

Moxa RS485 Gateway Setup

This Document describes the Setup for Moxa TCP Modbus Gateways, with usage for PHP Scripts and within the Symcon Studer Modules

Hardware

This Setup was tested with a Moxa MB3280 but other similar Device can be adopted (MB3270, MB3170, MB3270)

Security

Always make sure to tun the latest Firmware

Settings

a) Serial Settings

⚙️ **Serial Settings**

Port	Baud rate	Parity	Data bit	Stop bit	Flow control	FIFO	Interface	RTS on delay	RTS off delay
1	9600 ▼	Even ▼	8 ▼	1 ▼	None ▼	Enable ▼	RS-485 2-wire ▼	0	0
2	9600 ▼	Even ▼	8 ▼	1 ▼	None ▼	Enable ▼	RS-485 2-wire ▼	0	0

Submit

b) Protocol Settings => Mode

⚙️ **Modbus Operation Mode**

Port	Mode
1	RTU Slave ▼
2	Disable ▼

Submit

c) Protocol Settings => Modbus

Modbus Parameters

Modbus Settings

Initial Delay (0-30000ms, Default: 0ms)

Modbus Listen Port (1-65535, Default: 502)

Modbus TCP Exception ☐ Enable

Response Time-out

Response Time-out (10-120000ms, Default: 1000ms)

Port1

Port2

TCP/ProCOM

Interval Time-out

Inter-character Time-out (10-500ms, Default: 0ms)

Port1

Port2

Inter-frame Delay (10-500ms, Default: 0ms)

Port1

Port2

d) Protocol Settings => Modbus Routing

Modbus Routing

Port Routing Table

Channel No.	Local Interface	Local IP address / TCP port	Destination
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Slave ID Table (only for TCP port : 502)

Auto device routing

<input type="checkbox"/>	01	Manual	Modbus serial	Slave ID Range (Virtual ID<->Real ID)	001 - 254 <-> 001 - 254	Port1 (Serial)
<input type="checkbox"/>	02	Manual	Modbus serial		000 - 000 <-> 000 - 000	Port2 (Serial)