

1 How to compile and load ladder in CNC

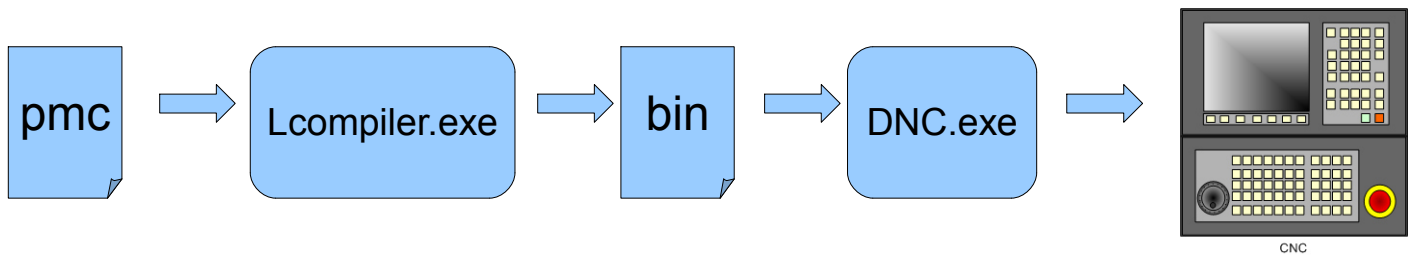
Ladder program is a text file with extension PMC.

For example: **cp503.pmc**

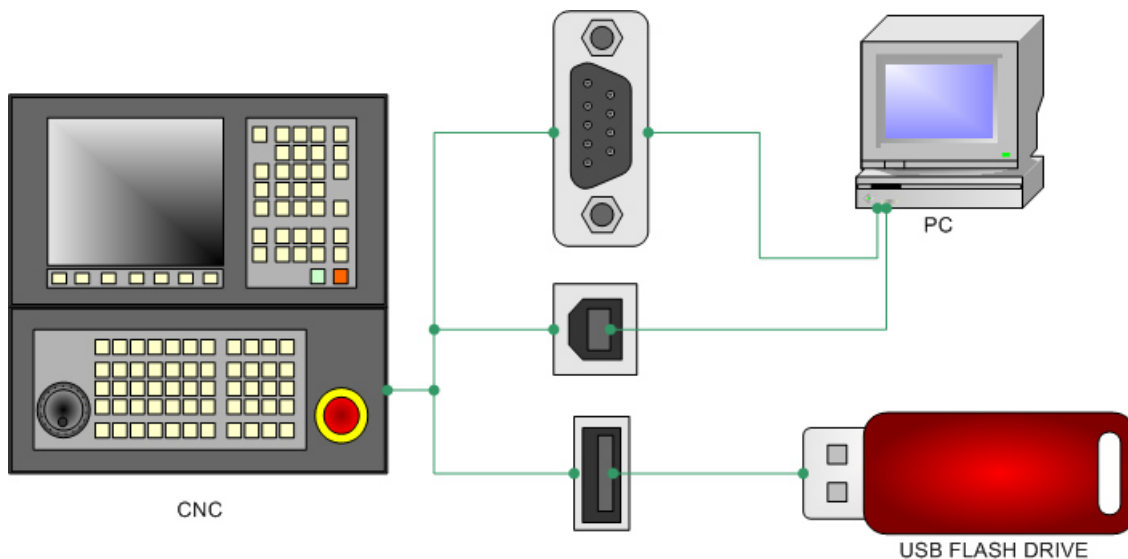
Compilation is done using **Lcompiler.exe** (in CD directory ladder: ..\CD\ladder)

Compiler generates 2 files – executable BIN file (this file is loaded in CNC) and graphics view of generated code – GFX file. This is text file and is used to check diagram of generated code. Only BIN file is loaded in CNC.

Loading ladder executable is done with program DNC.exe (..\CD\DNC).



2 Connection between CNC and PC:



CNC can transfer data between PC and CNC via serial port (RS232C) or by USB (in CNC20 there is embedded converter USB-RS232). Driver for windows is included in CD:

..\CD\USB_to_RS232_driver (for WIN XP, 7 and next). PC recognise device as COM port. Program for transfer is DNC.EXE, but any terminal program may be used if it supports Z-modem protocol (Z modem without crash recovery).

CNC20 can also transfer programs in EDIT mode from USB Flash Drive.

Files in USB flash stick must be with extension CNC and be in standart RS274 format.

Transfer is the same as transfer from PC. From which device (PC or USB flash) will be made transfer is selected using functional button [USB].