

**EUROMAP 84.10**

**OPC UA interfaces for plastics and rubber  
machinery – Extrusion – Part 10: Calibrator**

**Release 1.00, 2020-06-01**

**EUROMAP 84.10 (Release 1.00) is identical with  
OPC 40084-10 (Release 1.00) and VDMA 40084-10:2020-06**

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## Foreword

This specification was created by a joint working group of the OPC Foundation and EUROMAP. It is adopted identically as VDMA Specification.

## EUROMAP

EUROMAP is the European umbrella association of the plastics and rubber machinery industry which accounts for annual sales of around 13.5 billion euro and a 40 per cent share of worldwide production. Almost 75 per cent of its European output is shipped to worldwide destinations. With global exports of 10.0 billion euro, EUROMAP's around 1,000 machinery manufacturers are market leaders with nearly half of all machines sold being supplied by EUROMAP members.

EUROMAP provides technical recommendations for plastics and rubber machines. In addition to standards for machine descriptions, dimensions and energy measurement, interfaces between machines feature prominently. The provision of manufacturer independent interfaces ensures high levels of machine compatibility.

## OPC Foundation

OPC is the interoperability standard for the secure and reliable exchange of data and information in the industrial automation space and in other industries. It is platform independent and ensures the seamless flow of information among devices from multiple vendors. The OPC Foundation is responsible for the development and maintenance of this standard.

OPC UA is a platform independent service-oriented architecture that integrates all the functionality of the individual OPC Classic specifications into one extensible framework. This multi-layered approach accomplishes the original design specification goals of:

- Platform independence: from an embedded microcontroller to cloud-based infrastructure
- Secure: encryption, authentication, authorization and auditing
- Extensible: ability to add new features including transports without affecting existing applications
- Comprehensive information modelling capabilities: for defining any model from simple to complex

## 1 Scope

OPC 40084-10 describes the data exchange interface for calibrators as part of an extrusion line. The interface is used by

- MES (Manufacturing Execution System) for collecting the information generated by extrusion lines at a central point for easier quality assurance and job and dataset management.
- Line controllers to monitor and set process parameters.

Safety related signals like emergency stop are not included.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies

OPC 10000-1, *OPC Unified Architecture - Part 1: Overview and Concepts*

<http://www.opcfoundation.org/UA/Part1/>

OPC 10000-2, *OPC Unified Architecture - Part 2: Security Model*

<http://www.opcfoundation.org/UA/Part2/>

OPC 10000-3, *OPC Unified Architecture - Part 3: Address Space Model*

<http://www.opcfoundation.org/UA/Part3/>

OPC 10000-4, *OPC Unified Architecture - Part 4: Services*

<http://www.opcfoundation.org/UA/Part4/>

OPC 10000-5, *OPC Unified Architecture - Part 5: Information Model*

<http://www.opcfoundation.org/UA/Part5/>

OPC 10000-6, *OPC Unified Architecture - Part 6: Mappings*

<http://www.opcfoundation.org/UA/Part6/>

OPC 10000-7, *OPC Unified Architecture - Part 7: Profiles*

<http://www.opcfoundation.org/UA/Part7/>

OPC 10000-8, *OPC Unified Architecture - Part 8: Data Access*

<http://www.opcfoundation.org/UA/Part8/>

OPC 10000-9, *OPC Unified Architecture - Part 9: Alarms and Conditions*

<http://www.opcfoundation.org/UA/Part9/>

OPC 10000-11, *OPC Unified Architecture - Part 11: Historical Access*

<http://www.opcfoundation.org/UA/Part11/>

OPC 10001-1, *OPC Unified Architecture V1.04 - Amendment 1: AnalogItem Types*

<http://www.opcfoundation.org/UA/Amendment1/>

OPC 10001-3, *OPC Unified Architecture V1.04 - Amendment 3: Method Metadata*

<http://www.opcfoundation.org/UA/Amendment3/>

OPC 10000-100, *OPC Unified Architecture - Part 100: Devices*

<http://www.opcfoundation.org/UA/Part100/>

OPC 40083: OPC UA interfaces for plastics and rubber machinery – General Type definitions (version 1.02)

<http://www.opcfoundation.org/UA/PlasticsRubber/GeneralTypes>

OPC 40084-1: OPC UA interfaces for plastics and rubber machinery – Extrusion – Part 1: General Type Definitions (version 1.0)

<http://www.opcfoundation.org/UA/PlasticsRubber/Extrusion/GeneralTypes/>

### **3 Terms, definitions and conventions**

#### **3.1 Overview**

It is assumed that basic concepts of OPC UA information modelling are understood in this specification. This specification will use these concepts to describe the OPC 40084-10 Information Model. For the purposes of this document, the terms and definitions given in the documents referenced in Clause 2 apply.

