

TECHNOTE! Cincinnati 900CNC

Please note! The following information comes from our many years of experience in setting up RS-232 communications. However, our experience also has taught us that many controls do not necessarily match the standard. So, please double-check this information in the Operator or Maintenance or Parameter manual that came with your machine.

1. The Cincinnati 900 has parameters that are preset.
2. DNC parameters: 600 baud, ASCII, Even, 7 bits, 1 stop bit, Trailer: 1, Null

Sending a program from DNC to the Cincinnati 900 CNC

1. Press PGM CONT, DTA LINE, LD STORE
2. Enter a program ID number with the keypad and press ENTER.
3. Press START
4. At the DNC, queue up the part program to be sent.

Sending a program from the CNC to the DNC

1. At the DNC select Receive to queue up the program to be saved.
2. At the Cincinnati 900 CNC press PGM CONT, *STORE, SEARCH, PGM ID.
3. ADVANCE through the list to find the program you want to save or enter the ID with the keypad. Press ENTER if using the keypad.
4. Press TERMINATE. The ID number will be displayed in the ID field above.
5. Press XMIT PGM
6. Make sure RS-358 is selected and then press START.

Wiring

Use 24 AWG stranded, low capacitance computer cable with an overall shield (foil is fine and easier to work with.)

CNC (25 pin socket)	DNC COM port (25 pin socket)	CNC (25 pin socket)	DNC COM port (9 pin socket)
1-----	shield	1-----	shield
2-----	3	2-----	2
3-----	2	3-----	3
4-----	5	4-----	8
5-----	4	5-----	7
7-----	7	7-----	5
6---		6---	
20--		20--	

For more information call, Fax, email or visit our web site:

CAD/CAM Integration, Inc.

3 Bessom St. #212, Marblehead, MA 01945

Tel: 781-933-9500

Fax: 781-494-9585

Email: sales@shopfloormanager.com

Web: www.shopfloormanager.com