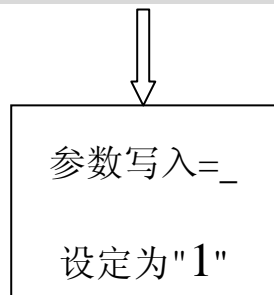
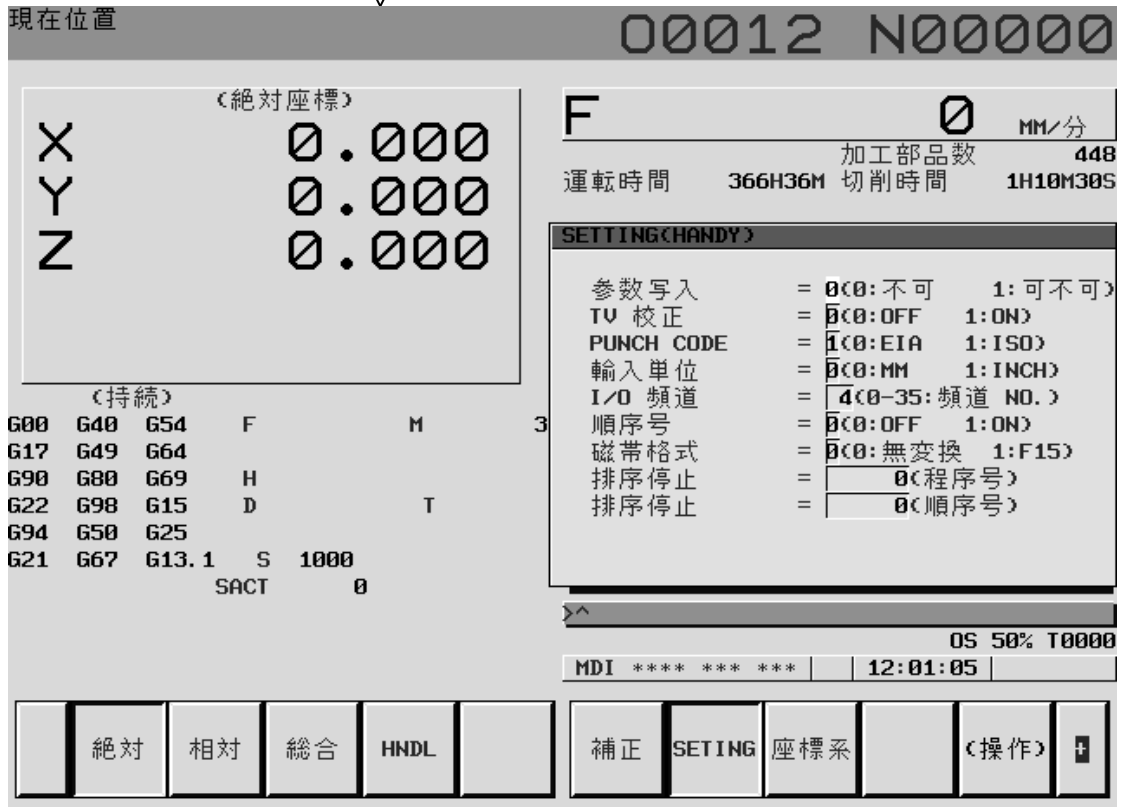
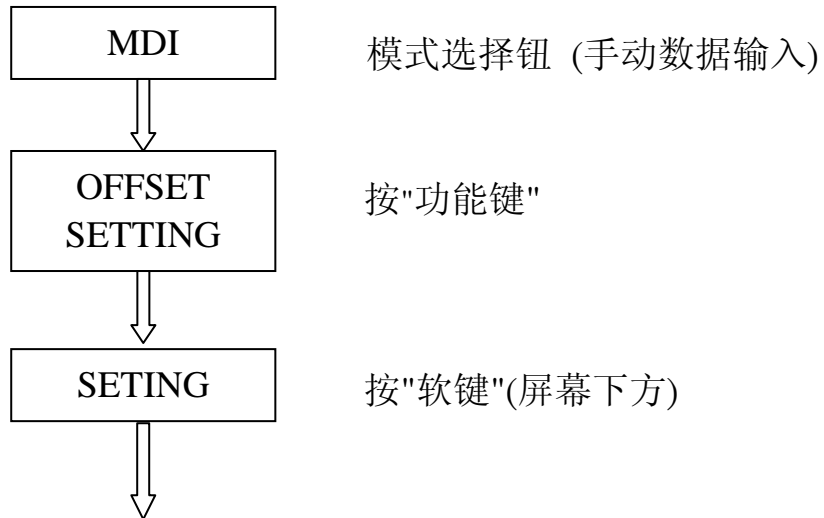


一. DATA SERVER 设定画面操作:

流程图:



現在位置 00012 N00000

X		0.000	
Y		0.000	
Z		0.000	

加工部品数 448
 運轉時間 365H26M 切削時間 11H51M59S

SETTING(CHANDY)

参数写入 = 0<0:不可 1:可不可>
 TV 校正 = 0<0:OFF 1:ON>
 PUNCH CODE = 1<0:EIA 1:ISO>
 輸入单位 = 0<0:MM 1:INCH>
 I/O 頻道 = 4<0-35:頻道 NO.>
 順序号 = 0<0:OFF 1:ON>
 磁帶格式 = 0<0:無变换 1:F15>
 排序停止 = 0<程序号>
 排序停止 = 0<順序号>

G00 G40 G54 F M 3
 G17 G49 G64
 G90 G80 G69 H
 G22 G98 G15 D T
 G94 G50 G25
 G21 G67 G13.1 S 3000
 SACT 0

OS 50% T0000
 MDI **** * 10:45:58

絕對 相對 綜合 HNDL NO檢索 接通:1 断開:0 +輸入 輸入

輸入

按"软键" (屏幕下方)

現在位置 00111 N00000

X		0.000	
Y		0.000	
Z		0.000	

加工部品数 99
 運轉時間 56H49M 切削時間 0H 0M 0S

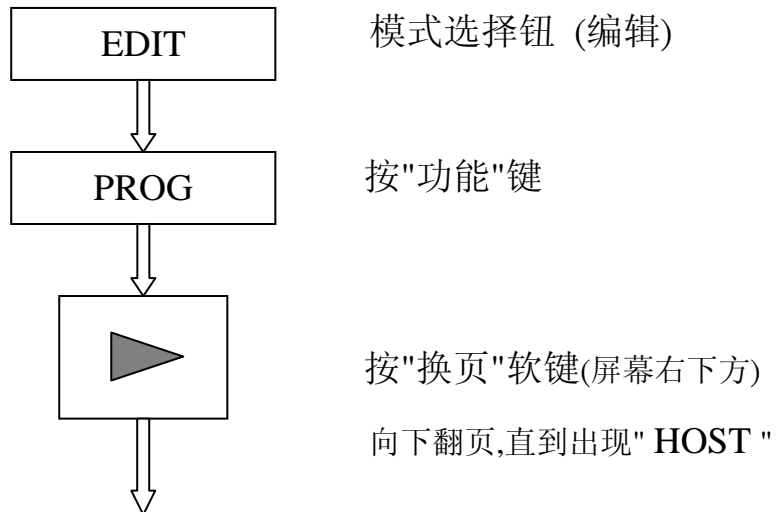
報警信号信息
 100 可写入参数

G00 G40 G54 F M
 G17 G49 G64
 G90 G80 G69 H
 G22 G98 G15 D T
 G94 G50 G25
 G21 G67 G50.1 S
 SACT 0

OS 50% T0000
 MDI **** * 11:01:11

絕對 相對 綜合 HNDL ALARM MESSAG 過程

五.程序传输(CNC 与 PC 联机)操作说明:



模式选择钮 (编辑)

按"功能"键

按"换页"软键(屏幕右下方)

向下翻页,直到出现"HOST"

現在位置

00111 N00000

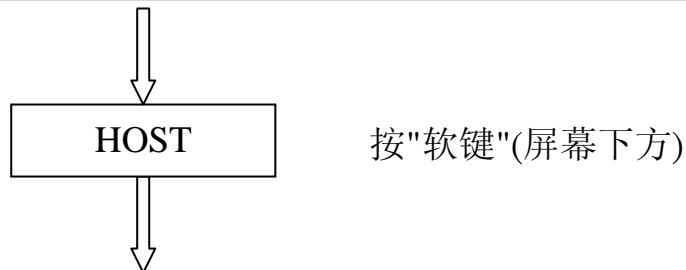
(絶対座標)
 X 0.000
 Y 0.000
 Z 0.000
 (持續)
 G00 G40 G54 F M
 G17 G49 G64
 G90 G80 G69 H
 G22 G98 G15 D T
 G94 G50 G25
 G21 G67 G50.1 S
 SACT 0

F 0 MM/分
 加工部品数 99
 運転時間 56H49M 切削時間 0H 0M 0S

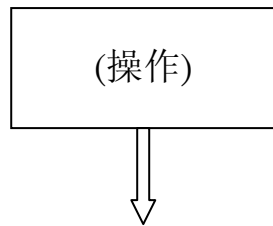
ETHERNET HOST FILE DIR
 AVAILABLE ETHERNET
 EMBEDDED PORT
 ETHERNET BOARD

OS 50% T0000
 EDIT **** * * * * 10:24:10

絶対 相對 綜合 HNDL HD-DIR HOST CONECT (操作)



按"软键"(屏幕下方)

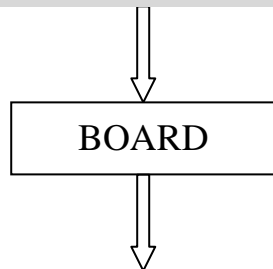


按"软键"

現在位置

00111 N00000

<p style="text-align: center;">〈絶対座標〉</p> <table style="width: 100%;"> <tr><td>X</td><td>0.0000</td></tr> <tr><td>Y</td><td>0.0000</td></tr> <tr><td>Z</td><td>0.0000</td></tr> </table> <p style="text-align: center;">〈持續〉</p> <table style="width: 100%;"> <tr><td>G00</td><td>G40</td><td>G54</td><td>F</td><td>M</td></tr> <tr><td>G17</td><td>G49</td><td>G64</td><td></td><td></td></tr> <tr><td>G90</td><td>G80</td><td>G69</td><td>H</td><td></td></tr> <tr><td>G22</td><td>G98</td><td>G15</td><td>D</td><td>T</td></tr> <tr><td>G94</td><td>G50</td><td>G25</td><td></td><td></td></tr> <tr><td>G21</td><td>G67</td><td>G50.1</td><td>S</td><td></td></tr> <tr><td></td><td></td><td>SACT</td><td></td><td>0</td></tr> </table>	X	0.0000	Y	0.0000	Z	0.0000	G00	G40	G54	F	M	G17	G49	G64			G90	G80	G69	H		G22	G98	G15	D	T	G94	G50	G25			G21	G67	G50.1	S				SACT		0	<p style="font-size: 2em; font-weight: bold;">F</p> <p style="text-align: right;">MM/分 99</p> <p>加工部品数</p> <p>運輸時間 56H49M 切削時間 0H 0M 0S</p> <div style="border: 1px solid black; padding: 5px;"> <p>ETHERNET PARAMETER</p> <p>AVAILABLE ETHERNET</p> <p>EMBEDDED PORT</p> <p>ETHERNET BOARD</p> </div> <p style="text-align: right;">OS 50% T0000</p> <p>MDI ***** 11:12:08</p> <table style="width: 100%; text-align: center;"> <tr> <td>絶対</td> <td>相對</td> <td>綜合</td> <td>HNDL</td> <td>BOARD</td> <td>EMBEDD</td> <td>PCMCIA</td> <td>SWITCH</td> </tr> </table>	絶対	相對	綜合	HNDL	BOARD	EMBEDD	PCMCIA	SWITCH
X	0.0000																																																	
Y	0.0000																																																	
Z	0.0000																																																	
G00	G40	G54	F	M																																														
G17	G49	G64																																																
G90	G80	G69	H																																															
G22	G98	G15	D	T																																														
G94	G50	G25																																																
G21	G67	G50.1	S																																															
		SACT		0																																														
絶対	相對	綜合	HNDL	BOARD	EMBEDD	PCMCIA	SWITCH																																											



按"软键"

与 PC 联机成功,会出现以下分享画面

HOST FILE DIR 00111 N00000

REGISTERED PROGRAMS : 4

CURRENT CONNECT HOST: 1

0001 T1.NCD

0002 T2.NCD

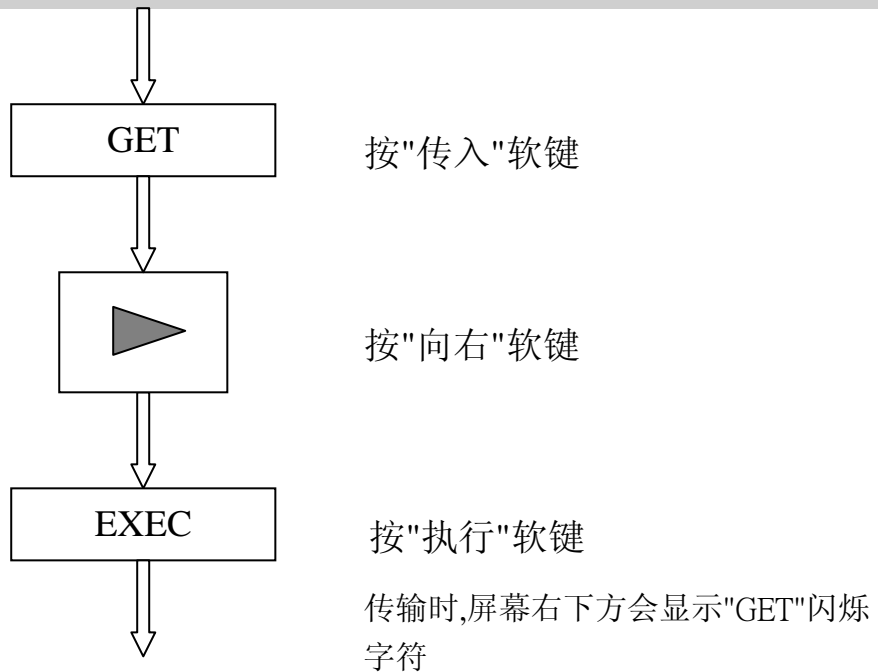
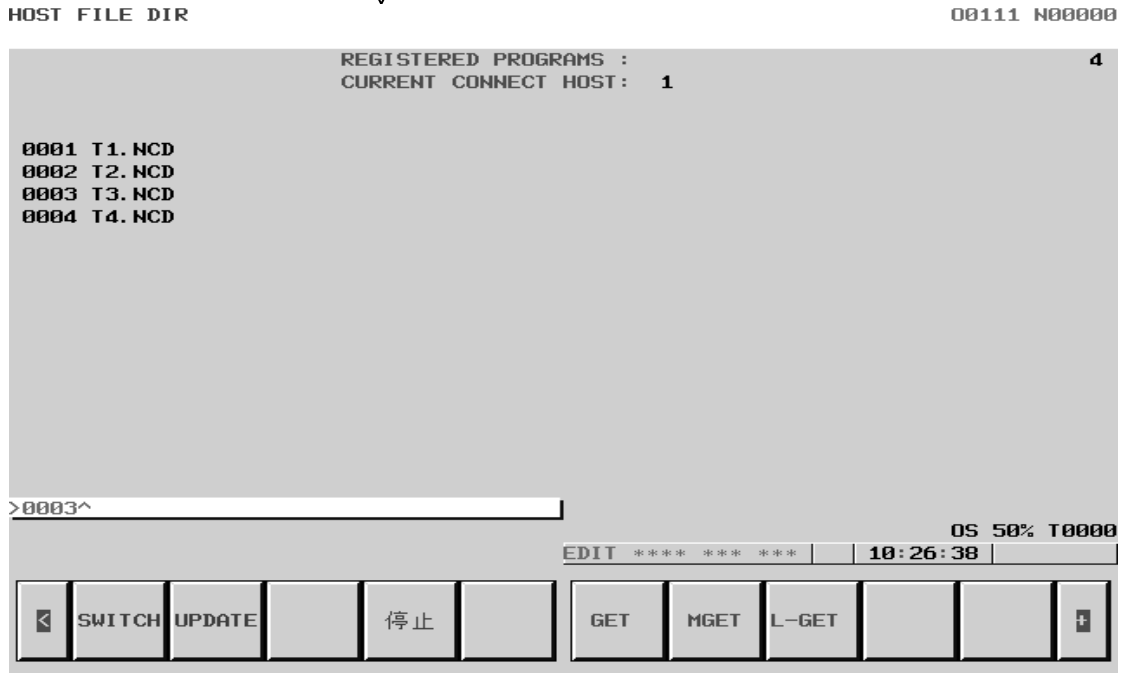
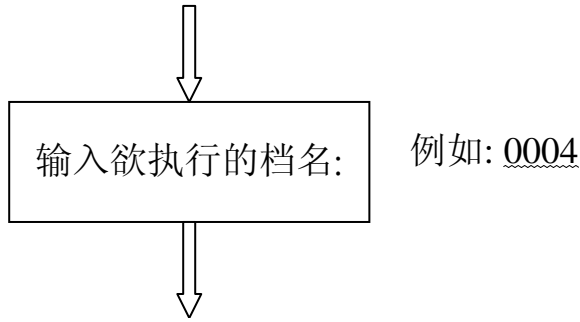
0003 T3.NCD

