

Type Code Reason Code	Description
1	General Production Record
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
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
2	Production Record Related to Coil Change
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
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	Custom List feedback from Machine Operator
Q	Quality Audit feedback from Machine Operator
C	Query List was triggered at XL Series controller
E	End of Shift
H	Runtime record
R	Downtime record
S	Start of Shift
H	Runtime record
R	Downtime record
G	General feedback record
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