

## 1. 客製化報表建立

LINKi 除了提供標準輸出模板(稼動率)(如下圖示)外，亦可自行定義輸出模板資料，方便客戶能快速建構客製化報表

This Month's State of Operation	
Equipment Name:	NCGuide
Collection Period:	2018/07/02~2018/07/31
Processing Time:	09:00~17:00

Table1. This Month's Status Occurrence Time		Unit [H]				
Index	1Month	1stWeek	2ndWeek	3rdWeek	4thWeek	5thWeek
OPERATE Time	122.6	30.0	22.2	36.1	34.3	0.0
MANUAL Time	8.3	2.5	0.8	2.5	2.5	0.0
STOP Time	6.1	2.5	2.5	0.6	0.6	0.0
ALARM Time	12.9	2.0	9.8	0.6	0.6	0.0
EMERGENCY Time	6.4	1.9	3.9	0.3	0.3	0.0
SUSPEND Time	0.8	0.6	0.3	0.0	0.0	0.0
DISCONNECT Time	42.8	0.5	0.5	0.0	1.8	40.0

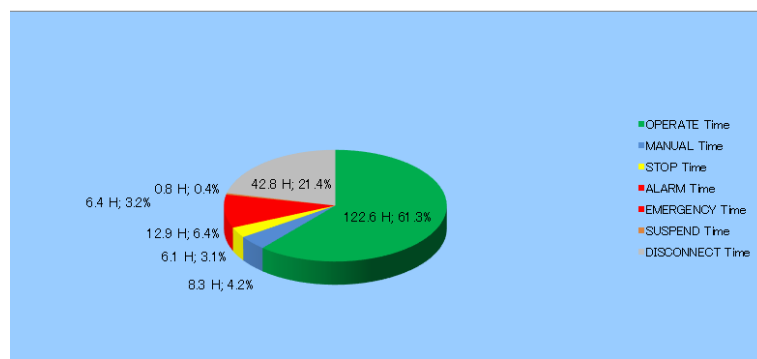


Fig1. This Month's Status Occurrence Time and

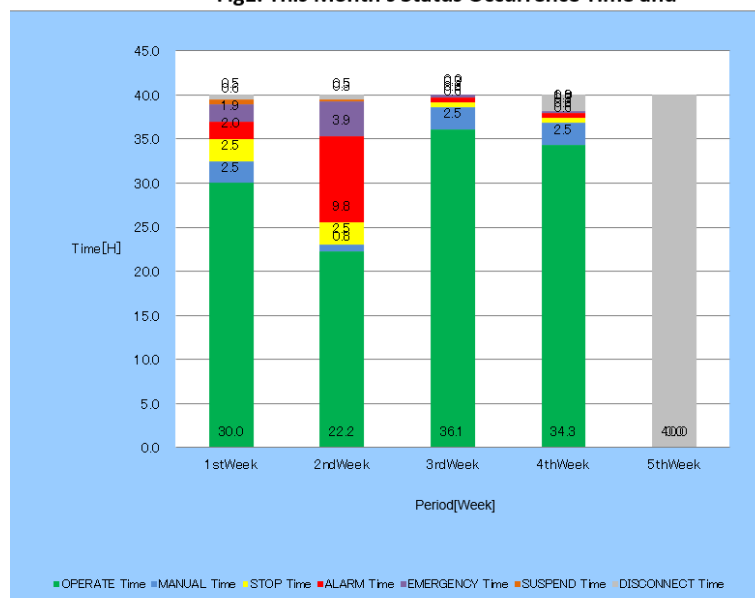



Fig1.2 Weekly Status Occurrence

			名稱	MT-LINK i 客製化報表模板		
	2023-10-17	施力誠	圖番			
	年 月 日	擔 當	台灣發那科			頁數 1/12

## 1.1 模板放置位置

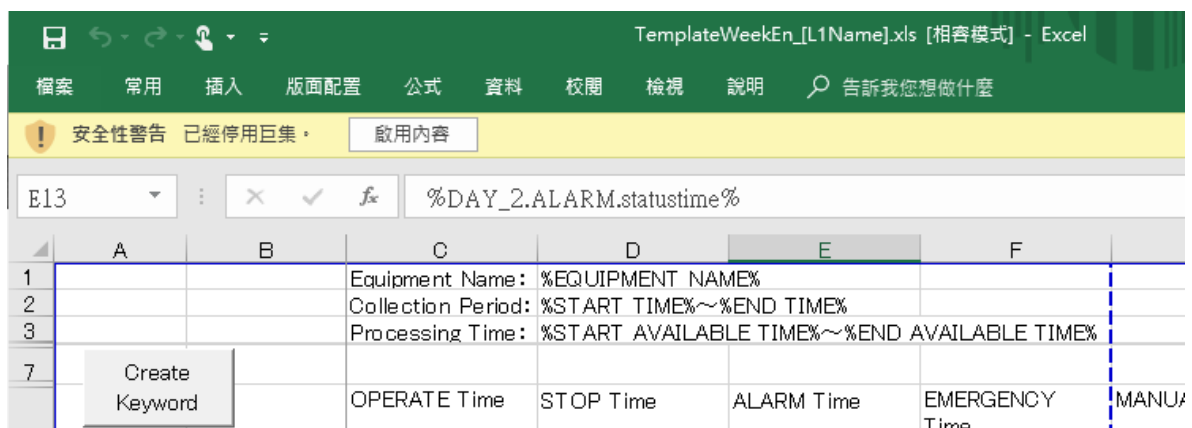
位置	模板檔案名稱
使用中的模板位置  C:\FANUC\MT-LINK\Template\Report\Master (預設安裝位置)	TemplateDayJp(對應語言 Jp/En/Cn).xls TemplateDayJp(對應語言 Jp/En/Cn)_[L1Name].xls TemplateWeekJp(對應語言 Jp/En/Cn).xls TemplateWeekJp(對應語言 Jp/En/Cn)_[L1Name].xls TemplateMonthJp(對應語言 Jp/En/Cn).xls TemplateMonthJp(對應語言 Jp/En/Cn)_[L1Name].xls
範例模板的位置  C:\FANUC\MT-LINK\Template\Report\Sample	TemplateDayJp(對應語言 Jp/En/Cn).xls TemplateDayJp(對應語言 Jp/En/Cn)_[L1Name].xls TemplateWeekJp(對應語言 Jp/En/Cn).xls TemplateWeekJp(對應語言 Jp/En/Cn)_[L1Name].xls TemplateMonthJp(對應語言 Jp/En/Cn).xls TemplateMonthJp(對應語言 Jp/En/Cn)_[L1Name].xls
輸出檔案的位置(預設) C:\FANUC\MT-LINK\Report	可在 System Setting→Setting 1 設定輸出位置 

