File Transfer Instructions

Haas Control

CNC to PC
Use these instructions to send files from your Haas to the DNC system

1. Press the "LIST PROG" key
2. Highlight the file you wish to send to the computer
3. Press "SEND RS232"

PC to CNC
Use these instructions to get a file from the DNC system into your Haas

1. Press the "LIST PROG" key
2. Highlight your trigger program (O7778)
3. Press "SELECT PROG"
4. Press "EDIT"
5. Highlight "(GET-xxxxxxxx.xxx)" where xxxxxxxx.xxx is the last file received
6. Type "(GET-xxxxxxxx.xxx)" where xxxxxxxx.xxx is the filename you wish to receive. This should be on the TOP line of the program, next to O7778
7. Press ALTER. Make sure there is an End Of Block at the end of the top line.

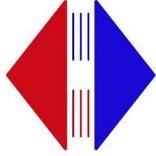Example- If you wanted to get file 7836D932.001 your O7778 trigger program would look like this:

O7778(GET-7836D932.001);
%

8. Press "LIST PROG"
9. Press "SEND RS232"
10. Key in your desired O-number (example: "O1302")
11. Press "RECV RS232"

Setup Notes:
This control is set for 19200 baud, 7 data bits, 1 stop bit, Even parity, DC CODES handshaking.

Use these notes with the CNV, CNX, CNW

File Transfer Instructions

Fanuc 6 Control

CNC to PC
Use these instructions to send files from your Fanuc 6 to the DNC system

12. Ensure the machine is in EDIT mode. Press the PROG key.
13. Type "Oxxxx" (where xxxx is the program to send)
14. Press the "PUNCH" button

PC to CNC
Use these instructions to get a file from the DNC system into your Fanuc 6

1. Ensure the machine is in EDIT mode. Press the PROG key.
2. Bring the O7777 program to the foreground (Press O7777 then the "line down" arrow)
3. Delete all information after the O7777 on the first line (except for the EOB)
4. Set the cursor to the O7777 command. Now type in Txxxx (INSERT) where XXXX is the first numeric portion of the file name. Now type (ABS/INC) Exxx (INSERT) where Exxx is the last half of the file name. The .001 is assumed automatically. Make sure that there is an End Of Block at the end of the first line.
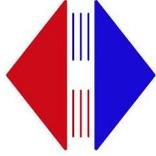
Example- If you wanted to get file 7836E932.001 then your O7777 trigger program would look like this:

O7778T7836 E932;
%

5. Type "O7777", then press the "PUNCH" key
6. Type Oxxxx where xxxx is the desired program number. For example, type "O1302"
7. Press the "READ" key

Setup Notes:
This control is set for 4800 baud, 7 data bits, 1 stop bit, Even parity, DC CODES enabled

File Transfer Instructions

Fanuc 15iM Control

CNC to PC

Use these instructions to send files from your Fanuc 15iM to the DNC system

8. Ensure the machine is in EDIT mode. Press the PROG key if not in the program display.
9. Display O7777 on the screen (There are several ways to do this. For example, press O7777 then press the "line down" button)
10. Press the "PUNCH" softkey followed by "THIS" (you may need to use the right-arrow softkey to scroll over to the "PUNCH" selection)

PC to CNC

Use these instructions to get a file from the DNC system into your Fanuc 15iM

1. Ensure the machine is in EDIT mode. Press the PROG key.
2. Bring the O7777 program to the foreground (Press O7777 then the "line down" arrow)
3. Make the first line look like O7777(GET-xxxxxxxxxxxx.xxx); where xxxxxxxxxxxx.xxx is the file to be received. Make sure that there is an End Of Block at the end of the first line.

Example- If you wanted to get file 7836E932.001 then your O7777 trigger program would look like this:

O7778(GET-7836E932.001);
%

4. Press the "PUNCH" softkey followed by "THIS" (you may need to use the right-arrow softkey to scroll over to the "PUNCH" selection)
5. Type Oxxxx where xxxx is the desired program number. For example, type "O1302"
6. Press the "READ" softkey followed by the "1_PROGRAM" softkey.

Setup Notes:

This control is set for 9600 baud, 7 data bits, 1 stop bit, Even parity, DC CODES enabled
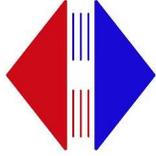
General Numeric / Fanuc 11M Control

CNC to PC
Use these instructions to send files from your Fanuc 15iM to the DNC system

7.   Ensure the machine is in EDIT mode. Press the PROGRAM softkey.
8.   Press the "PUNCH" softkey (you may need to use the right-arrow softkey to scroll over to the "PUNCH" selection)
9.   Type the O-number of the file to transfer (for example, type O1234)
10.   Press EXECUTE

PC to CNC
Use these instructions to get a file from the DNC system into your Fanuc 15iM

1.   Ensure the machine is in EDIT mode. Press the PROG key.
2.   Bring the O7777 program to the foreground (Press O7777 then the "line down" arrow)
3.   Make the first line look like O7777(GET-xxxxxxxxxxxx.xxx); where xxxxxxxxxxxx.xxx is the file to be received. Make sure that there is an End Of Block at the end of the first line.

