ORDER ITEM DATA

Order Data Import File Structure - Most order data is passed into Eclipse via this specification. This structure supports the core requirements to produce finished parts from a Machine. Other high-level order data might need to be passed via the Bundle Data Import File for printing or display purposes. Specific punching requirements might need to be passed via the Part Data Import File. From top to bottom, the fields starting with Bundle are specific to each cutlist item record. That is, each field can be applied to each specific cutlist item in the order, seperately. That means, for instance, that even though 2 cutlist items might share the same Bundle Number (for the purpose of packaging those physical parts together after they're produced), they could potentially have different information printed on each item.

Fields in this specification appear top-to-bottom. In the comma delimited text file, the fields must appear left-to-right. Character fields must be surrounded by quotation marks - "sample data" - numeric and logical fields should not use quotation marks. Each field must be separated with a comma. Optional fields that are not used should be left empty, except for character fields, which must still use open and closed quotation marks.

By default, Eclipse only accepts lengths in decimal inch. If using Metric, the first line of every Order Data Import File must be **UNITS=.39370078**. Eclipse will then process lengths in Metric millimeter.

Example - 2 orders imported within the same file, Order 1234 with 2 cutlist items, and Order 5678 with 1 cutlist item.
"Order 1234",1,10,60.000,"material code","","product code","","R","","","","ABC-123","C","",,"","",,,"","","","","","",""
"Order 1234",2,5,120.000,"material code","","product code","","R","","","","ABC-124","C","",,"","",,,"","","","","","",""
"Order 5678",1,100,24.875,"material code","","product code","","R","","","","ABC-123","C","",,"","",,,"","","","","","",""

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Order data will be saved in a text file with a .ORD extension.

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Order Number	Required	character	20*	**Order Number** - Identifies a batch of production for a given customer. This number may be duplicated only if the combination of Order Number/Material Code/Product Code form a unique combination.	*XL100 Series controllers are limited to 15 characters	
2	Bundle	Required	numeric	3*	**Bundle Number** - Identifies a set of lengths and quantities that should be packaged together. Multiple lengths may have the same Bundle Number. Eclipse does not "bundle" automatically. Bundle quantities are passed through exactly as they are processed.	*Bundle 0 always indicates Normal Production Scrap and bundle 900+ indicates Scrap, where the last two digits reference a Scrap Code	
3	Quantity	Required	numeric	4	**Quantity** - Number of parts to produce.		
4	Length	Required	decimal(10,3)	10,3*	**Part Length** - Finished Part Length.	*Lengths must be in decimal inch	
5	Material	Required	character	20*	**Material Code** - Defines the type of Material to be used to produce the final product. Material parameters used to generate specific codes are typcially: coil width, gauge, color, coating, galvinization, KSI, etc.	*XL100 Series controllers are limited to 18 characters	

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
6	Message	Optional	character	40	**Operator Message** - This is a line of text that will show up embedded within the cutlist of the order, just above the cutlist item originally associated with the message. If no Part Length, Quantity, or Part Number are entered, muli-line messages can be created. Be aware that the Operator Message is not linked to the cutlist item originally associated with it, once the Order reaches the Machine controller. That is, if the operator resequences the cutlist at the Machine, the Operator Message does not move with the original cutlist item. It is simply a line of text within the Order cutlist.		
7	Product Code	Required	character	20*	**Product Code** - Defines a set of tooling required to create a particular part shape. This might reference the roll former tooling, punching dies, or a cutoff die. This value should only change the Machine is required to come to a stop for the change to take effect. That is, if a punch die simply isn't used for a particular part, that would not constitute a Product Code change. However, if the Machine operator must physically remove one punch die and insert another, that fact should require a Product Code change.	*XL100 Series controllers are limited to 5 characters	
8	Part Number	Optional	character	30	**Part Number** - This field specifies a pre-defined or imported Part Definition in Eclipse. Typically, Part Numbers only specify punch locations. In some cases, Part Length will also be defined within the Part Definition. If the Part Definition includes length, leave the "Length" field blank when importing Order data.		

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
9	Part Option	Required	character	1*	**Part Option** - When programming punched parts, the user will typically define the part with reference to the leading edge of the part. Most commonly, the "leading edge" is the end of the part that exits the Machine first. This would be considered a "right-handed" part, regardless of whether the user is standing so Material exits right-to-left in reference to where the operator typically stands. In order to make punch programming flexible and easy, "right-handed" parts can be produced from the Machine with an opposing punch sequence simply by designating the same part number as a "left-handed" part. This would immediately lay out a punch pattern defined from the leading edge as if it were defined from the trailing edge. Optionally, users can specify an "alternating" part. Most often used by auto parts manufacturers, this produces 2 parts for each part programmed. The Machine will produce a right-handed part immediately followed by a left-handed part. Finally, for extremely complex punching patterns, a "mirrored" option exists. This allows users to program only half the part, and then specify that the Machine controller is to automatically "mirror" the punches on the first half of the part to the other half of the part, creating a mirror image of the punches divided down the center of the part.	*This field may only contain: R, L, A, or M	**R = Right-handed** **L = Left-handed** **A = Alternating** **M = Mirrored**
10	Bundle Label	Optional	character	254	**Bundle Print Message** - If the user prefers to directly program printer commands and print data, this field should be used. This field overrides any default print messages created within Eclipse, and this data is passed directly to a Bundle Ticket printer integrated directly to the XL Series controller. It is the user's responsibility to learn and understand the command structure of the printer used.		
11	Part Label	Optional	character	254	**Part Print Message** - If the user prefers to directly program printer commands and print data, this field should be used. This field overrides any default print messages created within Eclipse, and this data is passed directly to an Ink Jet printer integrated directly to the XL Series controller. It is the user's responsibility to learn and understand the command structure of the printer used.		
12	Kit Name	Optional	character	24	**Kit Name** - Kits are pre-generated orders in Eclipse. The user specifies a pre-defined Kit name, and all cutlist data is loaded from the Kit definition.		
13	Item ID	Required	character	22	**Item ID** - This is a unique identifier per Order cutlist item. Used in combination with Action Codes, this identifier allows the user to make edits to an Order within Eclipse without removing the entire Order from the Eclipse system. Also allows tracking of specific cutlist item data throughout the system.		

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
14	Action	Required	character	1*	**Action Code** - Specifies what Eclipse is to do with the associated record fields, such as: 1.) adding a new Order or making changes to an existing Order, 2.) sequencing Orders as they are added, 3.) recalling an Order from the Machine, deleting it from Eclipse and then sending a "returned" notification to the upstream system.	*This field may only contain: C, Q, or R	**C = Add new Order record or change existing Order record Q = Sequence Order and Assign it to a Machine (the Machine Number must be specified in the Machine Number field when this Action Code is used) R = Recall the Order from the Machine controller, delete the Order from Eclipse, and send a "returned" notification to the upstream system**
15	Schedule Date	Optional	date or character	8*	**Schedule Date** - Specifies a date and time to automatically send an Order to a Machine. The Machine Number must be specified in the Machine Number field when the Schedule Date field is used.	*Date format must be DD/MM/YY	
16	Machine	Optional*	numeric	2	**Machine Number** - This field corresponds to the Network Unit ID for a given Machine on the Eclipse network. If Eclipse is to auto-sequence Orders for production at a specific machine, or if Eclipse is to automatically download Orders to a specific machine, the Machine number must be known.	*This field is required when using an Action Code of Q or when using the Schedule Date field	
17	Items User1	Optional	character	254	**User Field 1** - The user may use this field for any data not already available within Eclipse. This data is linked to the cutlist item in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.		
18	Items User2	Optional	character	254	**User Field 2** - The user may use this field for any data not already available within Eclipse. This data is linked to the cutlist item in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.		
19	Hole Offset	Optional*	decimal(10,3)	8,3	**Offset** - Defines the distance (from the leading edge of a hole picked up by a photo-eye) where the Machine controller will fire the cutoff when operating in Hole Count mode.	*This field is required when using the "Holecount" field	
20	Hole Count	Optional*	numeric	4	**Hole Count** - In some rare instances, the XL200 Series controller is only in control of the cutoff on a Machine that has upstream, in-line punching. In these cases, the XL200 is counting holes pre-punched by an off line system. Instead of programming based on length, this controller is programmed based on the number of holes picked up by a sensor. When Order data is to be programmed in this way, Machine must be told how many holes to "look for" before cutting. This field essentially replaces the "Length" field.	*This field is required by customers who use XL Series Machine controllers with the "H" designator in the software model number	

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
21	Stagger	Optional	character	1*	**Stagger Panel** - This field is used to automatically force the Machine controller to alternate between at least 2 different part lengths in the same bundle. This feature allows convenient interleaving of part lengths within a bundle.	*This field may only contain: S or empty string	**S = Stagger Part Length with Adjoining Lengths also Marked for Stagger** **empty string = No Stagger**
22	Part Format Name	Optional	character	12	**Part Print Message Name** - This field allows the system to automatically change the Part Print Message at a Machine from the default to whatever pre-defined Part Print Message Name the user selects. The Part Print Message must be pre-defined within Eclipse.		
23	Bundle Format Name	Optional	character	12	**Bundle Print Message Name** - This field allows the system to automatically change the Bundle Print Message at a Machine from the default to whatever pre-defined Bundle Print Message Name the user selects. The Bundle Print Message must be pre-defined within Eclipse.		
24	Items User3	Optional	character	254	**User Field 3** - The user may use this field for any data not already available within Eclipse. This data is linked to the cutlist item in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.		
25	Items User4	Optional	character	254	**User Field 4** - The user may use this field for any data not already available within Eclipse. This data is linked to the cutlist item in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.		
26	Items User5	Optional	character	254	**User Field 5** - The user may use this field for any data not already available within Eclipse. This data is linked to the cutlist item in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.		
27	Bundle Code	Optional	character	15	**Bundle Code** - Some ERP systems use a specific Bundle Code to dictate bundling rules for the operator. This field is simply passed along and displayed or printed where ever the user selects.		
28	No Material Substitutes	Deprecated	numeric	0	**No Material Substitutions** - This field was improperly applied in this specification.		

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
29	Blank	Unsupported	numeric	0	Place-holder to provide compatibility with SQL specification.		
30	Blank	Unsupported	numeric	0	Place-holder to provide compatibility with SQL specification.		
31	SKU	Optional	character	50	**Stock-keeping Unit** - This field provides greater integration with ERP systems that support SKU numbers. There is no processing performed on this field, except to pass it back to the ERP when reporting Order completions.		
32	Profile	Optional	character	50	**Profile** - This field can be used to print on a part or bundle tag.		
33	Schedule Time	Optional	character	8	Time portion of the **Schedule Date** above. In 24-hour format		
34	Piece Mark	Optional	character	30	**Piece Mark** - This can be used to print on a part to uniquely identify it after it is produced.		

ORDER HEADER DATA

Bundle Data Import File Structure - This structure supports the bundle-specific data typically used in printing bundle tickets. Also supported here are some high-level data fields pertaining to the overall order. For example, this structure supports the Required Date field, used by the scheduler (Eclipse user) to determine production sequencing for Orders.

The Bundle field is used to identify some fields as pertaining to the entire Order. The Bundle field is also used to identify other fields as pertaining only to specific Bundles. For this reason, it's possible that each Order imported to the system will carry N + 1 Bundle records; where N = Number of Bundles in the Order (each having its own record and potentially its own data that just pertains to that particular Bundle) + 1 additional record to identify the data that pertains to all Bundles in the Order. For this reason, this specification is broken into 2 parts to help with user understanding of how the structure is applied.

Most companies will want to pass their Customer and shipping information through this data file.

Fields in this specification appear top-to-bottom. In the comma delimited text file, the fields must appear left-to-right. Character fields must be surrounded by quotation marks - "sample data" - numeric and logical fields should not use quotation marks. Each field must be separated with a comma. Optional fields that are not used should be left empty, except for character fields, which must still use open and closed quotation marks.

Example - 2 orders imported within the same file, Order 1234 with 2 bundles requiring special print data and alternate pre-formated print label, and Order 5678 with no special requirements
"Order 1234","material code","product code",1,"special print data","","","","","","","","bundle label format 1",""
"Order 1234","material code","product code",2,"different print data","","","","","","","","bundle label format 1",""
"Order 1234","material code","product code",0,"","","","","","","","","","","customer name","","","","","","","","","","","",01/01/01,"",F
"Order 5678","material code","product code",0,"","","","","","","","","","","customer name 2","","","","","","","","","","","",01/04/01,"",F

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Bundle data will be saved in a text file with a .BND extension.

Position	Field ID	Required	Data Type	Maximum Field Size	Data Pertains to:	Description	Notes	Options
1	Order Number	Required	character	20*	Both	**Order Number** - Identifies a batch of production for a given customer. This number may be duplicated only if the combination of Order Number/Material Code/Product Code form a unique combination.	*XL100 Series controllers are limited to 15 characters	
2	Material Code	Required	character	20*	Both	**Material Code** - Defines the type of Material to be used to produce the final product. Material parameters used to generate specific codes are typcially: coil width, gauge, color, coating, galvinization, KSI, etc.	*XL100 Series controllers are limited to 18 characters	

Position	Field ID	Required	Data Type	Maximum Field Size	Data Pertains to:	Description	Notes	Options
3	Product Code	Required	character	20*	Both	**Product Code** - Defines a set of tooling required to create a particular part shape. This might reference the roll former tooling, punching dies, or a cutoff die. This value should only change if Material must be physically removed from the Machine for the change to take effect. That is, if a punch die simply isn't used for a particular part, that would not constitute a Product Code change. However, if the Machine operator must physically remove one punch die and insert another, that fact should require a Product Code change.	*XL100 Series controllers are limited to 5 characters	
4	Bundle	Required	numeric	3	Either*	**Bundle Number** - Identifies a set of lengths and quantities that should be packaged together. Multiple lengths may have the same Bundle Number. Eclipse does not "bundle" automatically. Bundle quantities are passed through exactly as they are processed.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
5	User1	Optional	character	254	Either*	**User Field 1** - The user may use this field for any data not already available within Eclipse. This data is linked to the Bundle in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
6	User2	Optional	character	254	Either*	**User Field 2** - The user may use this field for any data not already available within Eclipse. This data is linked to the Bundle in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
7	User3	Optional	character	254	Either*	**User Field 3** - The user may use this field for any data not already available within Eclipse. This data is linked to the Bundle in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
8	User4	Optional	character	254	Either*	**User Field 4** - The user may use this field for any data not already available within Eclipse. This data is linked to the Bundle in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	