- ◆ 要使用的模板名稱改為以下範例，並放置到”使用中”模板位置(C:\FANUC\MT-LINK\Template\Report)

TemplateDayJp(對應語言 Jp/En/Cn)\_機械名稱.xls (日輸出檔案)  
 TemplateWeekJp(對應語言 Jp/En/Cn)\_機械名稱.xls (周輸出檔案)  
 TemplateMonthJp(對應語言 Jp/En/Cn)\_機械名稱.xls (月輸出檔案)

## 1.2 開啟模板，啟動巨集

因模板可自行編成關鍵字內文，故在開啟時，務必將”啟用內容”點選開啟



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1.3 了解模板組成

	A	B	C	D	E	F	G	H	I
1			Equipment Name: %EQUIPMENT_NAME%						
2			Collection Period: %START_TIME%~%END_TIME%						
3			Processing Time: %START_AVAILABLE_TIME%~%END_AVAILABLE_TIME%						
7	Create Keyword		OPERATE Time	STOP Time	ALARM Time	EMERGENCY Time	MANUAL Time	SUSPEND Time	DISCONNECT Time
9		Prefix / Suffix	OPERATE.statustime	STOP.statustime	ALARM.statustime	EMERGENCY.statustime	MANUAL.statustime	SUSPEND.statustime	DISCONNECT.statustime
10	Past 1 month	MONTH	%MONTH.OPERATE.statustime%	%MONTH.STOP.statustime%	%MONTH.ALARM.statustime%	%MONTH.EMERGENCY.statustime%	%MONTH.MANUAL.statustime%	%MONTH.SUSPEND.statustime%	%MONTH.DISCONNECT.statustime%
11	1Weeks	1WEEKS	%1WEEKS.OPERATE.statustime%	%1WEEKS.STOP.statustime%	%1WEEKS.ALARM.statustime%	%1WEEKS.EMERGENCY.statustime%	%1WEEKS.MANUAL.statustime%	%1WEEKS.SUSPEND.statustime%	%1WEEKS.DISCONNECT.statustime%
12	2Weeks	2WEEKS	%2WEEKS.OPERATE.statustime%	%2WEEKS.STOP.statustime%	%2WEEKS.ALARM.statustime%	%2WEEKS.EMERGENCY.statustime%	%2WEEKS.MANUAL.statustime%	%2WEEKS.SUSPEND.statustime%	%2WEEKS.DISCONNECT.statustime%
13	3Weeks	3WEEKS	%3WEEKS.OPERATE.statustime%	%3WEEKS.STOP.statustime%	%3WEEKS.ALARM.statustime%	%3WEEKS.EMERGENCY.statustime%	%3WEEKS.MANUAL.statustime%	%3WEEKS.SUSPEND.statustime%	%3WEEKS.DISCONNECT.statustime%
14	4Weeks	4WEEKS	%4WEEKS.OPERATE.statustime%	%4WEEKS.STOP.statustime%	%4WEEKS.ALARM.statustime%	%4WEEKS.EMERGENCY.statustime%	%4WEEKS.MANUAL.statustime%	%4WEEKS.SUSPEND.statustime%	%4WEEKS.DISCONNECT.statustime%
15	5Weeks	5WEEKS	%5WEEKS.OPERATE.statustime%	%5WEEKS.STOP.statustime%	%5WEEKS.ALARM.statustime%	%5WEEKS.EMERGENCY.statustime%	%5WEEKS.MANUAL.statustime%	%5WEEKS.SUSPEND.statustime%	%5WEEKS.DISCONNECT.statustime%
16	Monday	MON	%MON.OPERATE.statustime%	%MON.STOP.statustime%	%MON.ALARM.statustime%	%MON.EMERGENCY.statustime%	%MON.MANUAL.statustime%	%MON.SUSPEND.statustime%	%MON.DISCONNECT.statustime%
17	Tuesday	TUE	%TUE.OPERATE.statustime%	%TUE.STOP.statustime%	%TUE.ALARM.statustime%	%TUE.EMERGENCY.statustime%	%TUE.MANUAL.statustime%	%TUE.SUSPEND.statustime%	%TUE.DISCONNECT.statustime%
