TECHNOTE!
CNC RS-232 Parameters
Fanuc 6M

Please note! The following information comes from our many years of experience in setting up RS-232 communications with this CNC. 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. Put the CNC in MDI mode.
2. Select the Setting(Handy) screen by pressing the Setting button.
    Set TV Check to OFF.
    Make sure both input and output devices are set to RS-232.
    Set Punch code to ISO.
3. Select the Parameter screen by pressing the Parameter button. Set the following parameters:
    (Parameter bits not related to RS-232 communications are represented by an "x" and should not be changed.)
    340 =2 Input device
    341 =2 Output device
    311=xx001010 Use control codes, 1 stop bit, 9600 baud.

Note if 340 and 341 are set to 3 then 312 is used or if set to 4 then 313 is used to set the baud rate.

If you must change a parameter you must set the toggle switch on the bottom of the Master Printed Circuit Board to the Enable position (right.) You will get an alarm code 100. Select Parameters. Cursor to the parameter. Type in P followed by the new number   Press INPUT. When done set the toggle switch back to disable (left) and press Reset to clear the alarm.

4. Set the DNC machine properties to 9600, Even, 7 bits, 1 stop bit, both-no-wait. The protocol is Generic RS-232.

Wiring

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

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

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