Position	Field ID	Required	Data Type	Maximum Field Size	Data Pertains to:	Description	Notes	Options
9	User5	Optional	character	254	Either*	**User Field 5** - The user may use this field for any data not already available within Eclipse. This data is linked to the Bundle in the associated record. Typically, this field is used to pass print data, or to trigger Custom List events.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
10	Bundle Label	Optional	character	254	Either*	**Bundle Print Message** - If the user prefers to directly program printer commands and print data, this field should be used. This field overrides any default print messages created within Eclipse, and this data is passed directly to a Bundle Ticket printer integrated directly to the XL Series controller. It is the user's responsibility to learn and understand the command structure of the printer used.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
11	Part Label	Optional	character	254	Either*	**Part Print Message** - If the user prefers to directly program printer commands and print data, this field should be used. This field overrides any default print messages created within Eclipse, and this data is passed directly to an Ink Jet printer integrated directly to the XL Series controller. It is the user's responsibility to learn and understand the command structure of the printer used.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
12	Kit Name	Optional	character	24	Either*	**Kit Name** - New Kits can be imported to Eclipse via this specification. Bundle level Kit data should include a non-zero Bundle Number. Order level Kit data should include a Bundle number of 0.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
13	Bundle Format	Optional	character	12	Either*	**Bundle Print Message Name** - This field allows the system to automatically change the Bundle Print Message at a Machine from the default to whatever pre-defined Bundle Print Message Name the user selects. The Bundle Print Message must be pre-defined within Eclipse.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
14	Part Format	Optional	character	12	Either*	**Part Print Message Name** - This field allows the system to automatically change the Part Print Message at a Machine from the default to whatever pre-defined Part Print Message Name the user selects. The Part Print Message must be pre-defined within Eclipse.	*When the Bundle Number is a non-zero value, this field applies to the Bundle. When the Bundle Number is zero, this field applies to the entire Order.	
15	Customer Name	Optional	character	30	Order	**Customer Name** - Customer Name where the finished parts will be shipped.		

Position	Field ID	Required	Data Type	Maximum Field Size	Data Pertains to:	Description	Notes	Options
16	Customer Address Line 1	Optional	character	254	Order	**Customer Street or "Shipping" Address - First Line** - The first line for the customer's street or shipping address.		
17	Customer Address Line 2	Optional	character	254	Order	**Customer Street or "Shipping" Address - Second Line** - The Second line for the customer's street or shipping address.		
18	Customer City	Optional	character	254	Order	**Customer City** - City where the Customer is located.		
19	Customer State	Optional	character	2	Order	**Customer State** - State where the Customer is located.		
20	Customer Zip	Optional	character	10	Order	**Customer Zip Code** - Customer postal code.		
21	Customer Country	Optional	character	3	Order	**Customer Country** - Country code where the Customer is located.		
22	Customer Instructions	Optional	character	254	Order	**Customer Shipping Instructions** - Typically, these would be standard instructions for shipping to this particular customer. If there are special instructions for shipping a specific Order, those should be handled in a different field in a different table (ie - a user field in the Bundle Table).		
23	Staging Bay	Optional	character	10	Order	**Staging Bay** - The bay where finished parts should be staged.		
24	Loading Dock	Optional	character	10	Order	**Loading Dock** - The specific Loading Dock where the finished parts should be loaded onto a shipping vessel.		
25	Work Order	Optional	character	18	Order	**Work Order** - The **Work Order** number associated with this batch of production.		
26	Truck Number	Optional	character	12	Order	**Truck Number** - The Truck Number on which the finished Order should be loaded.		
27	Required Date	Optional	date or character	8	Order	**Required Date** - The date the Order must be completed.		
28	Pcodegrp	Optional	character	15	Order	**Product Code Group** - The Product Group to which this Product is assigned.		
29	Hold	Optional	Logical	1*	Order	**Hold** - If this field is True, then the Order will be imported to Eclipse with a status of Hold. No other functions within the system will allow the Order to go down to the Machine controller until a Scheduler releases the Order (Schedule Orders\Release).	*This field may only contain: T or F	**T = Order is imported with status of Hold** **F = Order is not held on import**
30	Blank	Unsupported	numeric	0		Place-holder to provide compatibility with SQL specification.		
31	Blank	Unsupported	numeric	0		Place-holder to provide compatibility with SQL specification.		

Position	Field ID	Required	Data Type	Maximum Field Size	Data Pertains to:	Description	Notes	Options
32	Required Time	Optional	character	8	Order			
33	Customer Phone	Optional	character	20	Order			
34	Purchase Order	Optional	character	30	Order			
35	Sales Order	Optional	character	30	Order			
36	Ship Date	Optional	datetime	20	Order			
37	Customer Number	Optional	character	30	Order			

PART DATA

Part Data Import File Structure - Punch patterns and ink jet printing locations can be imported using this specification. Ink jet printers are treated as if they were punch presses in terms of Tool Definitions and References.

Fields in this specification appear top-to-bottom. In the comma delimited text file, the fields must appear left-to-right. Character fields must be surrounded by quotation marks - "sample data" - numeric and logical fields should not use quotation marks. Each field must be separated with a comma. Optional fields that are not used should be left empty, except for character fields, which must still use open and closed quotation marks.

By default, Eclipse only accepts lengths in decimal inch. If using Metric, the first line of every Part Data Import File must be **UNITS=.39370078**. Eclipse will then process lengths in Metric millimeter.

Example - 2 parts imported within the same file, Part 1234 punches holes with Tool 1 at 12" from leading edge and evenly spaces punches every 24", Part 5678 receives a single punch from Tool 4 in the center of the part.
"Part 1234",,"",1,0,12.000,T,"",,
"Part 1234",,"",1,4,24.000,T,"",,
"Part 1234",,"",1,5,10.000,T,"",,
"Part 5678",,"",4,2,0.000,F,"",,

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Order data will be saved in a text file with a .PRT extension.

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Part Number	Required	character	30	**Part Number** - Defines the specific Part Number that will be referenced any time this particular punch pattern is desired on a finished part. Typically, Part Numbers only specify punch locations. In some cases, Part Length will also be defined within the Part Definition. If the Part Definition includes length, null the "Length" field in the Order data import database.		
2	Length	Optional*	decimal(10,3)	10,3**	**Part Length** - Finished Part Length. This field should only be used when the punch pattern for a given part is specfic to a particular length. If the length and punch pattern are not directly related, null this field, and use the "Length" field in the Order data import database.	*The "Length" field is required if Part Length is not included in the Order Data Import File **Lengths must be in decimal inch	
3	Part Option	Deprecated	null	0	**Part Option** - The Part Option field in the Order Data Import Database always supercedes the value in the Part data transfer. The field has been deprecated in this specification, and should be nulled.		
4	Tool Number	Required*	numeric	3	**Tool Number** - Defines the specific Tool Number to be used on the Machine to achieve the punch target(s). The Machine controller that will make the finished part must have a Tool Number corresponding to a physical tool defined in its Tool Data menu.	*If entering a Macro reference, this field should be nulled	
5	Reference	Required	numeric	1*	**Reference** - Defines the feature on the part from which the punch location will be referenced in the X direction. Reference options include: Leading Edge, Training Edge, Leading Center, Trailing Center, Even Spacing, Spacing Limit and Kerf Adjust.	*This field may only contain: 0, 1, 2, 3, 4, 5, or 8	**0 = Leading Edge** **1 = Trailing Edge** **2 = Leading Center** **3 = Trailing Center** **4 = Even Space** **5 = Spacing Limit** **8 = Kerf Adjust**

