

## PC-Topp Transfer of Machine Timetables

| Field No. | Description | A/N | Length (Bytes) | Offset | Remarks |
|-----------|-------------|-----|----------------|--------|---------|
|-----------|-------------|-----|----------------|--------|---------|

### 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.<br>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   |
|---|--------------------------------------|---|---|
| <b>Machine Open Time</b>                | 05:00 – 15:00<br>break 09:00 – 09:20 | 05:00 – 18:00<br>break 09:00 – 09:20<br>break 17:00 – 17:20 | 05:00 – 17:00<br>break 09:00 – 09:20<br>break 15:00 – 15:20 |
| <b>During Shift M<br/>05:00 – 13:00</b> | 07:40<br>→ Open                      | 07:40<br>→ Open   | 07:40<br>→ Open   |
| <b>During Shift A<br/>13:00 – 21:00</b> | 02:00<br>→ Closed                    | 04:40<br>→ Open   | 03:40<br>→ Closed   |
| <b>During Shift N<br/>21:00 – 05:00</b> | 00:00<br>→ Closed                    | 00:00<br>→ Closed   | 00:00<br>→ Closed   |