

Fadal CNC 88, CNC 88HS and MP-32

Machine Parameters

Strictly speaking it is not necessary to change any parameters. All that needs configuring is the Baud Rate. This can be changed by using the CD command, but this change is not retained on power off.

To change using the CD command:

Press the manual key until the ENTER NEXT COMMAND prompt is showing and enter CD, followed by a number listed below that represents the required baud rate. For example CD,8 would set the baud rate at 9600.

Value	Baud Rate
1	110
2	150
3	300
4	600
5	1200
6	2400
7	4800
8	9600
9	19200
10	38400

To change using the machine parameters

To change the baud rate so it is retained on power off. Press the manual key until the ENTER NEXT COMMAND prompt is showing and enter SETP. Press ENTER until the Baud Rate parameter is selected. Key in a number from the above table and then press the ENTER key. Press MANUAL to exit the parameters.

Other Settings

All Fadal controls have the settings detailed below. These are fixed and cannot be changed with the machine parameters.

Hand Shaking	XOn/XOff
Parity	Even
Data Bits	7
Stop Bits	1

How to send and receive

<ENTER> = press the ENTER key

Sending to machine

- ShopLink FLASH is powered up with the "FILE" led on, ready to send (select "SEND" folder).
- At the machine, press the manual key until the ENTER NEXT COMMAND prompt is showing.
- Enter TA,1 <ENTER>.

Receiving from machine

- ShopLink FLASH is powered up with the "FILE" led on, ready to receive (select "RECEIVE" folder).
- At the machine press the manual key until the ENTER NEXT COMMAND prompt is showing.
- Enter PU,2 <ENTER>.
- ShopLink FLASH "FILE" led will go off after 10 seconds, power off and remove FLASH drive.

There are different values that can be used with the PU command listed below:

Value	Description
0	Program, tool and fixture data
1	Tool and fixture data only
2	Program only
3	All programs in memory

DNC Operation

If you want to drip feed the Nc code to the machine because it is too large for the memory.

- ShopLink FLASH is powered up with the "FILE" led on, ready to send (select "SEND" folder).
- At the machine press the manual key until the ENTER NEXT COMMAND prompt is showing and enter DNC <ENTER>.
- Press the cycle start button at the machine.