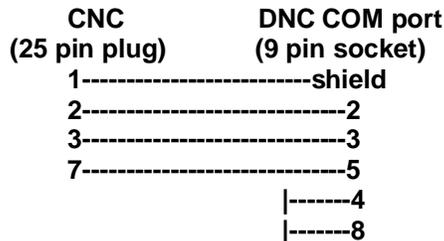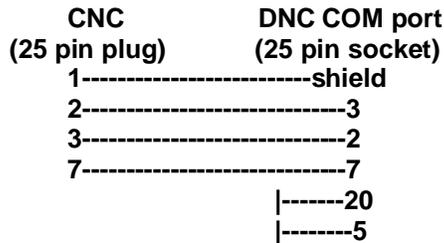# TECHNOTE!
Haas CNC

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.

1. Select List Programs then press Seting. Press the down arrow key until you see the screen with Baudrate, Word Length and Stop Bits and Handshake showing. Using the right arrow key select the proper settings. (2400, 7 Even, 1, XON/XOFF for DNC5000) (19200, 7, Even, 1, DC Codes for SuiteFactory.) Press WRITE to save each saved entry.

2. DNC Parameters

3. For DNC5000: 2400, 7. even, 1, Direct
4. For SuiteFactory set DNC machine properties as follows:

The protocol is Generic RS-232, the Data Type is ASCII. Communication settings are 19200, Even, 7 bits, 1 stop bit, XonXoff Wait. If you use the CCL command language for requesting files from your CNC control panel see CCL Technotes.

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
                          |-------20
                          |--------5


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

To Send a File to the Haas

Press LIST PROG. Cursor to ALL.   Enter Onnnnn (unless you want to use the O number in the file.) Press RECV RS232

Send the file from the DNC system. . (After the file is received, if the O number in the file differed from the one you entered, then you will get a warning alarm. However, the file will be received ok.)

To Receive a File from the Haas

On the DNC System, queue up the file to be received. At the Haas, press LIST PROG. Either cursor to the program you want to save or enter the O number. Press SEND RS232.