

# File Transfer Specs

Eclipse allows the transfer of data from and back to other computers or mainframes. Importing data requires that information only be entered once, saving time and money. This document addresses what is required for importing files into the Eclipse program and provides samples of various import files. It also addresses exporting production results back to upstream systems.

Data can be transferred between other software and Eclipse via ASCII files. Order files, Part Definition files, Bundle files, Coil Data files, Material Definition files, Product Code Definition files, and Customer information files are transferred to Eclipse via respective "DEL" files (OrderIn.DEL, PartIn.DEL, BundleIn.DEL, CoilIn.DEL, MaterialIn.DEL, PCodeIn.DEL, and Customer.DEL ).

Eclipse automatically inputs these files from designated directories. File names may be located in any directory as designated by the Import/Export Settings of the Settings form (found under Maintenance in Eclipse).

The files are composed of coma delimited-field records. Each record must be terminated with a line feed and carriage return symbol and each individual field must be separated by a comma. Character fields are further delimited with double quotes. Each has a size limitation which is specified in this appendix. If a field is not needed, place a set of double quotes between the commas to express an empty field. If trailing fields of the message are not needed, they may be left blank.

## File Import

Eclipse searches for import files at predetermined intervals as programmed in the "Settings" form found under the "Maintenance" menu bar. When a new file is detected in the directory, the information in the file will be read into Eclipse and the file will be deleted.

**The following procedure must be adhered to when using the file import.**

Eclipse may be interfaced through a wide range of software and hardware while performing file imports. In order to eliminate potential problems with data transfer, duplication, or loss, adhere to the following procedure.

- Buffer your data in a temporary file.
- Check for the existence of the last import file that was created. If it exists, Eclipse has not read it in yet so you must try later or write a different file name. Eclipse does support the "?" and "\*" wildcards in the file names specification located in the "Settings" form.

- **Do not modify existing import files!**  
**If you MUST modify an existing import file (NOT RECOMMENDED), rename it, make the necessary changes, and rename it back.**
- If the previous file no longer exists, copy or rename your buffer file.

Copies of all import files can be saved to the Windows Temp directory if the option is selected. This option may be selected in the Import / Export tab of the “Settings” form under the Maintenance menu of Eclipse. The file names will begin with “D” followed by 7 numbers. The following extensions will be used to identify the appropriate files:

“**ORD**” for Orders                      “**PRT**” for Parts                      “**COI**” for Coils  
“**BND**” for Bundles                      “**CUS**” for Customers                      “**MAT**” for Materials  
“**PCD**” for Product Codes

## **File Export**

Eclipse uses the same procedure for exporting production data as it uses for importing files.

- All data is buffered in a temporary file.
- The existence of the last export file is checked for. If it exists, data is kept in the buffer.
- If the last export file no longer exists, the buffer file is copied to the export file.

## ORDERIN.DEL

Field Name	Type	Size	Notes
Order Number	Character	18 or 15 20	15 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Bundle	Numeric	3	
Quantity	Numeric	4	
Length	Numeric	10,3	In inches Example 1234.123
Material	Character	20 or 18 20	18 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Message	Character	40	
Product Code	Character	5 or 20	20 if XL200 UART 3.03 controller
Part Number	Character	30	References punch pattern Only used if punching or printing on part
Part Option	Character	1	'R' = Right-handed 'L' = Left-handed 'A' = Alternate 'M' = Mirror
Bundle Label	Character	254	Contains actual print commands
Part Label	Character	254	Contains actual print commands
Kit Name	Character	24	Only used if importing Kit definitions
Item_ID	Character	22	Required when using action codes Should be unique for each item in an order
Action	Character	1	'A' = Add 'C' = Change 'D' = Delete - no Recall 'Q' = Sequence 'R' = Recall, Delete and Return 'X' = Recall and Delete
Schedule Date	Date or Character	8	MM/DD/YY
Machine	Number	2	Required when action = 'Q'
User1	Character	254	
User2	Character	254	
Hole Offset	Numeric	8,3	Used with Hole Count Option Example 1234.123
Hole Count	Numeric	4	Number of holes to count
Stagger	Character	1	"S" for a staggered bundle, blank otherwise
Part Format Name	Character	12	Specifies predefined format by name

