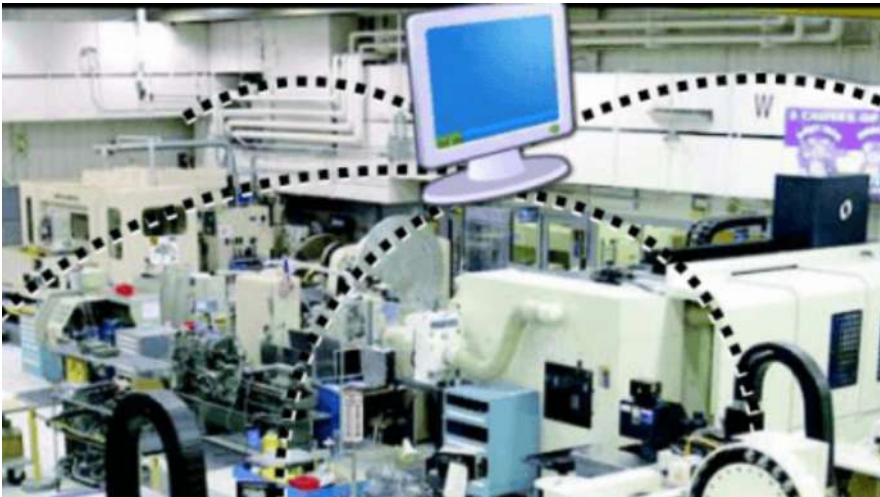


NCnet DNC software

- Works through RS-232 serial port
 - Support wired or wireless network
 - Work with commercially available standard hardware
 - Easy to set up – no special expertise required
 - DNC connection details available for 100+ controllers
- World's most widely used DNC software

What you can do with NCnet DNC software



Reduce machine downtime for program transfer

- Call programs from machines, without going to PC
- Latest proven program is automatically transmitted to machine
- Prevent mixing of proven and trial programs
- Do die milling with drip feed
- Reduce accidental deletion and overwriting of programs
- Reduce part rejections due to outdated programs
- Restrict physical access to PC containing programs
- Connect to CNC machines through RS232 serial port

NCnet screen shots

NCnet DNC software has easy to use interfaces for

- Sending, receiving programs
- Configuration of sending, receiving, remote calling
- Diagnosis of problems
- Report of program transfers to/from machines
- COM port testing

The screenshot shows the NCnet 7.0 software interface. At the top is a menu bar with 'File', 'DNC', 'Editor', 'DNC report', 'Trouble-shooting', 'View', and 'Help'. Below the menu is a toolbar with various icons. The main area contains a table with the following data:

Machine	Status	Filename	Rx lines	Tx lines	Progress.....	Start time	End time	Last operation
DC-1568	Transmitting	6559		53	23%	22:01		Transmitted
HC-1000	Receiving	1928	87		98%	22:02		Aborted
VJ-63	Idle						20:32	Transmitted
LL-300	Idle						19:58	Received
LL-250	Receiving	0943	243		92%	21:56		Received
VJ-1000	Idle	3233					19:43	
HDC-500	Transmitting			169	63%	21:59		Received

