4.7.4 CABLE CONNECTOR SPECIFICATIONS (CONT'D)

Table 4.6 RS422 Interface Connection Cable

Symbol	Signal Name	Pin No.	Connections	Pin No.	Symbol
				External Equipment	
				NC (DB-37P)	
SHIELD	Shield	1			
	Not used	2			
	Not used	3			
SD	Sending data	4			SD
	Not used	5			
RD	Receiving data	6			RD
RS	Request sending	7			RS
	Not used	8			
CS	Cable of sending	9			CS
	Not used	10			
	Not used	11			
ER	NC ready	12			ER
DR	I/O device ready	13			DR
	Not used	14			
		(			
		18			
SG	Signal grounding	19			
	Not used	20			
	Not used	21			
*SD	Sending data	22			*SD
	Not used	23			
*RD	Receiving data	24			*RD
*RS	Request sending	25			*RS
	Not used	26			
*CS	Capable of sending	27			*CS
	Not used	28			
	Not used	29			
*ER	NC ready	30			*ER
*DR	I/O device ready	31			*DR
	Not used	32			
		(37			

Table 4.7 RS232C Interface Connection Cable (B)

Symbol	Signal Name	Pin No.	Connections	Pin No.	Symbol
	NC (DB-25P)			**External Equipment**	
FG		1			FG
SD	Sending data	2			SD
RD	Receiving data	3			RD
RS	Request sending	4			RS
CS	Capable of sending	5			CS
	Not used	6			DR
SG	Signal grounding	7			SG
		8			
	Not used				ER (OR IO ALARM)
		25			

4.7.5 OPERATIONS USING DATA INPUT/OUTPUT INTERFACE

The use of data input/output interface allows the following operations and runs:

(1) The input/output operations of tool offset amounts, setting data, and parameter data and the output operations (punch out) of part programs. For details, see 4.4 TAPE INPUT/OUTPUT OPERATIONS OF NC DATA.

(2) The storing of part programs into memory. For details, see 4.5 LOADING PART PROGRAMS INTO MEMORY

(3) Tape-verification of part programs, tool offset amount, setting data, and parameter data. For details, see 4.8 TAPE VERIFYING.

(4) Automatic run in tape mode.

The control may be automatically run in tape mode not via the tape reader on the machine but via the data input/output interface. For details, see 7.6 OPERATION IN TAPE AND MEMORY MODE.