

SET THE FOLLOWING PARAMETERS ON THE MACHINE

Press the [Parameters] button for parameters settings

Press the [PAGE DOWN] button and select the 'Settings 2' submenu

Set the 'MODE SELECT' switch to 'MDI'

Set the 'NO PWE' parameter to 1 and press the 'Input' button. After changing parameters below, change this value to 0 again

Select the 'Settings 2' submenu

Set I/O = 1

With help of 'PAGE DOWN' and 'PAGE UP' buttons change bits in the following parameters. Please, don't change bits that didn't print in the table below

#002 (stop bit and data format)

bit 0	0 (1 stop bit)
bit 2	0 (RS232)
bit 3	1 (ASCII)

#0552 (baud rate). Set this parameter = 9

Baud	Parameter value
2400	9
4800	10
9600	11
19200	12

#0038 (IO device)

bit 1	0
bit 2	1
bit 4	0
bit 5	1
bit 6	0
bit 7	1

#0051 (Parity)

bit 1	1 (Yes)
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#0055 (Additional parameters)

bit 0	1 (ASCII)
bit 1	0 (CR)
bit 2	0 (Protocol A)
bit 3	0 (RS232)

SET THE FOLLOWING PARAMETERS ON THE PC SERIAL PORT TAB

Machine name	Fanuc 0T
Serial port	COM2 (or any free COM port)
Baud	2400
Data bits	7
Parity	Even
Stop bits	2

DATA FLOW CONTROL TAB

Use DTR	False
Use RTS	True
Require DSR	False
Require CTS	True
Set RTS	False
Set DTR	False
Software flowcontrol	None
Xon char	#11
Xoff char	#13

DATA EXCHANGE FORMAT TAB

Format mode	Uniform
Format parameters	Program start: % Program end: % Line start: Line end: #0A Skip lines: Ignore characters: No characters for remove Remove blank lines: No Program name prefix: O Program starting characters in the file: No