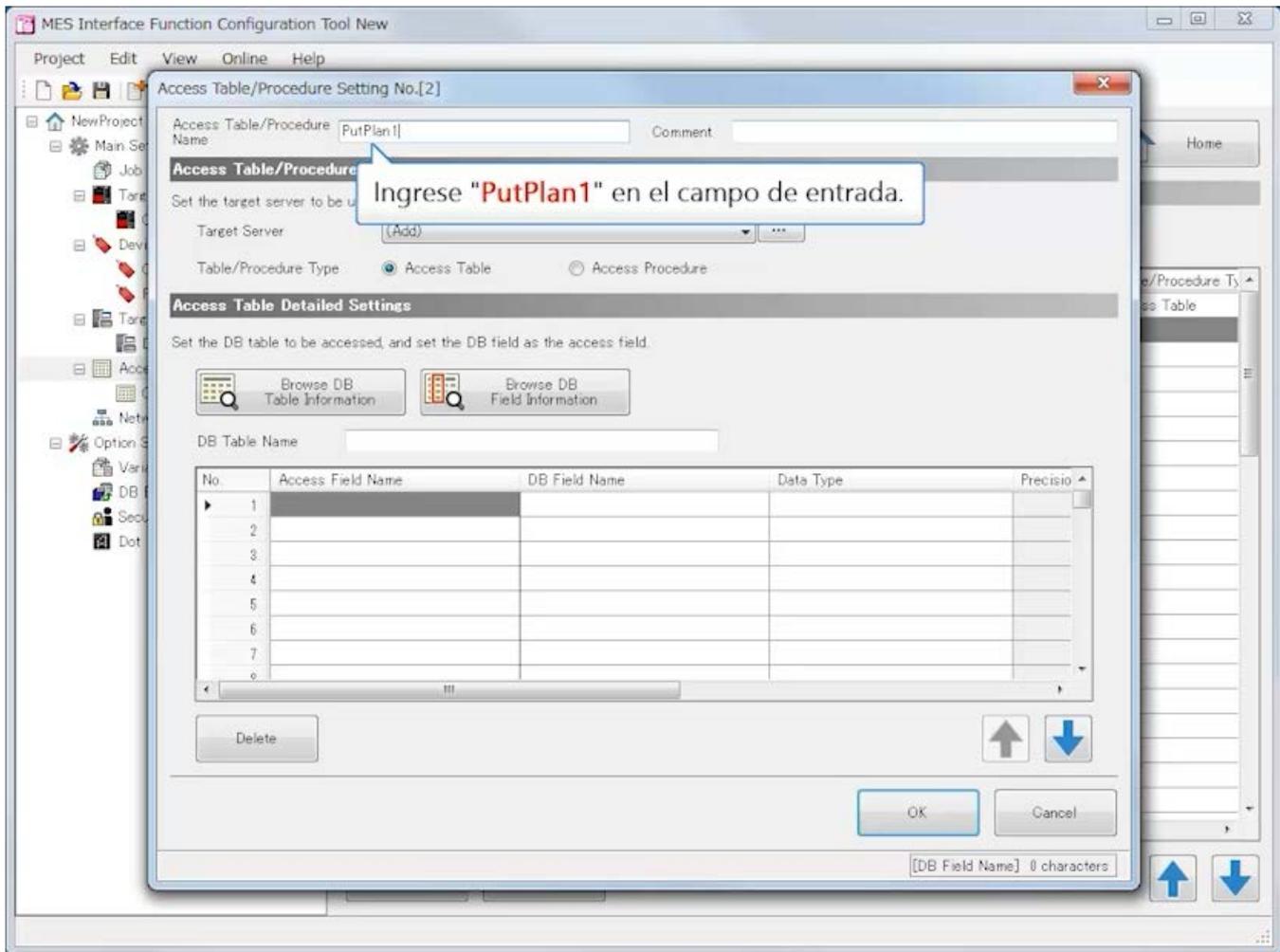
Anterior

Siguiente



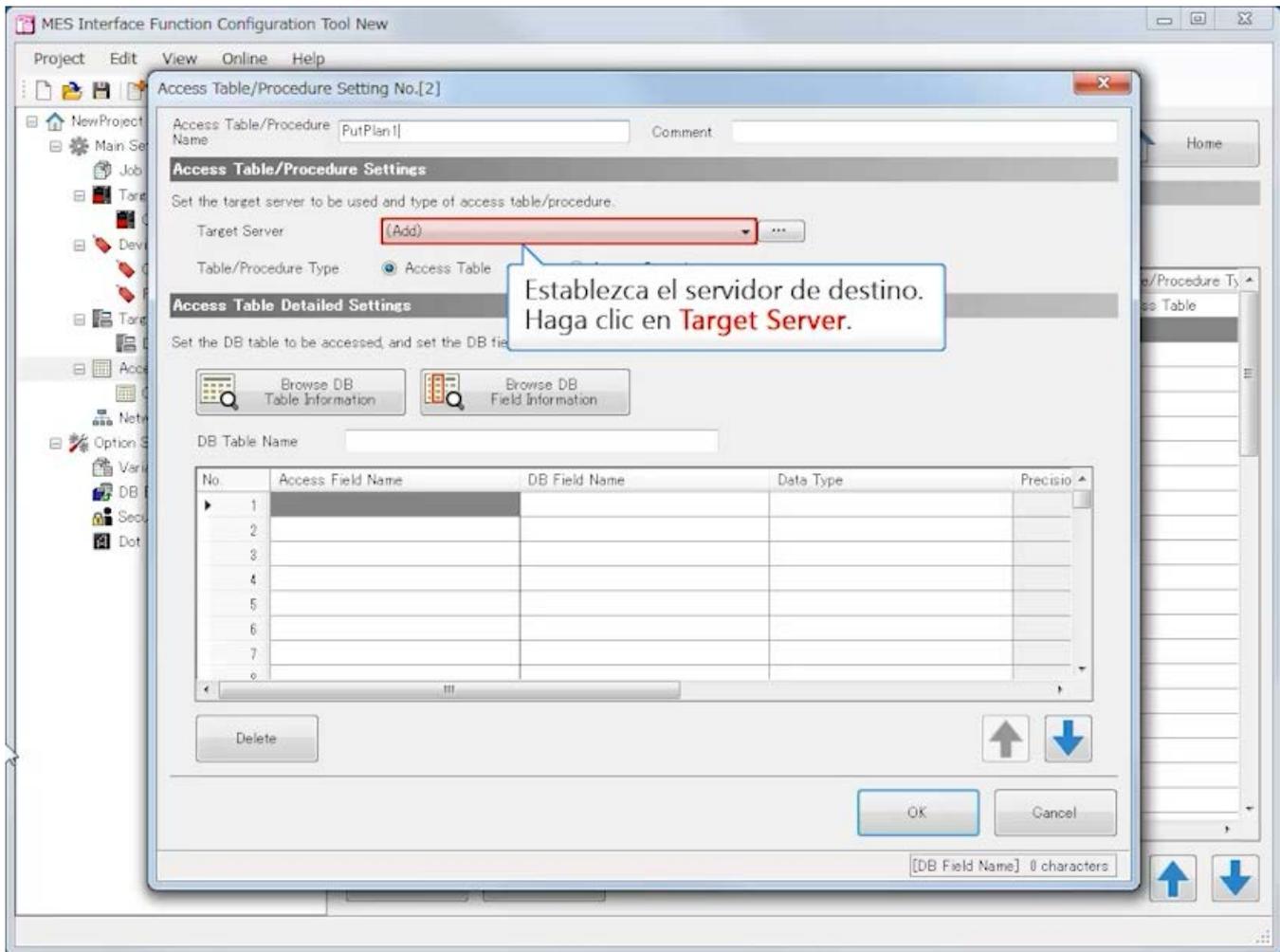
Anterior

Siguiente



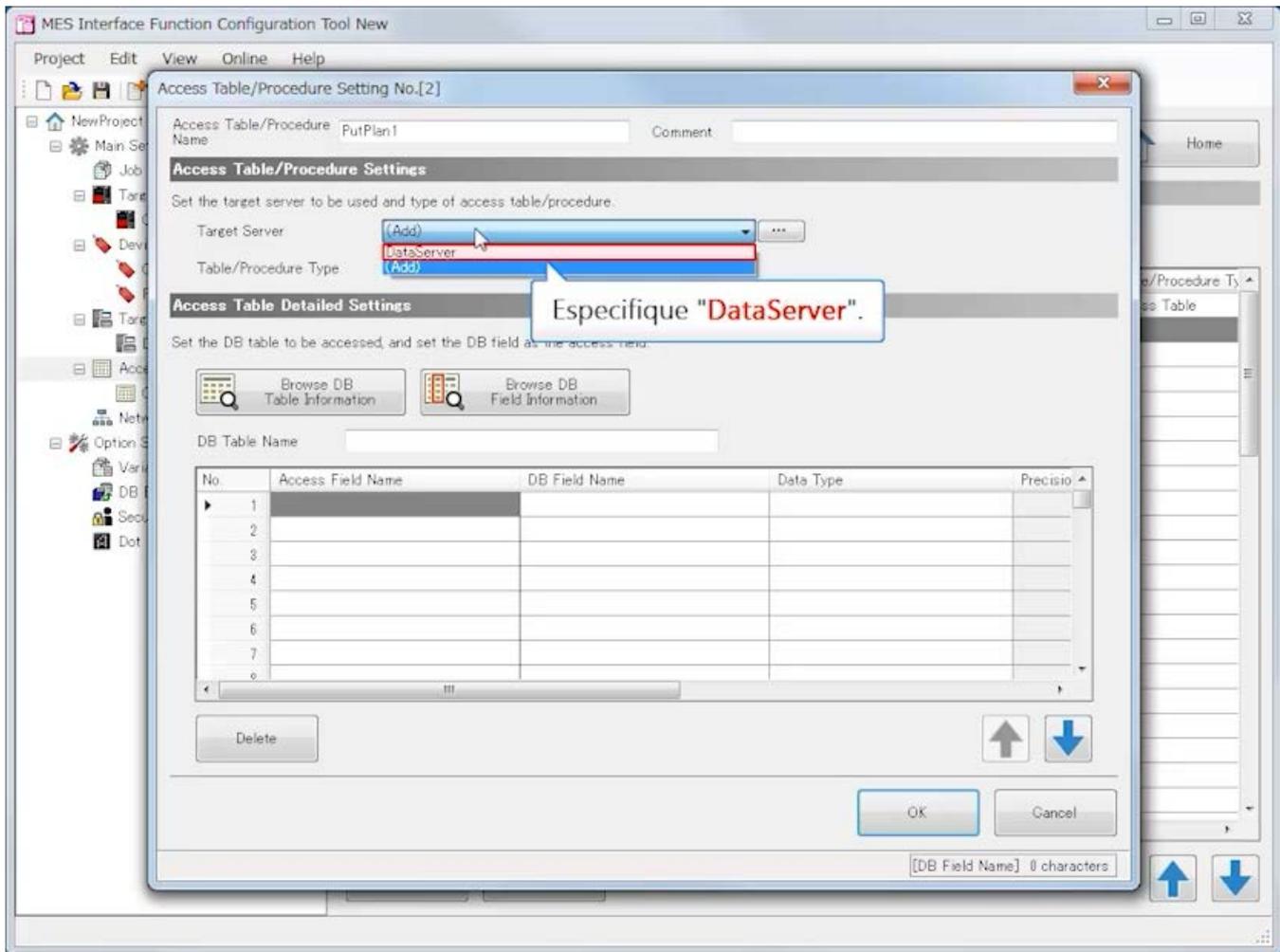
Anterior

Siguiente



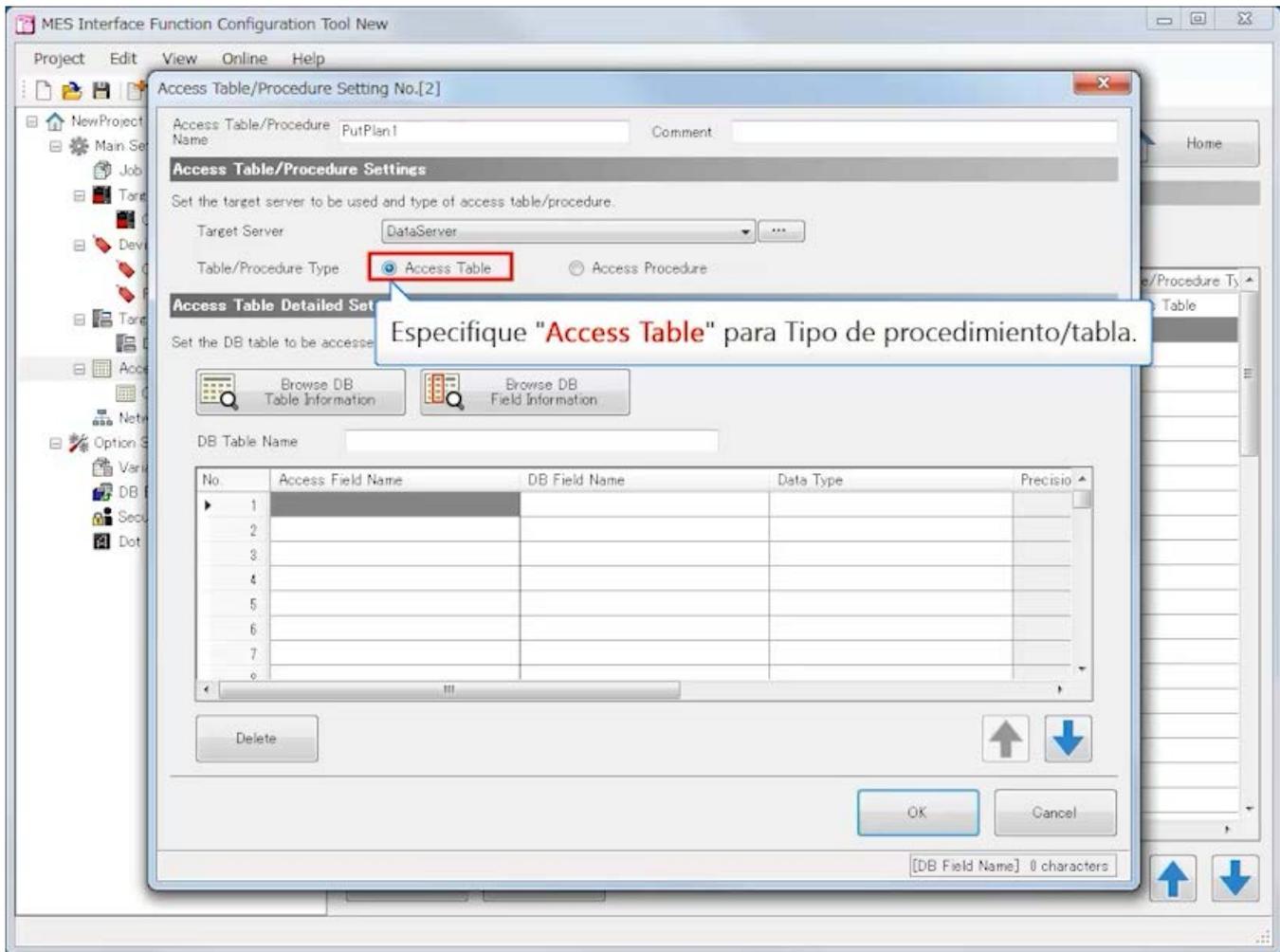
Anterior

Siguiente



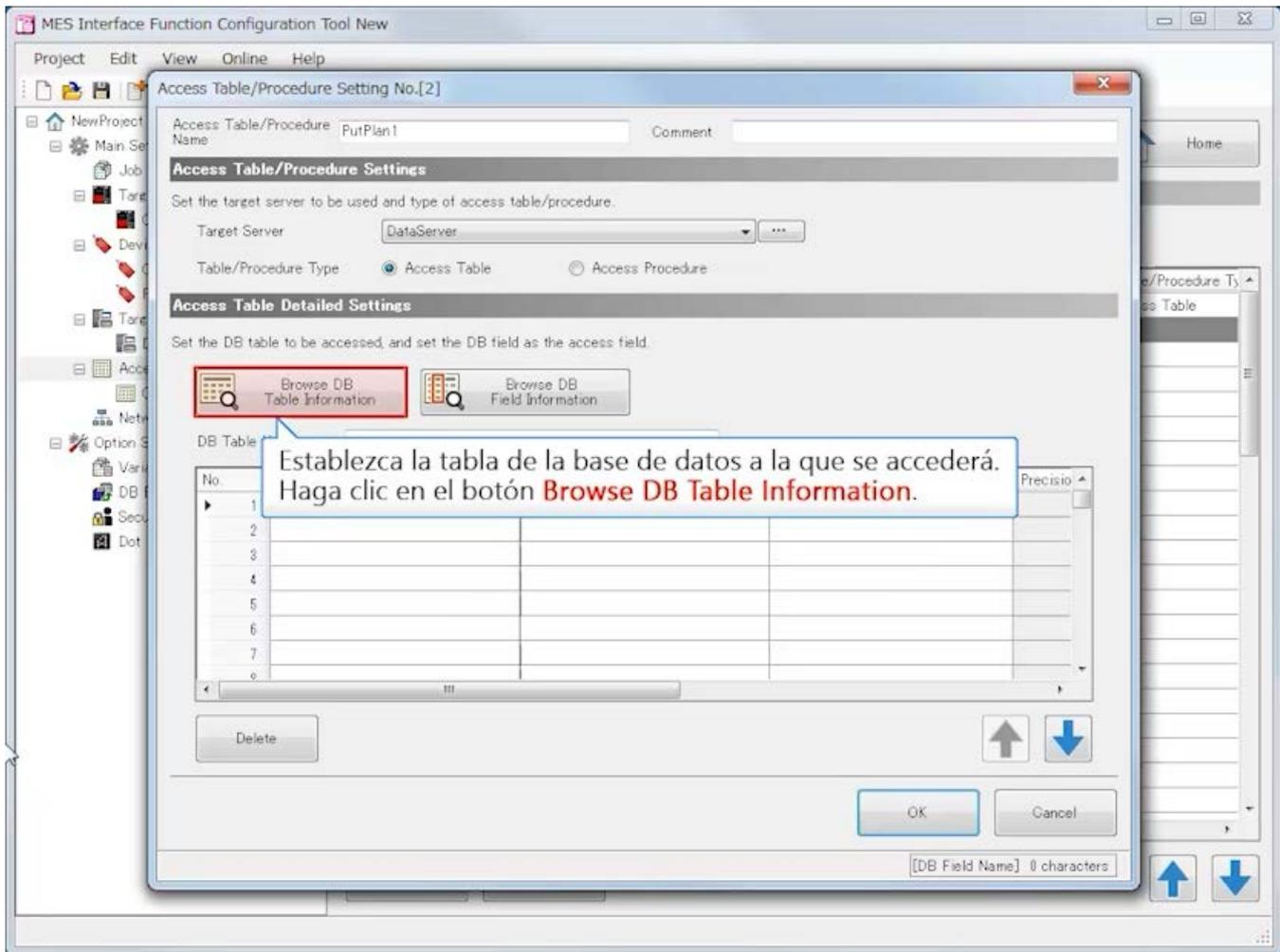
Anterior

Siguiente



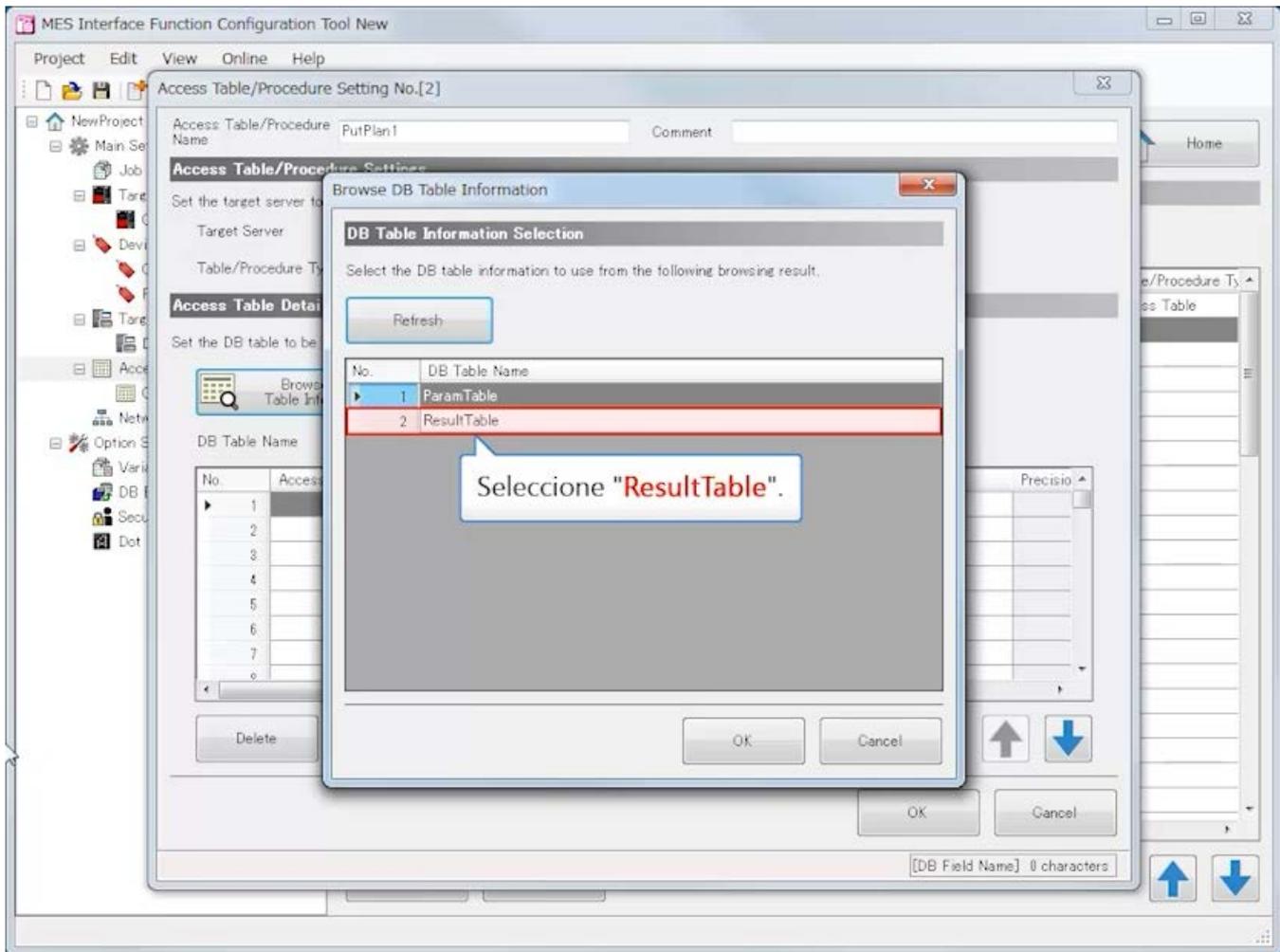
Anterior

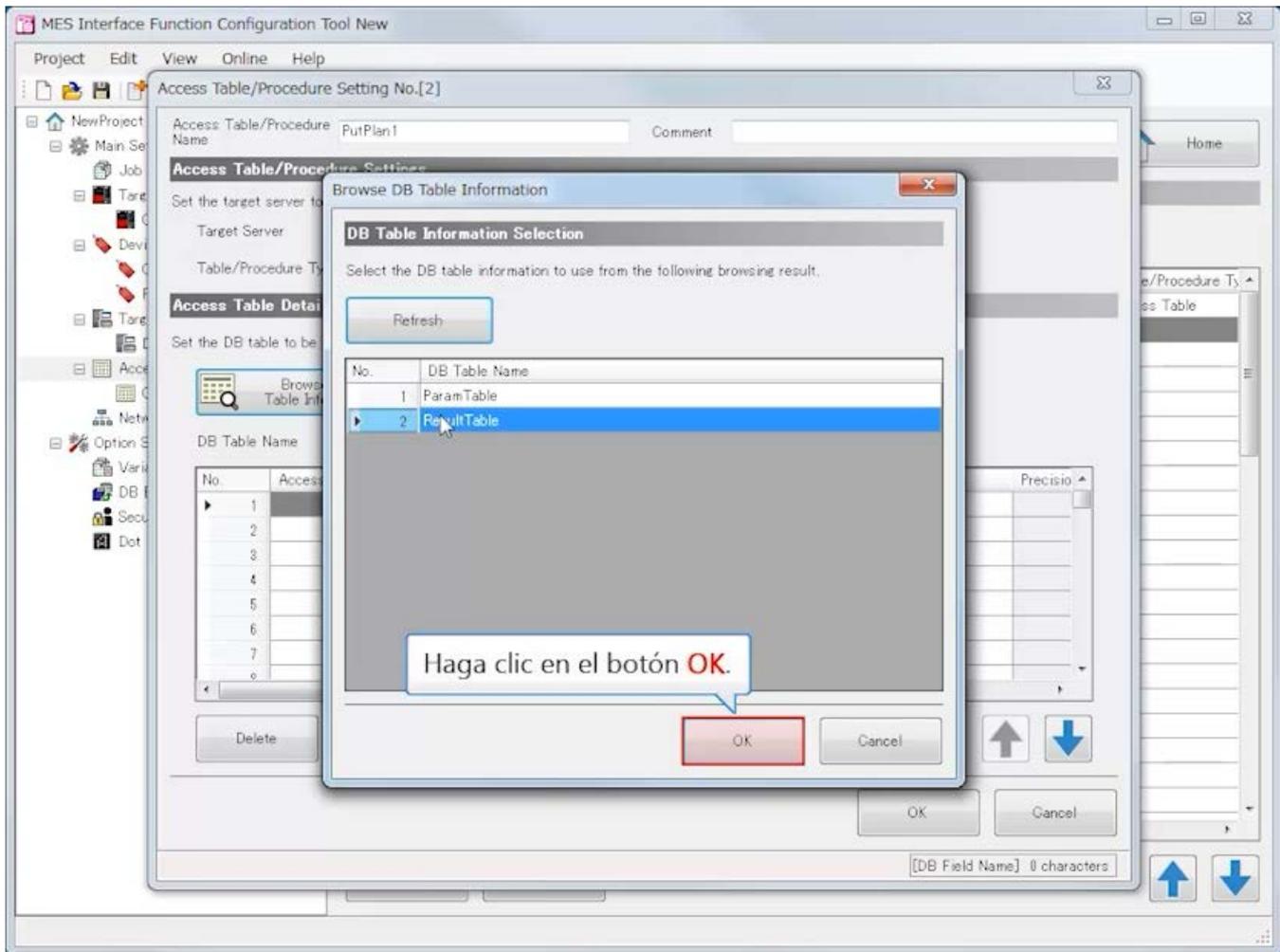
Siguiente



Anterior

Siguiente



[Anterior](#)[Siguiete](#)

Anterior

Siguiete

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment: _____

Access Table/Procedure Settings

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

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

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

DB Table Name: ResultTable

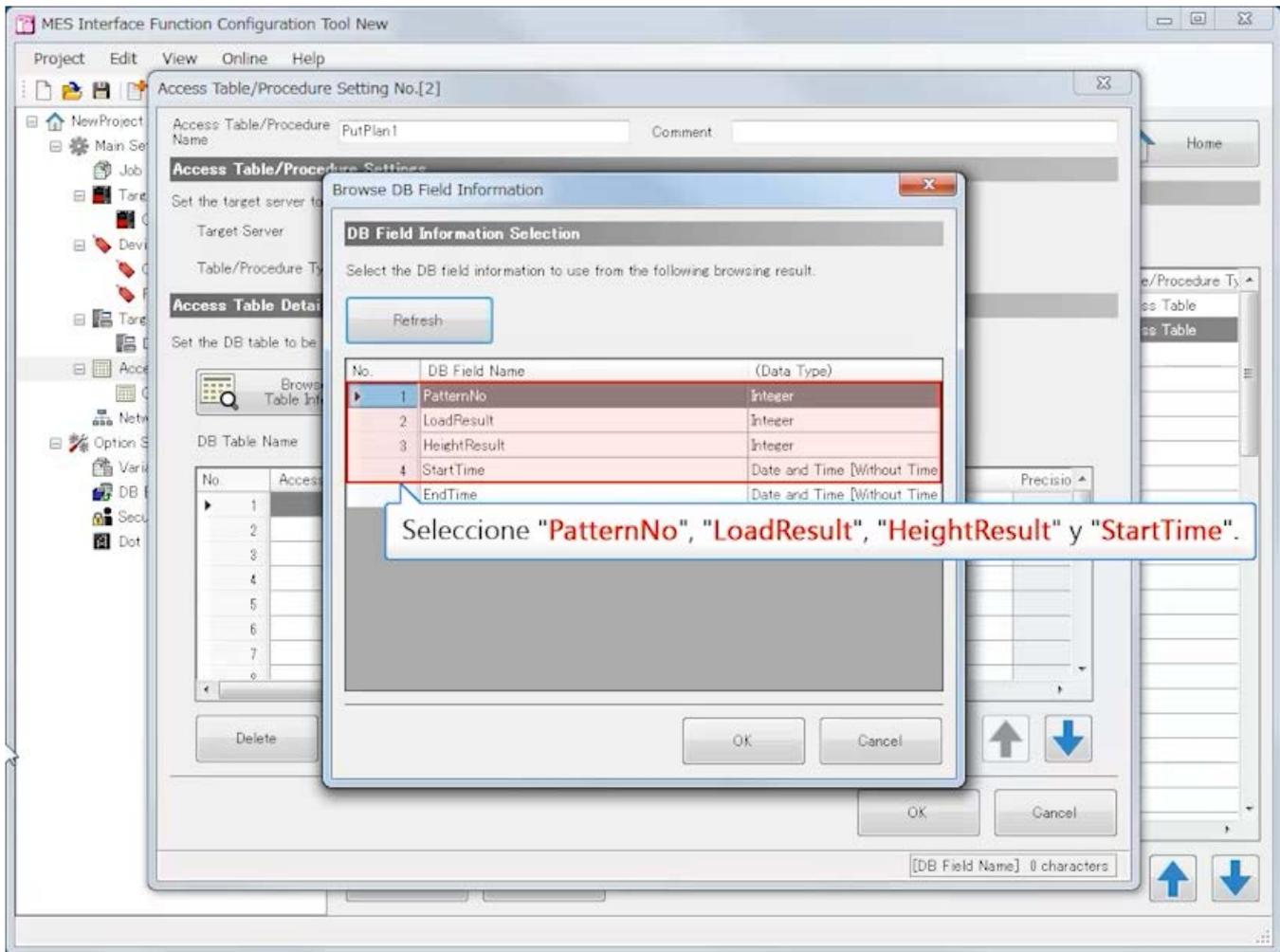
Buttons: Browse DB Table Information, Browse DB Field Information

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

Buttons: Delete, OK, Cancel

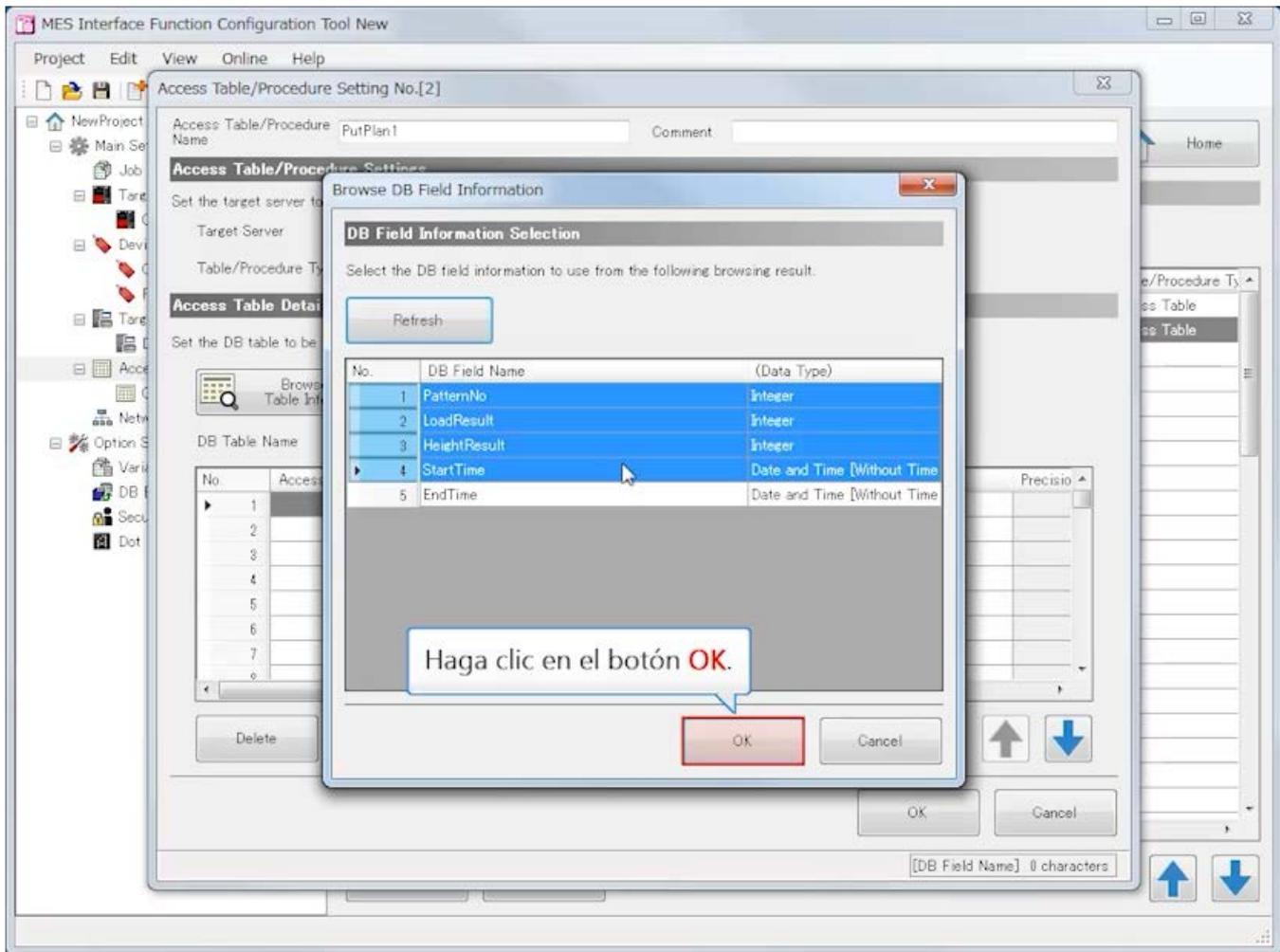
[DB Field Name] 0 characters

Callout: Establezca el campo de acceso. Haga clic en el botón **Browse DB Field Information**.

[Anterior](#)[Siguiente](#)

Anterior

Siguiente



Anterior

Siguiente

Seleccione "Integer" para Tipos de datos de "PatternNo", "LoadResult" y "HeightResult", y seleccione "Date and Time [Without Time Zone]" para Tipo de datos de "StartTime".

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

Anterior

Siguiente

Access Table/Procedure Setting No.[2]

Access Table/Procedure Name: PutPlan1 Comment:

Access Table/Procedure Settings

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

Target Server: DataServer

Table/Procedure Type: Access Table Access Procedure

Access Table Detailed Settings

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

Browse DB Table Information Browse DB Field Information

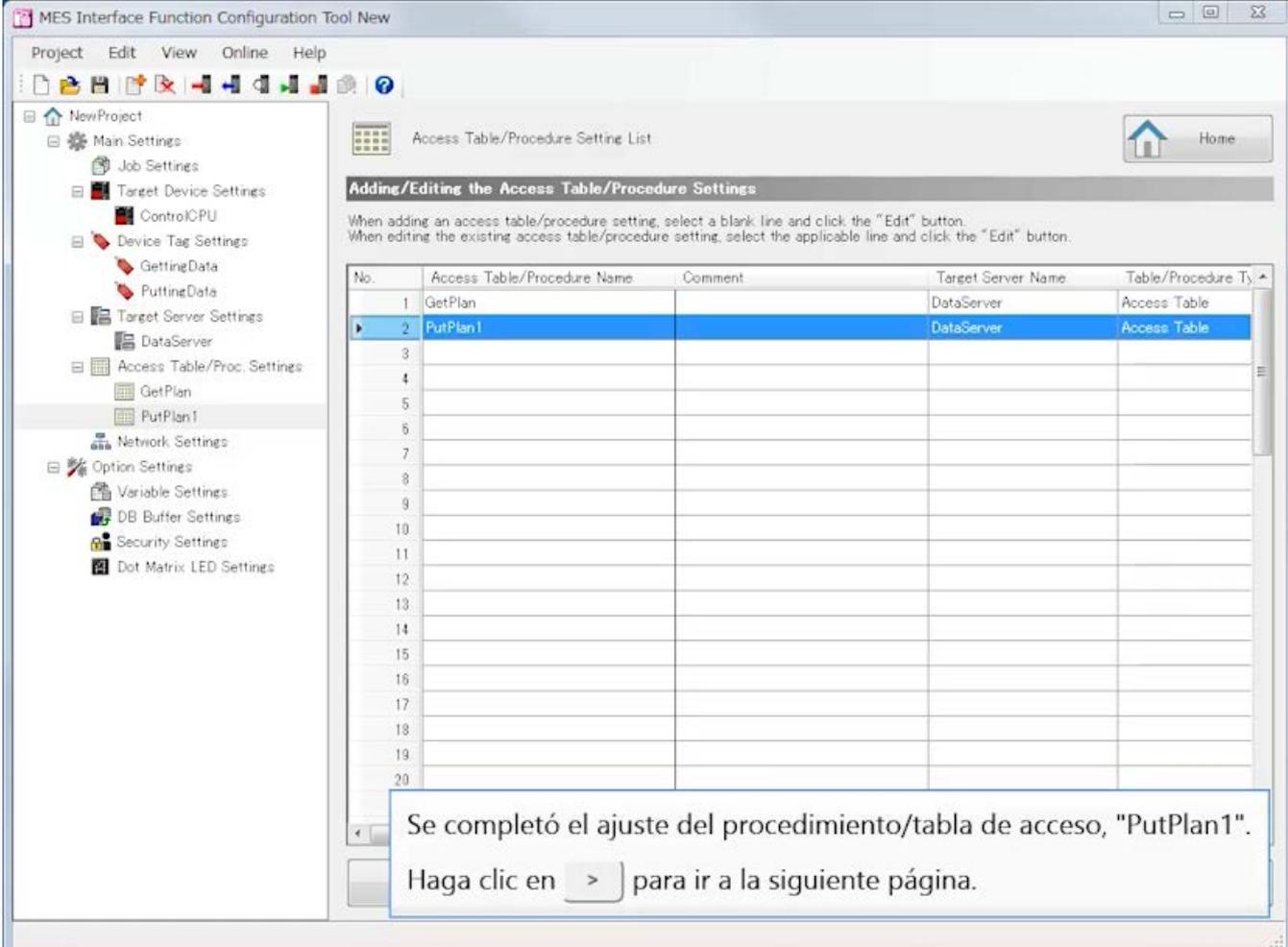
DB Table Name: ResultTable

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

Ahora, todos los elementos están registrados.
Haga clic en el botón **OK**.

Delete OK Cancel

[DB Field Name] 40 characters

[Anterior](#)[Siguiete](#)

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		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3				
4				
5				
6				
7				
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9				
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11				
12				
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18				
19				
20				

Se completó el ajuste del procedimiento/tabla de acceso, "PutPlan1".
Haga clic en > para ir a la siguiente página.

Anterior

Siguiente

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

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

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

Haga clic en el botón Reproducir.

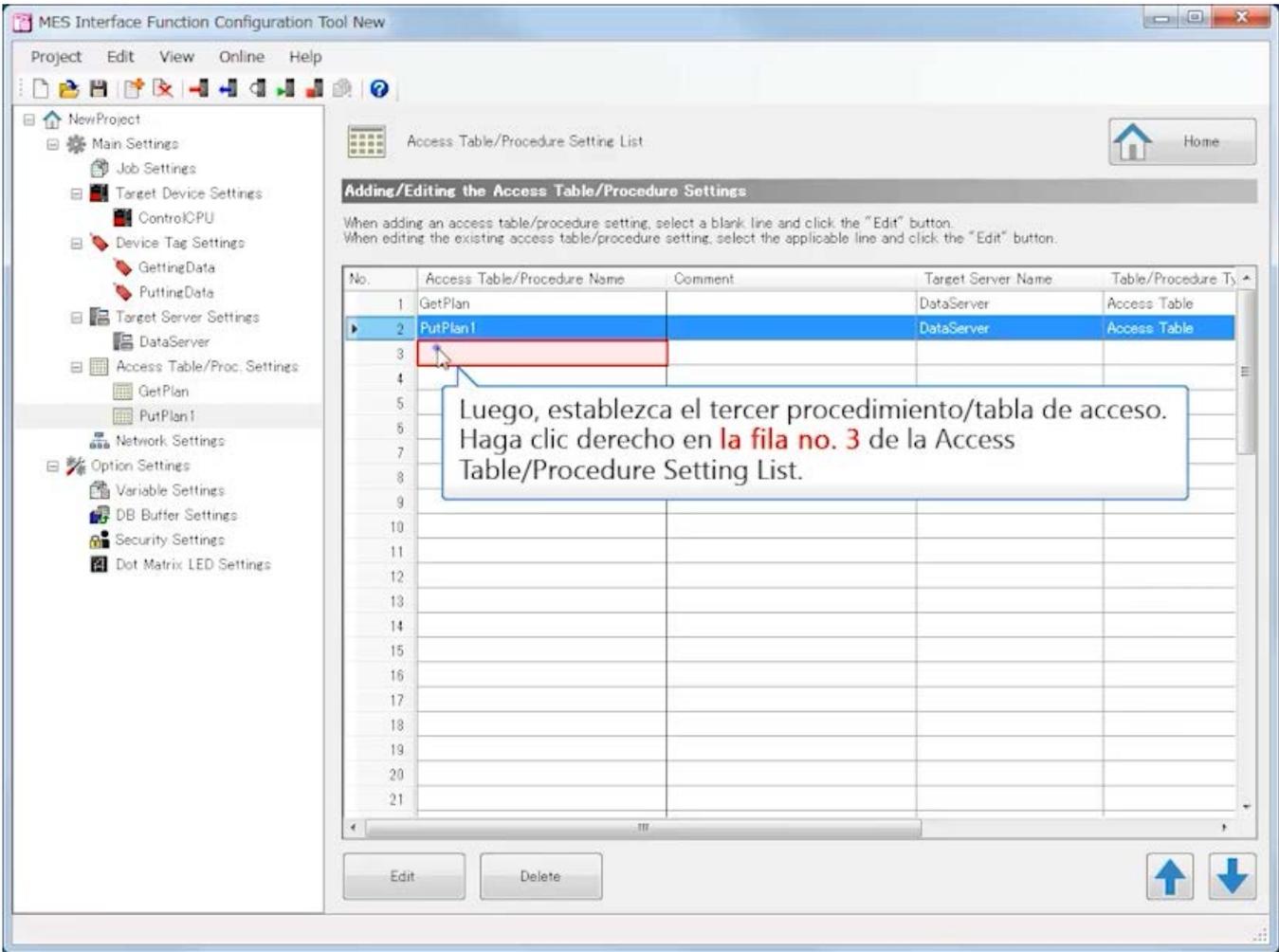
	Set Server Name	Table/Procedure Ty
2	PutPlan1	Access Table
3		
4		
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20		
21		

Edit Delete

Up Arrow Down Arrow

Anterior

Siguiente



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		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3				
4				
5				
6				
7				
8				
9				
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21				

Luego, establezca el tercer procedimiento/tabla de acceso.
Haga clic derecho en la fila no. 3 de la Access Table/Procedure Setting List.

Edit Delete

↑ ↓

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Edit View Online Help

Access Table/Procedure Setting List

Home

Adding/Editing the Access Table/Procedure Settings

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

No.	Access Table/Procedure Name	Comment	Target Server Name	Table/Procedure Type
1	GetPlan		DataServer	Access Table
2	PutPlanI		DataServer	Access Table
3				
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20				
21				

Edit Delete Add C

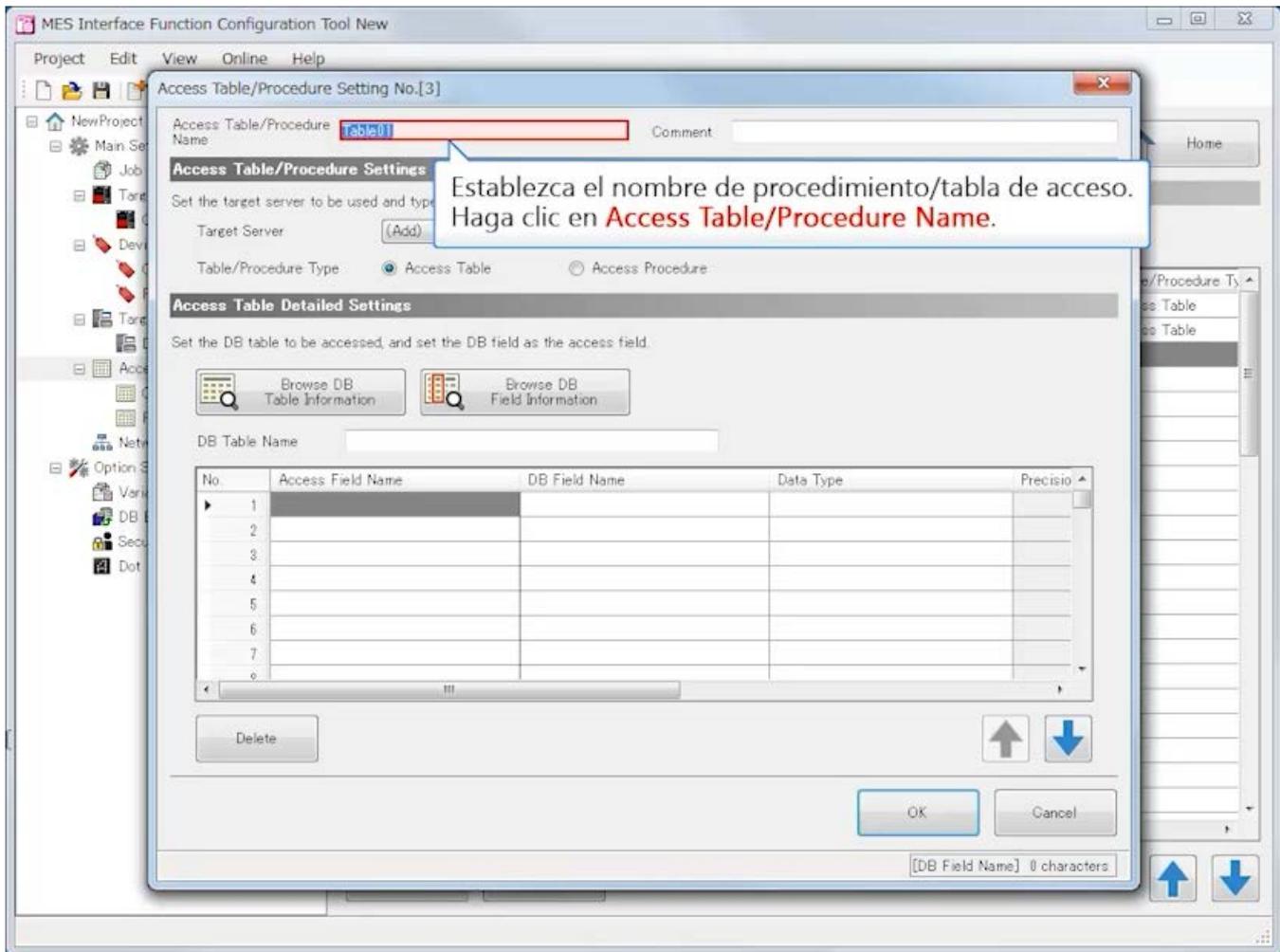
Seleccione Editar y establezca el procedimiento y la tabla de acceso. Haga clic en **Edit** desde el menú.

