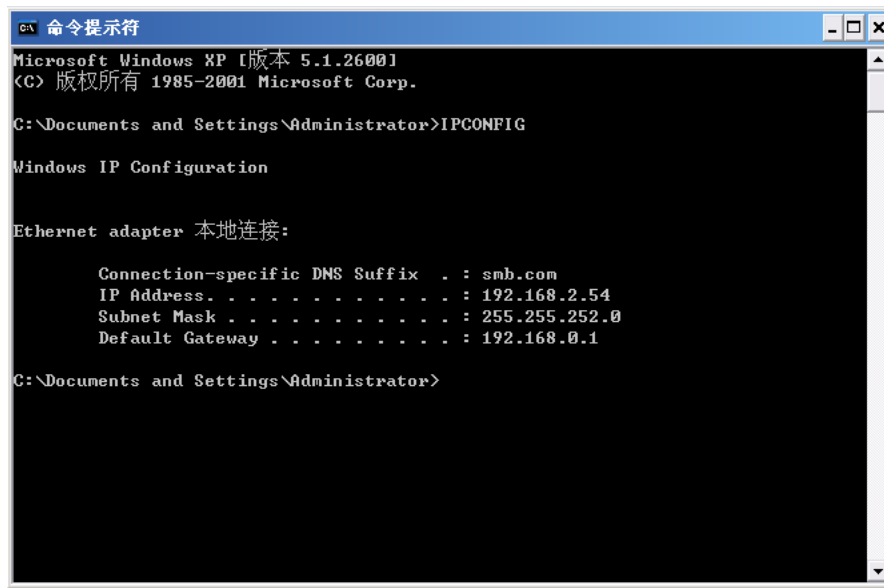


Network communication

(ForCNC46XX)

Connect a network cable to router.Enter windows command window .you can check the local PC IP address configure by type "IPCONFIG" command .as below note:



```
命令提示符
Microsoft Windows XP [版本 5.1.2600.1
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C:\Documents and Settings\Administrator>IPCONFIG

Windows IP Configuration

Ethernet adapter 本地连接:

    Connection-specific DNS Suffix  . : smb.com
    IP Address. . . . . : 192.168.2.54
    Subnet Mask . . . . . : 255.255.252.0
    Default Gateway . . . . . : 192.168.0.1

C:\Documents and Settings\Administrator>
```

According to the PC' s IP address .you can assign a same network segment IP address for controllers. But this address should have not been used. Meanwhile you should set the parameter communication options: all user or network

(e.g. PC IP address: 192.168.2.54 .Controller IP address: 192.168.2.2)

General EDIT Run Edit Param Coord Test

025,Z Soft PosLimit+(mm)	+ 9999.999	037, IO FilterWave(1~8)	0
026,Z Soft PosLimit-(mm)	- 9999.999	038,Communication Options<	Uart
027,4 Soft PosLimit+(mm)		Feed(mm/min)	6000
027,4 Soft PosLimit-(mm)		Feed(mm/min)	9000
029,Inp Speed(mm/min)		Efficient	1000
030,InpStartSpeed(mm/min)		Delaytime(ms)	100
031,InpAcceleration(mm/s)		Offset(mm)	+ 0.000
032,XBacklashExpiate(pul)		Offset(mm)	+ 0.000
033,YBacklashExpiate(pul)		Offset(mm)	+ 0.000
034,ZBacklashExpiate(pul)		Offset(mm)	+ 0.000
035,4BacklashExpiate(pul)			0
036,ZeroReturn Mode	Program	048, System Baudrate<•>	115200

confirm cancel

Stop

<<< Genl Axis Manage Tools Spindle Port >>>

General EDIT Run Edit Param Coord Test

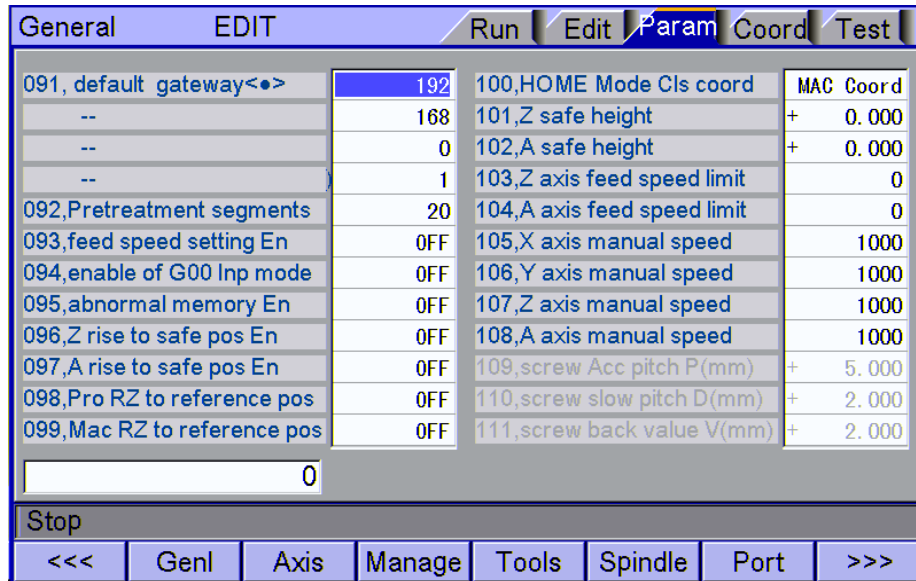
073,SpindleAlarm ELevel	0	085,HOMe Check Enable	ON
074,TransducerAlarm ELevel	0	086,X diameter prog enable	0
075,ExScram ELevel	0	087,default process plane	G17 (X_Y)
076,BackHome ModeConf(bit)	Z-XY	088,T code form	0
077,Arc Acc.for Radii	+ 50.000	089,IP address<•>	192
078,Arc Acc.for Speed	100	--	168
079,PretreatmentCode Set	500	--	2
080,Inp AccSpeed Mode	1	--	2
081,'S'Speed Acceleration	5000	090, subnet mask<•>	255
082,ExStart ELevel	0	--	255
083,ExPause ELevel	0	--	255
084,HOMe Check for alarm	OFF	--	0

0

Stop

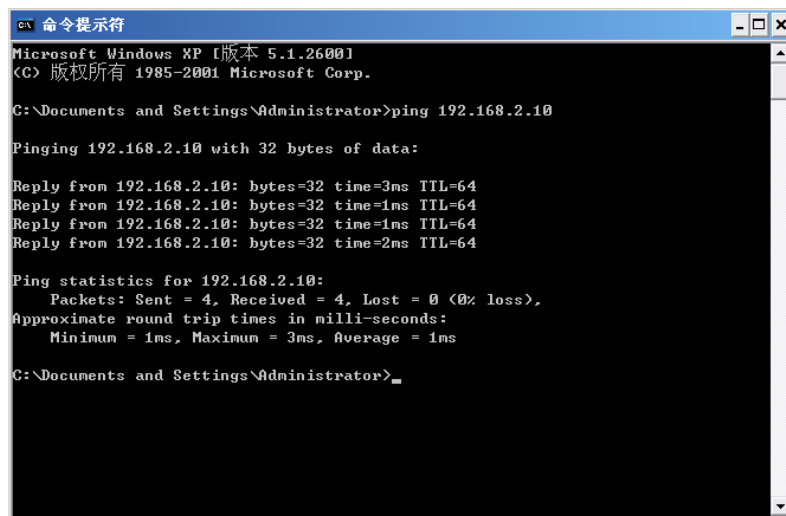
<<< Genl Axis Manage Tools Spindle Port >>>

Subnet mask and default gateway should be the same as PC



Then connect the network port circuit and type “ping” command in command window to check whether the connection is OK.

As below picture:



If display the interface as below .it means the network is not connect.

