

CNC Parameters

A15 - 206 (No parity, 2 stop bits, 8 data bits)
A16 - 1 (RS232 parameter for serial tape?)
A17 - 6 (CMT baud rate 4800)
A18 - 6 (EIA baud rate 4800)
A19 - 0 (Tape rewind code)
A20 - 1 (Output ISO)
A21 - 0 (Spaces between work # & data)
A22 - 0 (Spaces between programs)
A23 - 0 (Leader / trailer in feet)
A24 - 0 (Tape Vertical Parity Check = off)
A29 bit 0 - 0 (Don't stop at O or :)
A29 bit 1 - 1 (Stop at M02)
A30 bit 0 - 1 (Serial reader on)
A30 bit 1 - 1 (Serial punch on)
A30 bit 2 - 0 (Parallel reader off)
A30 bit 3 - 0 (Parallel punch off)
Remember: Bit 0 is the RIGHTmost bit
A31 - 109 ("#" code for EIA punch)
A32 - 70 (":" code for EIA punch)

PC DNC Settings

Baud: 4800
Code: 7 data bits / ASCII Even
Stop Bits: 2
EOB: CR/LF
Handshaking: XON/XOFF

ADVANCED

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

Additional Notes

Note: The transfer of Mazatrol programs with CMT IO requires PC-DNC plus 3.3.1 or later.

When transferring to / from this CNC, it is recommended that you use a hardware handshake cable. Diagram:

PC 9-pin to CNC 25-pin:
PC(2) to CNC(2)
PC(3) to CNC(3)
PC(7) to CNC(5)

PC(8) to CNC(4)
PC(5) to CNC(7)
Jumper 6,8,20 on CNC side only
Attach cable shield to pin 1 on CNC side only

PC 25-pin to CNC 25-pin:
PC(2) to CNC(3)
PC(3) to CNC(2)
PC(4) to CNC(5)
PC(5) to CNC(4)
PC(7) to CNC(7)
Jumper 6,8,20 on CNC side only
Attach cable shield to pin 1 on CNC side only

Steps for transferring CNC to PC (EIA programs):

EIA.1 Press PROGRAM softkey
EIA.2 Press PROGRAM FILE softkey
EIA.3 Press DATA IN OUT softkey
EIA.4 Press TAPE I/O softkey
EIA.5 Press PUNCH NC TAPE softkey
EIA.6 Enter work #
EIA.7 Press INPUT
EIA.8 Repeat 6/7 for addl. Work #'s
EIA.9 Press START

Steps for transferring CNC to PC (Mazatrol programs):

MAZ.1 Press PROGRAM softkey
MAZ.2 Press PROGRAM FILE softkey
MAZ.3 Press DATA IN OUT softkey
MAZ.4 Press CMT I/O softkey
MAZ.5 Press SAVE CMT softkey
MAZ.6 Enter work #
MAZ.7 Press INPUT
MAZ.8 Repeat 6/7 for addl. Work #'s
MAZ.9 Press START

Steps for transferring PC to CNC (EIA programs):

EIA.1 Press PROGRAM softkey
EIA.2 Press PROGRAM FILE softkey
EIA.3 Press DATA IN OUT softkey
EIA.4 Press TAPE I/O softkey
EIA.5 Press ALL LOAD NC<-TAPE
EIA.6 Press START

Steps for transferring PC to CNC (Mazatrol programs):

MAZ.1 Press PROGRAM softkey

- MAZ.2 Press PROGRAM FILE softkey
- MAZ.3 Press DATA IN OUT softkey
- MAZ.4 Press CMT I/O softkey
- MAZ.5 Press LOAD CMT softkey
- MAZ.6 Enter work #
- MAZ.7 Press INPUT
- MAZ.8 Press START

Tip: To avoid keying in program #'s for Mazatrol input, use the DATA IO -> CMT -> CMT CONTENTS function to load file contents onto the screen. Then select LOAD NC <- CMT and click START. Values will remain filled in for you.

Steps for setting parameters in the CNC:

- 1 Press LEFT PAGE key
- 2 Press PARAM softkey
- 3 Cursor to parameter
- 4 Key in new value
- 5 Press INPUT
- 6 POWER DOWN CNC