Edit Delete

↑ ↓

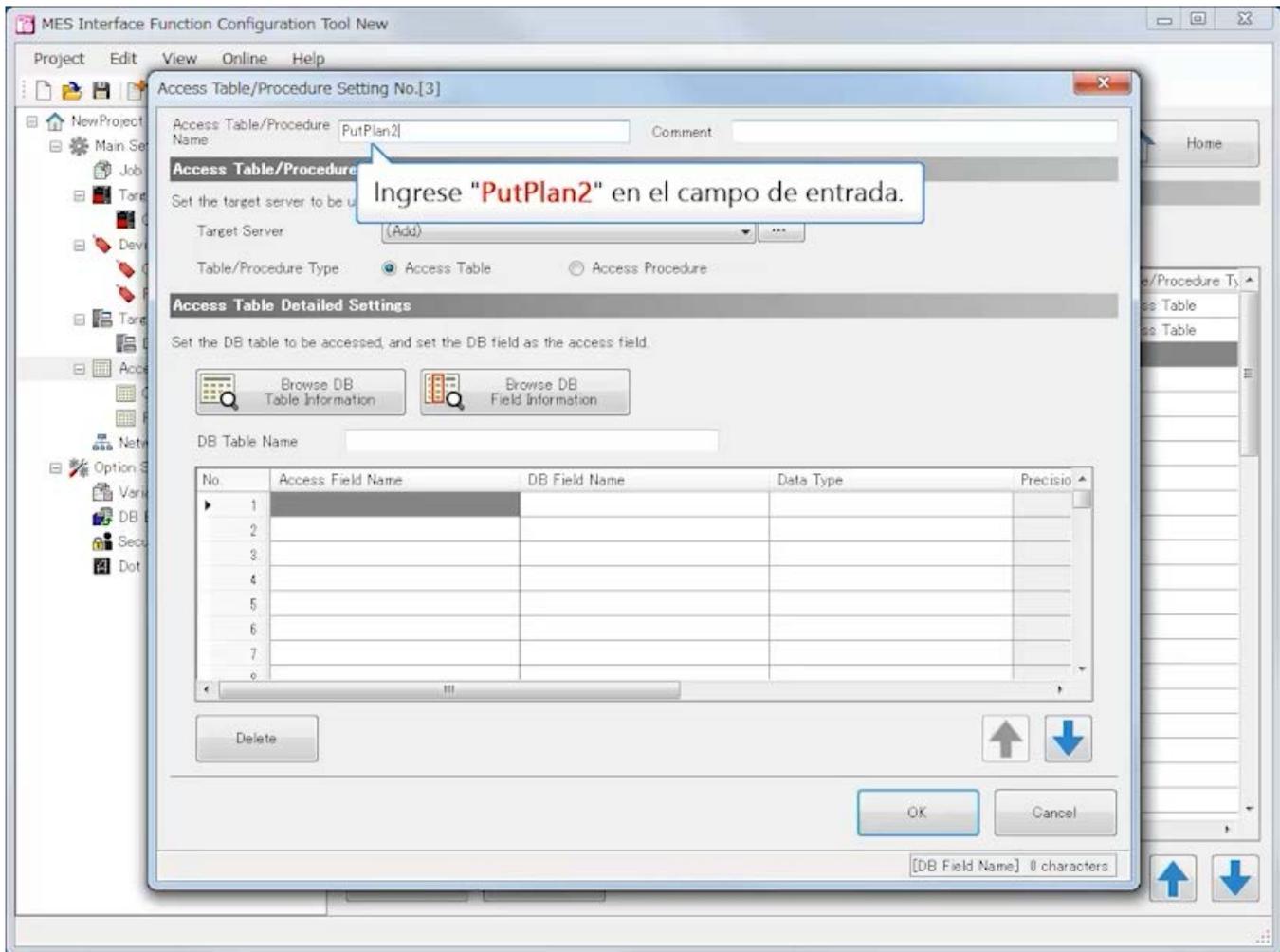
Anterior

Siguiente



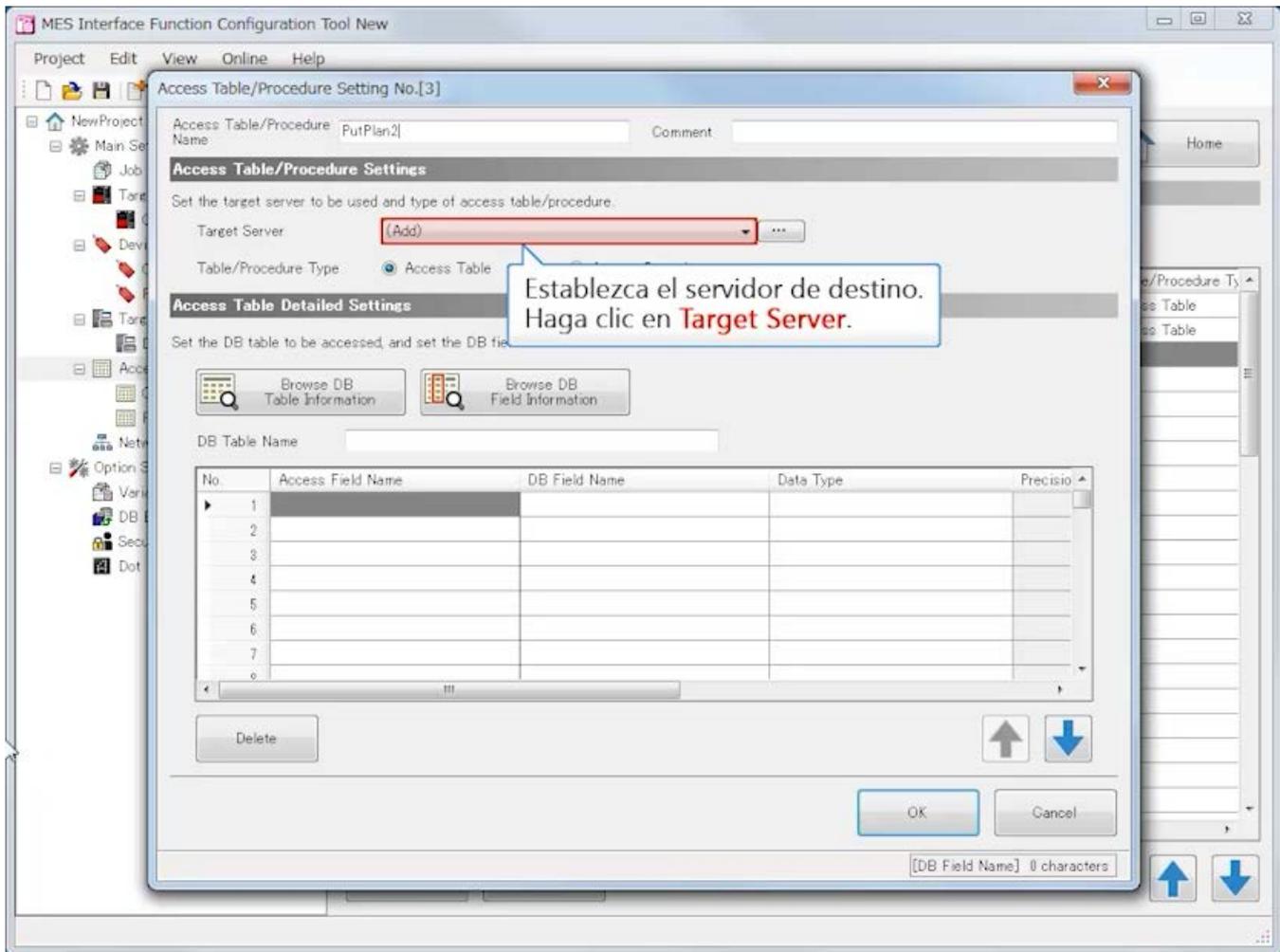
Anterior

Siguiente



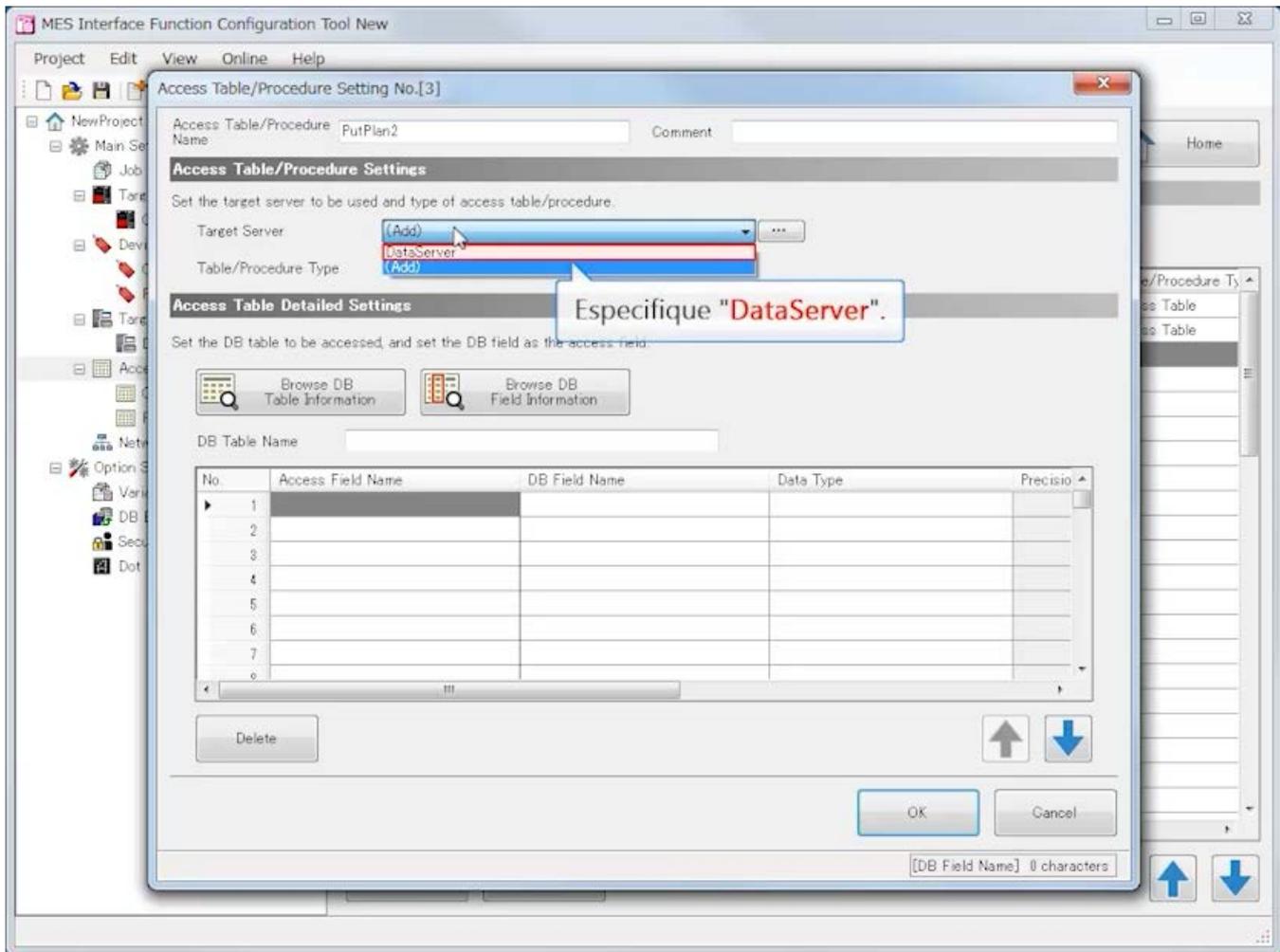
Anterior

Siguiente



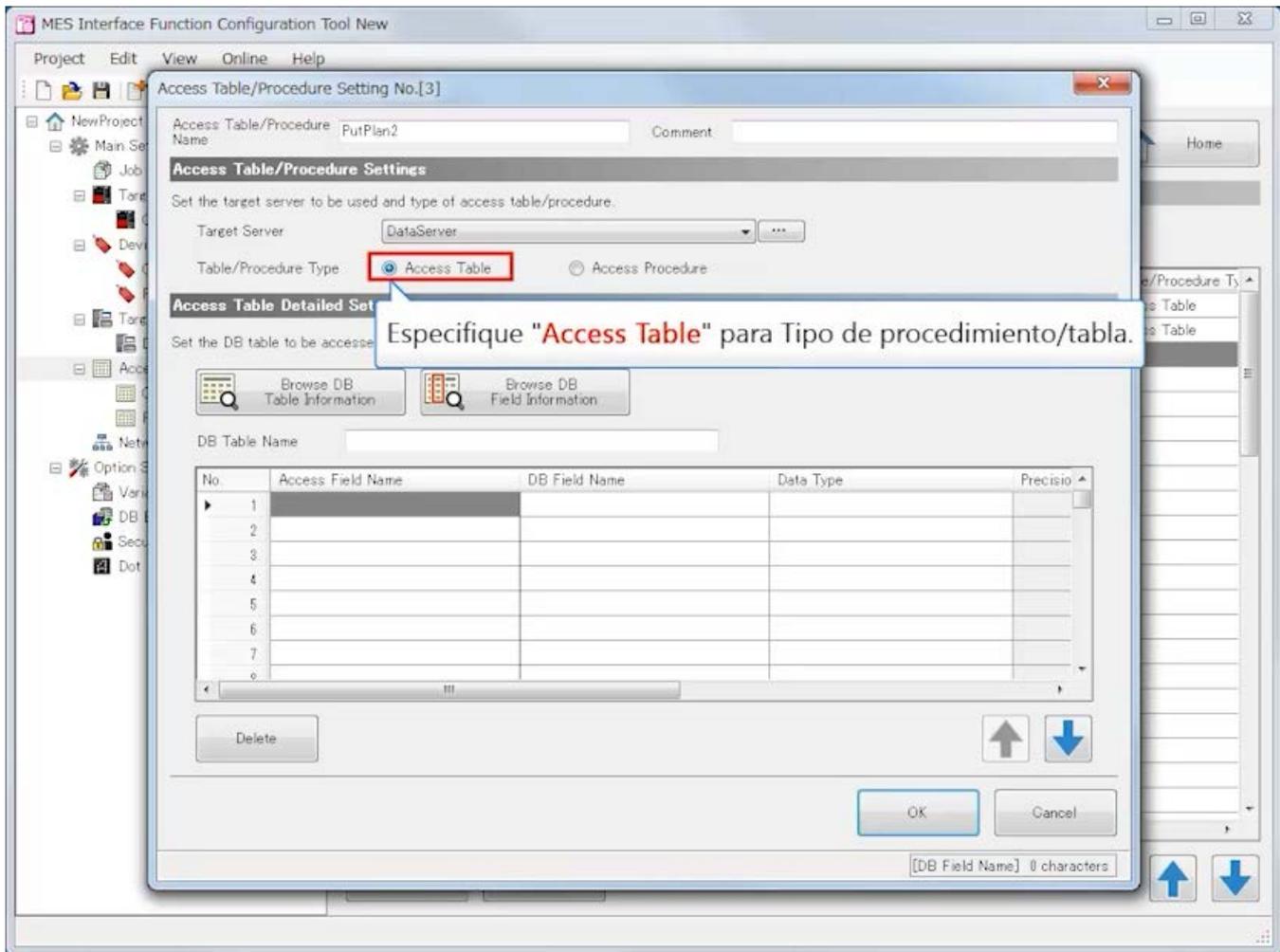
Anterior

Siguiente



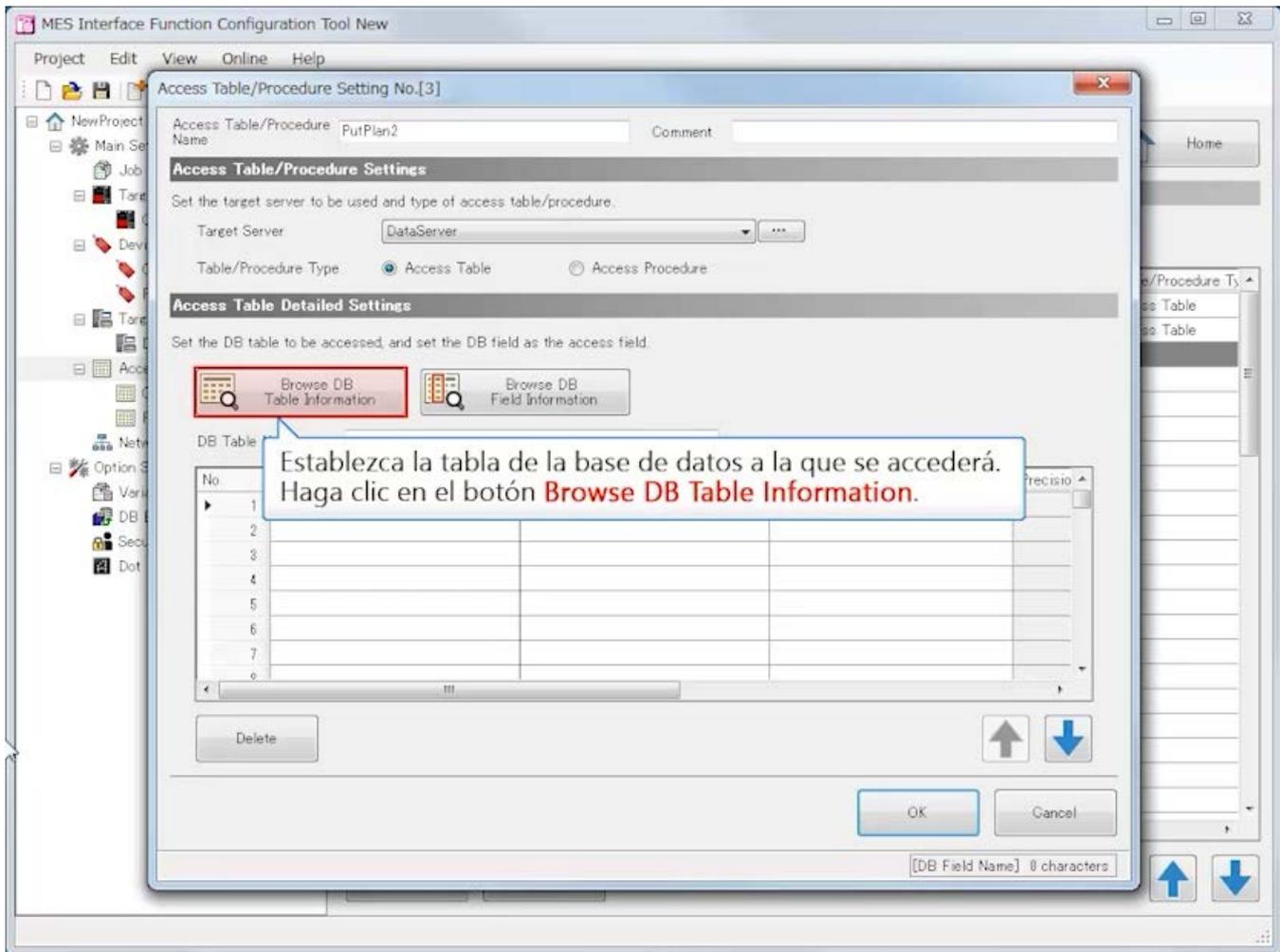
Anterior

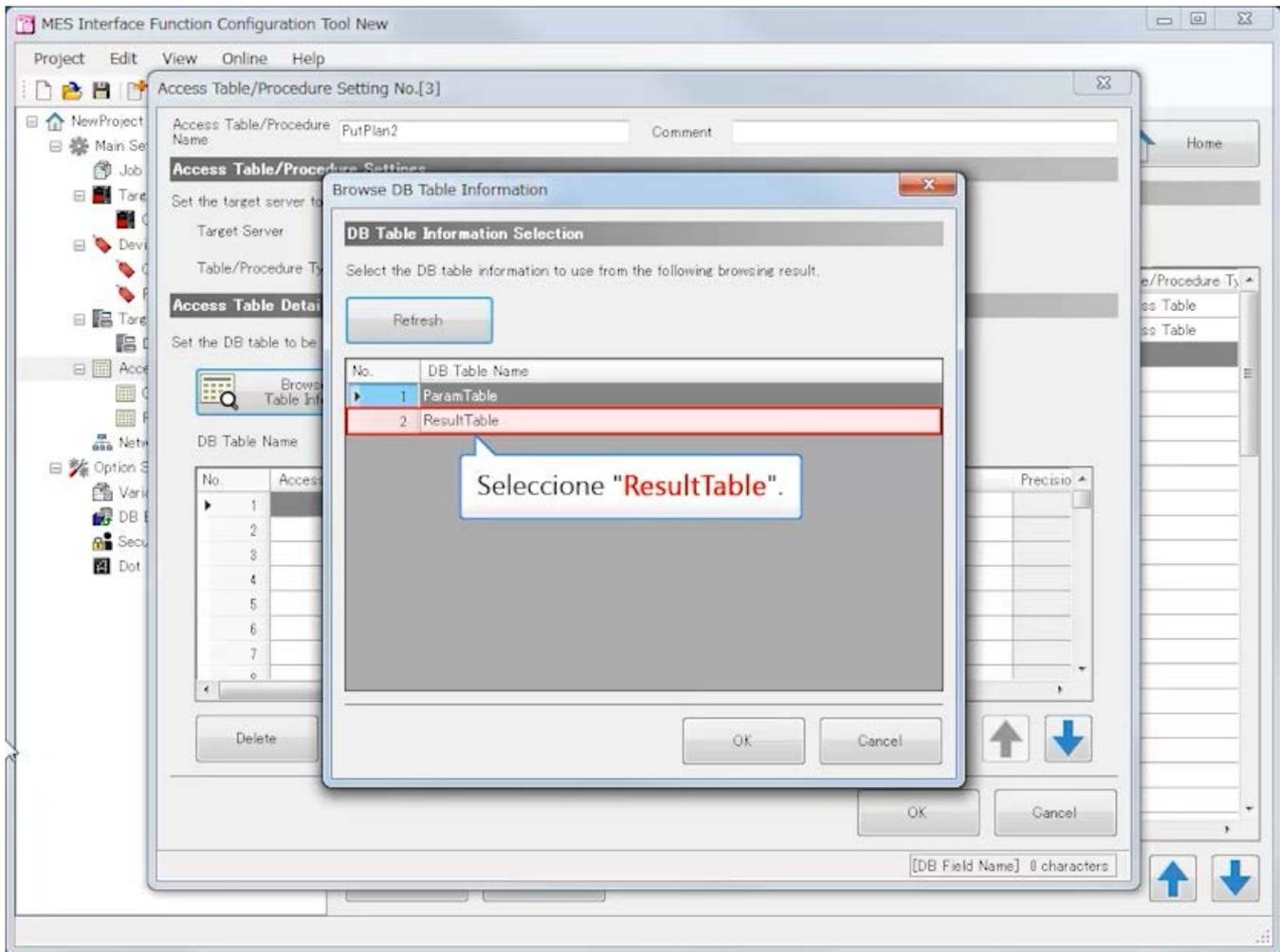
Siguiente

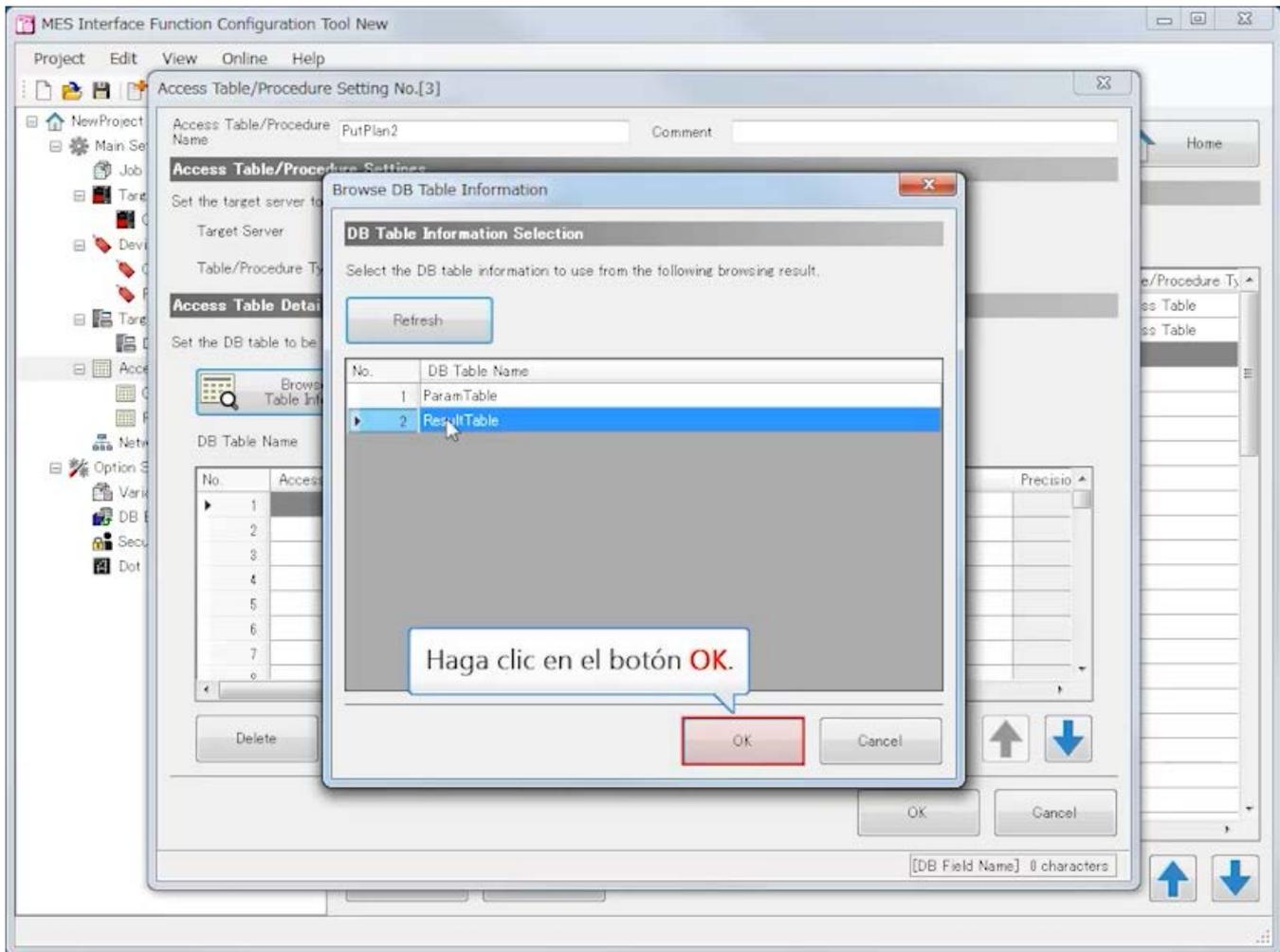


Anterior

Siguiente



[Anterior](#)[Siguiente](#)

[Anterior](#)[Siguiente](#)

Anterior

Siguiente

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
1	
2	
3	
4	
5	
6	
7	
8	

Delete

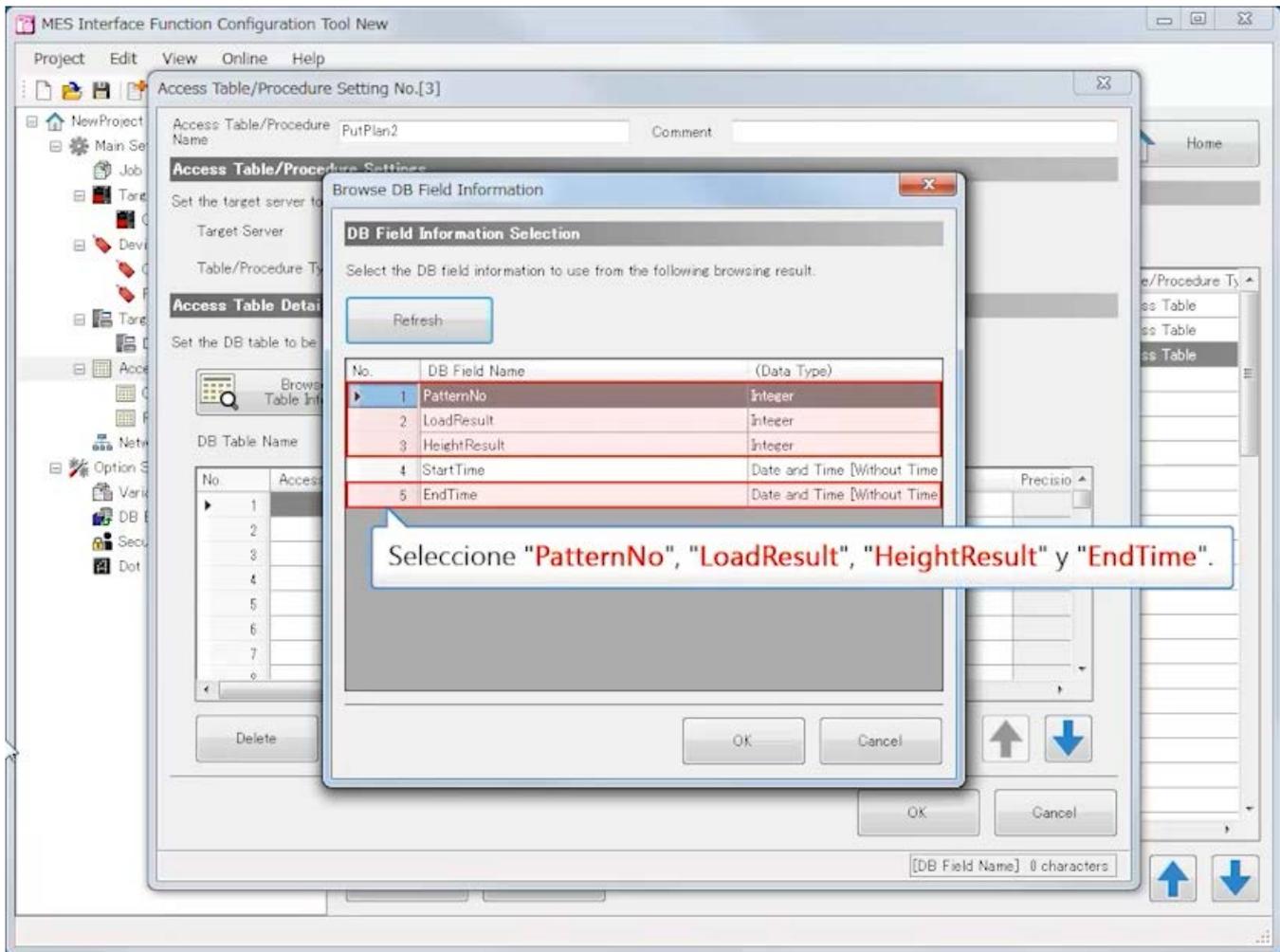
OK Cancel

[DB Field Name] 0 characters

Establezca el campo de acceso.
Haga clic en el botón **Browse DB Field Information**.

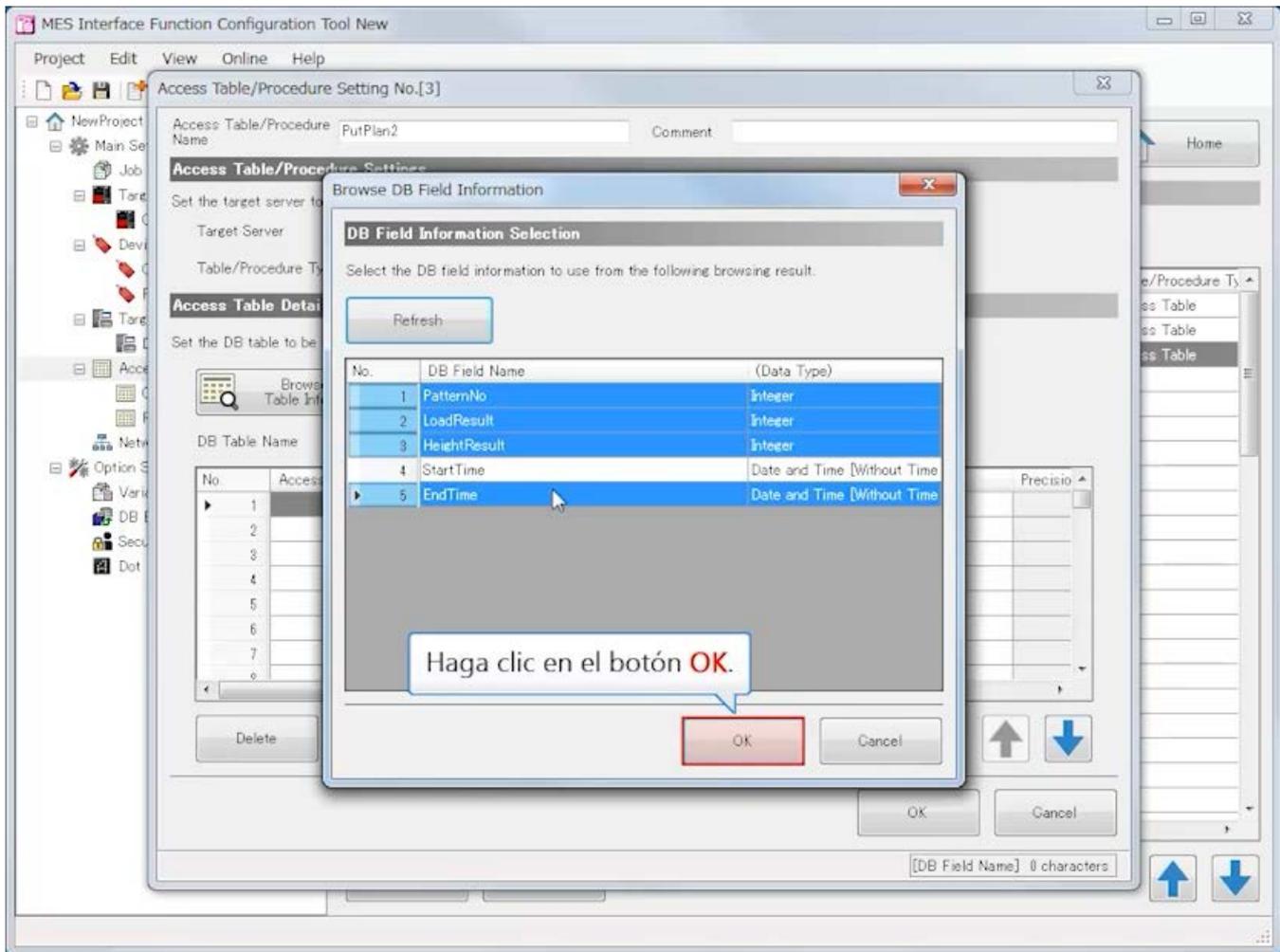
Anterior

Siguiente



Anterior

Siguiente



Anterior

Siguiente

Seleccione **"Integer"** para Tipos de datos de "PatternNo", "LoadResult" y "HeightResult", y seleccione **"Date and Time [Without Time Zone]"** para Tipo de datos de "EndTime".

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

Anterior

Siguiente

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

Ahora, todos los elementos están registrados.
Haga clic en el botón **OK**.

OK Cancel

[DB Field Name] 38 characters

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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		DataServer	Access Table
2	PutPlan1		DataServer	Access Table
3	PutPlan2		DataServer	Access Table
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				

Se completó el ajuste del procedimiento/tabla de acceso, "PutPlan2".
Haga clic en para ir a la siguiente página.

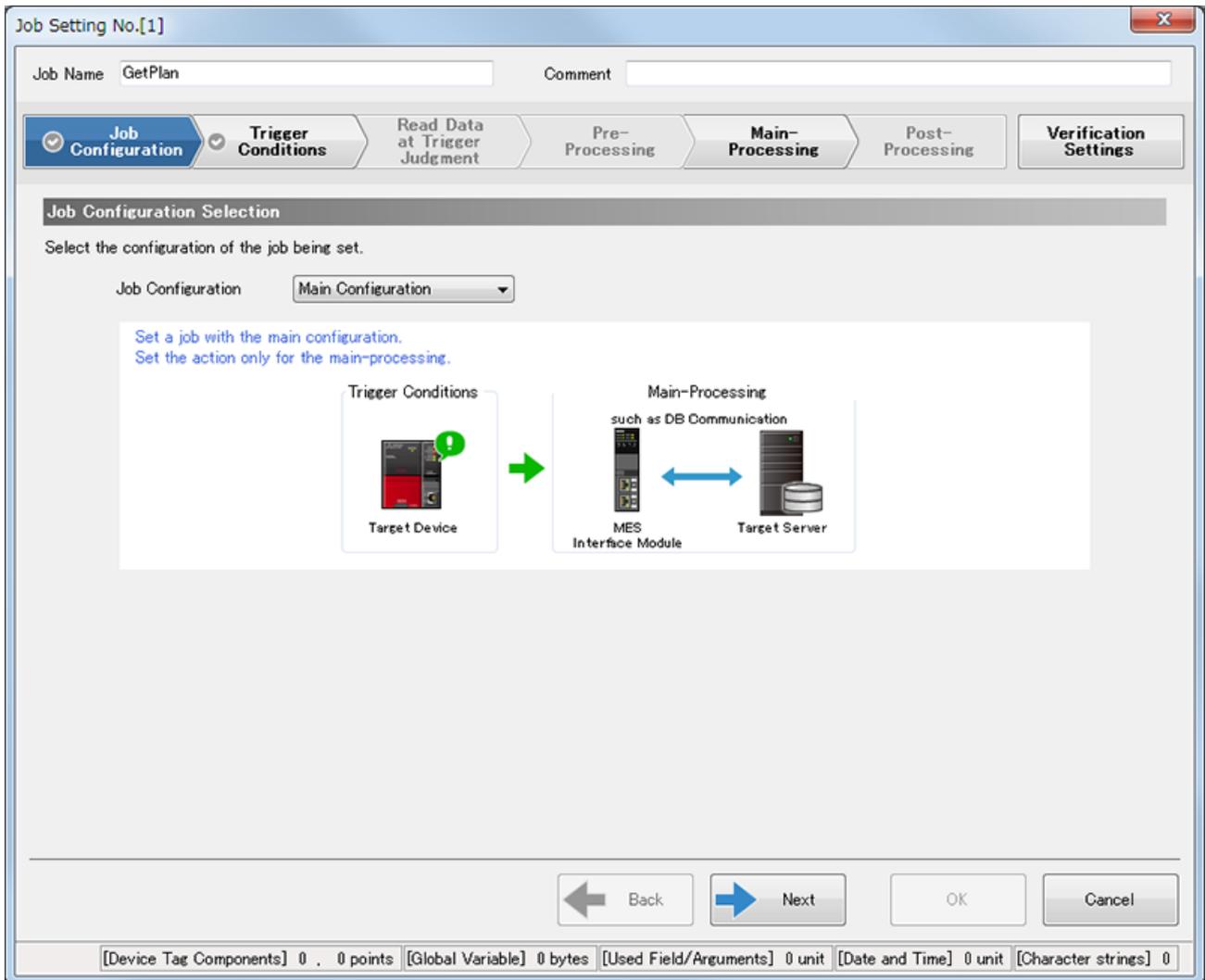
[Job Settings]

Cree un trabajo que extraiga los datos de la base de datos cuando la fabricación esté lista.

(1) Job Name: GetPlan

[Job Configuration]

Job Configuration: Main Configuration



[Trigger Conditions]

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

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

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[1]

Job Name: GetPlan Comment: _____

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

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type:

Condition Combination Type:

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

Event/Condition Settings

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

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

Trigger Buffering Setting (optional)

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

Trigger Buffering:

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

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

[Read Data at Trigger Judgment]

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

Job Setting No.[1]

Job Name: GetPlan Comment: _____

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

Access Type Selection

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

Access Type:

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

Target Device MES Interface Module Target Device Network

Access Interval Settings

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

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

Reading Target Data Setting (optional)

Reading Target Data:

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

[Main-Processing]

• Main-Processing Settings

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

Pestaña 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]

Pestaña Narrowing-Down Condition

Combination	Access Field	(Data type)	Comparing condition	Comparing target
	PatternNo	Integerr	=	[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.Setting.ValueofPressFittingLoad...
2		
3		
4		
5		
6		
7		
8		
9		
10		

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]: _____

[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 : No seleccionar
 - Inhibit the data output to the target server : No seleccionar
- Job Execution Inhibition Necessity Settings (optional)
 - Inhibit the job execution even when the trigger condition is satisfied.

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

[Anterior](#)[Siguiente](#)

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

Project Edit View Online Help

NewProject

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

Home

Project Name NewProject

Haga clic en el botón Reproducir.

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

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

Place the cursor to display the explanation of each item.

[Anterior](#)[Siguiete](#)

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

Anterior

Siguiete

MES Interface Function Configuration Tool New

Project Edit View Online Help

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

Job Setting List

Home

Adding/Editing the Job Settings

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

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

Edit Delete

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

[Anterior](#)[Siguiete](#)

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The interface includes a menu bar (Project, Edit, View, Online, Help), a toolbar, and a left-hand navigation tree. The 'Job Settings' section is expanded, showing various sub-items like 'Target Device Settings', 'Device Tag Settings', 'Target Server Settings', 'Access Table/Proc. Settings', 'Network Settings', and 'Option Settings'. The main area is titled 'Job Setting List' and contains a table with columns: 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. A context menu is open over the first row (No. 1), with the 'Edit' option highlighted. A text box explains: 'Seleccione Editar para crear un nuevo ajuste de trabajo. Haga clic en **Edit** desde el menú.' Below the table are 'Edit' and 'Delete' buttons, and a status bar at the bottom shows project details.

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Job Setting List

Home

Adding/Editing the Job Settings

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

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

Edit Delete Add One

Seleccione Editar para crear un nuevo ajuste de trabajo.
Haga clic en **Edit** desde el menú.

Edit Delete

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

[Anterior](#)[Siguiente](#)

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[1]' and contains the following elements:

- Job Name:** A text field containing 'Job01'.
- Comment:** An empty text field.
- Job Configuration:** A dropdown menu set to 'Main Configuration'.
- Diagram:** A flow diagram illustrating the process flow:
 - Trigger Conditions:** Represented by a red and black device icon with a green exclamation mark.
 - Main-Processing:** A central box containing 'MES Interface Module' and 'Target Server' connected by a double-headed blue arrow. Above this box is the text 'Main-Processing such as DB Communication'.
 - A green arrow points from the Trigger Conditions to the Main-Processing box.
- Buttons:** 'Back', 'Next', 'OK', and 'Cancel' buttons are located at the bottom of the window.
- Status Bar:** At the bottom, it shows resource usage: '[Device Tag Components] 0 . . 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 0 points . . 0 points(High-Speed) [Field/Argument used in the Project] 0 unit'.

A callout box with a blue border and white background is positioned over the Job Name field, containing the text: 'Cree un trabajo que extraiga los datos de la base de datos cuando la fabricación esté lista. Haga clic en Job Name.'

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

Job Configuration

Ingrese "GetPlan" en el campo de entrada de Job Name.

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

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

[Anterior](#)[Siguiete](#)

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

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

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

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

Target Device → MES Interface Module ↔ Target Server

Seleccione la configuración de trabajo que se está ajustando.
Haga clic en Job Configuration.

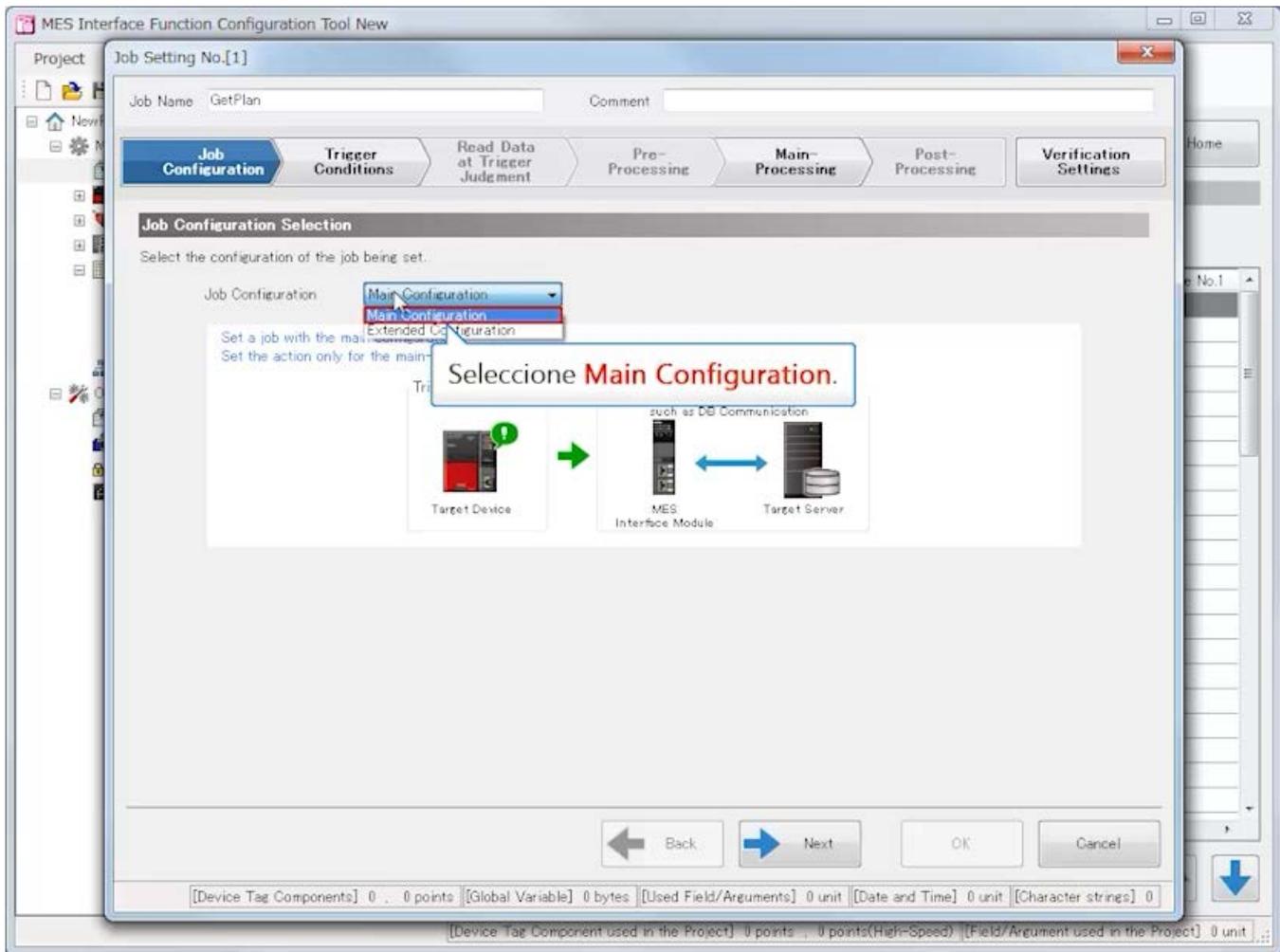
← Back Next OK Cancel

[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

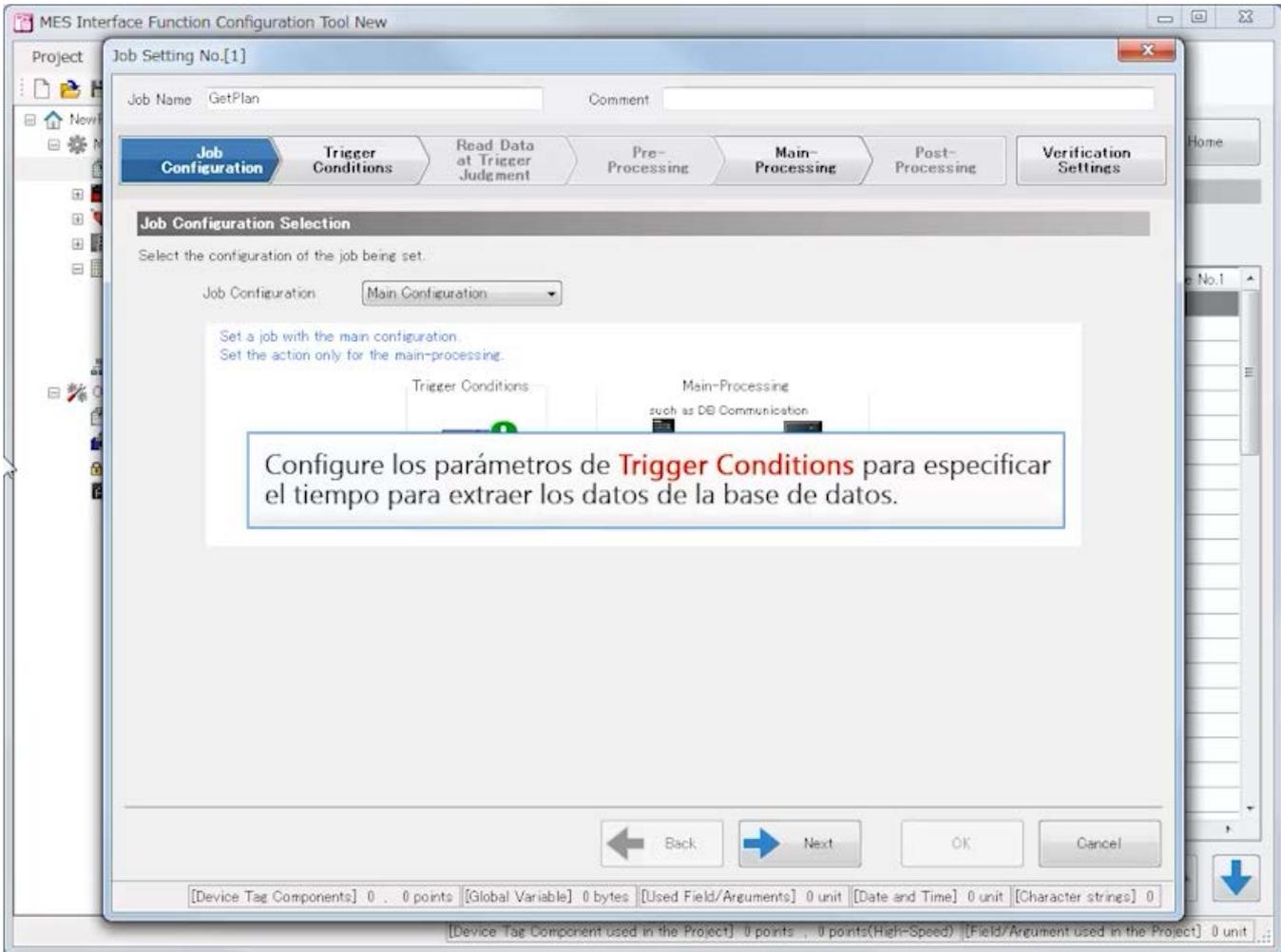
Anterior

Siguiente



Anterior

Siguiente



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MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

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

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

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

Trigger Conditions Main-Processing
such as DB Communication

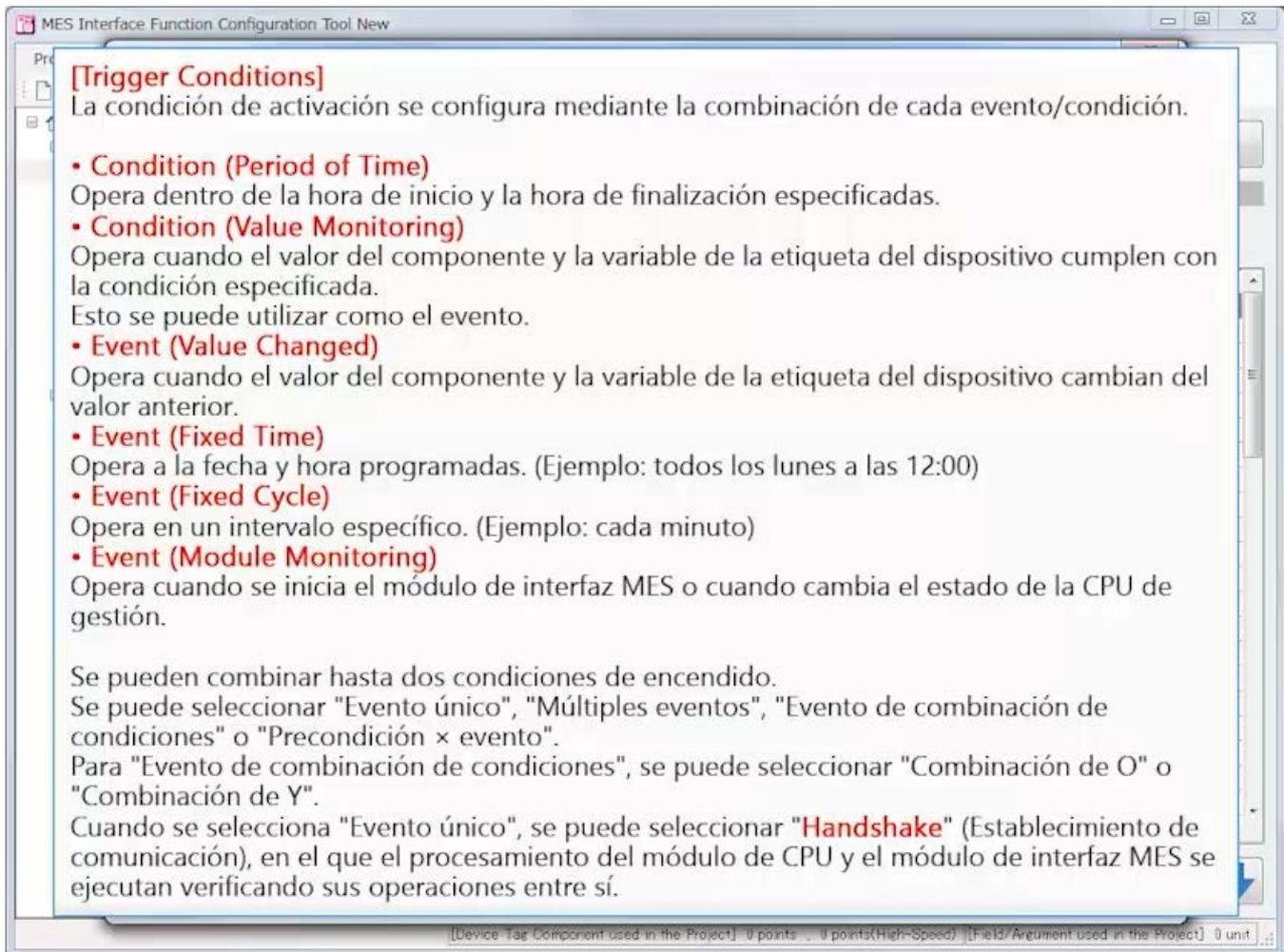
Configure los parámetros de **Trigger Conditions** para especificar el tiempo para extraer los datos de la base de datos.

