EUROMAP 26 Annex	PROTOCOL FOR COMMUNICATION BETWEEN EXTRUSION LINES AND A CENTRAL COMPUTER APPLICATION VARIABLE LIST FOR EXTRUSION LINES

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(24 pages)

This recommendation has been prepared by the Technical Commission of EUROMAP.

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
General Parameters	Data Set			Data Set Filename for Up- and Download	SP				RWE		E_DATASETFILENAME	V
				Confirming Variable for Data Set Up- and Download					RW		E_OKVARIABLE	S
				Control Variable for searching new filenames							E_NEWFILENAME	
	General Parameters for Line			energy consumption of line	AC	1	4	kWh	RET		E_ENCONLINE	R
		alarms		alarm 1 corresponding to text file of manufacturer					ET		E_MAL_1	I
				alarm 2 corresponding to text file of manufacturer							E_MAL_2	
				alarm 3 corresponding to text file of manufacturer							E_MAL_3	
				alarm 4 corresponding to text file of manufacturer							E_MAL_4	
				alarm 5 corresponding to text file of manufacturer							E_MAL_5	
				alarm 6 corresponding to text file of manufacturer							E_MAL_6	
				alarm 7 corresponding to text file of manufacturer							E_MAL_7	
				alarm 8 corresponding to text file of manufacturer							E_MAL_8	
				alarm 9 corresponding to text file of manufacturer							E_MAL_9	
				alarm 10 corresponding to text file of manufacturer							E_MAL_10	
		production status		*B0: production*					RET		E_PRODSTAT	
				B1: preparation for production								
				B2: production target reached								
				B3: prod. interrupted, no reason specified								
				B4: prod. interrupted, stopped by operator								
				B5: prod. interrupted, safety conditions								
				B6: prod. interrupted, maintenance								
		production target		number of parts					RW		E_PRODTARNUM	
				length to be produced				m			E_PRODTARLEN	
		extrusion line status		*B0: threading*					RET		E_LINESTAT	
				B1: preheating								
				B2: heating up								
				B3: stopped								
				B4: manual								
		auto status	automatic 1								E_LINEAUTO1	S
			automatic 2								E_LINEAUTO2	
			automatic 3								E_LINEAUTO3	
			automatic 4								E_LINEAUTO4	
			automatic 5								E_LINEAUTO5	
			automatic 6								E_LINEAUTO6	
			automatic 7								E_LINEAUTO7	
			automatic 8								E_LINEAUTO8	
			automatic 9								E_LINEAUTO9	
			automatic 10								E_LINEAUTO10	
		operator ID					20				E_OPIDENT	V
		job status	job code								E_JOBCODE	

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			code of next job								E_NXTJOBCODE	
			part code								E_PARTCODE	V
			amount	amount of parts							E_PARTAMOUNT	I
			length	length of one part		1	6	mm			E_LNGTHONEPRT	R
			job target	time and date of end of job		0	14	ymdhmin			E_DATENDJOB	V
Feeding System	Feeding 1	gravimetric		total material consumption				kg			E_F1GRTOTMATCON	I
				partial material consumption							E_F1GRPRTMATCON	
				total throughput	SP	1	5	kg/h	RW		E_F1GRTOTTHRSP	R
					AC				RET		E_F1GRTOTTHRAC	
			material 1	throughput	SP			kg/h%	RW		E_F1GRMAT1THRS	
					AC				RET		E_F1GRMAT1THRA	
				density	SP	2	3	g/cm3	RW		E_F1GRMAT1DENS	
			alarms	*B0: refill time expired*	AC				ET		E_F1GRALMAT1	I
				B1: weight less than 2%								
				B2: weight process failure								
				B3: refill failure								
				B4: speed error +								
				B5: speed error -								
				B6: dosing factor error								
		volumetric		not implemented yet								
		conveyor for rubber plants		current	AC			A	RET		E_F1VOCURR	S
				speed				m/min			E_F1VOSPD	
				width of skid				mm			E_F1VOSKIDWDTH	
				thickness of skid							E_F1VOSKIDTHCK	
				material code			6				E_F1VOMATCODE	V
			alarms	*B0: no material*	AC				ET		E_F1VOALARM	I
				B1: metal in material								
				B2: screw blocked								
		status		*B0: ready*							E_F1VOSTAT	S
		stuffer		current				A	RET		E_F1STUFCUR	
				screw speed		2	5	min -1			E_F1STUFSPD	R
				torque of stuffer motor	SP			Nm	RW		E_F1STUFTQNM	I
								%			E_F1STUFTQPC	S
		twin screw feeder		current	AC			A	RET		E_F1TWINCUR	
				screw speed		2	5	min -1			E_F1TWINSPD	R
Extruder	Extruder 1	temperature zone 1		temperature		1	4	°C,°F			E_EX1T1AC	
					SP				RW		E_EX1T1SP	
				plus/minus-tolerance of temp.							E_EX1T1TOL	S
				energy consumption	AC	1	4	kWh	RET		E_EX1T1ENCON	R
				controller output of energy consumption				%			E_EX1T1ENCRTL	

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VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			alarms	*B0: high temperature*					ET		E_EX1T1ALARM	I
				B1: low temperature								
				B2: optional								
		melt temperature 1				1	4	°C,°F	RET		E_EX1MELT1	R
		melt temperature 2									E_EX1MELT2	
		start up enable temperature			SP				RW		E_EX1ENABT	
		speeds		screw speed	AC		5	min -1	RET		E_EX1SPDAC	
					SP				RW		E_EX1SPDSP	
		pressures		pressure 1	AC			bar	RET		E_EX1PRES1	S
				pressure 2							E_EX1PRES2	
				pressure 3							E_EX1PRES3	
				pressure 4							E_EX1PRES4	
		torques		screw torque				Nm			E_EX1TRQNM	I
								%			E_EX1TRQPC	S
		current		current				A			E_EX1CUR	
		voltage		armature voltage				V			E_EX1ARMV	
		vacuum 1						mbar			E_EX1VAC1	
		vacuum 2									E_EX1VAC2	
		vacuum 3									E_EX1VAC3	
		vacuum 4									E_EX1VAC4	
		vacuum 5									E_EX1VAC5	
		vacuum 6									E_EX1VAC6	
		vacuum 7									E_EX1VAC7	
		vacuum 8									E_EX1VAC8	
		vacuum 9									E_EX1VAC9	
		vacuum 10									E_EX1VAC10	
		alarms		*B0: emergency stop*					ET		E_EX1ALARM	I
				B1: overload								
				B2: melt temperature too high								
				B3: melt temperature too low								
				B4: pressure too high								
				B5: melt filter clogged								
				B6: carbon brush								
		status		*B0: on/off*					RET		E_EX1STATUS	
				B1: preheating								
Melt Pump and Vacuum System	Melt Pump 1	speeds		pump speed		2	5	min -1			E_MP1SPDAC	R
					SP				RW		E_MP1SPDSP	
		temperature zone 1		temperature	AC	1	4	°C,°F	RET		E_MP1TZ1AC	
					SP				RW		E_MP1TZ1SP	