Example- If you wanted to get file 7836E932.001 then your O7777 trigger program would look like this:

O7778(GET-7836E932.001);
%

4.   Press the "PUNCH" softkey followed by "THIS" (you may need to use the right-arrow softkey to scroll over to the "PUNCH" selection)
5.   Press the "READ" softkey
6.   Type the O-number of the file to receive. For example, type O1234
7.   Press EXECUTE

Setup Notes:
This control is set for 9600 baud, 7 data bits, 1 stop bit, Even parity, DC CODES enabled
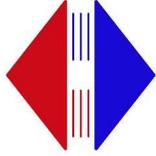
File Transfer Instructions

Mazak M32 Control

CNC to PC
Use these instructions to send files from your Mazak M32 to the DNC system

8. Press the leftmost green button under the display to return to the main menu.
9. Press the "DATA IO" softkey
10. Press the "TAPE IO" softkey
11. Press the "PUNCH" selection
12. Key in the program number(s) to punch followed by the input key after each one
13. Press the "START" softkey

PC to CNC
Use these instructions to get a file from the DNC system into your Mazak M32

1. Press the leftmost green button under the display to return to the main menu.
2. Press the "PROGRAM" softkey
3. Search for & display work number 7777 on the screen
4. Edit the top line to be "(GET-xxxxxxxx.xxx);" where xxxxxxxx.xxx is the file you wish to get.

Example- If you wanted to get file 7836E932.001 then your 7777 trigger program would look like this:

(GET-7836E932.001);

5. Press the leftmost green button under the display to return to the main menu.
6. Press the "DATA IO" softkey
7. Press the "TAPE IO" softkey
8. Press the "PUNCH" selection
9. Key in 7777 followed by the input key
10. Press the "START" softkey
11. Go to DATA IO –> TAPE IO –> LOAD
12. Key in the program number to store the new file as followed by the input key
13. Press the "START" softkey

Setup Notes:
This control is set for 2400 baud, 7 data bits, 1 stop bit, Even parity, DC CODES enabled
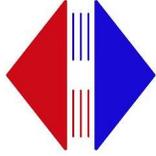
File Transfer Instructions

Okuma OSP500L Control

CNC to PC
Use these instructions to send files from your Okuma to the DNC system

14.   Press the EDIT AUX key
15.   Press the PIP softkey
16.   Press the PUNCH softkey
17.   Type the program name to send (ex. PART1234-123.MIN)
18.   Press the WRITE key

PC to CNC
Use these instructions to get a file from the DNC system into your Okuma

1.   Press the EDIT AUX key
2.   Press the EDIT softkey
3.   Type GET.MIN and press WRITE
4.   Edit the top line of the program to read (GET-filename)

Example- If you wanted to get file 7836D932.001 your GET.MIN trigger program would look like this:

(GET-7836D932.001);

5.   Press the EDIT QUIT softkey
6.   Press the PIP softkey
7.   Press the PUNCH softkey
8.   Type GET.MIN and press WRITE
9.   Press the READ softkey
10.   Press WRITE

Note that your file will be input as the first available program name, such as A.MIN, which will be shown at the top of your screen as the file is transferred. You may then rename it if you desire.

Setup Notes:
This control is set for 4800 baud, 7 data bits, 1 stop bit, Even parity, DC CODES handshaking.
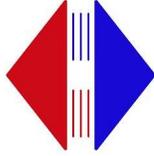
File Transfer Instructions

Westinghouse 2560 / Producer / Producer II

PC to CNC

Use these instructions to get a file from the DNC system into your 2560, Producer, Producer II

1. On your handheld terminal, press the F1 key for REMOTE.
2. If there is a program request on the terminal already, press DELETE until the line is blank.
3. Key in ** followed by the name of the file you wish to receive. For example, to receive FILE1234.001 your display should look like:

    **FILE1234.001

4. Press ENTER on the keypad.
5. The display should show dots across the screen until the file has been received, at which point it will display the number of bytes in the program. The program is now ready to be loaded in your machine.
6. Now go to your CNC and issue the command to receive the file to a program number you designate (which is exactly the same as you have always used with paper tape and the old DNC system).

Setup Notes:

This control is set for 9600 baud, 7 data bits, 1 stop bit, Even parity, DC CODES handshaking.
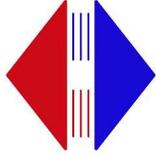
File Transfer Instructions

GE 2000 Control

CNC to PC
Use these instructions to send files from your Fanuc 6 to the DNC system

4. Press the INDEX key to bring up the list of files
5. Cursor down to the file you wish to send and press SELECT to highlight.
6. Press the SEND key, followed by Y (ENTER) to accept.

PC to CNC
Use these instructions to get a file from the DNC system into your Fanuc 6

1. Press the PROGRAM key to go to program mode followed by the <PAGE key to go back to the main menu. Select Edit PART PROGRAM (ENTER) then key in 7777 (ENTER) to edit the 7777 trigger program.
2. You will need to edit the top line of the part program to reflect the file you wish to request. Press the Cursor> key to cursor over on the line (a duplicate line will appear for editing. Change the line to read (ID, PROG,7777,xxxxxxxx.xxx) where xxxxxxxx.xxx is the file you wish to receive. Press ENTER.

Example- If you wanted to get file 7836E932.001 then your 7777 trigger program would look like this:

   (ID, PROG,7777,7836E932.001)

3. Press the INDEX key
4. Cursor down to the 7777 program, then press SELECT.
5. Press SEND followed by Y (ENTER) to confirm.
6. When done, press SELECT again to un-select 7777.
7. Press LOAD (ENTER). You will be prompted for a file number. Key this in, then press ENTER.

Setup Notes:
This control is set for 4800 baud, 7 data bits, 1 stop bit, Even parity, DC CODES enabled