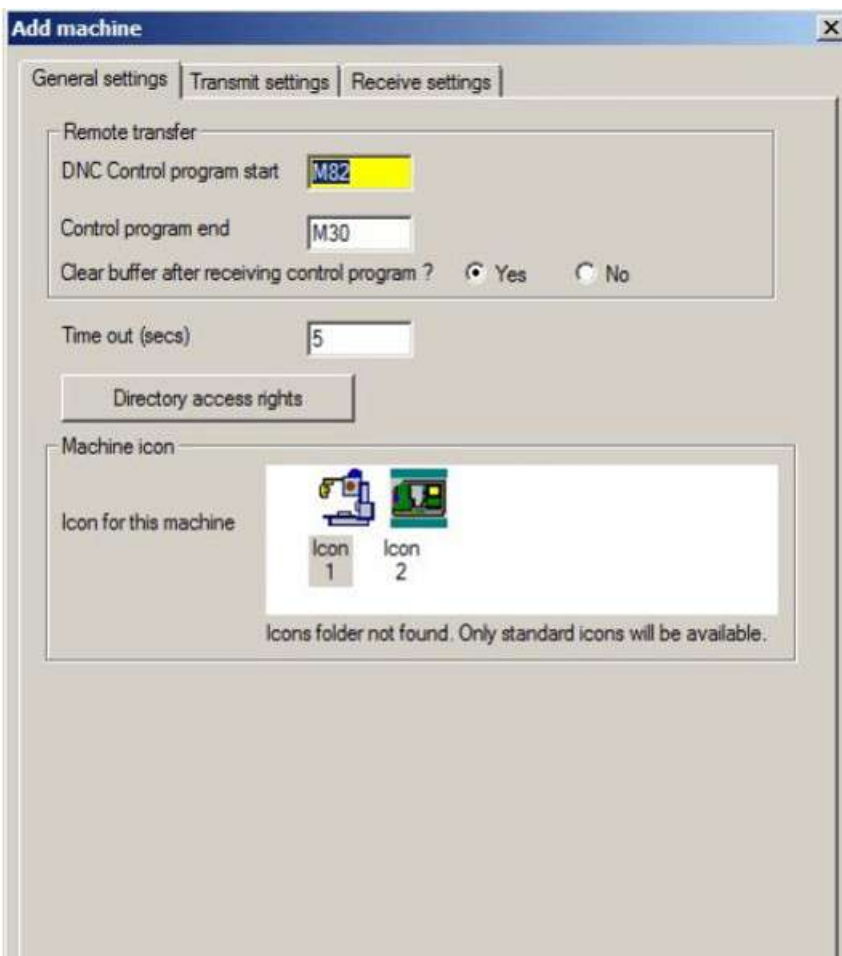
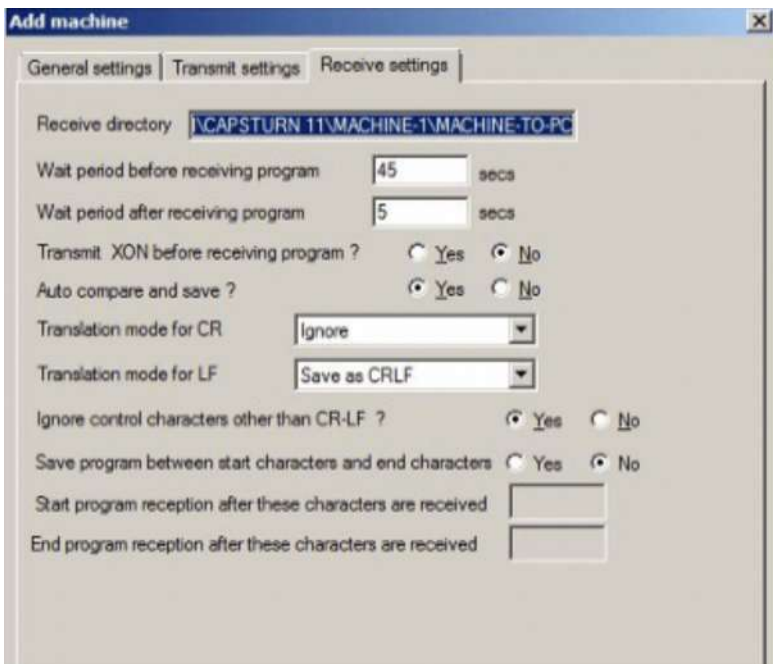
Below the table is a tabbed interface with tabs for 'General', 'DC-1568', 'HC-1000', 'VJ-63', 'LL-300', 'LL-250', 'VJ-1000', and 'HDC-500'. The 'General' tab is active, showing an 'NCnet message' field and a 'Remote commands' field. At the bottom, a status bar displays 'Machine Id: 7 Communication parameters: COM7 (9600 E 7.2 Software) Ready'.

Machine-1.rpt - Notepad					
----- DNC REPORT -----					
Machine name : DC-1568		Transmit Directory : D:\NCNET 7.0\M1\MC-TO-PC			
Machine id : 1		Receive Directory : D:\NCNET 7.0\M1\PC-TO-MC			

