P200L LATHE RS232 COMMUNICATION PARAMETERS
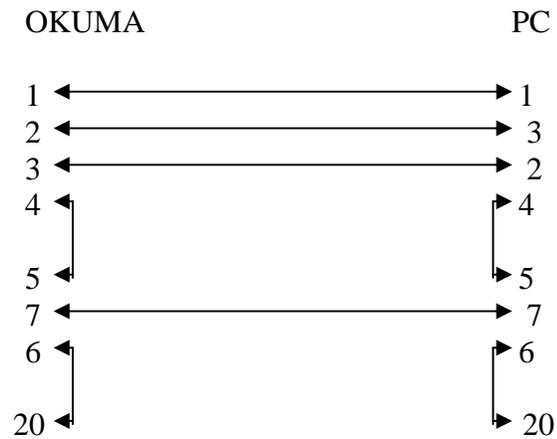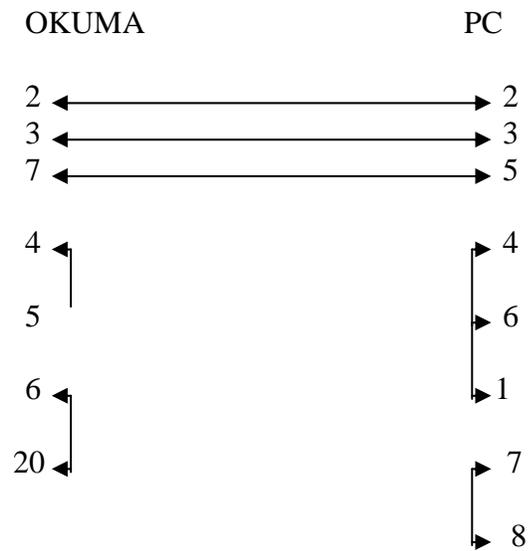
HOW TO SET UP A CABLE FOR RS-232 COMMUNICATIONS:

1. Configure the cable to the following diagram.

OKUMA   PC

1	⟷	1
2	⟷	3
3	⟷	2
4		4
5		5
7	⟷	7
6		6
20		20

If your PC has a 9 pin serial port, wire as follows:

OKUMA   PC

2	⟷	2
3	⟷	3
7	⟷	5
4		4
5		6
6		1
20		7
		8

SET UP PC AND CONTROL FOR RS-232 COMMUNICATIONS:

1. Set your PC software to:

   a) Data bits = 7
   b) Stop bits = 2
   c) Parity = EVEN
   d) Baud rate = 9600
   e) Handshaking = XON/XOFF

2. Set Okuma P200L Control to the following parameters:
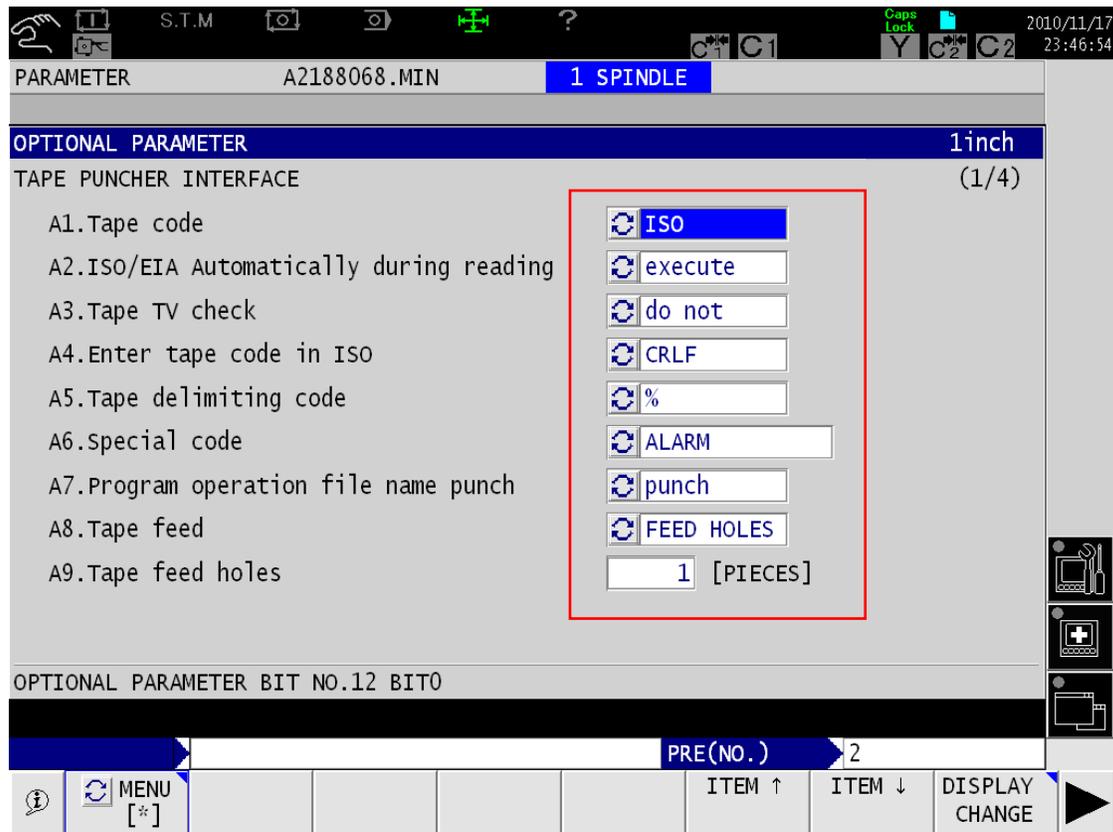
PARAMETER   A2188068.MIN   1 SPINDLE