0004 T4.NCD

OS 50% T0000

EDIT ***** 10:25:03

SWITCH	UPDATE	停止	SEARCH	DELETE
--------	--------	----	--------	--------



HOST FILE DIR

00111 N00000

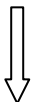
REGISTERED PROGRAMS : 4
CURRENT CONNECT HOST: 1

0001 T1.NCD
0002 T2.NCD
0003 T3.NCD
0004 T4.NCD

>0004^

OS 50% T0000
EDIT **** * * * * 11:33:21

◀	SWITCH	UPDATE		停止		LOCK		CAN	停止	EXEC	+
---	--------	--------	--	----	--	------	--	-----	----	------	---



HOST FILE DIR

00111 N00000

REGISTERED PROGRAMS : 4
CURRENT CONNECT HOST: 1

0001 T1.NCD
0002 T2.NCD
0003 T3.NCD
0004 T4.NCD

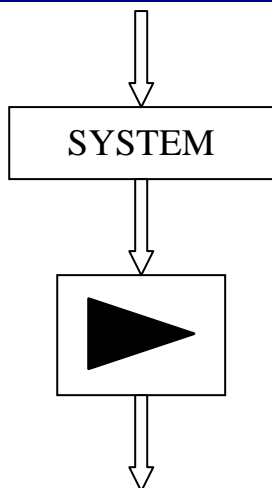
>^

COMPLETE

OS 50% T0000
EDIT **** * * * * 11:33:59

◀	SWITCH	UPDATE		停止		SEARCH				DELETE	+
---	--------	--------	--	----	--	--------	--	--	--	--------	---

(传输完成,会出现此画面)



进入 DATA SERVER 参数设定画面
按"功能键"

按"换页"软键(屏幕下方)
向下翻页,直到出现以下画面

現在位置

00111 N00000

(絶対座標)

X	0.000
Y	0.000
Z	0.000

(持續)

G00	G40	G54	F	M
G17	G49	G64		
G90	G80	G69	H	
G22	G98	G15	D	T
G94	G50	G25		
G21	G67	G50.1	S	
		SACT		0

ETHERNET PARAMETER

AVAILABLE ETHERNET

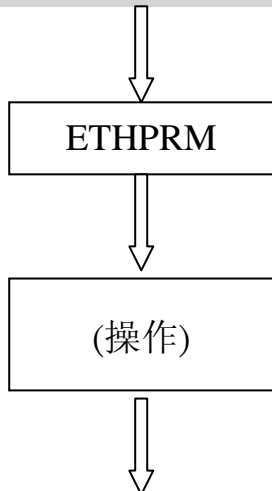
EMBEDDED PORT

ETHERNET BOARD

OS 50% T0000

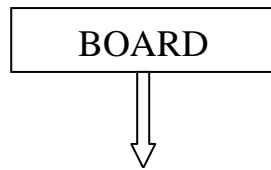
MDI **** * * * * 11:28:49

絶対 相對 綜合 HNDL ETHPRM ETHMNT <操作>



按"软键"

按"软键"



按"软键"

現在位置

00111 N00000

<p style="text-align: center;">(絶対座標)</p> <table style="width: 100%;"> <tr><td>X</td><td>0.000</td></tr> <tr><td>Y</td><td>0.000</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p style="text-align: center;">(持續)</p> <table style="width: 100%;"> <tr><td>G00</td><td>G40</td><td>G54</td><td>F</td><td>M</td></tr> <tr><td>G17</td><td>G49</td><td>G64</td><td></td><td></td></tr> <tr><td>G90</td><td>G80</td><td>G69</td><td>H</td><td></td></tr> <tr><td>G22</td><td>G98</td><td>G15</td><td>D</td><td>T</td></tr> <tr><td>G94</td><td>G50</td><td>G25</td><td></td><td></td></tr> <tr><td>G21</td><td>G67</td><td>G50.1</td><td>S</td><td></td></tr> <tr><td></td><td></td><td>SACT</td><td></td><td>0</td></tr> </table>	X	0.000	Y	0.000	Z	0.000	G00	G40	G54	F	M	G17	G49	G64			G90	G80	G69	H		G22	G98	G15	D	T	G94	G50	G25			G21	G67	G50.1	S				SACT		0	<p style="text-align: right;">F 0 MM/分</p> <p>加工部品数 99</p> <p>運轉時間 56H49M 切削時間 0H 0M 0S</p> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center;">ETHERNET PARAMETER</p> <p style="text-align: center;">AVAILABLE ETHERNET</p> <p style="text-align: center;">EMBEDDED PORT ETHERNET BOARD</p> </div> <p style="text-align: right;">OS 50% T0000</p> <p style="text-align: center;">MDI **** * 11:12:08</p>
X	0.000																																									
Y	0.000																																									
Z	0.000																																									
G00	G40	G54	F	M																																						
G17	G49	G64																																								
G90	G80	G69	H																																							
G22	G98	G15	D	T																																						
G94	G50	G25																																								
G21	G67	G50.1	S																																							
		SACT		0																																						

◀
絶対
相對
綜合
HNDL

BOARD
EMBEDD
PCMCIA
SWITCH

会出现以下画面

現在位置

00111 N00000

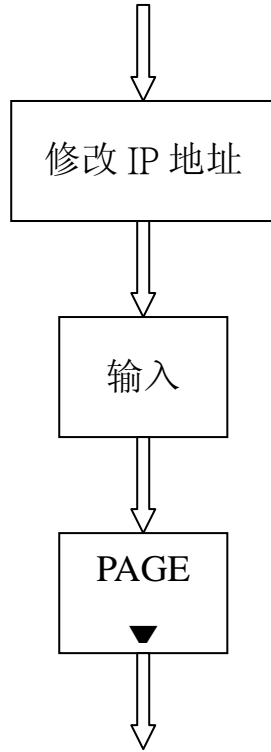
<p style="text-align: center;">(絶対座標)</p> <table style="width: 100%;"> <tr><td>X</td><td>0.000</td></tr> <tr><td>Y</td><td>0.000</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p style="text-align: center;">(持續)</p> <table style="width: 100%;"> <tr><td>G00</td><td>G40</td><td>G54</td><td>F</td><td>M</td></tr> <tr><td>G17</td><td>G49</td><td>G64</td><td></td><td></td></tr> <tr><td>G90</td><td>G80</td><td>G69</td><td>H</td><td></td></tr> <tr><td>G22</td><td>G98</td><td>G15</td><td>D</td><td>T</td></tr> <tr><td>G94</td><td>G50</td><td>G25</td><td></td><td></td></tr> <tr><td>G21</td><td>G67</td><td>G50.1</td><td>S</td><td></td></tr> <tr><td></td><td></td><td>SACT</td><td></td><td>0</td></tr> </table>	X	0.000	Y	0.000	Z	0.000	G00	G40	G54	F	M	G17	G49	G64			G90	G80	G69	H		G22	G98	G15	D	T	G94	G50	G25			G21	G67	G50.1	S				SACT		0	<p style="text-align: right;">F 0 MM/分</p> <p>加工部品数 99</p> <p>運轉時間 56H49M 切削時間 0H 0M 0S</p> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center;">ETHERNET PARAMETER</p> <p style="text-align: right;">PAGE: 1 / 7</p> <table style="width: 100%;"> <tr><td>MAC ADDRESS</td><td>080019039D4E</td></tr> <tr><td>NUMBER OF SCREENS</td><td>21</td></tr> <tr><td>MAXIMUM PATH</td><td>1</td></tr> <tr><td>HDD EXISTENCE</td><td>2</td></tr> <tr><td>IP ADDRESS</td><td>192.168.0.119</td></tr> <tr><td>SUBNET MASK</td><td>255.255.255.0</td></tr> <tr><td>ROUTER IP ADDRESS</td><td>192.168.0.120</td></tr> </table> <p style="text-align: left;">>192.168.0.119^</p> </div> <p style="text-align: right;">OS 50% T0000</p> <p style="text-align: center;">MDI **** * 10:55:38</p>	MAC ADDRESS	080019039D4E	NUMBER OF SCREENS	21	MAXIMUM PATH	1	HDD EXISTENCE	2	IP ADDRESS	192.168.0.119	SUBNET MASK	255.255.255.0	ROUTER IP ADDRESS	192.168.0.120
X	0.000																																																							
Y	0.000																																																							
Z	0.000																																																							
G00	G40	G54	F	M																																																				
G17	G49	G64																																																						
G90	G80	G69	H																																																					
G22	G98	G15	D	T																																																				
G94	G50	G25																																																						
G21	G67	G50.1	S																																																					
		SACT		0																																																				
MAC ADDRESS	080019039D4E																																																							
NUMBER OF SCREENS	21																																																							
MAXIMUM PATH	1																																																							
HDD EXISTENCE	2																																																							
IP ADDRESS	192.168.0.119																																																							
SUBNET MASK	255.255.255.0																																																							
ROUTER IP ADDRESS	192.168.0.120																																																							

◀
絶対
相對
綜合
HNDL

STRING
LOCK
輸入
+

*DATA SERVER 在网络上的 IP 地址与 PC 本身的 IP 地址,前三组数字设定须相同,最后一组可不同

IP ADDRESS : 为 DATA SERVER 在网络上的地址
 SUBNET MASK : 为 PC 本身的子网掩码
 ROUTER IP ADDRESS : 为 PC 本身的 IP 地址



例如: IP= 192.168.0.119
 用"↓"键,将光标移至"IP ADDRESS".

按"软键"(会出现"切断电源"警讯)

按"画页转换"键

向下翻页,直到出现以下画面

現在位置

00111 N00000

The screenshot shows the control panel interface with the following elements:

- Positioning Data:** X: 0.000, Y: 0.000, Z: 0.000 (Absolute coordinates).
- Machine Status:** F (Feed rate), 0 MM/分 (0 mm/min).
- Time/Counters:** 加工部品数 99 (Parts count), 56H49M (Run time), 切削時間 0H 0M 0S (Cutting time).
- ETHERNET PARAMETER Menu:**
 - (DATA SERVER) PAGE: 4 / 7
 - 1. PORT NUMBER 0
 - IP ADDRESS 192.168.0.120
 - USERNAME AWEA
 - PASSWORD
 - LOGIN DIR C:¥USER
- Bottom Panel:** Includes buttons for 絶対 (Absolute), 相对 (Relative), 総合 (Overall), HNDL, STRING, LOCK, 輸入 (Input), and a numeric keypad.

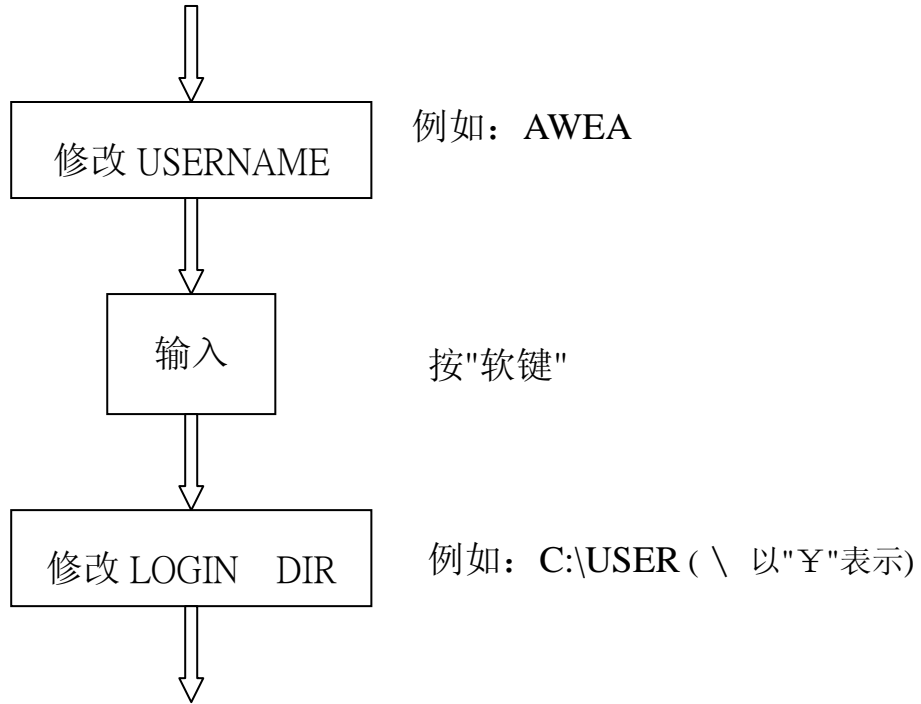
※ PORT NUMBER 设成 "21". (依据 "FANUC Data Server" 操作手册记载)

IP ADDRESS : 为 PC 本身的 IP 地址

USERNAME : 为进入 DATA SERVER 的使用者名称(以使用者为主)

PASSWORD : 为进入 DATA SERVER 的密码

LOGIN DIR : 为 PC 与 DATA SERVER 相连的工作目录



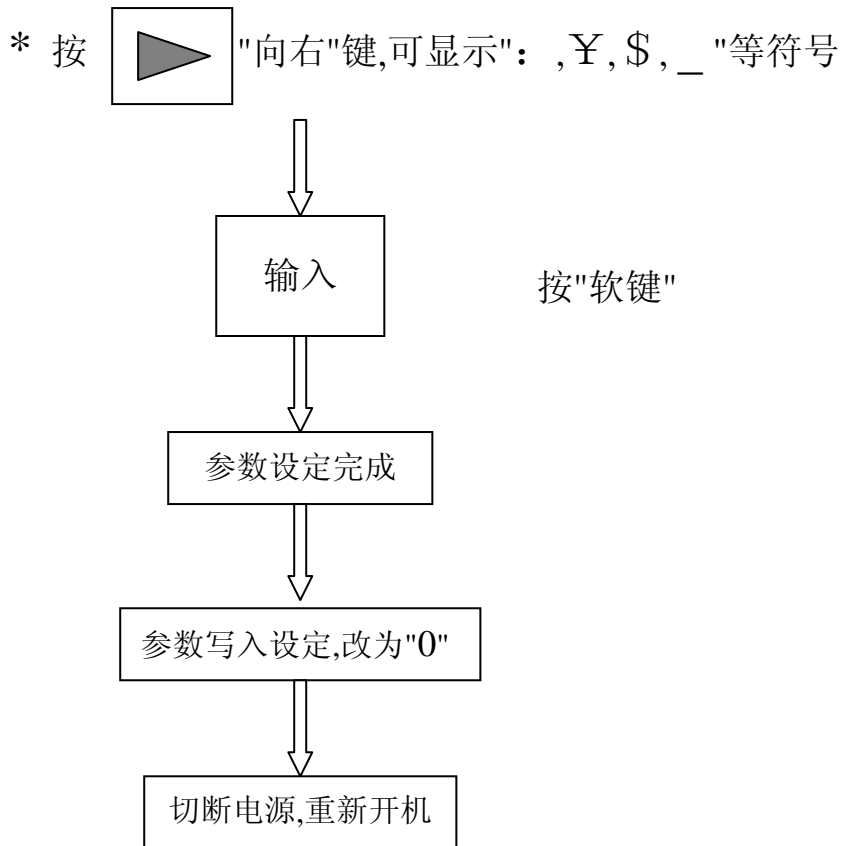
現在位置

00111 N00000

<p style="text-align: center;">(绝对座標)</p> <table style="width: 100%;"> <tr> <td style="font-size: 24px;">X</td> <td style="font-size: 24px;">0.000</td> </tr> <tr> <td style="font-size: 24px;">Y</td> <td style="font-size: 24px;">0.000</td> </tr> <tr> <td style="font-size: 24px;">Z</td> <td style="font-size: 24px;">0.000</td> </tr> </table> <p style="text-align: center;">(持續)</p> <table style="width: 100%; font-size: 12px;"> <tr> <td>G00</td><td>G40</td><td>G54</td><td>F</td><td>M</td> </tr> <tr> <td>G17</td><td>G49</td><td>G64</td><td></td><td></td> </tr> <tr> <td>G90</td><td>G80</td><td>G69</td><td>H</td><td></td> </tr> <tr> <td>G22</td><td>G98</td><td>G15</td><td>D</td><td>T</td> </tr> <tr> <td>G94</td><td>G50</td><td>G25</td><td></td><td></td> </tr> <tr> <td>G21</td><td>G67</td><td>G50.1</td><td>S</td><td></td> </tr> <tr> <td></td><td></td><td></td><td>SACT</td><td>0</td> </tr> </table>	X	0.000	Y	0.000	Z	0.000	G00	G40	G54	F	M	G17	G49	G64			G90	G80	G69	H		G22	G98	G15	D	T	G94	G50	G25			G21	G67	G50.1	S					SACT	0	<p style="font-size: 24px; font-weight: bold;">F</p> <p style="text-align: right;">加工部品数 99</p> <p>運轉時間 56H49M 切削時間 0H 0M 0S</p> <div style="border: 1px solid black; padding: 5px;"> <p style="text-align: center; margin: 0;">ETHERNET PARAMETER</p> <p style="margin: 0;">(DATA SERVER) PAGE: 4 / 7</p> <p style="margin: 0;">1. PORT NUMBER 0</p> <p style="margin: 0;">IP ADDRESS 192.168.0.120</p> <p style="margin: 0;">USERNAME AWEA</p> <p style="margin: 0;">PASSWORD</p> <p style="margin: 0;">LOGIN DIR C:¥USER</p> </div> <p style="text-align: right; font-size: 12px;">OS 50% T0000</p> <p style="text-align: center; font-size: 12px;">MDI **** * 10:57:41</p>
X	0.000																																									
Y	0.000																																									
Z	0.000																																									
G00	G40	G54	F	M																																						
G17	G49	G64																																								
G90	G80	G69	H																																							
G22	G98	G15	D	T																																						
G94	G50	G25																																								
G21	G67	G50.1	S																																							
			SACT	0																																						