18	Wednesday	WED	%WED.OPERATE.statustime%	%WED.STOP.statustime%	%WED.ALARM.statustime%	%WED.EMERGENCY.statustime%	%WED.MANUAL.statustime%	%WED.SUSPEND.statustime%	%WED.DISCONNECT.statustime%
19	Thursday	THU	%THU.OPERATE.statustime%	%THU.STOP.statustime%	%THU.ALARM.statustime%	%THU.EMERGENCY.statustime%	%THU.MANUAL.statustime%	%THU.SUSPEND.statustime%	%THU.DISCONNECT.statustime%
20	Friday	FRI	%FRI.OPERATE.statustime%	%FRI.STOP.statustime%	%FRI.ALARM.statustime%	%FRI.EMERGENCY.statustime%	%FRI.MANUAL.statustime%	%FRI.SUSPEND.statustime%	%FRI.DISCONNECT.statustime%
21	Saturday	SAT	%SAT.OPERATE.statustime%	%SAT.STOP.statustime%	%SAT.ALARM.statustime%	%SAT.EMERGENCY.statustime%	%SAT.MANUAL.statustime%	%SAT.SUSPEND.statustime%	%SAT.DISCONNECT.statustime%
22	Sunday	SUN	%SUN.OPERATE.statustime%	%SUN.STOP.statustime%	%SUN.ALARM.statustime%	%SUN.EMERGENCY.statustime%	%SUN.MANUAL.statustime%	%SUN.SUSPEND.statustime%	%SUN.DISCONNECT.statustime%
23	0 TO 1 O'clock	HR_0TO1	%HR_0TO1.OPERATE.statustime%	%HR_0TO1.STOP.statustime%	%HR_0TO1.ALARM.statustime%	%HR_0TO1.EMERGENCY.statustime%	%HR_0TO1.MANUAL.statustime%	%HR_0TO1.SUSPEND.statustime%	%HR_0TO1.DISCONNECT.statustime%
24	1 TO 2 O'clock	HR_1TO2	%HR_1TO2.OPERATE.statustime%	%HR_1TO2.STOP.statustime%	%HR_1TO2.ALARM.statustime%	%HR_1TO2.EMERGENCY.statustime%	%HR_1TO2.MANUAL.statustime%	%HR_1TO2.SUSPEND.statustime%	%HR_1TO2.DISCONNECT.statustime%
25	2 TO 3 O'clock	HR_2TO3	%HR_2TO3.OPERATE.statustime%	%HR_2TO3.STOP.statustime%	%HR_2TO3.ALARM.statustime%	%HR_2TO3.EMERGENCY.statustime%	%HR_2TO3.MANUAL.statustime%	%HR_2TO3.SUSPEND.statustime%	%HR_2TO3.DISCONNECT.statustime%
26	3 TO 4 O'clock	HR_3TO4	%HR_3TO4.OPERATE.statustime%	%HR_3TO4.STOP.statustime%	%HR_3TO4.ALARM.statustime%	%HR_3TO4.EMERGENCY.statustime%	%HR_3TO4.MANUAL.statustime%	%HR_3TO4.SUSPEND.statustime%	%HR_3TO4.DISCONNECT.statustime%
27	4 TO 5 O'clock	HR_4TO5	%HR_4TO5.OPERATE.statustime%	%HR_4TO5.STOP.statustime%	%HR_4TO5.ALARM.statustime%	%HR_4TO5.EMERGENCY.statustime%	%HR_4TO5.MANUAL.statustime%	%HR_4TO5.SUSPEND.statustime%	%HR_4TO5.DISCONNECT.statustime%

第一區：定義要顯示的時間週期(例如：以輸出月報表為例，2WEEKS 代表第二周的各项總和  
MON 代表本月所有周一的各项總和)

定義輸出的時間大於報表周期，是不會顯示的，請參考以下列表

定義	內容	月報表	周報表	日報表
MONTH	整個月份的摘要	可		
[N]WEEKS	固定周的摘要	可	可	
HR_[N]TO[M]	固定小時的摘要	可	可	可
DAY_[N]	固定天的摘要	可	可	可
MON,TUE,WED THU,FRI,SAT,SUN	固定星期的摘要	可	可	可

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## 第二區：定義輸出訊號名稱與類型(suffixes)