Haga clic en **Next**.

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

[Anterior](#)[Siguiente](#)

[Trigger Conditions]
La condición de activación se configura mediante la combinación de cada evento/condición.

- **Condition (Period of Time)**
Opera dentro de la hora de inicio y la hora de finalización especificadas.
- **Condition (Value Monitoring)**
Opera cuando el valor del componente y la variable de la etiqueta del dispositivo cumplen con la condición especificada.
Esto se puede utilizar como el evento.
- **Event (Value Changed)**
Opera cuando el valor del componente y la variable de la etiqueta del dispositivo cambian del valor anterior.
- **Event (Fixed Time)**
Opera a la fecha y hora programadas. (Ejemplo: todos los lunes a las 12:00)
- **Event (Fixed Cycle)**
Opera en un intervalo específico. (Ejemplo: cada minuto)
- **Event (Module Monitoring)**
Opera cuando se inicia el módulo de interfaz MES o cuando cambia el estado de la CPU de gestión.

Se pueden combinar hasta dos condiciones de encendido.
Se puede seleccionar "Evento único", "Múltiples eventos", "Evento de combinación de condiciones" o "Precondición x evento".
Para "Evento de combinación de condiciones", se puede seleccionar "Combinación de O" o "Combinación de Y".
Cuando se selecciona "Evento único", se puede seleccionar "**Handshake**" (Establecimiento de comunicación), en el que el procesamiento del módulo de CPU y el módulo de interfaz MES se ejecutan verificando sus operaciones entre sí.

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

Anterior

Siguiente

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.

Haga clic en Configuration Type.

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

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Siguiente

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

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

Event/Condition Settings

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

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

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

Trigger Buffering Disable

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

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

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 . . .

Seleccione **Single Event** para establecer la ocurrencia de un evento específico como activador.

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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

Condition Combination Type

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

Event/Condition Settings

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

No.	Event/Condition Type	Detail Type	Content
1			

Establezca el evento/condición.
Haga clic en el botón **Edit**.

Edit Delete

Trigger Buffering Setting (optional)

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

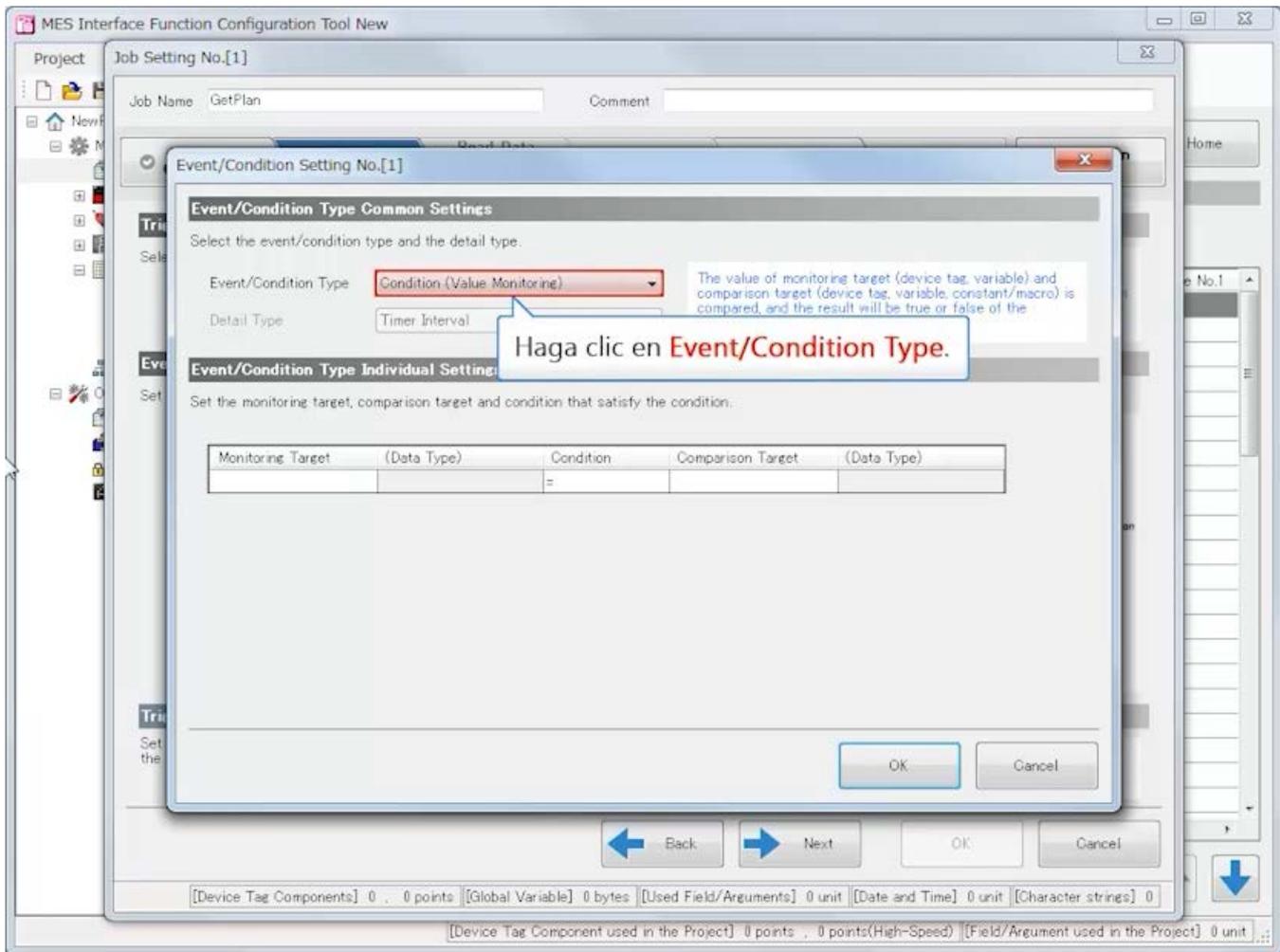
Trigger Buffering

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

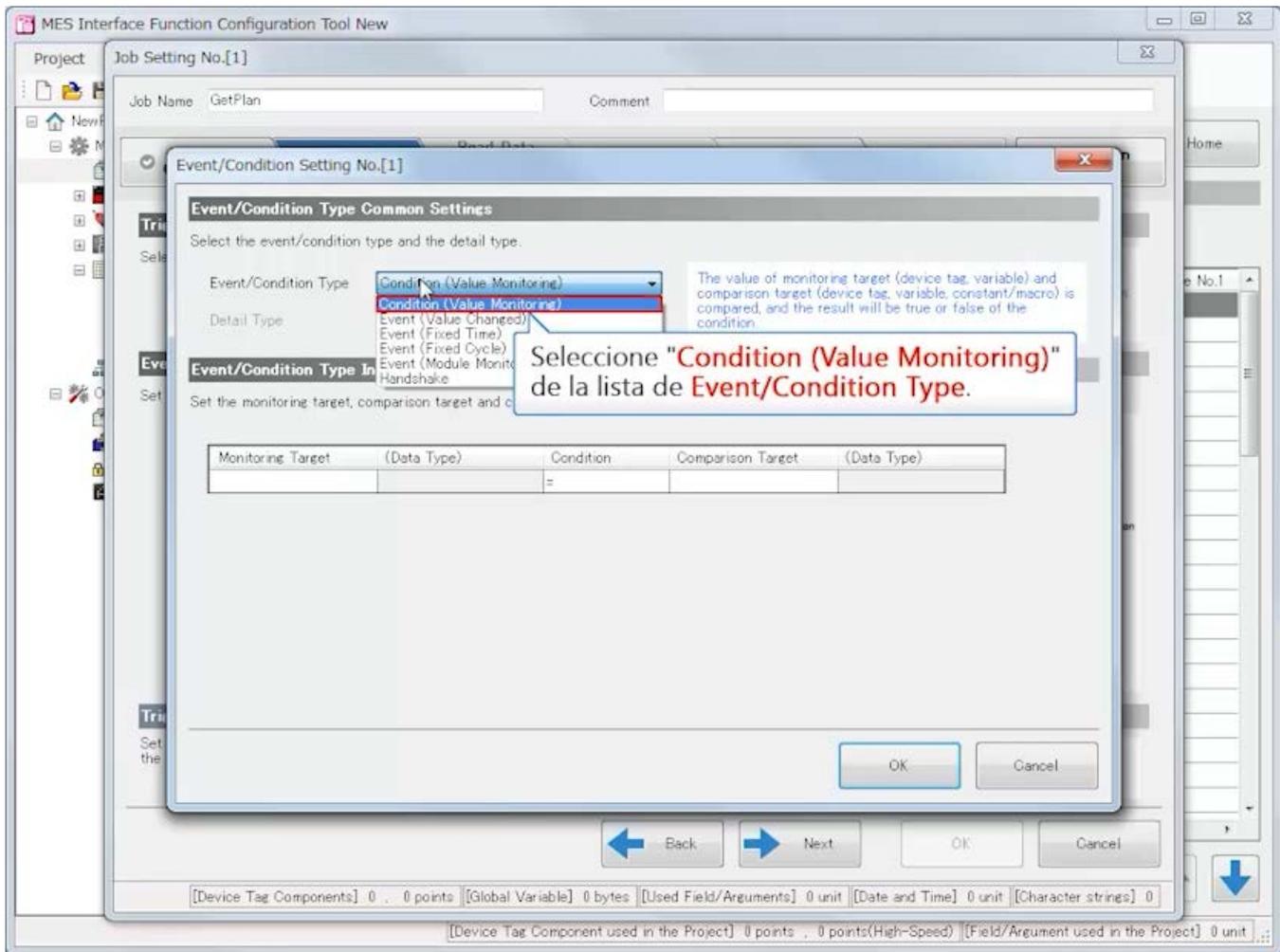
[Device Tag Components] 0 . 0 points [Global Variable] 0 bytes [Used Field/Arguments] 0 unit [Date and Time] 0 unit [Character strings] 0

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

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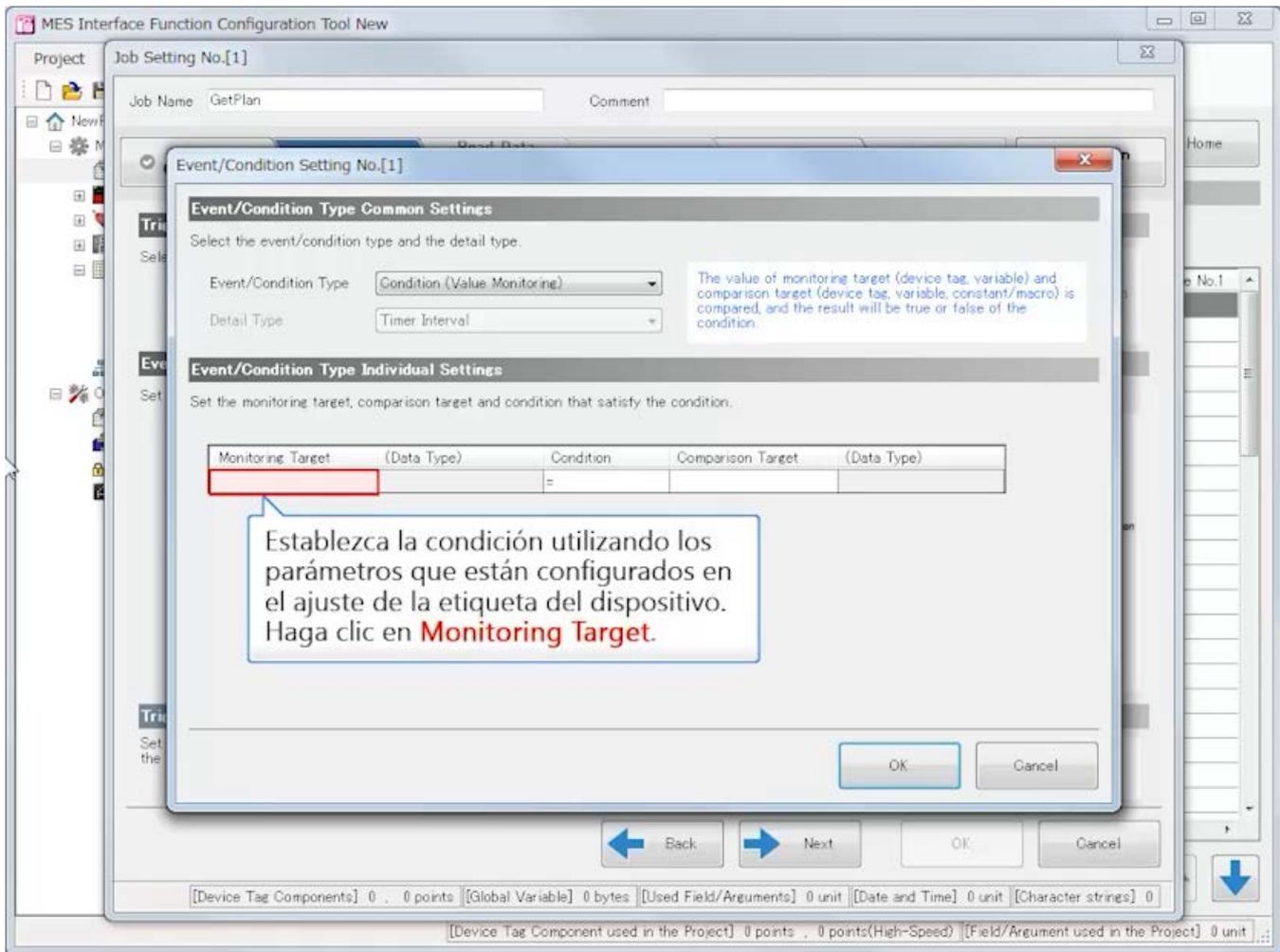
Anterior

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Event/Condition Setting No.[1]

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

Event/Condition Type:

Detail Type:

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)
<input type="text" value=""/>	<input type="text" value=""/>	<input "="" type="text" value="="/>	<input type="text" value=""/>	<input type="text" value=""/>

Device Tag

- GettingData
 - PatternNo
 - SettingValueofPressFitting
 - SettingValueofPressFitting
 - ManufacturingSettingValueAcquisition**
 - [Edit]
- PuttingData [Add]
- Variable

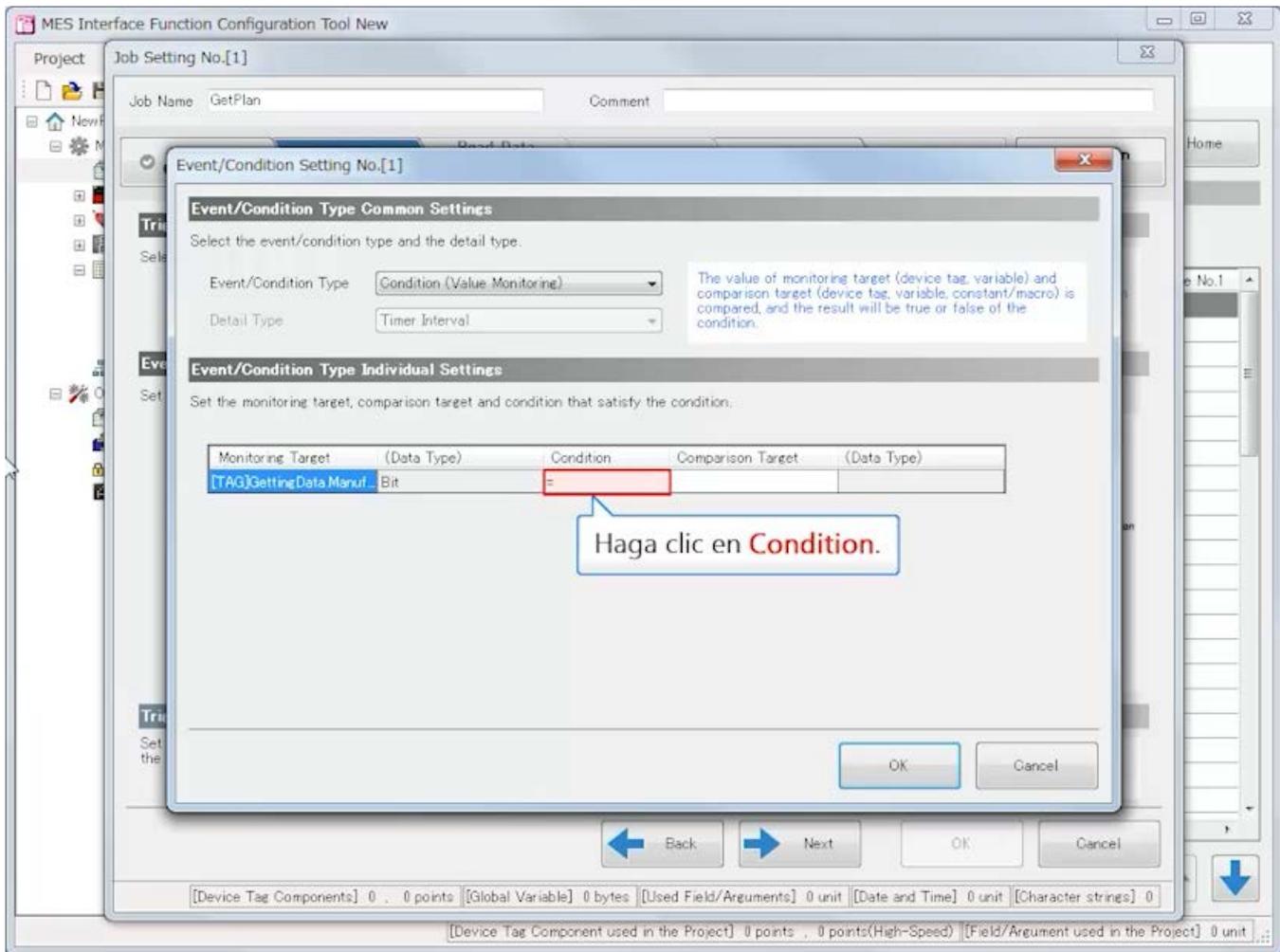
Configure el ajuste de "Cuando la adquisición del valor de configuración de fabricación (M0) está encendida". Haga clic en "ManufacturingSettingValueAcquisition" de "GettingData" de la lista de Monitoring Target.

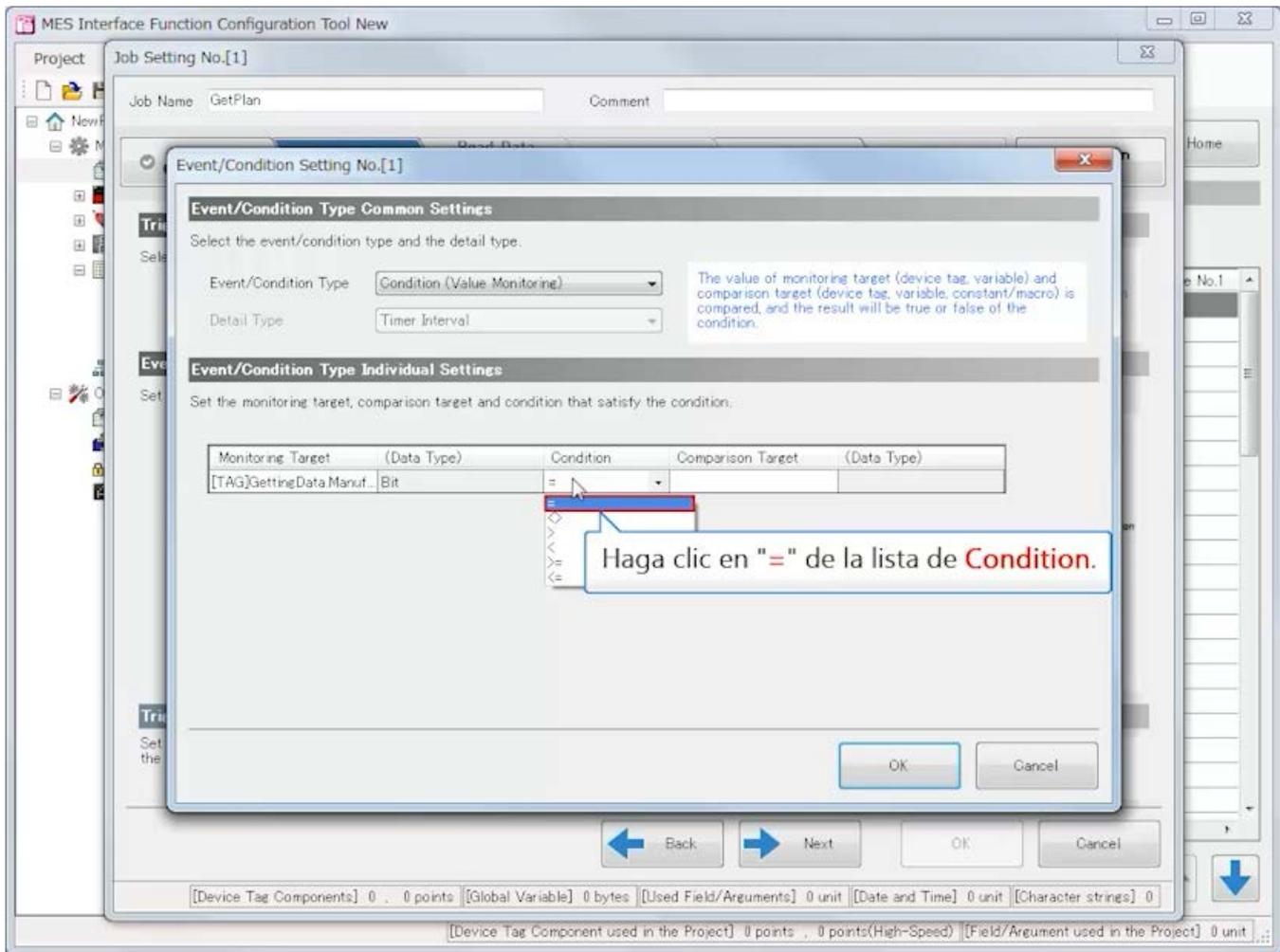
OK Cancel

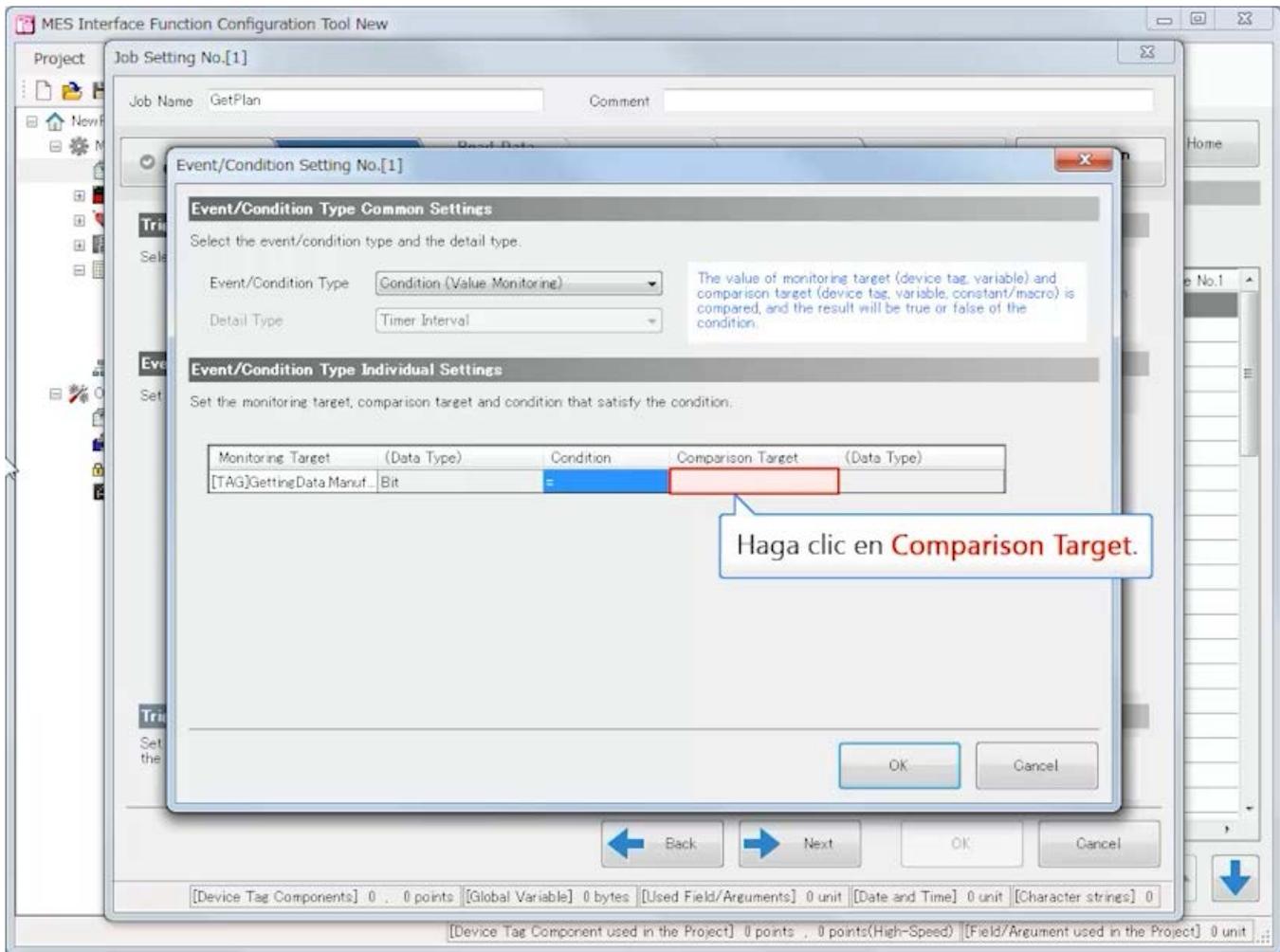
Back Next OK Cancel

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

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[Anterior](#)[Siguiente](#)

Event/Condition Setting No.[1]

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

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

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

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

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

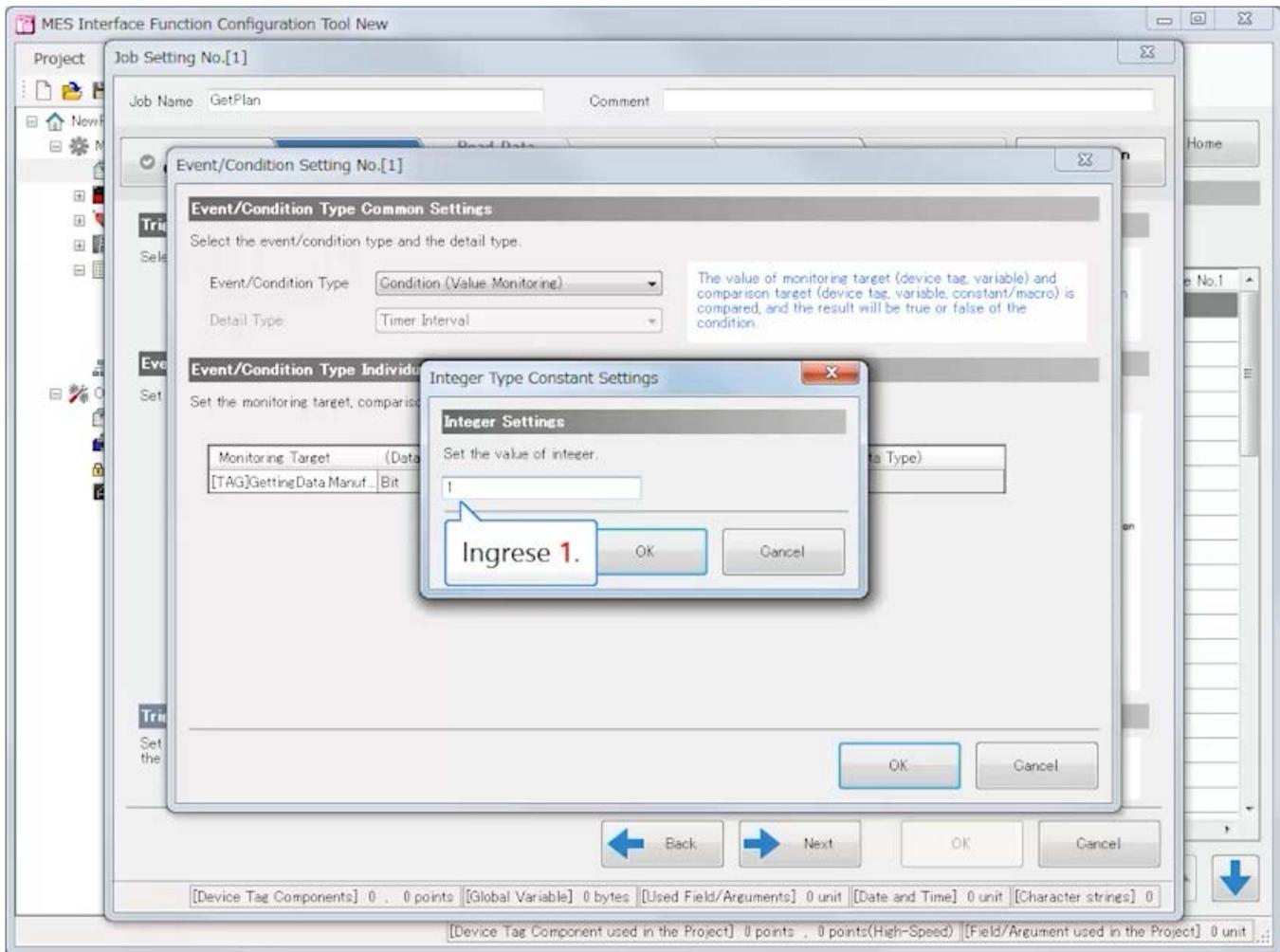
Comparison Target options: Device Tag, Variable, Constant, Integer, Real Number, Character String (Unicode)

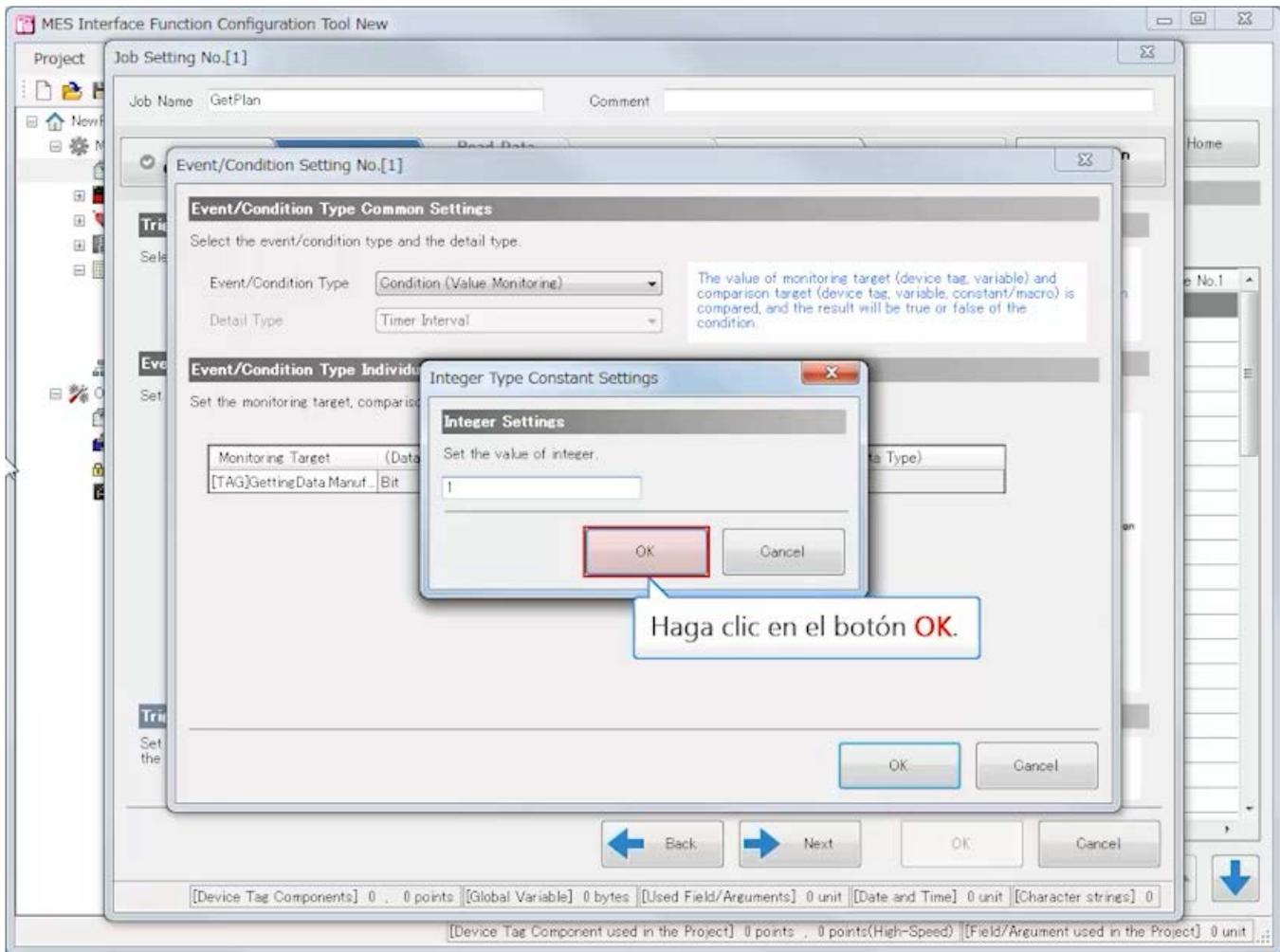
Haga clic en "Integer" de la lista de Comparison Target.

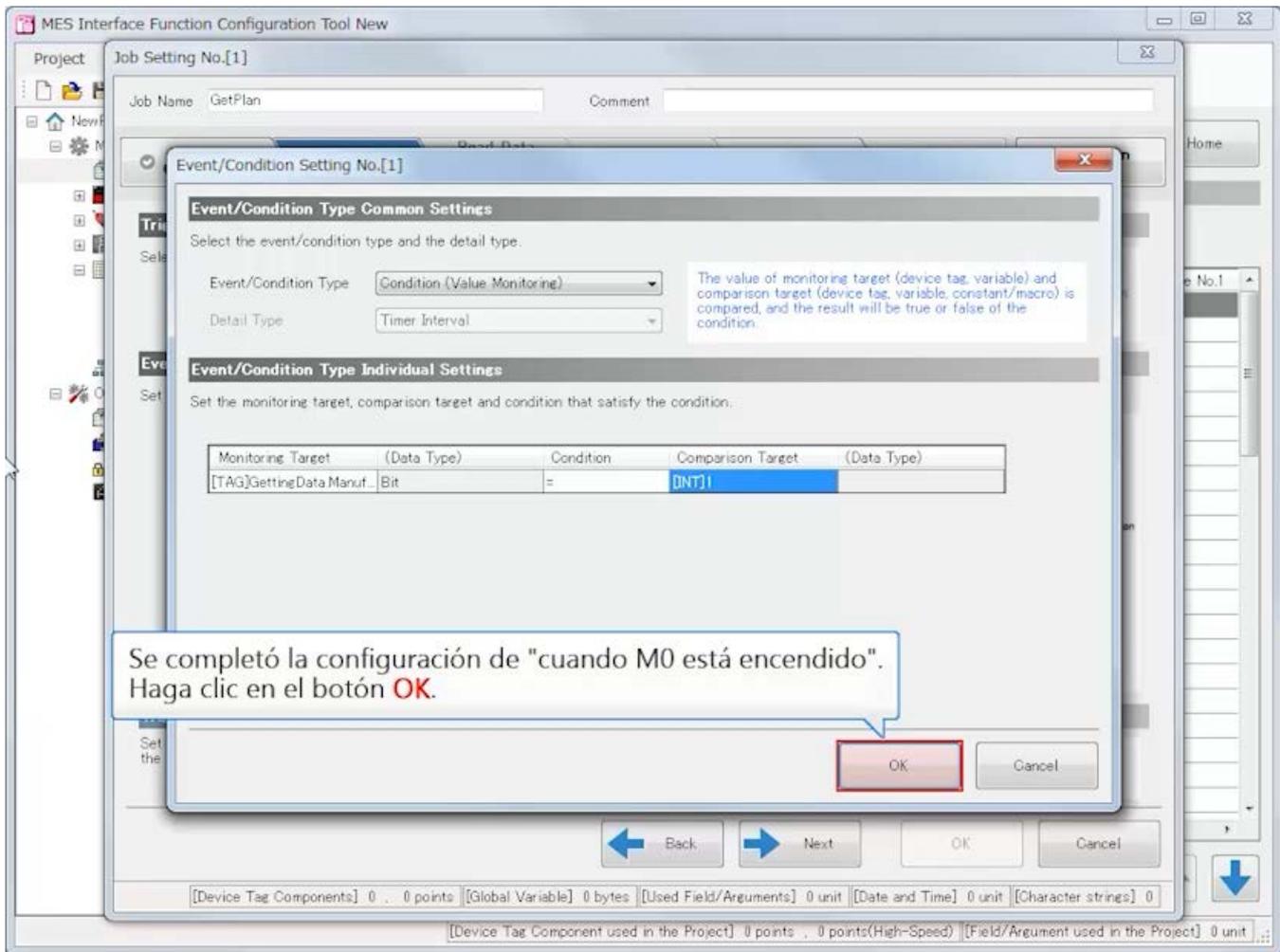
OK Cancel

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

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[Anterior](#)[Siguiete](#)

[Anterior](#)[Siguiete](#)

Anterior

Siguiente

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

Condition Combination Type

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

Event/Condition Settings

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

No.	Event/Condition Type	Detail Type	Content
1	Condition (Value Monit...	-	[TAG]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 the same time.

Trigger Buffering

Haga clic en **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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job Setting No.[1]

Job Name GetPlan Comment

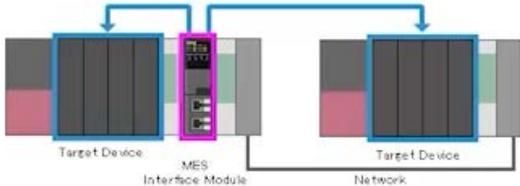
Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

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.



Access Interval Settings

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

Access Interval Seconds Specification 1 s

Reading Target Data

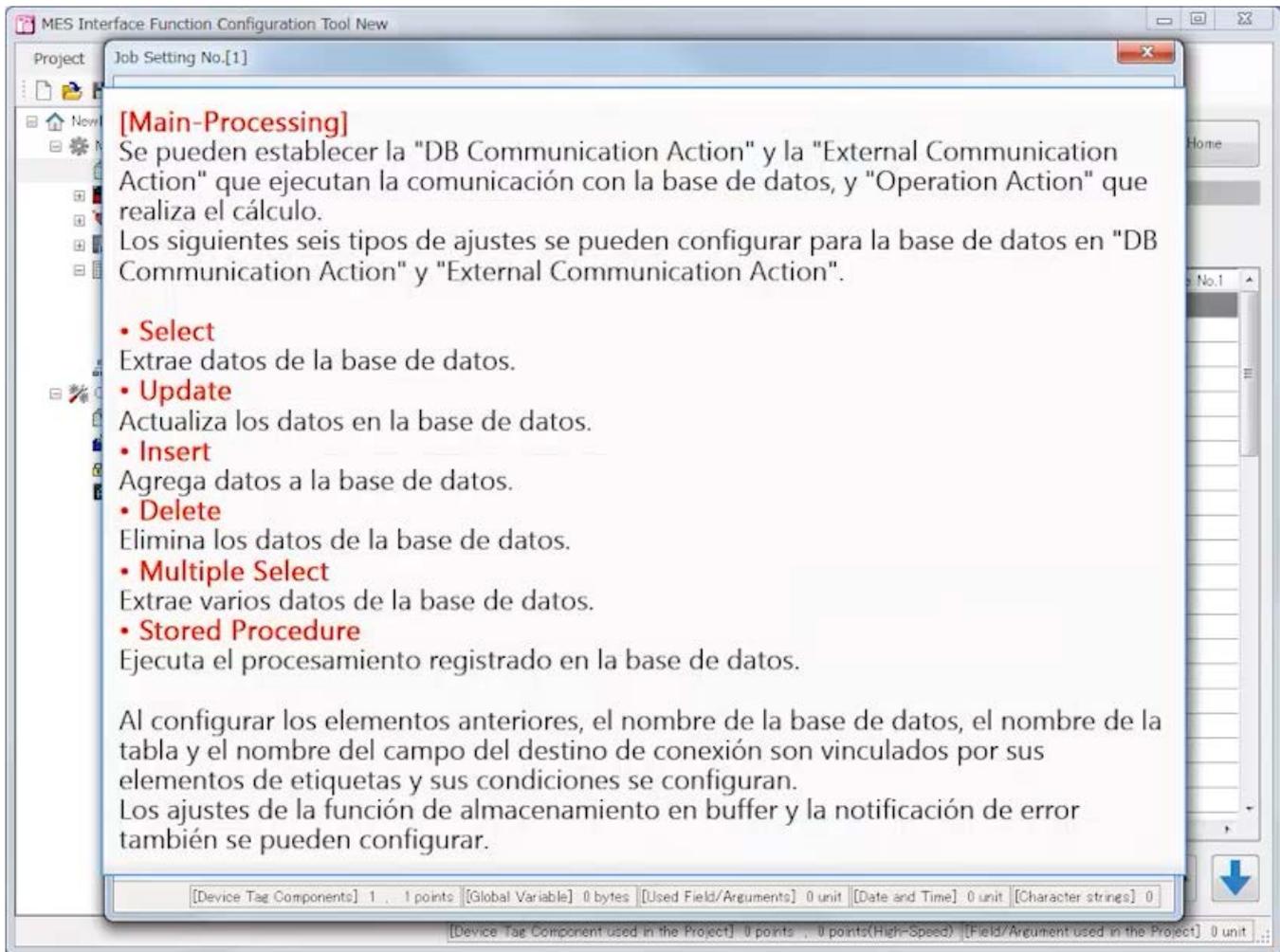
Reading Target

Utilice el ajuste predeterminado para Read Data at Trigger Judgment. Haga clic en el botón **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

[Anterior](#)[Siguiete](#)

[Main-Processing]
Se pueden establecer la "DB Communication Action" y la "External Communication Action" que ejecutan la comunicación con la base de datos, y "Operation Action" que realiza el cálculo.
Los siguientes seis tipos de ajustes se pueden configurar para la base de datos en "DB Communication Action" y "External Communication Action".

- **Select**
Extrae datos de la base de datos.
- **Update**
Actualiza los datos en la base de datos.
- **Insert**
Agrega datos a la base de datos.
- **Delete**
Elimina los datos de la base de datos.
- **Multiple Select**
Extrae varios datos de la base de datos.
- **Stored Procedure**
Ejecuta el procesamiento registrado en la base de datos.

Al configurar los elementos anteriores, el nombre de la base de datos, el nombre de la tabla y el nombre del campo del destino de conexión son vinculados por sus elementos de etiquetas y sus condiciones se configuran.
Los ajustes de la función de almacenamiento en buffer y la notificación de error también se pueden configurar.

[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

Anterior

Siguiente

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		

Configure el ajuste de main-processing.
Haga clic en el botón **Edit**.

Edit Delete

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

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

DB Buffer Use Size [byte] -

Back Next OK Cancel

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

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

[Anterior](#)[Siguiente](#)

The screenshot displays the 'MES Interface Function Configuration Tool' window. The main window is titled 'Job Setting No.[1]' and shows a navigation bar with tabs: Job Configuration, Trigger Conditions, Read Data at Trigger Judgment, Pre-Processing, Main-Processing (selected), Post-Processing, and Verification Settings. The 'Main-Processing Settings' section is active, showing a table with 10 rows for 'No.' and 'Action Type'. A dialog box titled 'Main-Processing Action No.[1]' is open, showing 'Action Type Selection' options: 'DB Communication Action' (highlighted with a red box), 'Operation Action', and 'External Comm...'. A callout box points to the 'DB Communication Action' button with the text: 'Establezca la acción para la entrada/salida de datos en el servidor de destino. Haga clic en el botón **DB Communication Action**.' Below the dialog box, the 'Operation Settings at Main-Processing' section is visible, including 'At Processing Failure' notification settings, 'DB Buffering' (No Buffering selected), and 'DB Buffer Use Size [byte]'.

Project Job Setting No.[1]

Job Name GetPlan Comment

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

Main-Processing Settings

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

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

Edit

Main-Processing Action No.[1]

Action Type Selection

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

DB Communication Action Operation Action

External Comm...

Set the action to

Establezca la acción para la entrada/salida de datos en el servidor de destino.
Haga clic en el botón **DB Communication Action**.

