

Professional Edition Manual

Version 3.04 2013/10/20

Table of Contents

I.	Insta	tall and Uninstall	
	1.	System Requirements	
	2.	Installation	
	3.	Uninstallation	
II.	Soft	ftware Registration	6
III.		Setting machines to be connected	
	2.	Modify the Machine	
	3.	Delete the Machine	11
IV.		Using the SkyMars	13
	1.	Connect to Machines	13
	2.	Data Monitoring (FANUC)	14
	3.	NC Uploading/Downloading	15
	4.	Alarm History (FANUC)	16
	5.	Servo Spindle Load Monitoring	17
	6.	Parameters (FANUC)	
		(1) Tool Offset	
		(2) Workpiece Coordinates	
		(3) Macro Variable	19
	7.	Maintenance Management	
	8.	Tool Management	
	9.	Program downloading from machine tool	
	10.	Overall Machine Tool Utilization Rate Service	
V.	Trou	oubleshooting and Repair	
	1.	Delete Windows registry keys	

- I. Install and Uninstall
 - 1. System Requirements
 - Controller model : FANUC 0i-C / 0i-D / 16i / 18i / 21i / 31i
 - CPU: Intel Pentium 1.2 GHz or higher. / (or equivalent AMD processor)
 - Please use dual-core and high GHz CPU when connecting more machines.

RAM: 512MB is recommended

Hard disc space : 500MB available

Internet connection : Network interface card required

OS: Windows XP / Vista / Windows 7 / Windows 8

- SkyMars supports Chinese Traditional, Chinese Simple, and English.
- 2. Installation

Please run Install_SkyMarsPro.exe which is in the SkyMars CD.



After executing "Install_SkyMarsPro.exe", a DOS installation window will come up.



Installation is going to check Microsoft .NET Framework 3.5. If it doesn't exist, Microsoft .NET Framework 3.5 will be installed automatically. It may take 10 minutes for installation. If Microsoft .NET Framework 3.5 has been installed, the setup of SkyMars will start to run automatically.



Please click [Next] until it is finished.

3. Uninstallation

Click[Start]-[Programs Menu]-[SkyMars CNC Monitor]-[Uninstall SkyMars Profession]



Click "Yes" to progress uninstallation.

Windows Installer	X
Are you sure you want to uninstall this p	roduct?
Yes No	

II. Software Registration

All applicants must first complete our registration before beginning SkyMars.



There is a button [Register] on the form, please press it to progress to registration. Notice: Completing registration requires an internet connection.



Read the terms of service, if you agree with it, please check [I accept the terms of service] and click [Next].

C License Agreement
License Agreement Please read the following license agreement
Precision Machinery Reasearch Development Center Software use authorization
This document for you (Licensee) and the Institute for Precision Machinery Research Development Center (hereinafter referred to as ?y PMC?z) legal contract between the books. Before using this software, please read the lease.
1. Ownership The software programs and documents attached to the package of all PMC, including but not limited to copyright, both PMC and is protected by international copyright law and international trade in terms of protection.
2. Authorized to use the right PMC authorize you to: use of the Software on a single computer, not a single computer to the outside while using the software. To multi-user computer workstation or other terminal on the LAN to use this software, you must also be authorized by the PMC can be.
3. Copy restrictions a). The PMC software and its accompanying documentation for the product, the copyright for 💌
 I accept the terms of the license agreement
◎ I do not accept the terms of the license agreement
Previous Next

Next step, the application will scan the internet connection. If it is online which means it's ready to register, you will see a green light; otherwise, you will see a red light which means your internet might not be available. Please check your connection at that time. When you see the green light, choose your member type and enter your unified business number.

Network Status:	PMC On-Line
Please enter the ID ha If you are registered f the "First time register © Company	is been registered. for the first time, please click " button. Workshon/Student
o company	© monep,etabent
Company ID number:	

Please enter the information of your company, we will not disclose, sell or provide such information to other parties. After entering all information, please click [Online Registration], and then SkyMars will connect to PMC.

ease fill in the registration	information	
Company Name:		
Address:		
ID:	201310290097	
Contact:		
Phone:		
Contact E-Mail:		
Products and Services:		
Online Registration		
TAIWAN I	recision Machinery Research & Development Center 886-4-2359900)9 #388

If data processing is correct, the sign-up window will come up. You have to create an account and password, and use it to apply for services. Please keep it properly. After entering all data, click [confirm] to finish the registration.