訊號名稱定義：訊號名稱除以下標準列表外，自行定義的訊號名亦可作為輸出訊號名稱

CNC 訊號種類		SV 訊號種類	SP 訊號種類
SigOP	PowOnTime	ActF	ActS
SigSTL	RunTime	ActFdec	SpindleLoad
SigSPL	CutTime	AbsPos	SigENB
SigAL	SigCUT	RelPos	SpindleSpeed
EMG	SigSBK	McPos	SpindleTemp
MODE	SigDM00	ServoSpeed	SpindleLeakResistData
MainProgram	SigDM01	ServoTemp	SpindleTotalRevX
ActProgram	SigMDRN	ServoError	InFanXSpdlComPwSpeed
Sequence	SigINP	ServoLoad	InFan1SpdlComPwStatus
MainComment	Override	ServoCurrent	RadFanXSpdlComPwSpeed
ActComment	Alarm	ServoCurrentPer	RadFanXSpdlComPwStatus
ModalS	CncState	PulseCoderTemp	InFanXSpindleAmpSpeed
ModalF	CncWarning	ApcBatZero	InFanXSpindleAmpStatus
ModalT	CncBatLow	ApcBatLow	RadFanXSpindleAmpSpeed
ModalM	CncFanXSpeed	IndBatZero	RadFanXSpindleAmpStatus
ModalM2	CncFanXStatus	SpdBatZero	
ModalM3		SSpdBatZero	
PartsNum		ServoLeakResistData	
PartsNumAll		InFanXSrvAmpSpeed	
		InFan1SrvAmpStatus	
		RadFanXSrvAmpSpeed	
		RadFanXSrvAmpStatus	
		InFanXSrvComPwSpeed	
		InFan1SrvComPwStatus	
		RadFanXSrvComPwSpeed	
		RadFanXSrvComPwStatus	

Equipment Setting 畫面選單中，以下部分為自行定義的訊號名稱

Multiple assign status area				
No	PriorityView	Status	Signal Definition	Web Name
1	<input type="checkbox"/>	OPERATE	(! Disconnect_NCGuid...	OPERATE
2	<input type="checkbox"/>	DISCONNECT	Disconnect_NCGuide	DISCONNECT
3	<input checked="" type="checkbox"/>	ALARM	(! Disconnect_NCGuid...	ALARM
4	<input type="checkbox"/>	EMERGENCY	(! Disconnect_NCGuid...	EMERGENCY
5	<input type="checkbox"/>	SUSPEND	(! Disconnect_NCGuid...	SUSPEND
6	<input type="checkbox"/>	STOP	(! Disconnect_NCGuid...	STOP
7	<input type="checkbox"/>	MANUAL		MANUAL
8	<input type="checkbox"/>	WARMUP		WARMUP
9	<input type="checkbox"/>	WARNING	(! Disconnect_NCGuid...	WARNING

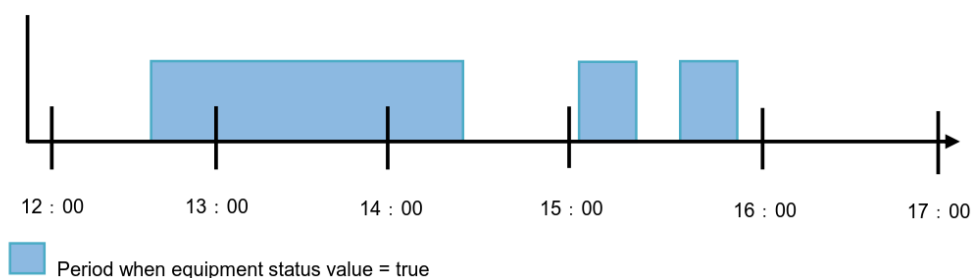
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## 訊號類型定義(suffixes)：

類型	內容	備註
[設備訊號名稱].statustime	顯示當[自定義名稱狀態]=[設備訊號名稱]時的區段時間	須為字串格式
[設備訊號名稱].time	顯示當[布林值狀態=True]時的時間	須為布林格式
[設備訊號名稱].count	顯示當[布林值狀態=True]時的次數	須為布林格式
[設備訊號名稱].countRise	顯示當[布林值狀態=True]時的變化次數	須為布林格式
[設備訊號名稱].errortime	顯示當[超出檢測=error]時的區段時間	
[設備訊號名稱].errorcount	顯示當[超出檢測=error]時的發生次數	
[設備訊號名稱].errorcountRise	顯示當[超出檢測=error]時的變化次數	
[設備訊號名稱].avg	顯示[整數型數值]時的平均數值	須為整數格式
[設備訊號名稱].max	顯示[整數型數值]時的最高數值	須為整數格式
[設備訊號名稱].min	顯示[整數型數值]時的最小數值	須為整數格式
.FULL_TIME	總結區段的總時間(秒數)	

其中，(error)count 計數方式須注意以下圖示

If the period when the signal = true are as shown below



Summary period	Obtained value (count) when using count as suffix
12:00 to 13:00	1
13:00 to 14:00	1
14:00 to 15:00	1
15:00 to 16:00	2
16:00 to 17:00	0
12:00 to 17:00	3

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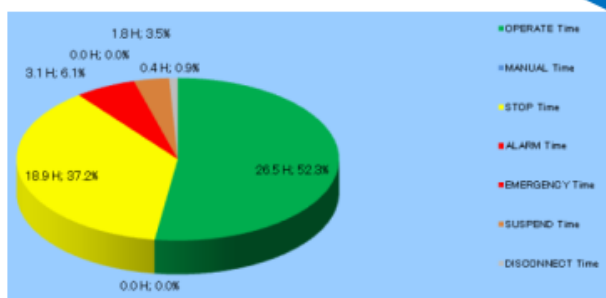
## 1.4 建立圖表

### 圓餅圖與直條比例圖(模板)

修改步驟：

1. 透過修改 C~I 欄位，自定義想要輸出的資料，類型為 **statustime** 或 **time** 或 **errortime**
2. 觸發 Create keyword 建立表格

