

## TECHNOTE! Okuma OSP5000

### **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. On the CNC select Parameter set by pressing the PARAMETER key. Use the up/down arrow keys to select the type of parameter. If necessary use the page up/down keys to change the page in the parameter category.

*(Parameter bits not related to RS-232 communications are represented by an "x" and should not be changed.)*

*Some parameters require that the CNC power be cycled off then on for changes to be made. This is true of many of the RS-232 related parameters.*

Parameters are changed by entering the new values and pressing WRITE.

**BEFORE CHANGING ANY PARAMETERS, RECORD THE OLD VALUE.**

2. Cursor to the Word type parameters.

Set Word Parameter 1 (Tape Feed) to 1.

For RS-232 connector CN0:

Set Word Parameter 34 (Busy time) to 30.

Set Word Parameter 39 (Baud rate) to 9600.

Set Word Parameter 44 (Punch device) to 0 (=CN0).

Set Word Parameter 54 (Read device) to 1 (=CN0).

For other connectors CN1, 2, 3 see your Okuma manual.

3. Cursor to the Bit type parameters.

Set Bit Parameter 1 to xxx01011 (% is end of program, no TV check, enable parity check, select ISO code.)

Set Bit Parameter 2 to 00001000 (no file name output at punching)

Set Bit Parameter 12 to 10111011 (read file name, DC codes, 8 bit word, even parity, one stop bit.

***Now turn the CNC power off. Wait 30 seconds and turn it back on. Check that the parameters you set have been saved.***

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

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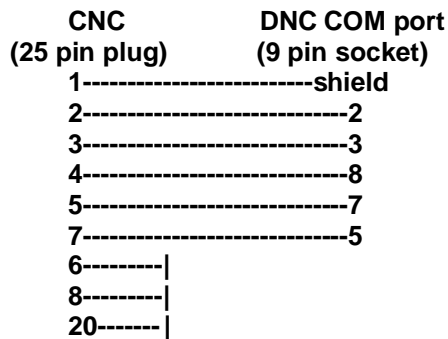
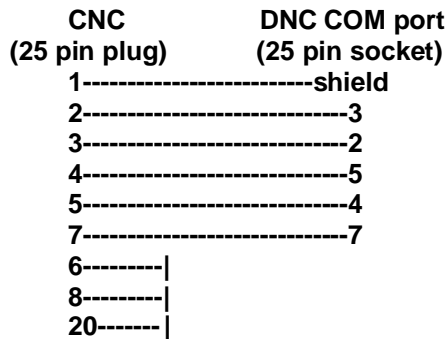
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4. Set the DNC machine properties as follows: The protocol is Generic RS-232, the Data Type is ASCII. Communication settings are 9600, Even, 7 bits, 1 stop bit, XON/XOFF Wait.

### **Wiring**

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



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