Cancel

Operation Settings at Main-Processing

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

DB Buffer Use Size [byte]

Back Next OK Cancel

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

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

Anterior

Siguiente

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: **Insert**

Access Table: (Add)

Data Assignment Option

Data Assignment Settings

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

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

Batch Insertion Delete

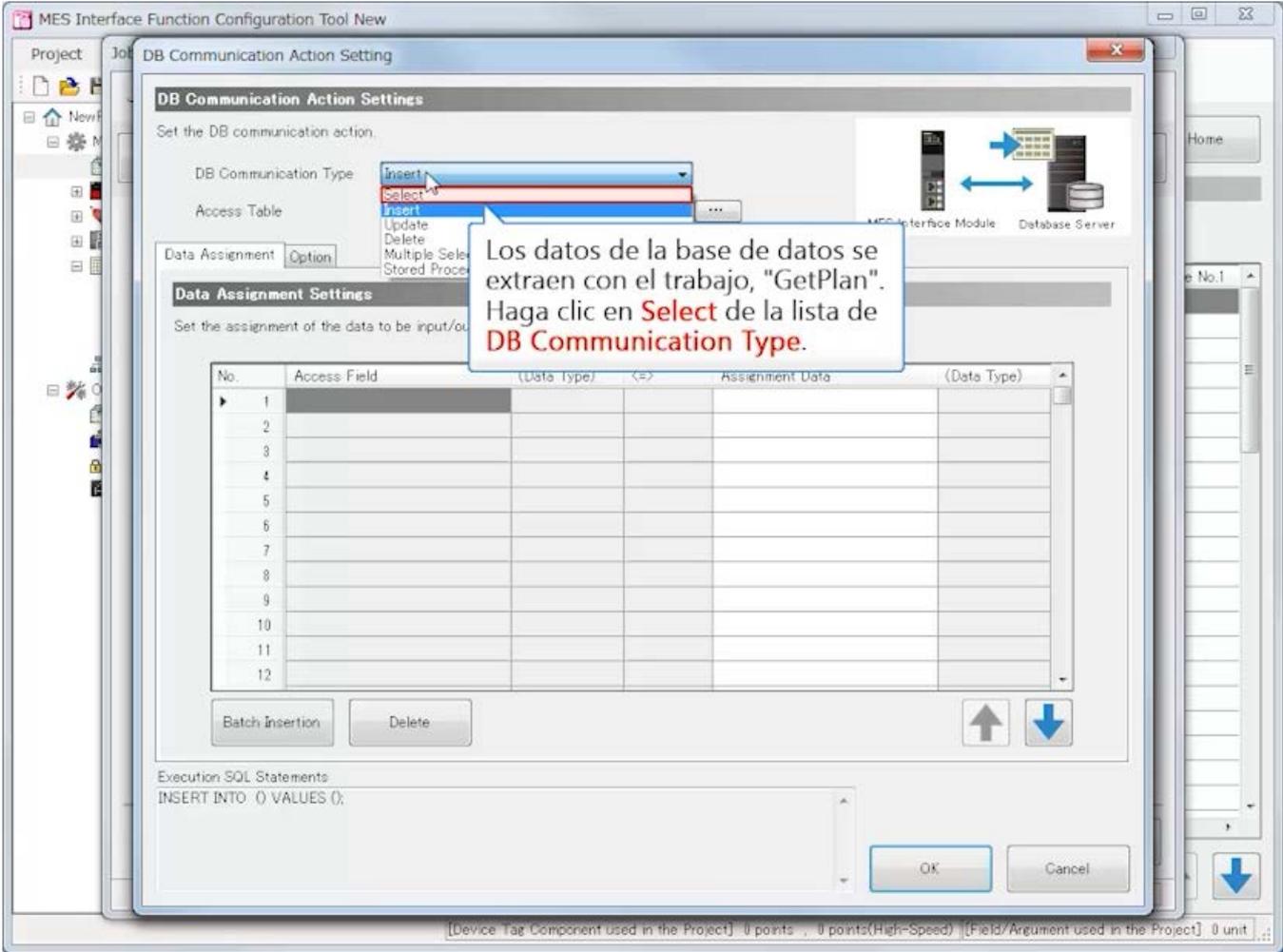
Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

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

Anterior

Siguiente



The screenshot shows the 'DB Communication Action Setting' dialog box within the 'MES Interface Function Configuration Tool New'. The dialog is titled 'DB Communication Action Setting' and contains the following sections:

- DB Communication Action Settings:** Includes a dropdown for 'DB Communication Type' (with 'Select' highlighted), an 'Access Table' field, and a 'Data Assignment' button.
- Data Assignment Settings:** Includes a table for assigning data to be input/output.
- Execution SQL Statements:** A text area containing the SQL statement: `INSERT INTO () VALUES ();`

A callout box with a blue border and white background points to the 'Select' option in the dropdown menu. The text in the callout reads: "Los datos de la base de datos se extraen con el trabajo, "GetPlan". Haga clic en **Select** de la lista de **DB Communication Type**."

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

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: (Add)

Data Assignment: Narrowing-Down Condition

Data Assignment Settings

Set the assignment of the data to be input/output.

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

Batch Insertion Delete

Execution SQL Statements

```
SELECT FROM;
```

OK Cancel

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

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

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

Data Assignment: Narrowing-Down

Data Assignment Settings

Set the assignment of the data to be input/output

Seleccione "GetPlan.DataServer" de la lista de Access Table.

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

Batch Insertion Delete

Execution SQL Statements

```
SELECT FROM;
```

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan.DataServer

Diagram: MES Interface Module ↔ Database Server

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

Data Assignment Settings

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

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

Batch Insertion Delete ↑ ↓

Execution SQL Statements
SELECT FROM [ParamTable].

OK Cancel

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

Establezca la etiqueta del dispositivo que escribe los datos extraídos de la base de datos en la memoria del dispositivo del módulo de CPU.
Haga clic en **Assignment Data** de **Load**.

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Data Assignment Settings

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

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

Device Tag

- GettingData
- PatternNo
- SettingValueofPressFitting
- SettingValueofPressFitting
- SettingValueofPressFitting

Dado que el signo de D100 se establece como el componente "SettingValueofPressFittingLoad" en device tag settings, haga clic en "SettingValueofPressFittingLoad" en "GettingData" de la lista de Assignment Data.

Batch Insertion Delete

Execution SQL Statements

```
SELECT FROM [ParamTable].
```

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

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

Data Assignment Settings

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

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	->		
2	Load	Integer	->	[TAG]GettingData.SettingValueof	Word [Unsigne...
3	Height	Integer	->		

Como se muestra en la siguiente tabla, configure el ajuste de "extraer los datos del campo Altura a la memoria del dispositivo D101". El procedimiento de ajuste es el mismo que "Load". El ajuste de operación se omite en este curso.

Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
Height	Integer	->	[TAG]GettingData.SettingValueofPressFittingHeight	Word [Unsigned]/Bit String [16-bit]

Batch Insertion Delete

Execution SQL Statements
SELECT [Load] FROM [ParamTable].

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Data Assignment Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

Se completó data assignment settings.

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan.DataServer

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

Data Assignment S

Set the assignment of

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Luego, configure el ajuste de **narrowing-down condition**. En este ajuste, se configuran los datos del registro a extraer de la tabla. Haga clic en la pestaña **Narrowing-Down Condition**.

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Establezca la condición que extrae los datos del registro en el que el valor establecido en D0 (PatternNo) del módulo de CPU y el valor establecido en el campo "PatternNo" de la tabla "ParamTable" son iguales. Haga clic en **Access Field**.

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

[Anterior](#)[Siguiente](#)

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

Haga clic en **Condition**.

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

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

Haga clic en "=" de la lista de **Condition**.

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Selecione la etiqueta del dispositivo para que sea el objetivo de comparación.
Haga clic en **Comparison Target**.

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Dado que el signo de D0 se establece como el componente "Pattern No." en device tag settings, haga clic en "Pattern No." en "GettingData" de la lista de Comparison Target.

Execution SQL Statements

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

OK Cancel

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

Anterior

Siguiente

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

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlanDataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Se completó el ajuste de extraer el registro en el que el valor del campo (PatternNo) es igual a la memoria del dispositivo D0.

Anterior

Siguiente

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

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan-DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion

Execution SQL Statements

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

OK Cancel

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

Cuando se completa el ajuste, "Execution SQL Statements" se crea automáticamente.
Sin embargo, esta declaración de SQL debe ser creada por el usuario para acceder a los datos en la base de datos.
Con esta MES interface function configuration tool, se puede acceder a la base de datos sin considerar crear la declaración de SQL, ya que se crea automáticamente.

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Select

Access Table: GetPlan:DataServer

MES Interface Module Database Server

Data Assignment Narrowing-Down Conditions Sorting Order Option Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion Delete

DB Communication Action Settings se completó.
Haga clic en el botón OK.

OK Cancel

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

Anterior

Siguiente

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

Haga clic en **Next**.

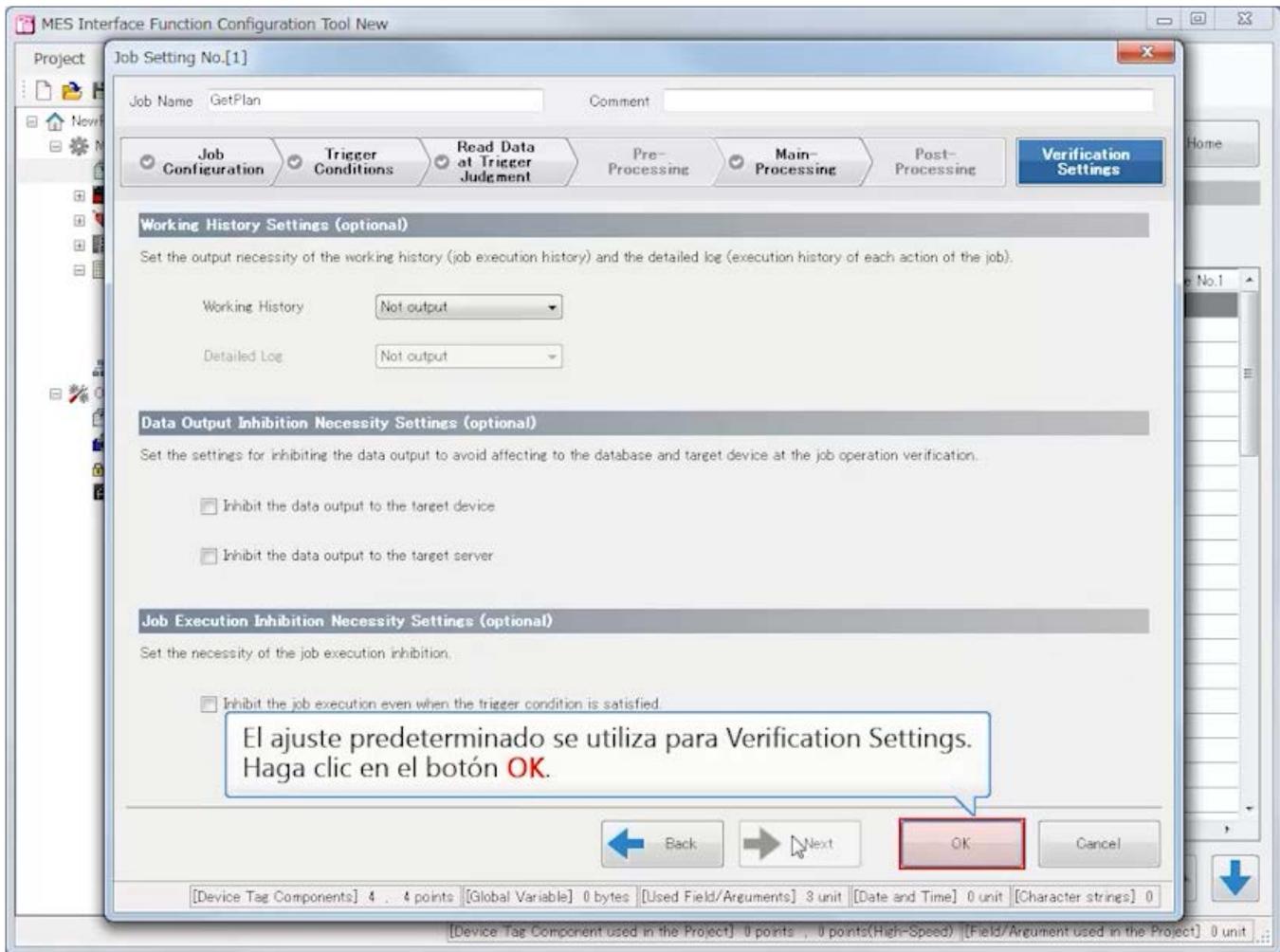
Back Next OK Cancel

[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

Anterior

Siguiente



Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

Job Setting List

Home

Adding/Editing the Job Settings

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

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

Edit Delete

Se completó el ajuste del trabajo, "GetPlan".
Haga clic en > para ir a la siguiente página.

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

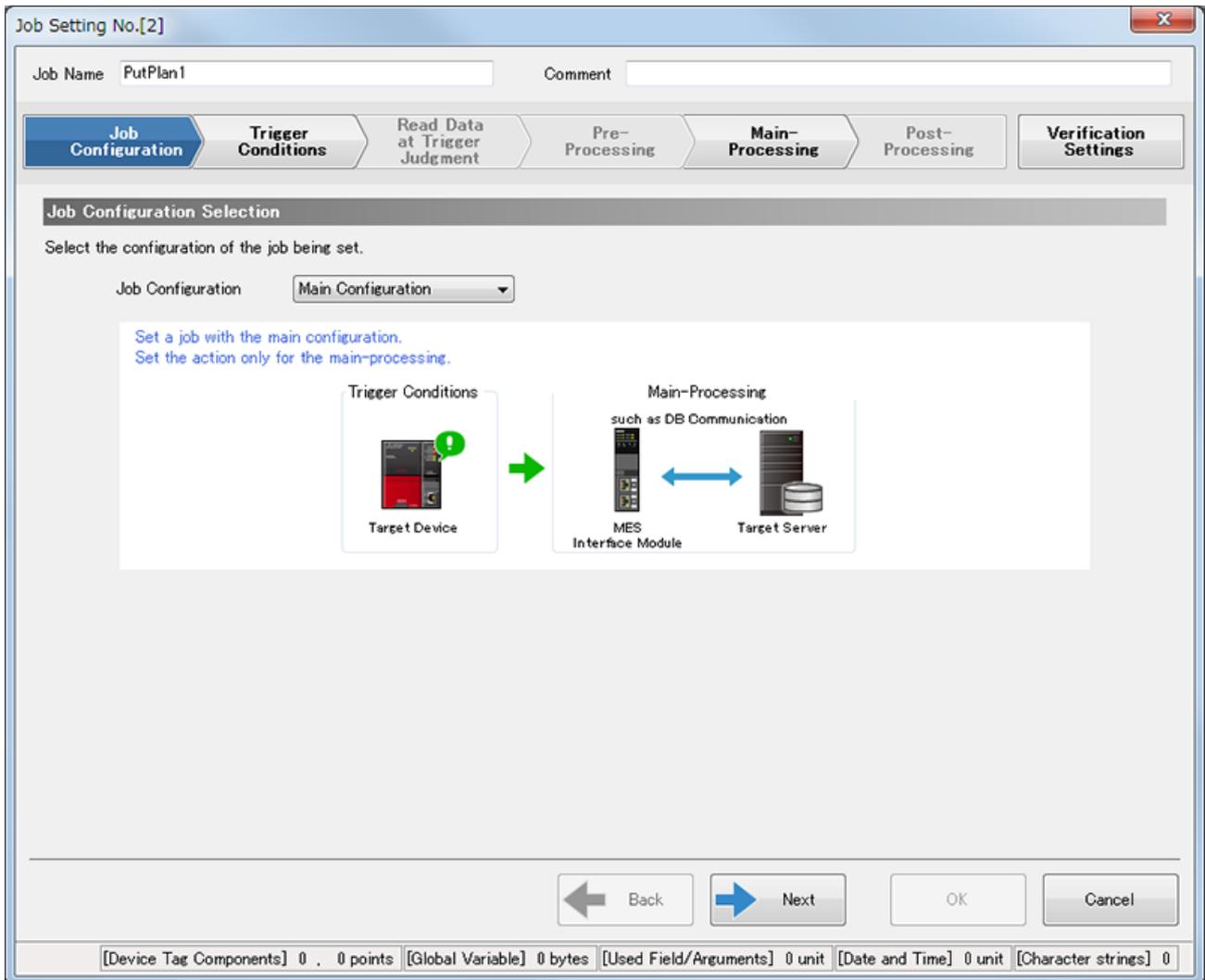
[Job Settings]

Cree un trabajo que escriba el registro en la base de datos al iniciar la fabricación.

(2) Job Name: PutPlan1

[Job Configuration]

Job Configuration: Main Configuration



[Trigger Conditions]

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

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

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[2]

Job Name PutPlan1 Comment

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

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type:

Condition Combination Type:

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

Event/Condition Settings

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

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

Trigger Buffering Setting (optional)

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

Trigger Buffering:

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

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

[Read Data at Trigger Judgment]

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

Job Setting No.[2]

Job Name PutPlan1 Comment

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

Access Type Selection

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

Access Type General Access

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

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

Pestaña 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

Para configurar el almacenamiento en buffer de base de datos, seleccione "Use the DB buffer 1." en [DB Buffer Settings] de [Option Settings] con anticipación.

Job Setting No.[2]

Job Name PutPlan1 Comment

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

Main-Processing Settings

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

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

Edit Delete ↑ ↓

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

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

DB Buffer Use Size [byte] 270

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

[Verification Settings]

- Working History Settings (optional)
Working History: Not output
- Data Output Inhibition Necessity Settings (optional)
Inhibit the data output to the target device : No seleccionar
Inhibit the data output to the target server : No seleccionar
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: No seleccionar

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

Anterior

Siguiente

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

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.

Haga clic en el botón Reproducir.

	Condition	Event/Condition Type No.1
2		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] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Job Setting List

Home

Adding/Editing the Job Settings

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

No.	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				
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17				
18				
19				
20				
21				

Edit Delete

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

Luego, configure el ajuste del segundo trabajo.
Haga clic derecho en la fila no. 2 en la Job Setting List.

[Anterior](#)[Siguiente](#)

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, with 'Job Settings' expanded. The main area displays a 'Job Setting List' table. A context menu is open over row 2, with the 'Edit' option highlighted. A tooltip in Spanish explains that clicking 'Edit' creates a new job setting.

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

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

Seleccione Editar para crear un nuevo ajuste de trabajo.
Haga clic en **Edit** desde el menú.

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

[Anterior](#)[Siguiente](#)

Project Job Setting No.[2]

Job Name Comment

Job Configuration

Job Configuration Set

Select the configuration of the job being set.

Job Configuration:

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

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

← 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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Job Configure 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

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

[Anterior](#)[Siguiete](#)

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

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration

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

Seleccione la configuración de trabajo que se está ajustando.
Haga clic en **Job Configuration**.

Target Device MES Interface Module Target Server

Back Next OK Cancel

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

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

[Anterior](#)[Siguiente](#)

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

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration Main Configuration
Main Configuration
Extended Configuration

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

Seleccione Main Configuration.

Target Device → MES Interface Module ← Target Server

such as DB Communication

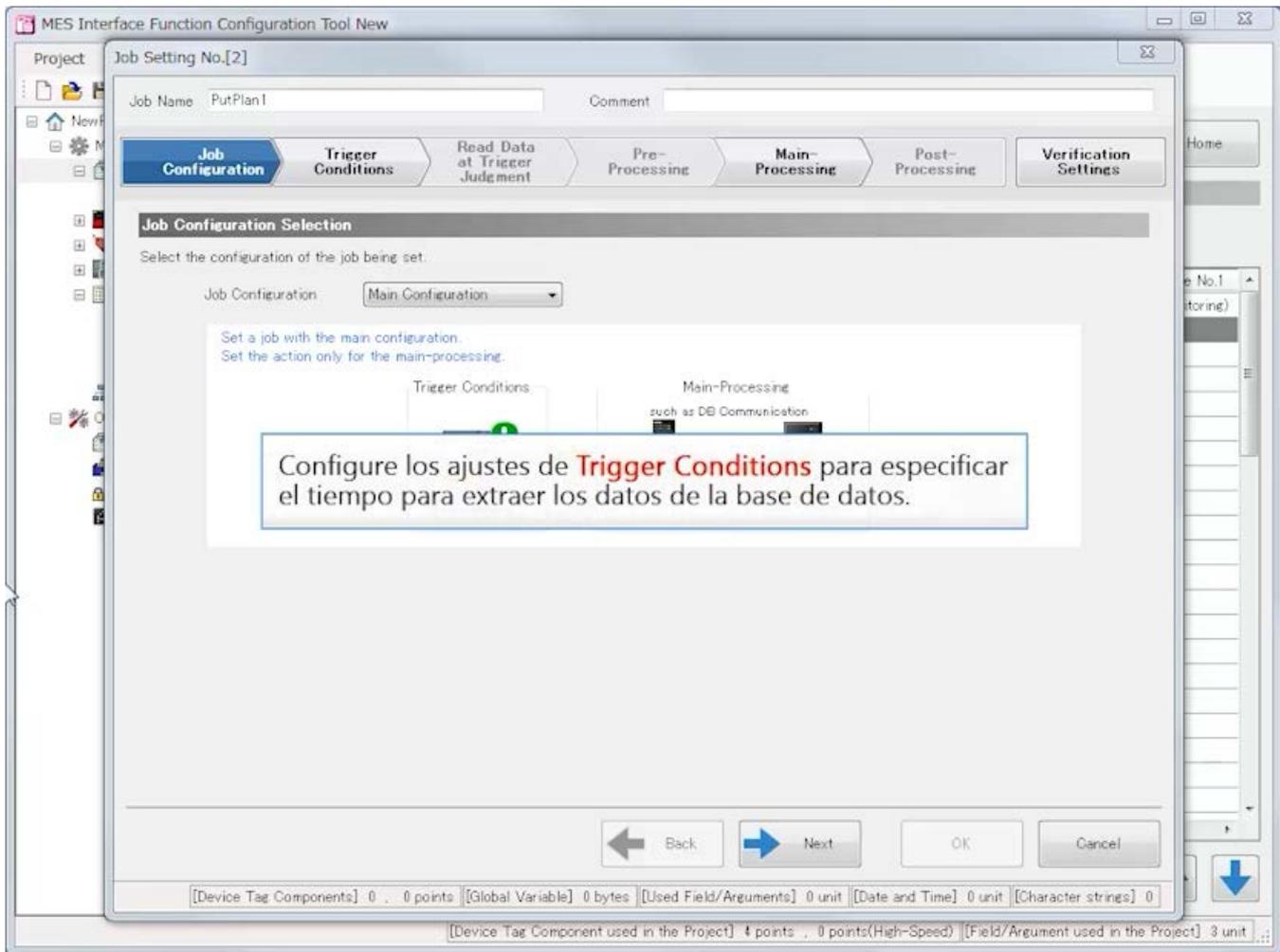
← Back Next OK Cancel

[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

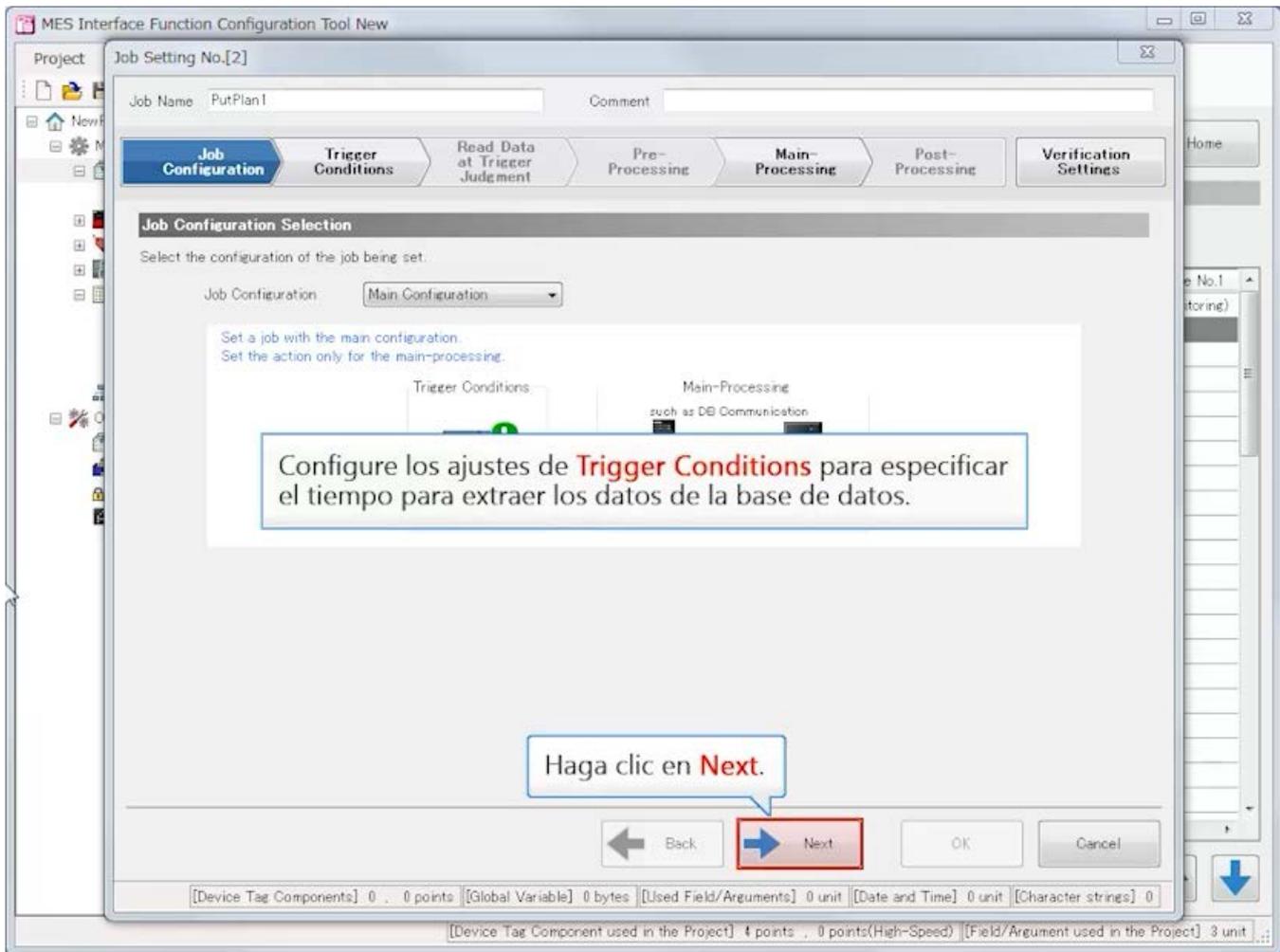
Anterior

Siguiente



Anterior

Siguiente



Anterior

Siguiente

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.

Haga clic en Configuration Type.

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 . . .

Anterior

Siguiente

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 Co Precondition

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

Event/Condition Settings

Set each event/condition to be used at Trigger

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

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

Trigger Buffering Disable

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

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

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 . .

Anterior

Siguiente

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

Condition Combination Type

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

Event/Condition Settings

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

No.	Event/Condition Type	Detail Type	Content
1			

Establezca el evento/condición.
Haga clic en el botón **Edit**.

Edit Delete

Trigger Buffering Setting (optional)

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

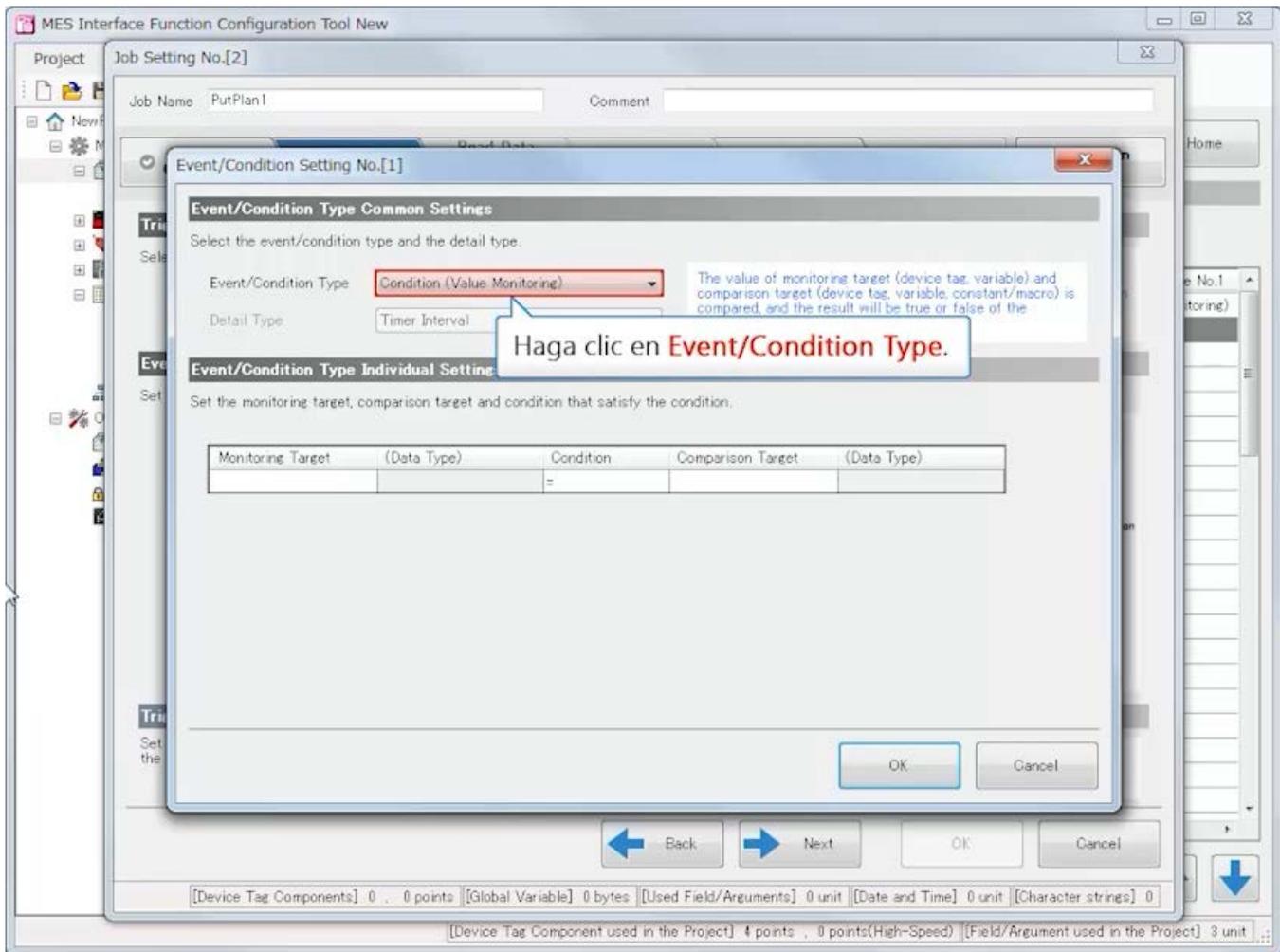
Trigger Buffering

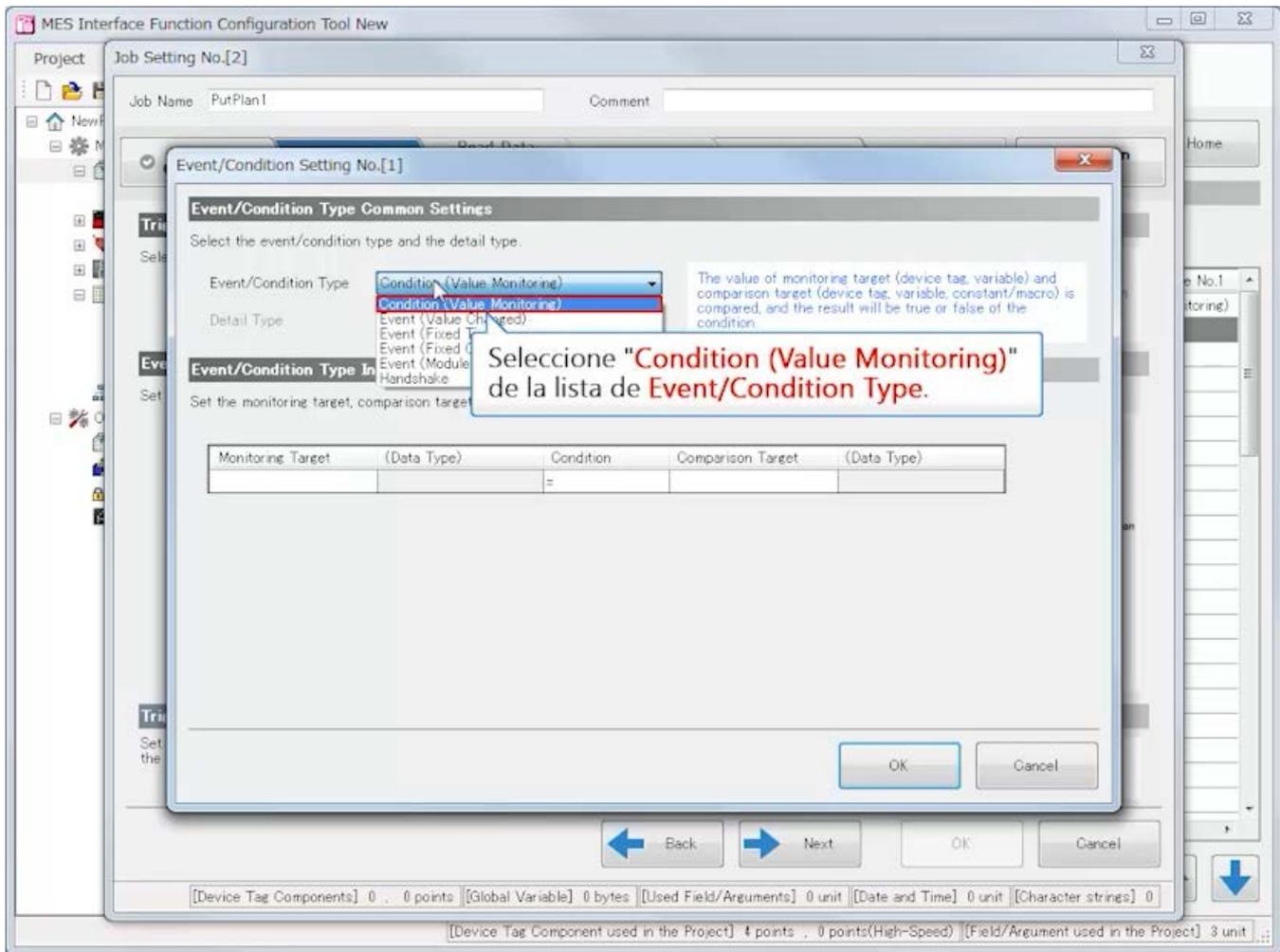
When disabled, even if the trigger condition of the same job is satisfied again while executing the job, the satisfied trigger condition will be disabled.

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

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[Anterior](#)[Siguiente](#)

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)
		=		

Establezca la condición utilizando los parámetros que están configurados en el ajuste de la etiqueta del dispositivo. Haga clic en **Monitoring 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] 4 points . 0 points(High-Speed) [Field/Argument used in the Project] 3 unit

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job Setting No.[2]

Job Name PutPlan1 Comment

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

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

Event/Condition Type Individual Settings

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

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

Device Tag

- GettingData
- PuttingData
- PatternNo
- ResultValueofPressFitting
- ResultValueofPressFitting
- StartManufacturing
- EndManufacturing

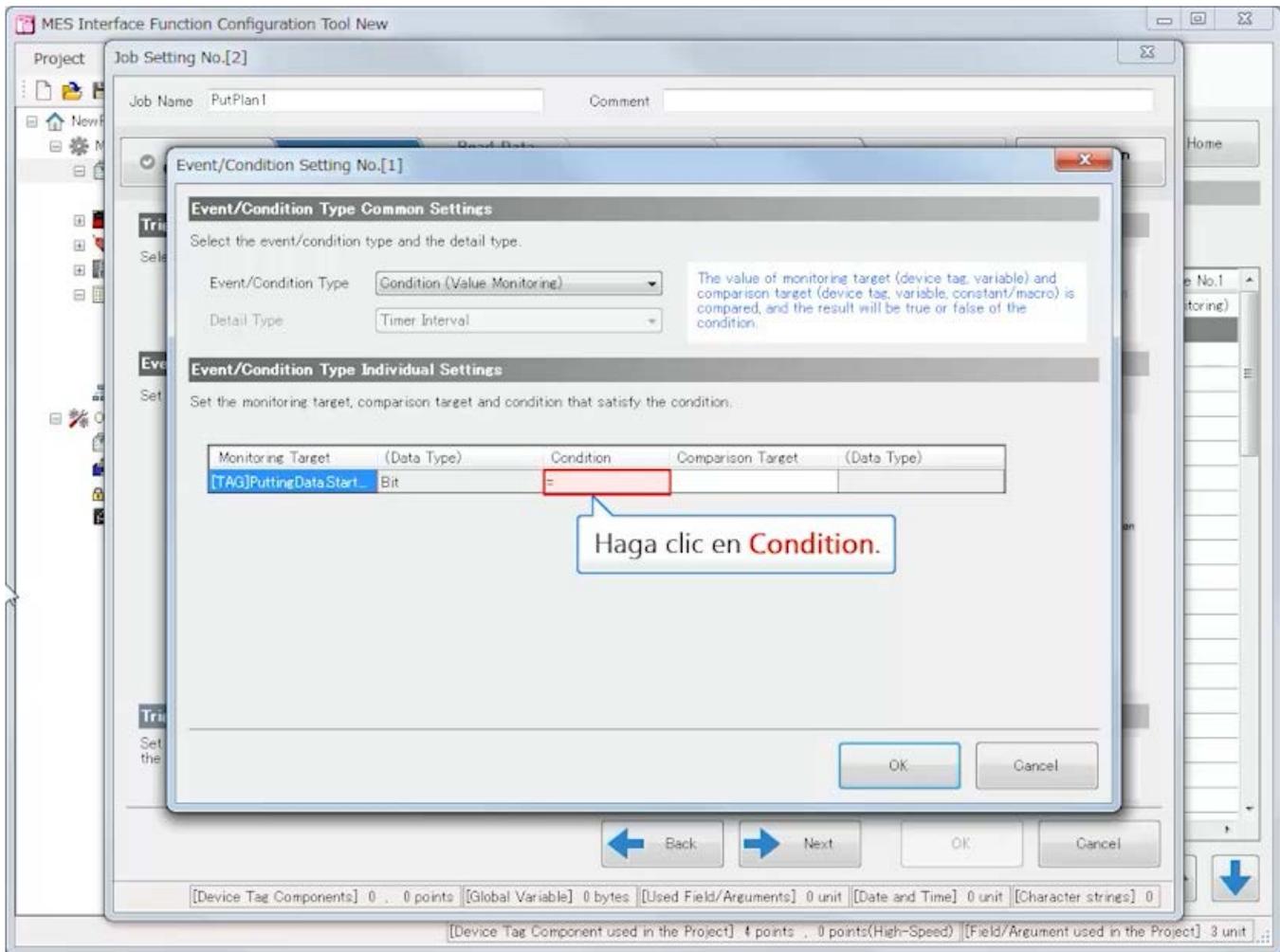
[Add] Variable

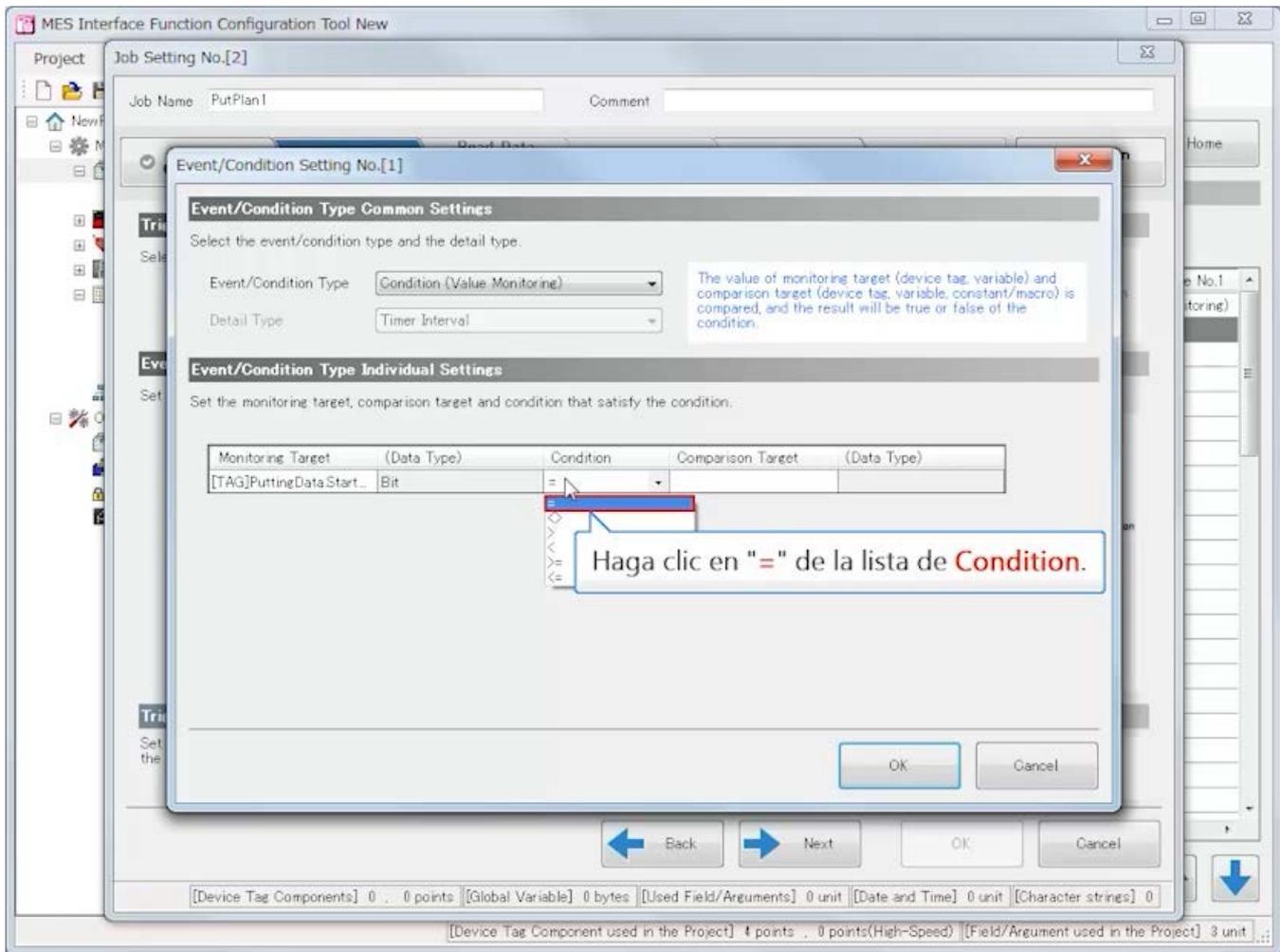
Configure el ajuste de "Cuando se enciende iniciar fabricación (M1)".
Haga clic en "StartManufacturing" de "PuttingData" de la lista de Monitoring Target.

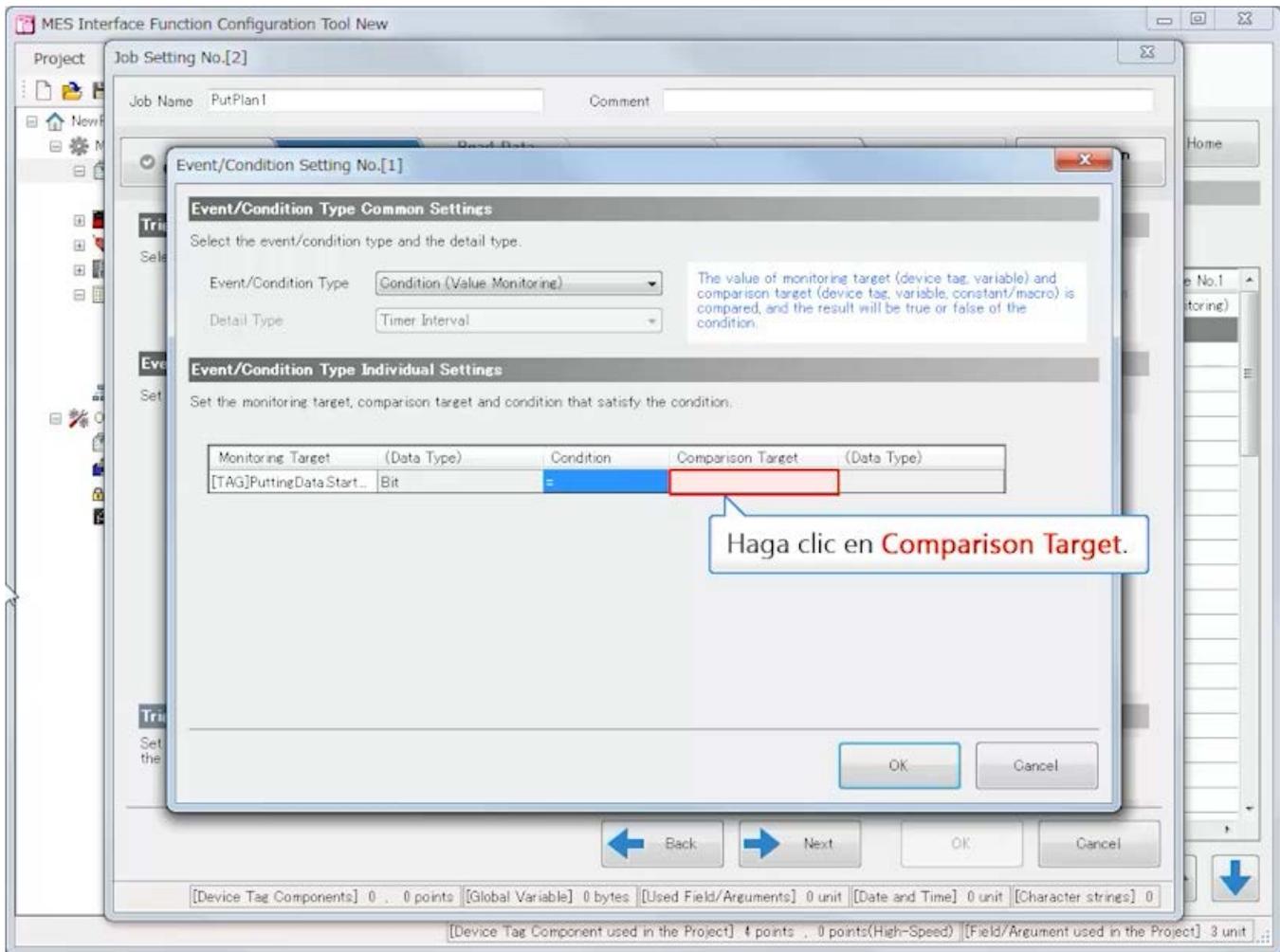
Back Next OK Cancel

[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

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[Anterior](#)[Siguiente](#)

Event/Condition Setting No.[1]

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

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

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

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

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

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

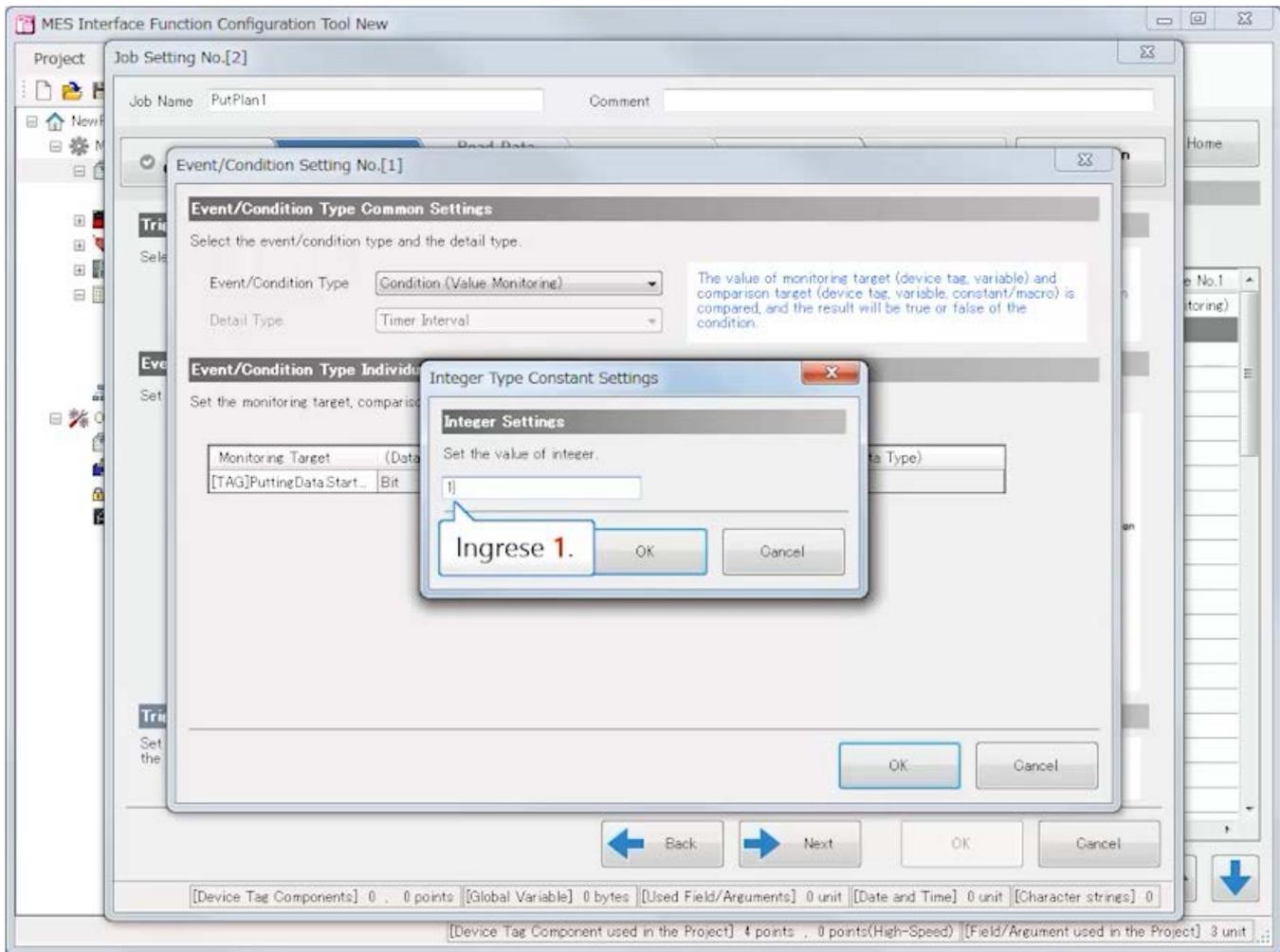
Haga clic en "Integer" de la lista de Comparison Target.

