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](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:

