

Adding New Machine to PC DNC Plus

To add a machine and configure machine parameters, choose CONFIGURE / DNC Windows.

🔁 Configure DNC windows								
Machine list: Fanuc Yasnac Cincinnati Mitsubishi Test	Serial Ports Advanced I/O Commands I/O Directories File names Path to DNC output window CVRYMVPC-DNC plus Server CVRYMVPC-DNC plus Server Stop bits COM: 6 8audrate: 115200 6 7 data bits 3 2 19200 6 7 data bits 7 1 stop bits 1 9600 9600 7 2 stop bits 7 2 stop bits							
Add machine name Rename machine Delete machine name Print this configuration	Handshshaking Transmit code Image: Standard serial I/O Image: Standard serial I/O Image: Standard serial I/O Image: Standard serial I/O Image: Standard serial I/O Image: Standard serial I/O							
OK Apply Cancel	 If port will not open, retry continuously every minute(s) Control CNCs memory protect key switch with DTR signal Check CTS and DTR at the end of each file before resetting (required for Moxa) Halt and reset port after 120 minutes of inactivity (required for Moxa) 							

Click ADD MACHINE NAME and enter appropriate settings for your machine control. Always copy config from another machine so that the basic defaults are set properly, then modify settings for specific machine using the information on the link below for CNC configs. Repeat for additional machines. To get assistance with parameters for common CNC controls, visit

http://support.rym.com/CNC_Configs.aspx , select your CNC Control from the pull-down menu. Click OK

When using an external serial device server, you must also go to Configure/DNC Windows. Check "Handshake using device driver."

In addition to the configuration settings you will have to assign the appropriate COM port for each machine. Check the Windows Device Manager/Ports to determine the new Com Port number of the device you just installed.

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🛱 Configure DNC windows									
Machine list:	Serial Ports Advanced I/O Commi	ands I/O Directories File names							
Fanuc Yasnac Cincinnati Mitsubishi Haas Simulator	When sending Leader: %LF Trailer: % Check handshake every 5 Skip lines that start with:	When receiving Ignore data before 1st EOB Ignore Fadal checksum Use auto code recognition Print file after PX: After TX: Separate files by IDs Receive & store blank lines Timeout when receiving (sec.) No timeout on manual receive Expect program ID on line # Okuma							
	Safety timeout: 7 seconds								
Add machine name Rename machine	✓ Reset file on safety timeout Character delay: 0 Block delay: 0 ms Delay after transmission (seconds)								
Delete machine name	Use CALL statements Skip M02/M30 in CALL ed files	EZTRAK AB 8200							
Print this configuration	Delete blank lines	🗖 Mazak CMT 🔽 RS491							
	□ Send RTS string <18> every 2 sec.	Limit time delays to 1st block							
	Force all output to upper case Handshake using device driver	Send Xon every 2 seconds							
Apply	 Verify port is open every 10 see 	Close /open port after each I/O							
Cancel	Send when: I CTS C DSR goes high	Don't send File Not Found msg.							

Enter directory paths for programs for each machine under the I/O Directories Tab.

Configure DNC windows						×
Machine list:	Serial Ports Advanced I/O Commands I/O Directories F					
Fanuc 31i					, 	
Haas Mitsubishi	Path(c) for files receiv	ad. Wkaren-gate	wav/tapes\$\input		^	browse
Yasnac	Pain(s) for lifes receiv	eu. In ser ser				
FTP (EXP)						
Toyoda Formo 21i		4				
Kitamura						
Mori Seiki	Path(s) for files cent:	\\karen-gate	way\tapes\$\output		^	browse
Robodrill	T duri(s) for mes serie	C:(TAPES				
					-	
					4	
· · · · · · · · · · · · · · · · · · ·	Auto-queue director	y:				browse
Add machine name	Keep Activity log co	py in:				browse
Rename machine	Search all subdirectories under send path(s) & display directory tree					
	Search within program for ID Select OP numbers using letter "N"					
Delete machine name	Send warning message if requested file was transmitted in last. hours					
Print this configuration	String to send before	e sending a file di	rectory C	8888		
	String to cond before	o conding a filo or	nfirmation:		_	
	Othing to send before	e senang a ne ca			_	
OK	String to send if file c	ioes not contain a	an iD:			
	String to send after p	rogram ID:				
Apply	Characters to mask	out while receivin	g data:			
	Characters to mask	out while transmit	ting data:			
Cancel						
					_	

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