

# CAD/CAM Integration, Inc.

## TECHNOTE! CNC RS-232 Parameters Heidenhain 426-430

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. Set operating mode to EXT1
2. Set Machine Parameter (MP) values  
5000=0 no interface inhibited

**The following parameters are accessible via code number 123:**

5020.0=104 7 bits + parity, no BCC, DC code handshake, even parity, 2 stop bits  
5030.0=0 standard data transfer

3. Set the DNC machine properties to 9600, Even, 7 bits, 2 stop bits, XON/XOFF NoWait. The protocol is Generic RS-232. Edit the trailer to be 1,<ETX>.

### Wiring

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