Note that OPC UA terms and terms defined in this specification are *italicized* in the specification.

#### **3.2 Conventions used in this document**

The conventions described in OPC 40083 apply.

#### **3.3 Abbreviations**

MES    Manufacturing Execution System

## **4 General information to OPC UA interfaces for plastics and rubber machinery and OPC UA**

For general information on OPC UA interfaces for plastics and rubber machinery and OPC UA see OPC 40083.

## **5 Use cases**

OPC 40084-10 describes the data exchange interface for calibrators as part of an extrusion line. The interface is used by

- MES (Manufacturing Execution System) for collecting the information generated by extrusion lines at a central point for easier quality assurance and job and dataset management.
- Line controllers to monitor and set process parameters.

## **6 Basic security requirements**

### **6.1 Application Security**

For the communication between cutters and MES the OPC UA application authentication via X509 certificates shall be used. OPC UA provides functionalities for using self-signed certificates that have to be manually added to a “trust list” as well as for certificates issued by a certificate authority (CA).

The minimum requirements of the protocol level for a OPC 40084-10 compliant connection are:

- Use of (self-signed) certificates for OPC UA application authentication
- Security Policy: Basic256
- Message Security Mode: sign

NOTE: It is not fixed by this specification if the certificate includes a fixed IP address and/or the host name. However, if the certificate includes a host name, a DNS server is expected to resolve the host name. An OPC UA GDS (Global Discovery Server) can be used to manage the connections and certificates.

### **6.2 User security/Access control**

#### **6.2.1 On calibrator**

On the calibrator authentication via user name and password is commonly used.

#### **6.2.2 On MES**

For the users and roles of the connection the following applies:

- User names can be manufacturer dependent.
- Standard roles are
  - “OPC40084”: read and write access for selected parameters
  - “OPC40084\_read\_only”: no writing permissions
- Manufacturers can add additional roles. They may not start with “OPC40084”. For these roles, more parameters can be writeable than for the OPC40084 role.
- The standard user “OPC40084” has the role “OPC40084” (and no other additional role), “OPC4004\_read\_only” has the roll “OPC40084\_read\_only” (and no other additional role); the passwords for the standard users are defined by the manufacturers (they may be empty).

NOTE: OPC UA also allow an anonymous-token (e.g. for testing)



## 7 Calibrator\_InterfaceType

### 7.1 Calibrator\_InterfaceType Definition

This OPC UA *ObjectType* is used for the root *Object* representing a calibrator as part of an extrusion line. It is based on the *ExtrusionDeviceType* (defined in OPC 40084-1) and formally defined in Table 1.

The instance(s) of *Calibrator\_InterfaceType* shall be located under the *DeviceSet* *Object* of the Server (see OPC UA Part 100).

NOTE: If the OPC UA server is implemented in the control of the calibrator so only one instance of *Calibrator\_InterfaceType* will be created. But it is also possible that one OPC UA server is connected to several machine controls as one interface to the MES. In this case several instances of *Calibrator\_InterfaceType* will be created.