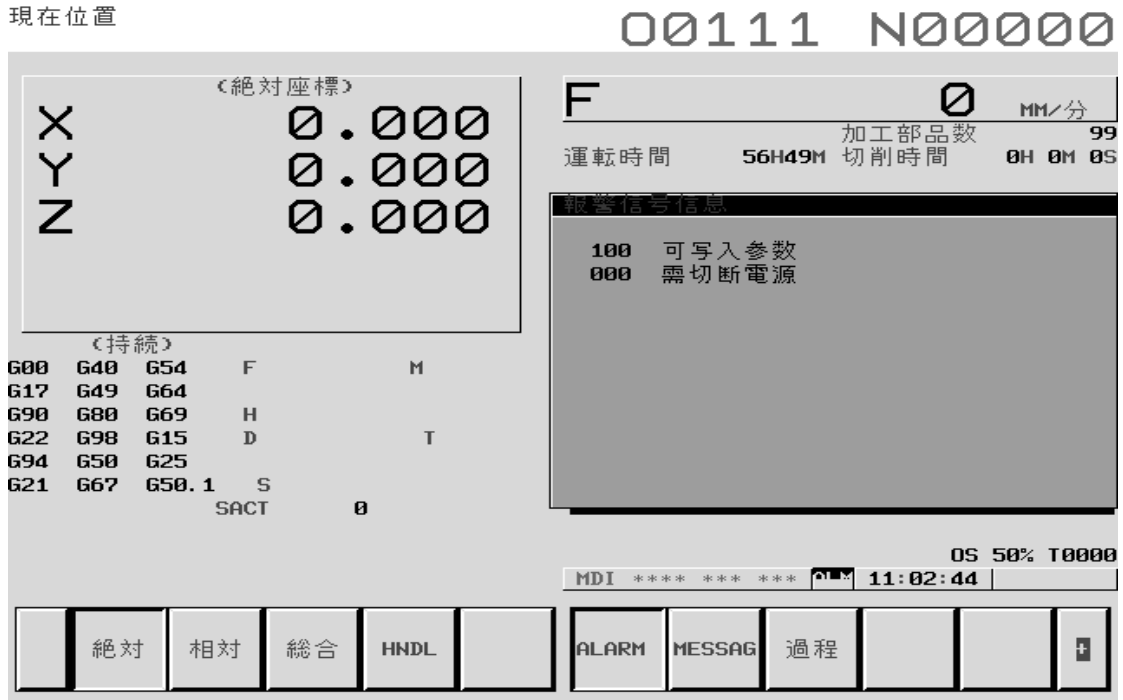
◀
绝对
相对
総合
HNDL

:
¥
\$
—
⏏



备注：

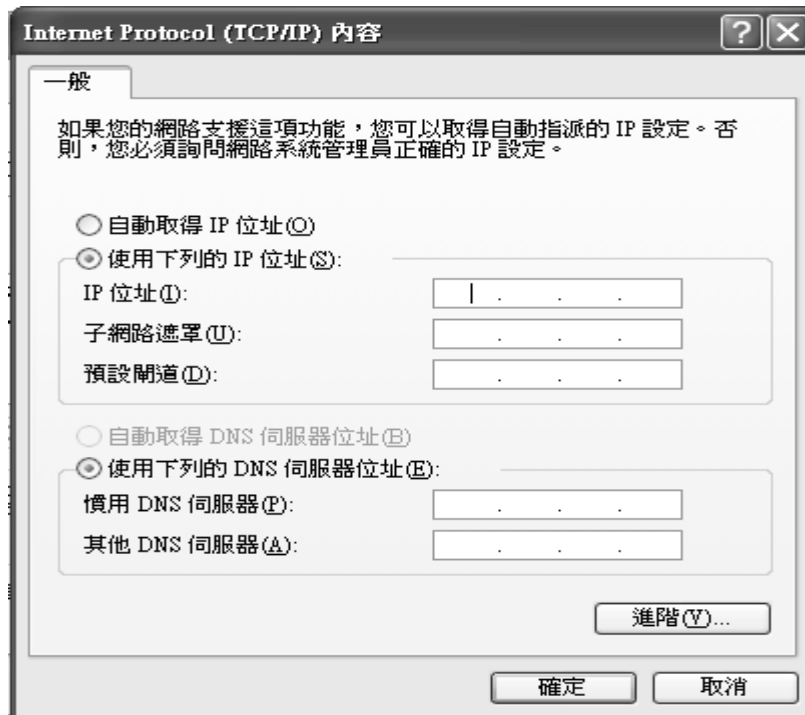
现在位置



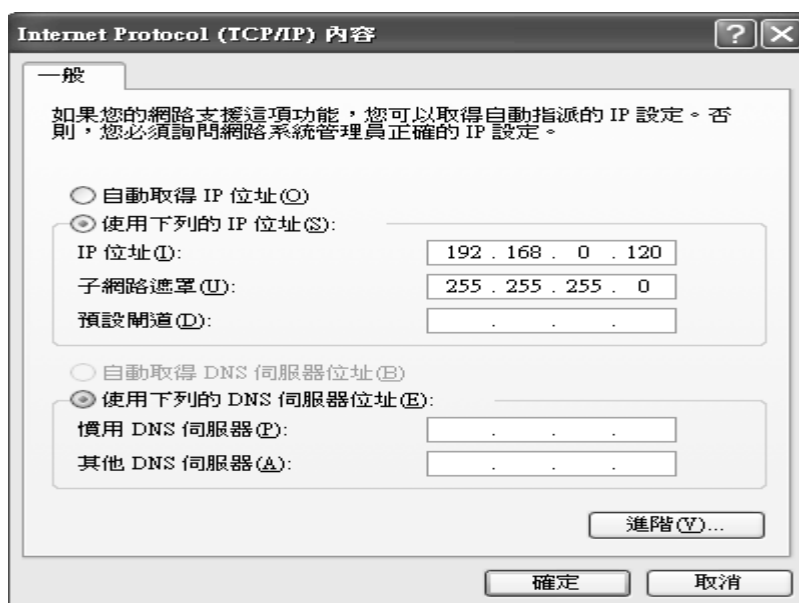
*操作中,出现此画面,暂时不予理会.待所有步骤都设定完成,再将电源切断.

二. IP 地址: (此为" Windows XP 版 " 设定画面)

- (1) 按 "开始" → "控制台" → "网络联机"(快按两下) → 选取 " Internet Protocol (TCP/IP) " → 按"内容" → 按 "使用下列的 IP 地址(S): "



- (2) 在" IP 地址 (I): 输入数字: 192.168.0.120 " (依据客户网络 IP 地址数字输入) 与" 子网掩码 (U): 输入数字: 255.255.255.0 ".

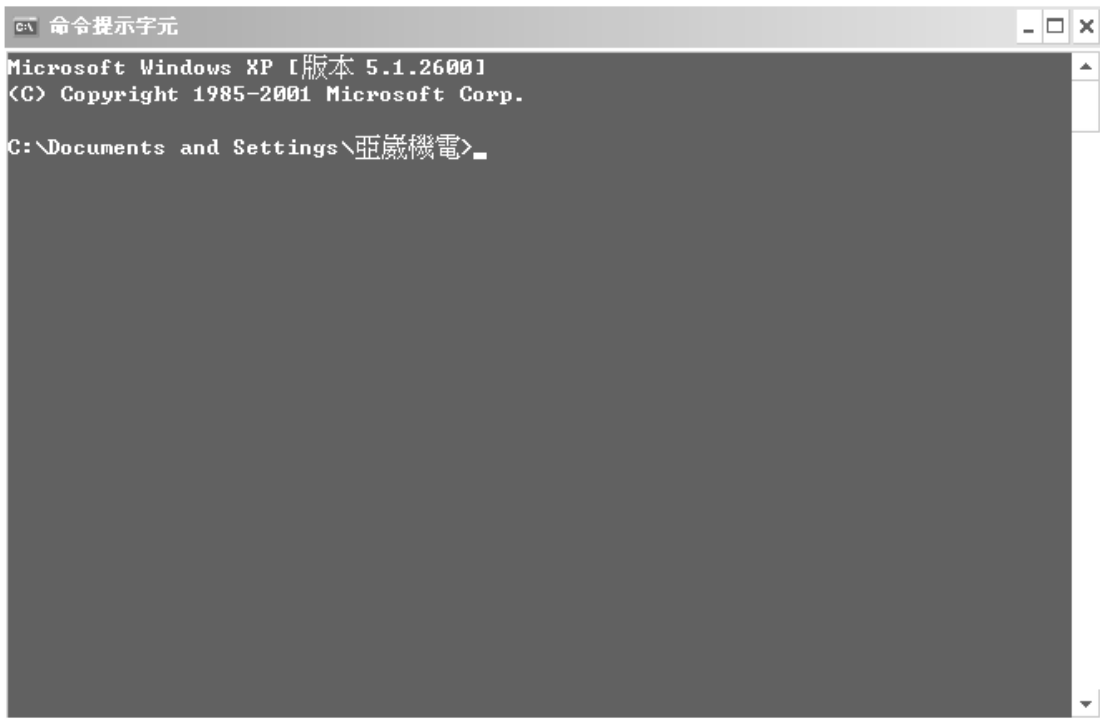


- (3) 按 "确定" (切换至以下画面) → 再按 "确定" → 关闭"网络联机"画面.



三.测试 NC 与 PC 之间网络是否接通: (此为" Windows XP 版 "设定画面)

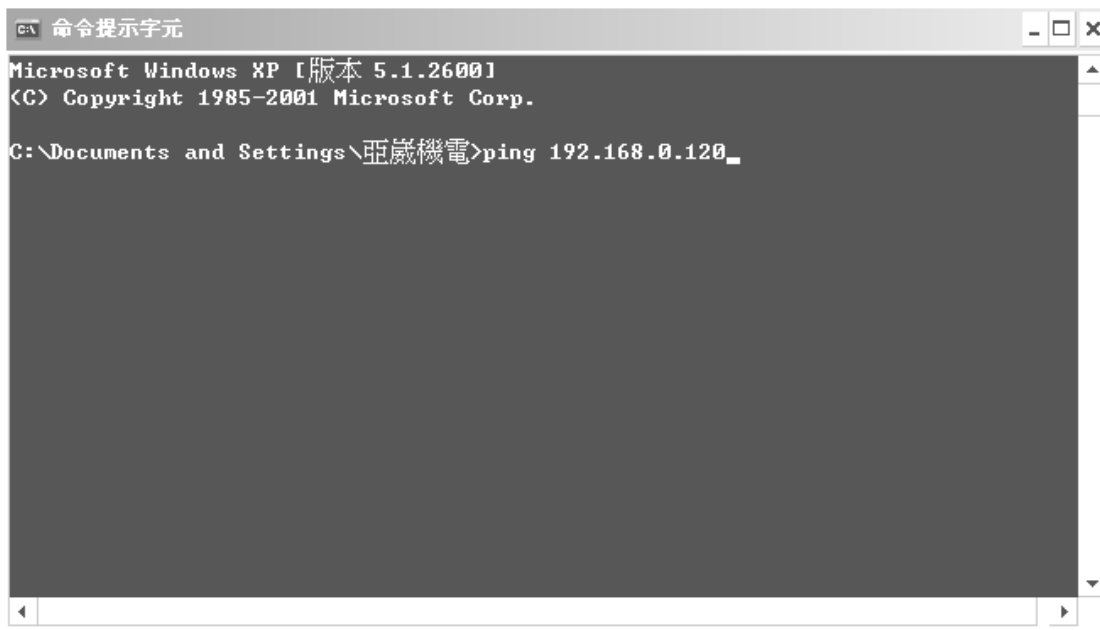
- (1) 按"开始" → "所有程序(P)" → "附属应用程序" → "命令提示字符" (相当于" Windows 98 "的" MS-DOS 模式 ") → 进入以下画面.



```

命令提示字符
Microsoft Windows XP [版本 5.1.2600]
<C> Copyright 1985-2001 Microsoft Corp.
C:\Documents and Settings\亞崙機電>
    
```

- (2) 输入 DOS 指令: " ping 192.168.0.120 ". (实际数字,须依照" DATA SERVER "内" IP_ADDRESS "的设定值而定)



```

命令提示字符
Microsoft Windows XP [版本 5.1.2600]
<C> Copyright 1985-2001 Microsoft Corp.
C:\Documents and Settings\亞崙機電>ping 192.168.0.120
    
```

(3) 按" Enter ",联机成功会出现此画面.

```

命令提示字元
Microsoft Windows XP [版本 5.1.2600]
(C) Copyright 1985-2001 Microsoft Corp.

C:\Documents and Settings\亞崙機電>ping 192.168.0.120

Pinging 192.168.0.120 with 32 bytes of data:

Reply from 192.168.0.120: bytes=32 time<1ms TTL=128
Reply from 192.168.0.120: bytes=32 time<1ms TTL=128
Reply from 192.168.0.120: bytes=32 time<1ms TTL=128
Reply from 192.168.0.120: bytes=32 time<1ms TTL=128

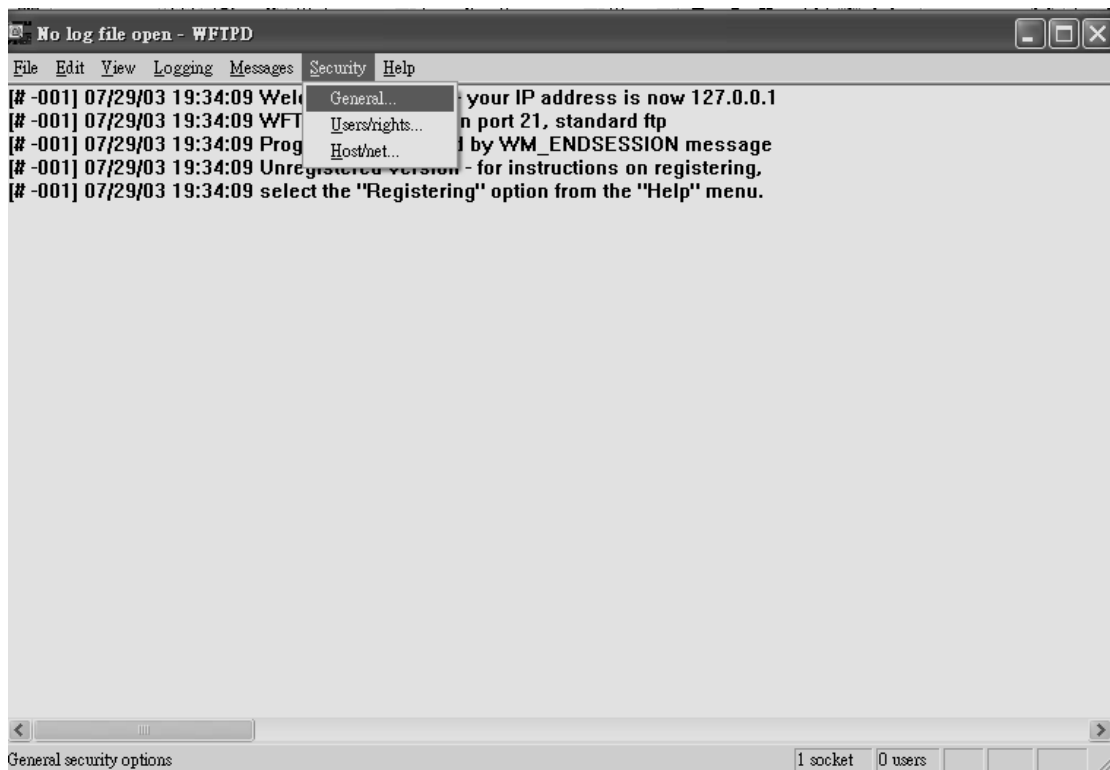
Ping statistics for 192.168.0.120:
    Packets: Sent = 4, Received = 4, Lost = 0 (0% loss),
    Approximate round trip times in milli-seconds:
        Minimum = 0ms, Maximum = 0ms, Average = 0ms

C:\Documents and Settings\亞崙機電>
    
```

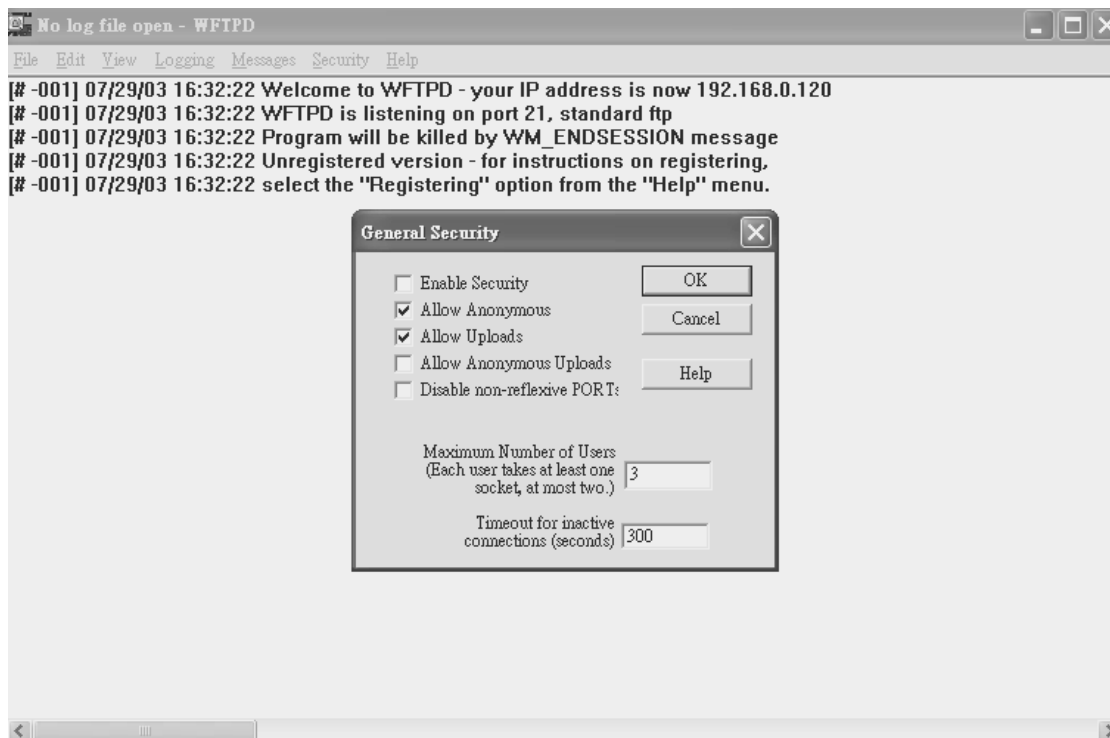
(4) 关闭此画面.

四.W_FTPD 软件安装及使用说明:

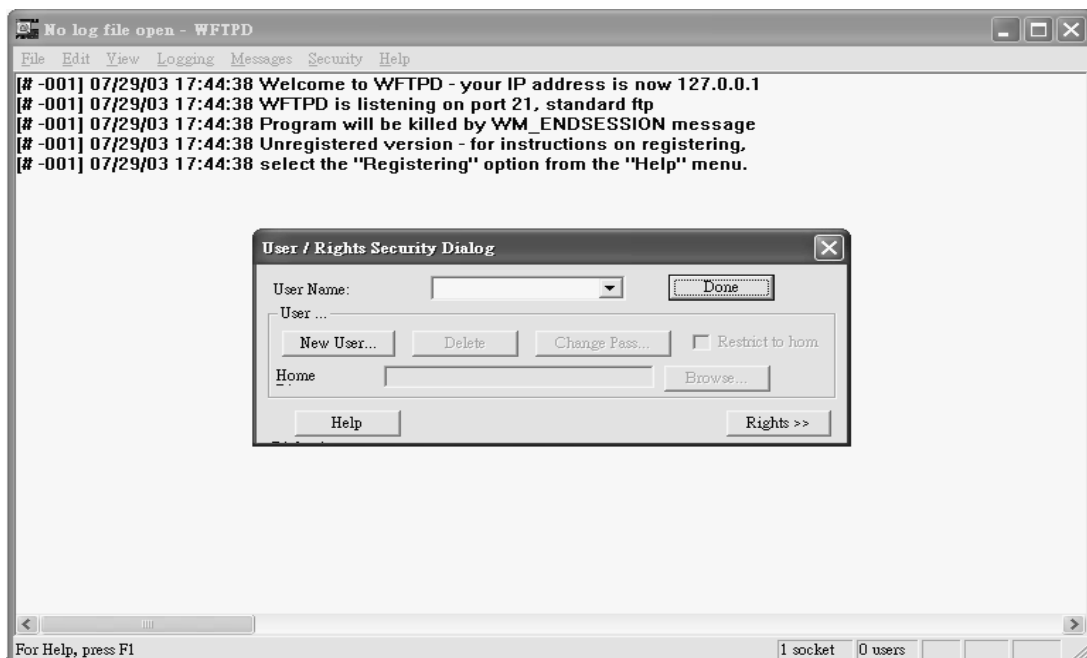
- (1) 进入"WINDOWS"系统,点选" Windows 档案总管".
- (2) 新建一名称为" X:\ DATA SERVER "的数据夹(或自订名称). (X:硬盘位置)
- (3) 将" W_FTPD "复制到新建的数据夹 (X:\ DATA SERVER)内.
- (4) 将数据夹内的" W_FTPD "传送到桌面当作快捷方式.
- (5) 用鼠标点选"快捷方式 W_FTPD"按两下,再点选" Security ".



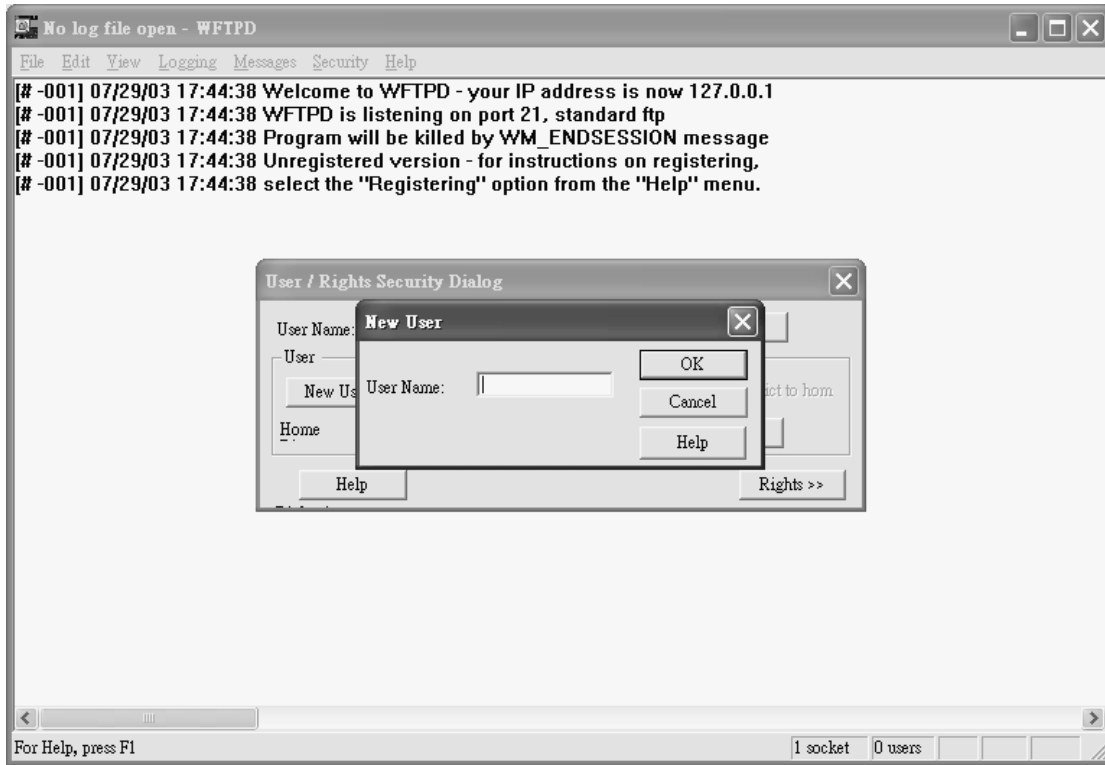
- (6) 点选"General..."进入下页画面,将"Allow Anonymous"选项打勾及"Maximum Number of Users"设定值更改为" 3 "或是以上的数字,不可为" 0 ",修改完成请按" OK ".



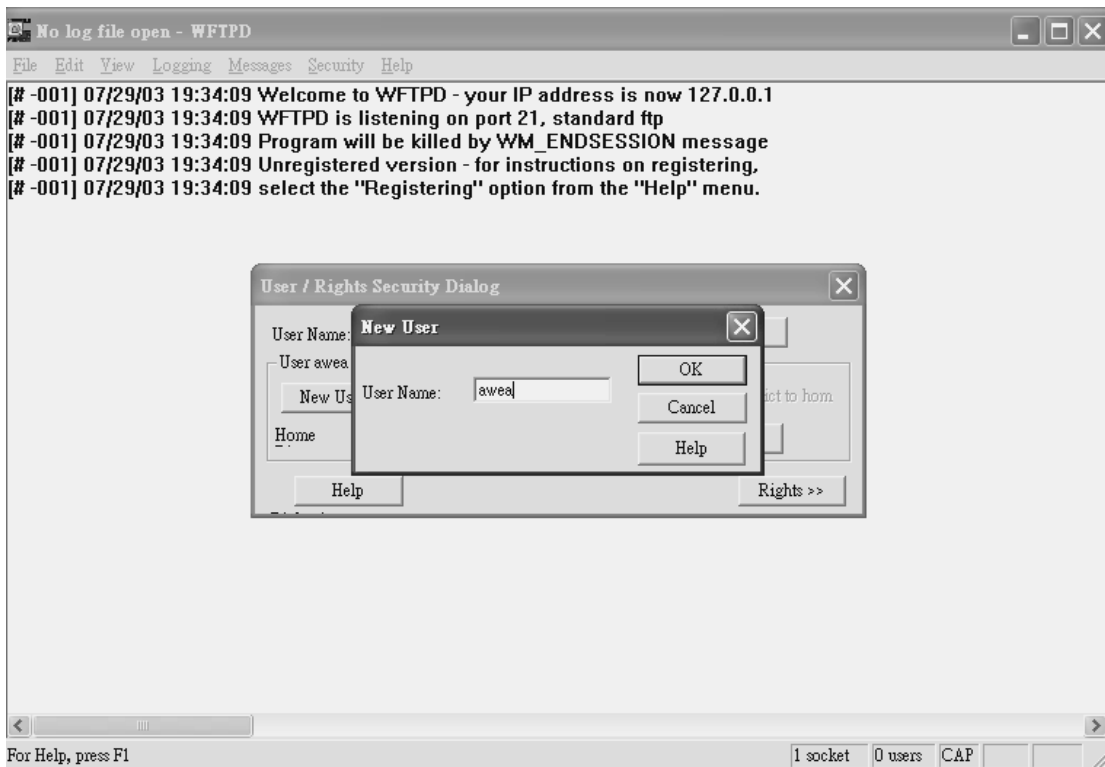
(7) 画面会自动切换回上一画面,点选" Security ",再点选" User/Rights… "。



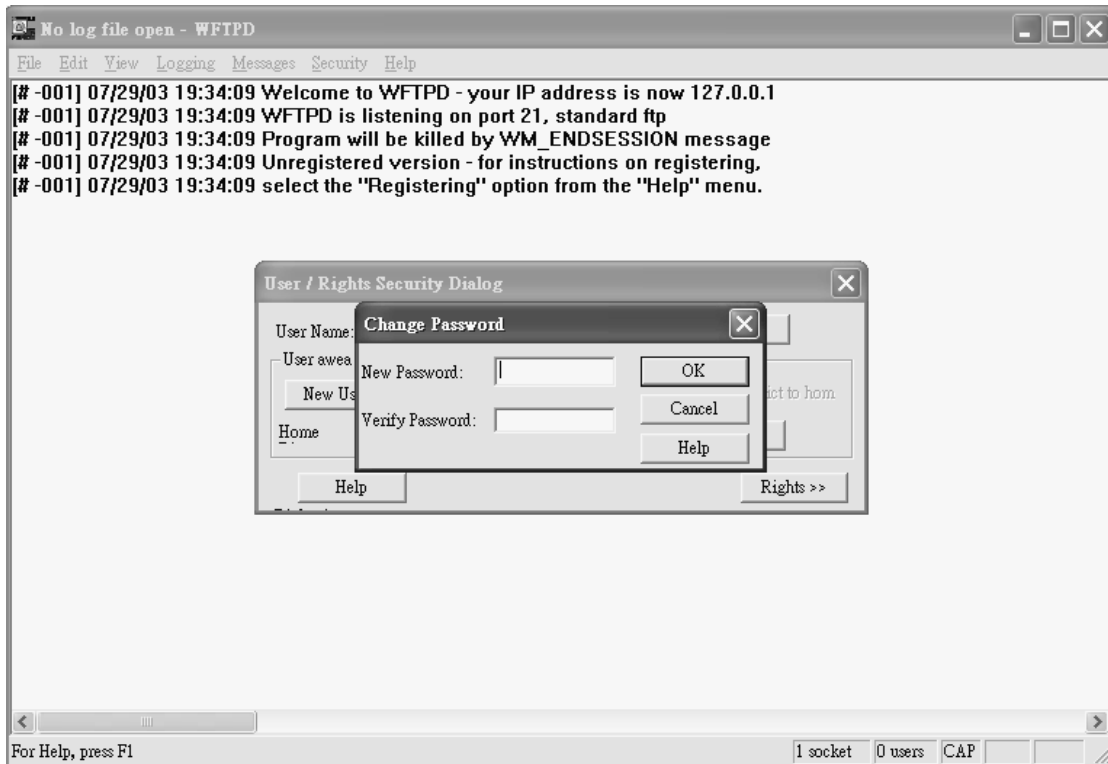
(8) 点选" New User "建立一个新的使用者名称(须与 NC 内 DATA SERVER 的使用者名称相同)。