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				plus/minus-tolerance of temp.							E_MP1TZ1TOL	S
			alarms	*B0: high temperature*	AC				ET		E_MP1TZ1ALARM	I
				B1: low temperature								
				B2: optional								
		temperature zone 2		temperature		1	4	°C,°F	RET		E_MP1TZ2AC	R
					SP				RW		E_MP1TZ2SP	
				plus/minus-tolerance of temp.							E_MP1TZ2TOL	S
			alarms	*B0: high temperature*	AC				ET		E_MP1TZ2ALARM	I
				B1: low temperature								
				B2: optional								
		temperature zone 3		temperature		1	4	°C,°F	RET		E_MP1TZ3AC	R
					SP				RW		E_MP1TZ3SP	
				plus/minus-tolerance of temp.							E_MP1TZ3TOL	S
			alarms	*B0: high temperature*	AC				ET		E_MP1TZ3ALARM	I
				B1: low temperature								
				B2: optional								
		temperature zone 4		temperature		1	4	°C,°F	RET		E_MP1TZ4AC	R
					SP				RW		E_MP1TZ4SP	
				plus/minus-tolerance of temp.							E_MP1TZ4TOL	S
			alarms	*B0: high temperature*	AC				ET		E_MP1TZ4ALARM	I
				B1: low temperature								
				B2: optional								
		pressures		inlet pressure	SP			bar	RW		E_MP1PRESINSP	S
					AC				RET		E_MP1PRESINAC	
				outlet pressure							E_MP1PRESOUAC	
		current		current of pump motor				A			E_MP1CURR	
		torque		torque of pump motor				Nm			E_MP1TRQ	
		alarms		*B0: motor overload*					ET		E_MP1ALARM	I
				B1: drive fault								
				B2: inletpressure low								
				B3: inlet pressure high								
				B4: outlet pressure low								
				B5: outlet pressure high								
				B6: outlet transducer fault								
	Vacuum System			*B0: general failure*							VACSYSALARM	
				B1: overload								
				B2: overtemperature								
Die-Hed	Head	temperature zone 1		temperature		1	4	°C,°F	RET		E_HDTZ1TAC	R
					SP				RW		E_HDTZ1TSP	
				plus-minus-tolerance of temp.							E_HDTZ1TTOL	S
				energy consumption	AC	1	4	kWh	RET		E_HDTZ1ENCON	R

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VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
				controler output of energy consumption				%			E_HDTZ1CONOU	S
			alarms	*B0: high temperature*					ET		E_HDTZ1ALARM	I
				B1: low temperature								
				B2: optional								
		temperatures		melt temperature 1		1	4	°C,°F	RET		E_HDMELT1	R
				melt temperature 2							E_HDMELT2	
				melt temperature 3							E_HDMELT3	
				melt temperature 4							E_HDMELT4	
				melt temperature 5							E_HDMELT5	
				melt temperature 6							E_HDMELT6	
				melt temperature 7							E_HDMELT7	
				melt temperature 8							E_HDMELT8	
				melt temperature 9							E_HDMELT9	
				melt temperature 10							E_HDMELT10	
		pressures		pressure 1				bar			E_HDPRES1	S
				pressure 2							E_HDPRES2	
				pressure 3							E_HDPRES3	
				pressure 4							E_HDPRES4	
				pressure 5							E_HDPRES5	
				pressure 6							E_HDPRES6	
				pressure 7							E_HDPRES7	
				pressure 8							E_HDPRES8	
				pressure 9							E_HDPRES9	
				pressure 10							E_HDPRES10	
			alarms	*B0: pressure high*					ET		E_HDPRESAL	I
		status		*B0: head open*					RET		E_HDSTATUS	
				B1: head closed								
Blown Film	Internal Bubble Cooling Device	temperature		air temperature		1	4	°C			E_IBCAIRTEMP	R
		volume		air volume				m3/min			E_IBCAIRVOL	S
		motors	speeds	external blower	SP			min -1	RW		E_IBCSPDEXBLOSP	
					AC				RET		E_IBCSPDEXBLOAC	
				inner blower	SP				RW		E_IBCSPDINBLOSP	
					AC				RET		E_IBCSPDINBLOAC	
				inner exhauster	SP				RW		E_IBCSPDEXHAUSP	
					AC				RET		E_IBCSPDEXHAUAC	
			alarms	*B0: external blower motor fault*					ET		E_IBCMOTALARM	I
				B1: internal blower motor fault								
				B2: exhauster motor fault								
		probe	position	control signal amount				%	RET		E_IBCPROBPOS	S
			alarm	*B0: bubble breakdown*					ET		E_IBCPROBALARM	I
	Bubble Guide Cage	position		vertical	SP			mm	RW		E_BGCPOSVERTSP	S

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VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
					AC				RET		E_BGCPOSVERTAC	
				x-Axis	SP				RW		E_BGCPOSXSP	
					AC				RET		E_BGCPOSXAC	
				y-Axis	SP				RW		E_BGCPOSYSP	
					AC				RET		E_BGCPOSYAC	
				diameter	SP				RW		E_BGCPOSDIASP	
					AC				RET		E_BGCPOSDIAAC	
				position of frostline	SP				RW		E_BGCPOSFROST	
		alarms		*B0: vertical motor fault*	AC				ET		E_BGCALARM	I
				B1: x-axis motor fault								
				B2: y-axis motor fault								
				B3: open/close motor fault								
	Flattening Boards	position		left flattening board	SP			mm	RW		E_FBLEFTSP	S
					AC				R		E_FBLEFTAC	
				right flattening board	SP				RW		E_FBRGHTSP	
					AC				RET		E_FBRGHTAC	
	Gusseting Device			left gusseting device, point	SP				RW		E_GDLEFTPNTSP	
					AC				RET		E_GDLEFTPNTAC	
				left gusseting device, bottom	SP				RW		E_GDLEFTBTMSP	
					AC				RET		E_GDLEFTBTMAC	
				right gusseting device, point	SP				RW		E_GDRGTPNTSP	
					AC				RET		E_GDRGTPNTAC	
				right gusseting device, bottom	SP				RW		E_GDRGTBTMSP	
					AC				RET		E_GDRGTBTMAC	
	Flattening Boards and Gusseting Device	alarm	motor overload	*B0: left flattening board*					ET		E_GDALARM	I
				B1: right flattening board								
				B2: left gusseting device point								
				B3: left gusseting device bottom								
				B4: right gusseting device point								
				B5: right gusseting device bottom								
	Film Profile	profile point 1				4	6	mm	RET		E_FILMPROF1	R
		profile point 360									E_FILMPROF360	
		wallthickness	setpoint		SP				RW		E_FPWLTHCKSP	
			maximum		AC				RET		E_FPWLTHCKMAX	
			minimum								E_FPWLTHCKMIN	
			average								E_FPWLTHCKAVE	
			positive tolerance		SP		5		RW		E_FPWLTHCKPT	
			negative tolerance								E_FPWLTHCKNT	
		excentricity	setpoint		AC		6		RET		E_FPWLTHCKEXC	
			tolerance		SP		5		RW		E_FPWLTHCKTOL	
		diameter	setpoint			2	6				E_FPDIASETPT	

