

PC-Topp Transfer of Machine Timetables

the TTDATA interface only contains the information „open shift“ or „closed shift “. The exact start and end times are not specified.

Field No.	Description	A/N	Length (Bytes)	Offset	Remarks
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Information about open shifts

1	<i>Machine Code</i>	A	6	0	
2	<i>Shift Date</i>	N	8	6	(DDMMYYYY)
3	<i>Shift Code</i>	A	1	14	
4	<i>Open / Closed</i>	N	1	15	0=closed, 1=open

Comments

Field	Remarks
2+3	All shifts of N days from today (included) will be recorded. The number N is a parameter (standard value 14).
4	A shift is considered to be open if at least 4 work hours are declared open in the machine timetable within the theoretical shift times (according to the model of the production day in the PC-Topp timetable).

Only information if shifts are open or not are transported via this interface. The precise open hours are not published (possibility to realize this in an additional mode in future).

Examples:

Model of the production day in the PC-Topp timetable:

Shift M 05:00 – 13:00

Shift A 13:00 – 21:00

Shift N 21:00 – 05:00

Example	1	2	3
Machine Open Time	05:00 – 15:00 break 09:00 – 09:20	05:00 – 18:00 break 09:00 – 09:20 break 17:00 – 17:20	05:00 – 17:00 break 09:00 – 09:20 break 15:00 – 15:20
During Shift M 05:00 – 13:00	07:40 → Open	07:40 → Open	07:40 → Open
During Shift A 13:00 – 21:00	02:00 → Closed	04:40 → Open	03:40 → Closed
During Shift N 21:00 – 05:00	00:00 → Closed	00:00 → Closed	00:00 → Closed