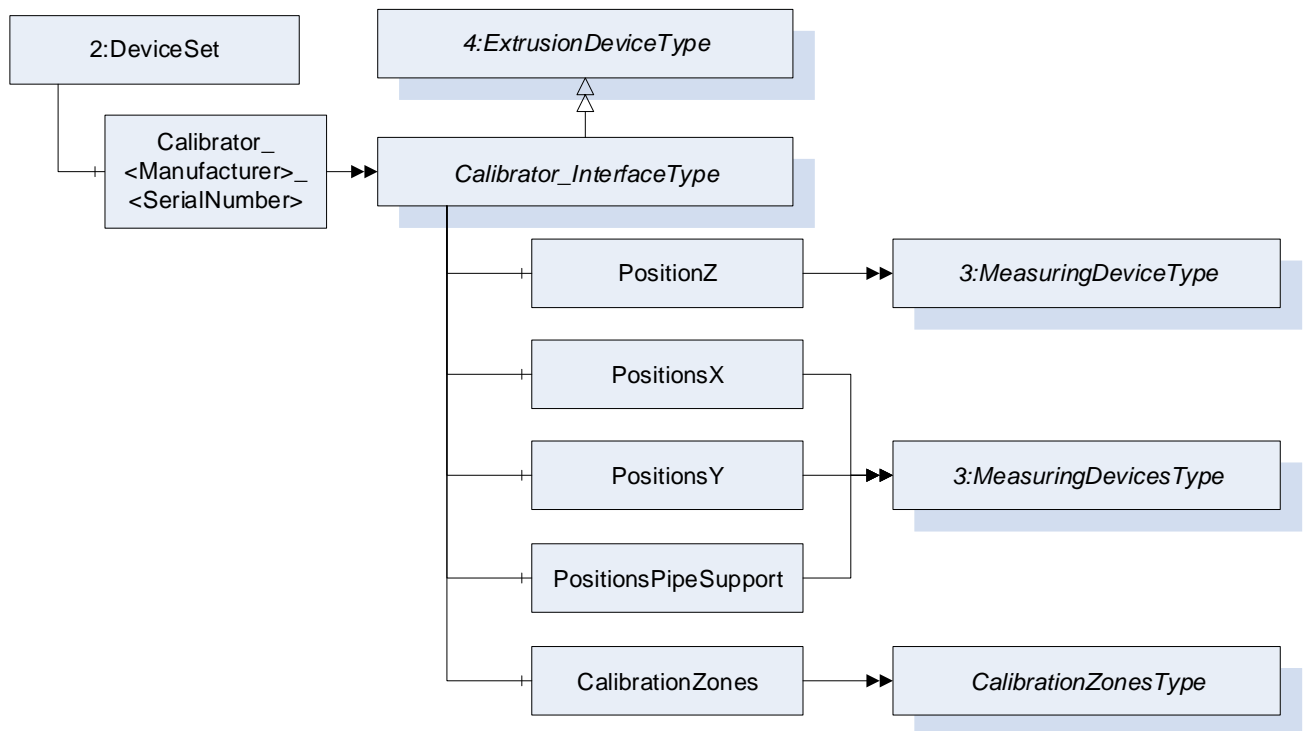


Figure 1 – Calibrator\_InterfaceType Overview

Table 1 – Calibrator\_InterfaceType Definition

Attribute	Value				
BrowseName	Calibrator_InterfaceType				
IsAbstract	False				
References	Node Class	BrowseName	DataType	TypeDefinition	Other
Subtype of 4:ExtrusionDeviceType (defined in OPC 40084-1)					
0:HasComponent	Object	PositionZ		3:MeasuringDeviceType	O
0:HasComponent	Object	PositionsX		3:MeasuringDevicesType	O
0:HasComponent	Object	PositionsY		3:MeasuringDevicesType	O
0:HasComponent	Object	PositionsPipeSupport		3:MeasuringDevicesType	O
0:HasComponent	Object	CalibrationZones		CalibrationZonesType	M

The *BrowseName* of the object instance shall be "Calibrator\_<Manufacturer>\_<SerialNumber>".

Example: "Calibrator\_battenfeld\_0123456".

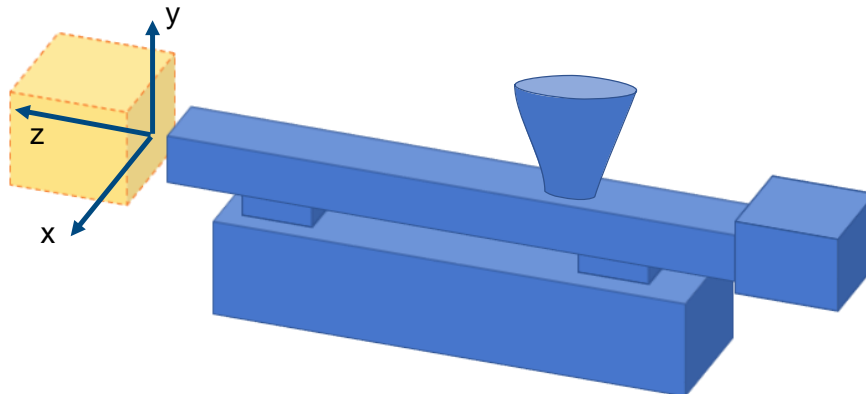
### 7.2 DeviceClass

The *DeviceClass* *Property* in the *MachineInformation* *Object* inside the *ExtrusionDeviceType* shall have the value "Calibrator".