Create an account increase the servic theAccount and pa	and password (to ce function, use assword)
Account:	
New Password:	
New Password Aga	ain:

Notice :

If your company had been registered before, you will see the window below. Please enter the registered account and password. The registration will be finished without other information.

Username and	Password confirmation
The company registered, (Account and	y ID number already please enter the registration l password.
Account: Password:	Confirm Cancel

If you register multiple times up to 5 times, the registration will fail. Please contact PMC or send an e-mail to inform us. E-mail:e9613@mail.pmc.org.tw III. Setting machines to be connected

Click [Add Machine]

	ars				Recommend	About
Machine Setting	g					
⊊ Sele	ected:0, Author	rized:10	CNC ID	CNC Port	CNC Controllor	
Connecti	ion F	Add	Modify Machine	Delete Machine	Auto Scan	PMC

1. Add the Machine

Please enter data of your machine to each field and click [Confirm].

Machine S	Set > Add Machine
Picture:	Select Default
Name:	F18
CNC Type:	FANUC -
CNC Controller:	0i/16i/18i/21i/30i/31i/32i 👻
CNC IP:	10.1.1.98
CNC PORT:	8193
Data Server	Not Data Server
	Confirm Cance

2. Modify the Machine

Select the machine you want to modify and click [Modify Machine].

	ected:0, Authoriz CNC Type FANUC	ed:10 Name F18	CNC IP 10.1.1.98	CNC Port 8193	CNC Controller 0//16//18//21//30//31//32i]
Connect	FANUC	Name F18	CNC IP 10.1.1.98	CNC Port 8193	CNC Controller 0i/16i/18i/21i/30i/31i/32i]
	FANUC	F18	10.1.1.98	8193	0i/16i/18i/21i/30i/31i/32i	
						-
Connecti	ion A.	dd 🚺	Modify	Delete	Auto Scan	5

After, the data will be shown in each field, change it and click [Confirm].

Machine Set > Add Machine				
Picture:	Select Default			
Name:	F18			
CNC Type:	FANUC -			
CNC Controller:	0i/16i/18i/21i/30i/31i/32i 👻			
CNC IP:	10.1.1.98			
CNC PORT:	8193 🛓			
Data Server	Not Data Server			
	Confirm Canc			

3. Delete the Machine

Select the machine you want to delete and click [Delete Machine].

Setting Selected:0, Authorized:10 Connect CNC Type Name CNC IP CNC Port CNC Controller FANUC F18 10.1.1.98 8193 0(/16//18//21//30//31//32)			rs				Recommend About
Connect CNC Type Name CNC IP CNC Port CNC Controller FANUC F18 10.1.1.98 8193 0V16V18V/21V/30V/31V/32	viacinine F	Setting	ted:0, Authorize	d:10			
FANUC F18 10.1.1.98 8193 0/16/18/21/30/31/32		Connect	CNC Type	Name	CNC IP	CNC Port	CNC Controller
		1			10.1.1.98		0i/16i/18i/21i/30i/31i/32i
Add Modify Delete Auto Scan							

IV. Using the SkyMars

1. Connect to Machines

Select machines you want SkyMars to connect, and click [Connection] to continue.