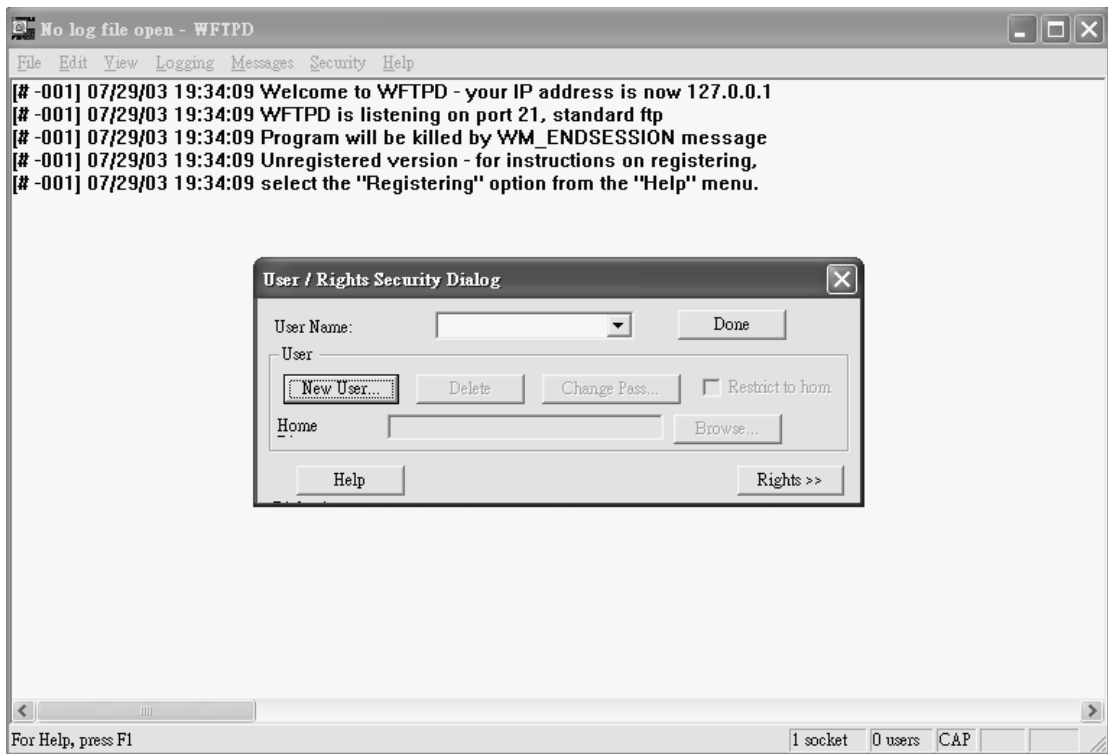
(9) 于" New User "空格内输入使用者名称,例如: awea



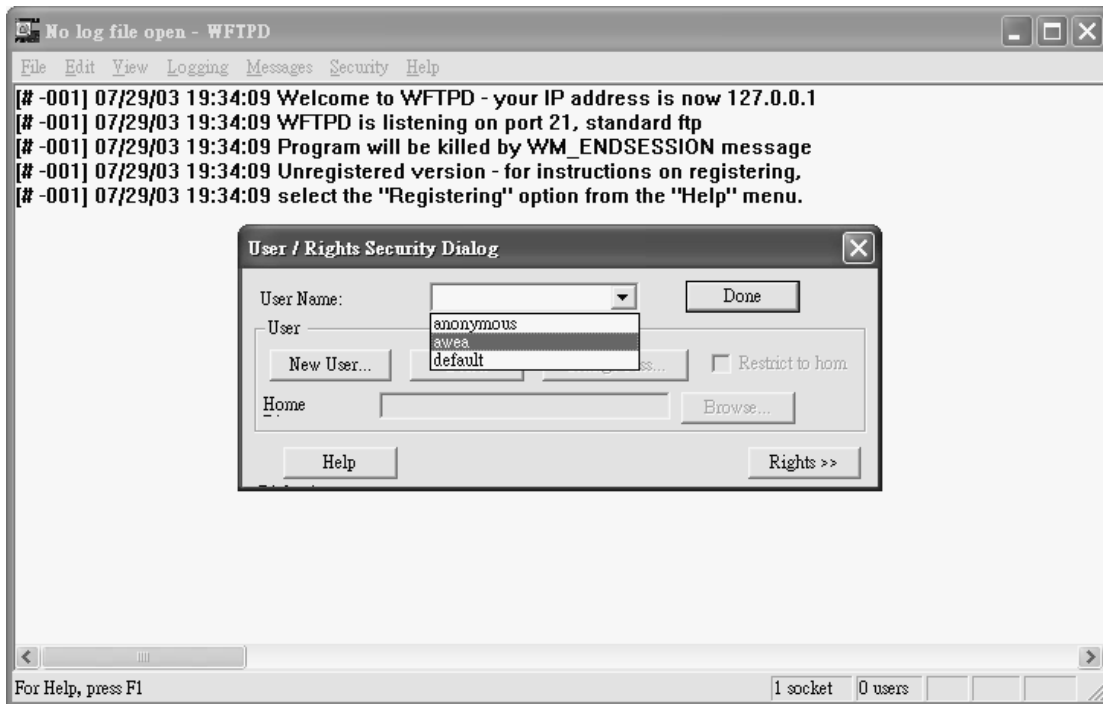
(10) 按" OK ",切换至如下图所示画面.可以不输入" Password "直接按" Cancel "



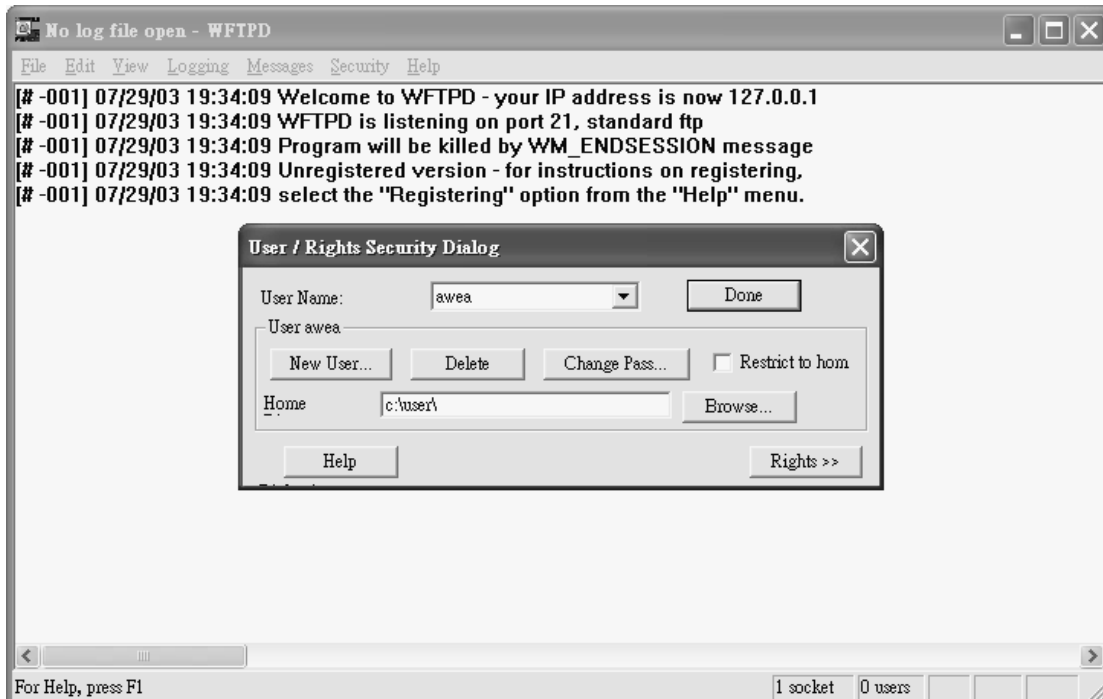
(11) 按" Cancel ",会出现以下的画面.



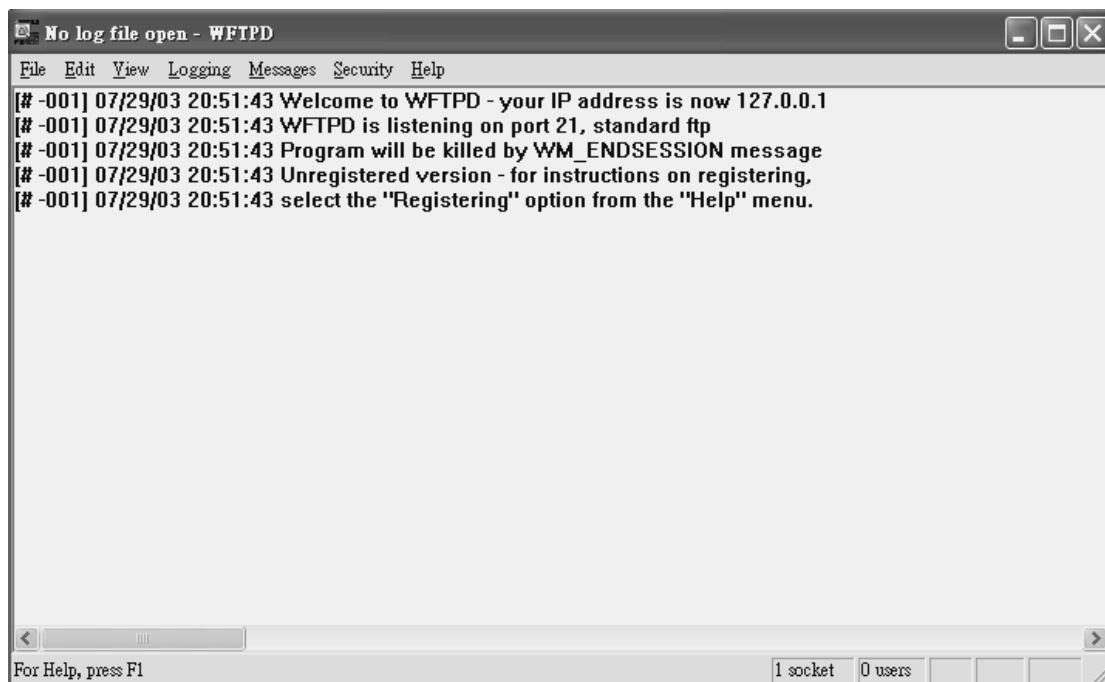
(12) 于" User Name "字段,按下" ▼ "选取"awea".



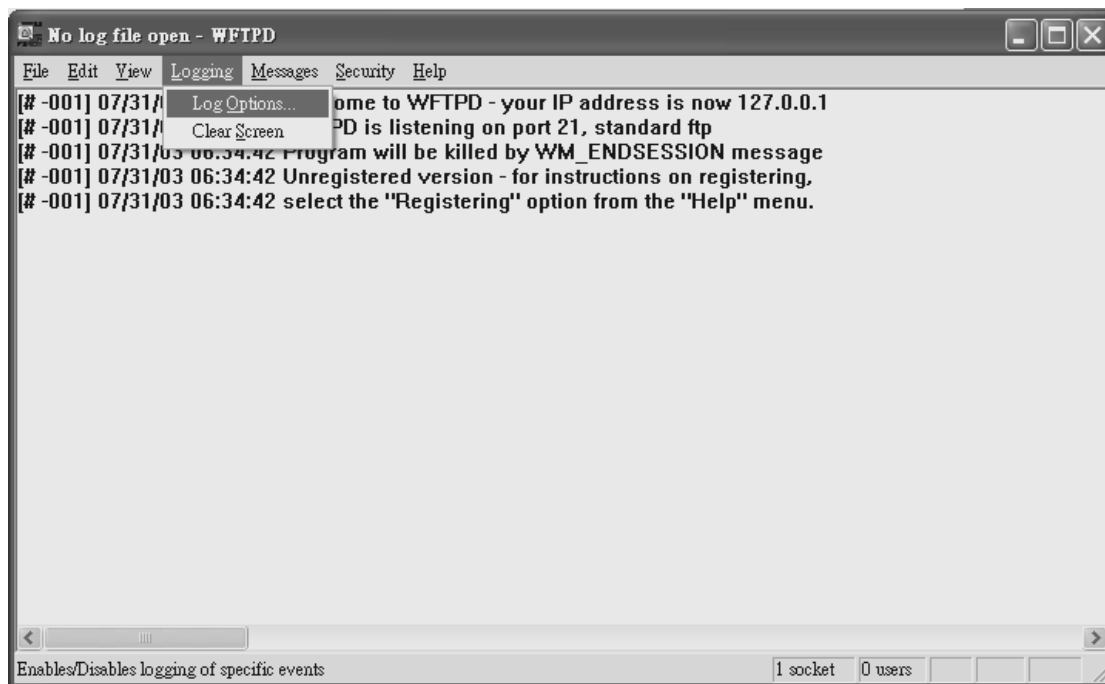
(13) 用鼠标点选" Home "字段,建立一个与 NC 内 DATA SERVER 相同的目录. 例如: " c:\user\ ",设定完成后按" Done ".



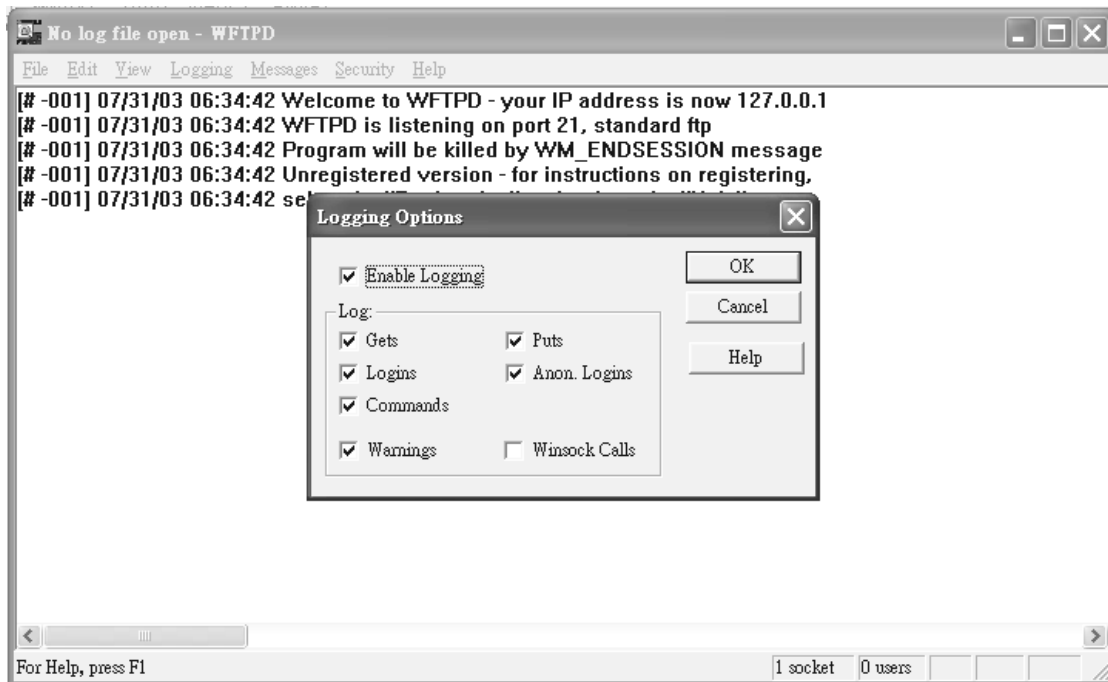
(14) 按" Done ",切换成以下画面.



(15) 按" Logging ",再点选"Log Options..."



(16) 将下列选项都打勾.

