The info directly below here is from a Fanuc source ... you may need to perform this to enable the FOCAS ethernet IP and TCP port.

This is info I saw from a Fanuc technician for enabling FOCAS. This may or may not directly apply to your controls.

In some cases the ethernet connection may be CD38A, not 39
You have to make sure you connect to the Fanuc Main Module in the electrical cabinet typically the (A02B-0319-B802) at the Ethernet connection CD39A. Any other Ethernet connection on the machine will not work.
Once connected you have to access the IP address on the Fanuc side of the control not the Windows PC side of the control.
For this you have to go to the "System" page, then "Embed Port", there you will find the IP Address that you can change to what you want.
One this is all done you should be able to communicate with the Fanuc Focus Libraries.
This should be the same for most control types.

Then ...
Below is some info concerning the Memex FOCASInterfaceTester ... there is no real manual since it is primarily a Memex engineering tool.

You can find a zip file containing the files for the FOCASTester at the following URL:
http://updates.memex.ca/installs/FOCASInterfaceTest2.zip

Unzip the file unto the desktop of a host computer with access to the network where the machines are located and connected to.
Check that the machine IPs are accessible by pinging the machine IPs from a Start -> Run -> CMD prompt. The machines which respond to PING are the ones you can then test.

Launch the FOCASInterfaceTester.exe application.
Input the IP address for the first machine to be tested.
Change the port ONLY if you know that the default was changed, **default is 8193.**
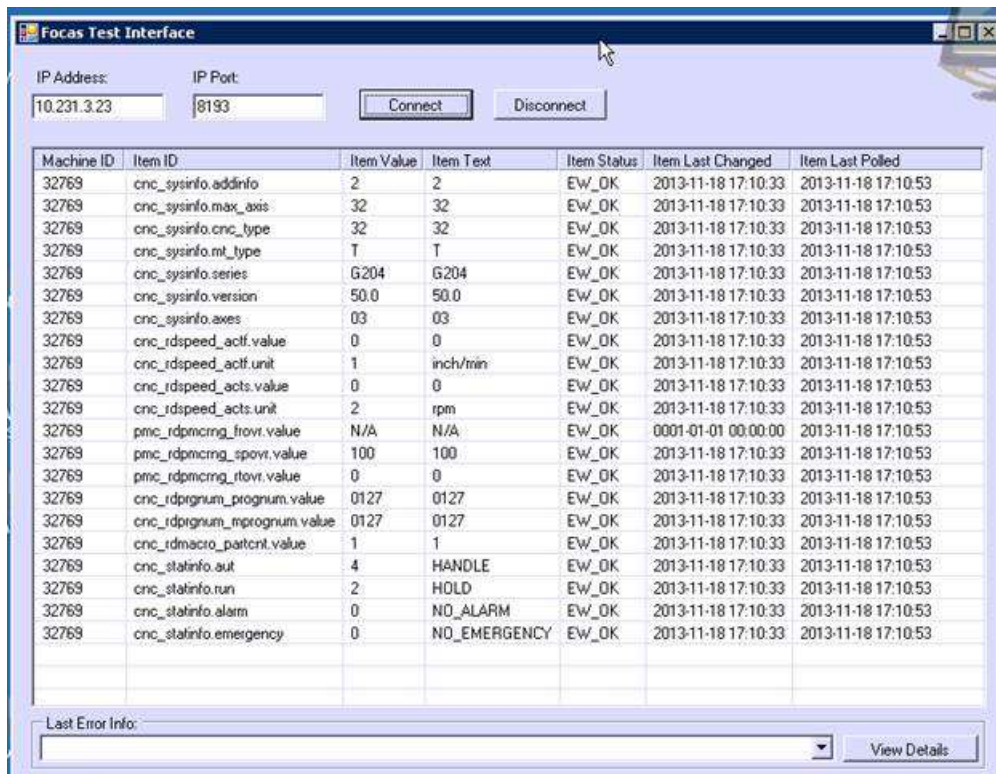Click Connect
If the tester fails to connect then:
1. The IP may not be for the machine tool port which hosts the FOCAS protocol (some Fanuc machine tools have two data servers with two ethernet ports)
2. The FOCAS protocol is not enabled, or is not executing/running...

If machine data is received the FOCAS tester will display it.

The Memex Merlin software does not care if the FOCAS version is 1 or 2, we accept both.

Click on 'Connect' and it should poll the machine for information similar to the example below:

Focas Test Interface

IP Address: `10.231.3.23` IP Port: `8193` [Connect] [Disconnect]

Machine ID	Item ID	Item Value	Item Text	Item Status	Item Last Changed	Item Last Polled
32769	cnc_sysinfo.addinfo	2	2	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.max_axis	32	32	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.cnc_type	32	32	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.mt_type	T	T	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.series	G204	G204	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.version	50.0	50.0	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_sysinfo.axes	03	03	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdspeed_actf.value	0	0	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdspeed_actf.unit	1	inch/min	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdspeed_acts.value	0	0	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdspeed_acts.unit	2	rpm	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	pmc_rdpmcrng_frovr.value	N/A	N/A	EW_OK	0001-01-01 00:00:00	2013-11-18 17:10:53
32769	pmc_rdpmcrng_spovr.value	100	100	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	pmc_rdpmcrng_rtovr.value	0	0	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdprgnum_prognum.value	0127	0127	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdprgnum_mprognum.value	0127	0127	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_rdmacro_partcnt.value	1	1	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_statinfo.aut	4	HANDLE	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_statinfo.run	2	HOLD	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_statinfo.alarm	0	NO_ALARM	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53
32769	cnc_statinfo.emergency	0	NO_EMERGENCY	EW_OK	2013-11-18 17:10:33	2013-11-18 17:10:53

Last Error Info: [ ] [View Details]