6	SkyMa	ars Profess	ional Ver:3.04 (TAI)	WAN Precision Ma	achinery Research & D	Development Cer	nter) Beta 3
S			rs			R	About
1	iciniic (ted:1 Authorized:3	0			
Г		Connect	CNC Type	Name	CNC IP	CNC Port	CNC Controller
1	9	V	FANUC	F18	10.1.1.98	8193	0i/16i/18i/21i/30i/31i/32i
			SYNTEC	SYNTEC	10.1.1.108	5566	WinCE Controller
	<u>.</u>	Connection	n Add Machine		dify hine Ma	chine	Auto Scan
Se	rial: 0	000	TAIWAN P	recision Machiner	y Research _Developr	ment Center 886	-4-23599009 #388 .::

2. Data Monitoring (FANUC)

Data monitoring offers real-time data from connected machines, including CNC Status, Coordinates, NC Information, G-Code, Non-G-Code, Part Count, Time, Actual Feed Rate, and Actual Spindle Speed, etc. If Machine Utilization Rate Service is on, SkyMars will send data about CNC Status, Part Count, and Time to PMC Cloud.

SkyMars Professional Ver:3.04 (TAIWAN Precision Machinery Research & De	evelopment Center) Beta 3
Server OFF-LINE 00202 00202 N00000	MEM START **** ****
F18	
Absolute Machine Relative A Relative DistanceToGo	00202 BC:00151525
X (mm) 117.650 X (mm) 379.684 Y (mm) 0.000 Y (mm) 0.000	G01X500. G04X3. T2 NIG01Y100.
Z (mm) 0.000 Z (mm) 0.000	G04X3. N0G01Z-200.F5000 N0M99
	601 617 690 622 694
	G21 G40 G49 G80 G98
	G50 G67 G97 G54 G64
	669 615 640.1 625 6160
	613.1
P Total: 4066 P Required: 12 P Count: 50	H: 0 F: 5000 T: 1
PowON Time: 16525H 15M	D: 0 S: 100 M: 99
Cutting Time: 3830H 01M 395	F%: 200 S%: 100
Cycle Time: 72H 08M 34S	Actual Feed: 10000 mm / min
Coperation Time: 1967H 34M 21S	Actual Speed: 0 RPM
- 🛐 💽 💻 🚺 🐝	🤫 🤇 👫 🗗 ,
Help Soft Center Information Program Alarm ServSpindle	Parameter Maintenance Tool Setting Exit
Disable machine utilisation service	

3. NC Uploading/Downloading

SkyMars offers NC uploading and downloading feature, allowing you to manage and edit NC programs on its user interface. It brings a lot of benefits for centralized program management.

SkyMars+ Ver:3.01 (F	Precision Machi	nery Research 8	k Developmen	t Center)					
		FANUC emo	Mit	Heid	Siem	Bie		Р	rofessional
Server ON-L	INE 0	1000 0	1000	N01000	MEM	**	***	****	****
Demo									
Local Disk(Allow Multi S	elect)		CNC (Allow m	ulti select)		NC Progra	ım Edit		
🗐 d: [D]	-		CNC Memory	Data Server		00001			
D:\TestNC\			Name	Size	Remark	%			
News	Cine A		00202	180	rearrier	01 (PM	C)		
Name	Size		G 01000	300		G02 I25.	F2.;		
1207C006.nc	16862		01235	240		G4 X1.;			
	32		01236	360		G03 I25.	F2.;		
	28		01238	300		G28 U0.	W0.;		
1 9108	/15 =		01510	120		SSUU MU			
9109	239		01511	120		G4 XOU.	,		
laaa.n	142		02101	300		5500 MC	4.		
EXI.H	204		02222	120		G4 X60	. '		
ex2.H	35/		04000	60		M05 :	'		
La ex3.H	4/0		04001	240	MULITTO	M98 P10	0002 :		
ex4.H	362		G 05000	120		M99;			
exo.H	740					%			
	559								
	20								
	102			m					
	04		EDEE (CLIAD)		<u> </u>				
	100 *		FREE (CHAR,	: 3381	00				
(III	•					1			
New Rename	Delete		× Delete		Reload	Se Se	arch	Calpace	Save Save
< 📖 🥥) 💂			ŝæ	8	Q	ŧI	٢ <u></u>	>
Help Soft Cer	nter Informatio	n Program	Alarm S	ervSpindle H	arameter	Maintenance	Tool	Setting	Exit
Enable machine uti	lisation service		With FANUC o	nline use Sky	Mars cust	omer, please	update to	the 2.13 versi	on.

