

RS-232 Settings Check List

In order to establish RS-232 Communication with a CNC Controller the following must be known.

Is the CABLE correctly configured for the machine? Yes _____ No _____

What COM PORT at the PC is the cable connected to? COM _____

Does the machine control use hardware or software flow control?

Software Xon - Xoff / Hardware RTS-CTS

*(DTR/DSR is a hardware handshake rarely used these days, however, it is used on some older machines and BTR units.
This must be active to use this hardware handshake.)*

What is the BAUD RATE set at your machine tool? Baud _____

What DATA BIT value is set at your machine? Data _____

What PARITY is your machine tool set to? Parity _____

What STOP BITS value is your machine set to? Stop _____

Are the above baud rate , stop bits and parity set up in the editor ? Yes / No

Are the above baud rate , stop bits and parity set up in the windows device manager ? Yes / No

Are there any beginning, end or end of line codes that the machine controller requires ?

Example: % percent symbols are a typical start and end code. ; semicolon symbols are common end of line codes.

%

G0 G90 G40 G20 ;

G00 X0.0 Y0.0 ;

G00 X10.0 Y10.0 ;

M02 ;

%

Start Code _____ End Code _____ End Of Line Code _____