### 7.3 PositionZ, PositionsX, PositionsY

These *Objects* represent the z-position and the several x- and y-positions of the calibrator. The *MeasuringDeviceType* and *MeasuringDeviceType* are defined in OPC 40083.

Definition of directions (from extruder output):



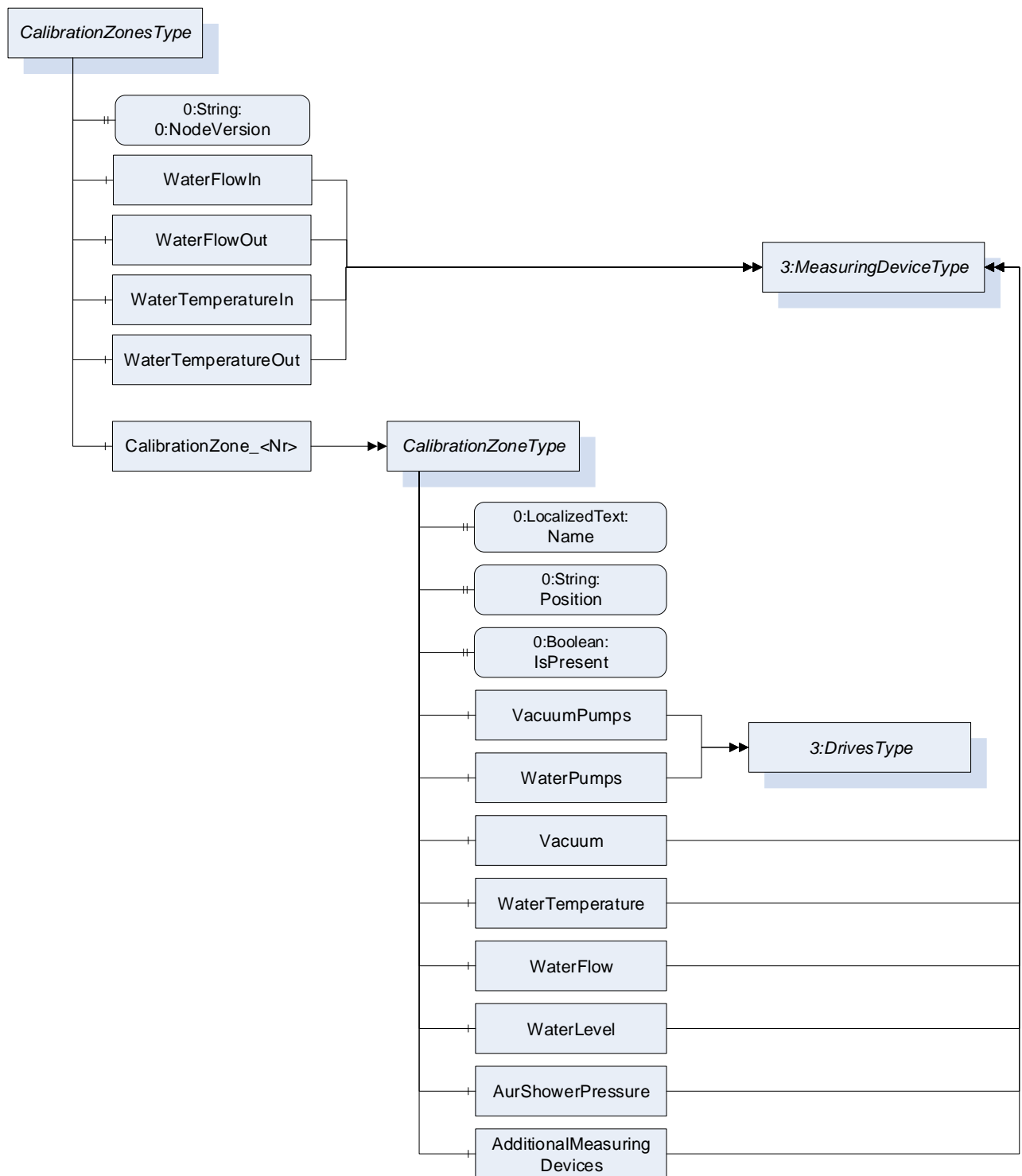
**Figure 2 – Definition of the direction of the x-, y- and z-positions of the calibrator**

### 7.4 PositionsPipeSupport

This *Object* represents the positions of a pipe support. The *MeasuringDeviceType* is defined in OPC 40083.

