

FAGOR



Fagor Automation Corp.

2250 Estes Avenue

Elk Grove Village, IL 60007

Tel: 847-981-1500

Fax: 847-981-1311

FAX MESSAGE

ATTENTION:

FROM:

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DATE: / / 1997

FAX:

TEL:

RE: RS232 Serial Line communication for 800 CNC

As per our conversation I am faxing you the information on RS232 communication settings. For example when working with ProComm or with your CAM software you will use General Device type of communication. Follow the format of part program files to be sent. When working with Fagor DNC software the CNC can be in any operating mode when communicating with the PC.

To create special ASCII characters you can use ProComm internal editor and combination of ALT key + number of the code from numerical keyboard. It is very important to add EOT character at the end of the file to properly terminate communication.

If you have any more questions please call me,

With Regards

RS232 Serial Line Communication Parameters:

MILL: 800 M, MG		LATHE: 800 T, TG
P0	Transmission speed (baudrate). Values Possible: 110, 150, 300, 600, 1200, 2400, 4800, 9600	P0
P1	Data bits per character 7 (7 least significant bits of character) 8 (all 8 bits of character, use this when for ASCII code over 127)	P1
P2	Parity 0=None, 1=Odd, 2=Even	P2
P3	# of Stop Bits 1=1 Stop Bit, 2=2 Stop Bits	P3
P607(7)	Status Report by Interruption 0=Not active, 1=Active	P606(8)
P607(6)	CNC does not abort DNC communication CNC will abort DNC communication if more than 30 sec elapse without receiving data, or more than 3 incorrect acknowledgements occur in a row. 0=Aborts, 1=Does not abort	P605(8)
P607(5)	DNC Active on Power-Up 0=Not Active, 1=Active	P605(7)
P607(4)	Type of Communication, DNC or Fagor Cassette 0=Communication with Fagor Cassette. In this case parameters P0, P1, P2 and P3 are not used. 1=DNC or General Device communication. Baudrate, Data bits, Parity and Stop bits set by P0, P1, P2, P3	P605(6)
P607(3)	DNC Availability 0=DNC function not available 1=DNC function available	P605(5)

It is suggested to set the 800 machine parameters for the serial port to: 9600 baudrate, 8 data bits, 1 stop bit, and the parity set to NONE.

NOTE:

To change parameters follow the keystrokes:

Very important: Press [RESET] key twice for CNC to accept the change.

G Codes Part Program File Format:

The 800 G code part program MUST begin with the % sign followed by a 99996 number (only this number can be used). Use this number for Part Program Name when working with General Device type of communication. The part program example follows:

```
%99996 <LF>
N10 G0 X0 <LF>
N20 X1.5<LF>
N30 M30 <LF>
<EOT>
```

NOTE:

The part program can also end with an <ESC> character or a series of 20 <NUL> characters.

<NUL> = ASCII (0) NUL Character = CTRL+@

<EOT> = ASCII (4) End of Tape Character = CTRL+D

<LF> = ASCII (10) Line Feed Character = CTRL+J

<ESC> = ASCII (27) Escape Character

NOTE: The ALT key + code of the character can also be used.

Serial Port Cable Connection CNC - PC