Please check whether the IP address is correct. Does some problem in wring .or the controller is not power on.

```
命令提示符
Microsoft Windows XP [版本 5.1.2600]
(C) 版权所有 1985-2001 Microsoft Corp.

C:\Documents and Settings\Administrator>ping 192.168.2.10

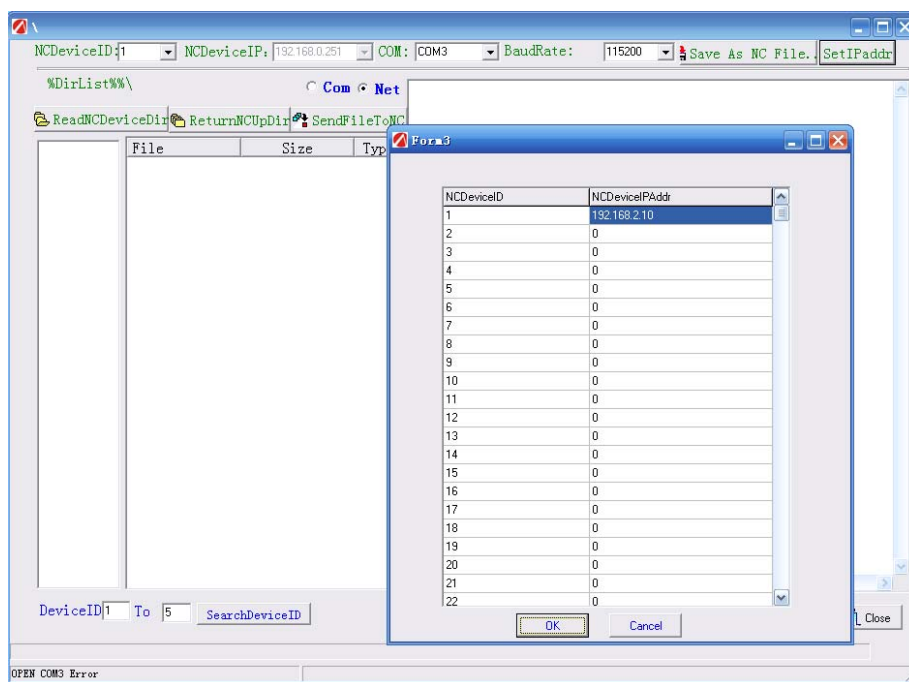
Pinging 192.168.2.10 with 32 bytes of data:

Request timed out.
Request timed out.
Request timed out.
Request timed out.

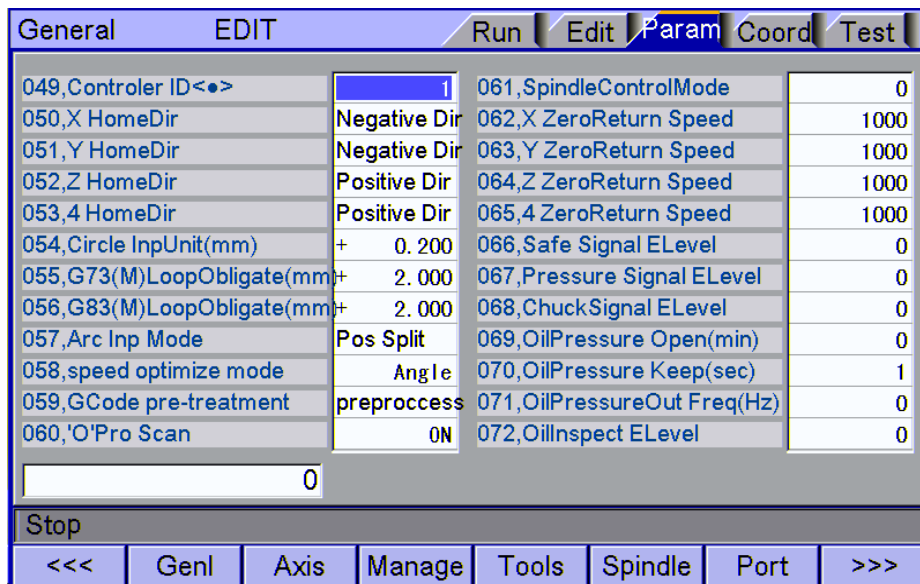
Ping statistics for 192.168.2.10:
    Packets: Sent = 4, Received = 0, Lost = 4 (100% loss),

C:\Documents and Settings\Administrator>
```