TemplateDayEn_[L1Name].xls [相容模式] - Excel									
L14 %HR_2TO3.SpindleLoad_[Axis]_path[Path]_[MachineName].avg%									
	A	B	C	D	E	F	G	H	I
1			Equipment Name: %EQUIPMENT NAME%						
2			Collection Period: %START TIME%~%END TIME%						
3			Processing Time: %START AVAILABLE TIME%~%END AVAILABLE TIME%						
7		Create Keyword	OPERATE Time	STOP Time	ALARM Time	EMERGENCY Time	MANUAL Time	SUSPEND Time	DISCONNECT Time
9		Prefix / Suffix	OPERATE.statustime	STOP.statustime	ALARM.statustime	EMERGENCY.statustime	MANUAL.statustime	SUSPEND.statustime	DISCONNECT.statustime
10	Aggregate 1	DAY_1	%DAY_1.OPERATE.statustime%	%DAY_1.STOP.statustime%	%DAY_1.ALARM.statustime%	%DAY_1.EMERGENCY.statustime%	%DAY_1.MANUAL.statustime%	%DAY_1.SUSPEND.statustime%	%DAY_1.DISCONNECT.statustime%
11	0 TO 1	O'clk HR_0TO1	%HR_0TO1.OPERATE.statustime%	%HR_0TO1.STOP.statustime%	%HR_0TO1.ALARM.statustime%	%HR_0TO1.EMERGENCY.statustime%	%HR_0TO1.MANUAL.statustime%	%HR_0TO1.SUSPEND.statustime%	%HR_0TO1.DISCONNECT.statustime%
12	1 TO 2	O'clk HR_1TO2	%HR_1TO2.OPERATE.statustime%	%HR_1TO2.STOP.statustime%	%HR_1TO2.ALARM.statustime%	%HR_1TO2.EMERGENCY.statustime%	%HR_1TO2.MANUAL.statustime%	%HR_1TO2.SUSPEND.statustime%	%HR_1TO2.DISCONNECT.statustime%
13	2 TO 3	O'clk HR_2TO3	%HR_2TO3.OPERATE.statustime%	%HR_2TO3.STOP.statustime%	%HR_2TO3.ALARM.statustime%	%HR_2TO3.EMERGENCY.statustime%	%HR_2TO3.MANUAL.statustime%	%HR_2TO3.SUSPEND.statustime%	%HR_2TO3.DISCONNECT.statustime%
14	3 TO 4	O'clk HR_3TO4	%HR_3TO4.OPERATE.statustime%	%HR_3TO4.STOP.statustime%	%HR_3TO4.ALARM.statustime%	%HR_3TO4.EMERGENCY.statustime%	%HR_3TO4.MANUAL.statustime%	%HR_3TO4.SUSPEND.statustime%	%HR_3TO4.DISCONNECT.statustime%
15	4 TO 5	O'clk HR_4TO5	%HR_4TO5.OPERATE.statustime%	%HR_4TO5.STOP.statustime%	%HR_4TO5.ALARM.statustime%	%HR_4TO5.EMERGENCY.statustime%	%HR_4TO5.MANUAL.statustime%	%HR_4TO5.SUSPEND.statustime%	%HR_4TO5.DISCONNECT.statustime%



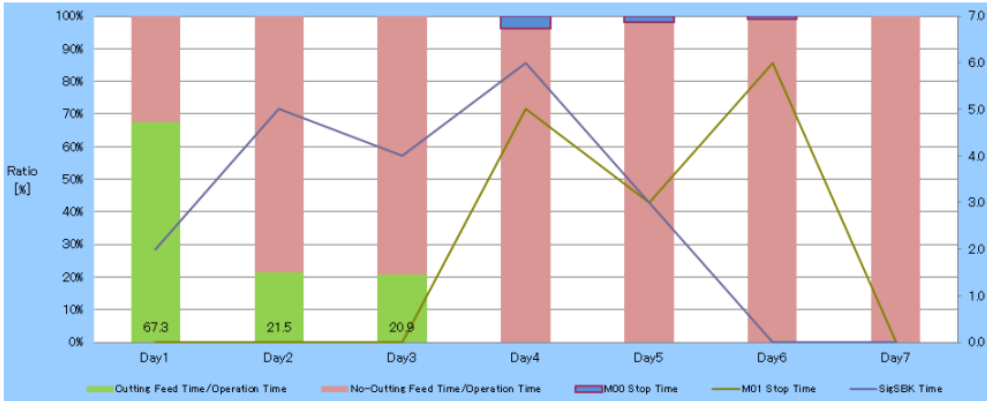
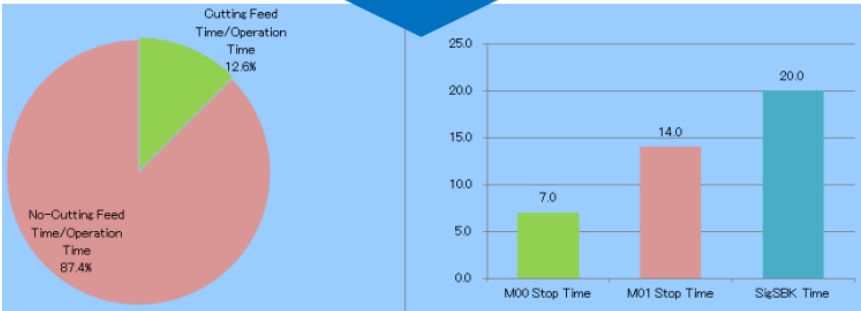
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圓餅圖/直條圖/直條比例圖(含平均線)(模板)

