

## PC-DNC FAQs

Making our customers' lives easier.

### Testing communication in PC DNC Editor

1. First test (Receive file in Terminal Window)
2. Click **I/O** menu then click **Select I/O Device**
3. Click on machine you want to test. If no machine names, click "default"
4. Click **Select**.
5. Click **I/O** menu again Then click **Terminal Window**

Leave terminal window open and go to machine and send a file. You should see one of four things in the terminal window:

Intelligible data - Your program is there and in recognizable G-code format with some extra information at the end of every line (line feeds <LF> and carriage returns <CR>).

Nothing - indicates wrong port on machine, wrong COM port on computer, incorrectly wired cable, or in rare cases a bad port on either the computer or machine

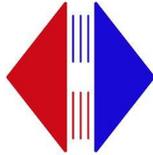
Garbled data - indicates one of the basic settings (baud rate, data bits, stop bits, or parity) is mismatched. NO other settings in the DNC software affect the terminal window. If you are sure these match, see if your CNC has the option to transfer in ISO/ASCII or EIA. If the CNC is set to EIA you will need to change it to ISO or ASCII

Note: Terminal Window does not capture the G-code file for sending back to the CNC. See test #3 to do that. It will allow you to save the file as a Rich Text File for further troubleshooting.

#### Second test (Receive file in PC DNC Editor)

1. Click **I/O** menu
2. Click **Receive File**. A window should open in Editor that will receive the file when it is sent from the machine.
3. Go to machine and send a file. The "Bytes" received in the bottom of the text box should increment, and the file should appear on the Editor screen a few seconds after data stops.

(From this point you can also do a File/Save As and save the file to your network)



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1. Third Test (Send file to machine)
2. First, change the O number of the file you just received to one that is not being used by a program on the machine. (Not necessary to save the file at this point in the testing)
3. Click **I/O** menu
4. Click **Send File**

Choose how you want to send file:

**DNC** for drip feeding long files, and sending the same file repeatedly.

**XON** will prepare file to be sent to machine. You then have to go out to the machine to get the machine ready and receive the file at the machine by pressing READ or INPUT

**Send Now** will send the program now. Your machine must already be in a READY state to receive the file.