4. Alarm History (FANUC)

SkyMars can get all alarm historical records from your machines, and show the last or the historical alarm data. Engineers can fix failures according to these messages as soon as possible.

6	SkyMars+ Ver:3.0	1 (Precisio	on Machine	ry Research	& Developn	nent Center)					X
			S		Mit	Heid	Siem				Professional
- F	2 Server O	N-LINE	010	00	01000	N01000	MEN	4 *	***	****	****
	Demo										
A	larm Operator										
	Alarm No.	Alar	rm Date T	ime			Aler	t Message			
	100	2012-1	LO-18 09:4	15:36	PARAMET	ER WRITE	ENABLE				
	0	2012-1	10-17 13:0	06:01	PLEASE T	URN OFF PO	OWER				
	100	2012-1	10-16 09:2	28:38	PARAMET	ER WRITE	ENABLE				
	Warning Desc	iption:									
	On the PARA	METER(SETTING)	screen, P	WE(param	eter writing	enabled) is	s set to 1. S	Set it to 0,	then reset	the
	system.		a								
<	m (-	89	Q	Ŧ	Ľ	>
	Help Sof	t Center	Information	Program	Alarm	ServSpindle	Parameter	Maintenance	Tool	Setting	Exit
	Enable machine	utilisatio	n service		With FANU	C online use S	kyMars cus	tomer, pleas	e update to	the 2.13 ver	sion.

5. Servo Spindle Load Monitoring

SkyMars can monitor servo spindle load and speed. Operators can view the machining status at present.

• Start capturing :

It can capture servo spindle load data and draw it as a chart.

• Stop retrieving :

Stop capturing servo spindle load data.

• Export :

It can export the captured data to a text file so that it can be used to integrate with external applications. (Turn on "Start Capture" to enable the export function.)

• Import :

It features the ability to import a text file as a chart that you want to view.



PS: Current support controllers have Fanuc, Mitsubishi, Heidenhain and ITRI.

6. Parameters (FANUC)

If you want to write parameter data (e.g.: tool compensation, the workpiece coordinate table and Macro variables) to controller, you must enter [Settings] form.

Switch to [Settings] page, To [Permission settings], [Allow write] is select.

	Recommend About
Machine Program Download Mode	Ö.
Plug-In Set Start Plug-In Port: 9500 Starting XML Port 9701 Set API Security Permission settings	
Parameter value write to controller: Cloud Setting Cloud Application: Allow Connect Not allow connect	

(1) Tool Offset

SkyMars features the ability of viewing the tool offset value.

ID	Length GEO	Length WEAR	Radius GEO	Radius WEAR	1
1	11.5	0.2	12	0.5	1
2	250	90	0.8	99.88	1
3	22	50	25	0	ľ
4	0	56	670	0	1
5	0	0	99.102	0	1
6	0	0	10	8790	1
7	300	0.5	50	0.95	1
8	6667	-29233.346	5556	6666	
9	0	0	0	0	
10	0	0	0	0	
11	0	0	0	0	
12	0	0	0	0	
12	0	0	0	0	

(2) Workpiece Coordinates

SkyMars features the ability of viewing the workpiece coordinates.

ID	x	Y	Z
хт	0	0	500
G 5 4	0	0	-1.2
555	-12	-200	-500
556	2	5	0
57	-560	-350	0
558	1	2	3
59	0	0	0
G54.1P1	0	0	0
554.1P2	111	4534	555
G54.1P3	0	0	0
G54.1P4	100	100	0
54.1P5	1000	200	300
54 1P6	0	0	0

(3) Macro Variable

SkyMars features the ability of viewing the value of Macro variables.

ool Offset	Work Coordinates	5 Macro	
Mouse dou	ble click to the edit	t	
ID	Value		▲ Write
27	0		
28	0		C Reload
29	0		
30	0		
31	0		
32	0		
33	0		
100	0		
101	0		
102	0		
103	0		
104	0		
105	0		
106	0		
1000000	Sec.		

7. Maintenance Management

SkyMars performs the component maintenance management feature.