Field Name	Type	Size	Notes
Bundle Format Name	Character	12	Specifies predefined format by name
User3	Character	254	
User4	Character	254	
User5	Character	254	
Bundle Code	Character	15	
No Material Substitutes	Logical	1	T or F (no quotes)

## Examples of "ORDERIN.DEL" file

### With No Hole Counting

"185-0093",1,250,144.875,"48RED024","","PCODE","124","R","","","","","","","08/23/98,2

### With Hole Counting

"185-0094",1,10,144.875,"48RED024","","PCODE","123","R","","","","","","08/23/98,2","","12.275,1

## PARTIN.DEL

Field Name	Type	Size	Notes
Part Number	Character	30	
Length	Numeric	10,3	1234.123
Part Option	Character	1	'R' = Right-handed 'L' = Left-handed 'A' = Alternate 'M' = Mirror
Tool Number	Numeric	3	S/B blank if punch is a macro
Reference	Numeric	1	0 = Leading Edge 1 = Trailing Edge 2 = Leading Center 3 = Trailing Center 4 = Even Spacing 5 = Spacing Limit 8 = Kerf Adjustment
Offset	Numeric	10,3	Example 1234.123
Permanent	Logical	1	T or F (no quotes)
Macro Name	Character	30	References a part number of a macro part
Y Offset	Numeric	8,3	Example 1234.123
Y Reference	Numeric	1	1 = Center + 2 = Center - 3 = + Edge 4 = - Edge 5 = Macro + 6 = Macro -

### Example of PARTIN.DEL file

**"124",120,"R",4,0,38.375,T**

**"124",120,"R",7,0,46.325,T**

**"124",120,"R",9,1,2.875,T**

## PARTDEF.DEL

Field Name	Type	Size	Notes
Type	Character	2	Always 'PD'
Part Number	Character	30	
Part Option	Character	1	'R' = Right-handed 'L' = Left-handed 'A' = Alternate 'M' = Mirror
Product Group	Character	20	References a part profile (not the same as product code)
Length	Numeric	10,3	1234.123
Shape/Macro	Character	1	'S' = Shape 'M' = Macro
Shape/Macro Name	Character	30	For <b>Shape/Macro</b> = "M", references a part number of a macro part
Diameter or Length	Numeric	8,3	1234.123
Width	Numeric	8,3	1234.123
X Coordinate	Numeric	10,3	Example 1234.123
X Reference	Character	2	'LE' = Leading Edge 'TE' = Trailing Edge 'LC' = Leading Center 'TC' = Trailing Center 'ES' = Even Spacing 'SL' = Spacing Limit 'KA' = Kerf Adjustment
Y Coordinate	Numeric	8,3	Example 1234.123
Y Reference	Character	2	'CP' = Center + 'CM' = Center - 'PE' = + Edge 'ME' = - Edge 'MP' = Macro + 'MM' = Macro -

The use of the PARTDEF.DEL format also requires special setup in Eclipse to support the process of assigning tool numbers. Refer to the Punch File Settings form found on the Maintenance menu.

