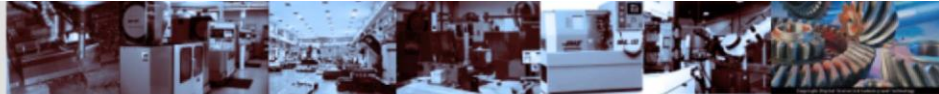**CADCAM INTEGRATION**
Driving Manufacturing Productivity for Over Two Decades

SuiteFactory Technote

Document and Records Mangement   Job Packets
DNC   Wired and Wireless Ethernet Networks
Wired and Wireless RS-232   Consulting Services

TECHNOTE!
Bridgeport EZpath and EZtrak
Created 3/9/2011 RHL

CNC Settings

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 times same model CNC's differ from each other. So, please double-check this information in the Operator or Maintenance or Parameter manual that came with your machine.

These controllers have the RS-232 communications hard coded as 9600 baud, 8 bits, 2 stop bits, No Parity.

DNC Parameters

Set the DNC machine properties as follows: The protocol is Generic RS-232, the Data Type is ASCII. Communication settings are 9600, None, 8 bits, 2 stop bits, Xon/Xoff NoWait, **Send Trailer must be set to 1,<SUB> which is the same as <Ctrl Z > the DOS end of file character**.

Wiring

Use 24 AWG stranded, low capacitance computer cable with an overall 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-------|


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

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

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Sending a file to the EZ (DNC to CNC)

This CNC does not send out an Xon character when you command it to receive a file therefore you have to set up the CNC to receive before you queue the file to send from SuiteFactory.

Press 9 UTILS – here you can see list of EZTRAK and Other (G-code) files.
Press 4 COMM
Press 3 ASCII and you will get the following menu:

<1> Send EZTRAK File
<2> Send Other File

<3> Receive EZTRAK File
<4> Receive Other File

<5> Show ALL EZTRAK Files
<6> Show ALL Other Files

<ESC> EXIT

Press 3 or 4 depending whether you are sending an EZTRAK conversational language file or an Other (G-code) file.

You will then be prompted to enter a file number. Enter the number of the file and press ENTER. The screen will show that it's waiting for data.

Go to a workstation running SuiteFactory and queue up the file you want to send to the CNC. The data will flow in a few seconds and if successful you will see COMPLETED OK message on the CNC screen.

Note: You can get a list of programs stored in the CNC memory by pressing 5 or 6. On some older versions of this DOS based CNC, the CNC will freeze after doing this and you will have to power it off and on.

Receiving a file from the EZ (CNC to DNC)

At a workstation running SuiteFactory, select or enter the filename you want and click Receive or if Remote Request is enabled, you can simply go to the CNC and punch out the program you want to save. If you have embedded a (SAVE filename) line in your program, the file will be saved with that filename. If there is no embedded SAVE command then the file will be saved and given a date/timestamp name which you can change latter.

Press 9 UTILS – here you can see list of EZTRAK and Other (G-code) files.
Press 4 COMM
Press 3 ASCII and you will get the menu shown above.

Press 1 or 2 depending on what kind of file you want to save.
You will be prompted to enter a file number. Enter the file number and press ENTER.
The date will be sent. *See note above regarding CNC freezing.*

Note: EZTRAK files are stored on the CNC with the extension .PGM. Other files are stored with the extension .TXT.

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