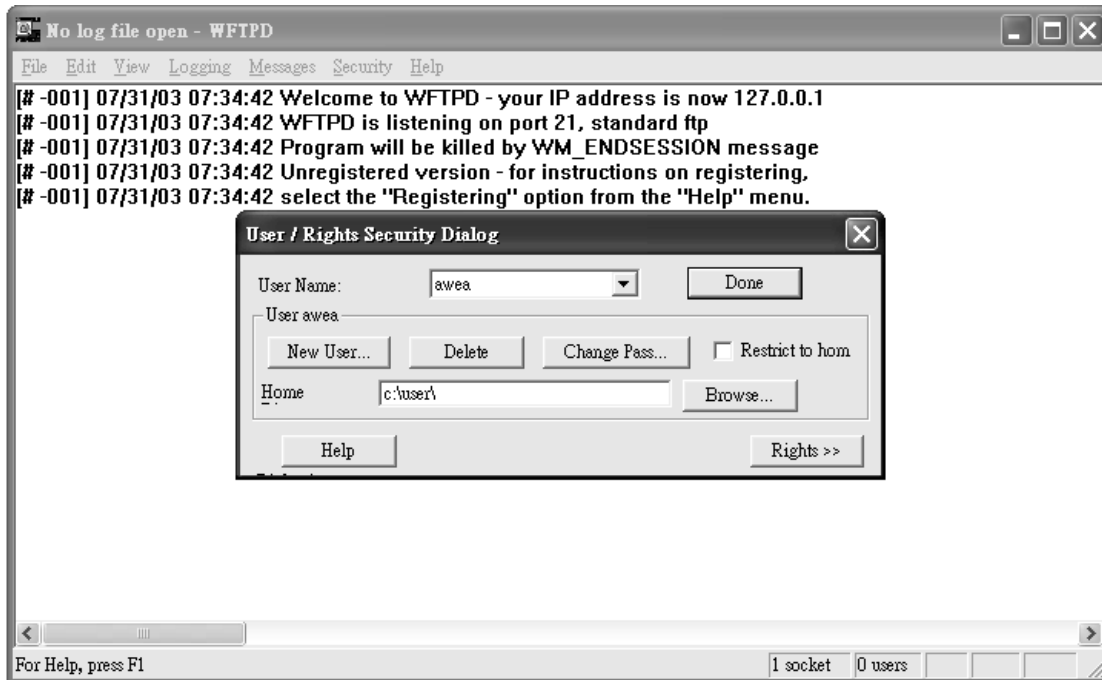


(17) 按" OK "会切换成以下的画面,关闭此画面.



(18) 执行传输前,先用鼠标点选"快捷方式 W-FTPD",再点选" Security ";"
User/Rights.. ",会进入如下页的画面,在" User Name "字段,按下" ▼ ",选

取" awea "。



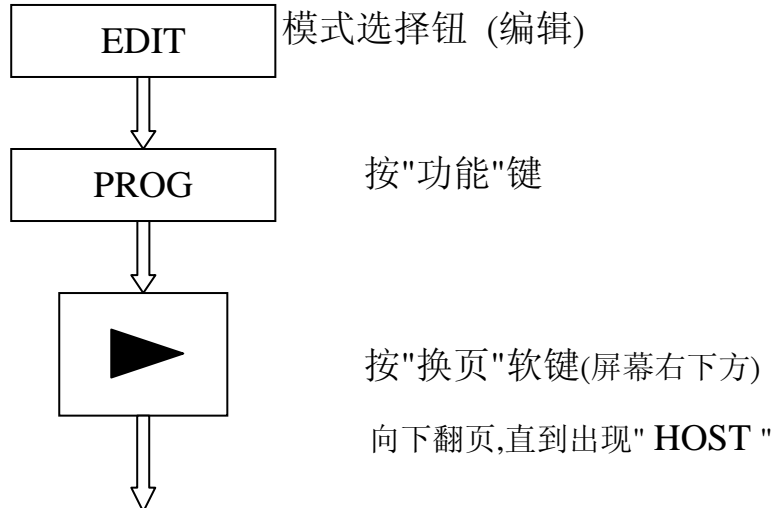
(19) 按" Done ",画面会切换如下图显示,再将画面窗口缩小 (" 最小化 ") ,如此就可以执行程序传输。



※ FTP软件使用方式: 可上网至"<http://www.slim.com.tw>"网站,于软件下载区寻找合适的" FTP "软件,任何的" FTP "软件皆可 ,建议使用" WFTPD "。

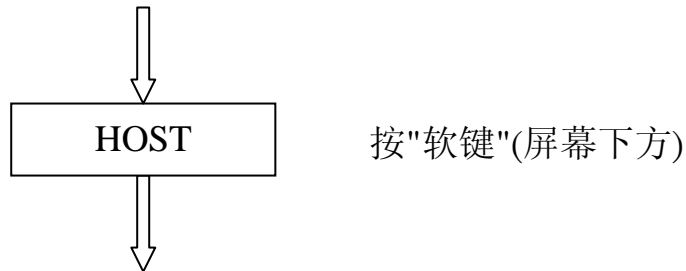
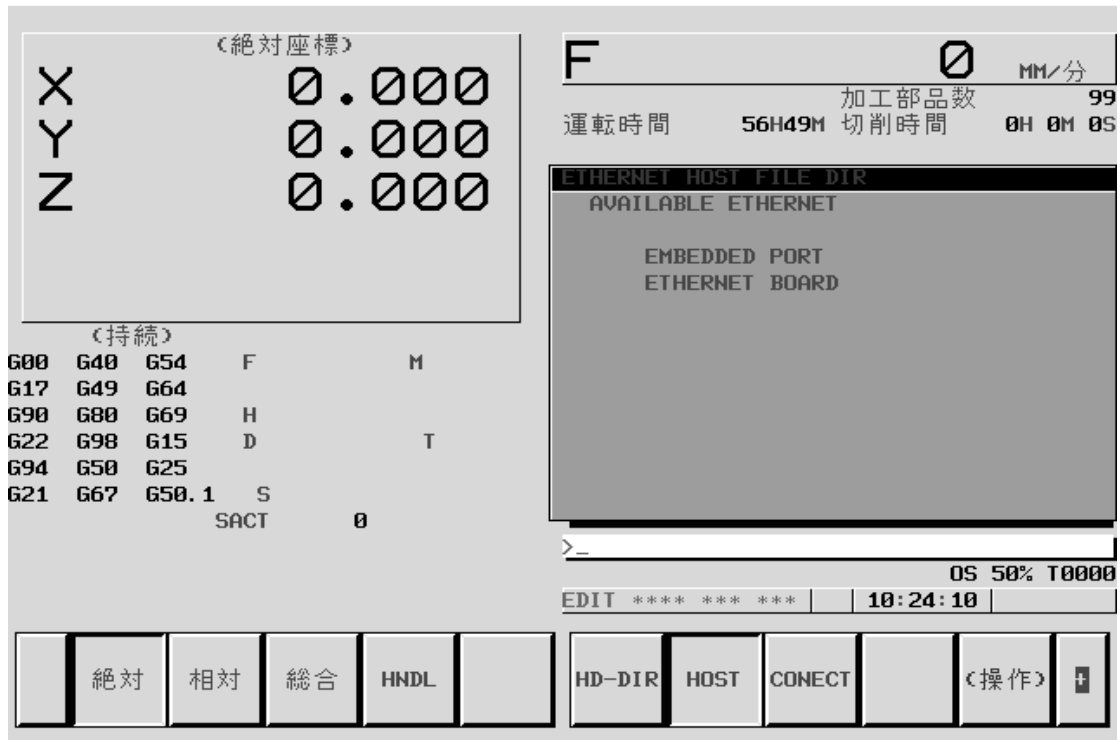
五.程序传输

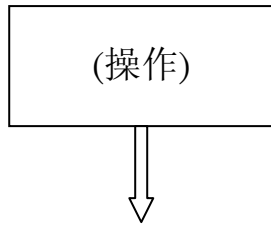
(CNC 与 PC 联机)操作说明:



现在位置

00111 N00000



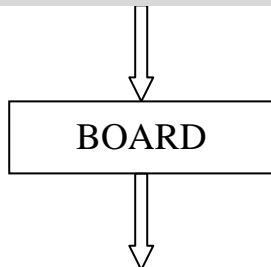


按"软键"

現在位置

00111 N00000

<p style="text-align: center;">〈絶対座標〉</p> <table style="width: 100%;"> <tr><td>X</td><td>0.000</td></tr> <tr><td>Y</td><td>0.000</td></tr> <tr><td>Z</td><td>0.000</td></tr> </table> <p style="text-align: center;">〈持續〉</p> <table style="width: 100%;"> <tr><td>G00</td><td>G40</td><td>G54</td><td>F</td><td>M</td></tr> <tr><td>G17</td><td>G49</td><td>G64</td><td></td><td></td></tr> <tr><td>G90</td><td>G80</td><td>G69</td><td>H</td><td></td></tr> <tr><td>G22</td><td>G98</td><td>G15</td><td>D</td><td>T</td></tr> <tr><td>G94</td><td>G50</td><td>G25</td><td></td><td></td></tr> <tr><td>G21</td><td>G67</td><td>G50.1</td><td>S</td><td></td></tr> <tr><td></td><td></td><td>SACT</td><td></td><td>0</td></tr> </table>	X	0.000	Y	0.000	Z	0.000	G00	G40	G54	F	M	G17	G49	G64			G90	G80	G69	H		G22	G98	G15	D	T	G94	G50	G25			G21	G67	G50.1	S				SACT		0	<p style="text-align: right;">F 0 MM/分</p> <p>加工部品数 99</p> <p>運轉時間 56H49M 切削時間 0H 0M 0S</p> <div style="border: 1px solid black; padding: 5px;"> <p>ETHERNET PARAMETER</p> <p>AVAILABLE ETHERNET</p> <p>EMBEDDED PORT</p> <p>ETHERNET BOARD</p> </div> <p style="text-align: right;">OS 50% T0000</p> <p style="text-align: center;">MDI ***** **</p> <p style="text-align: right;">11:12:08</p> <table style="width: 100%; text-align: center;"> <tr> <td>絶対</td> <td>相對</td> <td>綜合</td> <td>HNDL</td> <td>BOARD</td> <td>EMBEDD</td> <td>PCMCIA</td> <td>SWITCH</td> </tr> </table>	絶対	相對	綜合	HNDL	BOARD	EMBEDD	PCMCIA	SWITCH
X	0.000																																																	
Y	0.000																																																	
Z	0.000																																																	
G00	G40	G54	F	M																																														
G17	G49	G64																																																
G90	G80	G69	H																																															
G22	G98	G15	D	T																																														
G94	G50	G25																																																
G21	G67	G50.1	S																																															
		SACT		0																																														
絶対	相對	綜合	HNDL	BOARD	EMBEDD	PCMCIA	SWITCH																																											



按"软键"

与 PC 联机成功,会出现以下分享画面

HOST FILE DIR 00111 N00000

REGISTERED PROGRAMS : 4

CURRENT CONNECT HOST: 1

0001 T1.NCD

0002 T2.NCD

0003 T3.NCD

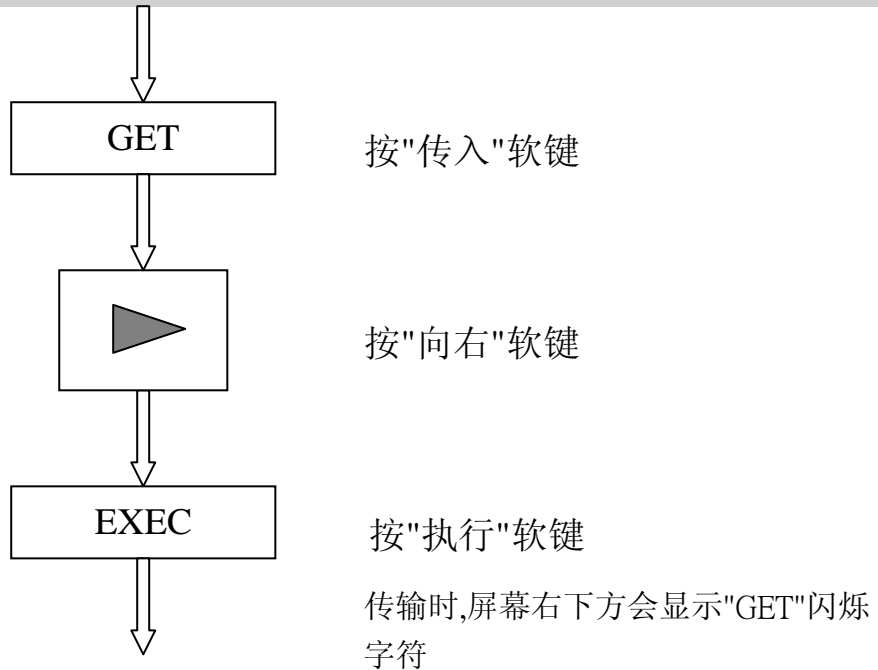
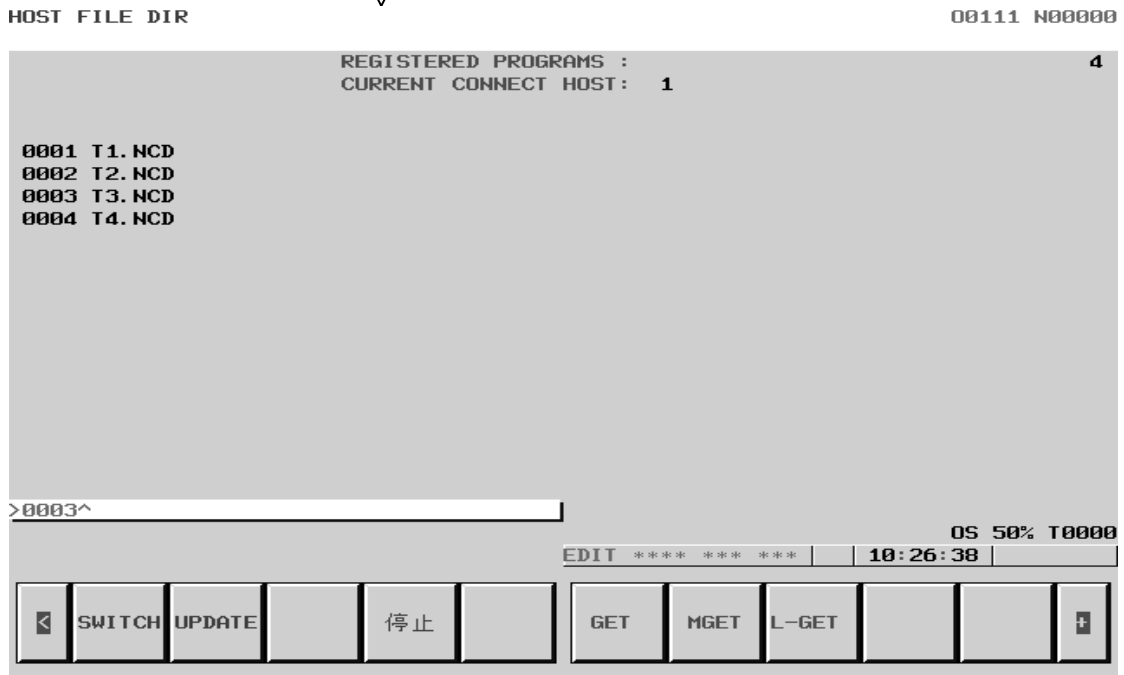
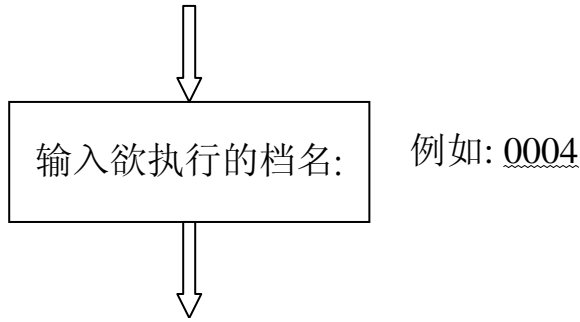
0004 T4.NCD

OS 50% T0000

EDIT ***** **

10:25:03

SWITCH	UPDATE	停止	SEARCH	DELETE
--------	--------	----	--------	--------



按"传入"软键

按"向右"软键

按"执行"软键

传输时,屏幕右下方会显示"GET"闪烁字符

HOST FILE DIR

00111 N00000

REGISTERED PROGRAMS : 4
CURRENT CONNECT HOST: 1

0001 T1.NCD
0002 T2.NCD
0003 T3.NCD
0004 T4.NCD

>0004^

OS 50% T0000
EDIT **** * * * * 11:33:21

◀	SWITCH	UPDATE		停止		LOCK		CAN	停止	EXEC	+
---	--------	--------	--	----	--	------	--	-----	----	------	---



HOST FILE DIR

00111 N00000

REGISTERED PROGRAMS : 4
CURRENT CONNECT HOST: 1

0001 T1.NCD
0002 T2.NCD
0003 T3.NCD
0004 T4.NCD

>^

COMPLETE

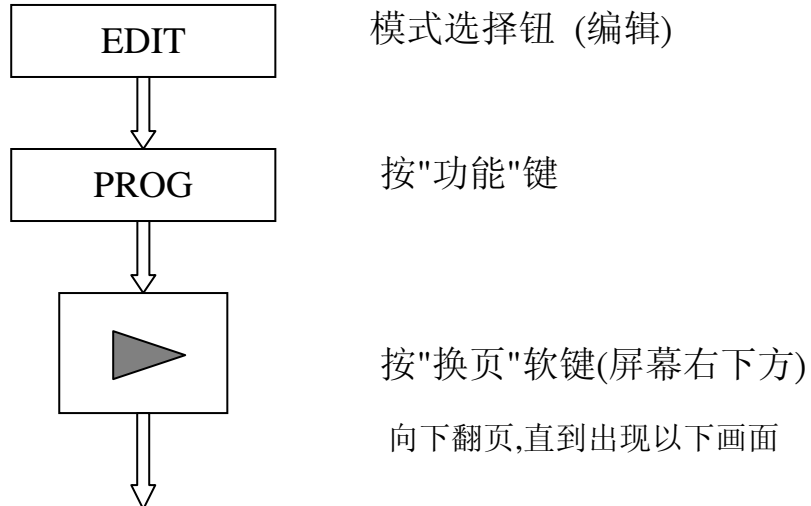
OS 50% T0000
EDIT **** * * * * 11:33:59

◀	SWITCH	UPDATE		停止		SEARCH				DELETE	+
---	--------	--------	--	----	--	--------	--	--	--	--------	---

(传输完成,会出现此画面)

