

Overview

The purpose of this procedure is to guide you through the steps on how to back-up the Fusion control through Data I/O using RS232

Tools Needed

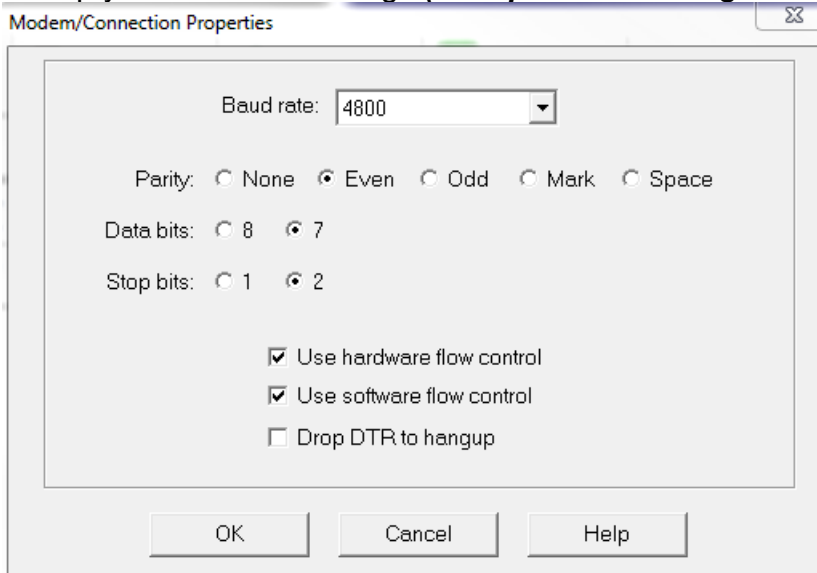
- RS232 Cable
- Laptop

Instructions

I. Configure settings

A. Configuring laptop software settings

1. Set up your software settings (*example shows using ProComm Plus*)



2. Set Baud rate to **4800**
3. Set Parity to **Even**
4. Set Data bits to **7**
5. Set stop bits to **2**

B. Setup Controller

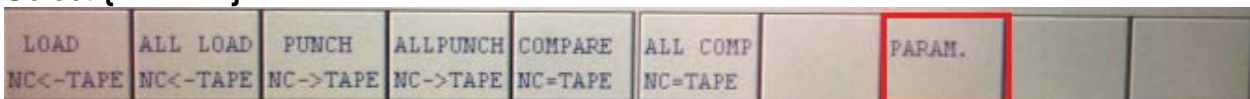
1. Select {DATA I/O}



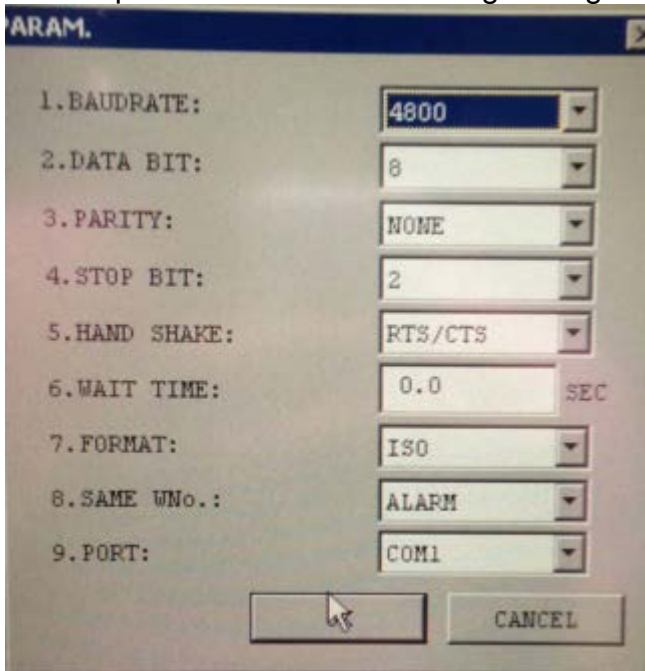
2. Select {TAPE}



3. Select {PARAM}



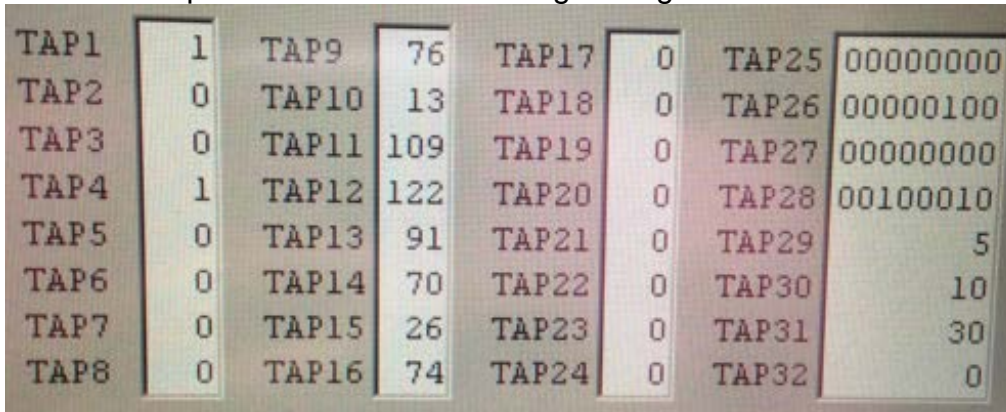
- Set the parameters to the following settings



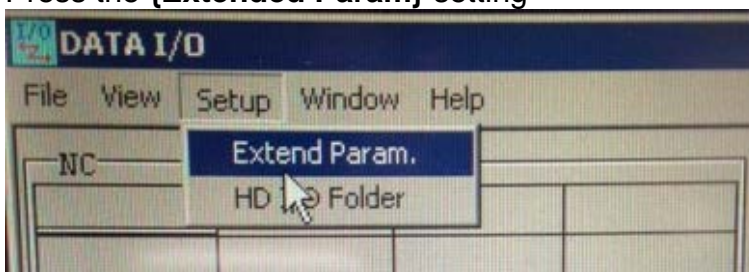
- Press the **{PARAM DETAIL}** soft key



- Set the TAP parameters to the following settings



- On the top left corner of the Data I/O screen. Press the **{SETUP}** tab
- Press the **{Extended Param}** setting



9. Set the parameters to the following settings

| | | | | | | | |
|------|---|-------|---|------|---|-------|---|
| DPR1 | 4 | DPR9 | 1 | IDD1 | 0 | IDD9 | 0 |
| DPR2 | 2 | DPR10 | 0 | IDD2 | 0 | IDD10 | 0 |
| DPR3 | 0 | DPR11 | 0 | IDD3 | 0 | IDD11 | 0 |
| DPR4 | 3 | DPR12 | 0 | IDD4 | 0 | IDD12 | 0 |
| DPR5 | 0 | DPR13 | 0 | IDD5 | 0 | IDD13 | 0 |
| DPR6 | 0 | DPR14 | 0 | IDD6 | 0 | IDD14 | 8 |
| DPR7 | 0 | DPR15 | 5 | IDD7 | 0 | IDD15 | 0 |
| DPR8 | 1 | DPR16 | 0 | IDD8 | 0 | IDD16 | 0 |

