

CNC Parameters

The parameters and settings shown here are for 6-A series controls only.

To change parameters on any 6-series control, you must first turn on a parameter write-enable toggle switch on the CNCs main (mother) board. This switch is clearly marked on the board, and must not be confused with the bubble memory free-mode (BMU) switch, also on the main mother board. When you turn on the Parameter Write/Enable switch, the CNC will display the alarm page. An alarm #100 is displayed until the Parameter Write/Enable switch is turned off and the RESET button is pressed. Automatic operation is inhibited while the Parameter switch is on.

With the Parameter Write/Enable switch turned on, and the mode-select switch in MDI mode, press the PARAM button, and page down to parameter 24. The settings shown here are for 4800 baud, 1 stop-bit, DC codes enabled (Xon/Xoff). The bits marked "x" are for another purpose, or not assigned. Don't change these.

002 x x 1 x x x x

024 x x x x x x 0 (0 = 1 stop bit, 1 = 2 stop bits)

025 1 1 1 0 1 1 1 (4800 baud. See chart in Maint. manual)

026 0 x x x x x x (0 = use DC codes, 1 = don't use DC codes)

To change any of these parameters, first key in the letter "P", then enter your new data, then press INPUT. Binary parameters are keyed in left-to-right as shown.

Once these parameters are entered, turn off the Parameter Write/Enable toggle switch, and press the RESET button to clear the Alarm #100. Also check the settings on the first SETTING screen, and be sure they are set as shown below. Display the settings by pressing the SET key.

TV CHECK = 0

PUNCH CODE = 1

INPUT UNIT = (doesn't matter)

INPUT DEVICE 1 = 0

INPUT DEVICE 2 = 1

PC DNC Settings

Baud: 4800

Code: 7 data bits / ASCII Even

Stop Bits: 1
EOB: LF
Handshaking: XON/XOFF

ADVANCED

Leader: %LF
Trailer: %
Skip lines which contain: %

Additional Notes

The Fanuc 6-A series controls are different from the B and C series controls in several important ways. The A series controls can be identified by the fact that they have only one output plug under a small hinged cover. This control was usually shipped with a 20-pin Honda connector, which was used for the Facit 4070 and TTY output signals.

If your control has only one connector, and it is a 25-pin D-shell connector (DB25S), then you're in luck, because your CNC has an optional serial port already installed. If your control has only a 20-pin, blue plastic Honda connector, you will have to convert it to RS232 before proceeding with a DNC connection.

Converting a 6T-A or 6M-A control from Facit/TTY to RS232

CNC Applications can provide a conversion kit consisting of the parts and instructions needed for converting the Facit port to RS232 on a Fanuc 6a controller. If you are interested in this kit, please give us a call.