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			maximum		AC				RET		E_FPDIAMAX	
			minimum								E_FPDIAMIN	
			average				4				E_FPDIAAVE	
			positive tolerance		SP	3			RW		E_FPDIAPOSTOL	
			negative tolerance								E_FPDIANEGTOL	
			alarm	*B0: out of tolerance*	AC				ET		E_FPDIAALRM	I
		alarms		*B0: no measuring* *B1: pulling control limit* *B2: min/max limit*							E_FPALARM	
		status		*B0: filter active* *B1: measuring on/off* *B2: centering on/off* *B3: pulling control on/off*					RET		E_FPSTATUS	
	RotatingTake-Off	temperature zone 1		temperature	SP	1	4	°C	RW		E_ROTTEMP1	R
		temperature zone 2									E_ROTTEMP2	
		temperature zone 3									E_ROTTEMP3	
		temperature zone 4									E_ROTTEMP4	
		temperature zone 5									E_ROTTEMP5	
		speeds		take-off				m/min			E_ROTSPDTKOFFSP	
					AC				RET		E_ROTSPDTKOFFAC	
				rotation	SP	2	3	1/h	RW		E_ROTSPDROTSP	
					AC				RET		E_ROTSPDROTAC	
				rotation time	SP	1	4	min	RW		E_ROTSPDTIMSP	
					AC				RET		E_ROTSPDTIMAC	
				rotation angle	SP			deg	RW		E_ROTSPDANGLE	S
		currents		motor	AC			A	RET		E_ROTCURMOT	
				blower 1							E_ROTCURBLO1	
				blower 2							E_ROTCURBLO2	
		alarms		*B0: motor overload* *B1: drive motor fault* *B2: rotation motor fault* *B3: drive motor fault* *B4: blower overload* *B5: filter clogged*					ET		E_ROTALARM	I
	Width Control	product width				1	6	mm	RET		E_WDCTPRODWDTH	R
		correction factors		gusseted film							E_WDCTCORRFAC	S
		side cutting left			SP			mm	RW		E_WDCTSDCUTLEFT	
		side cutting right									E_WDCTSDCUTRGHT	
		tolerance									E_WDCTTOL	
			alarm	*B0: out of tolerance*	AC				ET		E_WDCTTOLALARM	I

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	Corona Treatment	generator power			SP	1	3	kW	RW		E_CORTGENPOWSP	R
					AC				RET		E_CORTGENPOWAC	
		pull			SP			%	RW		E_CORTPULL	
		treatment intensity			AC				RET		E_CORTINTENS	
		speed/intensity ratio			SP		2		RW		E_CORTRATIO	
		treatment tension			AC			dyn	RET		E_CORTTENSION	S
		alarms		*B0: treatment device fault*					ET		E_CORTALARM	I
				B1: shut-off for short circuit								
	Winder	entry nip-roll	dancer roll	pulling force	SP			N	RW		E_WNDDNCRLFRCSP	S
					AC				RET		E_WNDDNCRLFRCAC	
				motor current				A			E_WNDDNCRLCUR	
		nip-roll 1	station 1	pulling force	SP	1	4	N	RW		E_WNDNP1ST1FRCSP	R
					AC				RET		E_WNDNP1ST1FRCAC	
				motor current				A			E_WNDNP1ST1CUR	S
		nip-roll 2	station 2	pulling force	SP	1	4	N	RW		E_WNDNP2ST2FRCSP	R
					AC				RET		E_WNDNP2ST2FRCAC	
				motor current				A			E_WNDNP2ST2CUR	S
		winder 1	status	*B0: contact winding*							E_WND1STAT	I
				B1: axial winding								
				B2: automatic								
			pressure	winding pressure	SP			N	RW		E_WND1PRESSP	S
					AC				RET		E_WND1PRESAC	
			target	reel target (length)	SP			m	RW		E_WND1TARGLEN	I
				reel target (diameter)				mm			E_WND1TARGDIA	S
			length	actual length	AC			m	RET		E_WND1ACLENGTH	I
				bad length							E_WND1BADLENGTH	
			diameter	actual diameter				mm			E_WND1ACDIA	S
			number	number of good reels since reel change							E_WND1GOODREELS	I
				number of failed cycles since reel change							E_WND1FAILREELS	
			dancer roll	pulling force	SP	1	4	N	RW		E_WND1PULFRCSP	R
					AC				RET		E_WND1PULFRCAC	
			alarm	*B1: motor overload*					ET		E_WND1ALARM	I
				B0: drive fault								
		winder 2	status	*B0: contact winding*					RET		E_WND2STAT	
				B1: axial winding								
				B2: automatic								
			pressure	winding pressure	SP			N	RW		E_WND2PRESSP	S
					AC				RET		E_WND2PRESAC	
			target	reel target (length)	SP			m	RW		E_WND2TARGLEN	I
				reel target (diameter)				mm			E_WND2TARGDIA	S
			length	actual length	AC			m	RET		E_WND2ACLENGTH	I

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				bad length							E_WND2BADLENGTH	
			diameter	actual diameter				mm			E_WND2ACDIA	S
			number	number of good reels since reel change							E_WND2GOODREELS	I
				number of failed cycles since reel change							E_WND2FAILREELS	
			dancer roll	pulling force	SP	1	4	N	RW		E_WND2PULFRCSP	R
			alarm	*B1: motor overload*	AC				ET		E_WND2ALARM	I
				B0: drive fault								
			dancer roll	pulling force		1	4	N	RET		E_WND2PULFRCAC	R
		alarms		*B0: entry nip roll supply air low pressure*					ET		E_WNDALARM	I
				B1: entry nip roll motor overload								
				B2: entry nip roll drive fault								
				B3: nip roll 1 motor overload								
				B4: nip roll 1 drive fault								
				B5: nip roll 2 motor overload								
				B6: nip roll 2 drive fault								
		PLC alarms		*B0: winder 1 auto cycle interrupted*							E_WNDPLCALRM	
				B1: loader 1 loading cycle fault								
				B2: winder 2 auto cycle interrupted								
				B3: loader 2loading cycle fault								
		length		film length since reset				m	RET		E_WNDLENGTH	
		lengthwisecutting		position of blade 1	SP			mm	RW		E_WNDCUTBLADE1	S
				position of blade 2							E_WNDCUTBLADE2	
				position of blade 3							E_WNDCUTBLADE3	
				position of blade 4							E_WNDCUTBLADE4	
				position of blade 5							E_WNDCUTBLADE5	
				position of blade 6							E_WNDCUTBLADE6	
Flat Sheet	PolishingCalander	speed		basic speed of line		3	5	m/min			E_CALBASSPD	R
		motor 1	speed slipping			2		%			E_CALMOT1SLIP	
			speed		AC			m/min	RET		E_CALMOT1SPD	
			current					A			E_CALMOT1CUR	S
			alarms	*B0: drive fault*					ET		E_CALMOT1ALARM	I
				B1: drive overload								
		motor 2	speed slipping		SP	2	5	%	RW		E_CALMOT2SLIP	
			speed		AC	3		m/min	RET		E_CALMOT2SPD	R
			current					A			E_CALMOT2CUR	S
			alarms	*B0: drive fault*					ET		E_CALMOT2ALARM	I
				B1: drive overload								
		motor 3	speed slipping		SP	2	5	%	RW		E_CALMOT3SLIP	R
			speed		AC	3		m/min	RET		E_CALMOT3SPD	
			current					A			E_CALMOT3CUR	S

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			alarms	*B0: drive fault* *B1: drive overload*					ET		E_CALMOT3ALARM	I
		ratio	motor 1/2		SP	5	6		RW		E_CALRAT1_2	R
			motor 2/3								E_CALRAT2_3	
		position	vertical			1	5	mm	R/W		E_CALPOSVERTSP	
					AC				RET		E_CALPOSVERTAC	
			horizontal		SP				RW		E_CALPOSHORSP	
					AC				RET		E_CALPOSHORAC	
			height, front		SP				RW		E_CALPOSHTFRSP	S
					AC				RET		E_CALPOSHTFRAC	
			height, rear		SP				RW		E_CALPOSHTRESP	
					AC				RET		E_CALPOSHTREAC	
			distance from zero		SP				RW		E_CALPOSDTZESP	
					AC				RET		E_CALPOSDTZEAC	
		roll 1	temperature		SP			°C	RW		E_CALRL1TEMPSP	
					AC				RET		E_CALRL1TEMPAC	
			tolerance		SP				RW		E_CALRL1TOL	
			alarms	*B0: deviation* *B1: thermoregulation fault* *B2: low level*	AC				ET		E_CALRL1ALARM	I
		roll 2	temperature		SP			°C	RW		E_CALRL2TEMPSP	S
					AC				RET		E_CALRL2TEMPAC	
			tolerance		SP				RW		E_CALRL2TOL	
			alarms	*B0: deviation* *B1: thermoregulation fault* *B2: low level*	AC				ET		E_CALRL2ALARM	I
		roll 3	temperature		SP			°C	RW		E_CALRL3EMPSP	S
					AC				RET		E_CALRL3TEMPAC	
			tolerance		SP				RW		E_CALRL3TOL	
			alarms	*B0: deviation* *B1: thermoregulation fault* *B2: low level*	AC				ET		E_CALRL3ALARM	I
		roll gaps	roll 1/2	left side	SP	3	5	mm	RW		E_CALGAP12LFTSP	R
					AC		6		RET		E_CALGAP12LFTAC	
				right side	SP		5		RW		E_CALGAP12RGTSP	
					AC		6		RET		E_CALGAP12RGTAC	
			roll 2/3	left side	SP		5		RW		E_CALGAP23LFTSP	
					AC		6		RET		E_CALGAP23LFTAC	
				right side	SP		5		RW		E_CALGAP23RGTSP	
					AC		6		RET		E_CALGAP23RGTAC	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE		NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)		SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			alarms	*B0: safety emergency off* *B1: roll 1/2 out of alignment* *B2: roll 2/3 out of alignment* *B3: closing device 1 fault* *B4: closing device 2 fault* *B5: closing device 3 fault* *B6 closing device 4 fault*						ET		E_CALGAPALARM	I
			status	*B0: ready to close 1/2* *B1: ready to close 2/3*						RET		E_CALGAPSTATUS	
	Infra-Red Heaters	group 1		*B0: active*								E_HEATGR1STAT	
			setpoint		SP				%	RW		E_HEATGR1SP	S
			current		AC				A	RET		E_HEATGR1CUR	
		group 2	status	*B0: active*								E_HEATGR2STAT	I
			setpoint		SP				%	RW		E_HEATGR2SP	S
			current		AC				A	RET		E_HEATGR2CUR	
		group 3	status	*B0: active*								E_HEATGR3STAT	I
			setpoint		SP				%	RW		E_HEATGR3SP	S
			current		AC	xx			A	RET		E_HEATGR3CUR	
		alarms		*B0: active*						ET		E_HEATALARM	I
	Sheet Profile	profile point 1					4	6	mm	RET		E_SHTPROFPNT1	R
		profile point 100										E_SHTPROFPNT100	
		wallthickness	setpoint		SP					RW		E_SHTPROFWALLSP	
			maximum		AC					RET		E_SHTPROFWALLMAX	
			minimum									E_SHTPROFWALLMIN	
			average									E_SHTPROFWALLAVE	
			positive tolerance		SP			5		RW		E_SHTPROFWALLPTO	
			negative tolerance									E_SHTPROFWALLNTO	
		width	setpoint				2	6				E_SHTPROFWDTHSP	
			maximum		AC					RET		E_SHTPROFWDTHMAX	
			minimum									E_SHTPROFWDTHMIN	
			average									E_SHTPROFWDTHAVE	
			positive tolerance		SP		3	4		RW		E_SHTPROFWDTHPTO	
			negative tolerance									E_SHTPROFWDTHNTO	
		correctionfactor		coupled covering material				5		RRW		E_SHTPROFCORR	
			alarm	*B0: out of tolerance*	AC					ET		E_SHTPROFCORRALA	I
		alarms		*B0: no measuring* *B1: pulling control limit* *B2: min/max limt*								E_SHTPROFALARM	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
		status		*B0: filter active*							E_SHTPROFSTATUS	
				B1: measuring on/off								
				B2: centering on/off								
				B3: pulling control on/off								
	Haul-Off	temperature zone 1		temperature	SP	1	4	°C/°F	RW		E_HOFFTZ1SP	R
					AC				RET		E_HOFFTZ1AC	
		temperature zone 2			SP				RW		E_HOFFTZ2SP	
					AC				RET		E_HOFFTZ2AC	
		temperature zone 3			SP				RW		E_HOFFTZ3SP	
					AC				RET		E_HOFFTZ3AC	
		temperature zone 4			SP				RW		E_HOFFTZ4SP	
					AC				RET		E_HOFFTZ4AC	
		temperature zone 5			SP				RW		E_HOFFTZ5SP	
					AC				RET		E_HOFFTZ5AC	
		motor		speed		2	5	m/min			E_HOFFMOTSPEED	
				current				A			E_HOFFMOTCUR	S
				pulling force				N			E_HOFFMOTFORCE	I
			alarms	*B0: motor overload*					ET		E_HOFFMOTALARM	
				B1: drive fault								
		film tension 1						N	RET		E_HOFFTENS1	S
		film tension 2									E_HOFFTENS2	
		status		*B0: close*							E_HOFFSTATUS	I
	Blade Cutting Unit			*B0: manual*							E_BLDSTATUS	
				B1: automatic								
		cut length			SP			mm	RW		E_BLDCUTLENGTH	S
		numbers		scrap or test pieces since reset	AC				RET		E_BLDNUMSCRAP	I
				good pieces since reset							E_BLDNUMGOOD	
				length since reset				m			E_BLDNUMRES	
		alarm		*B0: unit fault*					ET		E_BLDALARM	
	Saw Cutting Unit	motors	saw	speed	SP			min -1	RW		E_FSCUTMOTSPDSP	S
					AC				RET		E_FSCUTMOTSPDAC	
				current				A			E_FSCUTMOTCUR	
			cross run	speed	SP			min -1	RW		E_FSCUTCRSSPDSP	
					AC				RET		E_FSCUTCRSSPDAC	
				current				A			E_FSCUTCRSSPDCUR	
		cut length			SP			mm	RW		E_FSCUTLENGTH	
		lengthwisecutting		position of blade 1							E_FSCUTPOSBLADE1	
				position of blade 2							E_FSCUTPOSBLADE2	
				position of blade 3							E_FSCUTPOSBLADE3	
				position of blade 4							E_FSCUTPOSBLADE4	
				position of blade 5							E_FSCUTPOSBLADE5	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
				position of blade 6							E_FSCUTPOSBLADE6	
		alarms		*B0: saw overload*	AC				ET		E_FSCUTALARM	I
				B1: saw drive fault								
				B2: crossrun overload								
				B3: crossrun drive fault								
				B4: crossrun overstroke								
				B5: longitudinal overstroke								
				B6: exhauster motor fault								
		status		*B0: manual*					RET		E_FSCUTSTATUS	
				B1: auromatic								
		numbers		scrap or test pieces since reset							E_FSCUTNUMSCRAP	
				good pieces since reset							E_FSCUTNUMPCSRES	
				meters since reset				m			E_FSCUTNUMMETRES	
Pipes	Calibrator - Cooling Tanks	temperatures		inlet water		1	3	°C/°F			E_TNKTEMPINLET	R
				water tank1	SP				RW		E_TNKTEMPWAT1SP	S
					AC				RET		E_TNKTEMPWAT1AC	
				water tank2	SP				RW		E_TNKTEMPWAT2SP	
					AC				RET		E_TNKTEMPWAT2AC	
				water tank3	SP				RW		E_TNKTEMPWAT3SP	
					AC				RET		E_TNKTEMPWAT3AC	
				water tank4	SP				RW		E_TNKTEMPWAT4SP	
					AC				RET		E_TNKTEMPWAT4AC	
				water tank5	SP				RW		E_TNKTEMPWAT5SP	
					AC				RET		E_TNKTEMPWAT5AC	
				water tank6	SP				RW		E_TNKTEMPWAT6SP	
					AC				RET		E_TNKTEMPWAT6AC	
		vacuum		vacuum 1	SP			mbar	RW		E_TNKVAC1SP	
					AC				RET		E_TNKVAC1AC	
				vacuum 2	SP				RW		E_TNKVAC2SP	
					AC				RET		E_TNKVAC2AC	
		positions		distance from die	SP	xxx		mm	RW		E_TNKPOSDIESP	
					AC				RET		E_TNKPOSDIEAC	
		alarms		*B0: inlet water temp high*					ET		E_TNKALARM	I
				B1: inlet water temp low								
				B2: pres sprayer 1 low								
				B3: res sprayer 2low								
				B4: pres sprayer 1 low								
				B5: res sprayer 2 low								
	ThicknessMeasurement	profile point 1				4	6	mm	RET		E_PIPEPROF1	R
		profile point 360									E_PIPEPROF360	
		wallthickness	setpoint		SP	3	5		RW		E_THCKSP	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			maximum		AC				RET		E_THCKMAX	
			minimum								E_THCKMIN	
			average								E_THCKAVE	
			positive tolerance		SP		4		RW		E_THCKPOSTOL	
			negative tolerance								E_THCKNEGTOL	
		excentricity			AC		5		RET		E_THCKEXCAC	
			tolerance		SP		4		RW		E_THCKEXCTOL	
		diameter	setpoint			2	6				E_THCKDIASP	
			maximum		AC				RET		E_THCKDIAMIN	
			minimum								E_THCKDIAMAX	
			average								E_THCKDIAAVE	
			positive tolerance		SP	3	4		RW		E_THCKDIAPOSTOL	
			negative tolerance								E_THCKDIANEGTOL	
			alarm	*B0: out of tolerance*	AC				ET		E_THCKDIAALARM	
		alarm		*B0: no measuring*							E_THCKALARM	
				B1: pulling control limit								
				B2: min/max limit								
		status		*B0: filter active*					RET		E_THCKSTATUS	
				B1: measuring on/off								
				B2: centering on/off								
				B3: pulling control on/off								
	Haul - Off Belts	motor	speed		SP	3	5	m/min	RW		E_HOFFBMOTSPDSP	R
					AC				RET		E_HOFFBMOTSPDAC	
			current					A			E_HOFFBMOTCUR	S
		dimension	pipe diameter		SP			mm	RW		E_HOFFBDIASP	
		pressures		pressure 1				bar			E_HOFFBPRES1SP	
					AC				RET		E_HOFFBPRES1AC	
				pressure 2	SP				RW		E_HOFFBPRES2SP	
					AC				RET		E_HOFFBPRES2AC	
		forces		pulling force		1	6	N			E_HOFFBPULLFORCE	R
		length		number of meters since reset				m			E_HOFFBLNGTHRES	I
		alarms		*B0: motor overload*					ET		E_HOFFBALARM	
				B1: drive fault								
				B2: line underpressure								
		status		*B0: Clamping jaw open/closed*					RET		E_HOFFBSTATUS	
				B1: on/off								
	Saw Cutting Unit	motor		blade speed	SP			min -1	RW		E_PIPESAWBLSPDSP	S
					AC				RET		E_PIPESAWBLSPDAC	
			planetary	rotation speed	SP			1/s	RW		E_PIPESAWROTSPD	
		numbers		number of scrap pieces	AC				RET		E_PIPESAWNUMSCRP	I
				number of good pieces							E_PIPESAWNUMGOOD	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
		length 1			SP	3	7	m	RW		E_PIPESAWLGTH1SP	R
					AC				RET		E_PIPESAWLGTH1AC	
		length 2			SP				RW		E_PIPESAWLGTH2SP	
					AC				RET		E_PIPESAWLGTH2AC	
		length 3			SP				RW		E_PIPESAWLGTH3SP	
					AC				RET		E_PIPESAWLGTH3AC	
		length 4			SP				RW		E_PIPESAWLGTH4SP	
					AC				RET		E_PIPESAWLGTH4AC	
		buf. length 1			SP	2			RW		E_PIPESAWBUF1	
		buf. length 100									E_PIPESAWBUF100	
		handshake buf									E_PIPESAWHNDSP	
					AC				RET		E_PIPESAWHNDAC	I
		alarms		*B0: blade motor overload*					ET		E_PIPESAWALARM	
				B1: cycle fail								
				B2: no saw cutting								
				B3: saw in endposition								
	Winder	winder 1		pulling force	SP	1	5	N	RW		E_PIPEWND1FRCSP	R
					AC				RET		E_PIPEWND1FRCAC	
				pulling torque	SP			Nm	RW		E_PIPEWND1TRQSP	S
					AC				RET		E_PIPEWND1TRQAC	
			pipe guide	speed	SP	1	2	min -1	RW		E_PIPEWND1SPDSP	R
					AC				RET		E_PIPEWND1SPDAC	
		winder 2		pulling force	SP		5	N	RW		E_PIPEWND2FRCSP	
					AC				RET		E_PIPEWND2FRCAC	
				pulling torque	SP			Nm	RW		E_PIPEWND2TRQSP	S
					AC				RET		E_PIPEWND2TRQAC	
			pipe guide	speed	SP	1	2	min -1	RW		E_PIPEWND2SPDSP	R
					AC				RET		E_PIPEWND2SPDAC	
		alarms		*B0: winder 1 overload*					ET		E_PIPEWNDALARM	
				B1: winder 2 overload								
				B2: guide motor overload								
				B3: drive fault								
Profiles	Calibrator	temperatures		inlet water		1	3	°C	RET		E_CALITEMPINLET	R
				water calibrator 1							E_CALIWATTEMP1	S
				water calibrator 2							E_CALIWATTEMP2	
				water calibrator 3							E_CALIWATTEMP3	
				water calibrator 4							E_CALIWATTEMP4	
		pressure		inlet water				bar			E_CALIPRESINLET	
		calibrator 1	distributors	vacuum 1	SP			mbar	RW		E_CALI1VAC1SP	
					AC				RET		E_CALI1VAC1AC	
				vacuum 2	SP				RW		E_CALI1VAC2SP	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
					AC				RET		E_CALI1VAC2AC	
				vacuum 3	SP				RW		E_CALI1VAC3SP	
					AC				RET		E_CALI1VAC3AC	
				vacuum 4	SP				RW		E_CALI1VAC4SP	
					AC				RET		E_CALI1VAC4AC	
			alarms	*B0: pump 1 fault*					ET		E_CALI1ALARM	I
				B1: pump 2 fault								
				B2: pump 3 fault								
				B3: pump 4 fault								
				B4: pump 5 fault								
				B5: pump 6 fault								
				B6: vacuum 1 alarm								
				B7: vacuum 2 alarm								
				B8 vacuum 3 alarm								
				B9: vacuum 4 alarm								
		calibrator 2	distributors	vacuum 1	SP			mbar	RW		E_CALI2VAC1SP	S
					AC				RET		E_CALI2VAC1AC	
				vacuum 2	SP				RW		E_CALI2VAC2SP	
					AC				RET		E_CALI2VAC2AC	
				vacuum 3	SP				RW		E_CALI2VAC3SP	
					AC				RET		E_CALI2VAC3AC	
				vacuum 4	SP				RW		E_CALI2VAC4SP	
					AC				RET		E_CALI2VAC4AC	
			alarms	*B0: pump 1 fault*					ET		E_CALI2ALARM	I
				B1: pump 2 fault								
				B2: pump 3 fault								
				B3: pump 4 fault								
				B4: pump 5 fault								
				B5: pump 6 fault								
				B6: vacuum 1 alarm								
				B7: vacuum 2 alarm								
				B8 vacuum 3 alarm								
				B9: vacuum 4 alarm								
		calibrator 3	distributors	vacuum 1	SP			mbar	RW		E_CALI3VAC1SP	S
					AC				RET		E_CALI3VAC1AC	
				vacuum 2	SP				RW		E_CALI3VAC2SP	
					AC				RET		E_CALI3VAC2AC	
				vacuum 3	SP				RW		E_CALI3VAC3SP	
					AC				RET		E_CALI3VAC3AC	
				vacuum 4	SP				RW		E_CALI3VAC4SP	
					AC				RET		E_CALI3VAC4AC	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			alarms	*B0: pump 1 fault*					ET		E_CALI3ALARM	I
				B1: pump 2 fault								
				B2: pump 3 fault								
				B3: pump 4 fault								
				B4: pump 5 fault								
				B5: pump 6 fault								
				B6: vacuum 1 alarm								
				B7: vacuum 2 alarm								
				B8 vacuum 3 alarm								
				B9: vacuum 4 alarm								
		calibrator 4	distributors	vacuum 1	SP			mbar	RW		E_CALI4VAC1SP	S
					AC				RET		E_CALI4VAC1AC	
				vacuum 2	SP				RW		E_CALI4VAC2SP	
					AC				RET		E_CALI4VAC2AC	
				vacuum 3	SP				RW		E_CALI4VAC3SP	
					AC				RET		E_CALI4VAC3AC	
				vacuum 4	SP				RW		E_CALI4VAC4SP	
					AC				RET		E_CALI4VAC4AC	
			alarms	*B0: pump 1 fault*					ET		E_CALI4ALARM	I
				B1: pump 2 fault								
				B2: pump 3 fault								
				B3: pump 4 fault								
				B4: pump 5 fault								
				B5: pump 6 fault								
				B6: vacuum 1 alarm								
				B7: vacuum 2 alarm								
				B8 vacuum 3 alarm								
				B9: vacuum 4 alarm								
		position		distance from die	SP			mm	RW		E_CALIPOSDIESP	S
					AC				RET		E_CALIPOSDIEAC	
		alarms		*B0: inlet water temp high*					ET		E_CALIALARM	I
				B1: inlet water temp low								
	Haul - Off Belt	motor	speed		SP	3	5	m/min	RW		E_PRFHOFFSPDSP	R
					AC				RET		E_PRFHOFFSPDAC	
			current					A			E_PRFHOFFCUR	S
		pressures		driving belt pressure	SP			bar	RW		E_PRFHOFFPRESSP	
					AC				RET		E_PRFHOFFPRESAC	
		forces		pulling force		1	6	N			E_PRFHOFFFORCE	R
		length		number of meters since reset				m			E_PRFHOFFMETRES	I
				pieces length		3	5				E_PRFHOFFPCSRES	R
		numbers		scrap or test pieces							E_PRFHOFFNUMSCRP	I

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
				good pieces							E_PRFHOFFNUMGOOD	
		alarms		*B0: motor overload*					ET		E_PRFHOFFALARM	
				B1: drive fault								
				B2: line underpressure								
		status		*B0: clamping jaw open/closed*					RET		E_PRFHOFFSTATUS	
				B1: on/off								
	Saw Cutting Unit	motor		blade speed	SP			min -1	RW		E_PROFSAWBLD1SP	S
					AC				RET		E_PROFSAWBLD1AC	
			planetary	rotation speed	SP			1/s	RW		E_PROFSAWROTSPD	
		length 1				3	6	m			E_PROFSAWL1SP	R
					AC				RET		E_PROFSAWL1AC	
		length 2			SP				RW		E_PROFSAWL2SP	
					AC				RET		E_PROFSAWL2AC	
		length 3			SP				RW		E_PROFSAWL3SP	
					AC				RET		E_PROFSAWL3AC	
		length 4			SP				RW		E_PROFSAWL4SP	
					AC				RET		E_PROFSAWL4AC	
		buf. length 1			SP				RW		E_PROFSAWBUF1	I
		buf. length 100									E_PROFSAWBUF100	
		handshake buf									E_PROFSAWHAND	
		alarms		*B0: blade motor overload*	AC				ET		E_PROFSAWALARM	
				B1: cycle fail								
				B2: no saw cutting								
				B3: saw in endposition								
Rubber for tyre industry	Tread Line	take away	speed		SP	2	4	m/mim	RW		E_TRTAKESPDSP	R
					AC			m/min	RET		E_TRTAKESPDAC	
				positive Tolerance	SP				RW		E_TRTAKESPDPSTOL	
				negative Tolerance							E_TRTAKESPDNGTOL	
			current			1	3	A			E_TRTAKECURSP	
					AC				RET		E_TRTAKECURAC	
				positive Tolerance	SP				RW		E_TRTAKECURPSTOL	
				negative Tolerance							E_TRTAKECURNGTOL	
		Shrinkage	speed			2	4	m/min			E_TRSHRSPDSP	
					AC				RET		E_TRSHRSPDAC	
				positive Tolerance	SP				RW		E_TRSHRSPDPOSTOL	
				negative Tolerance							E_TRSHRSPDNEGTOL	
			current			1	3	A			E_TRSHRCURSP	
					AC				RET		E_TRSHRCURAC	
				positive Tolerance	SP				RW		E_TRSHRCURPOSTOL	
				negative Tolerance							E_TRSHRCURNEGTOL	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
			shrinkage		AC	2		%	RET		E_TRSHRSHRINK	
		scale	speed		SP		4	m/min	RW		E_TRSCLSPDSP	
					AC				RET		E_TRSCLSPDAC	
			current		SP	1	3	A	RW		E_TRSCLCURSP	
					AC				RET		E_TRSCLCURAC	
			weight		SP	3	5	g	RW		E_TRSCLWGSP	
					AC				RET		E_TRSCLWGAC	
				positive warn tolerance	SP			g/%	RW		E_TRSCLPOSWRNTOL	
				positive stop tolerance							E_TRSCLPOSSTPTOL	
				negative warn tolerance							E_TRSCLNEGWRNTOL	
				negative stop tolerance							E_TRSCLNEGSTPTOL	
			dancer roll	*position*	AC	0	3	%	RET		E_TRSCLROLPOS	
				material tension		1		bar			E_TRSCLTENSION	
		calander	speed		SP	2	4	m/min	RW		E_TRCALSPDSP	
					AC				RET		E_TRCALSPDAC	
			current		SP	1	3	A	RW		E_TRCALCURSP	
					AC				RET		E_TRCALCURAC	
			left gap					mm			E_TRCALLG	
				positive tolerance	SP				RW		E_TRCALLGPPOSTOL	
				negative tolerance							E_TRCALLGPNEGTOL	
			right gap		AC				RET		E_TRCALRG	
				positive tolerance	SP				RW		E_TRCALRGPPOSTOL	
				negative tolerance							E_TRCALRGPNEGTOL	
		cooling	speed			2	4	m/mim			E_TRCOLSPDSP	
					AC			m/min	RET		E_TRCOLRSPDAC	
				positive Tolerance	SP				RW		E_TRCOLSPDPOSTOL	
				negative Tolerance							E_TRCOLSPDNEGTOL	
			current			1	3	A			E_TRCOLCURSP	
					AC				RET		E_TRCOLCURAC	
				positive Tolerance	SP				RW		E_TRCOLCURPOSTOL	
				negative Tolerance							E_TRCOLCURNEGTOL	
		skiver	length				5	mm			E_TRSKVLNGSP	
					AC				RET		E_TRSKVLNAC	
			width		SP				RW		E_TRSKVWDSP	
					AC				RET		E_TRSKVWDAC	
		accelerator	speed		SP	2	4	m/mim	RW		E_TRACCSPDSP	
					AC			m/min	RET		E_TRACCRSPDAC	
				positive Tolerance	SP				RW		E_TRACCSPDPOSTOL	
				negative Tolerance							E_TRACCSPDNEGTOL	
			current			1	3	A			E_TRACCCURSP	
					AC				RET		E_TRACCCURAC	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
				positive Tolerance	SP				RW		E_TRACCCURPOSTOL	
				negative Tolerance							E_TRACCCURNEGTOL	
		check weighing	speed			2	4	m/min			E_TRCHKWSPDSP	
					AC				RET		E_TRCHKWSPDAC	
			current		SP	1	3	A	RW		E_TRCHKWCURSP	
					AC				RET		E_TRCHKWCURAC	
			weight		SP	3	5	g	RW		E_TRCHKWWGTSP	
					AC				RET		E_TRCHKWWGTAC	
				positive warn tolerance	SP			g/%	RW		E_TRCHKWPOSWRN	
				positive stop tolerance							E_TRCHKWPOSSTOP	
				negative warn tolerance							E_TRCHKWNEGWARN	
				negative stop tolerance							E_TRCHKWNEGSTOP	
			dancer roll	*position*	AC	0	3	%	RET		E_TRCHKWDANCROL	
				material tension		1		bar			E_TRCHKWTENSION	
		deceleration	speed		SP	2	4	m/mim	RW		E_TRDECSPDSP	
					AC			m/min	RET		E_TRDECRSPDAC	
				positive Tolerance	SP				RW		E_TRDECSPDPOSTOL	
				negative Tolerance							E_TRDECSPDNEGTOL	
			current			1	3	A			E_TRDECCURSP	
					AC				RET		E_TRDECCURAC	
				positive Tolerance	SP				RW		E_TRDECCURPOSTOL	
				negative Tolerance							E_TRDECCURNEGTOL	
		booking device	pieces			0	2	1			E_TRBOOKPIECES	
	Side Wall Line	take away	speed			2	4	m/mim			E_SWTAKESPDSP	
					AC			m/min	RET		E_SWTAKESPDAC	
				positive Tolerance	SP				RW		E_SWTAKESPDPSTOL	
				negative Tolerance							E_SWTAKESPDNGTOL	
			current			1	3	A			E_SWTAKECURSP	
					AC				RET		E_SWTAKECURAC	
				positive Tolerance	SP				RW		E_SWTAKECURPSTOL	
				negative Tolerance							E_SWTAKECURNGTOL	
		Shrinkage	speed			2	4	m/min			E_SWSHRSPDSP	
					AC				RET		E_SWSHRSPDAC	
				positive Tolerance	SP				RW		E_SWSHRSPDPOSTOL	
				negative Tolerance							E_SWSHRSPDNEGTOL	
			current			1	3	A			E_SWSHRCURSP	
					AC				RET		E_SWSHRCURAC	
				positive Tolerance	SP				RW		E_SWSHRCURPOSTOL	
				negative Tolerance							E_SWSHRCURNEGTOL	
			shrinkage		AC	2		%	RET		E_SWSHRSHRINK	
		scale	speed		SP		4	m/min	RW		E_SWSCLSPDSP	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
					AC				RET		E_SWSCLSPDAC	
			current		SP	1	3	A	RW		E_SWSCLCURSP	
					AC				RET		E_SWSCLCURAC	
			weight		SP	3	5	g	RW		E_SWSCLWGSP	
					AC				RET		E_SWSCLWGAC	
				positive warn tolerance	SP			g/%	RW		E_SWSCLPOSWRNTOL	
				positive stop tolerance							E_SWSCLPOSSTPTOL	
				negative warn tolerance							E_SWSCLNEGWRNTOL	
				negative stop tolerance							E_SWSCLNEGSTPTOL	
			dancer roll	*position*	AC	0	3	%	RET		E_SWSCLROLPOS	
				material tension		1		bar			E_SWSCLTENSION	
		calander	speed		SP	2	4	m/min	RW		E_SWCALSPDSP	
					AC				RET		E_SWCALSPDAC	
			current		SP	1	3	A	RW		E_SWCALCURSP	
					AC				RET		E_SWCALCURAC	
			left gap					mm			E_SWCALLG	
				positive tolerance	SP				RW		E_SWCALLGPPOSTOL	
				negative tolerance							E_SWCALLGPNEGTOL	
			right gap		AC				RET		E_SWCALRG	
				positive tolerance	SP				RW		E_SWCALRGPPOSTOL	
				negative tolerance							E_SWCALRGPNEGTOL	
		cooling	speed			2	4	m/mim			E_SWCOLSPDSP	
					AC			m/min	RET		E_SWCOLRSPDAC	
				positive Tolerance	SP				RW		E_SWCOLSPDPOSTOL	
				negative Tolerance							E_SWCOLSPDNEGTOL	
			current			1	3	A			E_SWCOLCURSP	
					AC				RET		E_SWCOLCURAC	
				positive Tolerance	SP				RW		E_SWCOLCURPOSTOL	
				negative Tolerance							E_SWCOLCURNEGTOL	
		cross cutter	length			0		m			E_SWCROSSLNGTH	
		winder		*total length per reel*			2				E_SWLENGTH	
			tension					Nm			E_SWWNDTENSSP	
					AC				RET		E_SWWNDTENSAC	
			number of reels		SP				1 RW		E_SWWNDREELSP	
					AC				RET		E_SWWNDREELAC	
	Apex Line	take away	speed		SP	2	4	m/mim	RW		E_APTAKESPDSP	
					AC			m/min	RET		E_APTAKESPDAC	
				positive Tolerance	SP				RW		E_APTAKESPDPSTOL	
				negative Tolerance							E_APTAKESPDNGTOL	
			current			1	3	A			E_APTAKECURSP	
					AC				RET		E_APTAKECURAC	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
				positive Tolerance	SP				RW		E_APTAKECURPSTOL	
				negative Tolerance							E_APTAKECURNGTOL	
		Shrinkage	speed			2	4	m/min			E_APSHRSPDSP	
					AC				RET		E_APSHRSPDAC	
				positive Tolerance	SP				RW		E_APSHRSPDPOSTOL	
				negative Tolerance							E_APSHRSPDNEGTOL	
			current			1	3	A			E_APSHRCURSP	
					AC				RET		E_APSHRCURAC	
				positive Tolerance	SP				RW		E_APSHRCURPOSTOL	
				negative Tolerance							E_APSHRCURNEGTOL	
			shrinkage		AC	2		%	RET		E_APSHRSHRINK	
		scale	speed		SP		4	m/min	RW		E_APSCLSPDSP	
					AC				RET		E_APSCLSPDAC	
			current		SP	1	3	A	RW		E_APSCLCURSP	
					AC				RET		E_APSCLCURAC	
			weight		SP	3	5	g	RW		E_APSCLWGSP	
					AC				RET		E_APSCLWGAC	
				positive warn tolerance	SP			g/%	RW		E_APSCLPOSWRNTOL	
				positive stop tolerance							E_APSCLPOSSTPTOL	
				negative warn tolerance							E_APSCLNEGWRNTOL	
				negative stop tolerance							E_APSCLNEGSTPTOL	
			dancer roll	*position*	AC	0	3	%	RET		E_APSCLROLPOS	
				material tension		1		bar			E_APSCLTENSION	
		cooling	speed		SP	2	4	m/mim	RW		E_APCOLSPDSP	
					AC			m/min	RET		E_APCOLRSPDAC	
				positive Tolerance	SP				RW		E_APCOLSPDPOSTOL	
				negative Tolerance							E_APCOLSPDNEGTOL	
			current			1	3	A			E_APCOLCURSP	
					AC				RET		E_APCOLCURAC	
				positive Tolerance	SP				RW		E_APCOLCURPOSTOL	
				negative Tolerance							E_APCOLCURNEGTOL	
		storage device	speed			2	4	m/mim			E_APSTORSPDSP	
					AC			m/min	RET		E_APSTORSPDAC	
				positive Tolerance	SP				RW		E_APSTORSPDPSTOL	
				negative Tolerance							E_APSTORSPDNGTOL	
			current			1	3	A			E_APSTORCURSP	
					AC				RET		E_APSTORCURAC	
				positive Tolerance	SP				RW		E_APSTORCURPSTOL	
				negative Tolerance							E_APSTORCURNGTOL	
		bead setting device	pieces			0			1		E_APBEADPIECES	
	Inner Liner Line	take away	speed			2	4	m/mim			E_INTAKESPDSP	

BASECLASS	SUBCLASS1	SUBCLASS2	SUBCLASS3	DESCRIPT	VALTYPE	NUMSCALE	NUMPRECS	UNIT	SERVICE	COMAPPL	VARNAME	SQL_TYPE
VARCHAR(30)	VARCHAR(40)	VARCHAR(30)	VARCHAR(30)	LONG VARCHAR	VARCHAR(2)	SMALLINT	SMALLINT	VARCHAR(10)	VARCHAR(5)	VARCHAR(2)	VARCHAR(16)	VARCHAR(1)
					AC			m/min	RET		E_INTAKESPDAC	
				positive Tolerance	SP				RW		E_INTAKESPDPSTOL	
				negative Tolerance							E_INTAKESPDNGTOL	
			current			1	3	A			E_INTAKECURSP	
					AC				RET		E_INTAKECURAC	
				positive Tolerance	SP				RW		E_INTAKECURPSTOL	
				negative Tolerance							E_INTAKECURNGTOL	
		cooling	speed			2	4	m/mim			E_INCOLSPDSP	
					AC			m/min	RET		E_INCOLRSPDAC	
				positive Tolerance	SP				RW		E_INCOLSPDPOSTOL	
				negative Tolerance							E_INCOLSPDNEGTOL	
			current			1	3	A			E_INCOLCURSP	
					AC				RET		E_INCOLCURAC	
				positive Tolerance	SP				RW		E_INCOLCURPOSTOL	
				negative Tolerance							E_INCOLCURNEGTOL	
		cross cutter	length			0		m			E_INCROSSLNGTH	
		winder		*total length per reel*			2				E_INLENGTH	
			tension					Nm			E_INWNDTENSSP	
					AC				RET		E_INWNDTENSAC	
			number of reels		SP				1 RW		E_INWNDREELSP	
					AC				RET		E_INWNDREELAC	
Granulating	Die Cutting Unit	speeds		blade	SP			min -1	RW		E_GRANBLDSPDSP	S
					AC				RET		E_GRANBLDSPDAC	
		temperatures		water				°C/°F			E_GRANWATTEMP	
		pressures						bar			E_GRANWATPRES	
		alarms		*B0: blade motor overload*					ET		E_GRANALARM	I
				B1: drive fault								
				B2: cooling water temp high								
				B3: cooling water temp low								
		status		*B0: head open/close*					RET		E_GRANSTATUS	
				B1: on/off								
EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF	EOF

EUROMAP

Europäisches Komitee der Hersteller von Kunststoff- und Gummimaschinen

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