

TECHNOTE

Allen-Bradley 8400

Connect to RS-232 port P4 of the CNC.

To set up the CNC Parameters:

Press the Exit button.

Use CNC Softkeys – press SUPPORT/AMP/CONFIGURE I/O

Set as follows:

Both,4800,4800, INT OFF, EVEN, 7, 2, Always High, Always High, None, None, 232P4, ON, ON,
OFF, 0, 17, 19, 18, 20, 16, 4, 0, SAVE, COMPUTER, COMPUTER.

DNC Parameters

4800 baud, 7 bit, even parity, Xon/Xoff Wait, 2 stop bits

To send a file from DNC to CNC

First queue the job on the DNC computer

At the CNC press the Exit button.

Use the softkeys: Press LOAD/SAVE, COMPUTER LOAD, NEW PROGRAM, SINGLE PROG.

To send a file from CNC to DNC

First queue the job on the DNC computer

At the CNC press the Exit button.

Use the softkeys: Press LOAD/SAVE, COMPUTER SAVE

Select the program number that you want to save.

Press SINGLE PROG.

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