



TECHNOTE!

Dynapath

Created 3/9/2011 RHL

CNC Settings

Please note! The following information comes from our many years of experience in setting up RS-232 communications with this CNC. However, our experience also has taught us that many times same model CNC's differ from each other. So, please double-check this information in the Operator or Maintenance or Parameter manual that came with your machine.

Setup the CNC to 9600 baud, 7 bits, 2 stop bits

DNC Parameters

1. Set the DNC machine properties as follows: The protocol is Generic RS-232, the Data Type is ASCII. Communication settings are 9600, Even, 7 bits, 2 stop bits Xon/Xoff Wait. If you use the remote command language for requesting files from your CNC control panel see Remote Command Technote.

Wiring

Use 24 AWG stranded, low capacitance computer cable with an overall shield (foil is fine and easier to work with.)

CNC (9 pin socket)	DNC COM port (25 pin socket)
1-----	shield
3-----	3
2-----	2
8-----	5
7-----	4
5-----	7

CNC (9 pin socket)	DNC COM port (9 pin socket)
1-----	shield
2-----	2
3-----	3
7-----	8
8-----	7
5-----	5

For more information call, Fax, email or visit our web site:

CAD/CAM Integration, Inc.
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Sending a file to the Dynapath (DNC to CNC)

If you are manually queuing files, then at a workstation running SuiteFactory, queue up the file you want to send to the CNC.

Note: Data gets sent to the active part program memory and will overwrite anything that is there already. **MAKE SURE YOU SAVE WHAT IS IN MEMORY IF NEEDED.**

Press MODE SELECT

Press 8 – Transmit/Receive

Set Source Device to S1 - Serial Port COM1

Set Target Device to T4 – Part Program Memory

Press (START OPERATION) soft key

The program will now be sent from the SuiteFactory database to the Dynapath's memory.

Receiving a file from the FANUC (CNC to DNC)

If you are manually queuing files then at a workstation running SuiteFactory, select or enter the filename you want and click Receive.

If you are using Remote Requests you can simply go to the CNC and punch out the program you want to save. If you have embedded a (SAVE filename) line in your program, the file will be saved with that filename. If there is not embedded SAVE command then the file will be saved and given a date/timestamp name which you can change latter.

Press MODE SELECT

Press 8 – Transmit/Receive

Set Source Device to S4 – Part Program Memory

Set Target Device to T1 – Serial Port COM1

Press (START OPERATION) soft key

Data will now be sent to the SuiteFactory database.

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