## BUNDLEIN.DEL

Field Name	Type	Size	Notes
Order	Character	20, 18 or 15	See ORDERIN.DEL spec
Material	Character	20 or 18	See ORDERIN.DEL spec
Product Code	Character	5 or 20	See ORDERIN.DEL spec
Bundle	Numeric	3	
User1	Character	254	
User2	Character	254	
User3	Character	254	
User4	Character	254	
User5	Character	254	
Bundle Label	Character	254	*Contains actual print commands
Part Label	Character	254	*Contains actual print commands
Kit Name	Character	30	Only used if importing kit definitions
Bundle Format	Character	12	*Specifies predefined format by name
Part Format	Character	12	*Specifies predefined format byname
Cust Name	Character	30	*Customer Name
Cust Address 1	Character	254	*Customer Address 1
Cust Address 2	Character	254	*Customer Address 2
Cust City	Character	254	*Customer City
Cust State	Character	2	*Customer State
Cust Zip	Character	10	*Customer Zip Code
Cust Country	Character	3	*Customer Country Abbr.
Cust Inst	Character	254	*Special Shipping Instructions
Staging Bay	Character	10	*Staging bay location for end product
Loading Dock	Character	10	*Defines loading dock for end product
Work Order	Character	18	*Customer defined field
Truck Number	Character	12	*Defines outbound truck/route number
Required Date	Character	8	*Date required at customer location MM/DD/YY
Product Group	Character	20	*Defines a Product Code group
Hold	Logical	1	T or F (no quotes)

### NOTES:

- If Bundle = 0, then User1 through User5 applies to the specified order.
- If Bundle  $\neq$  0, then User1 through User5 applies to the specified bundle.
- The Bundle file must be presented at the same time as the ORDERIN file to insure proper processing.

- \* These fields are entered or downloaded on a per order basis.  
(Bundle = 0)

### Example of BUNDLEIN.DEL file

**"081-00795","48RED024","PCODE",0**

## COILIN.DEL

Field Name	Type	Size	Notes
Action	Character	1	'A' = Add Coil 'C' = Change Coil – leave all unchanged fields empty 'D' = Delete Coil
Coil Number	Character	16	
Description	Character	40	
Date In	Character	10	
Date Out	Character	10	
Start Length	Character	8	Example 12345678
Length Used	Character	8	Example 12345678
Status	Character	1	I = Incomplete C = Complete
Vendor Name	Character	30	
Material	Character	20 or 18 20	18 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Type	Character	10	
Cost Per Lb.	Character	7	Example 1234.1234
Nex Scrap	Character	9	Non-exempt scrap (eg. Plant fault) Example 1234.1234
Ex Scrap	Character	9	Exempt scrap (eg. Supplier fault) Example 1234.1234
Other Adjust	Character	9	Other adjustments (eg. testing) Example 1234.1234
Weight	Character	10	Example 12345.1234
Heat Number	Character	20	
Vendor Code	Character	16	
Purchase Order	Character	10	
Storage Location	Character	20	

### Example of COILIN.DEL file

"A","985612-023","48-in wide painted","08/10/98","","3500","","I","USS","48RED024","","2.50"

## CUSTOMER.DEL

Field Name	Type	Size	Notes
Action	Character	1	'A' = Add Customer 'C' = Change Customer – leave all unchanged fields empty 'D' = Delete Customer
Customer Code	Character	11	
Customer Name	Character	30	
Customer Address 1	Character	30	
Customer Address 2	Character	30	
Customer City	Character	30	
Customer State	Character	2	
Customer ZIP	Character	10	
Customer Country	Character	3	
Shipping Instructions	Character	30	
Reserved	Character	1	
Max Bundle Weight	Numeric	4,0	
Delivery Phone	Character	30	
E-mail address	Character	100	

**Note:** These items will be added to a customer table that can be automatically recalled by associating the customer code to an order.

### Example of CUSTOMER.DEL file

"1","XYZ-100","XYZ Company","555 Hansbrough","Suite-K","RoundRock","MO","55555","USA","YellowFr"

## MATERIALIN.DEL

Field Name	Type	Size	Notes
Action	Character	1	'A' = Add Material 'C' = Change Material – leave all unchanged fields empty 'D' = Delete Material
Material	Character	20	18 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Gauge	Numeric	2	
Thickness	Numeric	6,4	
Width	Numeric	6,3	
Color	Character	20	
Type	Character	10	
Cover	Numeric	7,3	
Description	Character	40	
Lb/Ft	Numeric	7,3	
Cost/Lb	Numeric	7,2	
Normal Length	Numeric	9,3	
Reorder	Numeric	6	
Blank Sheet	Logical	1	T or F (no quotes)
Blank Material	Character	1	'1' = Aluminum '2' = Copper '3' = Stainless '4' = Steel '5' = Zinc

