



Cable and Parameter configurations for **HAAS** controls

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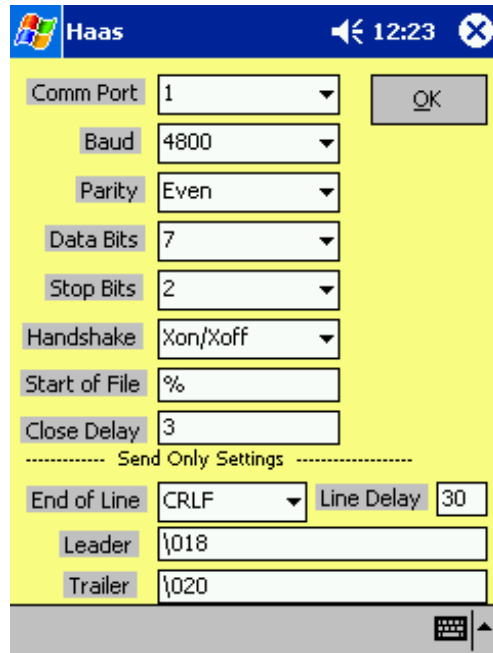
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Pocket DNC

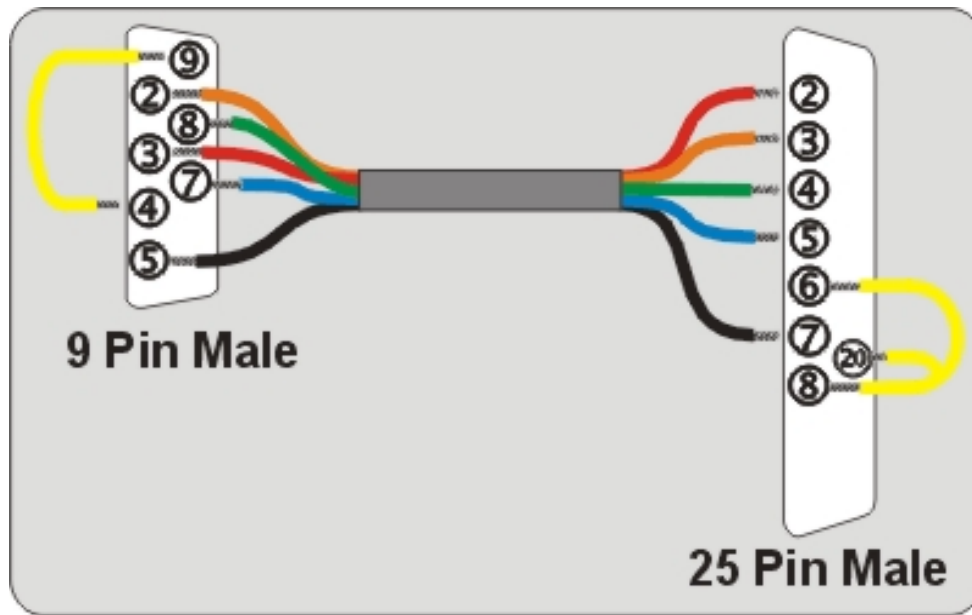


Pocket DNC Settings



Standard setting file for Haas controls

Cable Wiring





Warning

Only competent operators should make changes to machine setting data and parameters. Before changing any parameters please make a note of what they are currently.

Setting Communication Parameters

Before programs can be successfully transferred between the Pocket DNC and the Haas the machines communications parameters must be setup as follows.:-

- Press the **SETNG GRAPH** button
- Press the **PAGE DOWN** button until the page for the RS232 Port Settings is displayed.
- Using the Cursor **UP** and **DOWN** buttons to select a parameter and the Cursor **LEFT** and **RIGHT** buttons to alter its value set to the following :-

Baud Rate Select : 4800
Parity Select : **EVEN**
Stop Bit : 2
Synchronization : **DC CODES**
RS232 Data Bits : 7

Leader to Punch : **NONE**
EOB Pattern : **CR LF**
Add Space RS232 out : **ON**

NOTE : If you alter a parameter value you must press the **WRITE ENTER** key to retain its setting.

To send program from Haas control to Pocket DNC

1. To Exit press the **LIST PROG** button.
2. Press the **EDIT** button.
3. Press the **LIST PROG** button.
4. Use the **UP** and **DOWN** Cursors to highlight program to send.
5. Press the **SELECT PROG** button.
6. Press the **SEND RS232** button.



To send from Pocket DNC to Haas control

1. Press the **EDIT** button.
2. Press the **LIST PROG** button.
3. Use the **UP** and **DOWN** Cursors to highlight **ALL** at the bottom of the list.
4. Press the **RECV RS232** button.