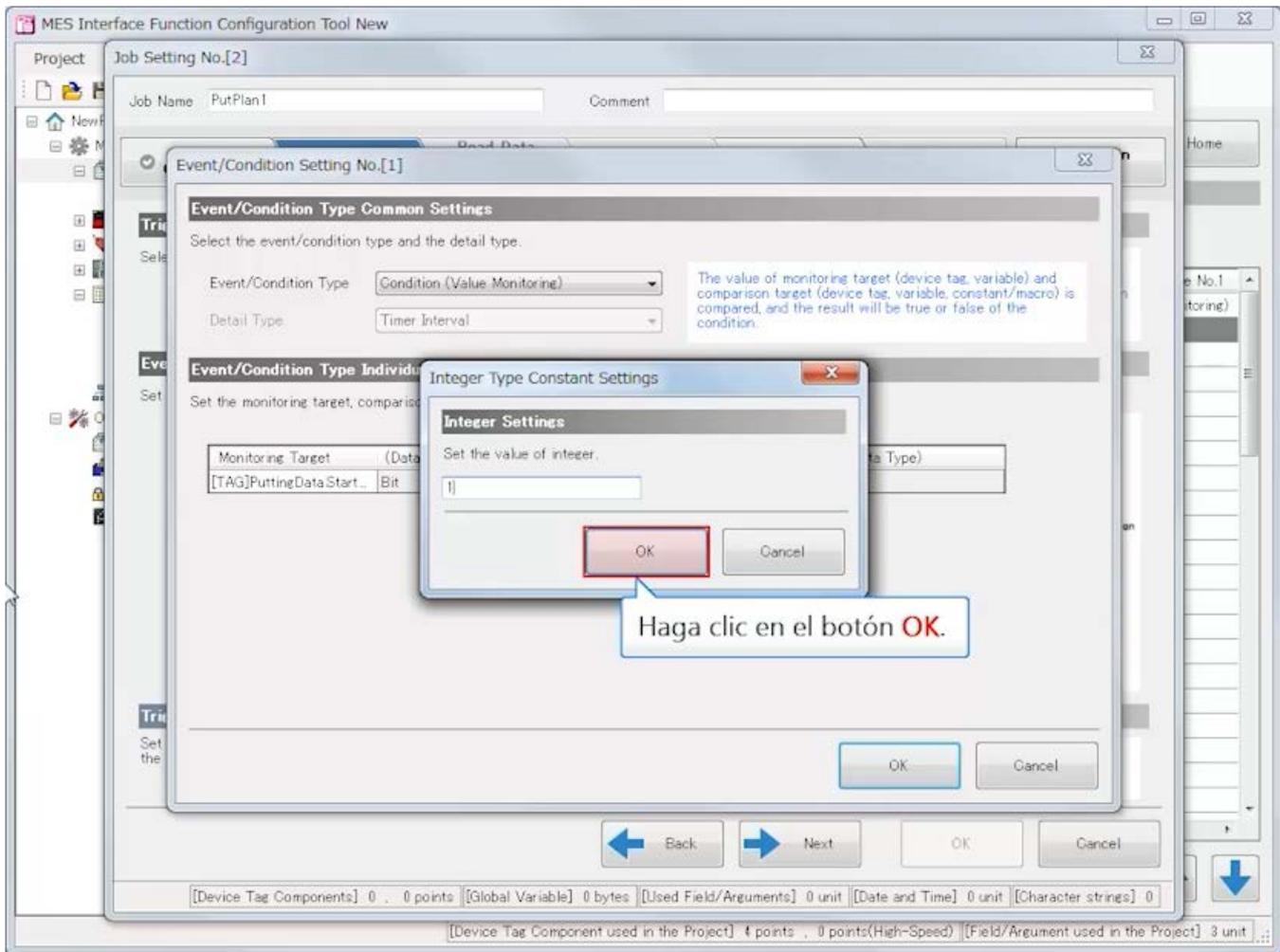
OK Cancel

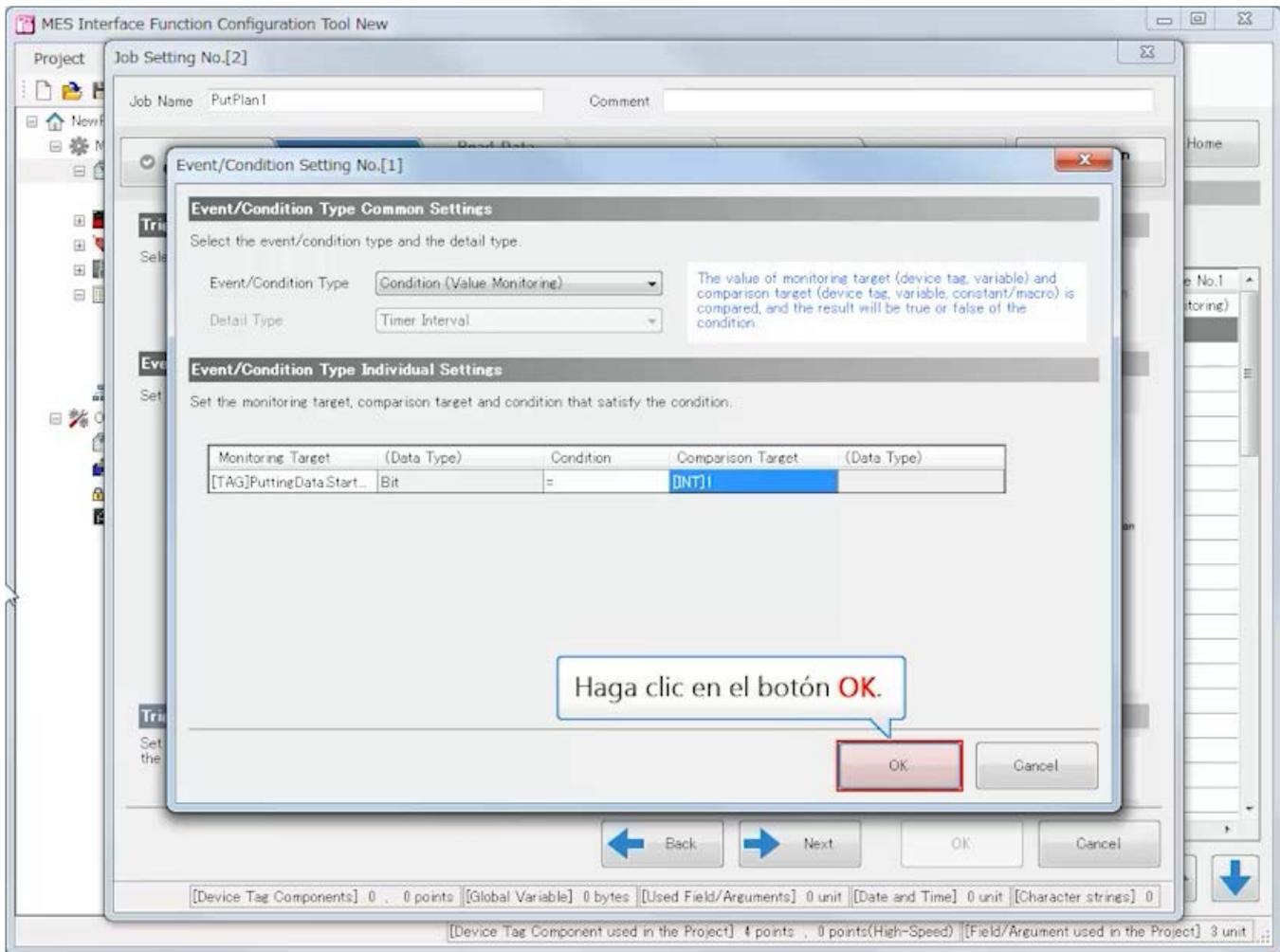
Back Next OK Cancel

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

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[Anterior](#)[Siguiente](#)

[Anterior](#)[Siguiente](#)

Anterior

Siguiente

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

Condition Combination Type

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

Event/Condition Settings

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

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

Edit Delete

Trigger Buffering Setting (optional)

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

Trigger Buffering

Haga clic en **Next**.

if the trigger condition of the same job is satisfied at the same time, the satisfied trigger condition will be

Back Next OK Cancel

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

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

Anterior

Siguiente

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

Access Type Selection

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

Access Type

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

Target Device MES Interface Module Target Device Network

Access Interval Settings

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

Access Interval Seconds Specification s

Reading Target Data Settings

Reading Target Data

Utilice el ajuste predeterminado para Read Data at Trigger Judgment. Haga clic en el botón **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

[Anterior](#)[Siguiente](#)

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Job Setting No.[2]' dialog is open, showing the 'Main-Processing' tab selected in the navigation bar. The 'Job Name' is 'PutPlan1' and the 'Comment' field is empty. The 'Main-Processing Settings' section contains a table with 6 rows and 3 columns: 'No.', 'Action Type', and 'Content'. The first row is selected. Below the table are 'Edit' and 'Delete' buttons, and up/down arrow buttons. The 'Operation Settings at Main-Processing Failure (optional)' section shows 'At Processing Failure' notification set to 'Not Set'. The 'DB Buffering Settings (optional)' section shows 'DB Buffering' set to 'No Buffering' and 'DB Buffer Use Size [byte]' set to '-'. At the bottom, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage statistics.

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		

Configure el ajuste de main-processing.
Haga clic en el botón **Edit**.

Edit Delete ↑ ↓

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

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

DB Buffer Use Size [byte]: -

← Back Next → OK Cancel

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

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

[Anterior](#)[Siguiente](#)

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Main-Processing' tab is active, showing a table of actions. A dialog box titled 'Main-Processing Action No.[1]' is open, displaying an 'Action Type Selection' window. The 'DB Communication Action' button is highlighted with a red box. A callout box with a blue border and white background contains the following text:

Establezca la acción para la entrada/salida de datos en el servidor de destino.
Haga clic en el botón **DB Communication Action**.

The background window shows the 'Main-Processing Settings' section with a table of actions:

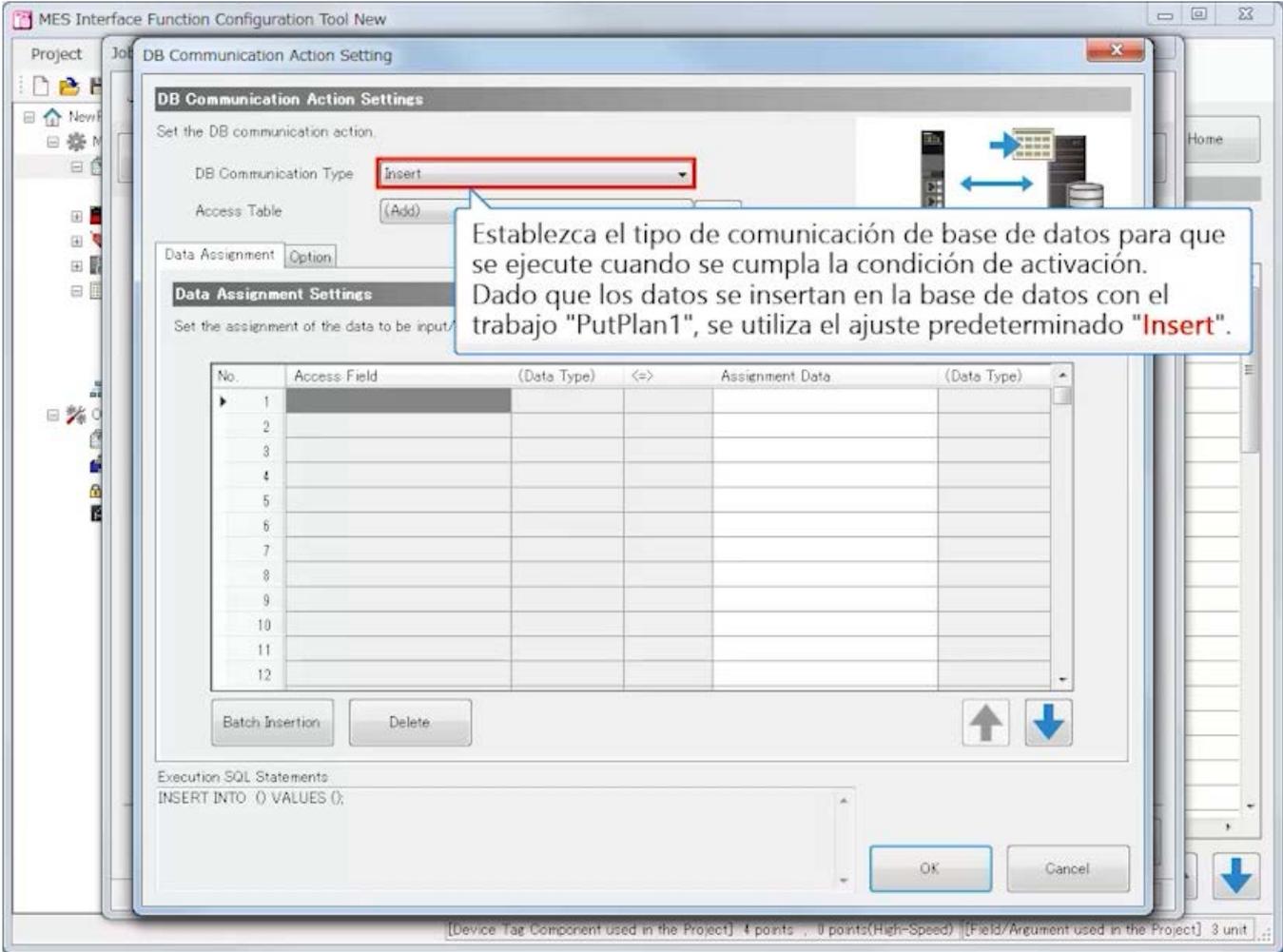
No.	Action Type
1	
2	
3	
4	
5	
6	
7	
8	
9	
10	

Below the table is an 'Edit' button. The 'Operation Settings at Main-Processing' section includes 'At Processing Failure' notification settings, 'DB Buffering' (No Buffering selected), and 'DB Buffer Use Size [byte]'.

At the bottom, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage: [Device Tag Components] 1 / 1 points, [Global Variable] 0 bytes, [Used Field/Arguments] 0 unit, [Date and Time] 0 unit, [Character strings] 0, [Device Tag Component used in the Project] 4 points / 0 points(High-Speed), [Field/Argument used in the Project] 3 unit.

Anterior

Siguiente



Establezca el tipo de comunicación de base de datos para que se ejecute cuando se cumpla la condición de activación. Dado que los datos se insertan en la base de datos con el trabajo "PutPlan1", se utiliza el ajuste predeterminado "Insert".

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

```
Execution SQL Statements
INSERT INTO () VALUES ();
```

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: (Add)

MES Interface Module Database Server

Data Assignment Settings

Set the assignment of the data to be input.

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

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings
Set the DB communication action.

DB Communication Type: Insert

Access Table: (Add) ...

Data Assignment Option: PutPlan1.DataServer

Data Assignment Settings
Set the assignment of the data to be input/output

Seleccione "PutPlan1.DataServer" de la lista de Access Table.

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

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

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

Anterior

Siguiente

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	<-		
2	LoadResult	Integer	<-		
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
INSERT INTO [ResultTable] () VALUES ();
```

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1.DataServer

MES Interface Module Database Server

Data Assignment Option

Data Assignment Settings

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

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	Device Tag	
2	LoadResult	Integer	<-	GettingData	
3	HeightResult	Integer	<-	PuttingData	
4	StartTime	Date and Time	<-	PatternNo	
5				ResultValueofPressFit	
				ValueofPressFit	
				Manufacturing	
				facturing	

Batch Insertion Delete

Execution SQL Statements
INSERT INTO [ResultTable] () VALUES ();

OK Cancel

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

Dado que el signo de D0 se establece como el componente "PatternNo" en device tag settings, haga clic en "PatternNo." en "PuttingData" de la lista de Assignment Data.

Anterior

Siguiente

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	<-		
5					

Luego, establezca los siguientes parámetros de enlace en la fila n.º 2 a 4.
 El procedimiento de ajuste es el mismo que "PatternNo".
 El ajuste de operación se omite en este curso.

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

Anterior

Siguiente

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

Se completó data assignment settings.

No.	Access Field	(Data Type)	(Data Type)	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	[TAG]PuttingData.PatternNo	Word [Unsigne...
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	StartTime	Date and Time	<-	[MACRO]Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