### 7.5 CalibrationZonesType

This *Object* is a container for the calibration zones but gives also information about the total water flow and water temperature.

**Figure 3 – CalibrationZonesType Overview**

**Table 2 – CalibrationZonesType Definition**

Attribute	Value				
BrowseName	CalibrationZonesType				
IsAbstract	False				
References	Node Class	BrowseName	Data Type	TypeDefinition	Other
Subtype of 0:BaseObjectType defined in OPC UA Part 5					
0:HasProperty	Variable	0:NodeVersion	0:String	0:PropertyType	M, RO
0:HasComponent	Object	WaterFlowIn		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterFlowOut		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterTemperatureIn		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterTemperatureOut		3:MeasuringDeviceType	O
0:HasComponent	Object	CalibrationZone_<Nr>		CalibrationZoneType	OP
0:GeneratesEvent	ObjectType	GeneralModelChangeEvent			

### 7.5.1 WaterFlowIn, WaterFlowOut

In and out Flow rate (in volume per time) of the water in the calibration zone. The used *MeasuringDeviceType* is defined in OPC 40083.

### 7.5.2 WaterTemperatureIn, WaterTemperatureOut

In and out temperature of the water in the calibration zone. The used *MeasuringDeviceType* is defined in OPC 40083.

### 7.5.3 CalibrationZoneType

This *Object* represents information about a single calibration zone.

**Table 3 – CalibrationZoneType Definition**

Attribute	Value				
BrowseName	CalibrationZoneType				
IsAbstract	False				
References	Node Class	BrowseName	Data Type	TypeDefinition	Other
Subtype of 0:BaseObjectType defined in OPC UA Part 5					
0:HasProperty	Variable	Name	0:LocalizedText	0:PropertyType	M, RW
0:HasProperty	Variable	Position	0:String	0:PropertyType	O, RO
0:HasProperty	Variable	IsPresent	0:Boolean	0:PropertyType	M, RO
0:HasComponent	Object	VacuumPumps		3:DrivesType	O
0:HasComponent	Object	WaterPumps		3:DrivesType	O
0:HasComponent	Object	Vacuum		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterTemperature		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterFlow		3:MeasuringDeviceType	O
0:HasComponent	Object	WaterLevel		3:MeasuringDeviceType	O
0:HasComponent	Object	AirShowerPressure		3:MeasuringDeviceType	O
0:HasComponent	Object	AdditionalMeasuringDevices		3:MeasuringDevicesType	O

#### 7.5.3.1 Name

Name of the calibration zone.

#### 7.5.3.2 Position

Position of the calibration zone.

#### 7.5.3.3 IsPresent

Indication if the calibration is present/used in the process

#### 7.5.3.4 VacuumPumps

Information about the vacuum pumps in the calibration zone. The *DrivesType* is defined in OPC 40083.

**7.5.3.5 WaterPumps**

Information about the water pumps in the calibration zone. The *DrivesType* is defined in OPC 40083.

**7.5.3.6 WaterTemperature**

Measurement of the water temperature in the calibration zone. The *MeasuringDevicesType* is defined in OPC 40083.

**7.5.3.7 WaterFlow**

Measurement of the water flow in the calibration zone. The *MeasuringDevicesType* is defined in OPC 40083.

**7.5.3.8 Water level**

Measurement of the water level in the calibration zone. The *MeasuringDevicesType* is defined in OPC 40083.

**7.5.3.9 AirShowerPressure**

Measurement of the pressure of the air shower in the calibration zone. The *MeasuringDevicesType* is defined in OPC 40083.

**7.5.3.10 AdditionalMeasuringDevices**

Container for any other measured values in the calibration zone.

**8 Profiles and Conformance Units**

This chapter defines the corresponding profiles and conformance units for the OPC UA Information Model for OPC 40084-10. *Profiles* are named groupings of conformance units. Facets are profiles that will be combined with other *Profiles* to define the complete functionality of an OPC UA *Server* or *Client*. The following tables specify the facets available for *Servers* that implement the OPC 40084-10 Information Model companion specification.

NOTE: The names of the supported profiles are available in the *Server Object* under *ServerCapabilities.ServerProfileArray*

Table 4 lists all Profiles defined in this document and defines their URIs.

**Table 4 – Profile URIs for OPC 40084-10**

Profile	URI
OPC 40084-10 Basic Server Profile	<a href="http://opcfoundation.org/UA-Profile/PlasticsRubber/Extrusion/Calibrator/Server/Basic">http://opcfoundation.org/UA-Profile/PlasticsRubber/Extrusion/Calibrator/Server/Basic</a>
OPC 40084-10 ProductionDatasetManagement Server Facet	<a href="http://opcfoundation.org/UA-Profile/PlasticsRubber/Extrusion/Calibrator/Server/ProductionDatasetManagement">http://opcfoundation.org/UA-Profile/PlasticsRubber/Extrusion/Calibrator/Server/ProductionDatasetManagement</a>

**Table 5 – OPC 40084-10 Basic Server Facet Definition**

Conformance Unit	Description	Optional/ Mandatory
OPC 40084-10 Basic	Support of <i>Calibrator_InterfaceType</i> and all mandatory child elements giving information on the calibrator itself and its components.	M
<b>Profile</b>		
ComplexType Server Facet (defined in OPC UA Part 7)		M
Standard Event Subscription Server Facet (defined in OPC UA Part 7)		M
Method Server Facet (defined in OPC UA Part 7)		M
BaseDevice_Server_Facet (defined in OPC UA Part 100)		M

**Table 6 – OPC 40084-10 ProductionDatasetManagement Server Facet Definition**

Conformance Unit	Description	Optional/ Mandatory
OPC 40084-10 ProductionDatasetManagement	Support of <i>ProductionDatasetManagementType</i> (defined in OPC 40083) for the management and transfer of recipes (= production datasets) between MES and calibrator	M

## 9 Namespaces

### 9.1 Namespace Metadata

Table 7 defines the namespace metadata for this specification. The *Object* is used to provide version information for the namespace and an indication about static *Nodes*. Static *Nodes* are identical for all *Attributes* in all *Servers*, including the *Value Attribute*. See Part 5 for more details.

The information is provided as *Object* of type *NamespaceMetadataType*. This *Object* is a component of the *Namespaces Object* that is part of the *Server Object*. The *NamespaceMetadataType ObjectType* and its *Properties* are defined in Part 5.

The version information is also provided as part of the *ModelTableEntry* in the *UANodeSet XML* file. The *UANodeSet XML* schema is defined in Part 6.

**Table 7 – NamespaceMetadata Object for this Specification**

Attribute	Value		
BrowseName	http://opcfoundation.org/UA/PlasticsRubber/Extrusion/Calibrator/		
References	BrowseName	DataType	Value
HasProperty	NamespaceUri	String	http://opcfoundation.org/UA/PlasticsRubber/Extrusion/Calibrator/
HasProperty	NamespaceVersion	String	1.00
HasProperty	NamespacePublicationDate	DateTime	2020-06-01 00:00:00
HasProperty	IsNamespaceSubset	Boolean	False
HasProperty	StaticNodeIdTypes	IdType[]	{Numeric}
HasProperty	StaticNumericNodeIdRange	NumericRange[]	Null
HasProperty	StaticStringNodeIdPattern	String	Null

### 9.2 Handling of OPC UA Namespaces

Namespaces are used by OPC UA to create unique identifiers across different naming authorities. The *Attributes NodeId* and *BrowseName* are identifiers. A *Node* in the *UA AddressSpace* is unambiguously identified using a *NodeId*. Unlike *NodeIds*, the *BrowseName* cannot be used to unambiguously identify a *Node*. Different *Nodes* may have the same *BrowseName*. They are used to build a browse path between two *Nodes* or to define a standard *Property*.

*Servers* may often choose to use the same namespace for the *NodeId* and the *BrowseName*. However, if they want to provide a standard *Property*, its *BrowseName* shall have the namespace of the standards body although the namespace of the *NodeId* reflects something else, for example the *EngineeringUnits Property*. All *NodeIds* of *Nodes* not defined in this document shall not use the standard namespaces.

Table 8 provides a list of mandatory and optional namespaces used in an OPC 40084-10 OPC UA *Server*.