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
6	X-Offset	Required	decimal	10,3*	**X-Offset** - Defines the distance from the reference point where the tooling must strike the Material to achieve the correct target location in the X-axis.	*Lengths must be in decimal inch	
7	Permanent	Required	logical	1*	**Permanent** - Defines whether Eclipse should keep the part in the Parts Definition database permenently, or if it should be automatically deleted when there is no longer an Order in the system that calls for that Part Definition.	*This field may only contain: T or F	**T = True** **F = False**
8	Macro Name	Optional	character	30	**Macro Name** - Specifies a reference to a pre-defined macro definition within Eclipse. Macros cannot be imported into Eclipse, but must be entered manually into the Parts\Part Definition form.		
9	Y-Offset	Optional*	decimal	8,3**	**Y-Offset** - Defines the distance from the **Y-Reference** point where the tooling must move to achieve the correct target location in the Y-axis.	*This field is required if importing Part Definitions that include Y-axis punch targets **Lengths must be in decimal inch	
10	Y-Reference	Optional*	numeric	1**	**Y-Reference** - Defines the feature on the part or Machine from which the punch location will be referenced in the Y direction. Reference options include: Center +, Center -, Edge +, Edge -, Macro +, and Macro -.	*This field is required if importing Part Definitions that include Y-axis punch targets **This field may only contain: 1, 2, 3, 4, 5, or 6	**1** = Center + 2 = Center - 3 = Edge + 4 = Edge - 5 = Macro + 6 = Macro -

PART DEF

Part Shape Data Import File Structure - Punch patterns and ink jet printing locations can be imported using this specification. Ink jet printers are treated as if they were punch presses in terms of Shape Definitions and References.

Fields in this specification appear top-to-bottom. In the comma delimited text file, the fields must appear left-to-right. Character fields must be surrounded by quotation marks - "sample data" - numeric and logical fields should not use quotation marks. Each field must be separated with a comma. Optional fields that are not used should be left empty, except for character fields, which must still use open and closed quotation marks.

By default, Eclipse only accepts lengths in decimal inch. If using Metric, the first line of every Part Shape Data Import File must be **UNITS=.39370078**. Eclipse will then process lengths in Metric millimeter.

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Type	Required	character	2*	**Type** - This field must always contain PD.	*This field must always be PD.	
2	Part Number	Required	character	30	**Part Number** - Defines the specific Part Number that will be referenced any time this particular punch pattern is desired on a finished part. Typically, Part Numbers only specify punch locations. In some cases, Part Length will also be defined within the Part Definition. If the Part Definition includes length, null the "Length" field in the Order data import database.		
3	Part Option	Deprecated	null	0	**Part Option** - The Part Option field in the Order Data Import Database always supercedes the value in the Part data transfer. The field has been deprecated in this specification, and should be nulled.		
4	Product Group	Required	character	20	**Product Group** - This field references the Profile definition found in Eclipse under Maintenance\Punch File Settings. This is the translation table between the shape names imported and the actual Tool ID numbers on the machine that will produce the part.		
5	Length	Optional*	decimal(10,3)	10,3**	**Part Length** - Finished Part Length. This field should only be used when the punch pattern for a given part is specfic to a particular length. If the length and punch pattern are not directly related, null this field, and use the "Length" field in the Order data import database.	*The "Length" field is required if Part Length is not included in the Order Data Import File **Lengths must be in decimal inch	
6	Shape or Macro Definition	Required	character	1*	**Shape or Macro Definition** - This field dictates whether the imported data references a Shape as defined in Maintenance\Punch File Settings or a Macro as defined in Parts\Part Definitions.	*This field must may only contain: S or M	**S = Shape** **M = Macro**
7	Shape Name or Macro Number	Required	character	30	**Shape Name or Macro Number** - This field contains the name of the shape or the macro number to be used.		
8	Diameter or Length	Required	numeric	8,3*	**Diameter or Length** - Defines the diameter or length of the shape to be produced on the finished part.	*Lengths must be in decimal inch	

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
9	Width	Required	numeric	8,3*	**Width** - Defines the width of the shape to be produced on the finished part.	*Lengths must be in decimal inch	
10	X-Offset	Required	decimal	10,3*	**X-Offset** - Defines the distance from the reference point where the tooling must strike the material to achieve the correct target location in the X-axis.	*Lengths must be in decimal inch	
11	X-Reference	Required	character	2*	**X-Reference** - Defines the feature on the part from which the punch location will be referenced in the X direction. Reference options include: Leading Edge, Training Edge, Leading Center, Trailing Center, Even Spacing, Spacing Limit and Kerf Adjust.	*This field may only contain: LE, TE, LC, TC, ES, SL, KA	**LE = Leading Edge** **TE = Trailing Edge** **LC = Leading Center** **TC = Trailing Center** **ES = Even Space** **SL = Spacing Limit** **KA = Kerf Adjust**
12	Y-Offset	Required	decimal	8,3*	**Y-Offset** - Defines the distance from the **Y-Reference** point where the tooling must move to achieve the correct target location in the Y-axis.	*Lengths must be in decimal inch	
13	Y-Reference	Required	character	2*	**Y-Reference** - Defines the feature on the part or Machine from which the punch location will be referenced in the Y direction. Reference options include: Center +, Center -, Edge +, Edge -, Macro +, and Macro -.	*This field may only contain: CP, CM, PE, ME, MP, or MM	**CP = Center +** **CM = Center -** **PE = Edge +** **ME = Edge -** **MP = Macro +** **MM = Macro -**

COIL DATA

Coil Data Import File Structure - Coil Inventory data is passed into Eclipse via this specification.

It is important to note, Eclipse can validate Coils - When a Machine operator loads a coil onto a Machine, the system can check to make sure the Coil's Material type matches the requirements for the Order to be produced. The user has a choice between pushing this data into a database for Eclipse to use, or using an existing SQL database within his own system.

When Coil validation occurs with an external database, the potential exists for some reporting structures to have inaccurate/missing data. Specifically, costing (reports showing the cost of an order based on raw Material consumption, as well as scrap costs) and footage used when there are processes that consume Material on Machines outside of the Eclipse network.

If Eclipse's reports aren't used, these issues don't matter. If accurate Eclipse reports are important to the user, then the Coil Database Structure in Eclipse should be maintained. Any Materials consumed by an external process should update the Eclipse Coil Database.

External Coil validation is covered at the end of this specification.

Example - 2 coils imported within the same file, Coil 1234 made of steel and Coil 5678 made of aluminum.
"A","Coil 1234","","01/01/01","","2500","","I","steel vendor","material code","steel","1.25","","","","1800","ABC123","SV","PO5678",""
"A","Coil 5678","","01/01/01","","3600","","I","steel vendor","material code 2","aluminum","0.80","","","","1100","DEF456","SV","PO5678",""

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Coil data will be saved in a text file with a .COI extension.