六.检视 HARD DISK FILE 程序目录操作说明:

流程图:



模式选择钮 (编辑)

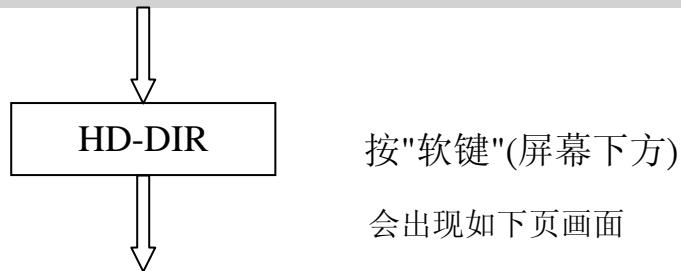
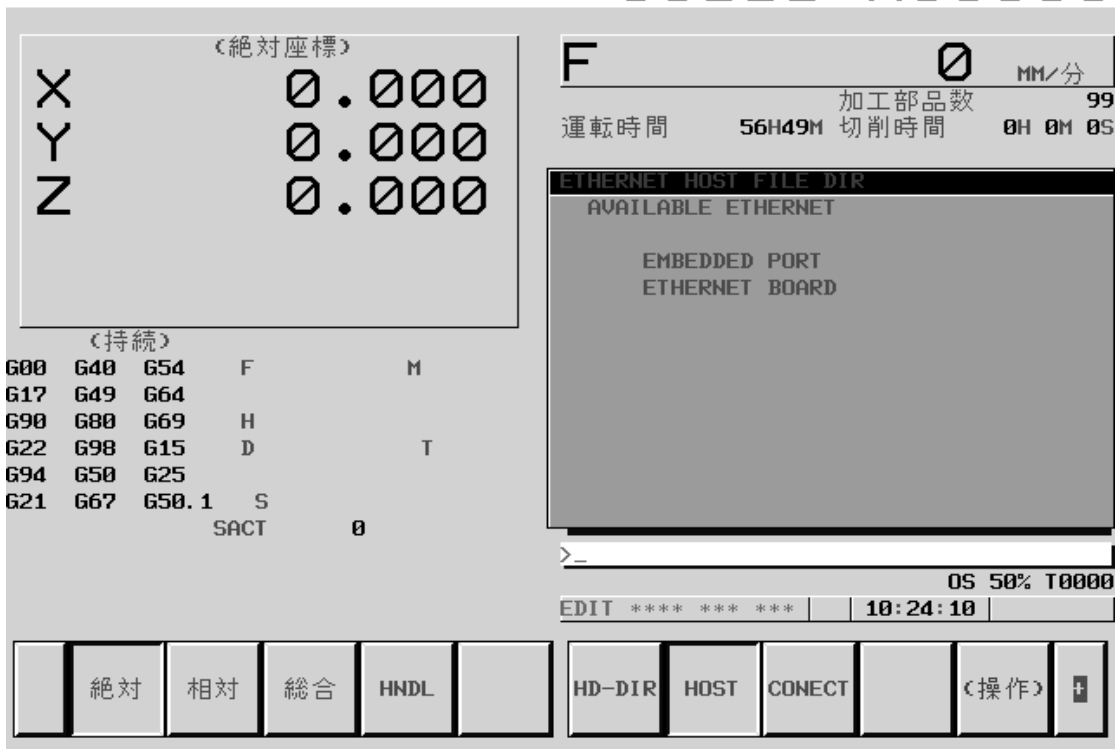
按"功能"键

按"换页"软键(屏幕右下方)

向下翻页,直到出现以下画面

现在位置

00111 N00000



按"软键"(屏幕下方)

会出现如下页画面

HARD DISK FILE DIR

00111 N00000

REGISTERED PROGRAMS :		3
FREE MEMORY AREA :		23,126,016
CURRENT DIRECTORY :		¥NCDATA

FILE NAME	SIZE	DATE
00001 T1.NCD	23,788	03-05-20 10:09
00002 T2.NCD	64,589	03-05-20 10:26
00003 T3.NCD	278,096	03-05-20 10:27

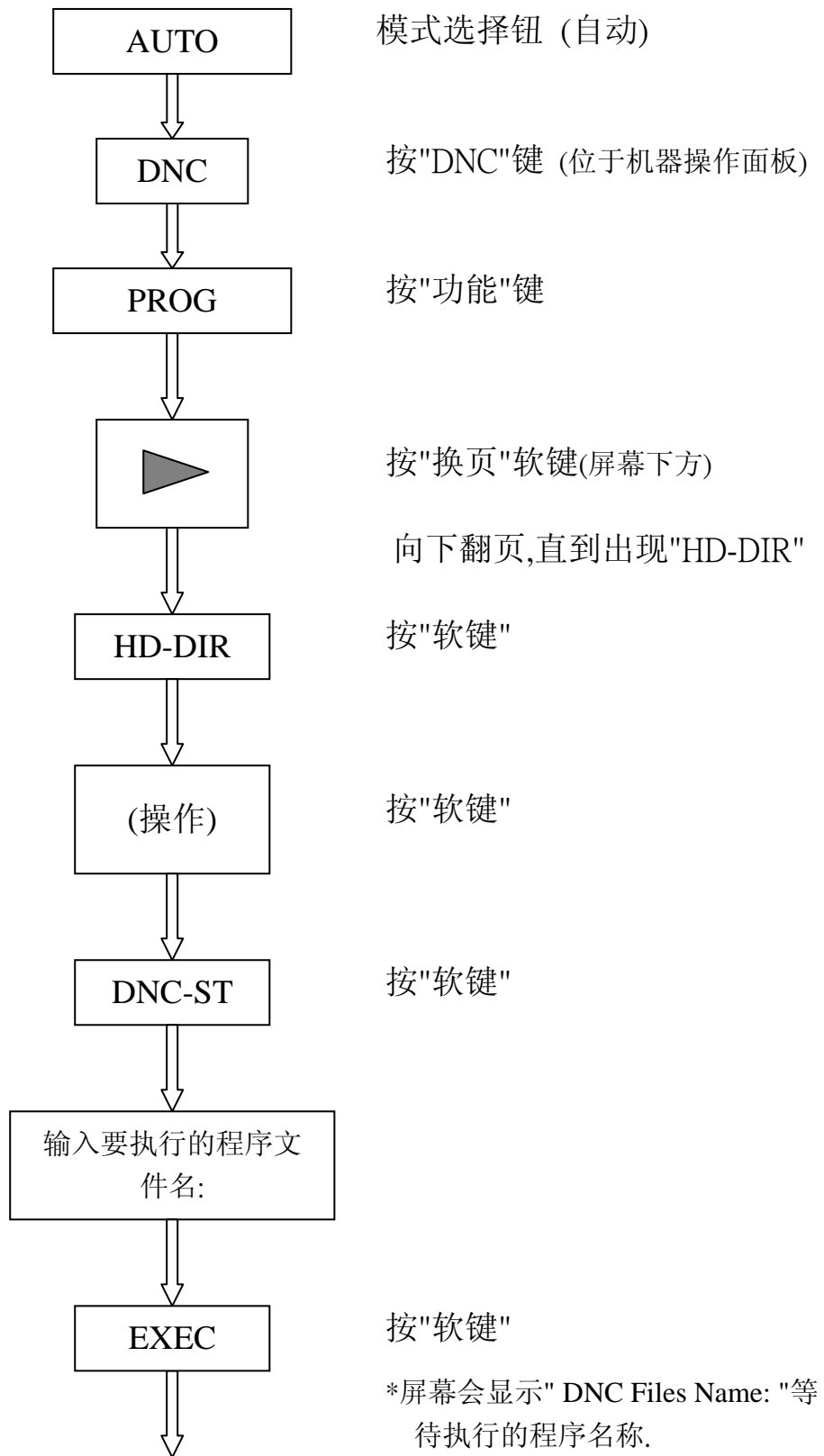
>>

OS 50% T0000

EDIT **** * * * * | 10:28:34

SWITCH		停止		HD-DIR	HOST	CONNECT		(操作)	+
--------	--	----	--	--------	------	---------	--	------	---

七.执行加工程序(DNC 联机)操作说明:



CYCLE
START

按"程序启动"键,执行 DNC 加工

I/O Channel (Parameter No.20) → " 0 "为" RS-232 "传输模式

" 5 "为" DATA SERVER "传输模式

現在位置 00012 N00000

(絶対座標)	F 0 MM/分
X	0.000
Y	0.000
Z	0.000
加工部品数 448	
運転時間 365H26M 切削時間 11H51M59S	
SETTING(HANDY)	
参数写入	= 0(不可) 1(可不可)
TV 校正	= 0(OFF) 1(ON)
PUNCH CODE	= 1(0:EIA) 1:ISO)
输入单位	= 0(MM) 1(INCH)
I/O 頻道	= 4(0-35:頻道 NO.)
順序号	= 0(OFF) 1(ON)
磁帶格式	= 0(無变换) 1:F15)
排序停止	= 0(程序号)
排序停止	= 0(順序号)

(持續)

G00	G40	G54	F	M	3
G17	G49	G64			
G90	G80	G69	H		
G22	G98	G15	D	T	
G94	G50	G25			
G21	G67	G13.1	S	3000	
			SACT	0	

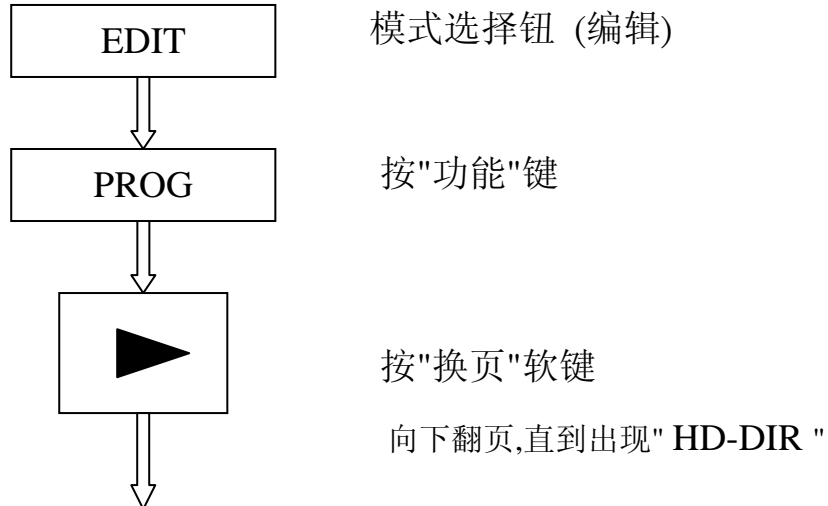
OS 50% T0000

MDI **** * * * * 10:46:44

绝对	相对	综合	HNDL	NO检索	接通:1	断开:0	+输入	输入
----	----	----	------	------	------	------	-----	----

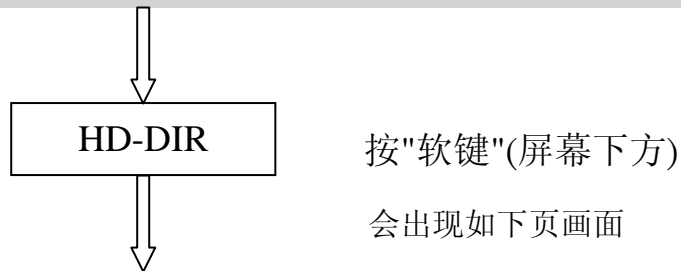
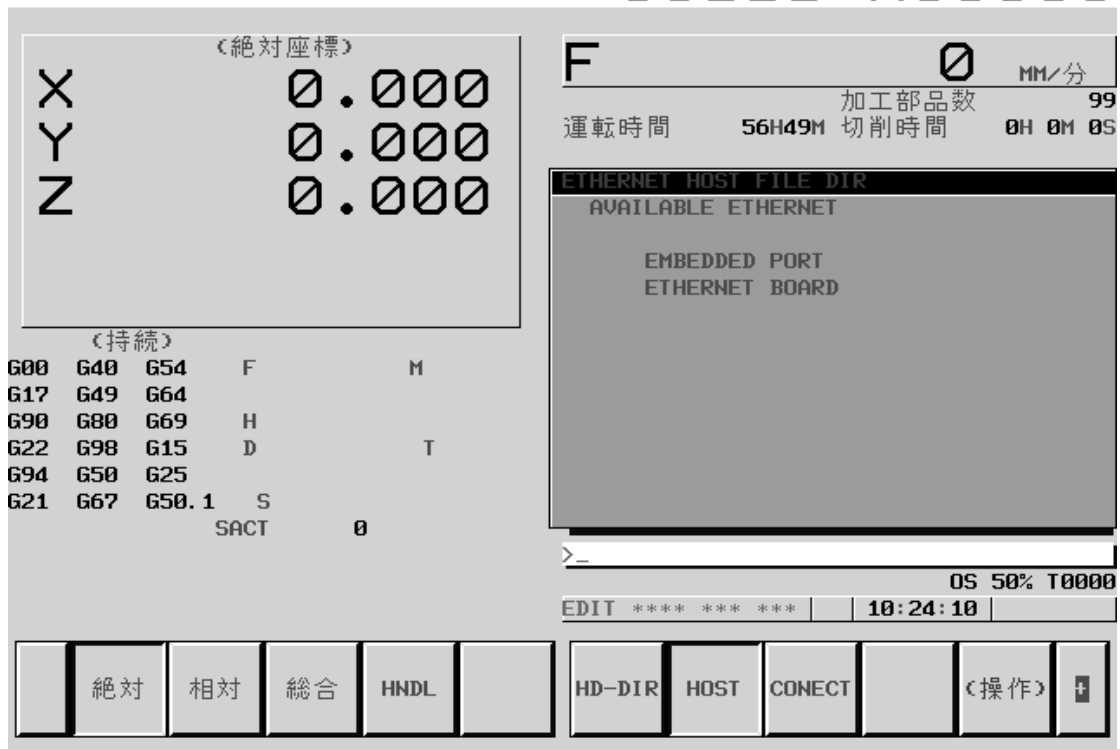
八.删除 HARD DISK FILE 程序目录操作说明:

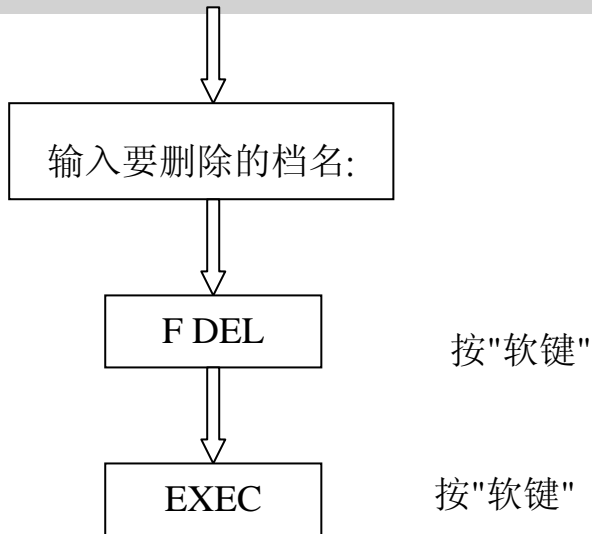
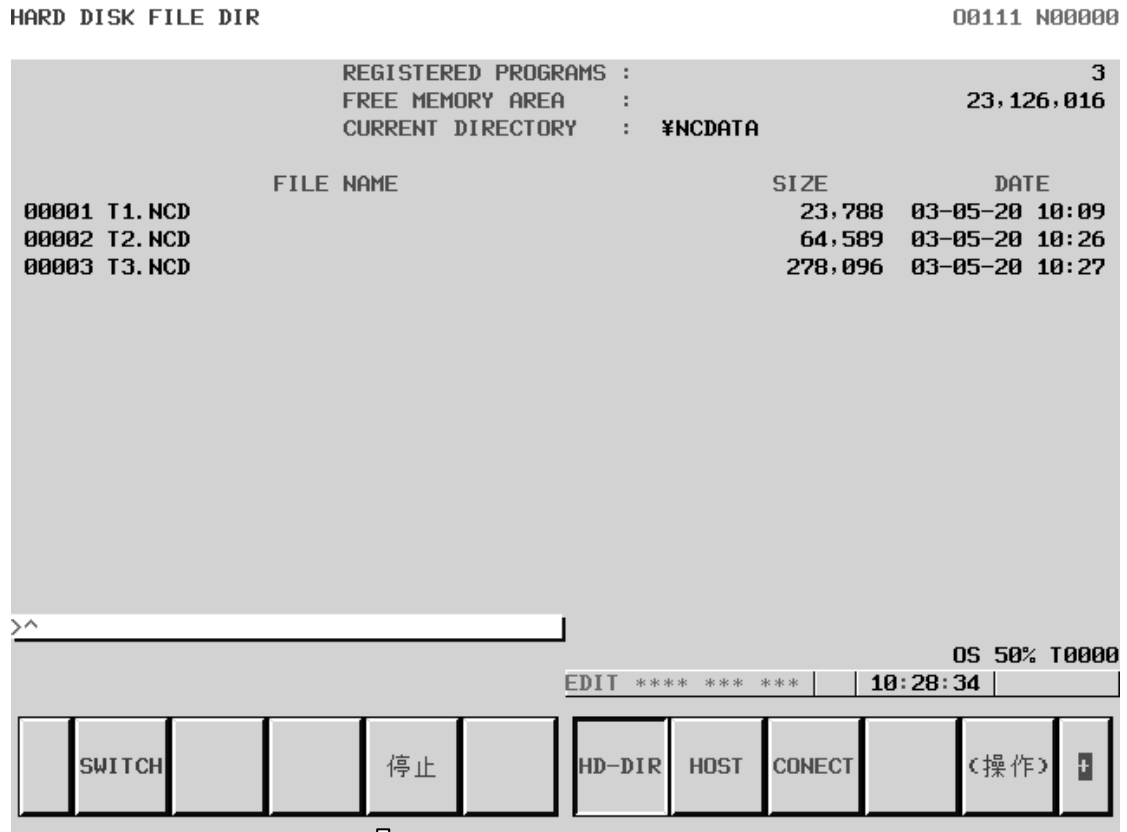
流程图:



现在位置

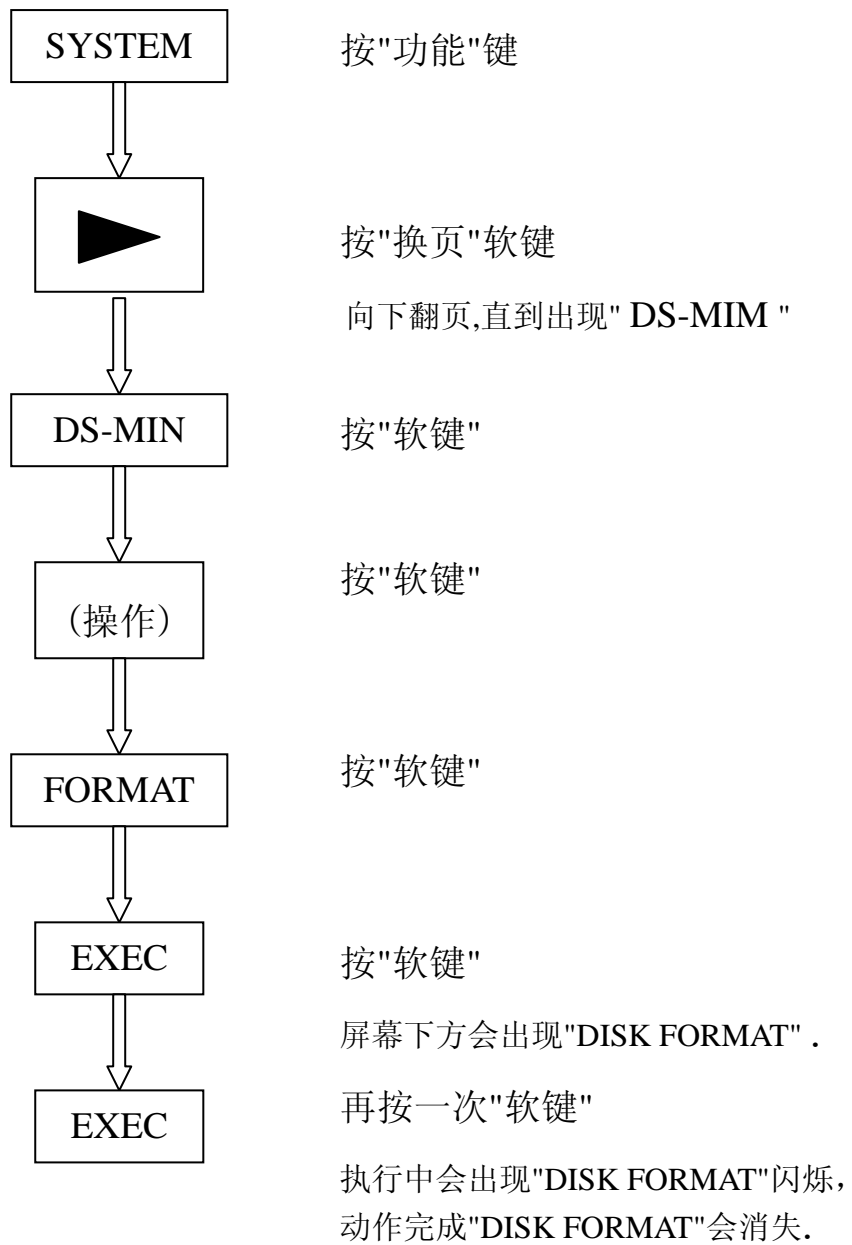
00111 N00000





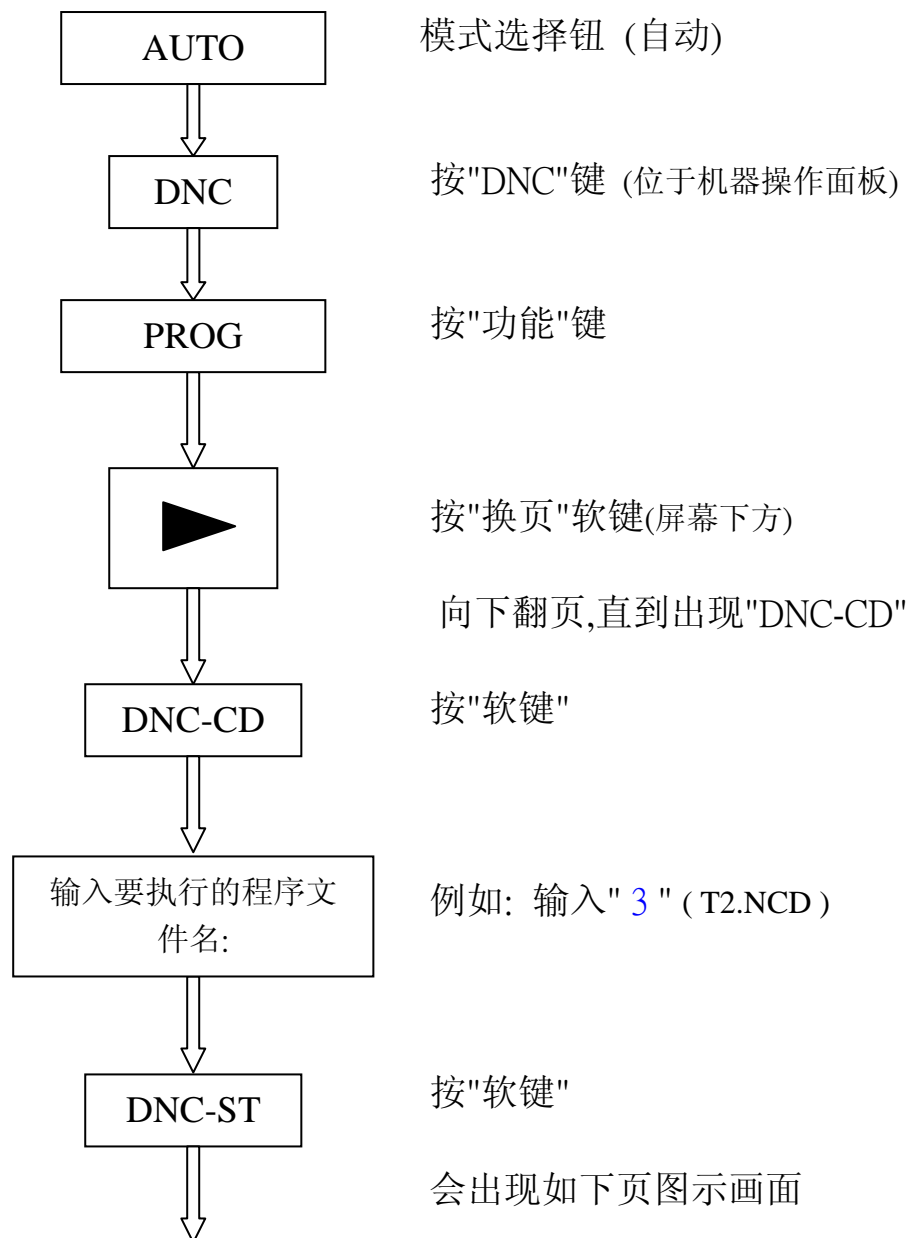
九. Hard Disk 格式化 (FORMAT) 操作说明:





十.使用记忆卡执行 DNC 联机加工:

使用屏幕侧边记忆卡插槽时, 可用来执行 DNC 加工与传输加工程序....等资料。将 I/O Channel (Parameter No.20) 设" 4 "及 Parameter No.138.7 设" 1 "。【以 Memory Card 执行 DNC 联机功能→" 启用 "】



※ 画面上会出现" DNC FILE NAME : [T2.NCD](#) ",即完成设定

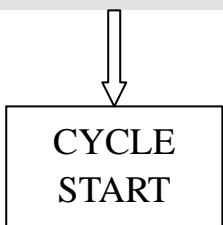
現在位置

01111 N00002

The screenshot shows the control panel interface with the following elements:

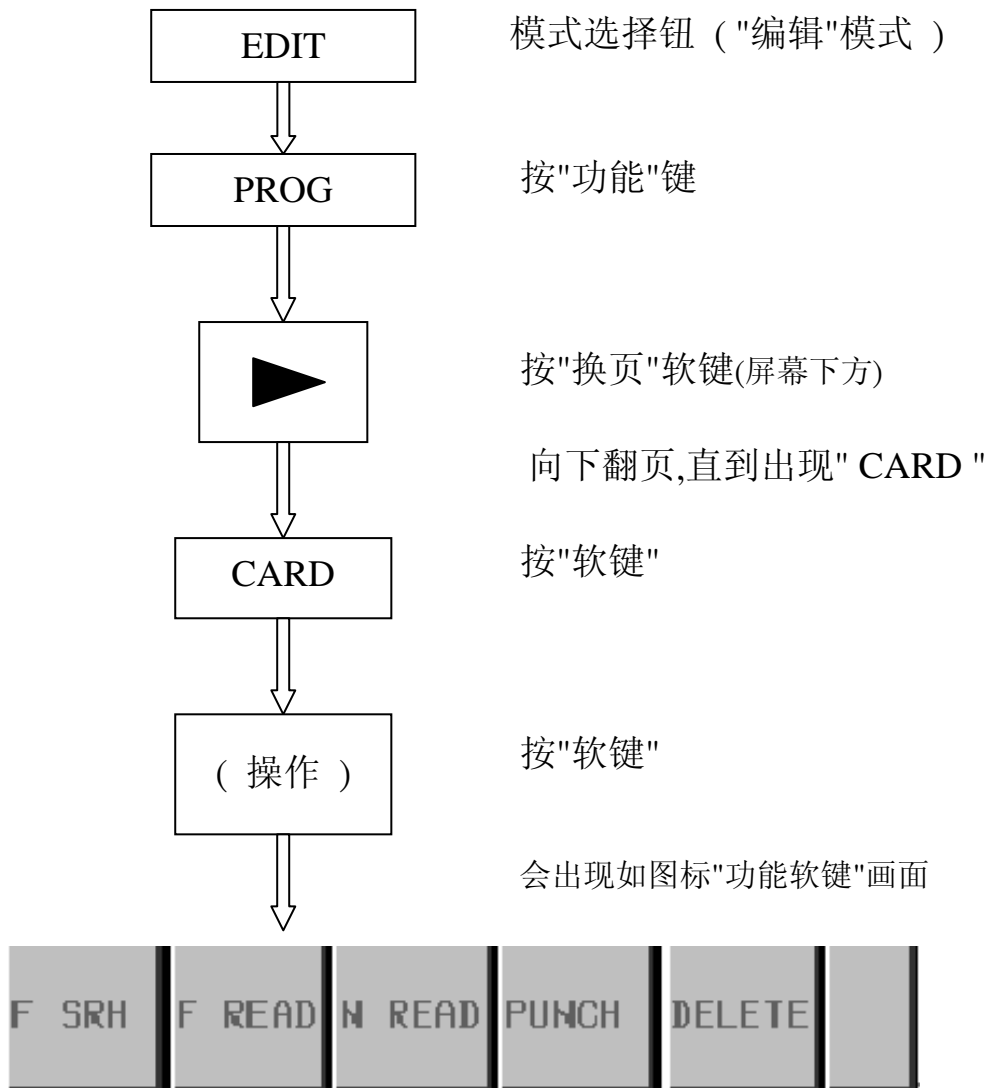
- Coordinates (絶対座標):** X: 571.854, Y: 886.481, Z: 0.000
- Program Parameters (持續):** G00 G40 G54 F M, G17 G49 G64, G90 G80 G69 H, G22 G98 G15 D T, G94 G50 G25, G21 G67 G50.1 S, SACT 0
- DNC OPERATION (M-CARD):**

NO.	FILE NAME	SIZE	DATE
0003	T2.NCD	64589	02-10-18
0004	T3.NCD	90	03-08-07
0005	SAM-2.NC	16470796	03-08-01
0006	SAM-1.NC	10973087	03-08-01
0007	TEST-1.NC	230988	03-04-10
- Bottom Panel:** Includes buttons for "絶対" (Absolute), "相對" (Relative), "綜合" (General), "HNDL", "F檢索" (F Search), and "DNC-ST".



按"程序启动"键,执行 DNC 加工

十一.使用记忆卡执行档案复制:



档案复制:从记忆卡读取加工程序到 NC 内存内.

(方式一) 利用"记忆卡程序号码"

(1) 按"F READ"

(2) 在" FILE NO "字段内输入程序 NO. ,例如: FILE NO.= 6;按"F

SET ";于" PROGRAM NO."字段内输入储存于内存内的档案

号码, 例如: PROGRAM NO.=111;按" O SET "输入.



(3) 按" EXEC ".

(方式二) 利用"程序号码"

(1) 按"N READ"

(2) 在" FILE NAME"字段内输入程序名称,如: O0122.按" F SET ";于

"PROGRAM NO."字段内输入储存于内存的档案号码, 如:

122.再按" O SET "输入.

(3) 按" EXEC ".

00112 N00000

NO.	FILE NAME	SIZE	DATE	NO.	FILE NAME	SIZE	DATE
0001	CNCPARAM. DAT	75608	03-02-02				
0002	PROGRAM. ALL	2158	03-02-08				
0003	00001	96	03-02-08				
0004	HV6. PGM	12846	02-10-24				
0005	00121	38	03-02-08				
0006	00122	732	03-02-08				
0007	00123	688	03-02-08				
0008	00100	100	03-02-08				
0009	HDCPY000. BMP	388278	03-02-09				

READ
FILE NAME=00122 PROGRAM NO. = 122

>>

EDIT ***** 10:10:36

←						F NAME	O SET	STOP	CAN	EXEC
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