C. Output data

1. Connect your RS232 cable (*Refer to Index*)
2. Select {DATA I/O}



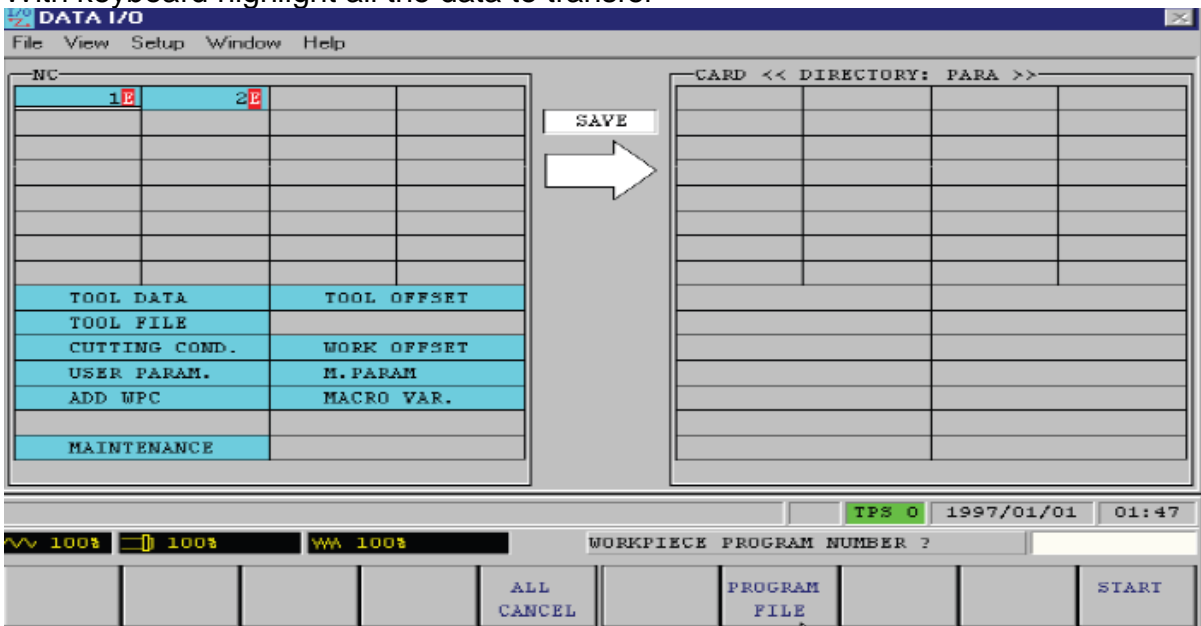
3. Select {TAPE}



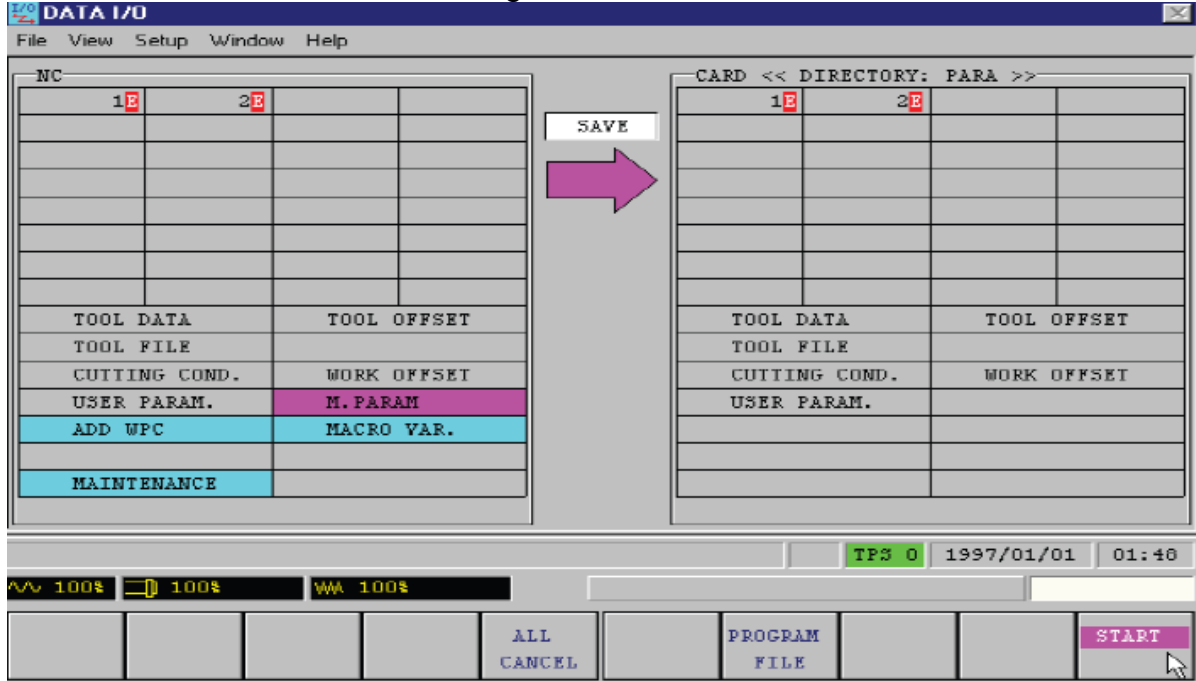
4. Select {PUNCH NC->TAPE}



5. Select {PROGRAM FILE}
6. Press on {PAGE SAVE} to save all the programs
7. With keyboard highlight all the data to transfer

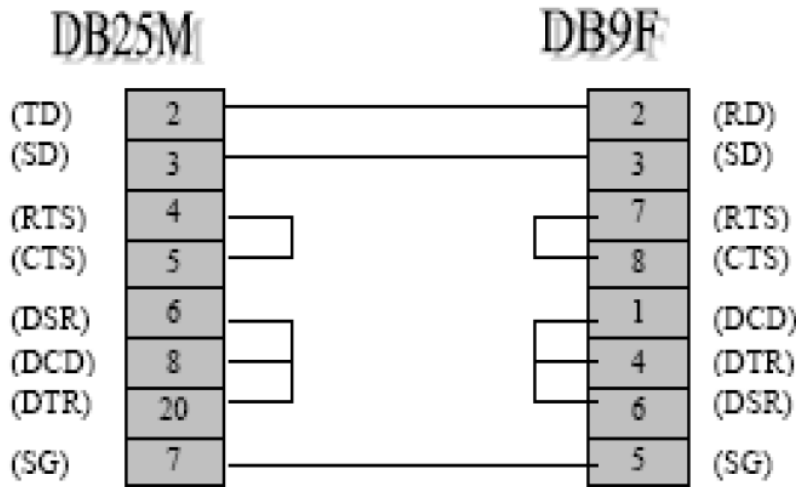


8. Get your software ready to receive the file
9. Press the **{START}** soft key
10. You should see the data transferring



Appendix

RS232 Cable Configuration



If you get alarms such as "541 TAPE PUNCHER MIS-CONNECTED" you need to check your connections. Make sure you are connected to COM1 port on the back of the NC keyboard

