
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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G Thomas



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Manual of instruction in army signalling. [Continued as] Signalling instructions [afterw.] regulations. [Continued as] Training manual-signalling. [With] Amendments. [Continued as] Signal training. [With] Amendments War office,1927 **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 TELECOMMUNICATIONS AND UNIFIED CAPABILITIES , Survival Ebooks Us Department Of Defense, www.survivalebooks.com, Department of Defense, Delene Kvasnicka, United States Government US Army, United States Army, Department of the Army, U. S. Army, Army, DOD, The United States Army, AR 25 13 03 25 2013 TELECOMMUNICATIONS AND UNIFIED CAPABILITIES Survival Ebooks *IAPX 86/88, 186/188 User's Manual Hardware Reference* Intel Corporation,1985 Introduction to PCM Telemetry Systems Stephen Horan,2018-10-03 Telemetry systems and applications have moved far beyond the space flight telemetry most people have heard of to cutting edge uses across a broad range of disciplines including industry medicine and meteorology To fully understand and participate in the acquisition of data this technology makes possible scientists in these fields along with engineers new to telemetry require some background in the concepts hardware and software that makes the technology so valuable Introduction to PCM Telemetry Systems Second Edition summarizes the techniques and terminology used in sending data and control information between users and the instruments that collect and process the data It gives an overall systems introduction to the relevant topics in three primary areas system interfaces data transport timing and synchronization and data transmission techniques The topics addressed include sensor characteristics user interface design data filtering data framing statistical analysis telemetry standards time code standards modulation techniques and radio propagation To reinforce understanding each chapter includes exercises Rather than focusing on design specifics which can change so rapidly with evolving technologies the author centers his discussions on concepts and standards This edition incorporates the latest standards LabVIEW based examples of telemetry and command processing and simulations using multiSim and Commsim

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