

RS232 Serial Line Communication Parameters:

MILL: 8025/30 M, GP		LATHE: 8025/30 T
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 8025/30 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:

OP MODE **9** **1** **xxx** **RECALL** **xxx** **=** **new value** **ENTER**

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

Part Program File Format:

The 8025/30 part program MUST begin with the % sign followed by a 5 digit part program number. Use this number for Part Program Name when working with General Device type of communication. The part program example follows:

```
%12345 <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