```
INSERT INTO [ResultTable] ([PatternNo], [LoadResult], [HeightResult], [StartTime]) VALUES
((PuttingData.PatternNo), (PuttingData.ResultValueofPressFittingLoad),
(PuttingData.ResultValueofPressFittingHeight), [YYYY-MM-DD hh:mm:ss]);
```

OK Cancel

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Insert

Access Table: PutPlan1:DataServer

MES Interface Module Database Server

Data Assignment Option

Data Assignment Settings

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

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo	Integer	<-	[TAG]PuttingData.PatternNo	Word [Unsigne...
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	StartTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Se completó DB communication action settings.
Haga clic en el botón OK.

OK Cancel

Execution
INSERT I
(Putting
(PuttingData.ResultValueofPressFitngHeight), [YYYY-MM-DD hh:mm:ss]);

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

Anterior

Siguiente

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

Establezca el almacenamiento en buffer de la base de datos.
Haga clic en el botón **Change**.

Operation Settings at Main-Processing

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

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 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

Anterior

Siguiente

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		
9		
10		

Para establecer el almacenamiento en buffer de base de datos, seleccione "Use the DB buffer 1." en DB Buffer Settings de Option Settings.

Edit

Establezca el almacenamiento en buffer de la base de datos. Haga clic en el botón **Change**.

Operation Settings at Main-Processing

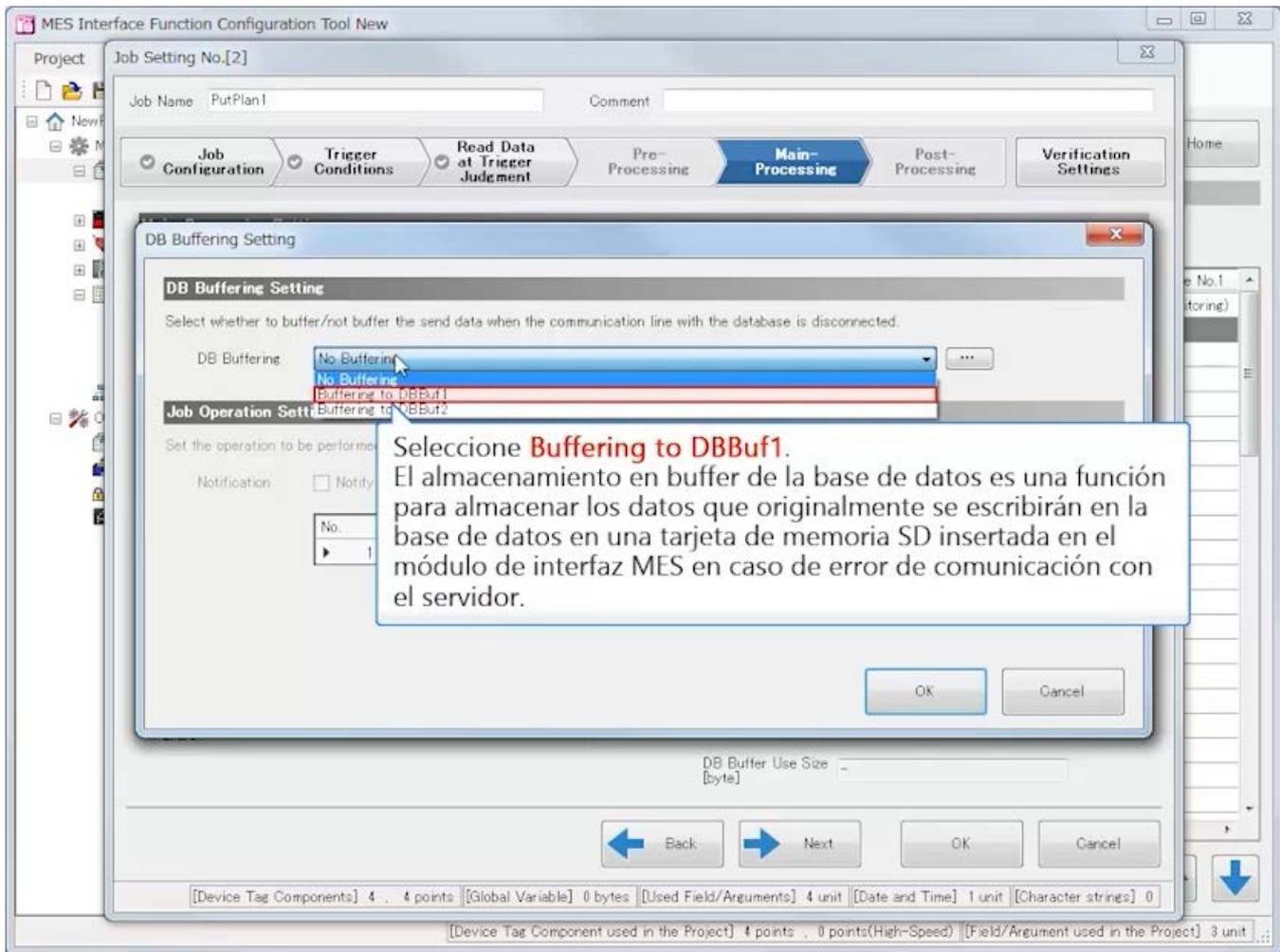
At Processing Notification: "Not Set" Change DB Buffering No Buffering Change

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 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

[Anterior](#)[Siguiente](#)

[Anterior](#)[Siguiente](#)

Project Job Setting No.[2]

Job Name PutPlan1 Comment

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

DB Buffering Setting

Select whether to buffer/not buffer the send data when the communication line with the database is disconnected.

DB Buffering Buffering to DBBut1

Job Operation Settings at DB Buffering

Set the operation to be performed after executing all actions for main-processing, whenever DB buffering is executed.

Notification Notify DB Buffering

No.	Notification Destination	(Data Type)	<->	Notification Data	(Data Type)
▶ 1			<-		

OK Cancel

Haga clic en el botón **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

Anterior

Siguiente

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

Cache Size 270

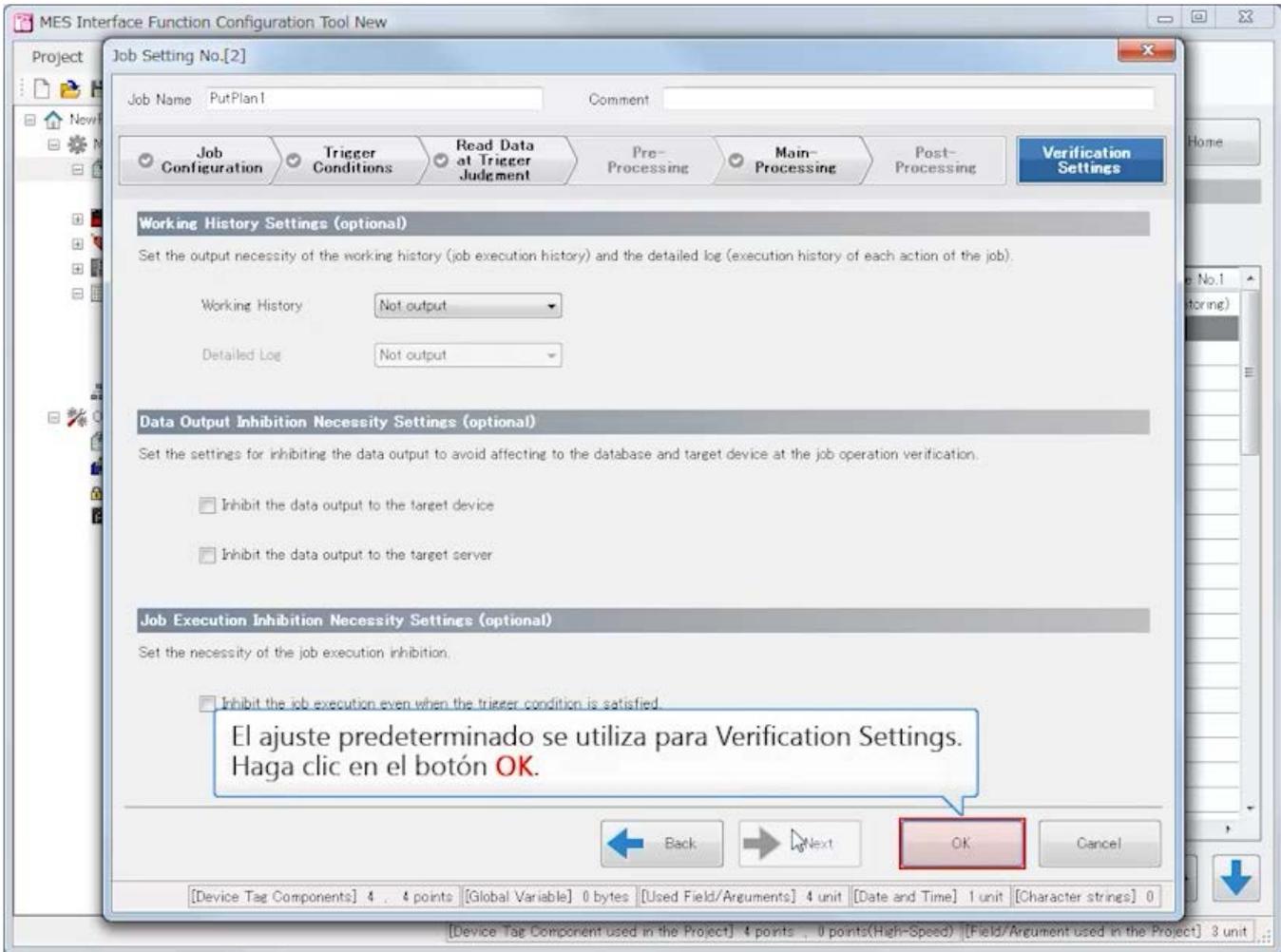
← Back **Next** → OK Cancel

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

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

Anterior

Siguiente



Anterior

Siguiete

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	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

Se completó el ajuste del trabajo "PutPlan1".
Haga clic en > para ir a la siguiente página.

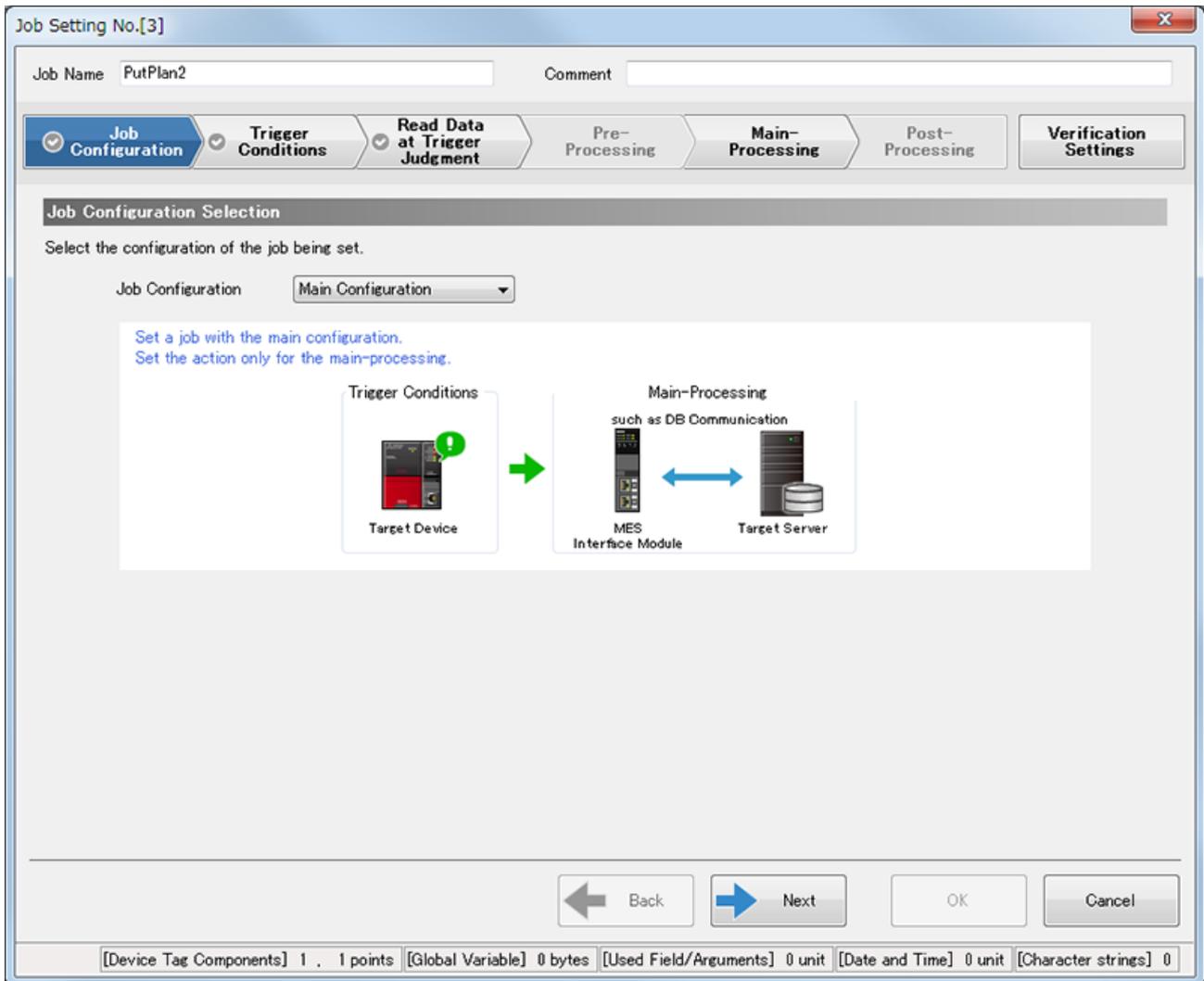
[Job Settings]

Cree un trabajo que actualice los datos en el registro de la base de datos cuando la fabricación finalice.

(3) Job Name: PutPlan2

[Job Configuration]

Job Configuration: Main Configuration



[Trigger Conditions]

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

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

- Trigger Buffering Setting (optional)
Trigger Buffering: Disable

Job Setting No.[3]

Job Name PutPlan2 Comment

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

Trigger Condition Configuration Settings

Select the configuration of the trigger condition.

Configuration Type:

Condition Combination Type:

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

Event/Condition Settings

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

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

Trigger Buffering Setting (optional)

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

Trigger Buffering:

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

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

[Read Data at Trigger Judgment]

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

Job Setting No.[3]

Job Name PutPlan2 Comment

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

Access Type Selection

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

Access Type General Access

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

Target Device MES Interface Module Network

Access Interval Settings

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

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

Reading Target Data Setting (optional)

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

Back Next OK Cancel

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

[Main-Processing]

• Main-Processing Settings

Action Type : DB Communication Action
DB Communication Type : Update
Access Table : PutPlan2.Database

Pestaña 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

Pestaña 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 Bufferings: Buffering to DBBuf2

Para configurar el almacenamiento en buffer de base de datos, seleccione "Use the DB buffer 2." en [DB Buffer Settings] de [Option Settings] con anticipación.

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 : No seleccionar
Inhibit the data output to the target server : No seleccionar
- Job Execution Inhibition Necessity Settings (optional)
Inhibit the job execution even when the trigger condition is satisfied.: No seleccionar

Job Setting No.[3] X

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

Detailed Log

Data Output Inhibition Necessity Settings (optional)

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

Inhibit the data output to the target device

Inhibit the data output to the target server

Job Execution Inhibition Necessity Settings (optional)

Set the necessity of the job execution inhibition.

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

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

Anterior

Siguiente

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

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.

Haga clic en el botón Reproducir.

	Job Setting	Event/Condition Type No.1
2	PutPlan1	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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

NewProject

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

Job Setting List

Home

Adding/Editing the Job Settings

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

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

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

Luego, configure el tercer parámetro de trabajo.
Haga clic derecho en la fila no. 3 en la Job Setting List.

[Anterior](#)[Siguiente](#)

The screenshot shows the 'MES Interface Function Configuration Tool New' window. The left sidebar contains a tree view of settings categories, including 'Job Settings' which is expanded to show 'GetPlan' and 'PutPlan1'. The main area displays a 'Job Setting List' table with columns for 'No.', 'Job Name', 'Comment', 'Job Configuration', and 'Event/Condition Type No.1'. The table contains two rows: row 1 with 'GetPlan' and row 2 with 'PutPlan1'. Row 3 is selected, and a context menu is open over it with options 'Edit', 'Delete', 'Add', and 'One'. A tooltip points to the 'Edit' option with the text: 'Seleccione Editar para crear un nuevo ajuste de trabajo. Haga clic en Edit desde el menú.' Below the table are 'Edit' and 'Delete' buttons. The status bar at the bottom shows project details.

Adding/Editing the Job Settings

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

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	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				

Seleccione Editar para crear un nuevo ajuste de trabajo.
Haga clic en **Edit** desde el menú.

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

Anterior

Siguiente

The screenshot displays the 'Job Setting No.[3]' window within the 'MES Interface Function Configuration Tool New'. The window is divided into several sections:

- Job Name:** A text field containing 'Job01'.
- Comment:** An empty text field.
- Job Configuration:** A dropdown menu set to 'Main Configuration'.
- Diagram:** A flow diagram illustrating the process flow. It starts with 'Trigger Conditions' (represented by a red and black icon) leading to 'Main-Processing such as DB Communication' (represented by a server rack icon). This processing step is connected to a 'Target Server' (represented by a server rack icon) via a double-headed blue arrow. A 'Target Device' (represented by a red and black icon) is also shown, connected to the 'Main-Processing' step by a green arrow.
- Buttons:** 'Back', 'Next', 'OK', and 'Cancel' buttons are located at the bottom of the window.
- Status Bar:** At the bottom of the window, there are several status indicators: '[Device Tag Components] 0 . . 0 points', '[Global Variable] 0 bytes', '[Used Field/Arguments] 0 unit', '[Date and Time] 0 unit', '[Character strings] 0', and '[Device Tag Component used in the Project] 8 points . . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit'.

A callout box with a blue border and a white background is positioned over the 'Job Name' field. It contains the following text in Spanish: 'Cree un trabajo que actualice los datos en el registro de la base de datos cuando la fabricación finalice. Haga clic en Job Name.' The text 'Job Name' is highlighted in red.

[Anterior](#)[Siguiete](#)

Job Setting No.[3]

Job Name: PutPlan2

Comment:

Job Configuration

Ingrese "PutPlan2" en el campo de entrada de nombre del trabajo.

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration: Main Configuration

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

Trigger Conditions

Target Device

Main-Processing
such as DB Communication

MES Interface Module

Target Server

Back Next OK Cancel

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

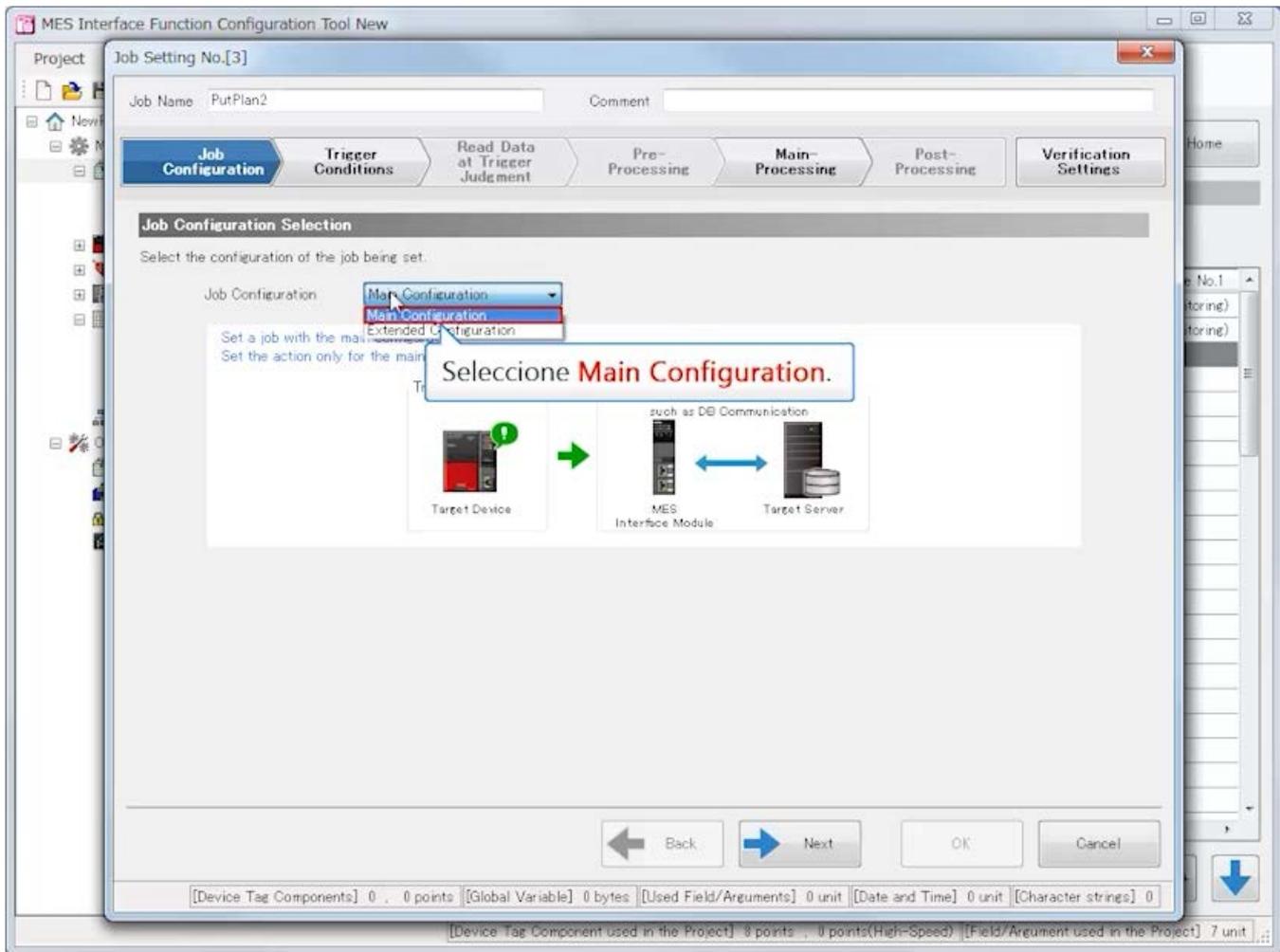
[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

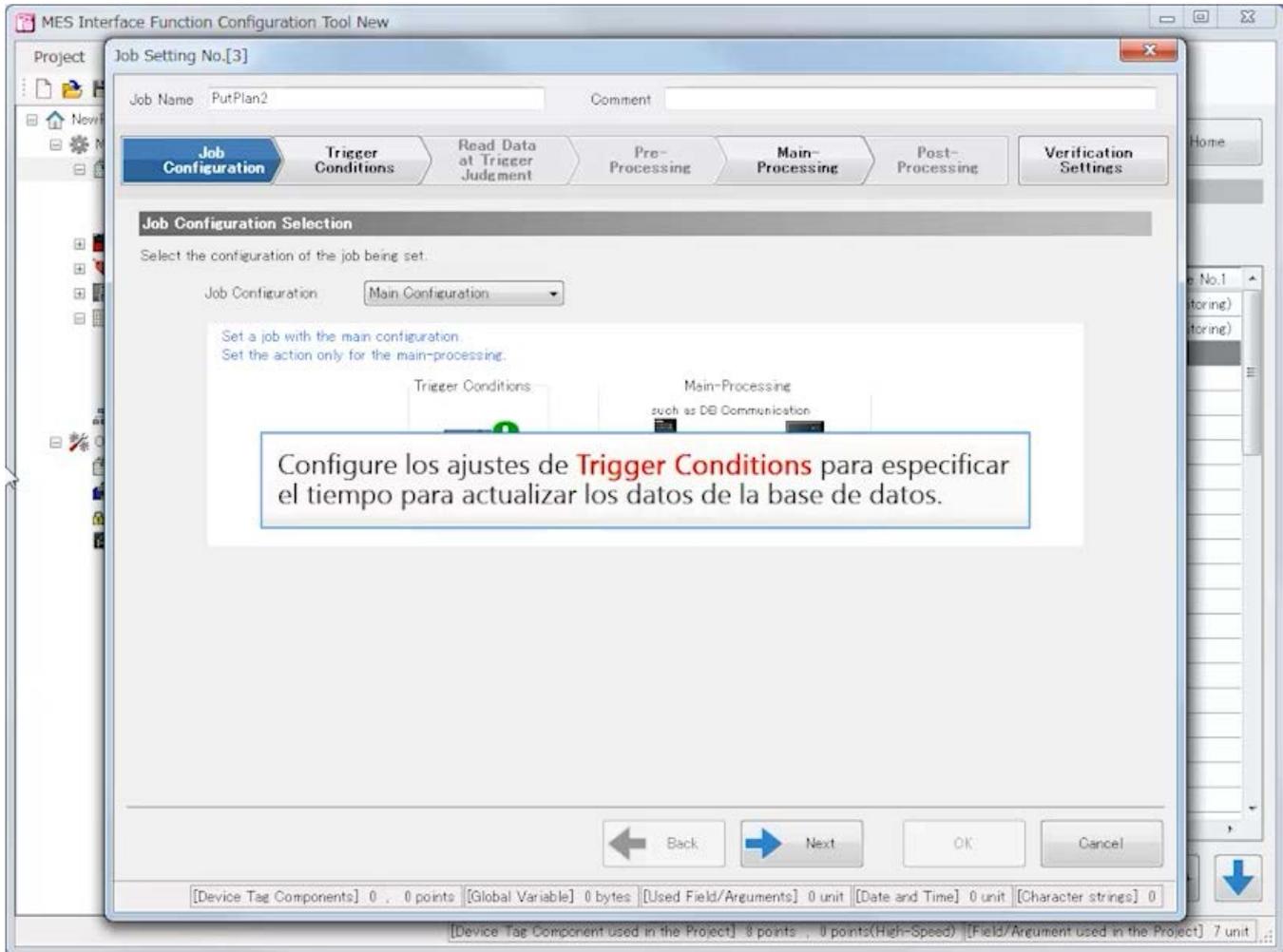
[Anterior](#)[Siguiete](#)

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The main window is titled 'Job Setting No.[3]' and contains a 'Job Name' field with 'PutPlan2' and a 'Comment' field. Below these are several tabs: 'Job Configuration', 'Trigger Conditions', 'Read Data at Trigger Judgment', 'Pre-Processing', 'Main-Processing', 'Post-Processing', and 'Verification Settings'. The 'Job Configuration' tab is active, showing a 'Job Configuration Selection' section with the instruction 'Select the configuration of the job being set.' and a dropdown menu currently set to 'Main Configuration'. A callout box with a blue border and white background contains the text: 'Seleccione la configuración de trabajo que se está ajustando. Haga clic en **Job Configuration**.' Below the callout is a diagram showing a 'Target Device' connected to a 'MES Interface Module', which is in turn connected to a 'Target Server'. At the bottom of the window, there are 'Back', 'Next', 'OK', and 'Cancel' buttons, and a status bar with various resource usage metrics.

Anterior

Siguiente



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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

Job Configuration Selection

Select the configuration of the job being set.

Job Configuration: Main Configuration

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

Trigger Conditions Main-Processing
such as DB Communication

Configure los ajustes de **Trigger Conditions** para especificar el tiempo para actualizar los datos de la base de datos.

Haga clic en **Next**.

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

Anterior

Siguiente

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.

Haga clic en Configuration Type.

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

Anterior

Siguiente

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 Co Precondition

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

Event/Condition Settings

Set each event/condition to be used at Trigger

No.	Event/Condition Type	Detail type	Content
1			

Edit Delete

Trigger Buffering Setting (optional)

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

Trigger Buffering Disable

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

Trigger Condition is Satisfied OR Trigger Condition is Satisfied

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

Anterior

Siguiente

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

Condition Combination Type

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

Event/Condition Settings

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

No.	Event/Condition Type	Detail Type	Content
1			

Establezca el evento/condición.
Haga clic en el botón **Edit**.

Trigger Buffering Setting (optional)

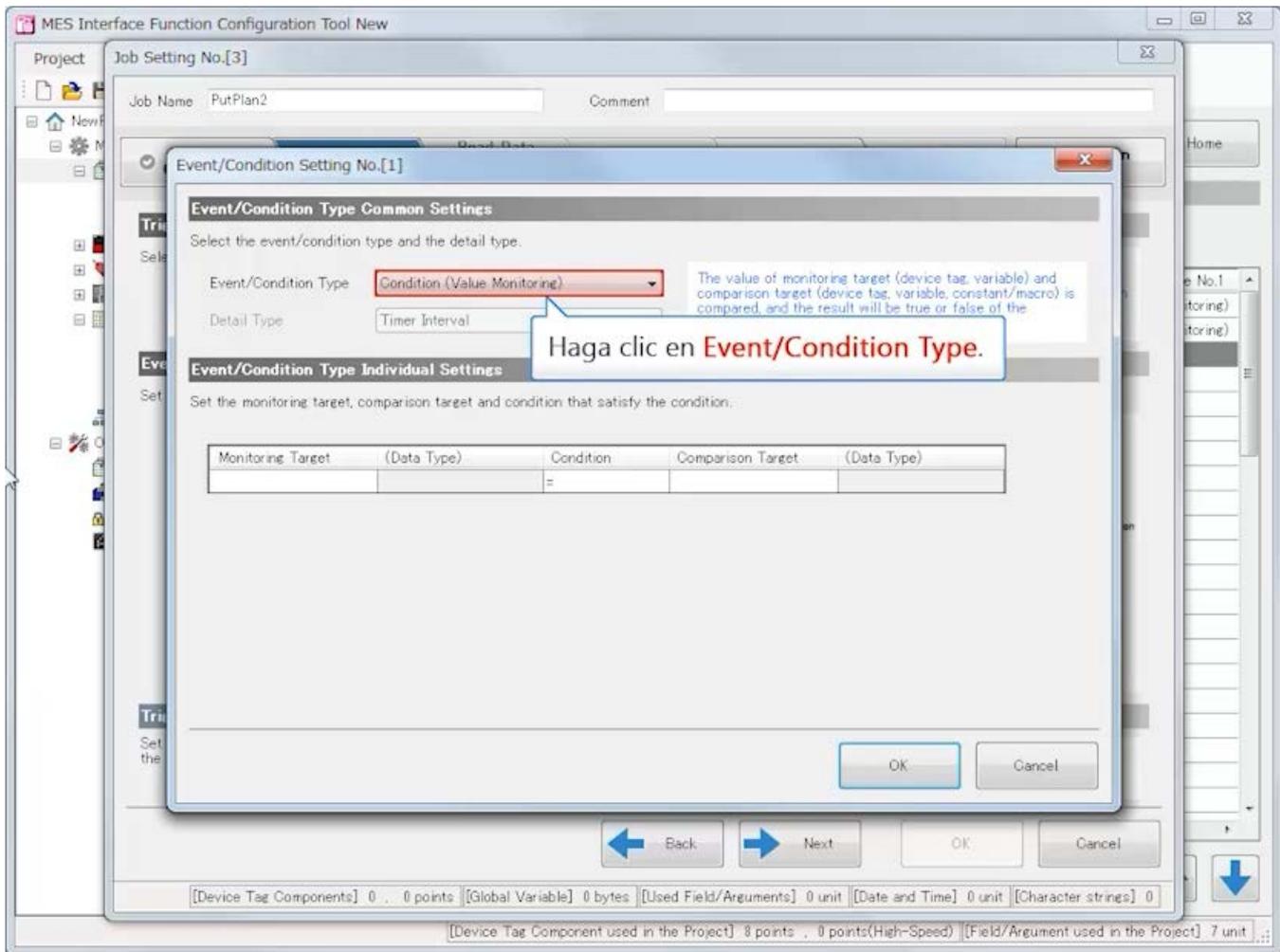
Set the operation of the job whenever the trigger conditions are satisfied at the same time.

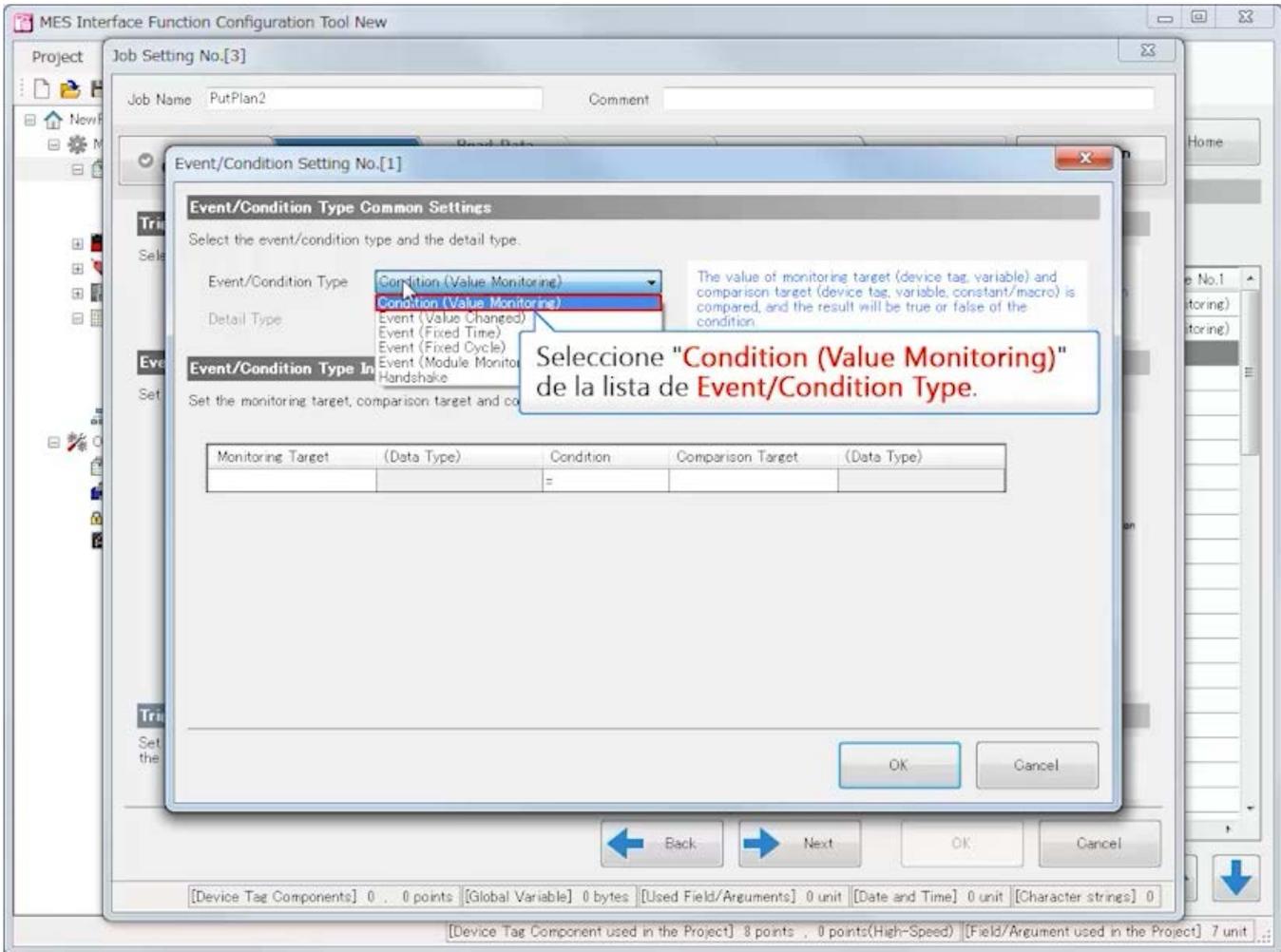
Trigger Buffering

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

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

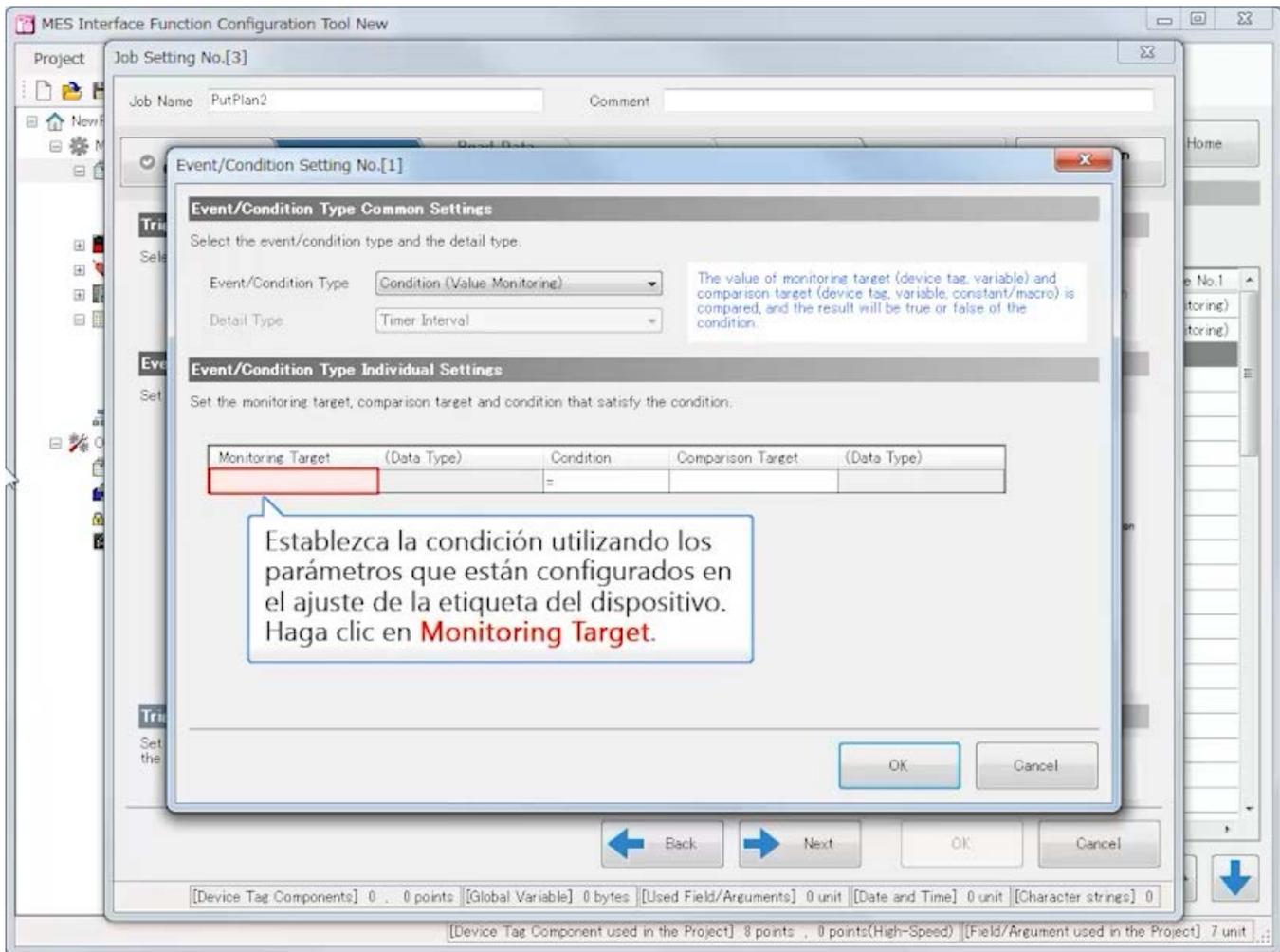
[Device Tag Component used in the Project] 8 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

[Anterior](#)[Siguiete](#)

[Anterior](#)[Siguiente](#)

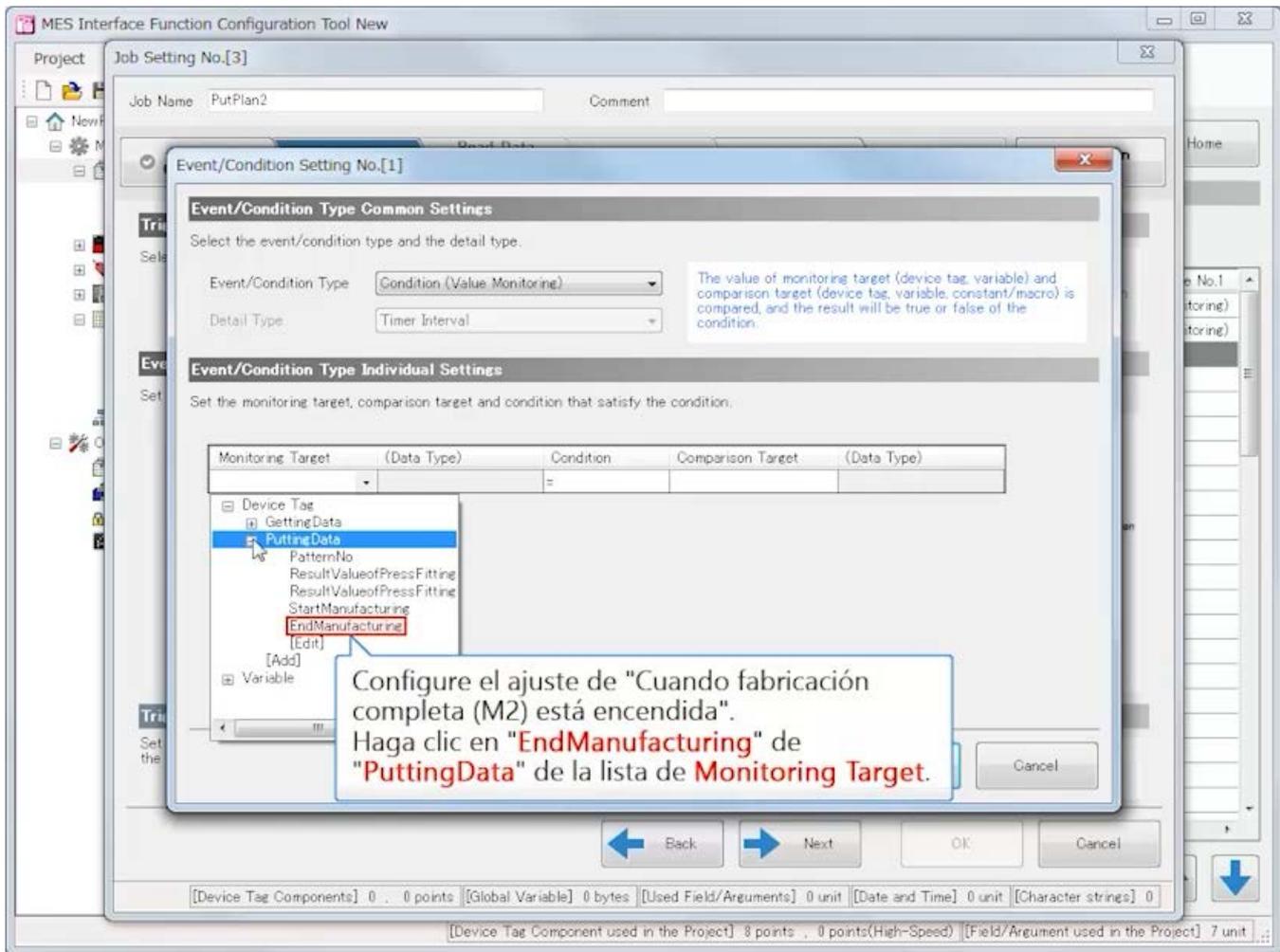
Anterior

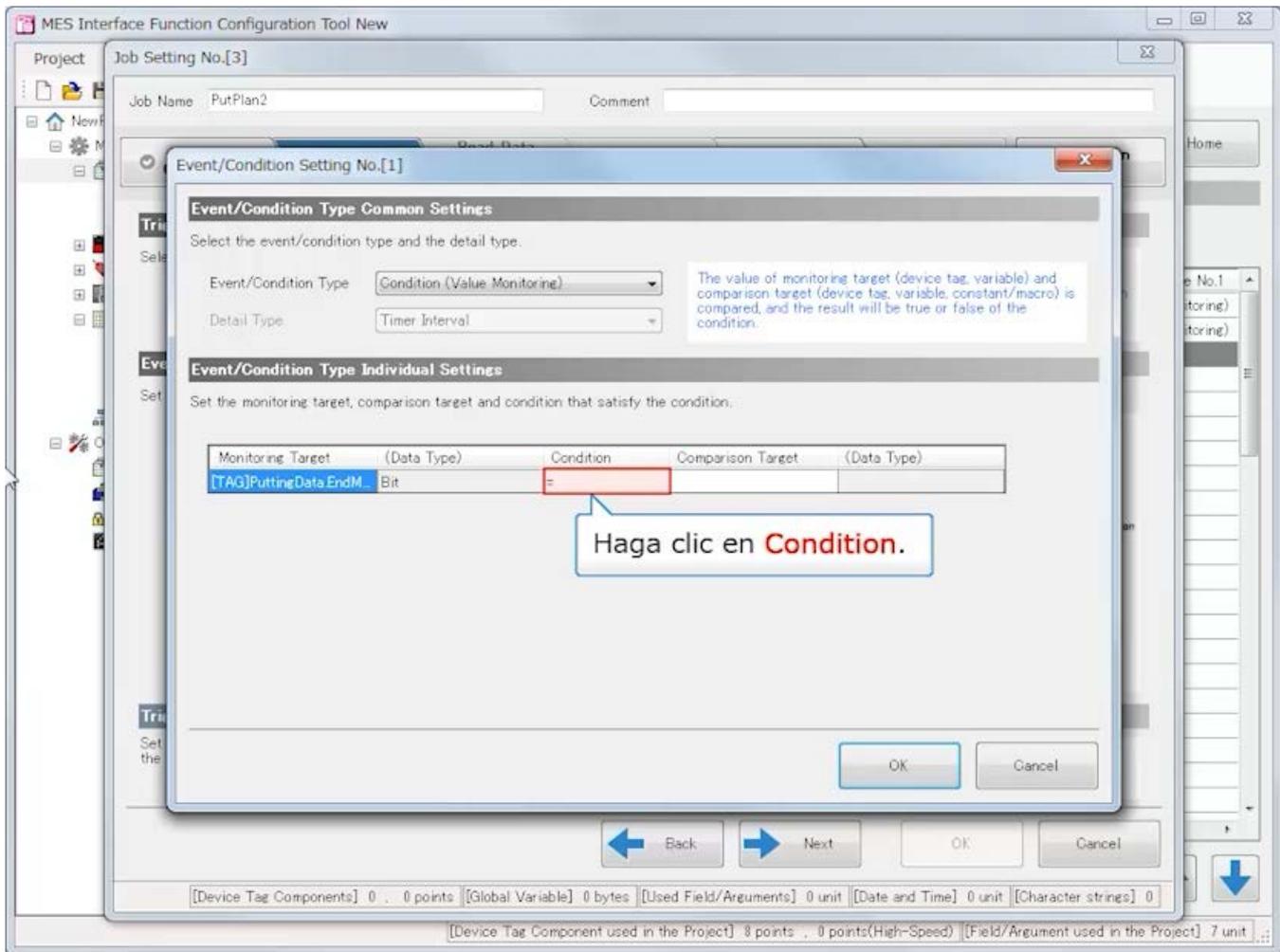
Siguiente



Anterior

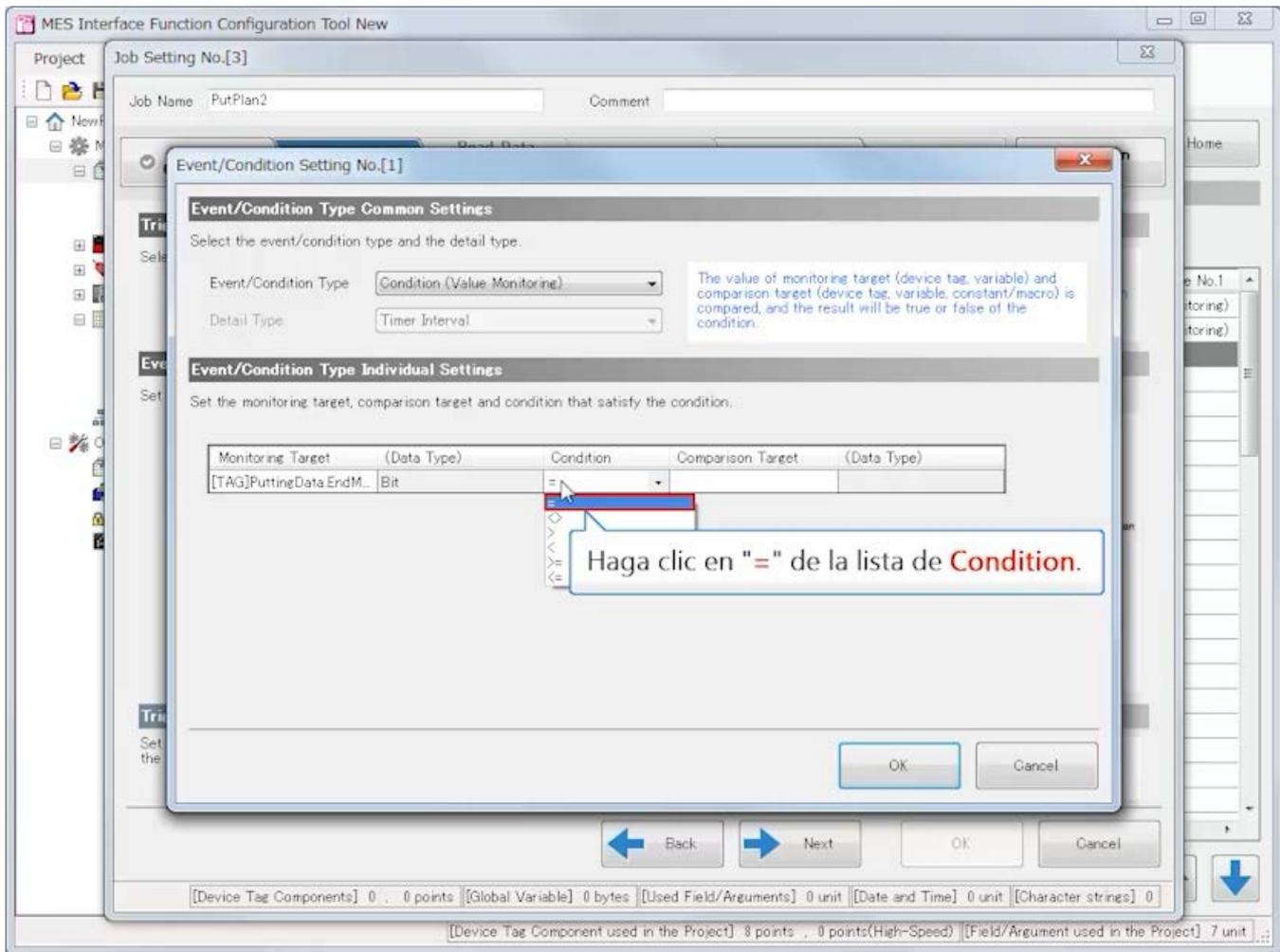
Siguiente

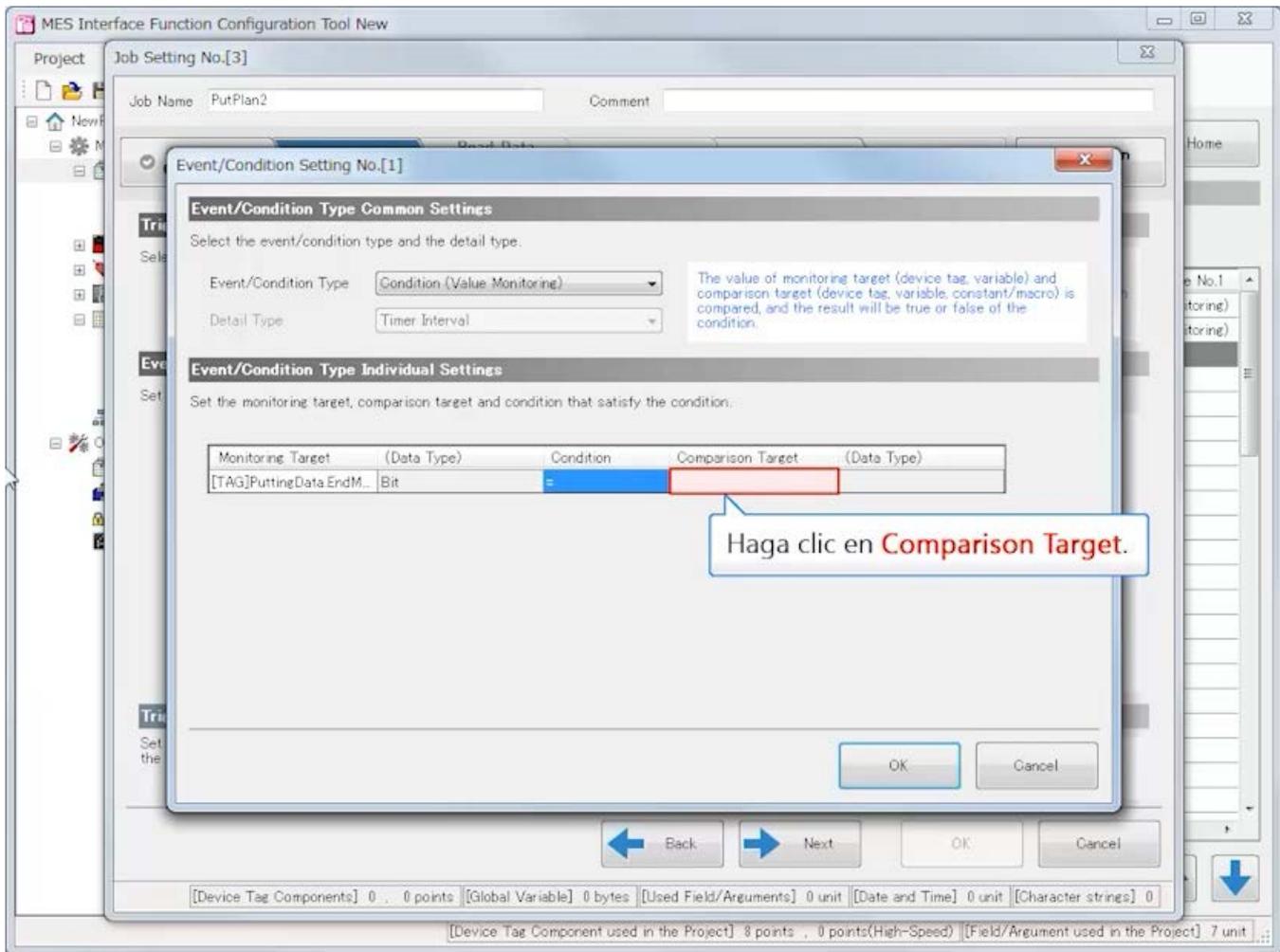


[Anterior](#)[Siguiente](#)

Anterior

Siguiente



[Anterior](#)[Siguiente](#)

Anterior

Siguiente

Event/Condition Setting No.[1]

Event/Condition Type Common Settings

Select the event/condition type and the detail type.

Event/Condition Type: Condition (Value Monitoring)

Detail Type: Timer Interval

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

Event/Condition Type Individual Settings

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

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

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

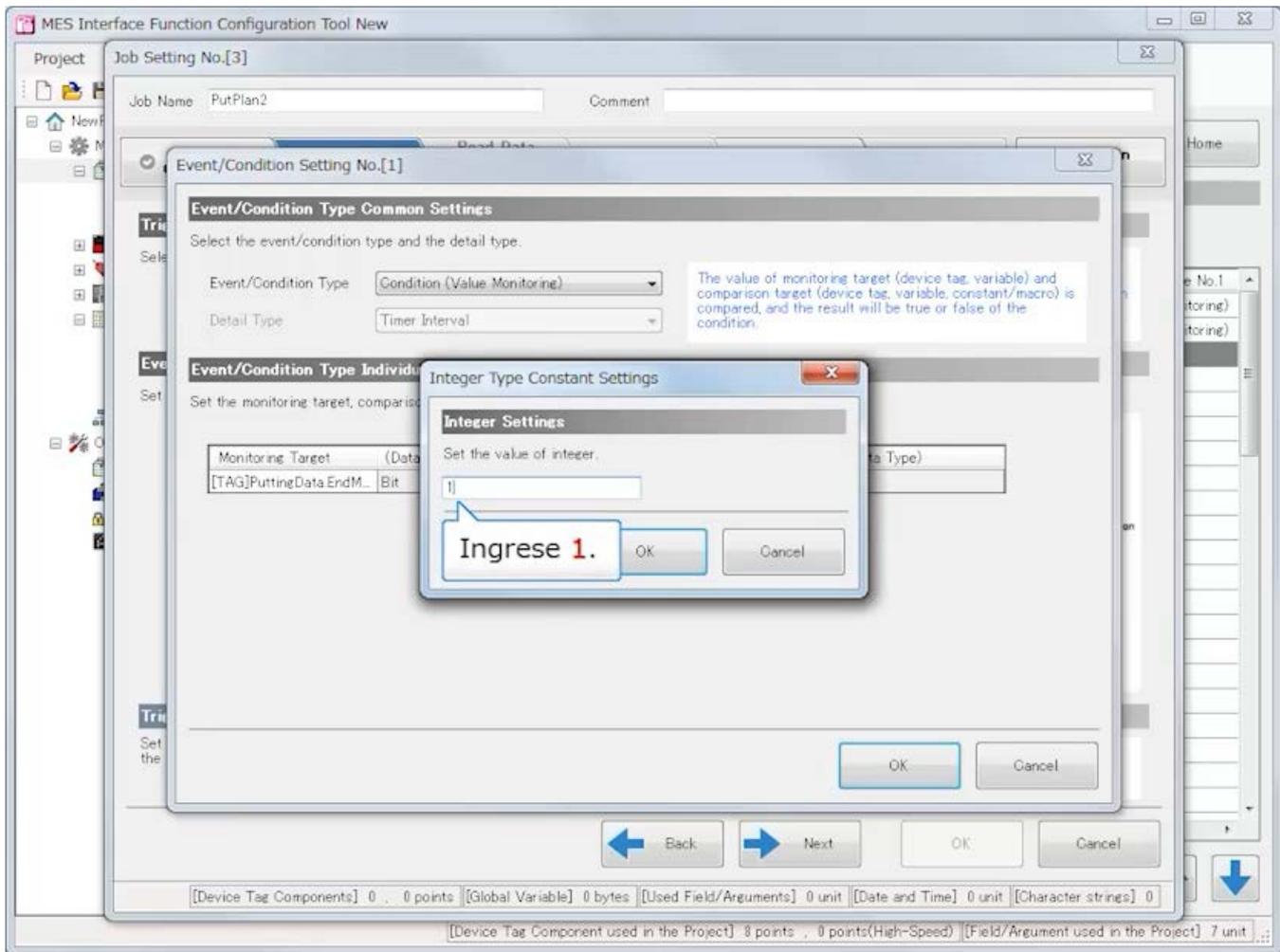
Haga clic en "Integer" de la lista de Comparison Target.

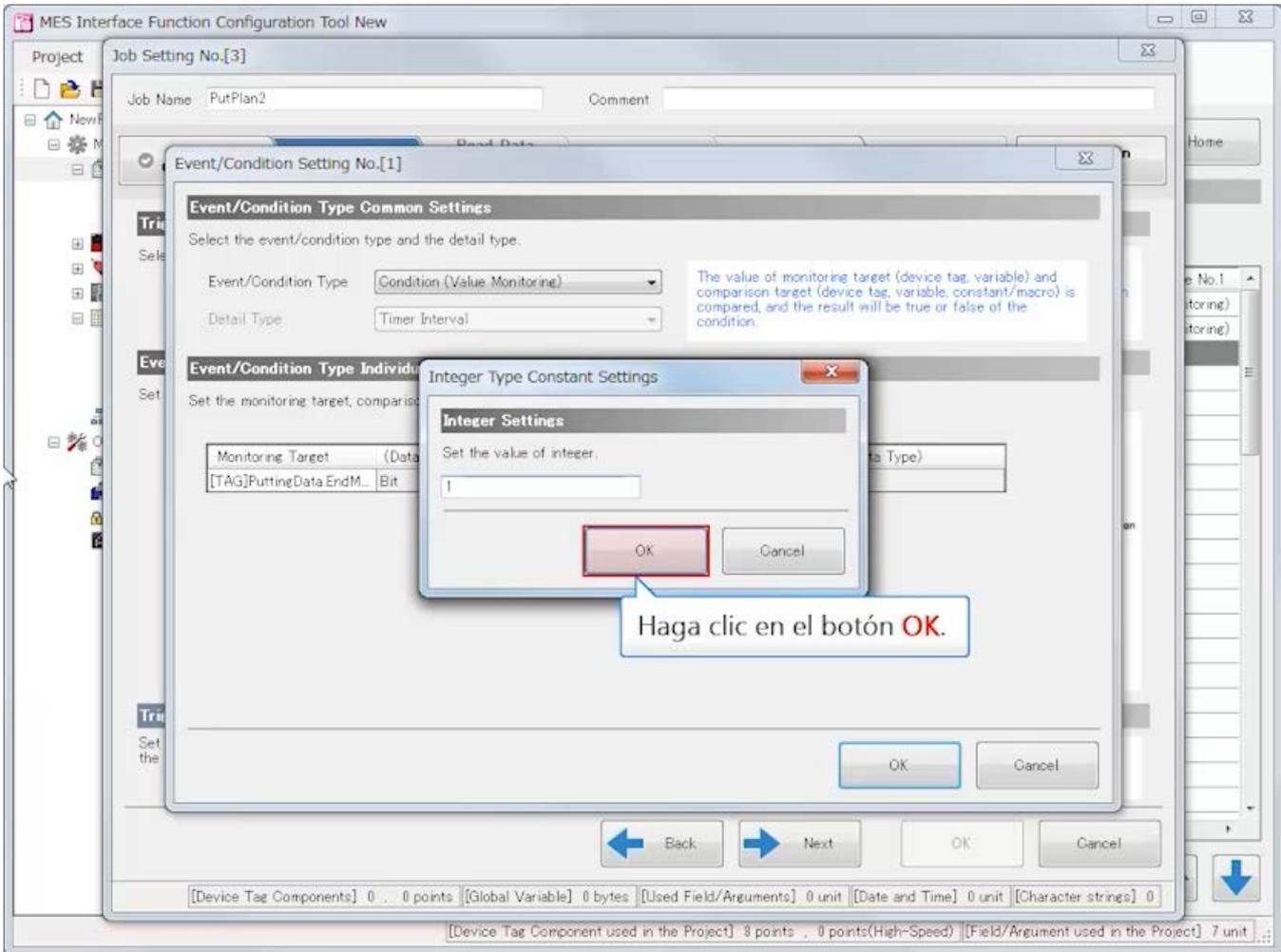
OK Cancel

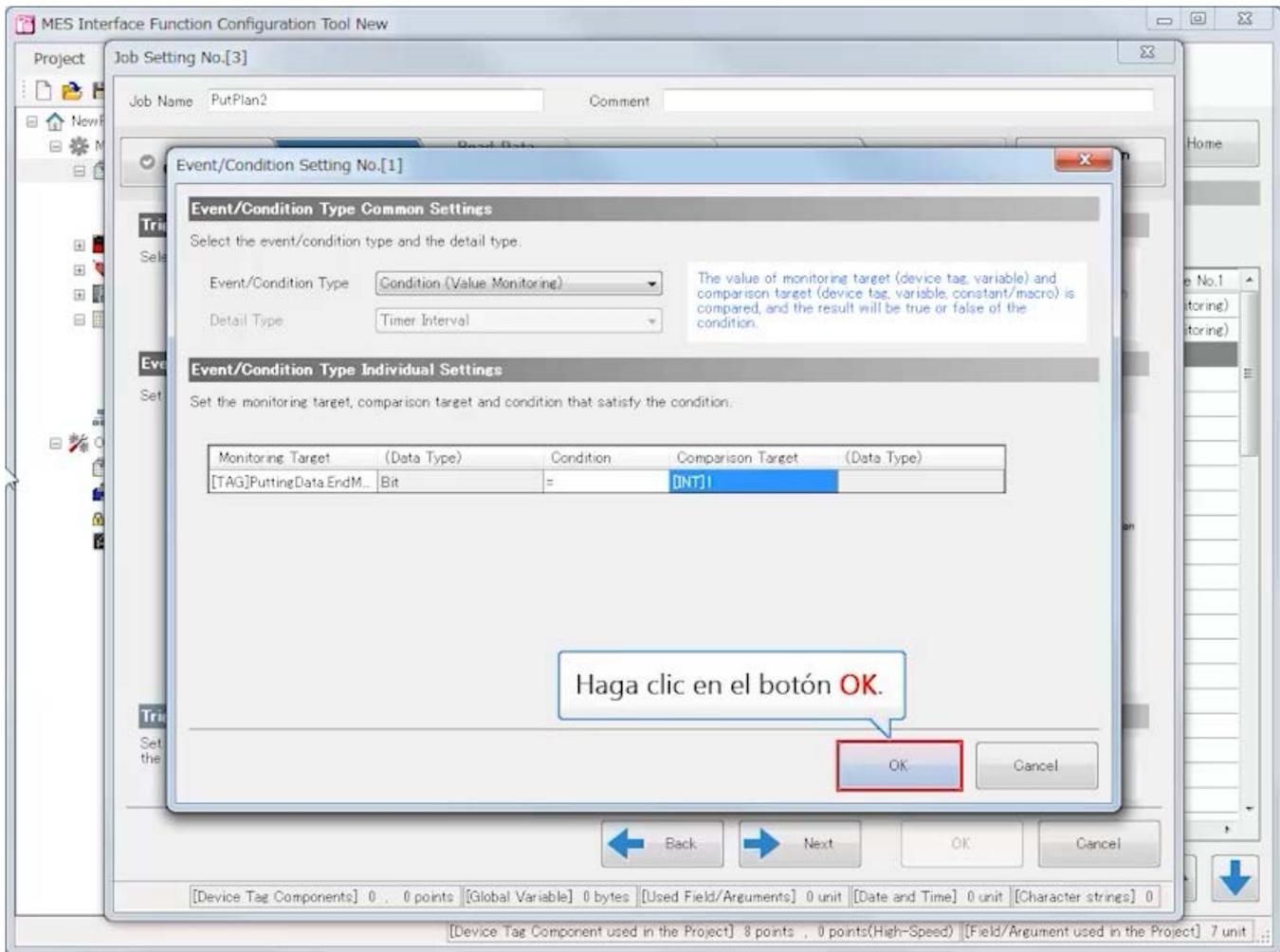
Back Next OK Cancel

[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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Anterior

Siguiente

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

Condition Combination Type

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

Event/Condition Settings

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

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

Edit Delete

Trigger Buffering Setting (optional)

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

Trigger Buffering

Haga clic en Next.

if the trigger condition of the same job is satisfied at the same time, the satisfied trigger condition will be

Back Next OK Cancel

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

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

Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Job Setting No.[3]

Job Name PutPlan2 Comment

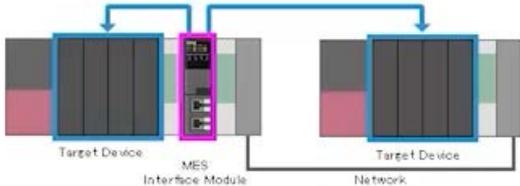
Job Configuration Trigger Conditions **Read Data at Trigger Judgment** Pre-Processing Main-Processing Post-Processing Verification Settings

Access Type Selection

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

Access Type

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 s

Reading Target Data Settings

Reading Target Data

Utilice el ajuste predeterminado para Read Data at Trigger Judgment. Haga clic en el botón **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

Anterior

Siguiente

The screenshot displays the 'MES Interface Function Configuration Tool New' window. The 'Job Setting No.[3]' dialog is open, showing the 'Main-Processing' tab selected in a sequence of tabs: Job Configuration, Trigger Conditions, Read Data at Trigger Judgment, Pre-Processing, Main-Processing, Post-Processing, and Verification Settings. The 'Job Name' is 'PutPlan2' and the 'Comment' field is empty.

The 'Main-Processing Settings' section includes a table with the following columns: No., Action Type, and Content. The table contains one row with '1' in the 'No.' column. Below the table are 'Edit' and 'Delete' buttons, and up/down arrow buttons.

Below the table, there are two optional settings sections:

- Operation Settings at Main-Processing Failure (optional):** At Processing Failure, Notification: "Not Set" (with a 'Change' button).
- DB Buffering Settings (optional):** DB Buffering: No Buffering (with a 'Change' button). DB Buffer Use Size [byte]: -

At the bottom, there are 'Back', 'Next', 'OK', and 'Cancel' buttons. A status bar at the very bottom shows resource usage: [Device Tag Components] 1 / 1 points, [Global Variable] 0 bytes, [Used Field/Arguments] 0 unit, [Date and Time] 0 unit, [Character strings] 0, [Device Tag Component used in the Project] 3 points / 0 points(High-Speed), [Field/Argument used in the Project] 7 unit.

A callout box with a blue border and white background is overlaid on the table, containing the text: "Configure el ajuste de main-processing. Haga clic en el botón **Edit**."

Anterior

Siguiente

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, click the "Edit" button.

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

Edit

Main-Processing Action No.[1]

Action Type Selection

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

DB Communication Action Operation Action

External Comment

Place the cursor

Establezca la acción para la entrada/salida de datos en el servidor de destino.
Haga clic en el botón **DB Communication Action**.

Cancel

Operation Settings at Main-Processing

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

DB Buffer Use Size [byte]

Back Next OK Cancel

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

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

Anterior

Siguiente

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: **Insert**

Access Table: (Add)

Data Assignment Option

Data Assignment Settings

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

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

Batch Insertion Delete

Execution SQL Statements
INSERT INTO () VALUES ();

OK Cancel

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

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: **Update**

Access Table: ...

Data Assignment: Option

Data Assignment Settings

Set the assignment of the data to be input.

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

Batch Insertion Delete

Execution SQL Statements

```
INSERT INTO () VALUES ();
```

OK Cancel

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

Los datos de la base de datos se actualizan con el trabajo, "PutPlan2". Haga clic en **Update** de la lista de **DB Communication Type**.

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: (Add)

MES Interface Module ↔ Database Server

Data Assignment Settings

Set the assignment of the data to be in

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

Batch Insertion Delete

Execution SQL Statements
UPDATE SET;

OK Cancel

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

Anterior

Siguiente

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: (Add) | GetPlan1.DataServer | PutPlan1.DataServer | PutPlan2.DataServer | (Add)

Data Assignment: Narrowing-Down

Data Assignment Settings

Set the assignment of the data to be input.

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

Batch Insertion Delete

Execution SQL Statements
UPDATE SET;

OK Cancel

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

Anterior

Siguiente

DB Communication Action Setting

DB Communication Action Settings

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

Data Assignment: Narrowing-Down Conditions | Option | Exception

Data Assignment Settings

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

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

Batch Insertion Delete

Execution SQL Statements

UPDATE [ResultTable] SET ;

OK Cancel

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

Seleccione la memoria del dispositivo del módulo de CPU, que son los datos que se actualizarán en la base de datos. Haga clic en **Assignment Data** de **LoadResult**.

Anterior

Siguiente

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	<-		
3	HeightResult	Integer	<-		
4	EndTime	Date and Time	<-		
5					
6					

Device Tag Settings:

- GettingData
 - PuttingData
 - PatternNo
 - ResultValueofPressFit
 - ResultValueofPressFitting
 - ResultValueofPressFitting

Batch Insertion Delete

Execution SQL Statements:
UPDATE [ResultTable] SET ;

OK Cancel

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

Dado que el signo de D200 se establece como el componente "ResultValueofProcessFittingLoad" en device tag settings, haga clic en "ResultValueofPressFittingLoad" en "PuttingData" de la lista de Assignment Data.

Anterior

Siguiente

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

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					

Luego, establezca los siguientes parámetros de enlace en la fila n.º 3 a 4.
El procedimiento de ajuste es el mismo que "LoadResult".
El ajuste de operación se omite en este curso.

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

Anterior

Siguiente

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

Data Assignment Settings

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

No.	Access Field	(Data Type)	<=>	Assignment Data	(Data Type)
1	PatternNo.	Integer	<-		
2	LoadResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
3	HeightResult	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	EndTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Se completó data assignment settings.

Anterior

Siguiente

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

Data Assignment Settings

Set the assignment of the

No.	Access	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
1	PatternN				
2	LoadResu				
3	HeightRes	Integer	<-	[TAG]PuttingData.ResultValueof...	Word [Unsigne...
4	EndTime	Date and Time	<-	[MACRO].Job Execution Start Da...	Date and Time
5					
6					
7					
8					
9					
10					
11					
12					

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Luego, configure el ajuste de **narrowing-down condition**. Establezca el registro para que se actualice con los ajustes configurados en "Data Assignment Settings". Haga clic en la pestaña **Narrowing-Down Condition**.

Anterior

Siguiente

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						
2						
3						
4						
5						
6						
7						
8						

Haga clic en **Access Field**.

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Anterior

Siguiente

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

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

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

Batch Insertion | Delete

↑ ↓

Execution SQL Statements

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

OK Cancel

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

Haga clic en "PatternNo" de la lista de Access Field.

Anterior

Siguiente

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	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Haga clic en **Condition**.

Anterior

Siguiente

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	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Haga clic en "=" de la lista de **Condition**.

Anterior

Siguiente

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	=		
2						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Seleccione la etiqueta del dispositivo para que sea el objetivo de comparación. Haga clic en **Comparison Target**.

Anterior

Siguiente

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	=	PuttingData	
2						
3						
4						
5						

Dado que el signo de D0 se establece como el componente "PatternNo" en device tag settings, haga clic en "PatternNo" en "PuttingData" de la lista de Comparison Target.

Execution SQL Statements

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

OK Cancel

[Device Tag Component used in the Project] 3 points | [Field/Argument used in the Project] 7 unit

Anterior

Siguiente

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						
3						
4						
5						
6						
7						
8						

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Luego, establezca la segunda condición. Haga clic en **Combination**.

Anterior

Siguiente

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						
3	AND					
4	OR					
5						
6						
7						
8						

Batch Insertion Delete

↑ ↓

Execution SQL Statements

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

OK Cancel

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

Establezca la combinación de Y para la segunda condición. Haga clic en "AND" de la lista de **Combination**.

Anterior

Siguiente

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			=		
3						
4						
5						
6						
7						
8						

Haga clic en **Access Field**.

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Anterior

Siguiente

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			=		
3		PatternNo				
4		LoadResult				
5		HeightResu				
6		EndTime				
7						
8						

Haga clic en "LoadResult" de la lista de Access Field.

Batch Insertion Delete

Execution SQL Statements

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

OK Cancel

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

Anterior

Siguiente

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						

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

Haga clic en **Condition**.

Anterior

Siguiente

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						

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

Haga clic en "=" de la lista de Condition.

Anterior

Siguiente

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						

En lugar de especificar la etiqueta del dispositivo, especifique directamente el valor numérico. Haga clic en **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

Anterior

Siguiente

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					Device Tag	
4					Variable	
5					Constant	
6					Integer	
					Number	
					Enter String (Unicode)	

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 ...

Dado que "0" fue escrito en LoadResult anteriormente, se actualiza el registro con LoadResult "0" al finalizar la fabricación. Esto evita sobrescribir el registro en el que ya se ha restablecido el valor resultante. Haga clic en "Integer" de la lista de Comparison Target.

Anterior

Siguiente

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	Acc	PatternNo	(Data Type)
1				
2	AND	Load		Word [Unsig...
3				
4				
5				
6				
7				
8				

Batch Insertion | Delete

Integer Type Constant Settings

Integer Settings

Set the value of integer.

0

Ingrese 0. OK Cancel

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

[Anterior](#)[Siguiete](#)

DB Communication Action Setting

Set the DB communication action.

DB Communication Type: Update

Access Table: PutPlan2DataServer

MES Interface Module ↔ Database Server

Data Assignment | Narrowing-Down Conditions | Option | Exception

Narrowing-Down Condition Settings

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

No.	Combination	Acc	PatternNo	(Data Type)
1				
2	AND	Load		Word [Unsig...
3				
4				
5				
6				
7				
8				

Batch Insertion | Delete

Integer Type Constant Settings

Integer Settings

Set the value of integer.

0

OK | Cancel

Haga clic en el botón OK.

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

Anterior

Siguiente

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	=	[INT]0	
3						

Luego, agregue los valores de la siguiente tabla a la tercera condición.
El procedimiento de ajuste es el mismo que "LoadResult".
El ajuste de operación se omite en este curso.

Combination	Access Field	(Data Type)	Condition	Comparison Target	(Data Type)
AND	HeightResult	Integer	=	[INT]0	

Execution SQL Statements

```
UPDATE [ResultTable] SET [LoadResult] = (PuttingData.ResultValueofPressFittingLoad), [HeightResult] = (PuttingData.ResultValueofPressFittingHeight), [EndTime] = [YYYY-MM-DD hh:mm:ss] WHERE [PatternNo] = (PuttingData.PatternNo) AND [LoadResult] = 0;
```

OK Cancel

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

Anterior

Siguiente

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	=	[INT]0	
3	AND	HeightResult	Integer	=	[INT]0	
4						
5						
6						
7						
8						

Se completó el registro de **Narrowing-Down Condition**.

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] = 0 AND [HeightResult] = 0.
```

OK Cancel

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

Anterior

Siguiente

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	=	[INT]0	
3	AND	HeightResult	Integer	=	[INT]0	
4						
5						
6						
7						
8						

Batch Insertion Delete

DB Communication Action Settings se completó.
Haga clic en el botón OK.

Execution SQL Sta
UPDATE [ResultTe
= (PuttingData Res
[PatternNo] = (PuttingData PatternNo) AND [LoadResult] = 0 AND [HeightResult] = 0.

OK Cancel

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

Anterior

Siguiente

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

Establezca el almacenamiento en buffer de la base de datos.
Haga clic en el botón **Change**.

Operation Settings at Main-Processing

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

DB Buffer Use Size [byte]

Back Next OK Cancel

[Device Tag Components] 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

Anterior

Siguiente

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		

Para establecer el almacenamiento en buffer de base de datos, seleccione "Use the DB buffer 2." en DB Buffer Settings de Option Settings.

Establezca el almacenamiento en buffer de la base de datos. Haga clic en el botón **Change**.