If the maintenance item does not have value in "PLC node", SkyMars will detect weather CNC is power-on or not and calculate the use of time.

If the maintenance item has value in "PLC node", SkyMars will detect PLC and calculate the use of time when the bit is "On".

Warnings will come up once the use of time is more than or equal to the life time.

SkyMars+ Ver:3.01 (Precision Machi	nery Research & Developr	ment Center)		Cour.		— X
	FANLIC emo	Heid	SIBIO	FANUC	Profe	essional
Server ON-LINE 01	1917 01917	N00000	HANDLE	****	****	****
УСМ						
Maintenance Management						
Modify Save	Abort Export Ex	ccel Import	Excel			Q
F2: modified for field Reset Du	Maintenance Item	Lice of time	Life Time (m)	PI C	Specifications	· ·
		5.406	20		Specifications	
	Air filter	5.406	15	-		1
1	III					Þ
< 🛍 🌒 💆		-	99 Q	₽1	Ê I	>
			00			

8. Tool Management

SkyMars performs the tool management feature. The processing time is measured when CNC is on the Cycle Start status. Warnings will come up once the processing time is more than or equal to the life time.

6 9	SkyMars+ Ver	:3.01 (Preci	ision Machine	ery Researc	ch & Developr	ment Center)						x
4	Server	Ma ud Computing r ON-LIN	rs Der	ANUC no	Mit 01917	Heid	Sierr HAND		**	****	Profess *	ional ***
	YC	м										
Т	ol Managem	ent										
	Modify F2: modified f	Sa for field	ve Reset butt	Abort	Export Ex	to 0	ort Excel					
Г	Status	i l		Tool	Knife type	1	Processing	Life Time	(m) Fe	ed s	Spindle	Wor
				1	End Mill	C		300	30	00 1	.000	S45C
				2	Facemilling	C		500	15	00 6	00	S45C
	11 <u>1</u>					10						,
<	m					÷	8		ŧI	Ľ		- >
	Help	Soft Center	Information	Program	Alarm	ServSpindle	Parameter	Maintenance	Tool	Setting	Exit	
	Enable mad	chine utilisat	tion service		With FANL	IC online use	SkyMars cus	stomer, please	update to	the 2.13 ve	ersion.	

9. Program downloading from machine tool

When operators are using the machine tool, it is allowed for operators to download CNC programs directly without using a PC and operating SkyMars to upload or download CNC programs. At this time, SkyMars could be regarded as or be simulated a kind of a CNC program server.

• SkyMars is supporting for FANUC and MITSUBISHI now. Before starting this function, you need some setting up, as follows :

(1) Check "Enable Machine Program Download Mode"

	About
9500 Starting XML F	Port 9701
L	Register
Machine Set	Connection
	9500 Starting XML F

(2) Click "Set"

allow the front panel b	y the machine S	kyMars action)	
Macro variables will us	e the implement	ation of two-way	S.
communication, specify	the number betw	veen 100-199)	
Command receiver:	100 🌩		
(Input 1: send the list o number to memory,-3_ to the DataServer / CF	f NC,-2: NC : Specifies the tard)	program sent by number sent by	the specified the NC program
Send to wait number:	100 🌲		
(Display -10: Wait for th program transmission, -9 not found)	e command / tra 0: NC upload erro	nsfer is complete, or, -91: NC read e	-11: NC rror, -92: File
ist of NC program:	0 🔺		
(When the command re number)	ceives -1, send t	he <mark>list belong</mark> s to	the program
IC program folder:			
En andring and fall			

SkyMars can use Macro variables or common variables of MITSUBISHI to achieve the communication between machine tools. It has to be set up the variable numbers which are used to send commands and receive commands.

