8040 / 8055 RS-232 SETUP AND COMMUNICATION

Serial Port Cable Connection CNC – PC

RS 232 PORT X 3 (9 PIN)			COM 1 or COM2 PC Computer (9 PIN)	(25 PIN)	
RxD	Pin 2		Pin 3	Pin 2	TxD
TxD	Pin 3		Pin 2	Pin 3	RxD
DTR	Pin 4		Pin 4	Pin 20	DTR
DSR	Pin 6		Pin 6	Pin 6	DSR
CTS	Pin 8		Pin 8	Pin 5	CTS
GND	Pin 5		Pin 5	Pin 7	GND
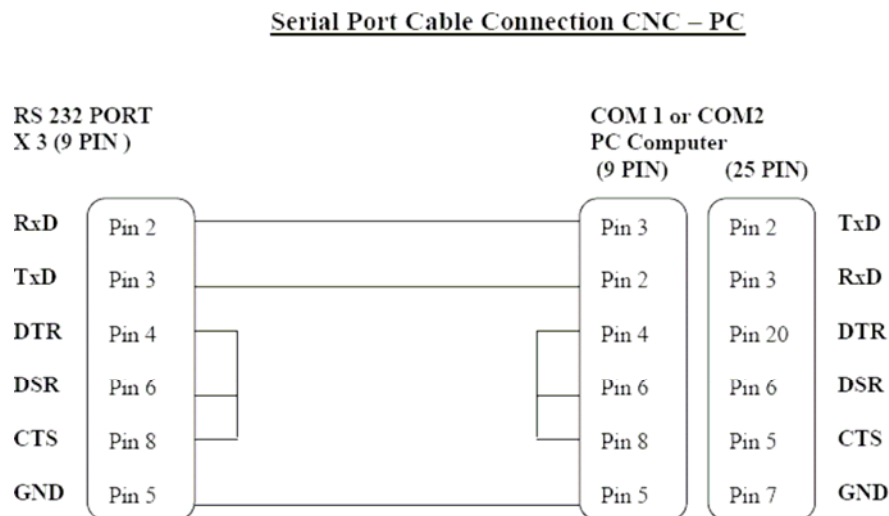
***Note: This cable is use for connecting directly from CNC to PC. If you are connecting to Turnkey Package you must use a straight thru cable.

Installation of software

- Go to the following website: www.fagorautomation.com and down load the free copy of WINDNC.

- Once you have downloaded the file double click on WinDNC_V04_01.exe and follow the instructions

Setup of software

- Go to start and select from the list WinDnc ver4.1

- Once the software is open go to **OPTIONS**

- Under **FILE SENDING** select file loading + deleting

- Click the check mark icon

- Go to **SETUP**

- Click on **NEW**

- Under **NAME** click on "NEW" and enter a name. Example "8040M" then press ENTER.

- Under **MODEL** select the type of control that you are working with. Example "8050M / 8055M". You would select this option for a CNC 8040M.

- Under **TYPE** select Serial Line.

- No need to do anything with connect on startup.

- Under **PORT**, select your corresponding port. Example "COM1"

- Select the correct Baudrate. Example "115,200"

- Double click under **WORK FOLDER** and navigate to c:/fagor/windnc/work. While the Work folder is highlighted click on **NEW**. Type in the name of the folder where all of your information will be saved to. Example "machine"

- Once the folder "machine" has been created , you must click select. The work folder should now read as c:/fagor/windnc/work/machine

- Click the **OK** icon

- Under devices highlight 8040M, then click on **SELECT,** then click **CONNECT**

****The screen should look like this:
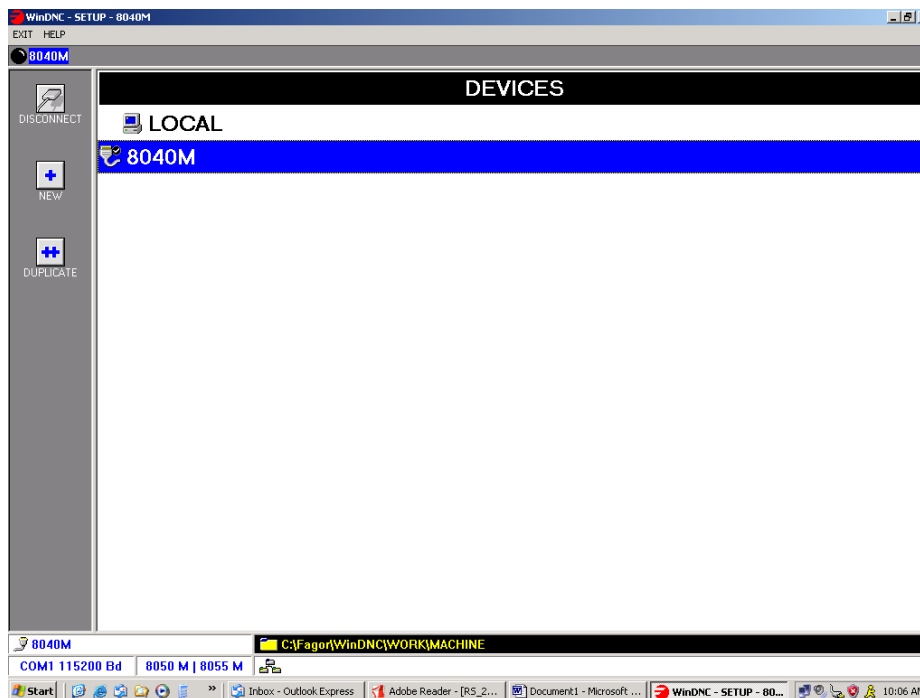
****note this only need to be created once. You can now go to any 8040 M / 8050 M / 8055M control and establish communication .

Setup of parameters on CNC

- Go to the G code side of control. Press shift then escape to change between G-Code and conversational.

- From the **MAIN MENU** press **F7 (+)**

- Go to **MACHINE PARAMETERS (F4)**

- Go to **SERIAL PARAMETERS (F4)**

- Select **SERIAL 2 (F2)**

**** Note: The parameters should be modified to the following:

SERIAL 2 PARAMETERS		P...... N....	DNC E 2	18:29:16
PARAMETER	**VALUE**	**NAME**		
P000	11	// BAUDRATE		
P001	1	// NBITSCHR		
P002	0	// PARITY		
P003	0	// STOPBITS		
P004	1	// PROTOCOL		
P005	YES	// PWONDNC		
P006	NO	// DNCDEBUG		
P007	0	// ABORTCHR		
P008	0	// EOLCHR		
P009	0	// EOFCHR		
P010	ON	// XONXOFF		

CAP INS

EDIT	MODIFY	FIND	INITIALIZE	LOAD	SAVE

****Once the parameters have been modified make sure you re-start the control, so the parameters take effect.

****Description of options for WINDNC can be found in the following directory of your computer: C:\Fagor\Help\WinDnc\English\WinDNC.html