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Action Code	Required	character	1*	**Action Code** - Specifies what Eclipse is to do with the associated record fields, such as: 1.) adding a new Coil, 2.) making changes to an existing Order, 3.) deleting a Coil from Eclipse.	*This field may only contain: A, C, or D	**A = Add new Coil record** **C = Change information regarding an existing coil. Unchanged fields should remain empty.** **D = Delete the coil from Eclipse**
2	Coil Number	Required	character	16	**Inventory Coil Number** - Identifies a specific Coil within the inventory.		
3	Description	Optional	character	40	**Description** - Description of the Material type.		
4	Date In	Optional	character	10	**Date In** - The date the Coil was added to the inventory.		
5	Date Out	Optional	character	10	**Date Out** - The date the Coil was removed from inventory (completely consumed by production, or shipped to another location).		
6	Starting Length	Optional	character	8*	**Starting Length** - Beginning length of Coil.	*Length must be in feet	
7	Length Used	Optional	character	8*	**Length Used** - Any length already consumed.	*Length must be in feet	
8	Status	Optional	character	1*	**Status** - Defines whether the Coil has been completely consumed, or if it is incomplete.	*This field may only contain: I or C	**I = Incomplete** **C = Complete**
9	Vendor Name	Optional	character	30	**Vendor Name** - Name of Coil vendor.		

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
10	Material Code	Required	character	20*	**Material Code** - Defines the type of Material to be used to produce the final product. Material parameters used to generate specific codes are typcially: coil width, gauge, color, coating, galvinization, KSI, etc.	*XL100 Series controllers are limited to 18 characters	
11	Type	Optional	character	10	**Type of Coil** - Used to categorize the Coil within the user's own terminology.		
12	Cost Per Pound	Optional	character	7	**Cost Per Pound** - Defines the cost of the Coil Material per lb.		
13	Non-exempt Scrap	Optional	character	9	**Non-Exempt Scrap** - When importing Coil data where Coils might be consumed by other processes (any situation where a Coil could be used where Eclipse can't track the usage), this field is used to pass Scrap tracking information back into Eclipse from the outside processes. Non-Exempt Scrap is Scrap that detracts from the operator's performance (Scrap footage over which the Machine operator has control).		
14	Exempt Scrap	Optional*	character	9	**Exempt Scrap** - When importing Coil data where Coils might be consumed by other processes (any situation where a Coil could be used where Eclipse can't track the usage), this field is used to pass Scrap tracking information back into Eclipse from the outside processes. Exempt Scrap is tallied for total Scrap tracking, but does not count against the Machine operator's performance (raw Material scrap, or scrap due to Material handling).		
15	Other Adjustments	Optional	character	9	**Other Adjust** - This field allows users to reconcile Coil consumption from processes external to the Eclipse system.		
16	Weight	Optional	character	10*	**Weight** - The starting Weight of the coil in pounds.	*Weight must be in pounds	
17	Heat Number	Optional	character	20	**Heat Number** - Heat Number.		
18	Vendor Code	Optional	character	16	**Vendor Code** - Internal company code used to reference the Vendor Name.		
19	Purchase Order	Optional	character	10	**Purchase Order Number** - The Purchase Order Number used to buy this Coil.		
20	Storage Location	Optional	character	20	**Storage Location** - The physical location where this Coil is stored.		

MATERIAL DATA

Material Data Import File Structure - This data is added to a Material Definitions Table within Eclipse. Eclipse must at least have the Material Code before an Order can be processed.

Predicting Bundle weights before the Bundles have been produced requires information from this internal table. Several fields are primarily used for printing purposes, but can be displayed throughout the system for the schedulers' and Machine Operators' benefit.

Example - 2 Material Codes processed within same file, Material Code added to Eclipse, Material Code 6 deleted from Eclipse.
"A","Material Code",18,0.0478,9.000,"","Steel","","18 Ga Steel",0.96,1.06,,1000
"D","Material Code 6",,,,"","","","","",,,,

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Material data will be saved in a text file with a .MAT extension.

Postion	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Action Code	Required	character	1*	**Action Code** - Specifies what Eclipse is to do with the associated record fields, such as: 1.) adding a new Material definition, 2.) making changes to an existing Material definition (leave unchanged fields nulled), 3.) deleting a Material definition from the database.	*This field may only contain: A, C, or D	**A = Add new Material definition record** **C = Change Material definition record (leave unchanged fields as empty strings)** **D = Delete Material definition record**
2	Material Code	Required	character	20*	**Material Code** - Identifies a specific raw Material type based on the user's parameters - typically coil width, thickness, color, coating, etc.	*XL100 Series controllers are limited to 18 characters	
3	Gauge	Optional	numeric	2	**Material Gauge** - Standard Gauge value for Material type.		
4	Thickness	Optional	decimal(6,4)	6,4*	**Material Thickness** - The physical thickness of the Material in decimal inches.	*Thickness must be in decimal inch	
5	Width	Optional	decimal(6,4)	6,4*	**Material Width** - Starting width of Material in decimal inches. Coil width.	*Width must be in decimal inch	
6	Color	Optional	character	20	**Material Color** - Color of Material if using painted product.		
7	Type	Optional	character	10	**Material Type** - Type of Material.		
8	Cover	Deprecated	null	0	**Coverage Area** - Originally, this parameter defined the finished width of a panel. Since that parameter is now part of the Product Code field, this field has been deprecated.		

Postion	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
9	Material Description	Optional	character	40	**Material Description** - This is the "human readable" identification or Description of the Material Code.		
10	Pounds Per Foot	Optional	decimal(7,3)	7,3*	**Pounds Per Foot** - The weight of the Material in Pounds Per Foot. This value is used to calculate and pre-estimate the weight of bundles before they are produced. The Scheduler can see the estimate before sending Orders to the Machines.	*Weight must be in pounds	
11	Cost Per Pound	Optional	decimal(7,2)	7,2	**Cost Per Pound** - Defines the average cost of this Material type per pound. If cost information is not defined for a Coil, Eclipse will attempt to calculate raw Material costs based on the Material defintion, instead.		
12	Normlngth	Deprecated	null	0	**Normal Length** - Before full Coil support was in Eclipse, this value was used to import the "Normal Length of a Coil of this Material Type". This field is no longer necessary and has been deprecated.		
13	Reorder Point	Optional	numeric	6	**Reorder Point** - This is the amount of Material remaining on-hand that should prompt the Purchasing Agent should buy more of this Material type.		

PRODUCT DATA (PCODE)

Product Data Import File Structure - This data is added to a Product Definitions Table within Eclipse.

IMPORTANT NOTE
Throughout the Eclipse system, the word PRODUCT always references a particular finished part profile - ie. shape. The only parameter for Product is the finished part profile. In other words, the Product Code should only change between Orders when there is a difference in Machine tooling required to produce the new shape. In terms of the Eclipse system, a tooling difference always means Material must be cleared from the Machine before the new tooling can be put into place to make the new profile.

Product Codes must not carry parameters such as: raw Material type, length, or any punching information (unless the punching requires a physical tooling change on the Machine that requires the Material to be cleared from the Machine before the tooling can be mounted).

Typcially, this table is imported once, and then only used to alert Eclipse to changes regarding existing Product definitions, or when deleting or adding records.

Example - 1 Product Code processed for 2 Machines within the same file, Product Code added to Eclipse for Machine 1 requires 80 mins for tooling change, where the same product on Machine 2 requires 25 mins due to rafted tooling.
"A",1,"Product Code","Roll Formed Part",12.125,"","",,F,F,1.500,"",12,80,225
"A",2,"Product Code","Roll Formed Part",12.125,"","",,F,F,1.500,"",12,25,225

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Material data will be saved in a text file with a .PCD extension.

