
Section 14: Communications

Communications

Character Code

The CNC 88 can send or receive either EIA or ASCII character codes. The EIA code output is intended for output to a tape punch only. The communications described in this section are intended for the ASCII mode.

Initial Connection

When the CNC 88 is in the command mode (ENTER NEXT COMMAND is on the screen), it constantly monitors the RS-232 port for incoming data. When data is detected, the CNC 88 switches to the terminal mode and subsequent input/output is through the RS-232 port. Also, the user can direct the CNC 88 to send its output to the RS-232 port by entering the proper CD command.

The initial communication to the machine requires the following communications parameters:

7 Data Bits

Even Parity

1 Stop Bit

Compatible Baud Rate (i.e. 2400 at both the computer and the machine).

Machine Grounding

The machine grounding may affect the communications capabilities. The machine **MUST** be properly grounded for best communication results. The FADAL VMC shall be grounded using any method listed in article 250 of the National Electrical Code. The minimum grounding method recommended by FADAL Engineering is detailed in the Installation chapter of the VMC Maintenance Manual. Inadequate grounding will result in a wide range of hard-to-diagnose problems in communications, positioning, spindle motion, etc.

Termination

If the **MANUAL** key is pressed while the control is in the terminal mode, communication will be terminated. This is also accomplished at the computer terminal by typing the word **BYE**.

Handshaking

Handshaking uses one of two available software protocols:

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Clinton Cortlandt Anderson



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Communications Programs/requirements and Resources Management Technician (AFSC 29670) Albert R. Wilbourn,1984 Technical Abstract Bulletin ,1982 **MC68851, Paged Memory Management Unit User's Manual** Motorola, Inc,1989 *The ARRL Operating Manual* American Radio Relay League,1995 **AR 25-13 03/25/2013**

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Adjutants' Manual Courtland Nixon,1917 **Field Artillery Manual** Arthur Riehl Wilson,1928 A Quick Reference Manual for Data Communications and File Management ,1987 A collection of microcomputer based file management and data communication procedures is provided to help users transfer data between applications within a microcomputer environment and mainframe applications Each procedure summarized possible applications and gives step by step instructions for implementation Example applications are given where available This manual is based on collective experience of the U S Army Construction Engineering Research Laboratory Facility Systems Division USA CERL FS researchers Thus only a limited number of potential applications are covered for microcomputer operations and micro PAX

interface *Tecplot, Version 6 User's Manual* Amtec Engineering Inc,1994 **Scientific and Technical Aerospace Reports** ,1989 **An Introductory Guide to EC Competition Law and Practice** Valentine Korah,1994 **The R.O.T.C. Manual, Infantry** ,1930 *Training Manual* United States. War Dept,1923 The Advanced Engineer Manual ,1930
 Supplement ... to Officers' Manual (for Use of Subalterns) James Alfred Moss,1907 Manual of garrison artillery 1887.
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