- Enter command receiving number "-1" on the machine tool : SkyMars will send a list of CNC programs to the machine tool, and the CNC program numbers in this list will be in order according to the setting, "NC program number list". The content of CNC programs will also be composed according to "NC program folder".
- Enter command receiving number "-2____: ____" on the machine tool. It is the CNC program number of the list. After entering it, SkyMars will read NC from the specific "NC program folder" and upload to the controller.
- (3) Use of "Read and write NC list to the machine tool"

CNC Screen Display Function - 10.4.33.98:8193	
<u>File View Option H</u> elp	
ACTUAL POSITION	00202 N00000
CABSOLUTE) X -4.100 Y -2.200	F Ø PART COUNT 7: RUN TIME 134H36M CYCLE TIME ØH ØM ØS
Z 12954.538 (MODAL) 600 640 654 F H 617 649 664 690 680 669 H 622 698 615 D T 694 650 625	NO. DATA NO. DATA 100 108
G21 G67 S SACT 0	S 0 L 0' MEM ***** *** 13:33:11 0' NO. SRH INP. C. INPUT 10'

Please enter "-1" to a specific variable number

(4) After entering, please open "the specific program number of NC list" in the setting page.

CNC Screen Display Function - 10.4.33.98:8193					
<u>File View Option Help</u>					
ACTUAL POSITION 02100 N02100					
X -4.100 Y -2.200	F Ø MM/M JOG F 0 PART COUNT ?1 RUN TIME 134H36M CYCLE TIME 0H 0M 0S				
	PROGRAM BC: 0000000				
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	02100; (NUMBER NC PROGRAM [REMARK]); (001 -> 00001); (002 -> 000012); (003 -> 00001F); (004 -> 00002 [PMC T31); (005 -> 00003 [TEST-00003]); (006 -> 00005 [PMC TEST]); (007 -> 00008); (008 -> 00010 [SQUARE]); (009 -> 00011);				
	S O L 0% MEM ***** **** 13:38:13				
ABS REL ALL HNDL	BG-EDT O SRH				

(5) Please check the CNC program number which you want to acquire, and enter "-2___" to the Macro variable. If you want to acquire the CNC program number, "002", please enter strings, "-2002".

CNC Screen Display Function - 10.4.33.98:8193	
<u>File View Option Help</u>	
ACTUAL POSITION	02100 N02100
X -4.100 Y -2.200	F Ø MM/M JOG F Ø PART COUNT 71 RUN TIME 134H36M CYCLE TIME ØH ØM ØS
2 12954.538	NO. DATA NO. DATA 100 0.000 108
(MODAL)	104 112
G00 G40 G54 F M	
617 649 664 698 698 669 8	
622 698 615 D T	
694 650 625	
G21 G67 S SACT 0	>-2002
ABS REL ALL HNDL	MEM **** *** *** 13:41:26 NO. SRH INP. C. INPUT

(6) After entering, SkyMars will send the CNC program, which number is 002, to the machine tool.

10. Overall Machine Tool Utilization Rate Service

When you go on business outside the office, you can use this kind of service in order to check the status of the online machines so that you can reply your customer the time for the shipment or offer your customer the visualized operation. It can enhance your trust and the core competitiveness of your enterprise for your customers.

- (1) Please open the website, <u>http://skymars.pmc.org.tw/</u>. Click
 - on "Utilization Service".

🗲 🕘 🥖 http://faremo	.pmc.org.tw/RegisterServer,	/Pag 🔎 🔻 🗟 🖒 🗙 🦉 PMC SI	cyMars Web Site 🗙	🔐 🔂 🖓	
Sk		Precision Machinery Research Development Center T4 Systems Engineering Department No.27, 37th Road, Taichung Industrial Park, Taichung, Taiwan, R.O.C. Tel: 886-4-23598046 Fax: 886-4-23598846			
Login			▶ <u>繁體中文</u>	▶ <u>简体中文</u> ▶ <u>English</u>	
Home Sky	Mars ndard SkyMars Professional	SkyMars Express	e <u>Utilization</u>	Contact Us	
Thank you for usin	ng PMC developm	ent SkyMars!			
So far SkyMars is compatible FANUC: 0-B / 0-C / MITSUBISHI: M70 / (Please install MITSU HEIDENHAIN: ITNCS SIEMENS: 840D Versions of SkyMars:	was developed by PMC III iride free trial of single CNC e with the following control 0I-D / 16i / 18i / 21i / 31i / M700 IBISHI CustomAPI in advan 330	voer to benen to manufactur monitoring and CNC program u lers(only with internet available /32i ce. Please contact your agency	ers of other users. ploading/downloading feature ones): or Mitsubishi Electric to get it.	.)	
	SkyMars Standard	SkyMars Professional	SkyMars Express		
Information	~	~	*		
Program	 Image: A second s	v	*		
Alarm History	×	×	*		
Servo and Spindle load	*	×	*		
*Relevant parameters	*	~	×		
Maintenance	*	4	*	5	

(2) Open or close overall utilization rate transmission.

Click on "Change settings", and login it.

C (C) (C
Requirements
It's required to run SkyMars Standard or SkyMars Professional. SkyMars has to connect to the internet and PMC server.
Note: After registration, utilization rate services is turned off by default. The service starts running only when you [change settings] into "on service".
Change Settings / Monitoring
Please login to use this service.
Change You can set the service into enable or disable. Settings:
Monitoring: Query machine status and utilization rate
Change settings Monitor
How to use the utilization rate of SkyMars
1. Run SkyMars, he sure your SkyMars is connected to PMC server, as shown below.
"Server ON-LINE" and "Enable utilization rate service" need to be green.
Conditionary Met HED PLUS
32 Server Of L1 Rr. 10022 0022 10000 920 0022 10000 920 0000 000
SarMani della Maria

Utilization Rate Service

	Enable Settings
On Service: Sky counts, and pro Off Service: Sto	Mars will send data of machine status, cessing time to PMC cache server. p sending data to PMC cache server.
The current service status:	Services are starting
6	On Service Off Service

[On Service]: Open utilization rate view, and then SkyMars will transmit data (the machine status) to a flash server of PMC (PMC cache server) to save it temporarily. It also provides a website to read utilization rate and show on the webpage.

[Off Service] : Close utilization rate view, and then SkyMars will stop transmitting data.

(3) Viewing utilization rate on the webpage

Please do the first step. Click on "Monitor".

(く) (④ http://faremo.pmc.org.tw/RegisterServer/Pag の・ 副 C ×) @ PMC SkyMars Web Site ×) ① 企 ③
Client
Requirements
It's required to run skymars Standard or skymars Professional. Skymars bar connect to the interret and PMC sonar
• Skymans has to connect to the internet and FMC server.
Note: After registration, utilization rate services is turned off by default. The service starts running only when you [change settings] into "on service".
Change Settings / Monitoring Please login to use this service.
Change Settings:
Monitoring: Query machine status and utilization rate
Change settings Monitor
How to use the utilization rate of SkyMars
1. Run SkyMars, be sure your SkyMars is connected to PMC server, as shown below.
"Server ON-LINE" and "Enable utilization rate service" need to be green.
SkyMors File Plus

Please wait the utilization rate system for 10 to 15 seconds, and it will show the information of overall machine tool utilization rate.



(4) If you use SkyMars Plus edition, please click on the name of the machine and then utilization rate webpage will show you more detail historical data of the machine, and it also can search for the historical data by using a specific date.

e e	<u>Demo</u>		MIT		<u>HEID</u>
O A	LARM	_	DLE	9	IDLE
Current NC	O0202	Current NC	008	Current NC	free_test.H
Part Total	0	Part Total	0	Part Total	0
Cycle Total	0	Cycle Total	0	Cycle Total	0

III.

Notice

While using "Overall machine tool utilization rate service", the computer you use must be connected to the internet. It must be shown as "Server ON-LINE" in the red square in the below figure so that "Overall machine tool utilization rate service" can be run.

SkyMars+ Ver:3.01 (Precision	Machinery Resea	arch & Develop	ment Center)				
						P	rofessional
Server ON-LINE	01000	01000	N01000	MEM	START	****	****
Domo							

V. Troubleshooting and Repair

If you install SkyMars unsuccessfully or there are some troubles happened in SkyMars but they cannot be fixed, you can delete the Windows registry keys and the built-in database, and then restart SkyMars.