## PCODEIN.DEL

Field Name	Type	Size	Notes
Action	Character	1	'A' = Add Product Code 'C' = Change Product Code – leave all unchanged fields empty 'D' = Delete Product Code
Machine	Numeric	3	
Product Code	Character	5 or 20	See ORDERIN.DEL spec
Description	Character	30	
Finished Width	Numeric	8,3	
Staging Bay	Character	10	
Loading Dock	Character	10	
Hole Spacing	Numeric	8,3	For XL controllers in hole count mode
Calculate Length	Logical	1	T or F (no quotes) only if Hole count = T
Hole Count	Logical	1	T or F (no quotes)
Target Rate	Numeric	4	
Coil Change Minutes	Numeric	6,3	
Tool Change Minutes	Numeric	6,3	
Tool Library	Character	25	
Setup Library	Character	25	
Custom List	Character	40	
Axis Library	Character	25	
Preferred Machine	Logical	1	T or F (no quotes)
Setup Instructions	Character	250	
Leg Height	Numeric	8,3	
Product Group	Character	20	

### Example of PCODEIN.DEL file

## ProdOut.del

Eclipse Field (Name)	Type	Size	Notes
Type	C	1	1=General Production Record 2=Coil Change 3=Machine Started 4=Controller Turned On 5=Job Request 6=Controller Fault 7=Delay 8=Custom or Query List/Quality Audit Feedback C=Quality Audit Trigger S=Start of Shift E=End of Shift G=General Feedback Record
Date	C	10	MM/DD/YYYY Date record created at Controller
Machine	N	2	Unit number of controller (1-30)
Time	C	8	HH:MM:SS Time record created at the controller
Order Number	C	20	15 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Bundle	N	3	Current bundle or lift (0 to 900) (900-999 refer to scrap codes)
Quantity	N	4	Number of pieces produced in this record
Item Length	N	10,3	Length of part (0 to 120,000.000 inches)
Pattern	C	3	Hole pattern for part ( 1 to 999) assigned by Eclipse
Part Option	C	1	'R' = Right-handed 'L' = Left-handed 'A' = Alternate 'M' = Mirror 'H' = Hole count
InvCoil	C	16	Current coil inventory number
Footage	N	14,3	<b>For Type 1 and Reason &lt;&gt; "X":</b> Length run in inches since last type "1" <b>For Type 1 and Reason = "X":</b> Always zero.
Reason	C	3	<b>For Type 1:</b> 'B' = Bundle halt

Eclipse Field (Name)	Type	Size	Notes
			'O' = Out-of-orders halt 'C' = End of Coil 'H' = Manual halt 'I' = Inter-item, no halt 'M' = Manual shear, no halt 'P' = XL100/XL200 power off 'T' = Tolerance halt 'E' = Coil-end-point halt 'X' = Decrement quantity 'Y' = Increment quantity 'R' = Remake 'Z' = Coast to stop <b>For Type 2:</b> 'L' = Load coil 'D' = Delete coil 'R' = Return coil to inventory <b>For Type 8:</b> 'C' = Custom list 'Q' = Query list <b>For Type G:</b> 'R' = Order returned for changes 'D' = Order is done 'I' = Order added by importing 'M' = Order sent to controller 'S' = Order started 'U' = Order recalled from controller 'X' = Order deleted in import 'C' = Coil inventory update <b>For Type E and S:</b> 'H' = Runtime record 'R' = Downtime record
Minutes	N	13	Date and time converted to minutes since Jan. 1, 1980
Material	C	20	18 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Scrap Code	N	3	<b>For Type 1:</b> Scrap code as defined by user if Footage – Total Length <> zero
Employee ID	N	7	
Name	C	30	Employee name
Lb. / Ft	N	7,3	Weight per foot of material specified in order
Delay Code	N	2	