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Action Code	Required	character	1*	**Action Code** - Specifies what Eclipse is to do with the associated record fields, such as: 1.) adding a new Product definition, 2.) making changes to an existing Product definition (leave unchanged fields nulled), 3.) deleting a Product definition from the database.	*This field may only contain: A, C, or D	**A = Add new Product definition record** **C = Change Product definition record (leave unchanged fields as empty strings)** **D = Delete Product definition record**
2	Machine	Required	numeric	3	**Machine Number** - This is the Network Unit ID for the Machine that can produce this Product. For each Machine that is capable of running a given Product, there must be another definition for that Product Code in the Product Code Definitions table in Eclipse. Orders with a Product Code cannot be sent to a Machine unless there is a corresponding Product Code definition tying the Machine to the Product Code.		
3	Product Code	Required	character	20*	**Product Code** - Identifies the finished Product shape, or tooling required to produce a given Product shape.	*XL100 Series controllers are limited to 5 characters	
4	Description	Optional	character	30	**Product Description** - This is the "human readable" identification or Description of the Product Code.		
5	Finished Width	Optional	decimal(8,3)	8,3*	**Finished Width** - Defines the width of the finished Product after the forming process is complete.	*Width must be in decimal inch	
6	Staging Bay	Optional	character	10	**Staging Bay** - Defines the default Staging Bay for this Product. If the Staging Bay field in the Bundle Data Import structure is used, that value overrides this value for a specific Order.		

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
7	Loading Dock	Optional	character	10	**Loading Dock** - Defines the default Staging Bay for this Product. If the Staging Bay field in the Bundle Data Import structure is used, that value overrides this value for a specific Order.		
8	Hole Spacing	Optional*	decimal(8,3)	8,3**	**Hole Spacing** - Defines the physical distance between holes on pre-punched parts when counting holes for length control.	*This field is required when sending Order data to a XL200 Series controller when the length will not be sent in the Order Data structure **Length must be in decimal inch	
9	Calculate Length	Optional*	logical	1**	**Calculate Length** - In order for a XL200 Series controller to report production data back to Eclipse, part lengths must be present in the order data sent to the Machine. If the user will not import the length data in the Length fields from other Data Import structures, Eclipse must calculate the length based on the number of holes to count and the distance between each hole.	*This field is required when sending Order data to a XL200 Series controller when the length will not be sent in the Order Data structure **This field may only contain: T or F	**T** = Eclipse will calculate estimated part length based on number of holes multiplied by the Hole Spacing field
							F = Eclipse will not send length-based data to the XL200 series controller
10	Hole Count	Optional*	logical	1**	**Hole Count** - In some rare instances, the XL200 Series controller is only in control of the cutoff on a Machine that has upstream, in-line punching. In these cases, the XL200 is counting holes pre-punched by an off line system. Instead of programming based on length, this controller is programmed based on the number of holes picked up by a sensor. When Order data is to be programmed in this way, the Product Code must specify Hole Counting.	*This field is required when sending Order data to a XL200 Series controller with the Hole Count model option, when the machine is in the Hole Count mode **This field may only contain: T or F	**T = Part information will be sent in "number of holes to count" instead of length** **F = Part information will be sent in length instead of "number of holes to count"**
11	Leg Height	Optional	decimal(8,3)	8,3*	**Leg Height** - Defines the longest "leg" or vertical section of the finished Product shape.		
12	Product Code Group	Optional	character	20	**Product Code Group** - Allows the user to assign multiple Product Codes to a Product Group or "family of products".		
13	Coil Change Minutes	Optional*	decimal(6,3)	6,3	**Average Minutes Per Coil Change** - This is the average time required to complete a Coil change for this particular Product. This value is used when Eclipse estimates completion times.	*This field is required if the user is to rely on the estimated Order completion times in Eclipse. The more Coil changes per shift that take place, the farther the compleition times are skewed without this data.	

Position	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
14	Tooling Change Minutes	Optional*	decimal(6,3)	6,3	**Average Minutes Per Tooling Change** - This is the average time required to complete a Tooling change for this particular Product. This value is used when Eclipse estimates completion times.	*This field is required if the user is to rely on the estimated Order completion times in Eclipse. The more Coil changes per shift that take place, the farther the compleition times are skewed without this data.	
15	Feet Per Minute	Optional*	numeric	4**	**Maximum Line Speed in Feet Per Minute** - Defines the maximum line speed for this Product. This value is used when calculating OEE values in Eclipse. For more accurate OEE numbers relating to Machine speed, the user must interface with Eclipse to define maximum speed based on part length.	*This field is required if the user will rely on OEE reports from Eclipse **Line speed must be in feet per minute	

CUSTOMER DATA

Customer Data Import File Structure - This data is added to a Customer table within Eclipse that can be automatically recalled by associating the customer code to an Order in the Bundle Table.

This information is most often used to print Bundle Tickets for shipping purposes. It's also used in Eclipse production history reports as a filterable field, and can be displayed in other areas of the system (the machine controller, for instance) for whatever purpose the user desires.

If importing data from a ERP system, the most efficient way to handle passing Customer shipping information is to always pass the Customer fields in the Bundle Data Table.

Example - 2 Customer records processed within the same file, Customer 124 added and Customer 50 updated with new Delivery Instructions.
"A",124,"Bob's Buildings","12180 Prichard Farm Road","","Maryland Heights","MO","63043","US","Deliver to side door.",500,"+1 (314) 344-3144",""
"C",50,"","","","","","","","","Do not deliver to front!",,"",""

Copies of all import data can be saved to the Windows Temp directory if the option is selected in Eclipse\Maintenance\Settings\Import/Export. File names will begin with "D" followed by 7 digit numbers. Customer data will be saved in a text file with a .CUS extension.

Postion	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
1	Action Code	Required	character	1*	**Action Code** - Specifies what Eclipse is to do with the associated record fields, such as: 1.) adding a new Customer, 2.) making changes to an existing Customer (leave unchanged fields nulled), 3.) deleting a Customer from the database.	*This field may only contain: A, C, or D	**A = Add new Customer record C = Change Customer record (leave unchanged fields as empty strings) D = Delete Customer record**
2	Customer Code	Required	character	11	**Customer Code** - Identifies a customer by internally generated and maintained code system.		
3	Customer Name	Required	character	30	**Customer Name** - Company name of customer.		
4	Customer Address Line 1	Optional	character	30	**Customer Street or "Shipping" Address - First Line** - The first line for the customer's street or shipping address.		
5	Customer Address Line 2	Optional	character	30	**Customer Street or "Shipping" Address - Second Line** - The Second line for the customer's street or shipping address.		
6	Customer City	Optional	character	30	**Customer City** - City where the Customer is located.		
7	Customer State	Optional	character	2	**Customer State** - State where the Customer is located.		
8	Customer Zip	Optional	character	10	**Customer Zip Code** - Customer postal code.		
9	Customer Country	Optional	character	3	**Customer Country** - Country code where the Customer is located.		
10	Customer Instructions	Optional	character	30	**Customer Shipping Instructions** - Typically, these would be standard instructions for shipping to this particular customer. If there are special instructions for shipping a specific Order, those should be handled in a different field in a different table (ie - a user field in the Bundle Table).		
11	Max Bundle Weight	Optional	numeric	4*	**Maximum Bundle Weight** - Defines maximum weight per bundle the Customer can handle from a truck (due to crane or fork lift restrictions).	*Weight must be in pounds	
12	Delivery Phone	Optional	character	30	**Delivery Phone Number** - The contact phone number at the point of delivery.		

