

TECHNOTE!

Fanuc 16/18/20/21

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 controls do not necessarily match the standard. 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 or emergency stop state.
2. Select the Setting(Handy) screen by pressing the Setting button and/or the Setting soft key.

Set TV check to OFF.
Set Punch code to ISO.

3. To change parameter values, set Parameter Write to 1 by moving the cursor to the Parameter Write line, pressing the OPRT soft key, then pressing the ON:1 soft key or entering 1 then pressing the Input soft key. To change parameter values enter the data and then press the Input soft key.
(Parameter bits not related to RS-232 communications are represented by an "x" and should not be changed.)

0000=xxxxxx10 (ISO/TV check off)
0020=0 or 1 (If connecting to channel 1. (2 for channel 2 or 3 for channel 3))
0100=xxxx1xxx (Out put LF as end of block when punching)

If 0020=0 (physical port 1)
0101=1xxx0xx1 (Do not output feed holes, use ISO, 2 stop bits)
0102=0 (Use DC codes)
0103=11 (9600 baud)

If 0020=1 (physical port1)
0111=1xxx0xx1 (Do not output feed holes, use ISO, 2 stop bits)
0112=0 (Use DC codes)
0113=11 (9600 baud)

If 0020=2 (physical port 2)
0121=1xxx0xx1 (Do not output feed holes, use ISO, 2 stop bits)
0122=0 (Use DC codes)
0123=11 (9600 baud)

If 0020=3 (physical port 3)
Note port 3 is used for special, optional protocols. Refer to your Fanuc manual.
0131=1xxx0xx1 (Do not output feed holes, use ISO, 2 stop bits)
0132=0 (Use DC codes)
0133=11 (9600 baud)
0134 and 0135 must also be set. See Fanuc manual.

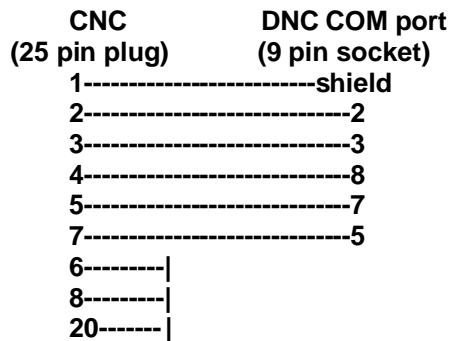
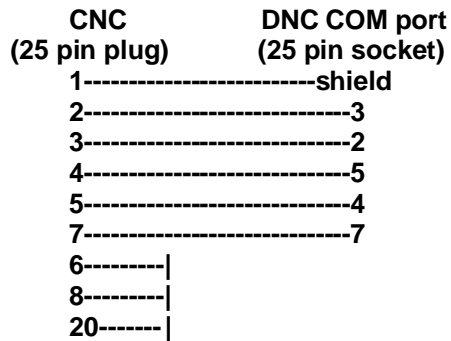
For more information call, Fax, email or visit our web site:

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- Set the DNC machine properties to 9600, Even, 7 bits, 2 stop bits, both-no-wait. The protocol is Generic RS-232.

Wiring

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



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