4.7.3 SETTING OF BAUD RATE AND OTHERS OF SERIAL INTERFACE (CONT'D)

b. Setting Stop Bit

Input and Output in Common	#6027D4	= 1: Stop bit as 2 bits
Input	#6027D4	= 0: Stop bit as 1 bit
Output	#6029D4	

c. Setting Control Code Sending

Input and Output in Common	#6027D5	= 1: Does not send control code
Input	#6027D5	= 0: Sends control code
Output	#6029D5	

Notes:

1. Some controls do not allow the switching between the setting types by #6028D6 but are fixed to the type in which data is set for input and output combined.

2. Set the baud rate and stop bit length according to the specifications of the input/output equipment to be used.

3. The start and stop signals to be send from the NC to the input/output equipment after pressing IN, VER, or OUT key are called "control codes." If the specifications of the input/output equipment do not allow the acceptance of the control codes, set the parameter for control code transmission designation to "1" (not send). In this case, it is necessary to press IN, VER, or OUT key on the NC side then start/stop the input/output equipment manually.

4.7.4 CABLE CONNECTOR SPECIFICATIONS

The specifications of the cable connectors for data input/output interface are as shown in Tables 4.7.10 through 4.7.14. These specifications depend on the external equipment to be used and are therefore listed in this publication for reference purpose only. Refer to the manual of the external equipment.

Table 4.2 FACIT 4070 Interface Connecting Cable

NC (MR-20F)			Connections	External Equipment (DB-25P)	
Symbol	Signal Name	Pin No.		Pin No.	Symbol
PR	PUNCH READY	1	◯——◯	12	PR
TL	TAPE LOW	2	◯——◯	21	TL
ERR1	ERROR	3	◯——◯	20	ERR1
	Not Used	4			
+6 V	FACIT/ASR. Auto-selection	5	◯——◯	24	+6 V
	Not Used	6			
	Not Used	7			
0 V	GROUND	8			
0 V	GROUND	9	◯——◯	10	SD
0 V	GROUND	10	◯——◯	25	0 V
CH1	PUNCH DATA 1	11	◯——◯	1	CH1
CH2	PUNCH DATA 2	12	◯——◯	2	CH2
CH3	PUNCH DATA 3	13	◯——◯	3	CH3
CH4	PUNCH DATA 4	14	◯——◯	4	CH4
CH5	PUNCH DATA 5	15	◯——◯	5	CH5
CH6	PUNCH DATA 6	16	◯——◯	6	CH6
CH7	PUNCH DATA 7	17	◯——◯	7	CH7
CH8	PUNCH DATA 8	18	◯——◯	8	CH8
CH9	FEED HOLD	19	◯——◯	9	CH9
PI	PUNCH INSTRUCTION	20	◯——◯	11	PI

└─Note

Note: The pin numbers at the time the external equipment is FACIT 4070 and its plug-in connector is DB-25P.