
Okuma America Corporation

Okuma MTConnect Adapter

Release Notes

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OKUMA MTConnect Adapter	Version: 3.2.0.0
Release Notes	Date: 11/05/2019

Revision History

Date	Version	Description	Author
7/25/2011	S5053-004-00	Public release System Version 1.0.0.0	Linh Huynh
10/14/2011	S5053-004-01	Public release System Version 1.3.0.0	Linh Huynh
12/20/2011	S5053-004-02	Public release System Version 1.3.2.0	Linh Huynh
02/17/2012	S5053-004-06	Public release System Version 1.3.6.0	Linh Huynh
02/20/2012	S5053-004-07	Public release System Version 1.3.7.0	Linh Huynh
06/08/2012	S5053-004-08	Public release System Version 1.3.8.0	Linh Huynh
10/09/2013	S5053-004-09	Beta release System Version 1.5.0.0	Linh Huynh
11/05/2013	S5053-004-10	Beta release System Version 1.5.1.0	Linh Huynh
01/07/2014	S5053-004-11	Beta release System Version 1.5.2.0	Linh Huynh
01/09/2014	S5053-004-12	Beta release System Version 1.5.3.0	Linh Huynh
04/15/2014	S5053-004-13	Beta release System Version 1.5.4.1	Linh Huynh
05/06/2014	S5053-004-14	Beta release System Version 1.5.5.1	Linh Huynh
05/14/2014	S5053-004-15	Beta release System Version 1.5.5.2	Linh Huynh
05/16/2014	S5053-004-16	Beta release System Version 1.5.5.3	Linh Huynh
06/24/2014	S5053-004-17	Public release System Version 1.5.6.0	Linh Huynh
07/28/2014	S5053-004-18	Beta release System Version 1.5.6.1	Linh Huynh
08/04/2014	S5053-004-19	Public release System Version 1.5.7.0	Linh Huynh
10/31/2014	S5053-004-20	Public release System Version 2.0.0.0	Linh Huynh
02/06/2015	S5053-004-21	Public release System Version 2.1.0.0	Linh Huynh
06/19/2015	S5053-004-22	Beta release System Version 2.1.2.0	Linh Huynh
09/24/2015	S5053-004-23	Beta release System Version 2.2.2.0	Linh Huynh
06/24/2016	S5053-004-25	Public Release System Version 2.2.5.0	Linh Huynh
09/26/2016	S5053-004-26	Public Release System Version 3.0.0.0	Linh Huynh
03/16/2017	S5053-004-27	Public Release System Version 3.1.0.0	Linh Huynh
04/11/2019	S5053-004-28	BETA Release System Version 3.1.9.0	Linh Huynh
11/05/2019	S5053-004-29	Public Release System Version 3.2.0.0	Linh Huynh

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Release Notes for Okuma MTConnect Adapter

1. Introduction

1.1 Disclaimer of Warranty

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1.2 Purpose

The purpose of the **Release Notes** document is to communicate major new features and changes in this release of the Okuma MTConnect Adapter. It also documents known problems and workarounds.

1.3 Scope

This document describes this public release of Okuma MTConnect Adapter version 3.2.0

1.4 References

None

2. About This Release

In this release, the device configuration file, named Devices.xml, is automatically generated by the application to meet per machine specification that the adapter currently can support.

2.1 Prerequisite Software

This release of this application is required to include:

- THINC API release 1.22.0.0 for Lathe
- THINC API release 1.22.0.0 for MC
- THINC API release 1.22.0.0 for Grinder
- Start-up Service version 4.4.0 or latest version
- MTConnect Agent version 1.3.0.17 or latest version
- MTConnect schemas 1.3.0.0 only.

2.2 License

Not applicable

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2.3 Machine Model

This release supports OKUMA OSP- P300A/P300/P200/P100II or newer controls.

The following files included with the installation disk contain data items that can be supported per machine type:

- Lathe2SPDevices.xml : Lathe with 2 sides
- LatheDevices.xml: Any Lathe except for 2 sides Lathe
- MCDevices: Any Machining Center
- GrinderDevices: Any P300G Grinder
- Agent.cfg: default agent configuration file

Please contact your local distributor service department if you experience any difficulties with installing the software or using the system.

2.4 Features

The adapter supports MTConnect schema version 1.3.0 only.

This version and new version of MTConnect Adapter can support the following languages:

- English (default)

3. Changes/New

3.2 Pallet ID

Please refer to the section 5.3.2.10 in the Installation Manual for more information

3.3 Part Count

Please refer to the section 5.3.2.11 in the Installation Manual for more information

3.4 Tool Asset

The following specification of machine can be supported on:

- P300L Multi Tool Spec spec.
- P300S Extended ATC Magazine

Please refer to the section 8.3 Tool Assets in the Installation Manual for more information

3.5 Sensors

Please refer to the section 8.4 in the Installation Manual for more information

3.6 Conditions

Please refer to the section 8.5 in the Installation Manual for more information

4. Known Issues

4.1.1 P100II - Two side Lathe

```
<DataItem type="EXECUTION" name="plexecution" category="EVENT" id="L2p1execution"/>
<DataItem type="EXECUTION" name="p2execution" category="EVENT" id="L2p2execution"/>
```

Feed hold status does not report correctly for these tags. It only reports the current active side of machine on NC HMI but not the individual side of machine.

4.1.2 P300G

```
<DataItem type="PROGRAM" name="p1program" category="EVENT" id="Gp1program"/>
<DataItem type="PART_COUNT" name="p1partcount" category="EVENT" id="Gp1partcount"/>
```


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When Grinder uses Work Selection, part count and part program can only report total count of program for Grinding G Cycle as a whole.

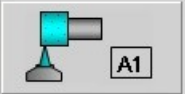
The future release of OSP system will allow part program and part count per running part program when Work Selection is using.

CYCLE SELECT

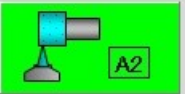
SELECT INDEX PROGRAM



G



A1



A2

CYCLE	SELECT MAIN PROGRAM	PROGRAM NAME
GRINDING G	LD-GRIND.MIN	02345
DRESSING A1	LD-DRESS.MIN	01234
WHL. TRUING A2	LD-IDRS.MIN	04567

AUTO OPERATION										W0001.IDX											
MacMan HMI																					
START					OPERATING					IN-PRO SETUP											
MACH NAME:MC.NAME																					
MACHINING REPORT:DAILY(TODAY):2016/09/16																					
MAIN PROGRAM					PROG NAME			START DAY		START TIME		NO.OF WORK		OPERATING %		RUNNING		OPERATING		CUTTING	
LD-GRIND.MIN					04567			2016/09/16		00:00:00		7		0		16:15		0		0	
SUM								2016/09/16		00:00:00		7		0		16:15		0		0	

4.1.3 Tool Data for P300S/P300L

For P300S(LP) :

Tool Asset, Current Tool for A/B/C turret, and ToolAssetID tags will not be available when one of the following conditions are met:

- Tool ID is ON
- TMIM is OFF

For P300L:

Tool Asset, Current Tool for A/B/C turret, and ToolAssetID tags will not be available when the specification of LTIM is OFF.

```

<!-- Tool Path related to upper A/H1 turret-->
<DataItem type="TOOL_NUMBER" name="p1CurrentTool" category="EVENT" id="Lp1CurrentTool" />
<DataItem type="TOOL_ASSET_ID" name="p1ToolAssetId" category="EVENT" id="Lp1ToolAssetId" />

<!-- Tool Path related to B turret-->
<DataItem type="TOOL_NUMBER" name="p2CurrentTool" category="EVENT" id="Lp2CurrentTool" />
<DataItem type="TOOL_ASSET_ID" name="p2ToolAssetId" category="EVENT" id="Lp2ToolAssetId" />

<!-- Tool Path related to C turret-->
<DataItem type="TOOL_NUMBER" name="p3CurrentTool" category="EVENT" id="Lp3CurrentTool" />

```

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```
<DataItem type="TOOL_ASSET_ID" name="p3ToolAssetId" category="EVENT" id="Lp3ToolAssetId" />
```

```
<?xml version="1.0" encoding="UTF-8"?>
<MTConnectAssets xsi:schemaLocation="urn:okuma.com:OkumaToolAssets:1.3 /schemas/OkumaToolAssets_1.3.xsd"
xmlns:x="urn:okuma.com:OkumaToolAssets:1.3" xmlns:xsi="http://www.w3.org/2001/XMLSchema-instance"
xmlns="urn:mtconnect.org:MTConnectAssets:1.3" xmlns:m="urn:mtconnect.org:MTConnectAssets:1.3"><Header
assetCount="0" assetBufferSize="1024" version="1.3.0.17" instanceId="1484830744" sender="OKUMA-90BF578E1"
creationTime="2017-01-19T13:00:10Z"/><Assets/></MTConnectAssets>
```

5. Defects fixed in this release

5.1 Lathe

5.1.1 Tool Assets

Symptom: Tool Asset configuration is enable from Tag Configuration but not data once application is restarted.

5.2 All OSP-P controls

5.2.1 Adapter stops due to error in connection with Agents

Symptom: Adapter stops responding to agents due to error in connection.

Solution: The system will be restarted itself to re-establish the connections with any client.

5.2.2 Alarm Condition

5.2.2.1 Time stamp

Symptom: when multiple alarms are active the time stamp is not correctly stamped when one of the alarms become inactive

5.2.2.2 24 hours period

Symptom: Existing alarms are sent to MTConnect Agent again when time is just passed 24 hours period or next day.

5.2.2.3 Multiple alarm conditions

Symptom: Cannot support multiple alarm conditions occurring on NC.

5.2.3 Windows 10

Symptom: Cannot move main form by dragging the title bar.