



Memex Automation Inc.

777 Walkers Line,
Burlington, Ontario
Canada
L7N 2G1

Phone: 905-635-3040

Fax: 905-631-9640

<http://www.memex.ca>

**Fanuc 6 Serial & Facit 4070
Connections & Parameters**

Fanuc 6 Serial & Facit 4070 Connections & Parameters

Setting Screen Parameter

Set the following SETTING SCREEN parameters:

TV CHECK = 0 (OFF)
PUNCH CODE = 1 (ISO)
INPUT DEVICE 1 = 0 (TAPE)
all other settings can stay the same..

Note that Parameter 2.5 (xx1x xxxx) needs to be on to enable punching.

Parameter Numbers 340, 341 (Facit 4070 Puncher for Output and Tape for Input)

340: IDVICE - Selects the input device and setting to be used to input data. - Set to 0.

341: ODVICE - Selects the output device and setting to be used to output data. - Set to 0.

Set Value	Input/Output Device
0	Input: Tape Reader Output: Facit 4070 Puncher
1	I/O: ASR33/ASR43 Set Parameter 310
2	I/O: RS232C Set Parameter 311
3	I/O: RS232C Set Parameter 312
4	I/O: RS232C Set Parameter 313

NB: Make sure to check SETTING screen for device selection "INPUT DEVICE1=0" (for TAPE) & "INPUT DEVICE2=0" (for Serial) and Punch format (1=ISO).

To Read A Program Serially into Fanuc from PC

- On SETTING page set Input Device1 and 2 to a value of 0 and Parameter 340 to 0 depending on the communications settings.
- In edit mode press the READ button. If program number is not at beginning of data you must enter by hand before pressing READ.



be left.

- On PC you must now send data using your software. Note: If using terminal program use 7 Data Bits Even Parity using ASCII (text). The FANUC LF (line feed) is used to determine EOB (end of block) so be sure that the software does not strip this character. Also note that as a result of automatic ISO/EIA checking, the first line of the program will be lost - use the standard format as follows:

```
%           <-- Note the first line is lost with Fanuc Controls as
O1234       it looks for EOB (which is a LF or Hex 10 in ISO).
...         <-- Your lines of RS274 G&M code inserted here.
M30        <-- Or G50 or M99 or M02 as valid line ends.
%          <-- Fanuc ends right on %, any characters after will
```

To Send A Program via the Facit 4070 Parallel Punch from the Fanuc to PC (NetDNC)

- On setting page set Tape Code to a value of 1 (ISO) and parameter 341 to 0 with a Memex Mx1100 BTR connected..
- On the PC you must set computer to read data in using the same software settings as above (7 Data Bits, Even Parity, 1 Stop Bit and to ISO/ASCII Data).

In edit mode input program number (example: O1234) and press the PUNCH button. The data should now transfer to your computer fitted with terminal or DNC software such as our Multi-DNC.

Facit 4070 Parallel Punch Connector

Facit 4070 Blue Honda MR20 Male

14	CH4		1 PR
15	CH5	8 SG	2 TE
16	CH6	9 SD	3 ERR
17	CH7	10 OV	4 TTY3
18	CH8	11 CH1	5 +6V
19	CH9	12 CH2	6 TTY2
20	PI	13 CH3	7 TTY1



Memex Automation Inc.

777 Walkers Line
Burlington, Ontario
Canada L7N 2G1

Phone: 905-635-3040 Fax: 905-631-9640

<http://www.memex.ca>

Thank you for using Memex memory

Automate the Automation™