DATE	TIME	PROGRAM NO.	NO.OF CHARS	TYPE OF TRANSACTION	REMARKS

24/3/2010	15:6 :0	0	0	Error	UNABLE TO FIND PROGRAM
24/3/2010	15:36:28	1000	5022	Transmitted	Program transmitted
24/3/2010	15:42:4	1000.2	175839	Received	Program saved
24/3/2010	15:43:14	1000	5022	Transmitted	Program transmitted
25/3/2010	16:15:38	1000	3648	Abort	Program transmission aborted.
25/3/2010	16:19:0	1000	5022	Transmitted	Program transmitted
25/3/2010	16:24:53	1.1	5022	Received	Program saved
25/3/2010	16:28:34	1000	5022	Transmitted	Program transmitted
25/3/2010	16:58:49	ABC.1	0	NOT	Program not received.
25/3/2010	16:59:4	ACK1.ERR	5116	Transmitted	Program transmitted
26/3/2010	11:19:6	1000	0	Abort	Program transmission aborted.
26/3/2010	11:19:57	1000	5022	Transmitted	Program transmitted
26/3/2010	11:25:37	1250CHAR.1	33	Received	Program saved
26/3/2010	11:26:17	1000	5022	Received	No change in program. Not saved
26/3/2010	11:34:55	1000	5022	Transmitted	Program transmitted
26/3/2010	11:37:30	1000	5022	Transmitted	Program transmitted
26/3/2010	11:48:4	1000	200920	Transmitted	Program transmitted
26/3/2010	11:53:22	1000.3	50227	Received	Program saved
26/3/2010	11:57:27	1000.3	50227	Received	No change in program. Not saved
5/4/2010	17:18:47	M74.txt	20	Abort	Program transmission aborted.
5/4/2010	17:23:6	1000	200920	Transmitted	Program transmitted
5/4/2010	17:24:21	0	0	Error	Invalid Command for Machine ID

Machine details	
Machine name	Machine-1
Control system	Sinumerik
Machine ID	1
Cell name	
Shop name	
Communication channel	Serial port
Is drip feed required ?	<input type="radio"/> Yes <input checked="" type="radio"/> No
Folder for PC-to-Machine transfer	D:\Program Files\VCadem\CAPSturn 11\Mac ...
Folder for Machine-to-PC transfer	D:\Program Files\VCadem\CAPSturn 11\Mac ...
Port number	COM1
Baud rate	9600
Parity	Even
Data bits	7
Stop bits	2
Handshake	Software
	Advanced
	Create parameter file
	Read parameter file



NCnet v7.0
Troubleshooting guide

? Indicates the possible problem.
🔧 Indicates the possible remedy.

Software does not start up

- > Message "No hardware lock found"
- > Message "Failed to create empty document"

Software starts up but does not work properly

- > Message "Unable to open DNC port (COMx) assigned to yyyy"
- > Message "NCnet.dat is either corrupt or modified outside"
- > Message "Machines not configured, Configure user settings"
- > Message "Access to directory denied"
- > Message "File Programmer.dll not found"
- > Software aborts after some time

Manual mode communication is improper

- > Communication is not working both ways - PC to Machine and Machine to PC
- > PC receives garbled characters
- > Machine sends the program, but PC does not receive it
- > Communication is proper with some machines, but not with others
- > Message "Unable to find program"
- > Message "Machine not ready"
- > Machine does not receive programs at all
- > Machine receives the program but does not come out of the data flow mode
- > Machine receives the program but does not save it in the memory
- > Machine controller displays Buffer overflow alarm

Remote mode communication is improper

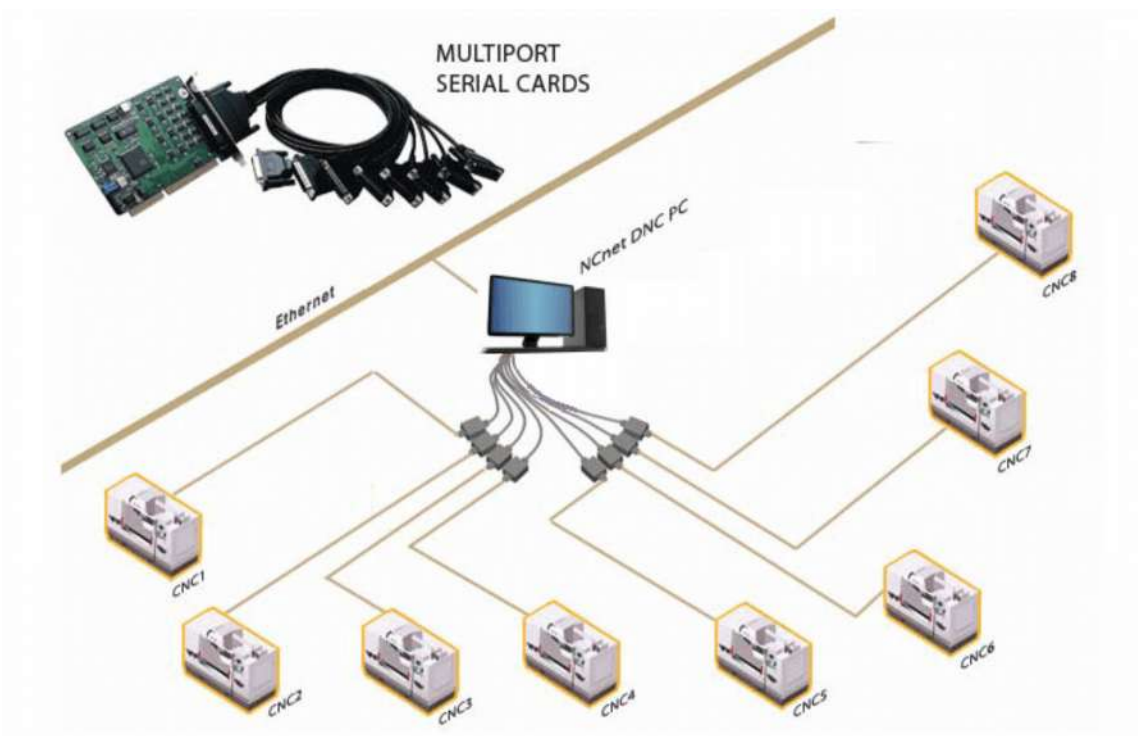
- > PC does not respond to control programs
- > Acknowledgement / error messages do not

