4.7 SUPPLEMENT TO DATA INPUT / OUTPUT INTERFACE

The external equipment having the designated input/output interface may be attached to the NC to input/output the following NC information:

(1) Part Programs.
(2) Tool Offset Amount.
(3) Setting Data and Parameters.

4.7.1 TYPES AND FUNCTIONS OF INTERFACE

Table 4.1

	1	2	3	4
Name of interface	FACIT 4070 Interface	Current Loop Interface (20mA)	RS232C Interface	RS422 Interface
Type of interface	Parallel·Voltage Interface	Serial·Current Interface	Serial·Voltage Interface	Serial·Balanced Interface
Data transmission speed	70 char/s	Parameter setting	Input: #6026 Output: #6028	Input: #6027 Output: #6029
Connector (Note)	MR-20MR		DB-25S	DB-37S
Max cable length	5 m	50 m	15 m	100 m
External equipment	FACIT 4070 or equipment having equivalent interface	ASR-33 or equipment having current loop (20 mA) interface	Equipment having RS232C interface	Equipment having RS422 interface
Functions	· Output the NC data to the external equipment (for punching out NC tape)		· Storing NC data into NC memory or collating them. · Outputting NC data to external equipment (punch out) · Automatic operation in the Tape mode	

Note: The types of the connector on the NC side. For the mating connectors to this connector, use the following: MR-20F, DB-25P, DB-37P

④ RS422 INTERFACE (DB-37S)
③ RS232C INTERFACE (DB-25S)
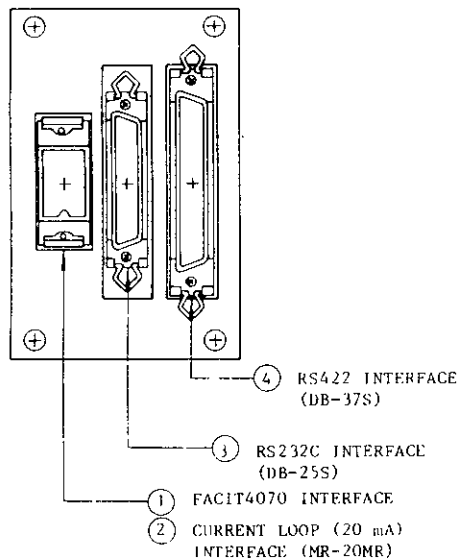① FACIT 4070 INTERFACE
② CURRENT LOOP (20 mA) INTERFACE (MR-20MR)

Fig. 4.39 Data I/O Interface Receptacles in Control Cabinet

4.7.2 SETTING OF DATA INPUT/OUTPUT INTERFACE TO BE USED

To use data input/output interface, it is necessary to set which interface is to be used. Make this setting as follows:

(1) Setting of Data Input Interface to Be Used

IDVCE1 (#6003, D1)	IDVCE0 (#6003, D0)	Data Input Interface to be used
0	0	PTR Interface (Note)
0	1	RS232C Interface
1	0	RS422 Interface

Note: PTR interface is for the standard tape reader. Usually, this interface is set.