Operation Settings at Main-Processing

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

DB Buffer Use Size [byte]

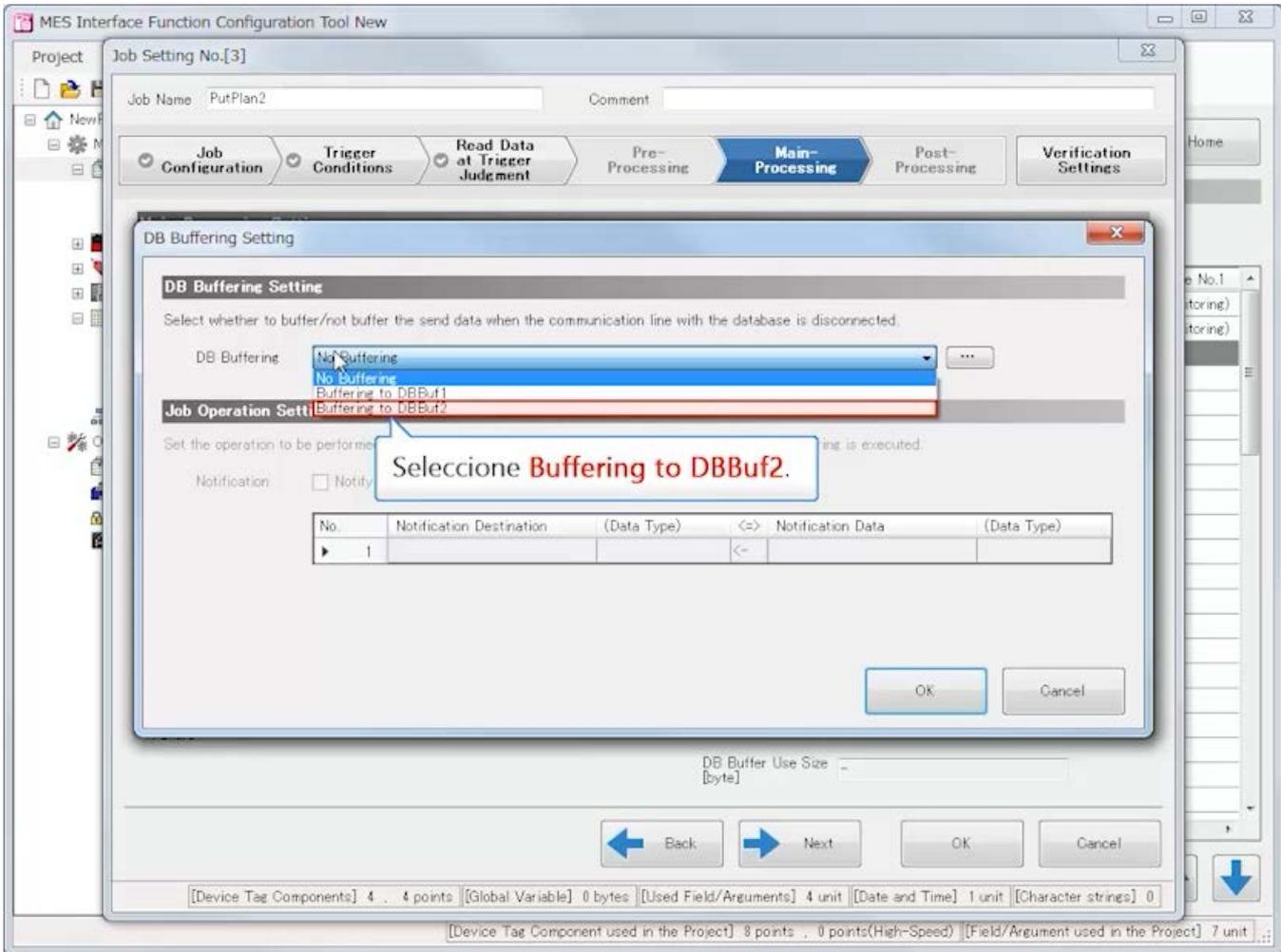
Back Next OK Cancel

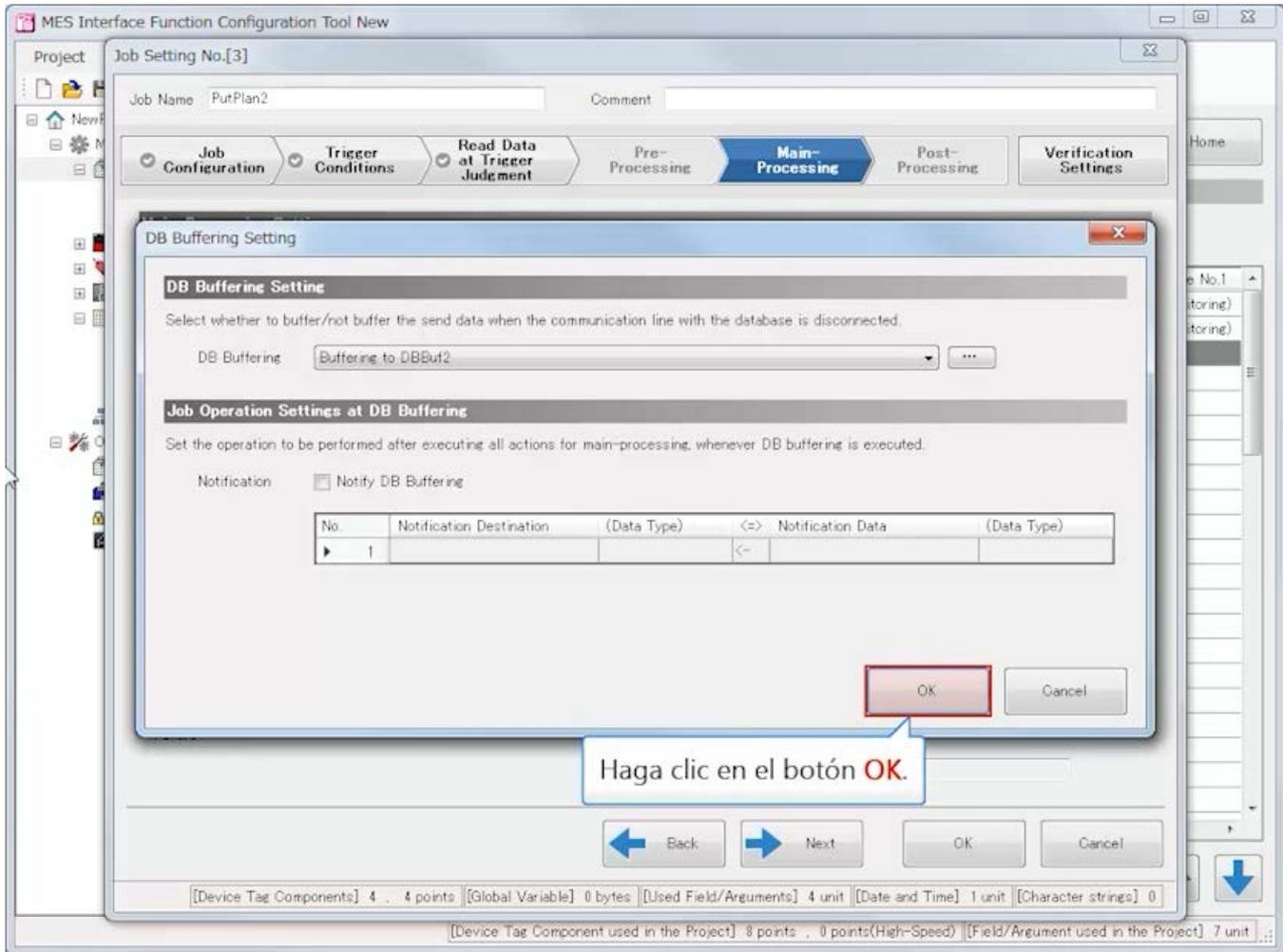
[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

[Device Tag Component used in the Project] 3 points . 0 points(High-Speed) [Field/Argument used in the Project] 7 unit

Anterior

Siguiente



[Anterior](#)[Siguiente](#)

Anterior

Siguiente

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 850

Back Next OK Cancel

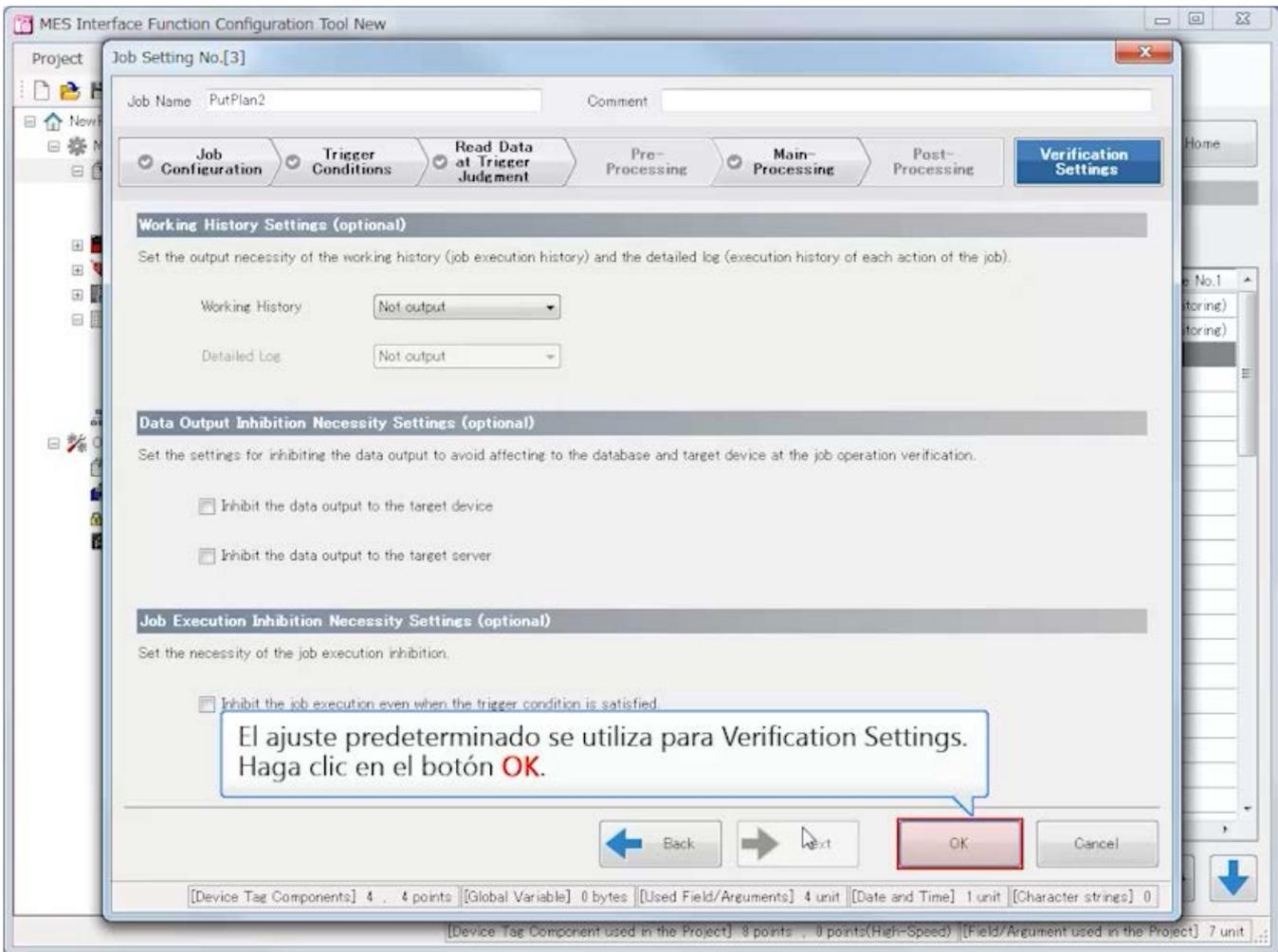
[Device Tag Components] 4 . 4 points [Global Variable] 0 bytes [Used Field/Arguments] 4 unit [Date and Time] 1 unit [Character strings] 0

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

Haga clic en Next.

Anterior

Siguiente



Anterior

Siguiente

MES Interface Function Configuration Tool New

Project Edit View Online Help

Job Setting List

Home

Adding/Editing the Job Settings

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

No.	Job Name	Comment	Job Configuration	Event/Condition Type No.1
1	GetPlan		Main Configuration	Condition (Value Monitoring)
2	PutPlan1		Main Configuration	Condition (Value Monitoring)
3	PutPlan2		Main Configuration	Condition (Value Monitoring)
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				
21				

Edit Delete

Se completó el ajuste del trabajo "PutPlan2".
Haga clic en > para ir a la siguiente página.

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

Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**

Haga clic en el botón Reproducir.

Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**

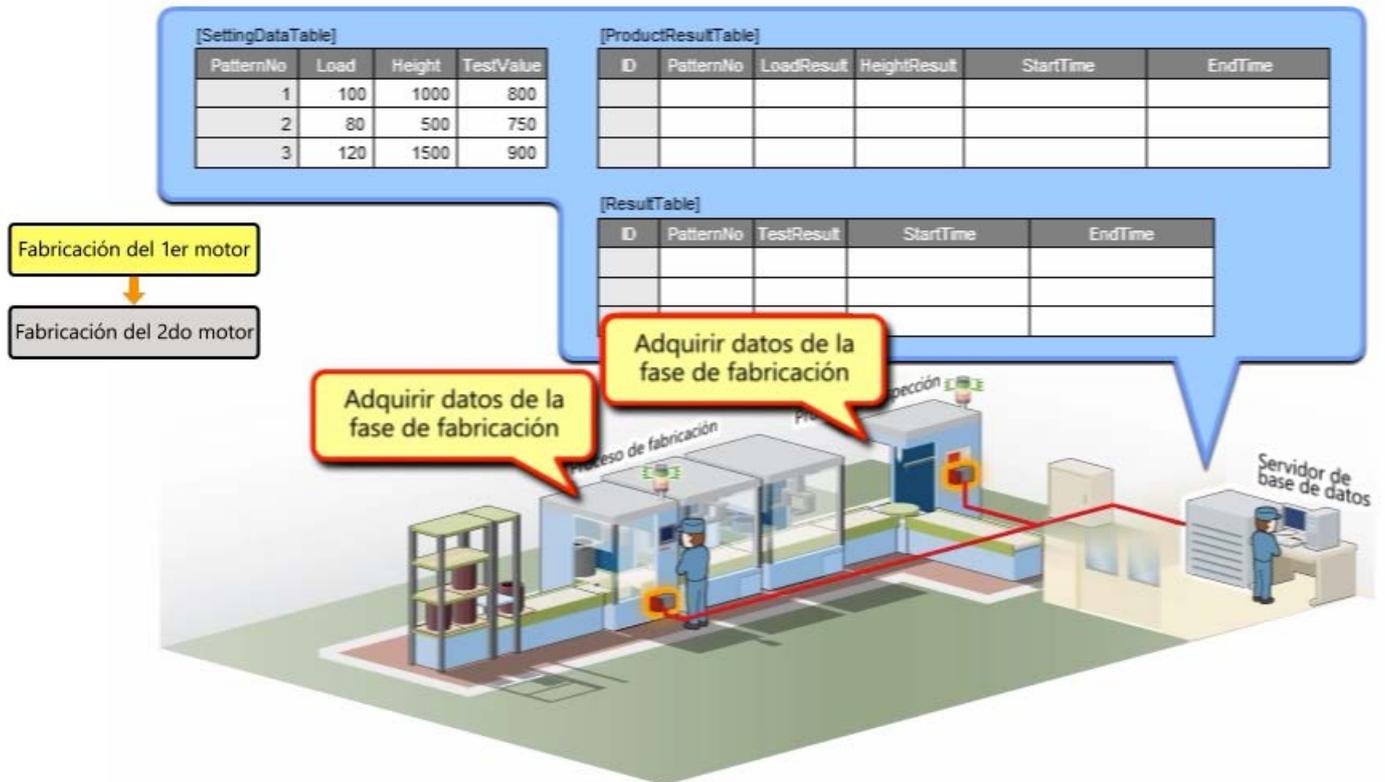
Usted ha aprendido cómo conectar la memoria del dispositivo del módulo de CPU y la tabla de la base de datos utilizando el módulo de interfaz MES tomando un equipo como ejemplo.

En esta sección, verá el ejemplo del sistema operado en varias máquinas.

Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**



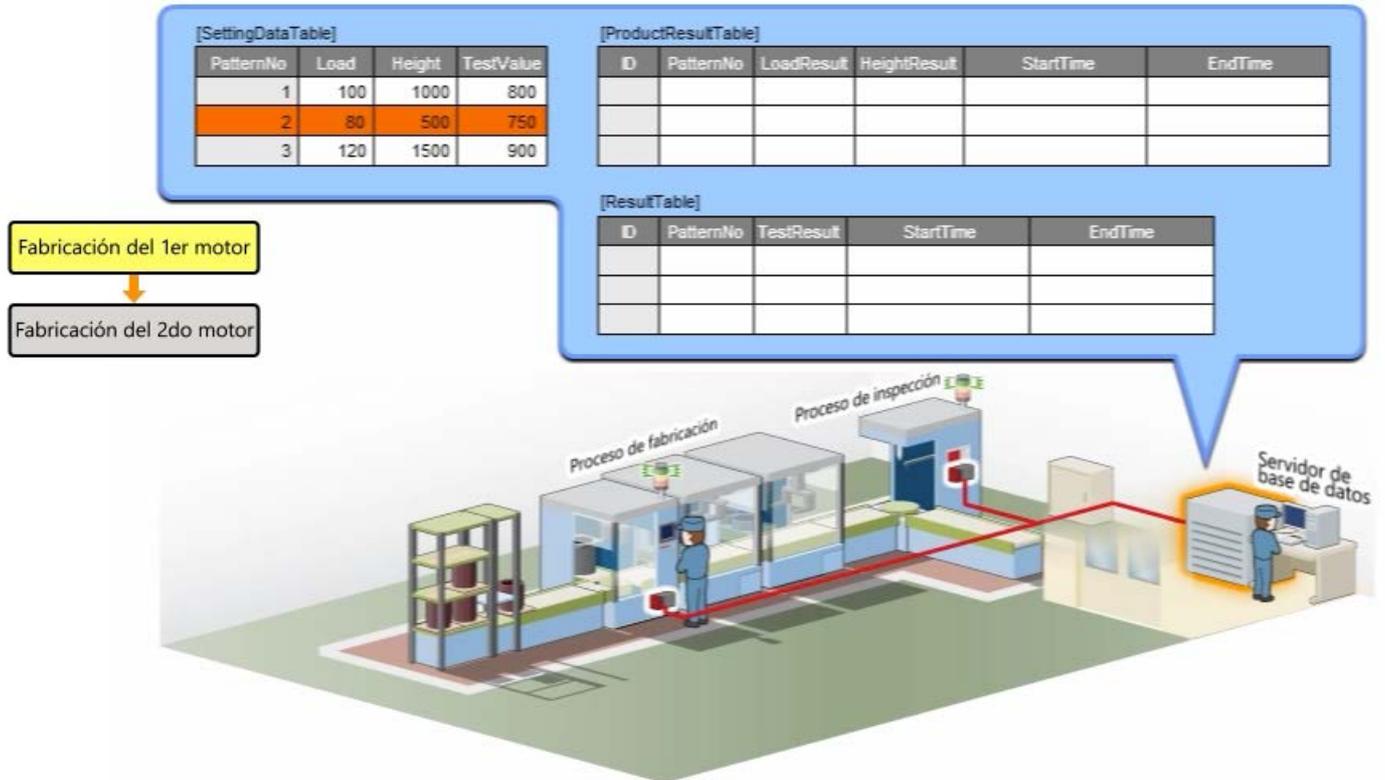
3.5

Ejemplo de sistema del módulo de interfaz MES

Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

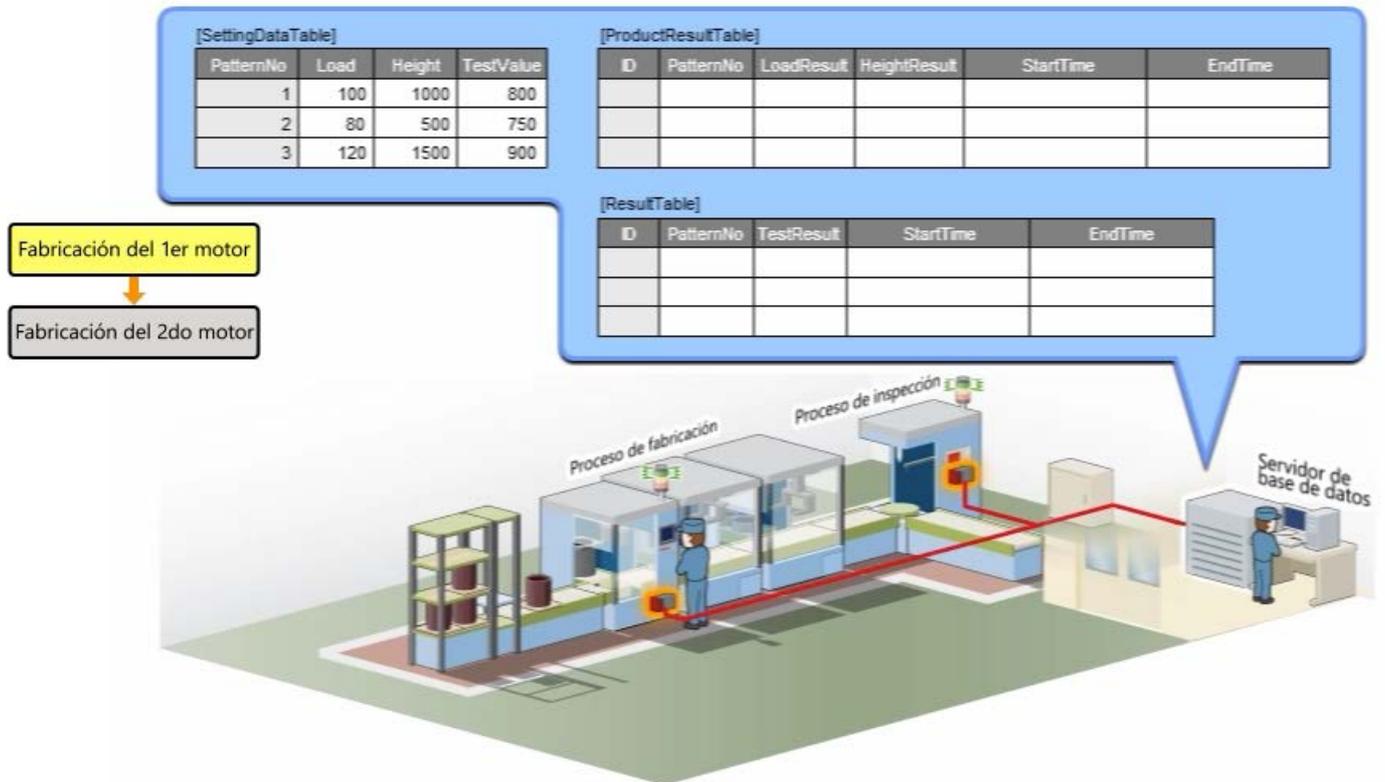
A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**



Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

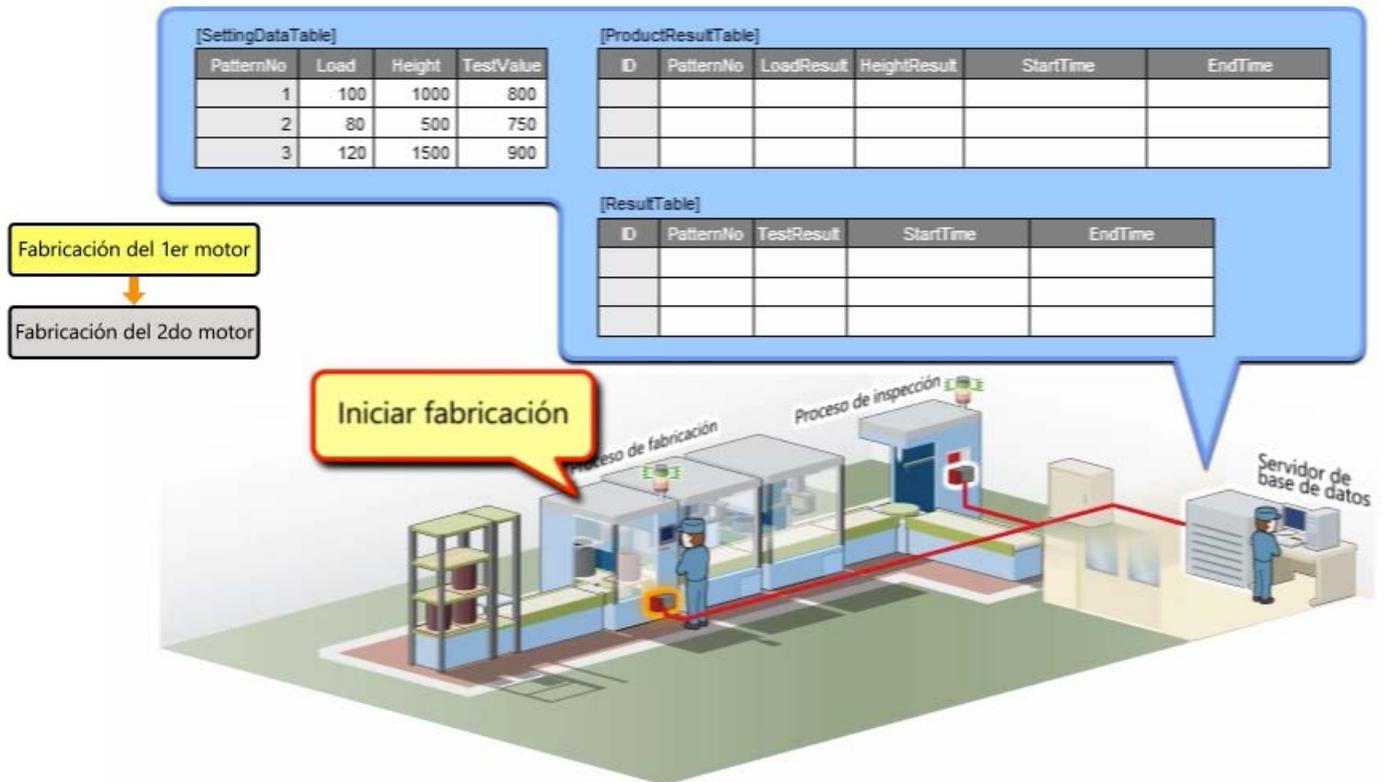
A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**



Ha completado el ajuste del sistema del módulo de interfaz MES de este curso.

En realidad, se requiere que el ajuste se escriba en el módulo de interfaz MES después de que se complete, aunque ese procedimiento se omite en este curso.

A continuación se muestran las operaciones y el flujo de datos del sistema configurado. **(Observe el siguiente video).**



