TECHNOTE!
GE1050MC-CM with DNC Comm. Option

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 GE1050MC has no parameters that can be changed manually. All setup data in stored via the Executive Software tape(s) and the Machine Setup Data (MSD) tape.
2. DNC parameters: 600 baud, ASCII, Even, 7bits, 1 stop bit, Leader: 1,DC2, Trailer: 1,EOT

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
        7----------------------------7


        CNC              DNC COM port
   (25 pin plug)         (9 pin socket)
        1-------------------------shield
        2----------------------------2
        3----------------------------3
        7----------------------------5
```

Sending a program from DNC to the GE1050MC CNC

1. Put the CNC in Terminal Mode: Display Switch to "Message Recall" and Mode Switch to MDI. The screen goes blank.
2. At the DNC, queue up the part program to be sent. The DC2 in the leader puts the CNC in Level 1 communications mode and the Store push-button light should go on while data is loading. The program ID number shows on the screen.
3. After file is completely sent (the EOT in the trailer signals the end of transmission) the light goes out. Change display switch to Index to verify that the program was stored.
4. To view the program, press the NEXT button to highlight the newly saved program. Press * to select it. Press S to get the program source menu. Press NEXT to highlight Memory. Press * to select it. Go to Single Mode and use the Tape FWD/REV push-buttons to scan through the program.

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

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 GE1050MC CNC, put the display switch to Index. Press the NEXT push-button to highlight the program you want to save. Press * to select it.
3. Press S to get the program source menu. Press the NEXT push-button to highlight Memory.
4. Press P to get the data type menu. Press the NEXT push-button to highlight 358. Press * to select it. The program will be transmitted to the DNC.

Note!

The part program stored on the DNC computer must have the following format for proper operation:

```
%
$xxxxxxxxxxxx  (this is the program ID which can be up to 12 digits long)


        .
        .
        .
body of program
        .
        .
        .
M3
%
```