Eclipse Field (Name)	Type	Size	Notes
Delay Reason	C	30	
Duration	N	8	<b>For Type 1, 3, 7 and E:</b> Time in minutes since last type 1, 3, or 7 production message. Used for Runtime, Downtime and Exempt Time.
Item ID	C	22	Identifier of item if item_id was sent to Eclipse – this value should relate back to your back-end system (AS400, etc.)
Product Code	C	20	20 if XL200 UART 3.03 controller
Cost Per Lb.	N	7,2	Cost per pound of material specified in order
Customer Name	C	30	
Order Type	C	1	'H' if Hole Count order
Hole Count	N	4,0	Number of holes counted if Order Type = 'H'
Hole Offset	N	8,3	Distance to 1st hole if Order Type = 'H'
Work Order Nbr	C	18	
List ID	N	10	<b>For Type 8 only:</b> Custom or Query list ID
List Text	C	40	<b>For Type 8 only:</b> Custom or Quality audit list text

### Expanded ProdOut.del

Eclipse Field (Name)	Type	Size	Notes
Type	C	1	1=General Production Record 2=Coil Change 3=Machine Started 4=Controller Turned On 5=Job Request 6=Controller Fault 7=Delay 8=Custom or Query List/Quality Audit Feedback C=Quality Audit Trigger S=Start of Shift E=End of Shift G=General Feedback Record

Eclipse Field (Name)	Type	Size	Notes
Reason	C	3	<p><b>For Type 1:</b>            'B' = Bundle halt            'O' = Out-of-orders halt            'C' = End of Coil            'H' = Manual halt            'I' = Inter-item, no halt            'M' = Manual shear, no halt            'P' = XL100/XL200 power off            'T' = Tolerance halt            'E' = Coil-end-point halt            'X' = Decrement quantity            'Y' = Increment quantity            'R' = Remake            'Z' = Coast to stop</p> <p><b>For Type 2:</b>            'L' = Load coil            'D' = Delete coil            'R' = Return coil to inventory</p> <p><b>For Type 8:</b>            'C' = Custom list            'Q' = Query list</p> <p><b>For Type G:</b>            'R' = Order returned for changes            'D' = Order is done            'I' = Order added by importing            'M' = Order sent to controller            'U' = Order recalled from controller            'X' = Order deleted in import            'C' = Coil inventory update</p> <p><b>For Type E and S:</b>            'H' = Runtime record            'R' = Downtime record</p>
Date	C	10	MM/DD/YYYY Date record created at Controller
Time	C	8	HH:MM:SS Time record created at the controller
Minutes	N	13	Date and time converted to minutes since Jan. 1, 1980
Production Date	C	10	Shift Date MM/DD/YYYY
Shift	C	1	
Machine	N	2	Unit number of controller (1-30)
Order Number	C	20	15 if controller is using Product Codes 20 if XL200 UART 3.03 controller