Postion	Field ID	Required	Data Type	Maximum Field Size	Description	Notes	Options
13	E-mail Address	Optional	character	100	**E-mail Address** - The contact e-mail address at the point of delivery.		

PRODUCTION EXPORT

Production Data Export File Structure - All Production data from the Machine(s) is pulled into Eclipse, and is available for export to an upstream system. The Production data from Eclipse is exactly the same data and format that comes from the Machine(s), as it comes from the Machine(s). Production data is reported to Eclipse in a "stream of concsiousness" fashion, that is, each event updates Eclipse with all current Order status at the same time the event that triggered the Production Record is reported. For instance, if the Machine Operator halts the line, a Production Record is created to report "Machine Operator halted the line". At the same time, had the operator recently run 5 pieces of a 50 piece Bundle, the report would also include that 5 pieces were completed on the current Bundle. Eclipse tracks all of this and uses this information for completions.

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
Type	character	1*	**Production Record Type** - Defines the Type of Production record reported.	*This field will only contain: 1, 2, 3, 4, 5, 6, 7, 8, C, S, E, or G	1 = General Production record 2 = Production record related to coil change 3 = Machine Operator placed XL Series controller into Run mode 4 = Machine Operator powered up XL Series controller 5 = Order requested by Machine Operator from XL Series controller 6 = XL Series controller reports an on-screen message (warning, error, notification) 7 = Machine Operator reported a Downtime code 8 = Custom List request or Query List feedback from Machine Operator C = Query List was triggered at XL Series controller S = Start of Shift E = End of Shift G = General feedback record
Reason	character	3*	**Production Record Type Reason** - Defines the Reason for the original Record Type. Each Reason Code is defined by its parent Record Type.	*For Record Type 1 this field will only contain: B, C, E, H, I, M, O, P, R, T, X, Y, or Z	**B** = Machine halted automatically due to a Bundle number change. The XL Series controller must be in Bundle Halt Mode.
					C = Coil Tailout sensor detects passage of end of Coil. Machine is automatically halted and End of Coil Scrap Code is reported for any remaining Material, unless Machine Operator running a Scrap Bundle with 900+ Bundle Number, in which case that Scrap reason is reported for remaining material
					E = Machine was automatically halted because the programmed Coil Endpoint was reached. Machine Operator was prompted to cut the Coil at the pre-determined point prior to the entry to the roll former
					H = Machine Operator halted the Machine manually
					I = XL Series controller reports Bundle completion, but Machine controller was not configured for Bundle Halt Mode, so Machine continues producing by immediately and automatically changing to next Bundle

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
					M = XL Series controller reports Manual Shear by Machine Operator
					O = XL Series controller halts Machine automatically due to Out-of-Orders. There were no more Orders to run that could be queued (Material Code or Product Code change, or simply no more Orders in memory)
					P = Machine Operator removed power from the XL Series controller
					R = Machine Operator employed Remake function on Machine controller to replace Scrap parts
					T = XL Series controller automatically halted Machine due to Out of Tolerance part
					X = Machine Operator employed Decrease Quantity function to alert the system that a part previously counted as Scrap is actually Good Footage
					Y = Machine Operator employed Increase Quantity on Machine controller to replace scrap parts
					Z = Machine coast-to-stop. This code will always accompany a 1C record for a Tailout situation
				*For Record Type 2 this field will only contain: D, L or R	**D** = Machine Operator reported Coil was completely consumed
					L = Machine Operator reported new Coil loaded
					R = Machine Operator reported remaining Coil was returned to inventory
				*For Record Type 8 this field will only contain: C or Q	**C** = Custom List feedback from Machine Operator
					Q = Quality Audit feedback from Machine Operator
				*For Record Type E and S this field will only contain: H or R	**H** = Runtime record
					R = Downtime record
				*For Record Type G this field will only contain: C, D, I, M, R, S, U, or X	**C** = Coil inventory update
					D = Order is Done
					I = Order added to Eclipse via import
					M = Order sent to XL Series controller
					R = Order returned to ERP system
					S = Order started at machine
					U = Order Recalled from controller to Eclipse
					X = Order deleted from Eclipse via import

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
Date	datetime	8	**Date** - The date the Production record was created at the XL Series controller.		
Time	character	8*	**Time** - The time the Production record was created at the XL Series controller.	*Time format is HH:MM:SS in 24 hour format	
Minutes	decimal(11,2)	11,2	**Minutes** - Date and time converted to minutes since January 1, 1980.		
Production Date	datetime	8	**Production Date** - The Shift date. If a shift crosses midnight, this date indicates the shift started the day before.		
Shift	numeric	1*	**Shift Number** - First, second or third shift.	*This field will only contain: 1, 2, or 3	1 = First shift 2 = Second shift 3 = Third shift
Machine	numeric	3	**Machine Number** - Same as the Network Unit ID for each XL Series controller. Each XL Series controller must have its own unique Network Unit ID.		
Order_	character	20	**Order Number** - Order Number ran at the Machine. This number will reflect Orders sent from Eclipse or entered by hand by the Machine Operator.		
Material	character	20	**Material Code** - Defines the type of Material to be used to produce the final product. This number will reflect Orders sent from Eclipse or entered by hand by the Machine Operator.		
Pcode	character	20	**Product Code** - Defines a set of tooling required to create a particular part shape. This number will reflect Orders sent from Eclipse or entered by hand by the Machine Operator.		
Custname	character	30	**Customer Name** - The Customer Name as imported or entered into Eclipse associated with the current Order Number.		
Workorder	character	18	**Work Order** - The Work Order number as imported or entered into Eclipse.		
Ordertype	character	1**	**Order Type** - Indicates whether cutlist items for this order were defined in terms of finished part lengths, or in terms of hole count.	*This field is optional, unless the user must transmit orders to machines that use XL Series controllers with the Hole Count software option, in which case it is required	
				**This field will only contain: H or empty string	H = hole count programming empty string = standard length programming
Bundle	numeric	3*	**Bundle Number** - Identifies a set of lengths and quantities that should be packaged together. Multiple lengths may have the same Bundle Number. This number will reflect the Orders sent from Eclipse or entered by hand by the Machine Operator.	*Bundle 0 always indicates Normal Production Scrap and bundle 900+ indicates Scrap, where the last two digits reference a Scrap Code	
Qty	numeric	4	**Quantity** - Number of parts to produced since the last Production record.		
Length	decimal(10,3)	10,3*	**Part Length** - Finished **Part Length**. This is the length actually produced, regardless of whether the Order was sent from Eclipse or entered by hand by the Machine Operator.	*Lengths will be in decimal inch	
Option_	character	1*	**Part Option** - Indicates the Part Option used for producing punched parts at the Machine.	*This field will only contain: R, L, A, M, or H	**R = Right-handed** **L = Left-handed** **A = Alternating** **M = Mirrored** **H = Hole Count**