**Table 8 – Namespaces used in an OPC 40084-10 Server**

NamespaceURI	Description	Use
http://opcfoundation.org/UA/	Namespace for <i>NodeIds</i> and <i>BrowseNames</i> defined in the OPC UA specification. This namespace shall have namespace index 0.	Mandatory
Local Server URI	Namespace for nodes defined in the local server. This may include types and instances used in a device represented by the server. This namespace shall have namespace index 1.	Mandatory
http://opcfoundation.org/UA/DI/	Namespace for <i>NodeIds</i> and <i>BrowseNames</i> defined in OPC UA Part 100. The namespace index is server specific.	Mandatory
http://opcfoundation.org/UA/PlasticsRubber/GeneralTypes/	Namespace for <i>NodeIds</i> and <i>BrowseNames</i> defined in OPC 40083. The namespace index is server specific.	Mandatory
http://opcfoundation.org/UA/PlasticsRubber/Extrusion/GeneralTypes/	Namespace for <i>NodeIds</i> and <i>BrowseNames</i> defined in OPC 40084-1. The namespace index is server specific.	Mandatory
http://opcfoundation.org/UA/PlasticsRubber/Extrusion/Calibrator/	Namespace for <i>NodeIds</i> and <i>BrowseNames</i> defined in this specification. The namespace index is server specific.	Mandatory
Vendor specific types and instances	A server may provide vendor specific types like types derived from <i>MachineType</i> or <i>MachineStatusType</i> or vendor specific instances of devices in a vendor specific namespace.	Optional

Table 9 provides a list of namespaces and their index used for *BrowseNames* in this specification. The default namespace of this specification is not listed since all *BrowseNames* without prefix use this default namespace.

**Table 9 – Namespaces used in this specification**

NamespaceURI	Namespace Index	Example
http://opcfoundation.org/UA/	0	0:NodeVersion
http://opcfoundation.org/UA/DI/	2	2:DeviceClass
http://opcfoundation.org/UA/PlasticsRubber/GeneralTypes/	3	3:MachineInformationType
http://opcfoundation.org/UA/PlasticsRubber/Extrusion/GeneralTypes/	4	4:ExtrusionDeviceType

## Annex A (normative)

### OPC 40084-10 Namespace and mappings

#### A.1 Namespace and identifiers for OPC 40084-10 Information Model

This appendix defines the numeric identifiers for all of the numeric *NodeIds* defined in this specification. The identifiers are specified in a CSV file with the following syntax:

<SymbolName>, <Identifier>, <NodeClass>

Where the *SymbolName* is either the *BrowseName* of a *Type Node* or the *BrowsePath* for an *Instance Node* that appears in the specification and the *Identifier* is the numeric value for the *NodeId*.

The *BrowsePath* for an *Instance Node* is constructed by appending the *BrowseName* of the instance *Node* to the *BrowseName* for the containing instance or type. An underscore character is used to separate each *BrowseName* in the path. Let's take for example, the *MachineInformationType ObjectType Node* which has the *ControllerName Property*. The **Name** for the *ControllerName InstanceDeclaration* within the *MachineInformationType* declaration is: *MachineInformationType\_ControllerName*.

The *NamespaceUri* for all *NodeIds* defined here is <http://opcfoundation.org/UA/PlasticsRubber/Extrusion/Calibrator/>

The CSV released with this version of the specification can be found here:

- <http://www.opcfoundation.org/UA/schemas/PlasticsRubber/Extrusion/Calibrator/1.00/NodeIds.csv>

NOTE: The latest CSV that is compatible with this version of the specification can be found here:

- <http://www.opcfoundation.org/UA/schemas/PlasticsRubber/Extrusion/Calibrator/NodeIds.csv>

A computer processible version of the complete Information Model defined in this specification is also provided. It follows the XML Information Model schema syntax defined in Part 6.

The Information Model Schema released with this version of the specification can be found here:

- <http://www.opcfoundation.org/UA/schemas/PlasticsRubber/Extrusion/Calibrator/1.00/Opc.Ua.PlasticsRubber.Extrusion.Calibrator.NodeSet2.xml>

NOTE: The latest Information Model schema that is compatible with this version of the specification can be found here:

- <http://www.opcfoundation.org/UA/schemas/PlasticsRubber/Extrusion/Calibrator/Opc.Ua.PlasticsRubber.Extrusion.Calibrator.NodeSet2.xml>

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