

Abstract

An object of the present invention is to provide a processing control system that externally monitors and manages CNC control devices, with which machine devices operating by various NC programs are able to communicate, in a unified manner regardless of communication schemes and variables. The centralized processing control system is configured such that a communication scheme and variable correspondence table indicating communication schemes and macro variable names of NC programs corresponding to machine devices and a unified communication scheme and macro variable name corresponding to the centralized processing control system is stored and updated, and once a request for reading operation information of an arbitrary machine device is provided, the centralized processing control system performs translation into a communication scheme and a macro variable name in accordance with content of the request for reading and the machine device, transmits a calling instruction to a CNC control device of the machine device of the request for reading, and outputs a response numerical value of the macro variable called in response to reception of the instruction as a response numerical value of the communication scheme and the macro variable name of the present system.