Fanuc 0M

Set the following parameters on the machine

    0002 = 00000001
    0552 = 9 (For 2400 baud rate)

Set the setting data as follows
    T.V.ON   = 0   (0: OFF, 1: ON)
    ISO   = 1
    I/O   = 0

To set the controller in the Drip feed mode

Enable parameter G127.5 in the ladder diagram
Select AUTO (DNC) mode on machine
Press Cycle start

Parameters for the various baud rates

For baud rates other than 2400 set as follows:

Baud rate	Parameter
50	1
100	2
110	3
150	4
200	5
300	6
600	7
1200	8
2400	9
4800	10
9600	11

Set the following parameters on the PC

General settings

Machine name	MCH-1
Control system	Fanuc
Machine ID	01
Time out (sec)	5
Control program start	M82
Control program end	M30
Control program format	Standard
Clear receive buffer after receiving control program	No
Is DNC required	Yes

DNC settings

Port Number	COM2 (or any free COM port)
Baud rate	2400
Data bits	7
Parity	Even
Stop bits	2
Handshake	Hardware

Transmit settings

Transmit directory	Specify folder to store programs to be sent to machine from PC
Wait period at start of transmission	10.00
Wait period after transmitting program	8.0
Size of transmit packet	0
Delay period after each packet	0
Wait for XON before transmitting program	No
Drip feed	Off
Transmit comments?	Yes
Comment start character	(
Comment end character	)
Translation mode for CR	Transmit as CR
Translation mode for LF	Transmit as LF
Program start string	
Program end string	
Filter Null Characters	Yes
Character to transmit at start	Number of Characters
Character to transmit at end	Number of Characters

Receive settings

Receive directory	Specify folder to store programs coming from machine
Wait period before receiving program	45.0
Wait period after receiving program	5.0
Transmit XON before transmitting program	No
Auto compare and save	Yes
Acknowledgements and errors	Transmit descriptive messages
Translation mode for CR	Ignore
Translation mode for LF	Save as CRLF
Save Program between Start Characters and End Characters	No
Start Program reception after these characters are received	
End Program reception after these characters are received	
Acknowledgement / Error message start	% **O**1234
Acknowledgement / Error message	M30 %
Ignore control characters other than CR-LF	Yes

To set the PC in the Drip-feed mode

Handshake to   = Software
Drip feed   = ON

Cable connection

If the PC has 9 pin connector

Null modem		Full Handshake	
PC 9 pin	CNC 25 pin	PC 9 pin	CNC 25 pin
1	8	1	8
2 — 2		2 — 2	
3 — 3		3 — 3	
4 — 20		4 — 6	
5 — 7		5 — 7	
6 — 6		6 — 20	
7 — 4		7 — 5	
8 — 5		8 — 4	

If the PC has 25 pin connector

Null modem		Full Handshake	
PC 25 pin	CNC 25 pin	PC 25 pin	CNC 25 pin
8	8	8	8
2 — 3		2 — 3	
3 — 2		3 — 2	
20 — 20		20 — 6	
7 — 7		7 — 7	
6 — 6		6 — 20	
4 — 4		4 — 5	
5 — 5		5 — 4	