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
Part_num	character	30	**Part Number** - The Part Number currently being produced at the time this Production record was created.		
Pattern	numeric	3	**Pattern Number** - Pattern Number used at controller for punched part.		
Totlength	decimal(14,3)	14,3*	**Total Length** - The total length in inches for all items produced or reclaimed in this Production record. This field will never include scrap.	*Lengths will be in decimal inch	
Footage	decimal(14,3)	14,3*	**Footage** - The total length in inches for all good, reclaimed, and/or scrap footage in this Production record.	*Lengths will be in decimal inch	
Offset	decimal(8,3)	8,3**	**Offset** - Defines the distance (from the leading edge of a hole picked up by a photo-eye) where the Machine controller will fire the cutoff when operating in Hole Count mode.	*This field is required when using the "Holecount" field **Lengths will be in decimal inch	
Holecount	numeric	4	**Hole Count** - If the XL series controller is in Hole Count mode, this field reports the current programmed Hole Count value for the Machine Controller.	*This field is required by customers who use XL Series Machine controllers with the "H" designator in the software model number	
Invcoil	character	16	**Coil Number** - The inventory Coil Number currently loaded on the Machine for this Production record.		
Coilmatl	character	20*	**Coil Material Code** - The Material Code defined for the currently loaded Coil.		
Matlwidth	decimal(6,3)	6,3*	**Material Width** - The Material Width of the currently loaded Coil as defined under the Maintenance\Material Code Definitions table.		
Lb_ft	decimal(7,3)	7,3*	**Pounds Per Foot** - The weight per length unit for the currently loaded coil if the data is available, or the average weight per length unit for the current material type if the data is available in the Material Definitions table.		
Cost_lb	decimal(7,2)	7,2	**Cost Per Pound** - The cost per weight unit for the currently loaded coil if the data is available, or the average cost per weight unit for the current material type if the data is available in the Material Definitions table.		
Heatnbr	character	20	**Heat Number** - Heat Number of Coil currently loaded on the Machine as entered or imported to Eclipse.		
Code_type	character	1*	**Code Type** - Details the type of code (Downtime, Query, or Scrap) reported for this Production record.	*This field will only contain: D, Q, or S	**D = Downtime Code** **Q = Query** **S = Scrap Code**
Code_val	numeric	3	**Code Value** - The numeric value for the Downtime, Query, or Scrap Code selected by the Machine Operator.		
Code_desc	character	30	**Code Description** - A textual description of the Downtime, Query, or Scrap Code reported by the Machine Operator.		
Code_exmpt	character	1*	**Code Exempt** - Indicates of the Downtime Code or Scrap Code is exempt.	*This field will only contain: E, N, or empty string	**E = Exempt** **N = Not Exempt** **empty string = No code reported for this record**
Machstatus	character	1*	**Machine Status** - The Run mode status of the machine at the time the record was reported.	*This field will only contain: H or R	**H = Halted** **R = Running**
Duration	decimal(8,2)	8,2*	**Duration** - Time elapsed since last Duration reported.	*Times will be in minutes	
Runtime	decimal(8,2)	8,2*	**Run Time** - The amount of time the Machine has been in run for this Production record.	*Times will be in minutes	
Downtime	decimal(8,2)	8,2*	**Down Time** - The amount of time the Machine has been down for this Production record.	*Times will be in minutes	
Exemptime	decimal(8,2)	8,2*	**Exempt Time** - The amount of down time that was exempt for this Production record.	*Times will be in minutes	

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
Good	decimal(14,3)	14,3*	**Good Length** - The amount of Good length reported in this Production record - does not include reclaimed length.	*Lengths will be in decimal inch	
Scrap	decimal(14,3)	14,3*	**Scrap Length** - The amount of Scrap length reported in this Production record.	*Lengths will be in decimal inch	
Exmptscrap	decimal(14,3)	14,3*	**Exempt Scrap Length** - The amount of exempt scrap length reported in this Production record.	*Lengths will be in decimal inch	
Reclaimed	decimal(14,3)	14,3*	**Reclaimed Length** - The amount of Reclaimed length reported in this Production record.	*Lengths will be in decimal inch	
Actspeed	decimal(8,3)	8,3*	**Actual Speed** - The current Line Speed of the Machine at the time this Production record was reported. This is not a throughput value, but true Machine speed.	*Speeds will be in feet per minute	
Targspeed	decimal(8,3)	8,3*	**Target Speed** - The target Line Speed of the Machine as defined in Machine Definitions, superceded by Target FPM as defined in Base Efficiency Values, superceded by Target FPM as defined in Product Code Definitions\Length Related Data.	*Speeds will be in feet per minute	
Employ_id	numeric	7	**Employee ID** - Employee number used to idenify the Machine Operator or employee currently responsible for the Machine. If no Employee ID is entered at the Machine, a default of "0" is used.		
Name	character	30	**Employee Name** - Employee Name used to identify the Machine Operator or employee currently responsible for the Machine. If no Employee Name is entered at the Machine, a default of "0" is used.		
Item_id	character	22	**Item ID** - This is a unique identifier per Order cutlist item. It allows tracking of specific cutlist item data throughout the system.		
Listid	numeric	10	**Custom List ID** - Custom List ID interface reported for this Production record.		
Listtext	character	40	**List Text** - The specific text presented to the Machine Operator at time of List generation.		
Plant Name	character	30	**Plant Name** - The name of plant from which this production record is being reported as entered under Maintenance\Settings\General\Reports\Company/Plant Name.		
Listvalid	character	100	**List Value ID** - The value reported by the Machine Operator in response to the List Text.		
Code_resp	numeric	1*	**Code Responsibility** - General area of responsibility for code.	*This field will only contain: 0, 1, 2, or 3	0 = Not Specified 1 = Operational 2 = Equipment 3 = External
Bundle Code	character	15	**Bundle Code** - Some companies have an internal system for handling and packaging of bundles. This code can be passed down from the ERP system for printing on bundle ticket labels.		
Toolchg	numeric	1*	**Tool Change** - Details whether a Tool Change occurred to produce the current Order.	*This field will only contain: 0 or 1	0 - No Tool Change occurred 1 - Tool Change occurred
Matlchg	numeric	1*	**Material Change** - Details whether a Material Change occurred to produce the current Order.	*This field will only contain: 0 or 1	0 - No Material Change occurred 1 - Material Change occurred
Coilchg	numeric	1*	**Coil Change** - Details whether a Coil Change occurred to produce the current Order.	*This field will only contain: 0 or 1	0 - No Coil Change occurred 1 - Coil Change occurred
Matldev	numeric	1*	**Material Deviation** - The Material Code for the currently loaded Coil does not match the Material Code specified by the current Order.	*This field will only contain: 0 or 1	0 - No Material Deviation occurred 1 - Material Deviation occurred

Field ID	Data Type	Maximum Field Size	Description	Notes	Options
SKU	character	50	**Stock-keeping Unit** - This field provides greater integration with ERP systems that support SKU numbers. There is no processing performed on this field, except to pass it back to the ERP when reporting Order completions.		
Scrapqty	numeric	5	**Scrap Quantity** - When a Machine Operator uses Remake or Increase Quantity to replace scrapped parts, this field will indicate the number of good parts that were produced to replace scrapped parts.		
Exptmatlen	decimal(14,6)	14,6*	**Expected Material Length** - The total length of raw material consumed to create the finished part. For tile machines and spiral duct work machines, this field can be compared to the length field to determine the difference between material consumed for a finished part and finished part length.	*Lengths will be in decimal inch	
Shearkerf	decimal(14,6)	14,6*	**Shear Kerf** - The length of material scrapped during the shearing process.	*Lengths will be in decimal inch	
Bundleid	character	15	**Bundle ID** - Many ERP systems generate unique identifiers for each cutlist item, or bundle of cutlist items, within an order. Optionally, the XL/Eclipse system can generate a unique identifier.		