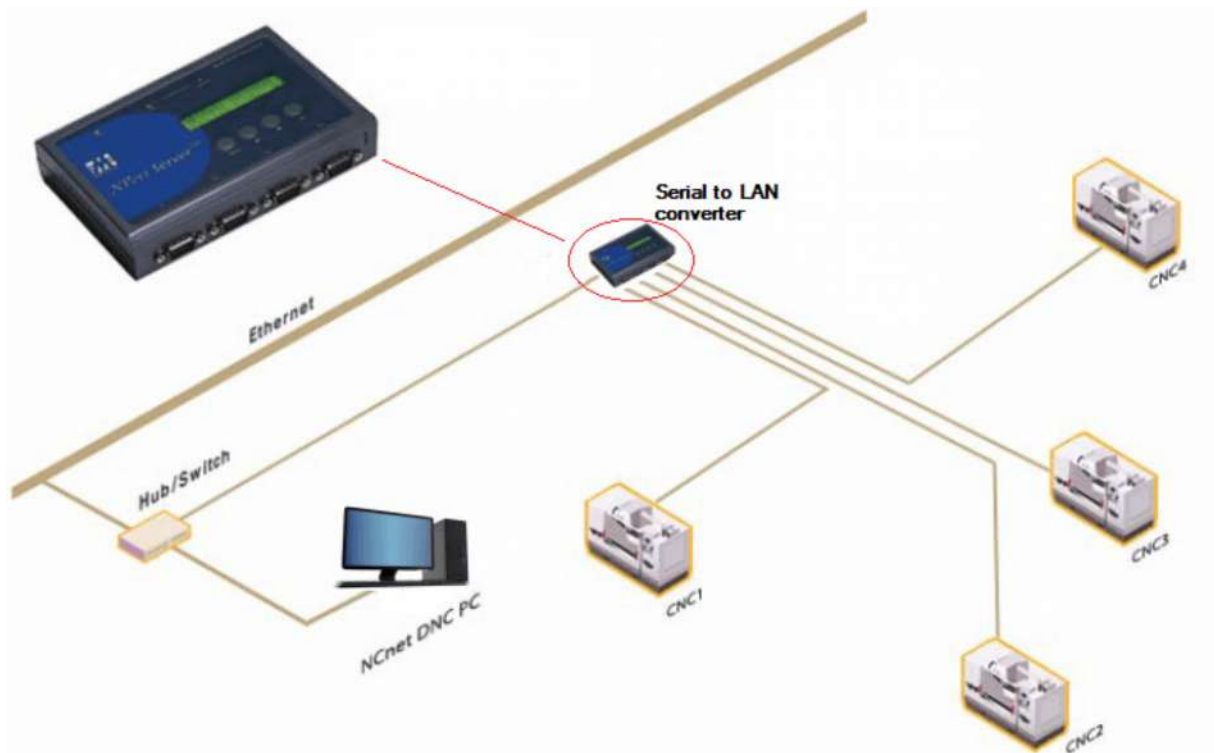


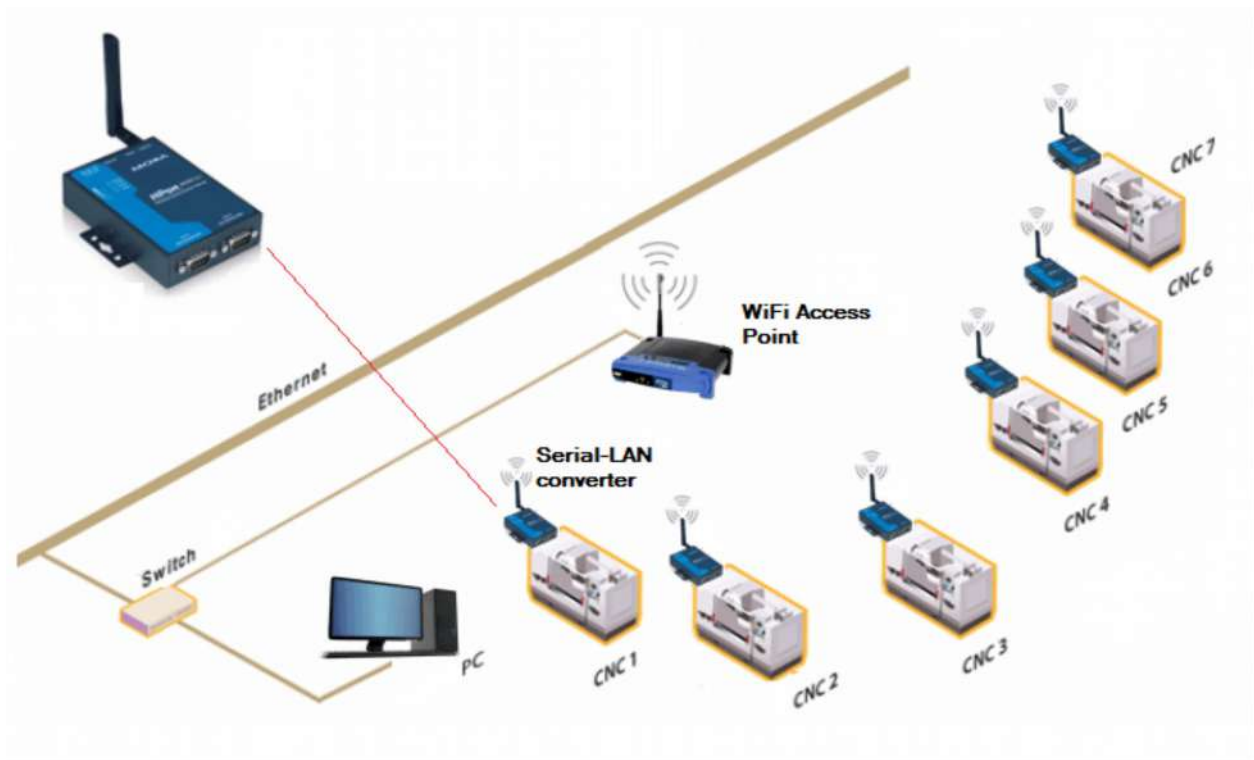
Connection options

You can connect to CNC machines' RS232 serial ports in various ways using standard hardware available in the market.

- Direct wired connection using the PCs serial port (1/2 machines)
- Direct wired connection using a multi-port serial card (up to 16 machines)
- Through wired LAN, using serial-LAN converters (up to 256 machines)
- Through WiFi LAN, using serial-WiFi converters (up to 256 machines)







NCnet Lite – FREE DNC

Connects to 1 CNC machine through the RS232 port.

- Genuinely free DNC software, no strings attached.
- Easy to use interface
- Easy configuration
- 200000 users worldwide.

Important

NCnet Lite DNC software DOES NOT support drip feed. For drip feed, try our NCnet full version.

Feature	NCnet Lite	NCnet
No. of machines supported	1	256
Proven programs safety - separate folders for programs sent to and received from machine	✓	✓
Drip feed machining	✗	✓
Auto restart from interruption in drip feed	✗	✓
Remote calling of programs from machine	✗	✓
Remote sending of programs from machine	✗	✓
Auto compare and save of programs received from machine	✗	✓
DNC Report	✗	✓

Here's how you can reduce the time to get DNC going

Buy our DNC support package :Email support for 2 weeks + Ready-made DNC connection data

We've done thousands of DNC connections over the past 30 years, and there's very little we don't know about DNC.

Why waste many days of your and your machine's time trying to figure out the right cable connection and the settings in the software, on the machine ?

Just buy our DNC support package – it costs peanuts.

DNC data is available for 110 CNC controllers. For each controller there are: Cable connection diagram, parameter settings on the controller, settings in NCnet / NCnet Lite free DNC,PDF file with the details, XML to automatically set required parameters. Here's the List of controllers for which DNC data is available. Here's a Sample PDF file with connection data

Hardware that you will need for the DNC

You will need hardware for the DNC connection for NCnet as well as for NCnet Lite free DNC, depending on how many machines you have and how you want to connect to them. Examples: Cables, gender changers, RS232 tester, optical isolator, etc.

Cadem's web site has a page with suggested hardware, and sources where you can buy them online.