

TECHNOTE! CNC RS-232 Parameters Fanuc 0 Mate

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.

1. Put the CNC in MDI mode.
2. Select the Setting(Handy) screen by pressing the Setting button.

Set:

Tvon=0
 ISO=1
 I/O=0 (parameters 0002 and 0552 are effective)
 Or
 I/O=1 (parameters 0012 and 0553 are effective)
 Or rarely
 I/O=2 (parameters 0050 and 0250 are effective)
 Or rarely
 I/O=3 (parameters 0051 and 0251 are effective)

Set PWE = 1

3. Select the Parameter screen by pressing the Parameter button. Set the following parameters:
(Parameter bits not related to RS-232 communications are represented by an "x" and should not be changed.)

0002 and 0012 and (if present) 0050 and 0051 = 1xxxx0x1
 0552 and 0553 and (if present) 0250 and 0251 = 11 (9600 baud)
Return to the Setting screen and set PWE = 0.

DNC Parameters

4. 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, both-no-wait. If you use the CCL command language for requesting files from your CNC control panel see CCL Technotes.

Wiring

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

CNC (25 pin plug)	DNC COM port (25 pin socket)
1-----	shield
2-----	3
3-----	2
4-----	5
5-----	4
7-----	7
6-----	
8-----	
20-----	