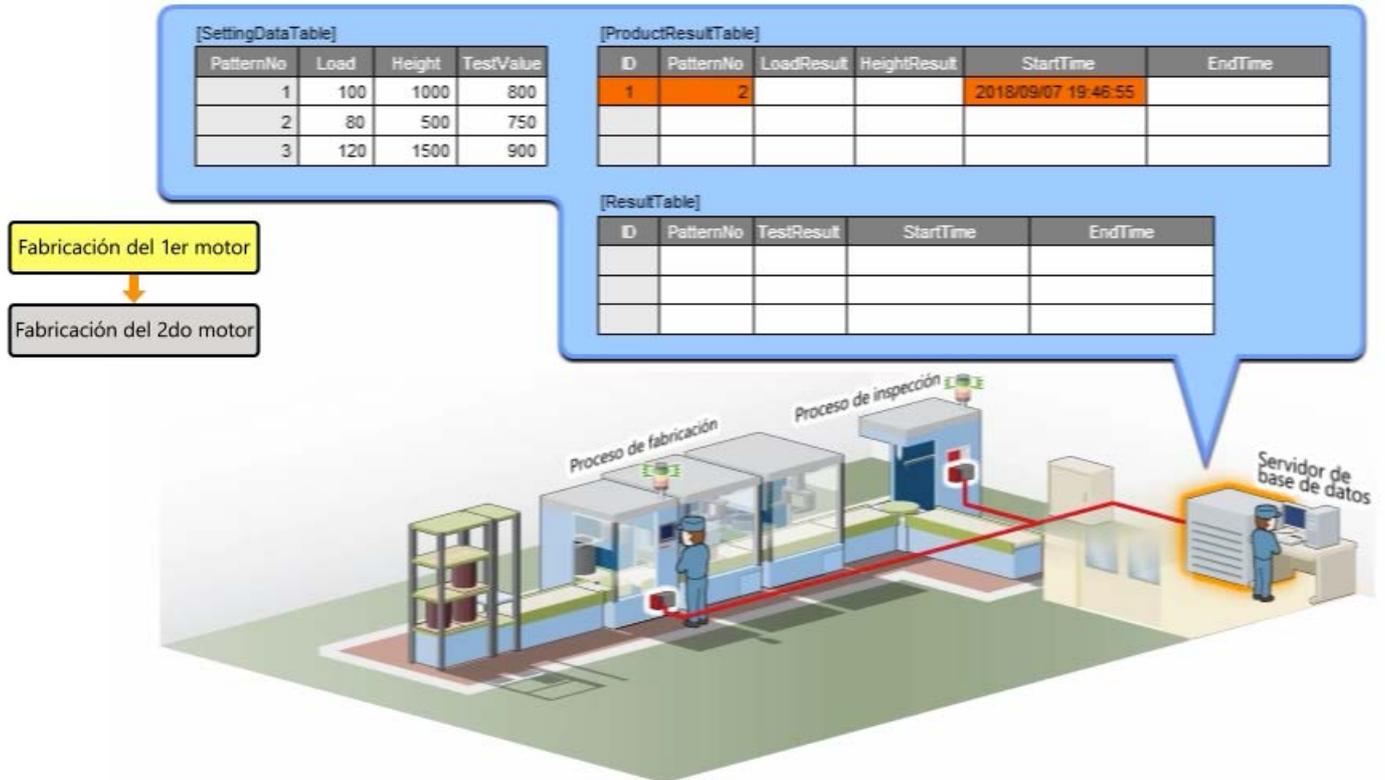
3.5

Ejemplo de sistema del módulo de interfaz MES

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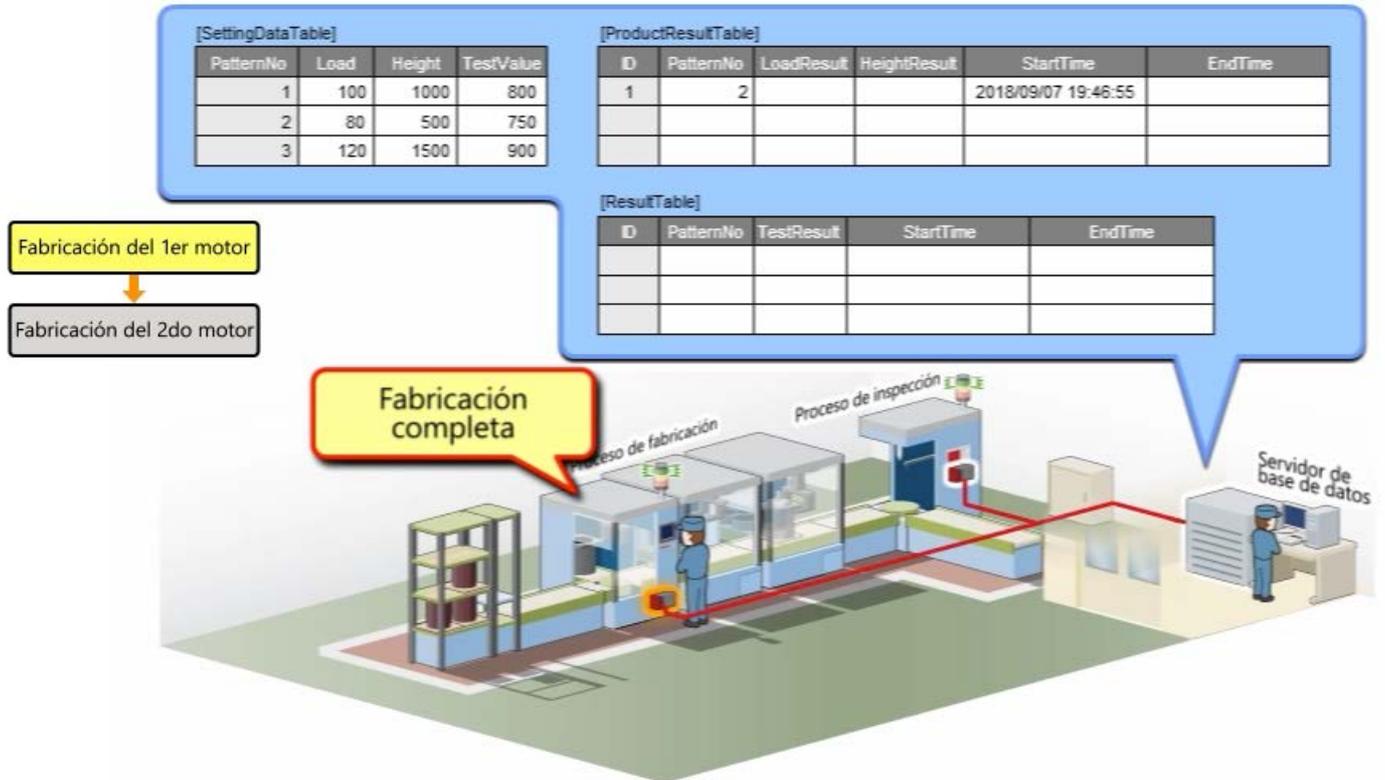
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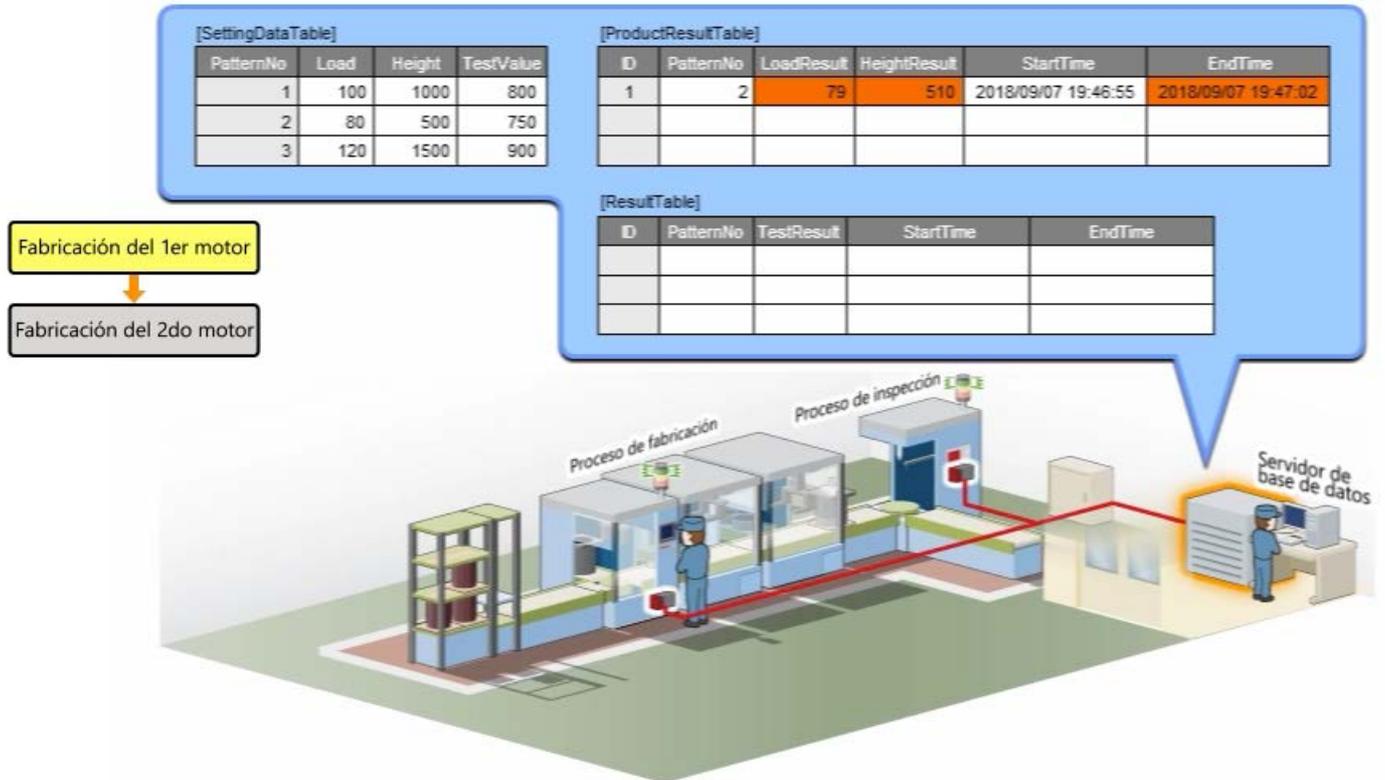
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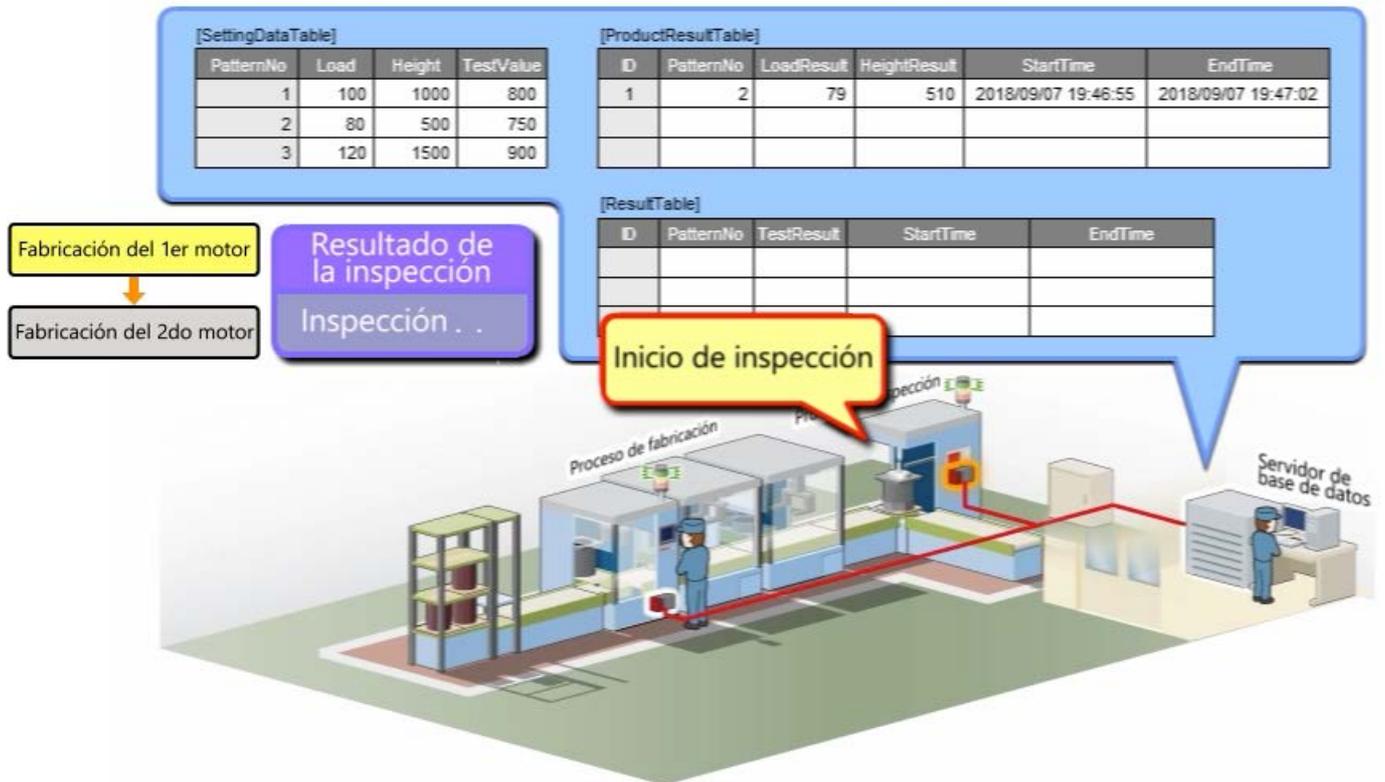
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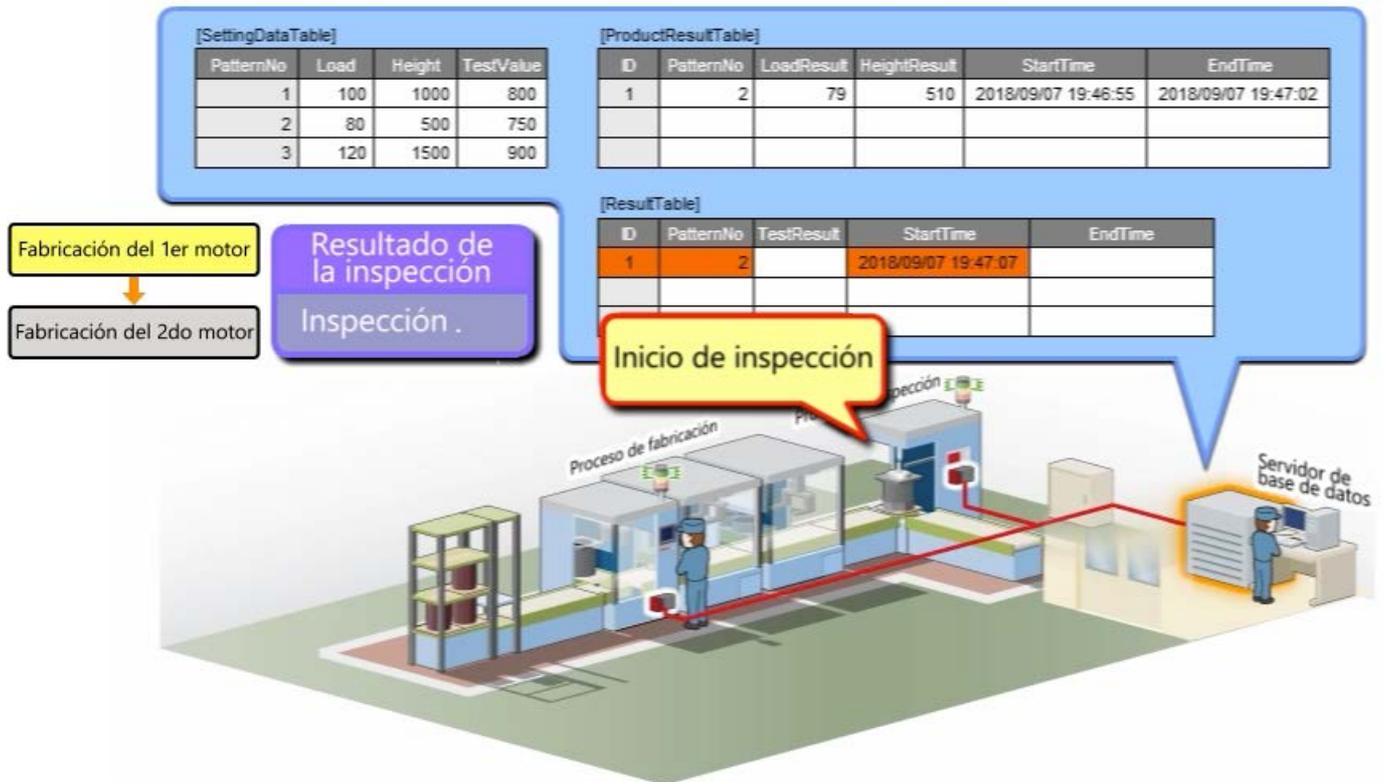
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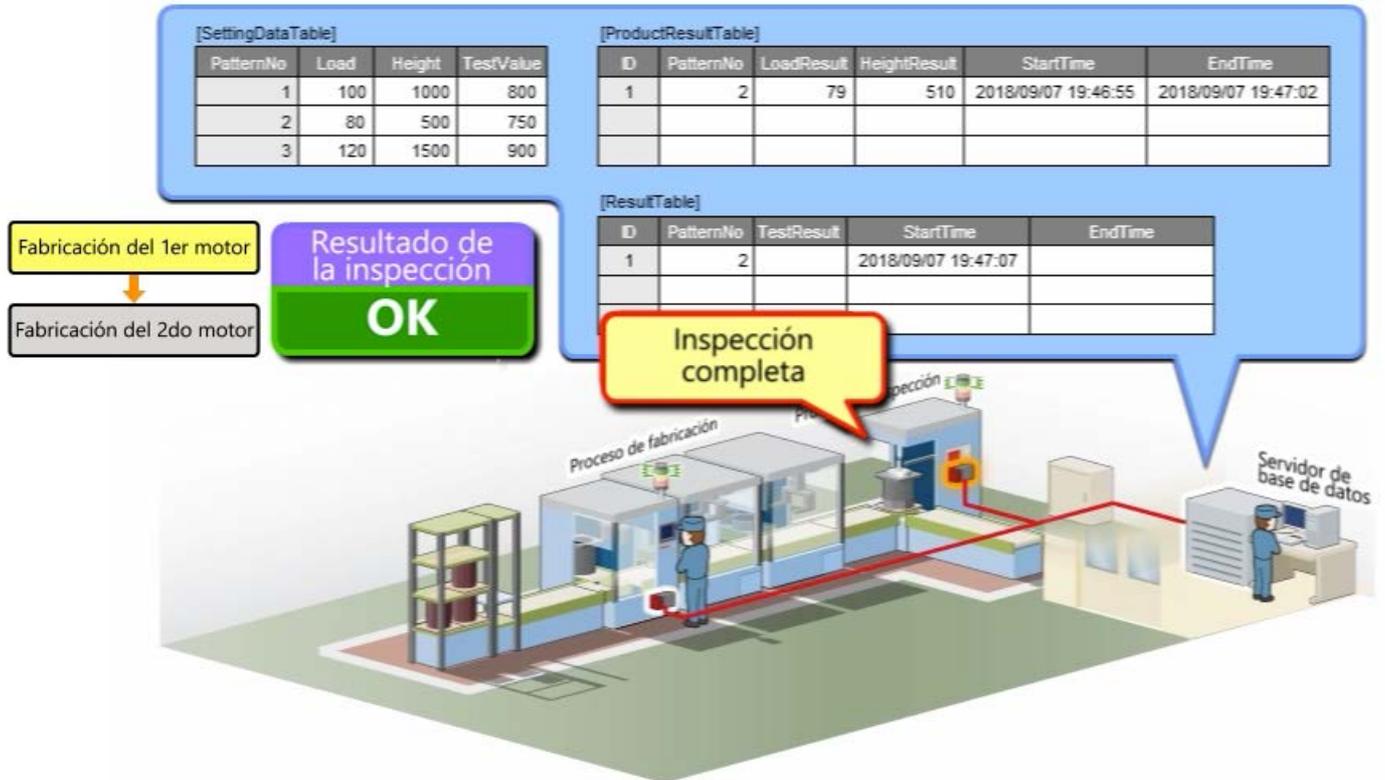
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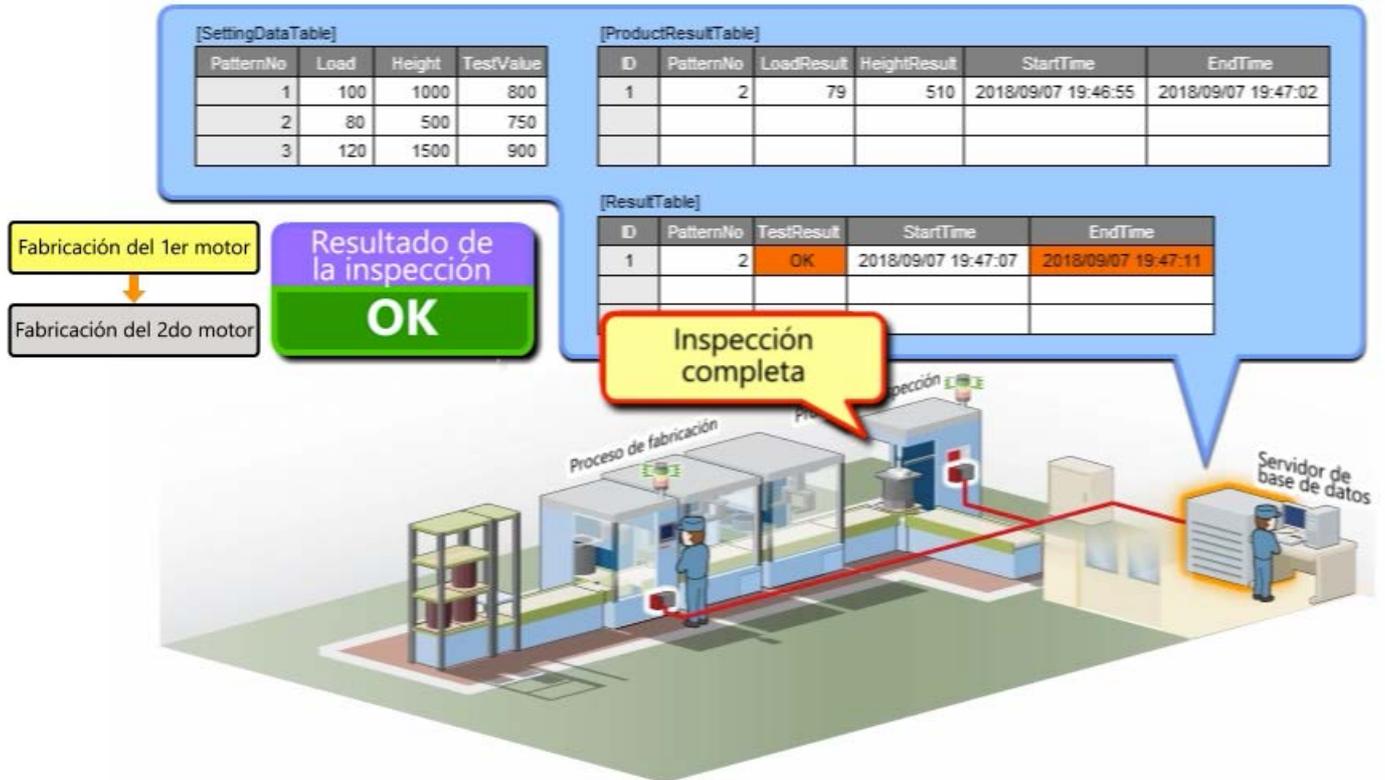
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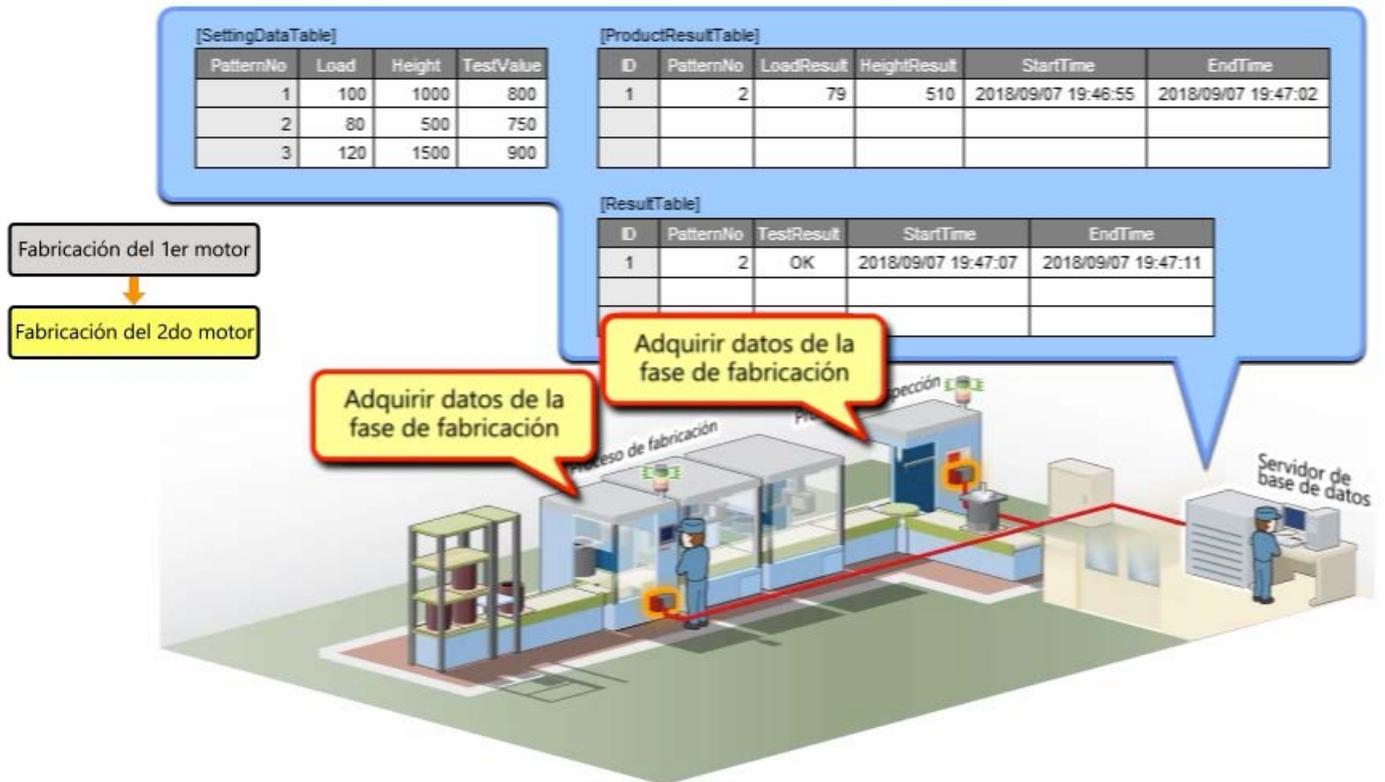
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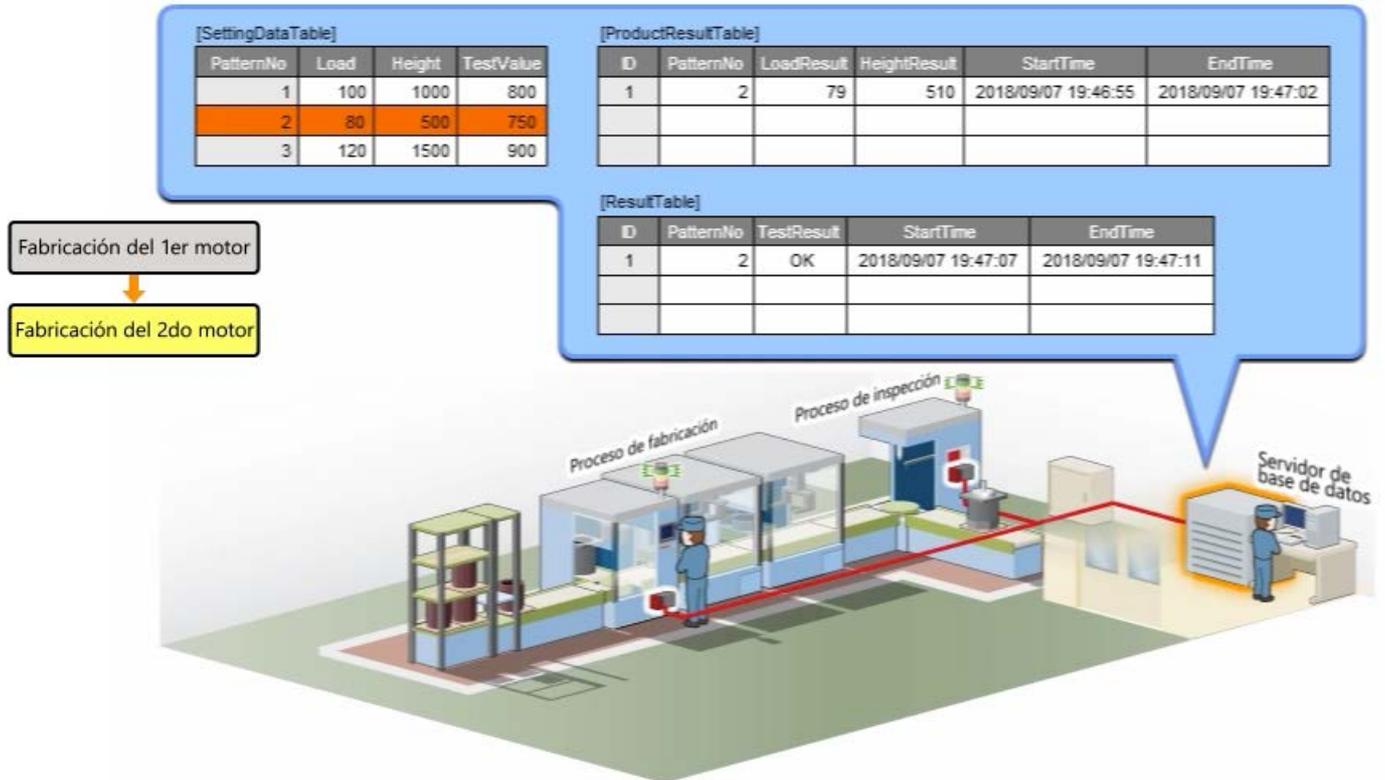
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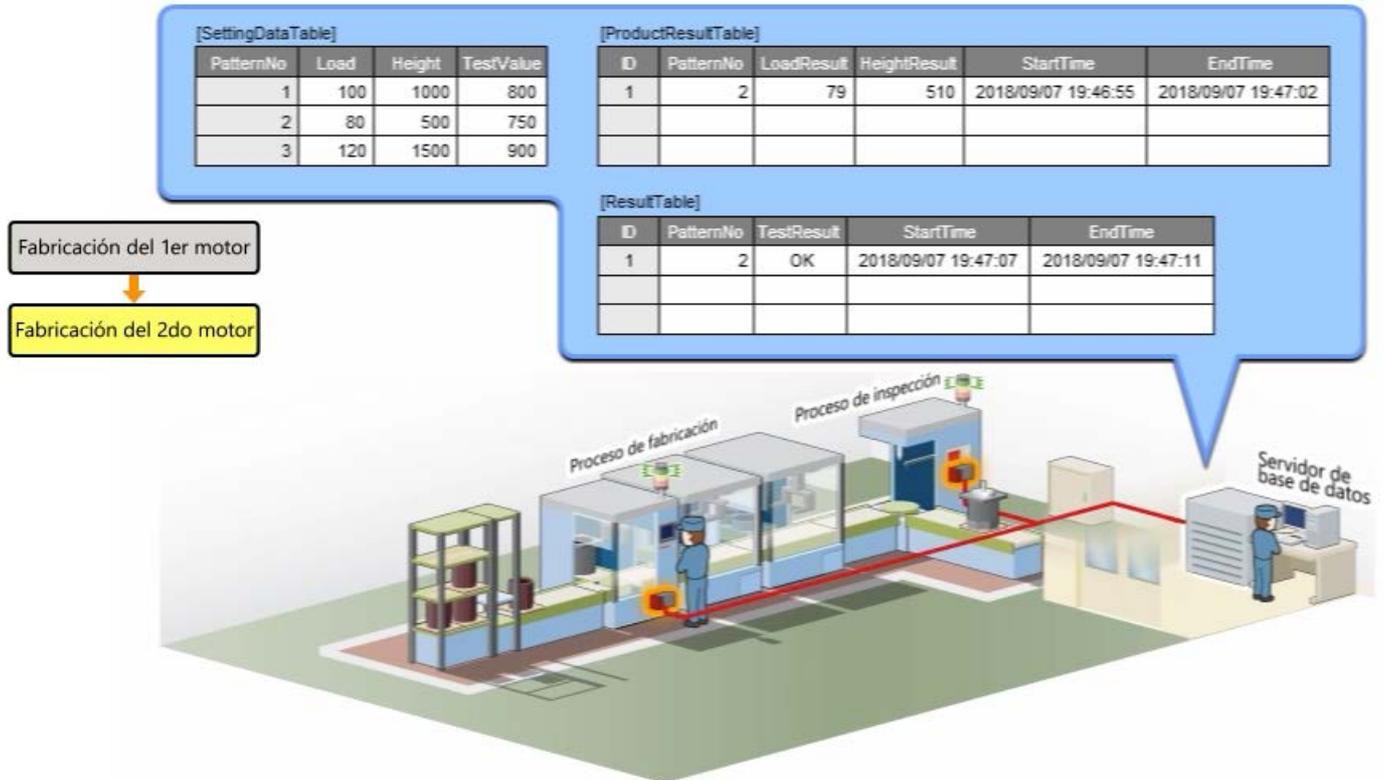
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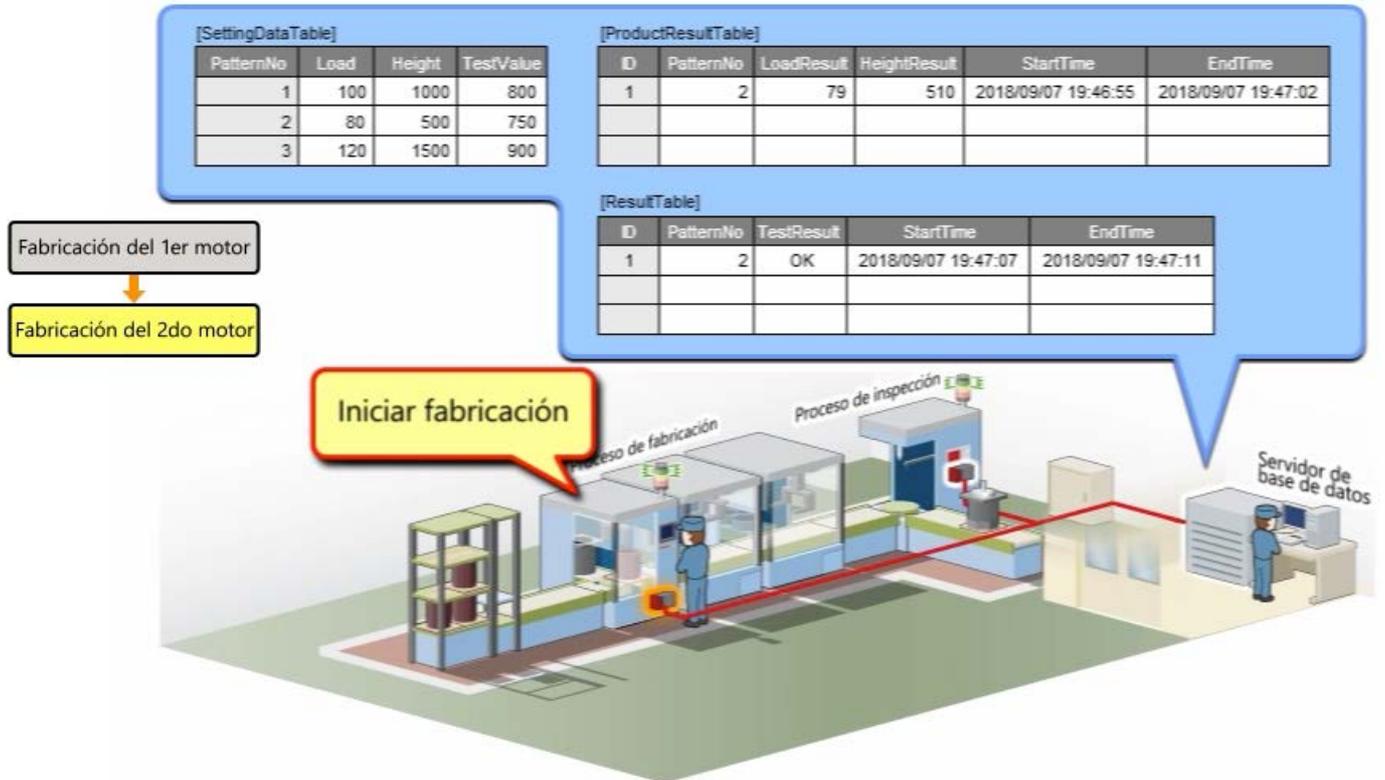
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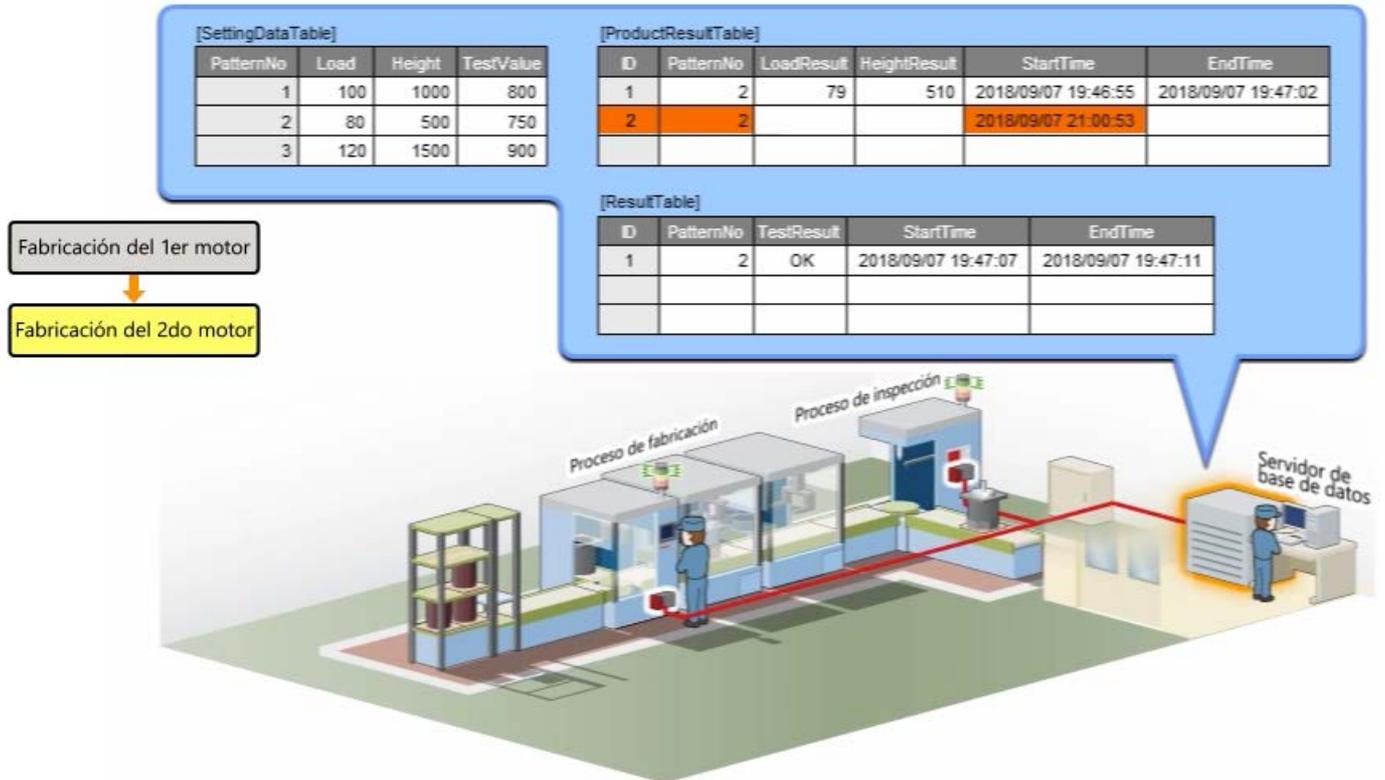
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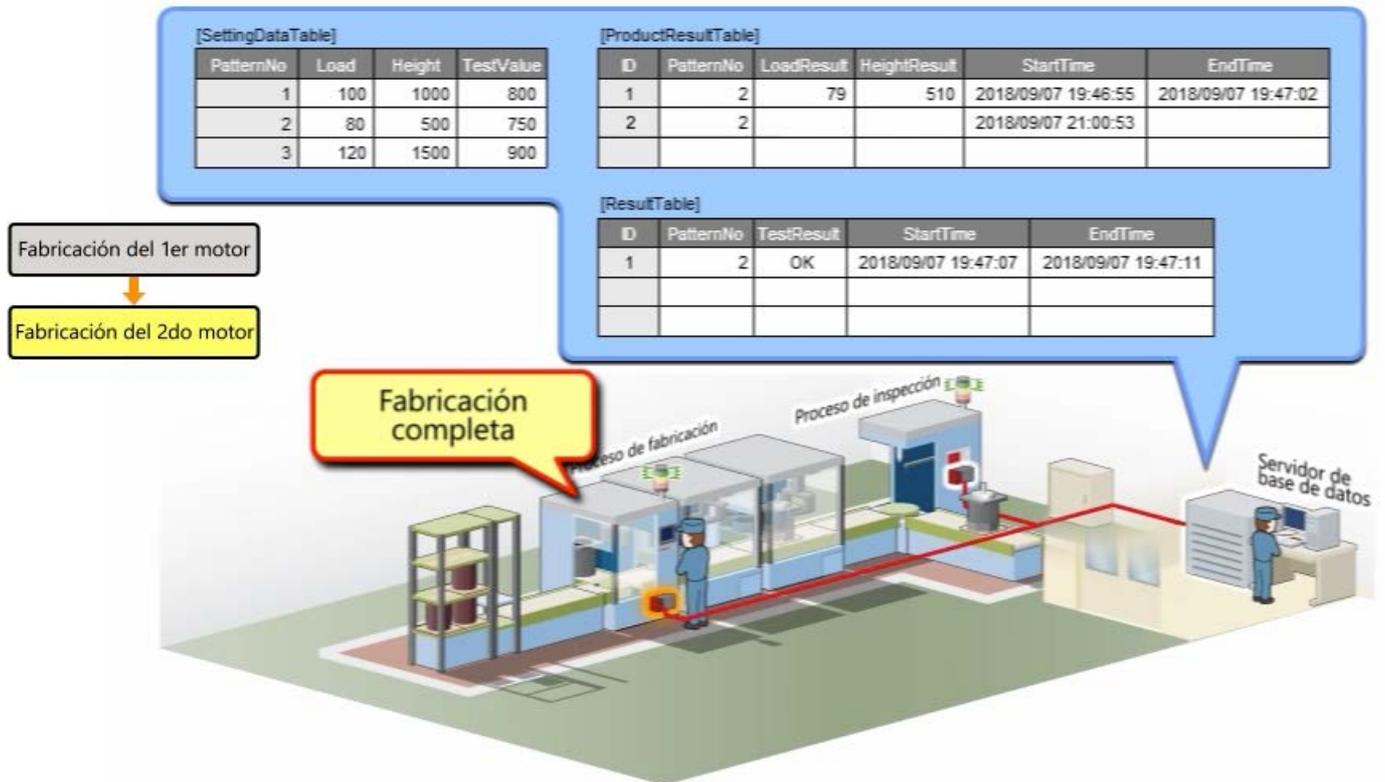
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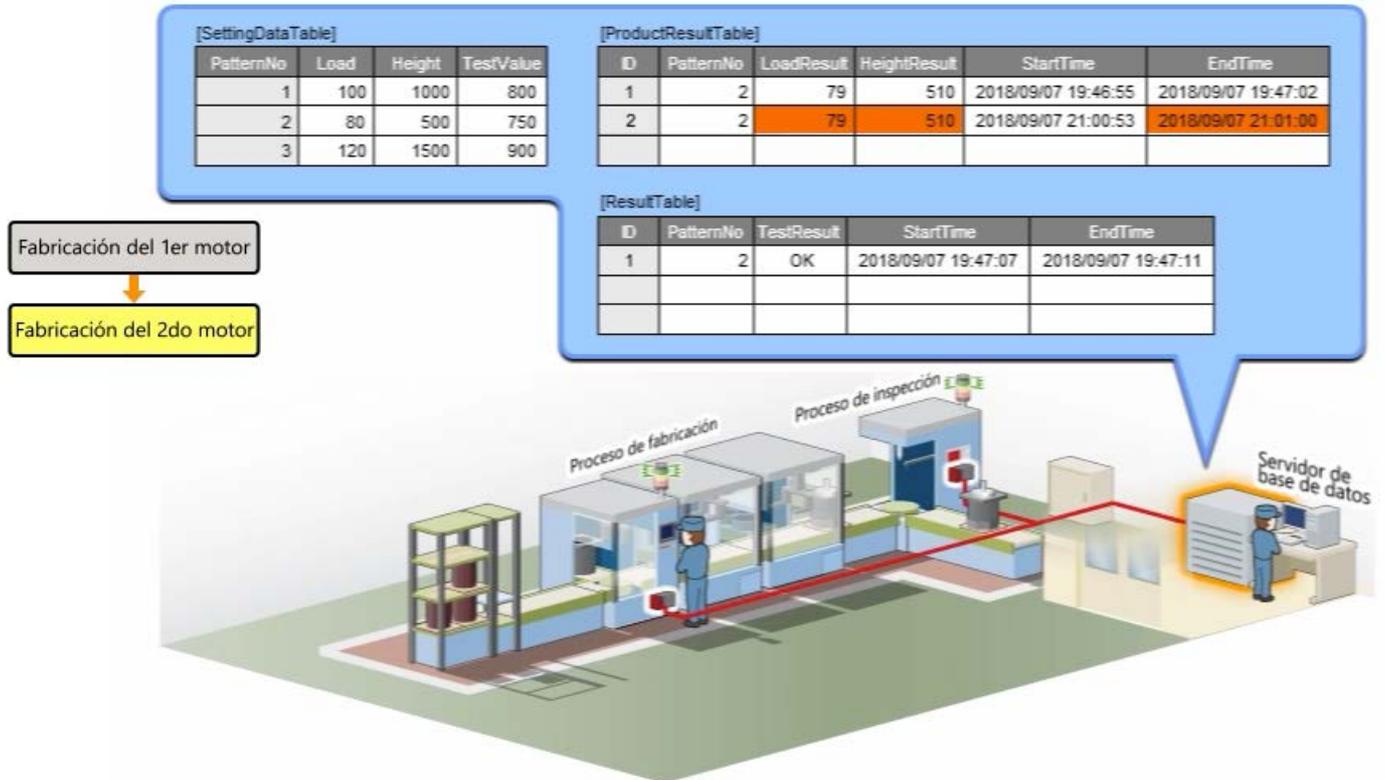
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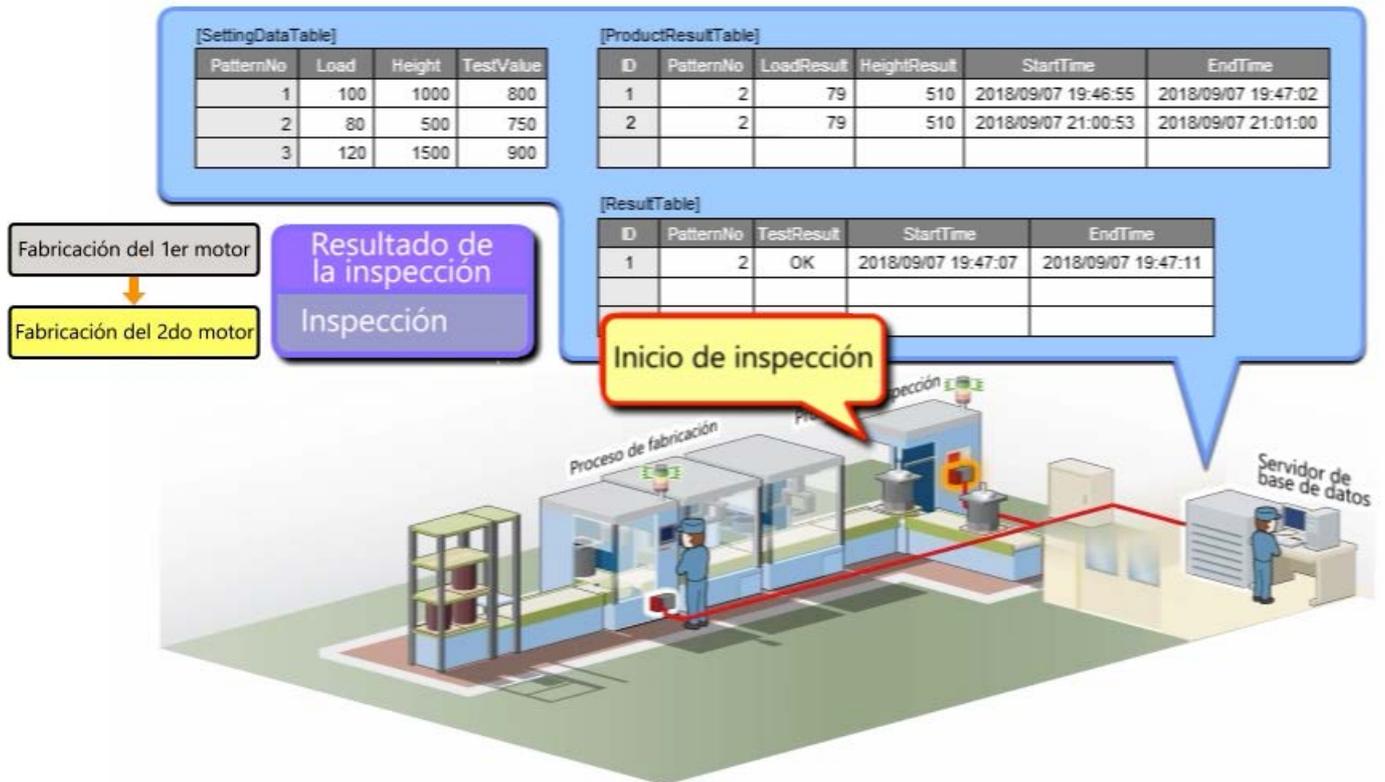
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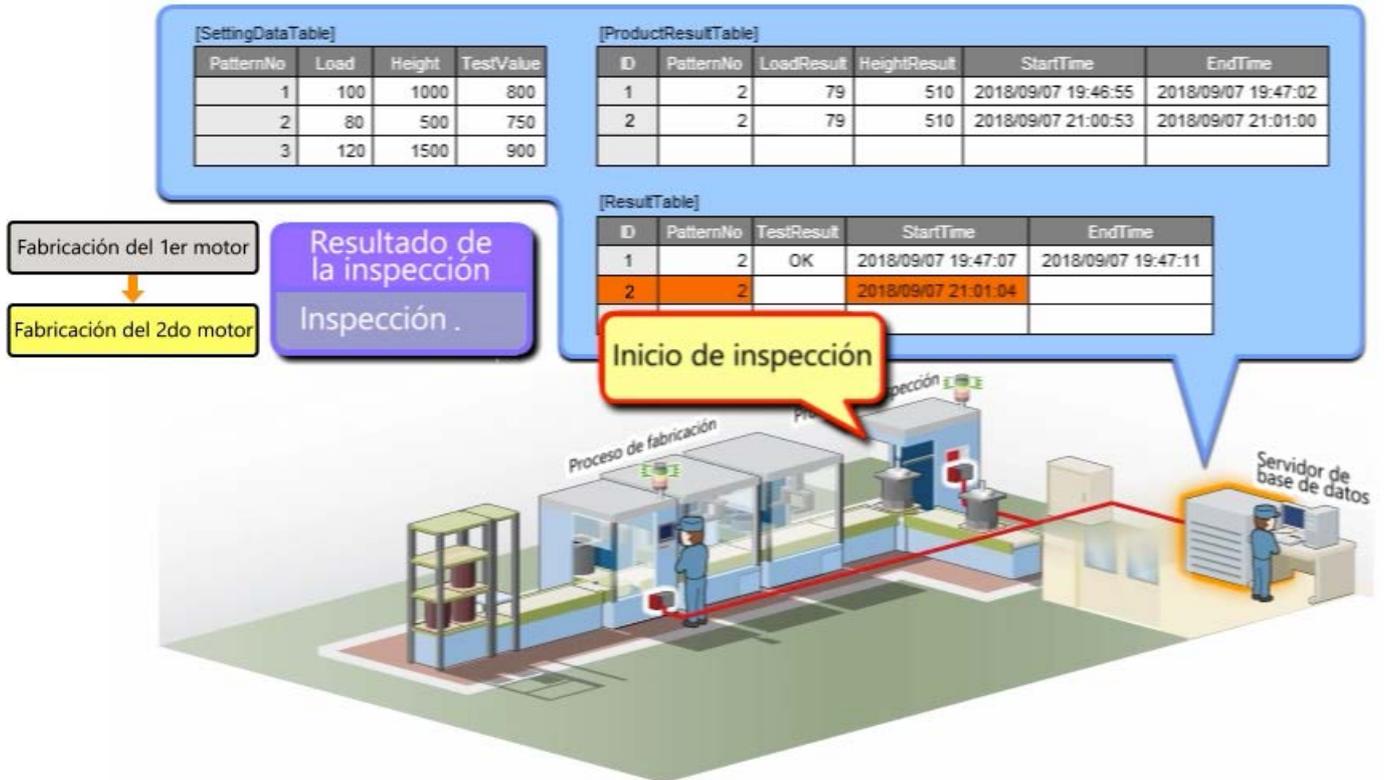
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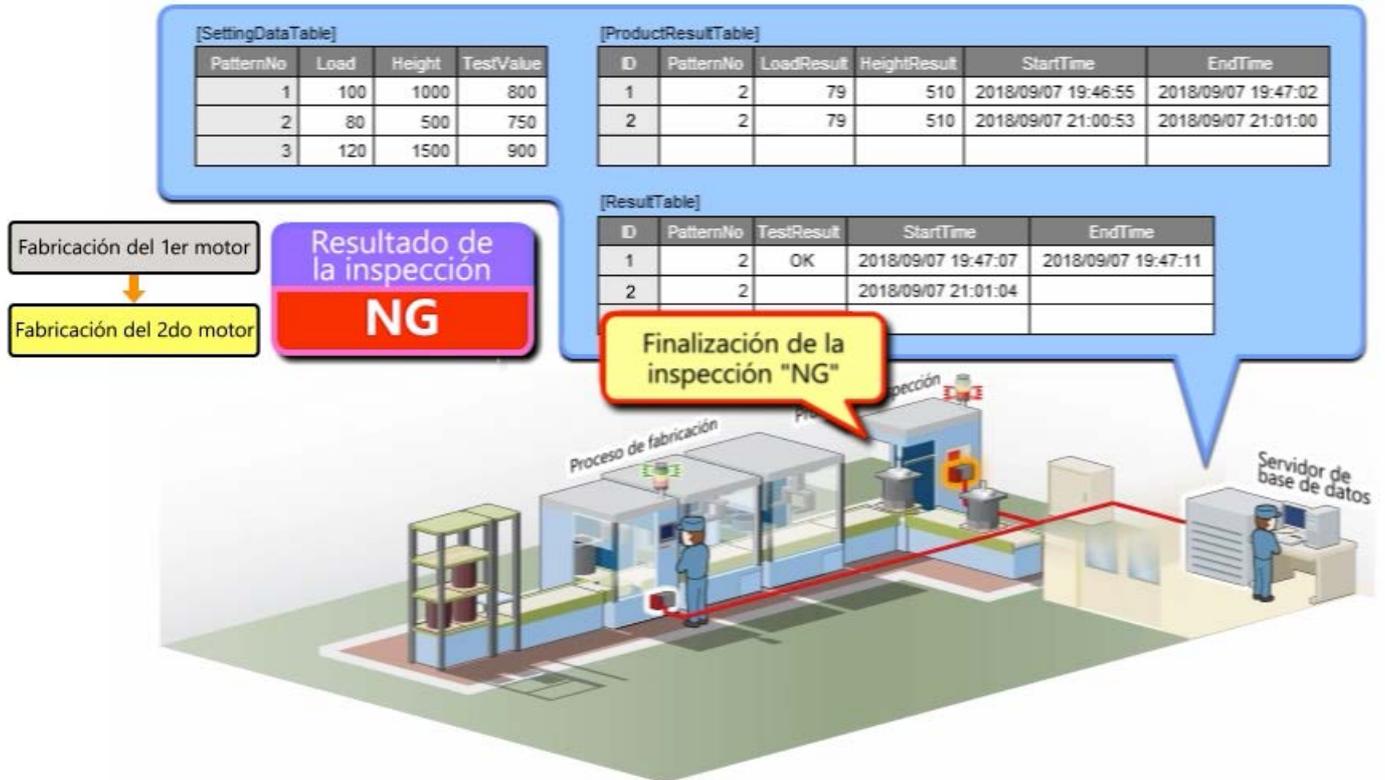
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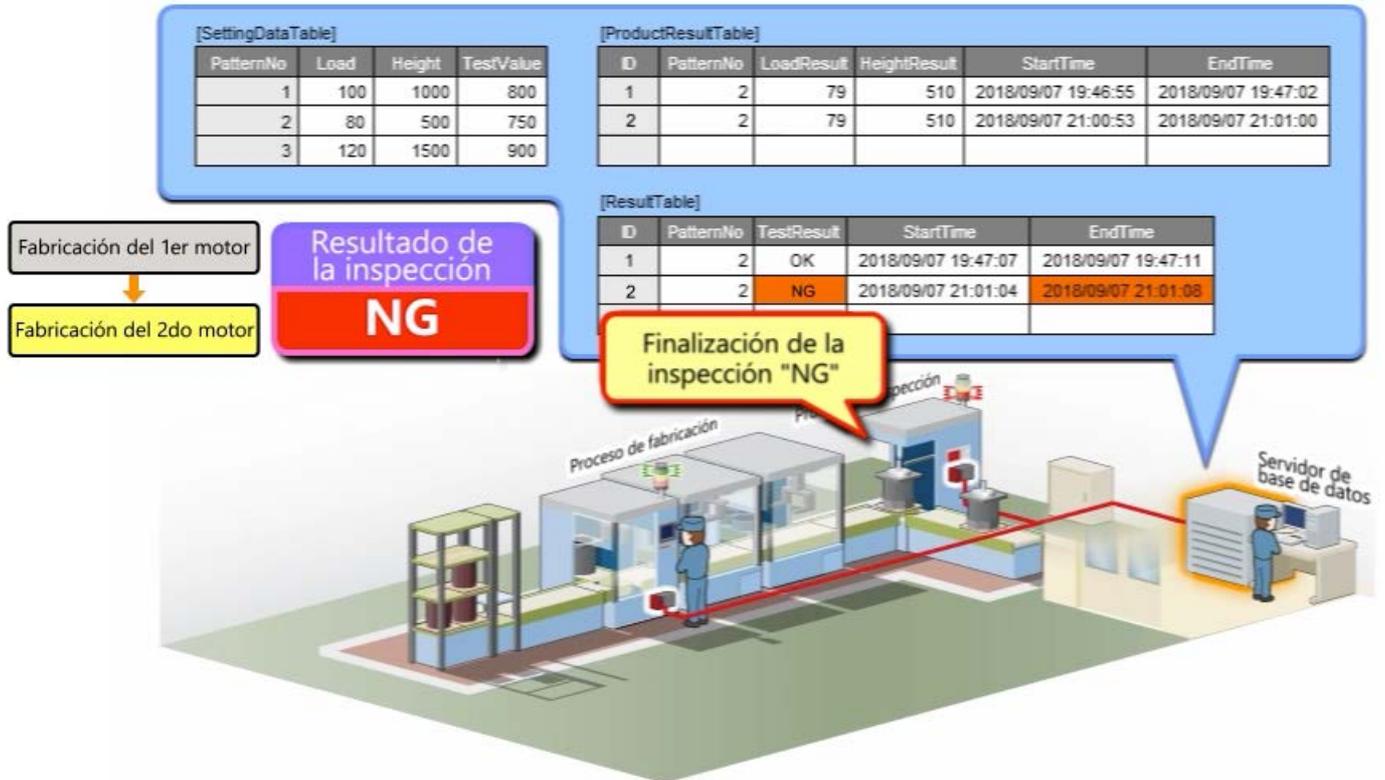
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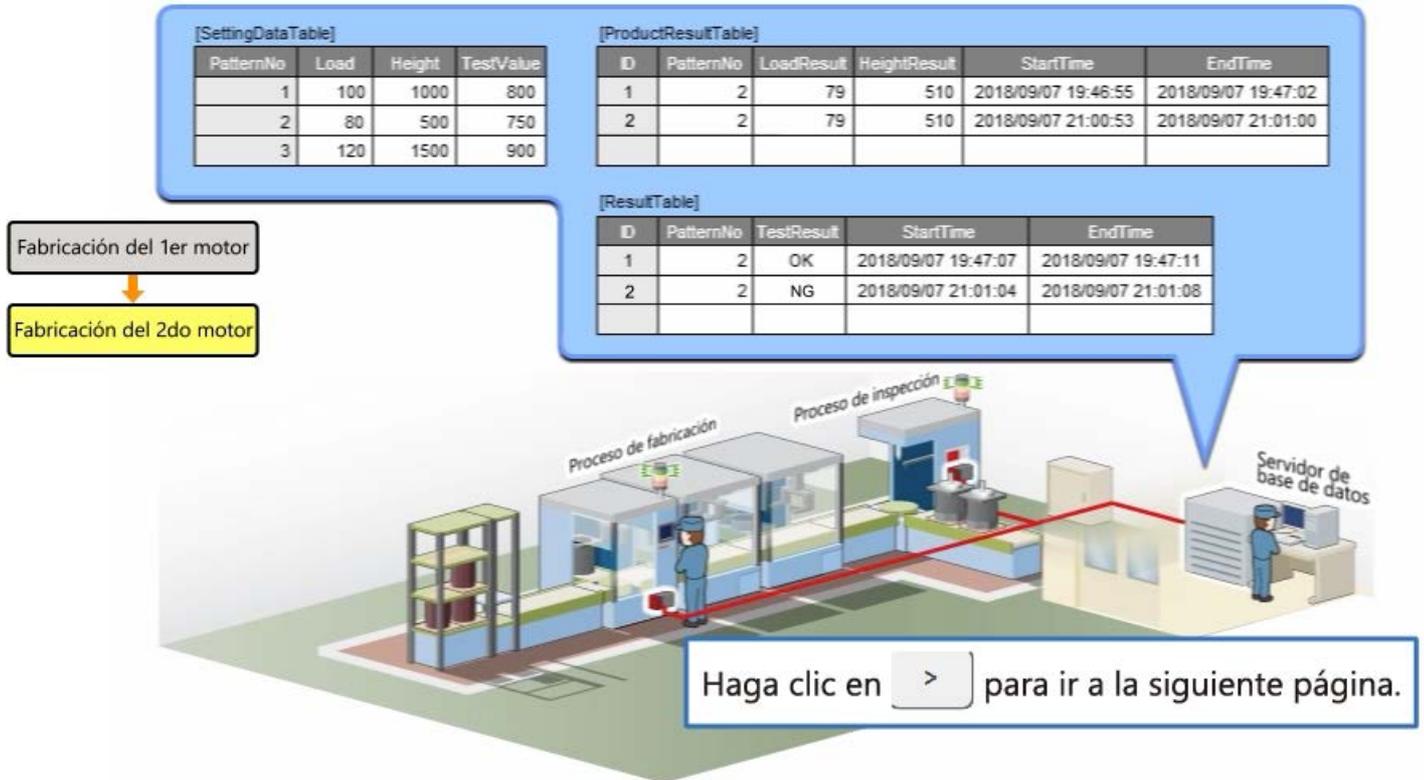
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En este capítulo, usted ha aprendido lo siguiente:

- Estructura de la base de datos
- Función de la MES interface function configuration tool
- Tipos de activador
- Tipos de acción

Puntos

Estructura de la base de datos	La base de datos es un conjunto de datos compartidos por varias aplicaciones o usuarios. El conjunto de datos está representado por una tabla, y su columna se llama campo, y la fila se llama registro.
Función de la MES interface function configuration tool	Con el módulo de interfaz MES, establezca qué valor del controlador programable está conectado a qué datos de la base de datos y a qué hora. Cuando el ajuste completo se escribe en el módulo de interfaz MES, este opera con el ajuste configurado.
Tipos de activador	<p>El tiempo de operación (condición de activación) difiere según la combinación de seis tipos de eventos y condiciones, y se pueden seleccionar varios patrones.</p> <p><Común en eventos/condiciones></p> <ul style="list-style-type: none"> • Condition (Value Monitoring): Esto se utiliza para operar cuando los valores del componente y la variable de la etiqueta del dispositivo cumplen con la condición específica. <p><Condición></p> <ul style="list-style-type: none"> • Condition (Period of Time): Esto se utiliza para operar dentro de la hora de inicio hasta la hora de finalización especificadas. <p><Evento></p> <ul style="list-style-type: none"> • Event (Value Changed): Esto se utiliza para operar cuando los valores del componente y la variable de la etiqueta del dispositivo cambian del valor anterior. • Event (Fixed Time): Esto se utiliza para operar a la hora específica. • Event (Fixed Cycle): Esto se utiliza para operar en el intervalo de tiempo especificado, o en intervalos especificados basados en la hora especificada. • Event (Module Monitoring): Esto se utiliza para operar cuando se inicia el módulo de interfaz MES, se reinicia la función de interfaz o se actualiza su ajuste, o se cambia el estado de la CPU de gestión. • Handshake: Esto se utiliza al iniciar o completar trabajos en sincronización con el controlador programable del equipo.
Tipos de acción	<p>Los siguientes seis tipos de acciones son las funciones para comunicarse con la base de datos.</p> <ul style="list-style-type: none"> • Select: Extrae datos de la base de datos. • Insert: Agrega datos a la base de datos. • Update: Actualiza los datos en la base de datos. • Delete: Elimina los datos de la base de datos. • Multiple Select: Extrae varios datos de la base de datos. • Stored Procedure: Ejecuta el procesamiento registrado en la base de datos.

[Prueba de comprensión]

¿Ha comprendido todo el contenido del Capítulo 3?

Tome la prueba de comprensión para verificar y revisar el contenido.

(3 secciones, 3 preguntas)

Seleccione correcto o incorrecto para la siguiente descripción de la base de datos.

La base de datos está estructurada por una lista llamada tabla, y su fila se llama "campo", y su columna se llama "registro".

Correcto

Incorrecto

Seleccione correcto o incorrecto para la siguiente descripción de los ajustes de la etiqueta del dispositivo. En "Ajustes de etiqueta de dispositivo", configure los ajustes para que el nombre del dispositivo del módulo de CPU (como D100) y el nombre del campo de la base de datos estén directamente vinculados.

Correcto

Incorrecto

Seleccione correcto o incorrecto para la siguiente descripción del módulo de interfaz MES.
El módulo de interfaz MES se puede utilizar sin una tarjeta de memoria SD.

Correcto

Incorrecto

Seleccione correcto o incorrecto para la siguiente descripción de la base de datos.

La base de datos está estructurada por una lista llamada tabla, y su fila se llama "campo", y su columna se llama "registro".

Correcto

Incorrecto

Seleccione correcto o incorrecto para la siguiente descripción de los ajustes de la etiqueta del dispositivo. En "Ajustes de etiqueta de dispositivo", configure los ajustes para que el nombre del dispositivo del módulo de CPU (como D100) y el nombre del campo de la base de datos estén directamente vinculados.

Correcto

Incorrecto

Seleccione correcto o incorrecto para la siguiente descripción del módulo de interfaz MES.
El módulo de interfaz MES se puede utilizar sin una tarjeta de memoria SD.

Correcto

Incorrecto

Usted ha completado la prueba de comprensión del Capítulo 3.
El siguiente es el resultado de su prueba.

¿Cuál fue su resultado?

Se recomienda volver a intentar con las preguntas que respondió incorrectamente.

	1	2	3	4	5	6	7	8	9	10
Prueba de comprensión 1	✓									
Prueba de comprensión 2	✓									
Prueba de comprensión 3	✓									

Total de preguntas: **3**

Respuestas correctas: **3**

Porcentaje: **100 %**

Borrar

Ahora que ha completado todas las lecciones sobre **Información básica de visualización de fabricación (módulo de interfaz MES de la serie MELSEC iQ-R)**, está listo para tomar la prueba final. Si no tiene claro alguno de los temas cubiertos, tome esta oportunidad para revisar esos temas.

Hay un total de 5 preguntas (5 áreas) en esta Prueba Final.

Puede tomar la prueba final las veces que desee.

Resultados de la calificación

El número de respuestas correctas, el número de preguntas, el porcentaje de respuestas correctas, y el resultado sobre si aprobó o no aparecerá en la página de calificación.

		1	2	3	4	5	6	7	8	9	10	11	12	
Volver a intentar	Prueba 1	✓	✓	✓	✗									Total de preguntas: 28 Respuestas correctas: 23 Porcentaje: 82 %
	Prueba 2	✓	✓	✓	✓									
	Prueba 3	✓												
	Prueba 4	✓	✓											
	Prueba 5	✓	✓											
Volver a intentar	Prueba 6	✓	✗	✗	✗									
	Prueba 7	✓	✓	✓	✓									
	Prueba 8	✓	✓	✓	✓	✓								
	Prueba 9	✓												
Volver a intentar	Prueba 10	✗												

Para pasar la prueba, se requiere el **60%** de respuestas correctas.

Seleccione la aplicación correcta para administrar la planta de fabricación y realizar la fabricación de manera eficiente. (Seleccione una opción)

ERP

PDM

MES

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar la base de datos en comparación con la gestión de datos utilizando archivos. (Seleccione una opción)

- Se pueden gestionar muchos datos y la capacidad de búsqueda de datos es alta.
- Se pueden gestionar menos datos, pero la capacidad de búsqueda de datos es alta.
- Se admite el acceso simultáneo múltiple ya que tiene un alto rendimiento en el procesamiento exclusivo.

Seleccione correcto o incorrecto para la siguiente descripción de la base de datos.
La base de datos está estructurada por una lista llamada tabla, y su fila se llama "campo", y su columna se llama "registro".

Correcto

Incorrecto

Seleccione la descripción correcta para el ciclo PDCA que se implementa para mejorar la fabricación en la planta. (Seleccione una opción)

- Una ejecución del ciclo PDCA es suficiente para mejorar la fabricación.
- Ejecutar el ciclo PDCA continuamente es importante para mejorar la fabricación.
- En Planificar, el primer paso del ciclo PDCA, se realiza un plan aproximado en base a la suposición sin utilizar los datos reales.

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar el módulo de interfaz MES para recopilar los datos en la planta de fabricación. (Seleccione una opción)

- Los datos se envían/reciben en/desde la base de datos automáticamente mediante la instalación del módulo de interfaz MES en el controlador programable del equipo.
- La base de datos y el módulo de CPU se pueden conectar creando un programa de comunicación y registrándolo en el módulo de interfaz MES.
- Los datos se pueden recopilar en tiempo real en el sistema que utiliza el módulo de interfaz MES, y la fiabilidad de ese sistema es alta.

Seleccione la aplicación correcta para administrar la planta de fabricación y realizar la fabricación de manera eficiente. (Seleccione una opción)

ERP

PDM

MES

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar la base de datos en comparación con la gestión de datos utilizando archivos. (Seleccione una opción)

- Se pueden gestionar muchos datos y la capacidad de búsqueda de datos es alta.
- Se pueden gestionar menos datos, pero la capacidad de búsqueda de datos es alta.
- Se admite el acceso simultáneo múltiple ya que tiene un alto rendimiento en el procesamiento exclusivo.

Seleccione correcto o incorrecto para la siguiente descripción de la base de datos.
La base de datos está estructurada por una lista llamada tabla, y su fila se llama "campo", y su columna se llama "registro".

Correcto

Incorrecto

Seleccione la descripción correcta para el ciclo PDCA que se implementa para mejorar la fabricación en la planta. (Seleccione una opción)

- Una ejecución del ciclo PDCA es suficiente para mejorar la fabricación.
- Ejecutar el ciclo PDCA continuamente es importante para mejorar la fabricación.
- En Planificar, el primer paso del ciclo PDCA, se realiza un plan aproximado en base a la suposición sin utilizar los datos reales.

Seleccione la respuesta incorrecta en cuanto a la ventaja de utilizar el módulo de interfaz MES para recopilar los datos en la planta de fabricación. (Seleccione una opción)

- Los datos se envían/reciben en/desde la base de datos automáticamente mediante la instalación del módulo de interfaz MES en el controlador programable del equipo.
- La base de datos y el módulo de CPU se pueden conectar creando un programa de comunicación y registrándolo en el módulo de interfaz MES.
- Los datos se pueden recopilar en tiempo real en el sistema que utiliza el módulo de interfaz MES, y la fiabilidad de ese sistema es alta.

Ha completado la prueba final. Sus resultados del área son los siguientes.
Para finalizar la prueba final, continúe con la próxima página.

	1	2	3	4	5	6	7	8	9	10
Prueba final 1	✓									
Prueba final 2	✓									
Prueba final 3	✓									
Prueba final 4	✓									
Prueba final 5	✓									

Total de preguntas: **5**

Respuestas correctas: **5**

Porcentaje: **100 %**

Borrar

Ha completado el curso **Información básica de visualización de fabricación (módulo de interfaz MES de la serie MELSEC iQ-R).**

Gracias por tomar este curso.

Esperamos que haya disfrutado las lecciones y que la información recibida en este curso le sea útil en el futuro.

Puede revisar el curso las veces que desee.

Revisar

Cerrar