- You have to close SkyMars in advance.
- 1. Delete Windows registry keys

(1) Run regedit and open the Registry Editor.

(You can execute [Command Prompt] and enter "regedit" to open the Registry Editor.)

Programs (1)
🃸 regedit.exe
Files (1)
🗐 SkyMars Pro Startup Guide_3.04 - English.doc
>> See more results
regedit × Shut down +

(2) Search for [HKEY_CURRENT_USER]-[PMC_SkyMars], shown below:

Registry Editor							
<u>File Edit V</u> iew F <u>a</u> vorites <u>H</u> elp							
▲ I Computer	Name	Туре	Data	•			
HKEY CLASSES ROOT	ab (Default)	REG_SZ	(value not set)	1			
HKEY_CURRENT_USER	ab ADD_maint_single	REG_SZ	True				
AppEvents	ab ADD_toolmanage_single	REG_SZ	True	1			
Console	ab CHECK_cam_running	REG_SZ	True	l			
Environment	et CHECK_ni9233_running	REG_SZ	True	4			
	ab CHECK_rs232_data_received	REG_SZ	True				
Identities	ab CLOSE_rs232	REG_SZ	True				
Keyboard Layout	ab CONNECT_cam	REG_SZ	True				
	DEL_maint_single	REG_SZ	True				
PMC SkyMars	DEL_nc_ftp	REG_SZ	True				
PMC_SkyMars_API	DEL_nc_mem	REG_SZ	True				
Printers	DEL_toolmanage_single	REG_SZ	True				
Software	DISCONNECT_cam	REG_SZ	True				
System	et GET_alm_current	REG_SZ	True				
Volatile Environment	@GET_alm_current_heid	REG_SZ	True				
P HKEY_LOCAL_MACHINE	et GET_alm_current2	REG_SZ	True				
HKEY_USERS	eb GET_alm_history	REG_SZ	True				
▶ - B HKEY_CURRENT_CONFIG	@GET_alm_history_heid	REG_SZ	True				
	eb GET_alm_history2	REG_SZ	True				
	et GET_cam_error	REG_SZ	True				
	💩 GET_cam_image	REG_SZ	True				
	ab GET_feed_spindle	REG_SZ	True				
	赴 GET_gcode	REG_SZ	True				
	et GET_information	REG_SZ	True				
	et GET_information_heid	REG_SZ	True				
	et GET_macro_all	REG_SZ	True	-			
			Þ	Ĩ			
Computer\HKEY_CURRENT_USER\PMC_SkyMars_API							
		-					

(3) Delete [PMC_SkyMars].

💣 Registry Editor	-			
File Edit View Favorites	Help			
⊿ 🖳 Computer		Name	Туре	Data
HKEY_CLASSES_RO	OT	(Default)	REG_SZ	(value not set)
A B HKEY_CURKENT_US	EK	API_COMPATIBLE_OLD	REG_SZ	False
▷ → AppEvents		API_CONNECTIONKEY	REG_SZ	
Control Panel		API_ENCRYPTIONMODE	REG_SZ	0
Environment		API_PWD	REG_SZ	
EUDC		ab) CNC	REG_SZ	<dsCNC xmlns="http://te</td>
b Identities		ab Debug	REG_SZ	0
Keyboard Layou	ıt	ab) kType	REG_SZ	0
		ab Language	REG_SZ	ENGLISH
PMC_SkyMar		ab PlugInPort	REG_SZ	9500
PMC_SkyMar	Ехра	nd	REG_SZ	C:\Program Files (x86)\PM
Printers	New	▶ 'ort	REG_SZ	9701
b - b Software	Find.		REG_SZ	3000
👂 🍌 System			REG_SZ	120000
Volatile Envi	Delet	e p	REG_SZ	False
HKEY_LOCAL_M	Rena	me	REG_SZ	http://faremo.pmc.org.tw
HKEY_USERS	Expo	t	REG_SZ	http://faremo.pmc.org.tw
	Perm	issions		
	Сору	Key Name		
-				•
Computer\HKEY_CURRENT_US	ER\PMC_	SkyMars		

(4) Restart SkyMars.