After the network well .you can open the communication software. Set the IP address.As below shows:

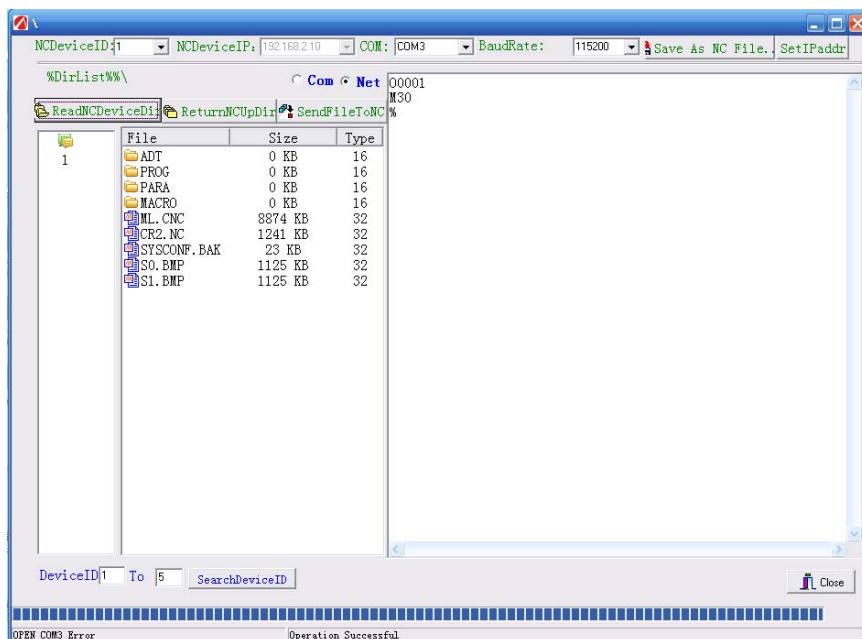


After setting correct IP address. Select "Net" . Use network communication .set controller ID (Genl parameter 049)



Click "searchdeviceId" bottom. You can visit the content of controllers.

As below shows:



Click **[SearchDeviceID]**, the software will search the device From 1 to 5 (the range can be modified), the searched CNC device will be listed in the list with ID such as 1 2 ..n. Double-click the device ID ,the files will be displayed in the list box. You can operate the files directly, It' s similar to enter catalogue file reading and deleting in Windows System explorer .

(Note: when there are several CNC controllers communicate with PC, Each controller' s ID should be different .otherwise it will fail to communicate between upper software and lower network since the collision).

[ReadNCDeviceDir]: list catalogue files of selected CNC system ID

[ReturnNCDeviceDir]: back upper directory file of current CNC system ID

[SendFileToCNC]: Send PC' s NC files or other files to catalogue files of current ID system

[NCDeviceID]: Current selected ID

[NCDeviceIP]: the binding IP of current device ID.
(when use network communicate)

[COM]: the communicate port NO of current device ID .
(when use serial port communication)

[BaudRate]: the communicate baud rate of current device ID
(when use serial port to communicate ,this value should be the same as lower CNC system' s Genl parameter P48.otherwise it will fail to communicate)

[Save As NC File]: Read the files of right edit box save as NC
file to local PC

[SetIPaddr]: when use network to communication, Each CNC system
should Binding corresponding IP. Otherwise it can' t
communicate .the unused device ID should set into 0,
Otherwise it will fail to communicate.