修改步驟：

- 1. 透過修改 J,K,O,P 欄位，自定義想要輸出的資料，類型為 statustime 或 time 或 errortime
- 2. 觸發 Create keyword 建立表格

	A	B	J	K	L	M	N	O	P
1									
2									
3									
7									
		Create Keyword	SigOUT Time	SigSBK Time	SpindleLoad (Average)	SpindleLoad (Max)	SpindleLoad (Min)	MOO Stop Time	M01 Stop Time
9		Prefix / Suffix	SigOUT_path[Path][MachineName].time	SigSBK_path[Path][MachineName].time	SpindleLoad_Axis_path[Path][MachineName].avg	SpindleLoad_Axis_path[Path][MachineName].max	SpindleLoad_Axis_path[Path][MachineName].min	SigDM00_path[Path][MachineName].time	SigDM01_path[Path][MachineName].time
10	Aggregate 1	DAY_1	%DAY_1_SigOUT_path[Path][MachineName].time%	%DAY_1_SigSBK_path[Path][MachineName].time%	%DAY_1_SpindleLoad_Axis_path[Path][MachineName].avg%	%DAY_1_SpindleLoad_Axis_path[Path][MachineName].max%	%DAY_1_SpindleLoad_Axis_path[Path][MachineName].min%	%DAY_1_SigDM00_path[Path][MachineName].time%	%DAY_1_SigDM01_path[Path][MachineName].time%
11	0 TO 1	O'clkHR_0TO1	%HR_0TO1_SigOUT_path[Path][MachineName].time%	%HR_0TO1_SigSBK_path[Path][MachineName].time%	%HR_0TO1_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_0TO1_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_0TO1_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_0TO1_SigDM00_path[Path][MachineName].time%	%HR_0TO1_SigDM01_path[Path][MachineName].time%
12	1 TO 2	O'clkHR_1TO2	%HR_1TO2_SigOUT_path[Path][MachineName].time%	%HR_1TO2_SigSBK_path[Path][MachineName].time%	%HR_1TO2_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_1TO2_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_1TO2_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_1TO2_SigDM00_path[Path][MachineName].time%	%HR_1TO2_SigDM01_path[Path][MachineName].time%
13	2 TO 3	O'clkHR_2TO3	%HR_2TO3_SigOUT_path[Path][MachineName].time%	%HR_2TO3_SigSBK_path[Path][MachineName].time%	%HR_2TO3_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_2TO3_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_2TO3_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_2TO3_SigDM00_path[Path][MachineName].time%	%HR_2TO3_SigDM01_path[Path][MachineName].time%
14	3 TO 4	O'clkHR_3TO4	%HR_3TO4_SigOUT_path[Path][MachineName].time%	%HR_3TO4_SigSBK_path[Path][MachineName].time%	%HR_3TO4_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_3TO4_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_3TO4_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_3TO4_SigDM00_path[Path][MachineName].time%	%HR_3TO4_SigDM01_path[Path][MachineName].time%
15	4 TO 5	O'clkHR_4TO5	%HR_4TO5_SigOUT_path[Path][MachineName].time%	%HR_4TO5_SigSBK_path[Path][MachineName].time%	%HR_4TO5_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_4TO5_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_4TO5_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_4TO5_SigDM00_path[Path][MachineName].time%	%HR_4TO5_SigDM01_path[Path][MachineName].time%
16	5 TO 6	O'clkHR_5TO6	%HR_5TO6_SigOUT_path[Path][MachineName].time%	%HR_5TO6_SigSBK_path[Path][MachineName].time%	%HR_5TO6_SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_5TO6_SpindleLoad_Axis_path[Path][MachineName].max%	%HR_5TO6_SpindleLoad_Axis_path[Path][MachineName].min%	%HR_5TO6_SigDM00_path[Path][MachineName].time%	%HR_5TO6_SigDM01_path[Path][MachineName].time%



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直條圖/走勢圖(模板)

