

# Procedure to Setup Workstations (NT) for Access to FAGOR CNC 8055/ABC with TCP/IP:

## 1. Setup Fagor CNC 8055 HDE Machine Parameters - example below:

```
P0 (HDDIR) = C:\CNC\USER
P2 (CNID) = NLSCNC1 (name of the machine in plant)
P3 (CNGROUP) = WORKGROUP
P6 (CNHDDIR1) = \CNC\USER (hard disk directory)
P21 (SERUNI2) = E
P22 (DNCEACT) = 1
P23 (IPTYPE) = 0
P24 ( DIRIP) = 172.16.1.81 (IP address of CNC)
P25 (NETMASK) = 255.255.255.0 (Subnet Mask)
P26 (IPGATWAY) = 172.16.1.XX (IP of Default Gateway)
P27 (IPSWDNC) = 172.16.1.80 (IP address of computer with
WINDNC)
*P28 (IPSNFS) = 172.16.1.80 (IP address of computer with
remote hard drive)
*P29 (IPRNFS) = /C
```

\*\*\*\* P28 and P29 is only used for Remote Hard Drive. If the remote hard drive will not be used leave the parameters in default. You will see a error on startup “communication error with hard drive”. This will appear until you install the software on your PC needed for remote hard drive communication.

## 2. Checking communication with CNC:

- Login as Administrator on your PC.
- Right click on START then select RUN.
- Under open type CMD then press enter or execute the command prompt from your programs.
- Once the command prompt is open type in PING followed by parameter 24.

Example: ping 172.16.1.81 (If connection is made you will see the following)

```
Reply from 172.16.1.81: bytes=32 time=8ms TTL=255
Reply from 172.16.1.81: bytes=32 time=3ms TTL=255
Reply from 172.16.1.81: bytes=32 time=4ms TTL=255
Reply from 172.16.1.81: bytes=32 time=8ms TTL=255
```

- Setup WINDNC4.1 to communicate with CNC thru TPC/IP.

## 8040 / 8055 ETHERNET SETUP AND COMMUNICATION

\*\*\*Note: Use must use a crossover cable for a point to point connection. If you are connecting to HUB you must use a straight thru cable.

### Installation of software

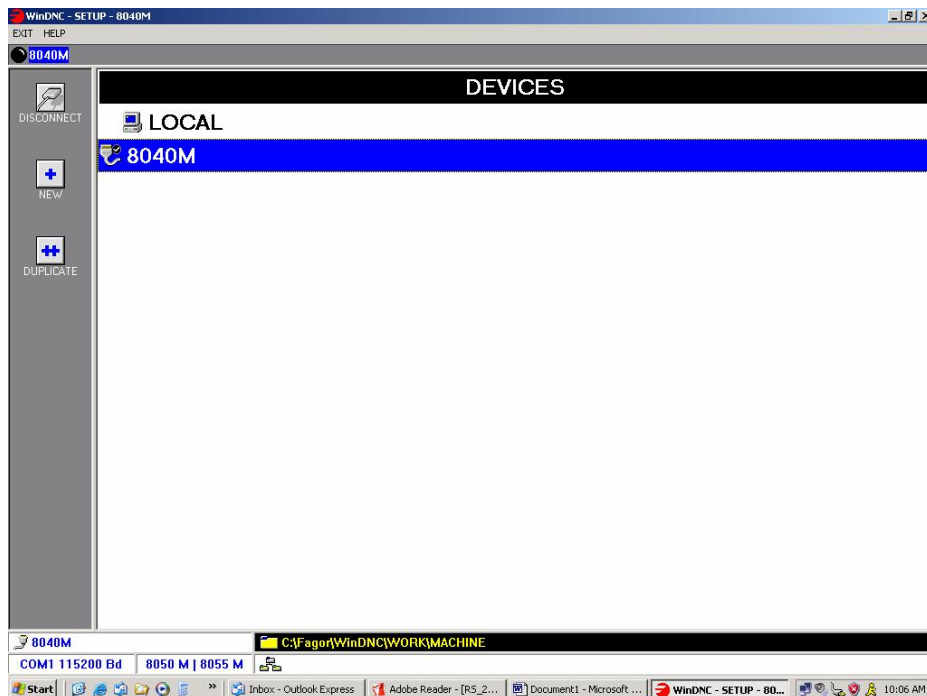
- Go to the following website: [www.fagorautomation.com](http://www.fagorautomation.com) and down load the free copy of WINDNC.
- Once you have downloaded the file double click on WinDNC\_V04\_01.exe and follow the instructions

### Setup of software

- Go to start and select from the list WinDnc ver4.1
- Once the software is open go to **OPTIONS**
- Under **FILE SENDING** select file loading + deleting
- Click the check mark icon
- Go to **SETUP**
- Click on **NEW**
- Under **NAME** click on “NEW” and enter a name. Example “8040M” then press ENTER.
- Under **MODEL** select the type of control that you are working with. Example “8050M / 8055M”. You would select this option for a CNC 8040M.
- Under **TYPE** select Network Node.
- No need to do anything with connect on startup.
- Under **IP ADDRESS**, Use the value of Ethernet parameter 24. example “ 172.16.1.81”
- Double click under **WORK FOLDER** and navigate to c:/fagor/windnc/work. While the Work folder is highlighted click on **NEW**. Type in the name of the folder where all of your information will be saved to. Example “machine”

- Once the folder “machine” has been created , you must click select. The work folder should now read as c:/fagor/windnc/work/machine
- Click the **OK** icon
- Under devices highlight 8040M, then click on **SELECT**, then click **CONNECT**

\*\*\*\*The screen should look like this:



\*\*\*\*note this only need to be created once. You can now go to any 8040 M / 8050 M / 8055M control and establish communication .

### Setup of parameters on CNC

- Go to the G code side of control. Press shift then escape to change between G-Code and conversational.
- From the **MAIN MENU** press **F7 (+)**
- Go to **MACHINE PARAMETERS (F4)**
- Go to **SERIAL PARAMETERS (F3)**
- Select **ETHERNET (F3)**

\*\*\*\* Note: The parameters should be modified to the following:

PARAMS. HD/ETHERNET		P.....N....	DNC E 2	19-11-24
I0 HOME ALL AXIS				
PARAMETER	VALUE	NAME		
P019		//	NODREQ2	
P020		//	REQPAS2	
P021	E	//	SERUMI2	
P022	1	//	DNCEACT	
P023	0	//	IPTYPET	
P024	172.16.1.81	//	DIRIP	
P025	255.255.255.0	//	NETMASK	
P026	0.0.0.0	//	IPGATWAY	
P027	172.16.1.80	//	IPSWDNC	
P028	0.0.0.0	//	IPSNFS	
P029		//	DIRNFS	
P030	00000	//	MACID	
P031	00000	//	ETHEINLE	

CAP INS					
EDIT	MODIFY	FIND	INITIALIZE	LOAD	SAVE

\*\*\*\*Once the parameters have been modified make sure you re-start the control, so the parameters take effect.

\*\*\*\*Description of options for WINDNC can be found in the following directory of your computer: C:\Fagor\Help\WinDnc\English\WinDNC.html