Eclipse Field (Name)	Type	Size	Notes
Material	C	20	18 if controller is using Product Codes 20 if XL200 UART 3.03 controller
Product Code	C	20	20 if XL200 UART 3.03 controller
Customer Name	C	30	
Work Order Nbr	C	18	
Order Type	C	1	'H' if Hole Count order
Bundle	N	3	Current bundle or lift (0 to 900) (900-999 refer to scrap codes)
Quantity	N	4	Number of pieces produced in this record
Item Length	N	10,3	Length of part (0 to 3500.000 inches)
Part Option	C	1	'R' = Right-handed 'L' = Left-handed 'A' = Alternate 'M' = Mirror 'H' = Hole count
Part Number	C	30	
Pattern	C	3	Hole pattern for part ( 1 to 999) assigned by Eclipse
Total Length	N	14,3	Quantity x Item Length in inches
Footage	N	14,3	<b>For Type 1 and Reason &lt;&gt; "X":</b> Length run in inches since last type "1" <b>For Type 1 and Reason = "X":</b> Always zero.
Hole Offset	N	8,3	Distance to 1 <sup>st</sup> hole if Order Type = 'H'
Hole Count	N	4,0	Number of holes counted if Order Type = 'H'
InvCoil	C	16	Current coil inventory number
Coil Material	C	20	
Coil Width	N	6,3	
Lb. / Ft	N	7,3	Weight per foot of material specified in order
Cost Per Lb.	N	7,2	Cost per pound of material specified in order
Heat Number	C	20	Coil batch number
Code Type	C	1	<b>For Type 1:</b> 'S' = Scrap if Footage – Total Length <> zero <b>For Type 2:</b> 'C' = if coil verification error <b>For Type 3, 7 and E:</b> 'D' = Delay if duration is <> zero

Eclipse Field (Name)	Type	Size	Notes
Code Value	N	3	<b>For Type 1:</b> Scrap code as defined by user <b>For Type 3, 7 and E:</b> Delay code as defined by user
Code Description	C	30	<b>For Type 1:</b> Scrap reason <b>For Type 2:</b> Coil verification error <b>For Type 3, 7 and E:</b> Delay reason
Code Exempt	C	1	<b>For Type &lt;&gt; 2:</b> 'E' = Exempt 'N' = Non-exempt example: Non-plant or non operator-fault – scrap coil was damaged in shipment, delay scheduled maintenance
Machine Status	C	1	'R' = Running 'H' = Halted
Duration	N	8,2	<b>For Type 1, 3, 7 and E:</b> Time in minutes since last type 1, 3, or 7 production message. Used for Runtime, Downtime and Exempt Time.
Runtime	N	8,2	<b>For Type 1 and (Type E with Reason = "H"):</b> Duration In minutes
Downtime	N	8,2	<b>For Type 3, 7, and (Type E and Reason = "R"):</b> Duration in minutes if Delay is non-exempt
Exempt Time	N	8,2	<b>For Type 3, 7, and (Type E and Reason = "R"):</b> Duration in minutes if Delay is exempt
Good Footage	N	11,3	<b>For Type 1 and Reason &lt;&gt; "X":</b> Qty * Length in inches – (Excludes Decrement Qty. footage)

Eclipse Field (Name)	Type	Size	Notes
Scrap Footage	N	14,3	<b>For Type 1 and Reason &lt;&gt; "X":</b> Total footage run minus good footage in inches if Scrap is non-exempt – (Excludes Decrement Qty. footage) <b>For Type G:</b> Adjustments to coil non-exempt scrap – for manual adjustments in Eclipse
Exempt Scrap	N	14,3	<b>For Type 1 and Reason &lt;&gt; "X":</b> Total footage run minus good footage in inches if Scrap is exempt – (Excludes Decrement Qty. footage) <b>For Type G:</b> Adjustments to coil exempt scrap – for manual adjustments in Eclipse
Reclaimed	N	14,3	<b>For Type 1 and Reason = "X":</b> Qty * Length in inches – (Includes only Decrement Qty. footage)
Actual Speed	N	8,3	
Target Speed	N	8,3	
Employee ID	N	7	
Name	C	30	Employee name
Item ID	C	22	Identifier of item if item_id was sent to Eclipse – this value should relate back to your back-end system (AS400, etc.)
List ID	N	10	<b>For Type 8 only:</b> Custom or Query list ID
List Text	C	40	<b>For Type 8 only:</b> Custom or Quality audit list text
Plant Name	C	30	
List Valid	C	100	<b>For Type 8 and Reason = "C" or "Q" only:</b>
Code Responsibility Type	N	1	<b>For Type &lt;&gt; 2:</b> 0 = Not Specified 1 = Operational 2 = Equipment 3 = External
Bundle Code	C	15	