

# SHOPLINK FLASH 2.0

## LOW COST USB 2.0 FLASH MEMORY UPGRADE FOR CNC'S

Please call and have your questions answered. 941-322-2286.

### Quick Start Fanuc

Read and or print out the ShopLinkFlashManual.pdf located on the supplied flash drive in the \IMAGE folder.

Typical CNC serial settings for ShopLink FLASH that will match the default settings in config.ini.

9600, Even parity, 7 data bits, 1 stop bit, **DC CODES** (this is essential)



Insert the supplied flash drive into your computer. Open your desired GCODE program in your favorite editor. Then follow this procedure, FILE, SAVE AS, navigate to the FOLDER0 on the flash drive, select the SEND.TXT file already present and then click SAVE, when the dialog "overwrite" appears click YES. Note, you are always going to be overwriting the SEND.TXT file in FOLDER0 with the file you desire to load into the CNC. Close the editor and any open windows showing the supplied flash drive (it won't eject properly if you do not close all windows that have displayed the flash drive) then Use the "SAFELY REMOVE HARDWARE" icon (right side in task bar) to eject (Stop) and remove the flash drive.

Attach the ShopLink FLASH to the CNC serial port, plug in the FLASH box power, turn OFF power if ON. **Note, insure the FLASH box power is switched OFF when inserting or removing the flash drive.**

Insert the flash drive and select "0" on the panel switch.

Power up the FLASH and observe the POWER (green LED) then the FILE (yellow LED) lights.

Now the FLASH box is listening to your CNC waiting for the READ\RECEIVE\INPUT command to send the SEND.TXT file.

At the CNC operator panel

1. Initiate the dialog to READ\RECEIVE\INPUT a file. Different controls will use different terms for loading a file.
2. Observe the loading of the file and verify that the beginning and end of the file has loaded.

NOTE: if your CNC can DNC\DRIP\SPOON FEED\TAPE this execution is specific to the control type. Refer to your control operator manual for instructions.

Receiving a file from the CNC

Insert the flash drive and select "1" on the panel switch. Note: Folder1 was set to a RECEIVE Folder.

Power up the FLASH and observe the POWER (green LED) then the FILE (yellow LED) lights.

Now the FLASH box is listening to your CNC waiting for the PUNCH\SEND\OUTPUT command to send the CNC file to the FLASH FOLDER1\RECEIVE.TXT file. When the CNC is finished **wait 10 seconds until the FLASH box FILE (YELLOW) led goes out.** Power off the FLASH box, remove the flash drive and take it to your computer.

Navigate to FOLDER1 and open RECEIVE.TXT with WORDPAD or your editor. NOTE: FLASH does not do any file filtering, what you see is what the CNC output. Save your file appropriately.

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# SHOPLINK FLASH 2.0

## LOW COST USB 2.0 FLASH MEMORY UPGRADE FOR CNC'S

### Quick Start Haas

Read and or print out the ShopLinkFlashManual.pdf located on the supplied flash drive in the \IMAGE folder. Typical Haas serial settings for ShopLink FLASH that will match the default settings in config.ini. 9600, Even parity, 7 data bits, 1 stop bit, **SYNCHRONIZATION DC CODES** (this is essential)

#### CHANGING MACHINE PARAMETERS

1. PRESS SETTING/GRAPH KEY.
2. PRESS PAGE DOWN UNTIL RS232 PORTS ARE DISPLAYED ON THE TOP OF THE SCREEN.
3. USE UP DOWN CURSOR TO HIGHLIGHT PARAMETER TO CHANGE THE LEFT, RIGHT ARROW TO CHOOSE OPTIONS, THEN PRESS WRITE KEY TO MAKE PERMANENT.

#### PARAMETERS

- 11 BAUD RATE SELECT 9600
- 12 PARITY SELECT EVEN
- 13 STOP BIT 1
- 14 **SYNCHRONIZATION DC CODES**
- 37 RS-232 DATA BITS 7
- 24 LEADER PUNCH NONE
- 25 EOB PATTERN CR LF
- 41 ADD SPACES RS232 OUT ON

Insert the supplied flash drive into your computer. Open your desired GCODE program in your favorite editor. Then follow this procedure, FILE, SAVE AS, navigate to the FOLDER0 on the flash drive, select the SEND.TXT file already present and then click SAVE, when the dialog "overwrite" appears click YES. Note, you are always going to be overwriting the SEND.TXT file in FOLDER0 with the file you desire to load into the CNC. Close the editor and any open windows showing the supplied flash drive (it won't eject properly if you do not close all windows that have displayed the flash drive) then Use the "SAFELY REMOVE HARDWARE" icon (right side in task bar) to eject (Stop) and remove the flash drive.

Attach the ShopLink FLASH to the Haas serial port 1, plug in the FLASH box power, turn OFF power if ON. Note, insure the FLASH box is switched OFF when inserting or removing the flash drive.

Insert the flash drive and select "0" on the panel switch.

Power up the FLASH and observe the POWER (green LED) then the FILE (yellow LED) lights.

Now the FLASH box is listening to your Haas waiting for the RECEIVE command to send the SEND.TXT file.

At the Haas operator panel

1. Press RESET (clears out com port receive register, if not receive errors on initial read)
2. Press "Program list" button
3. Cursor down to "ALL"
4. Press the "Receive" or "Receive RS232" button
5. Observe the loading of the file

**Haas DNC mode** – Enable DNC from MDI (parameter 55). Press MDI button twice to initiate DNC mode.

**NOTE!** Users report that optimal speed and error free DNC function is achieved by removing all comments and line numbers from DNC programs. The Haas read algorithm must strip out these items wasting CPU time.

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