## Drip Feed Settings in PC DNC Plus

**Configure DNC windows**

**Machine list:**
- Fanuc
- Yasnac
- Cincinnati
- Mitsubishi
- Test

| Serial Ports | **Advanced** | I/O Commands | I/O Directories | File names |

**When sending ...**

- Leader: %LF
- Trailer: %
- Check handshake every [5] characters

**3.** If still having problems after 1 & 2, Increment "Check handshake every X Characters" down by 1 until you reach 1 (i.e. try 4, then 3, then 2, then 1)

- Skip lines that start with:
- Skip data that starts with:
- Skip lines that contain: %
- Skip data upto:
- Skip all data after:

☐ Receive & store blank lines
Timeout when receiving (sec.) [3]

- Safety timeout: [7] seconds
- ☐ Reset file on safety timeout

**1.** Uncheck box "Reset file on safety timeout"

- Character delay: [0]   Block delay: [0] ms

**4.** If #3 does not work, try adding a 1 ms block delay

- Delay after transmission (seconds): [ ]
- ☐ Use CALL statements
- ☑ Skip M02/M30 in CALLed files
- ☐ Delete blank lines

☐ Wiedemann     ☐ Haas loop
☐ Mazak CMT     ☑ RS491
☐ Limit time delays to 1st block

- ☐ Send RTS string <18> every [2] sec.
- ☐ Force all output to upper case
- ☑ Handshake using device driver

**2.** IF USING EXTERNAL HUBS, Check box "Handshake using device driver")

- ☐ Verify port is open every 10 sec.
- Send when: ⦿ CTS  ○ DSR  goes high

☐ Don't send File Not Found msg.

**Buttons:**
- Add machine name
- Rename machine
- Delete machine name
- Print this configuration
- OK
- Apply
- Cancel