

Adjustments in the CNC for RS232C communication.

The following are the parameter settings more usual in the CNC of the “i” Series (0i, 16i, 18i, 21i, 30i, 31i, 32i...) for RS232C communication.

For the procedure of display or alter the parameters of CNC, or other operations, consult the manual of CNC or with the machine manufacturer.

RECOMMENDED PARAMETER SETTING:

	#7	#6	#5	#4	#3	#2	#1	#0
0000							ISO	

Standard Selection:

ISO=1

This adjustment must correspond with the next one in the PC:

- data bits: 7 bits

- parity: Even

0020	I/O CHANNEL: Selection of an input/output device or selection of input device in the foreground
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0 : Channel 1 (serial port 1 RS-232-C)

1 : Channel 1 (serial port 1 RS-232-C)

2 : Channel 2 (serial port 2 RS-232-C)

Standard Selection: 0 (E/S =0 the setting screen)

	#7	#6	#5	#4	#3	#2	#1	#0
0101	NFD				ASI			SB2

Standard Selection:

NFD =1

ASI =0

SB2=1 (2 stop bits → Should correspond to the setting in the PC.)

0102	Number specified for the input/output device (when the I/O CHANNEL is set to 0)
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Standard Selection: 0

0103	Baud rate (when the I/O CHANNEL is set to 0)
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- 9: 2400 Bauds
- 10: 4800 Bauds
- 11: 9600 Bauds
- 12: 19200 Bauds

Standard Selection: 11

Has to correspond with the adjustment on the PC: (Speed = 9600)

Example of adjustment in the PC:

