

Serial Cable Pin Configuration

The HFB Machine

The FS and LD Machines

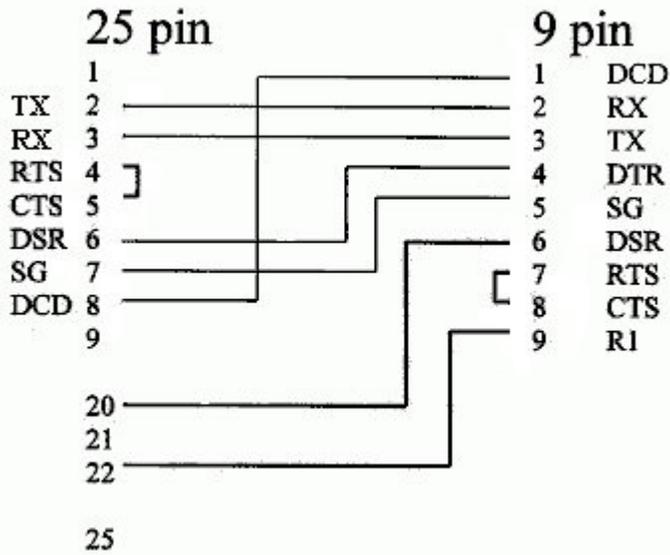
Cable Connection

The Ex Machine

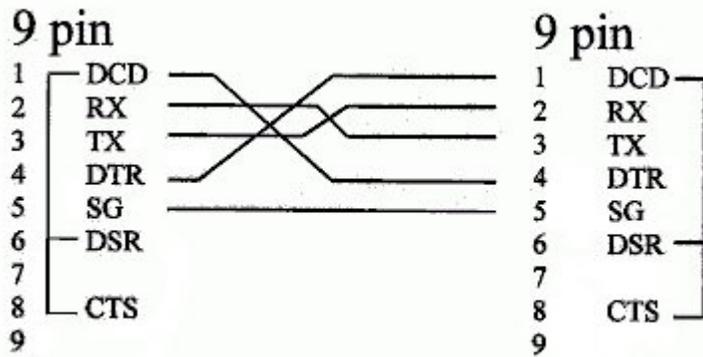
The Blanking Machine

The HFB Machine

The connection cable wiring configuration required between the HFB control and the PC, using a 25-pin and 9-pin RS-232 interface:

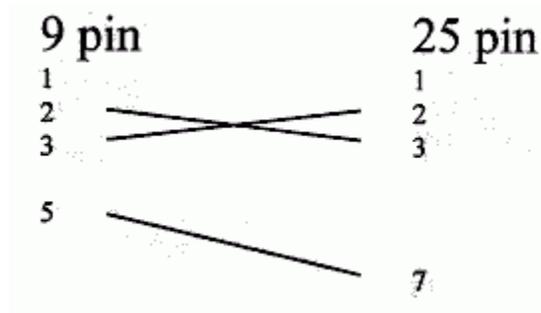


The connection cable wiring configuration required between the HFB control and the PC, using two 9-pin RS-232 interface connections:

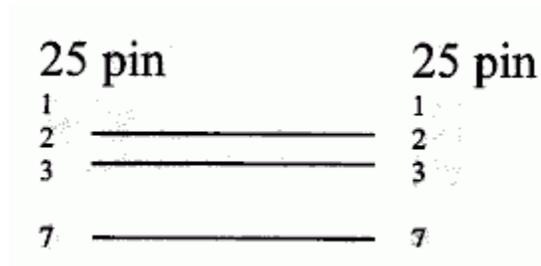


The Ex Machine

The connection cable wiring configuration between the Ex control and the PC, using a 25-pin and 9-pin RS-232 interface:

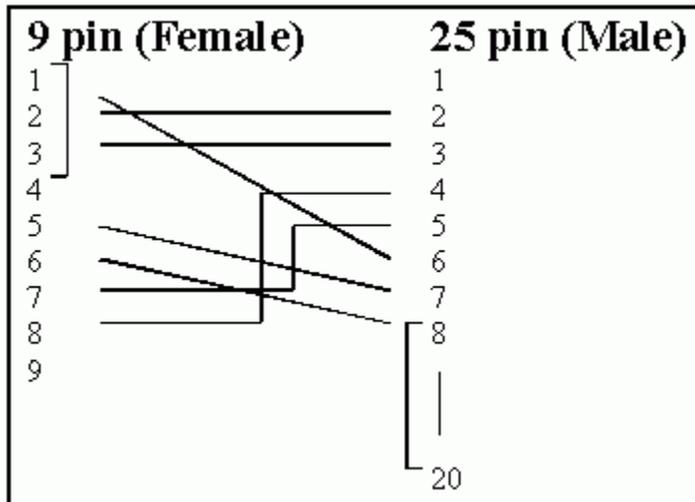


The connection cable wiring configuration required between the Ex control and the PC, using two 25-pin RS-232 interface connections:



The FS and LD Machines

The connection required between the PC and the FS or LD control, using a 9-pin and 25-pin RS-232 interface, is the GS/F/FS wiring configuration as indicated below:

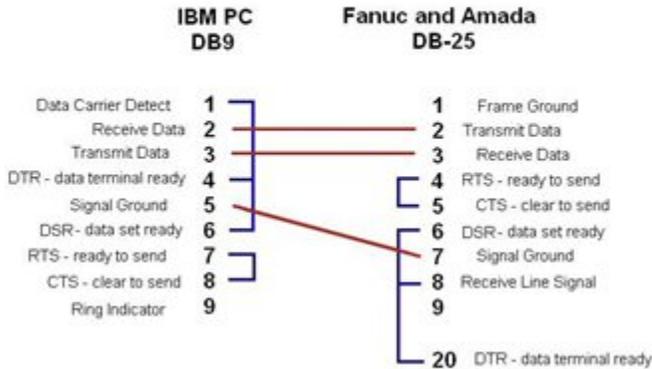


The Blanking Machine

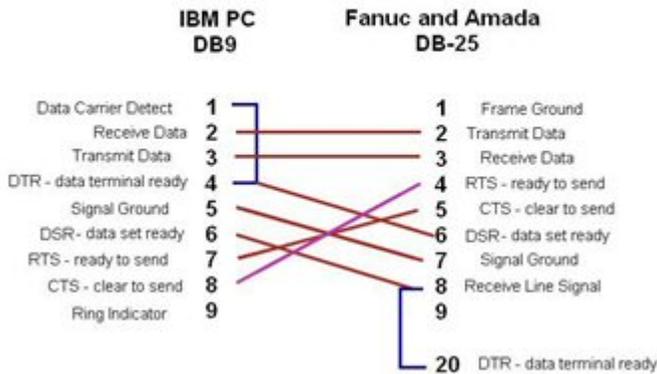
Serial RS-232 Communication Ports

DNC communication uses serial RS-232 communication ports to send and receive data. The connectors can be either 9-pin or 25-pin.

RS232 CABLE CONFIG for LOOP-BACK CABLE

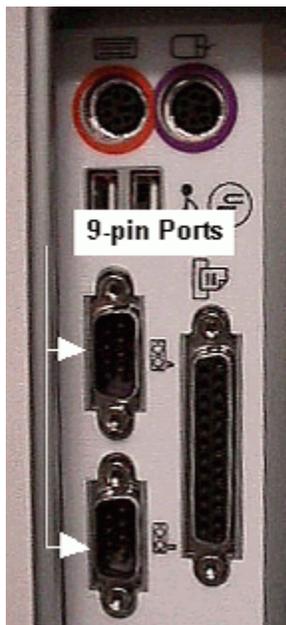
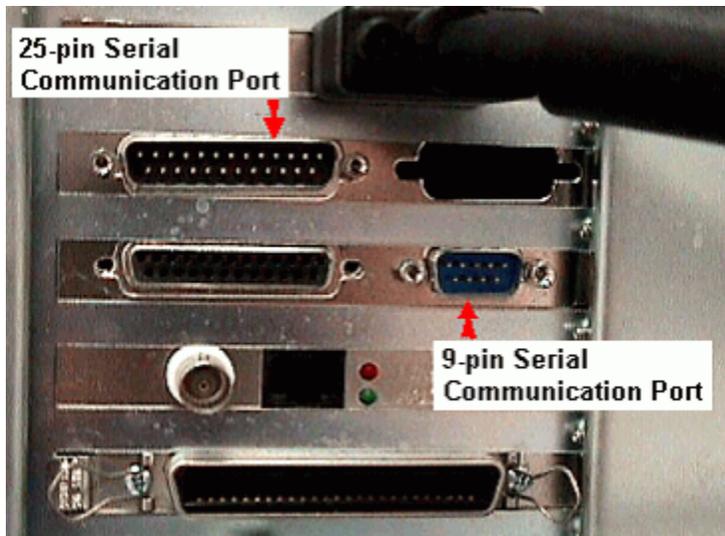


RS232 CABLE CONFIG for FULL HANDSHAKING



Serial Communication Ports – Host Computer

Serial communication ports, also known as "COM" ports, support simplex, rather than duplex communication protocols. Your host computer is probably configured with more than one communication or COM port. The COM ports are often labeled COM 1, COM 2, COM 3, etc. A typical IBM-PC compatible computer has two serial communication ports, i.e., COM1 and COM2, as part of the hardware configuration. Sometimes these ports are labeled as serial ports "A" and "B". Legacy computers have a different communication port arrangement than that of newer computer systems, but function the same.



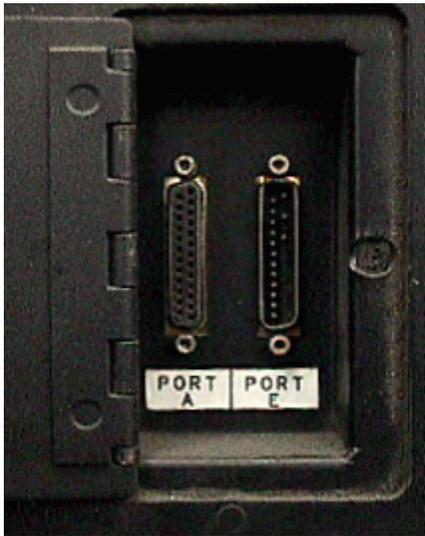
COM1 can be a 9-pin port while COM2 can be a 25-pin port. A simple converter can be used to convert a 9-pin to a 25-pin port or, a 25-pin port can be converted into a 9-pin port.

If you assign a node to use COM1, your computer will send and receive data through only COM1 whenever you use this particular node. Make sure you do not assign nodes to a communication port (COM) that are used by devices such as mice, modems, etc., because it may crash your computer when you try to use FabriTALK.

For example, if you assign the node "FANUC 6M" to COM1, every time that you use the "FANUC 6M" node your computer uses the serial communication port 1 (or COM1) to communicate with the CNC machine via the cable. However, if a mouse is being used on COM1, the computer may lockup. Therefore it is important that you know which serial communication port (or COM) you want to use for a particular node.

Serial Communication Ports – CNC Machines

The communication port on your CNC machine is likely to be a male connector. Some controls use 9-pin male connectors while others use 25-pin male connectors.



Some controls have more than one communication port. It is important that you know for what purpose each port is used. If you do not know, reference the user manual for that control. If necessary, call the manufacturer for information about the communication ports on your CNC machine.

The DNC Cable

For FabriTALK to work with your control, you need the appropriate DNC cable with a specific wiring configuration for your control. If your cable does not come as part of the software, or if you are unsure, call technical support or the sales department.

Cable Connection



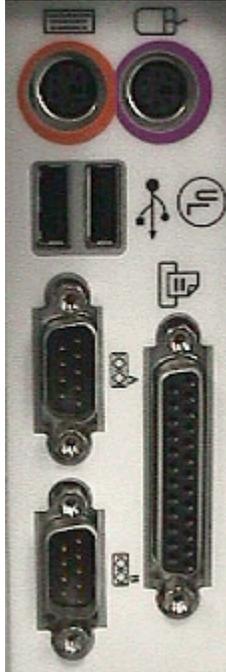
RS-232 DNC transmissions are sensitive to electromagnetic interference. Make sure the DNC cable is routed away from lighting fixtures, power transformers, other high voltage sources and mechanisms that generate strong magnetic fields.

Control RS-232 Communication Port

The RS-232 communication port on the 630R machines is behind the control panel. For the 1000R machines, the port is on the left side of the control.

Serial Communication Ports on Computers

Most computers have two communication ports (COMs). Communication ports on legacy computers are labeled as COM1 and COM2. Serial communication ports on a more recent computer, shown on the right, are labeled as "A" and "B". Typically "A" and "B" correspond to "COM1" and "COM2," respectively. Notice that they are both 9-pin male ports.



Serial communication ports on a legacy computer are shown below. Typically the 9-pin male connector, the lower right port, is the communication port 1 (COM1). The 25-pin male port, the upper left port, is the communication port 2 (COM2). Be aware of your computer configuration. It may differ from what is shown here.