修改步驟：

- 1. 透過修改 L~N 欄位，自定義想要輸出的資料
- 2. 觸發 Create keyword 建立表格

	A	B	J	K	L	M	N	O	P
1									
2									
3									
7	Create Keyword		SigOUT Time	SigSBK Time	SpindleLoad (Average)	SpindleLoad (Max)	SpindleLoad (Min)	M00 Stop Time	M01 Stop Time
9		Prefix / Suffix	SigOUT_path[Path][MachineName].time	SigSBK_path[Path][MachineName].time	SpindleLoad_Axis_path[Path][MachineName].avg	SpindleLoad_Axis_path[Path][MachineName].max	SpindleLoad_Axis_path[Path][MachineName].min	SigDM00_path[Path][MachineName].time	SigDM01_path[Path][MachineName].time
10	Aggregate 1	DAY_1	%DAY_1 SigOUT_path[Path][MachineName].time%	%DAY_1 SigSBK_path[Path][MachineName].time%	%DAY_1 SpindleLoad_Axis_path[Path][MachineName].avg%	%DAY_1 SpindleLoad_Axis_path[Path][MachineName].max%	%DAY_1 SpindleLoad_Axis_path[Path][MachineName].min%	%DAY_1 SigDM00_path[Path][MachineName].time%	%DAY_1 SigDM01_path[Path][MachineName].time%
11	0 TO 1 O'clk	HR_0TO1	%HR_0TO1 SigOUT_path[Path][MachineName].time%	%HR_0TO1 SigSBK_path[Path][MachineName].time%	%HR_0TO1 SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_0TO1 SpindleLoad_Axis_path[Path][MachineName].max%	%HR_0TO1 SpindleLoad_Axis_path[Path][MachineName].min%	%HR_0TO1 SigDM00_path[Path][MachineName].time%	%HR_0TO1 SigDM01_path[Path][MachineName].time%
12	1 TO 2 O'clk	HR_1TO2	%HR_1TO2 SigOUT_path[Path][MachineName].time%	%HR_1TO2 SigSBK_path[Path][MachineName].time%	%HR_1TO2 SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_1TO2 SpindleLoad_Axis_path[Path][MachineName].max%	%HR_1TO2 SpindleLoad_Axis_path[Path][MachineName].min%	%HR_1TO2 SigDM00_path[Path][MachineName].time%	%HR_1TO2 SigDM01_path[Path][MachineName].time%
13	2 TO 3 O'clk	HR_2TO3	%HR_2TO3 SigOUT_path[Path][MachineName].time%	%HR_2TO3 SigSBK_path[Path][MachineName].time%	%HR_2TO3 SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_2TO3 SpindleLoad_Axis_path[Path][MachineName].max%	%HR_2TO3 SpindleLoad_Axis_path[Path][MachineName].min%	%HR_2TO3 SigDM00_path[Path][MachineName].time%	%HR_2TO3 SigDM01_path[Path][MachineName].time%
14	3 TO 4 O'clk	HR_3TO4	%HR_3TO4 SigOUT_path[Path][MachineName].time%	%HR_3TO4 SigSBK_path[Path][MachineName].time%	%HR_3TO4 SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_3TO4 SpindleLoad_Axis_path[Path][MachineName].max%	%HR_3TO4 SpindleLoad_Axis_path[Path][MachineName].min%	%HR_3TO4 SigDM00_path[Path][MachineName].time%	%HR_3TO4 SigDM01_path[Path][MachineName].time%
15	4 TO 5 O'clk	HR_4TO5	%HR_4TO5 SigOUT_path[Path][MachineName].time%	%HR_4TO5 SigSBK_path[Path][MachineName].time%	%HR_4TO5 SpindleLoad_Axis_path[Path][MachineName].avg%	%HR_4TO5 SpindleLoad_Axis_path[Path][MachineName].max%	%HR_4TO5 SpindleLoad_Axis_path[Path][MachineName].min%	%HR_4TO5 SigDM00_path[Path][MachineName].time%	%HR_4TO5 SigDM01_path[Path][MachineName].time%
16									



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## 2. 如何匯出報表



選擇 Report Schedule Setting 選項

匯出報告形式分成以下兩種

自動匯出	手動匯出
The screenshot shows the 'Report Schedule Setting' dialog box. On the left is an 'Equipment list' with 'NewMachine001'. The 'Schedule Output' tab is selected. Under 'Report Type', 'Daily' is selected. 'Output schedule' is set to '18:00'. 'Output range' is set to 'Start time: 09:00' and 'Period: 08 : 00'. 'Schedule Status' has 'Schedule Enable' checked. There are 'Register' and 'Unregister' buttons. A 'Close' button is at the bottom right.	The screenshot shows the 'Report Schedule Setting' dialog box. On the left is an 'Equipment list' with 'NewMachine001'. The 'Manual Output' tab is selected. Under 'Report Type', 'Daily' is selected. 'Output range' is set to 'Start date: 2019/10/14', 'Start time: 09:00', and 'Period: 08 : 00'. A 'Run' button is visible. A 'Close' button is at the bottom right.

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## 2.1 自動匯出報告 (Schedule Output)

### 自動排程設定手順：

1. 選擇要匯出的機械 (可複數勾選)
2. 點選 **Schedule Output** (排程輸出) · 並勾選報告型式(Report Type)  
Daily (日報表) / Weekly (周報表) / Monthly (月報表)
3. 設定指定輸出時間 (Output schedule)  
報告開始時間 (Start time) 與區間 (Period)
4. 設定完成後，點選 **Register** 登入確認此排程
5. 更新資料庫設定資訊 (Send to DB)

### 取消或修正排程設定方式：

1. 點選 **Unregister** 取消排程設定 (取消排程動作)
2. 重新修正排程時間
3. 設定完成後，點選 **Register** 登入確認此排程
4. 更新資料庫設定資訊 (Send to DB) (取消排程動作)

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## 2.2 手動匯出報告

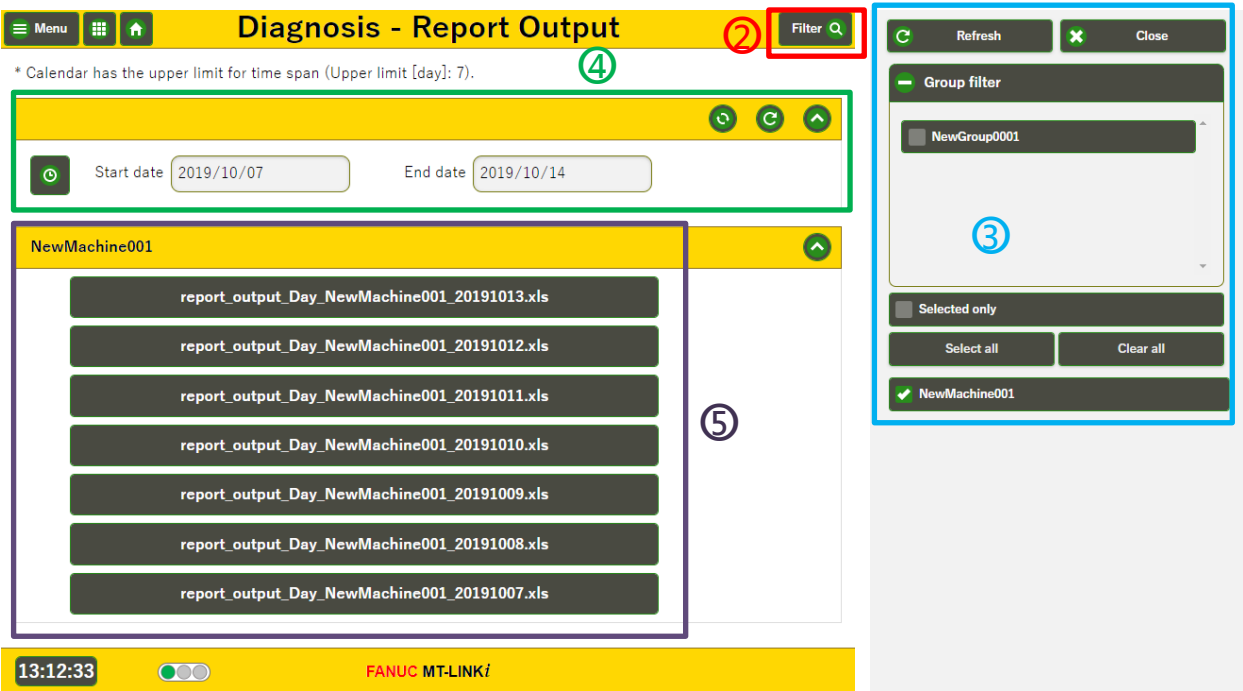
The screenshot shows the 'Report Schedule Setting' dialog box. It has a title bar with a close button. The main area is divided into several sections. On the left, there is a list box labeled 'Equipment list' containing 'NewMachine001'. This list box is highlighted with a red rectangle and a circled '1'. To the right of the list box, there are two tabs: 'Schedule Output' and 'Manual Output'. The 'Manual Output' tab is selected and highlighted with a blue rectangle and a circled '2'. Below the tabs, there is a 'Report Type' section with three radio buttons: 'Daily' (selected), 'Weekly', and 'Monthly'. Below that is an 'Output range' section with three input fields: 'Start date' (2019/10/14), 'Start time' (09:00), and 'Period' (08 : 00). This section is highlighted with a green rectangle and a circled '3'. At the bottom right, there is a 'Run' button highlighted with a purple rectangle and a circled '4'. A 'Close' button is located at the bottom right of the dialog box.

### 手動報告匯出手順：

1. 選擇要匯出的機械 (可複數勾選)
2. 點選 Manual Output (手動輸出) · 並勾選報告型式(Report Type)  
Daily (日報表) / Weekly (周報表) / Monthly (月報表)
3. 設定指定輸出時間 (Output range)  
報告開始日期 (Start date) / 開始時間 (Start time) / 區間 (Period)
4. 點選 Run 匯出報告

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3. 報告查看方式



報告查看手順：

- 1. 登入前台，點選 Report Output
- 2. 點選 Filter 進行設備選擇
- 3. 選擇設備後，點選 Refresh 更新選擇設定
- 4. 設定查看報告時間
- 5. 點選報告進行下載



搜尋指定時間報告  
(最多七天)

搜尋內定時間  
(當天~前一天)

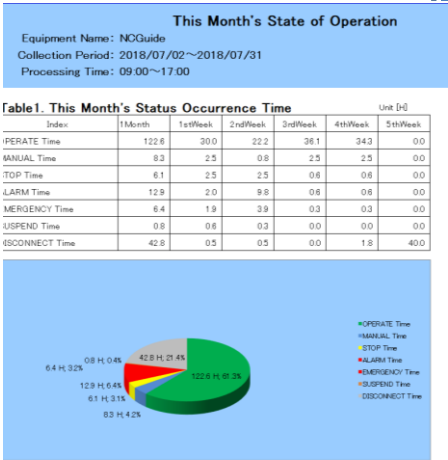


Fig1. This Month's Status Occurrence Time and

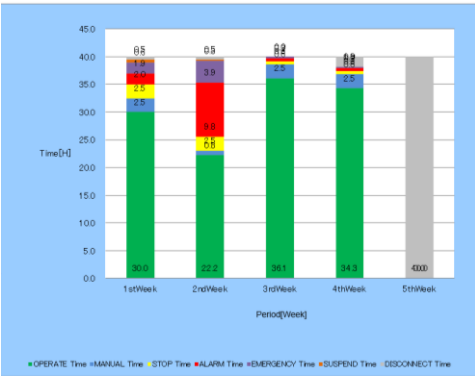


Fig1.2 Weekly Status Occurrence

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