OPTIONAL PARAMETER   1inch
TAPE PUNCHER INTERFACE   (2/4)

	7	6	5	4	3	2	1	0
A10.Tape code EIA '='	■							
A11.Tape code EIA '*'								
A12.Tape code EIA '['								
A13.Tape code EIA ']'								
A14.Tape code EIA '$'								
A15.Irregular code								
A16.Irregular replace code								

OPTIONAL PARAMETER BIT NO.21 BIT7

PRE(NO.)   2

□/✔ [*]   ITEM ↑   ITEM ↓   DISPLAY CHANGE   ▶

PARAMETER   A2188068.MIN   1 SPINDLE

OPTIONAL PARAMETER   1inch
TAPE PUNCHER INTERFACE (INPUT/VERIFY PARAMETER)   (3/4)

Device name of program operation	CN1:
B1. baud rate(bps)	9600
B2. RS232C character	8 bit
B3. RS232C parity bit	NON
B4. RS232C stop bit	2
B5. Ready waiting time	30 [s]
B6. Flow control	DC CODE
B7. The delay timer until the RS switches OFF	0 [ms]
B8. Designates the amount of RS OFF time	0 [ms]
B9. DC3 when read/verify finished	DOES

OPTIONAL PARAMETER WORD NO.4

PRE(NO.)   2

MENU [*]   ITEM ↑   ITEM ↓   DISPLAY CHANGE   ▶

PARAMETER   A2188068.MIN   1 SPINDLE

OPTIONAL PARAMETER   1inch
TAPE PUNCHER INTERFACE (OUTPUT PARAMETER)   (4/4)

    Device name of program operation   CN1:
    C1. baud rate(bps)   9600
    C2. RS232C character   8 bit
    C3. RS232C parity bit   NON
    C4. RS232C stop bit   2
    C5. Ready waiting time   30 [s]
    C6. Flow control   DC CODE
    C7. The delay timer until the RS switches OFF   0 [ms]
    C8. Designates the amount of RS OFF time   0 [ms]
    C9. DC2/DC4 at punch   DOES

OPTIONAL PARAMETER WORD NO.5

                                        PRE(NO.)   2

ⓘ   MENU   ITEM ↑   ITEM ↓   DISPLAY
     [*]   CHANGE

PARAMETER   A2188068.MIN   1 SPINDLE

OPTIONAL PARAMETER   1inch
READ/WRITE

    1.Device number(for Parameter set)   CN1:
    2.Tape delimiting code   %
    3.RS232C stop bit   2
    4.RS232C parity bit   NON
    5.Baud rate(bps)   9600
    6.Flow control   DC CODE
    7.Ready waiting time   30 [s]
    8.RS232C character   8 bit

OPTIONAL PARAMETER BIT NO.30 bit2

                                        PRE(NO.)   2

ⓘ   MENU   ITEM ↑   ITEM ↓   DISPLAY
     [*]   CHANGE

1 SPINDLE

OPTIONAL PARAMETER   1inch

LONG WORD			WORD			BIT									
NO.			NO.			NO.	7	6	5	4	3	2	1	0	
1	500		1	0		11					✔				
2	320		2	1000		12	■	✔			✔		✔	✔	
3	100		3	1		13									
4	2000		4	1		14									
5	20		5	1		15									
6	500		6	0		16	✔		✔		✔		✔		
7	0		7	9600		17			✔	✔					
8	1000		8	9600		18			✔	✔					
9	0		9	4800		19			✔	✔					
10	0		10	4800		20									

ACTUAL POSI.

X	0.0000
Z	2.2517
C	0.000
W	24.3779
Fr	0.0000
V	0
S	0

TOOL NO.   4
OFFSET NO.   0
NOSE R NO.   0

Ignore special code in tape

PRE(CAL)

| ⓘ | ☐/✔ [*] | | | FIND | | ITEM ↑ | ITEM ↓ | DISPLAY CHANGE | ▶ |