



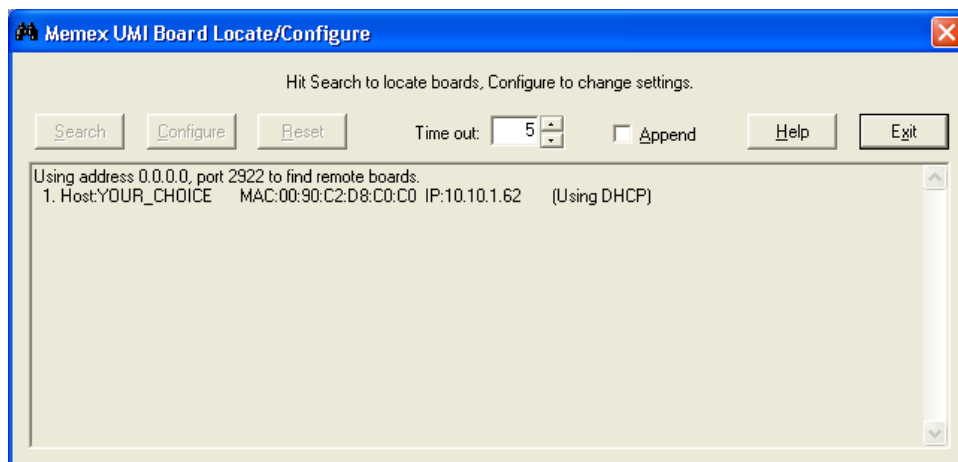
Mx1053 Pictorial Installation Guide

Install the Mx1053 in the Fanuc control with COM1 attached to the Fanuc serial port with the null modem cable supplied. This cable is special in that pins 6, 8 & 20 are jumpered at the CNC end and +24VDC comes through on pin 25 to pin 9 of the DB9 at the MX1053 end. The Memex board gets power from this supply.

The Mx200 Handheld Terminal is connected to COM2 (the middle port named port C or 4321 in LocatIP) while the serial cable is connected to COM1 (Port D or 4444) from the LocatIP side.

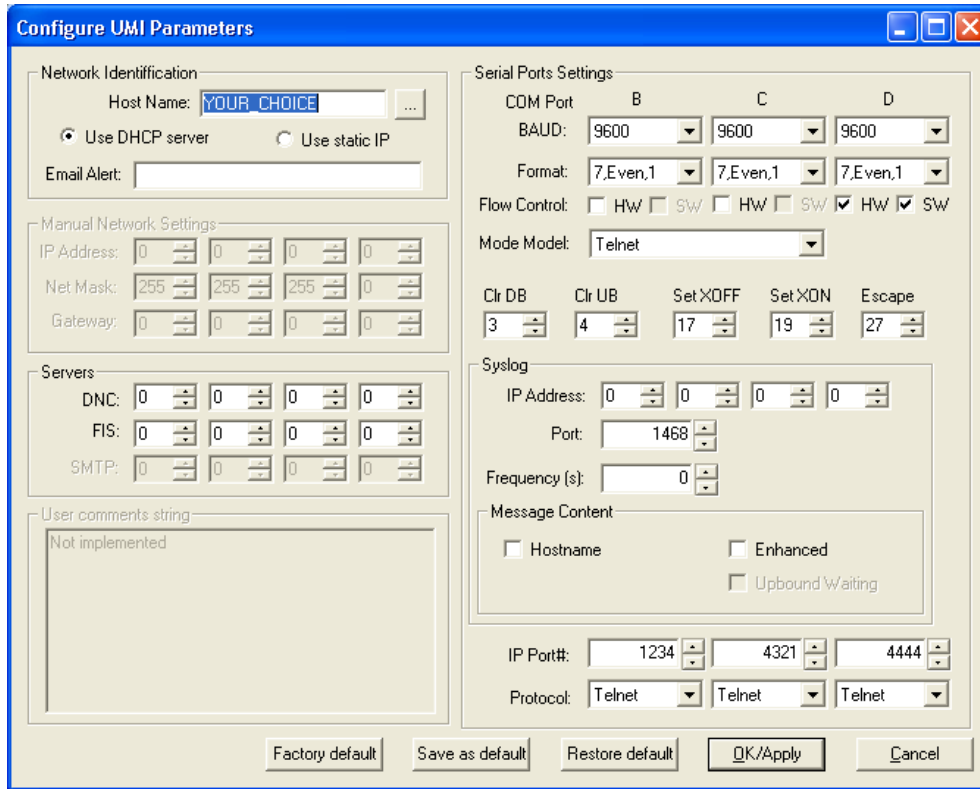
Step 1:

After the Mx1053 unit is installed, powered and on the network – use the LocatIP utility to find the board on the network



Step 2:

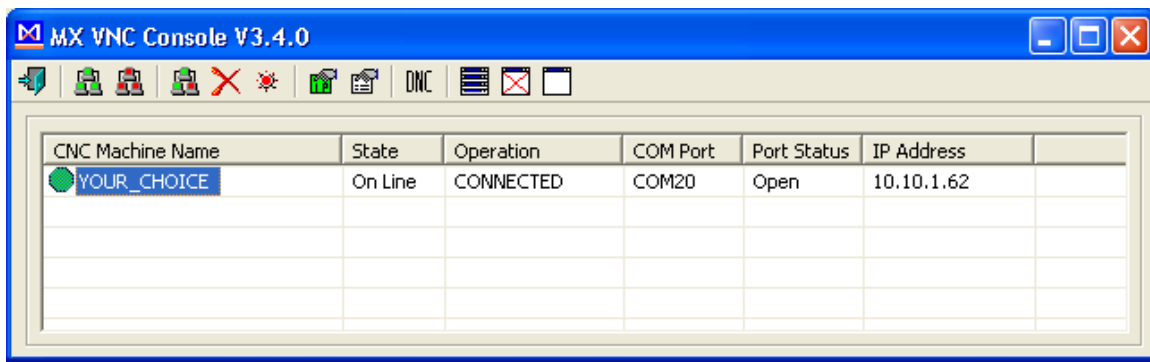
Once the unit appears, select "Config" to configure the Mx1053 as follows changing the baud rate of Port D (the Data Port called COM1) as necessary to match your machine. You will note that this unit only supports only 1 stop bit, so some parameter changes on the CNC may be needed. Consult our website www.memex.ca under the manuals section for detail on serial protocols for various controls.



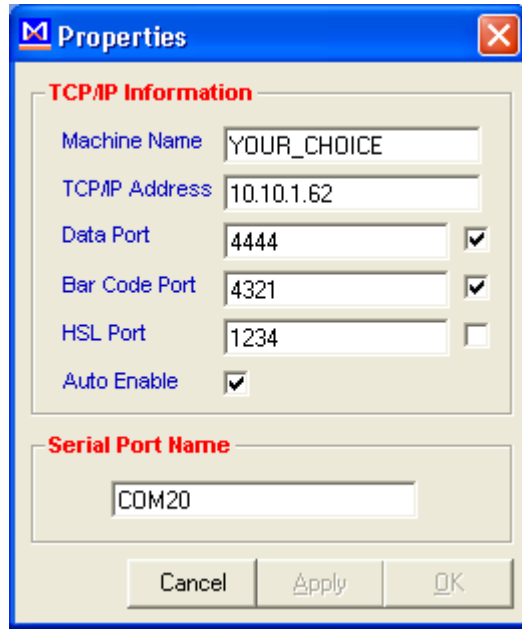
MxServer Ver 3.4 Installation

Step 3:

Install MxServer Ver 3.4.0 and change the DNS name (now called YOUR_CHOICE) of the Mx1053 as necessary to identify the CNC.

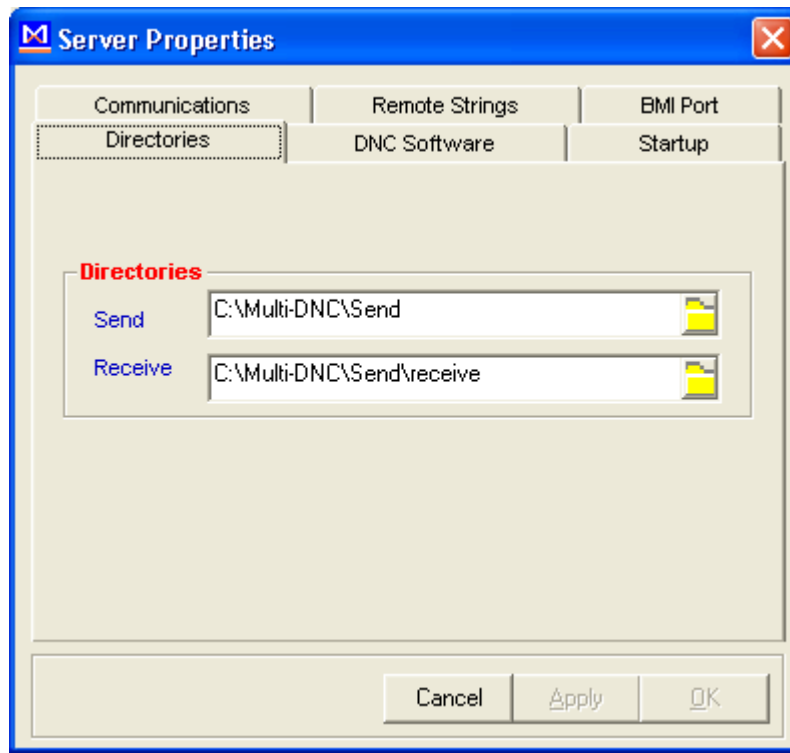


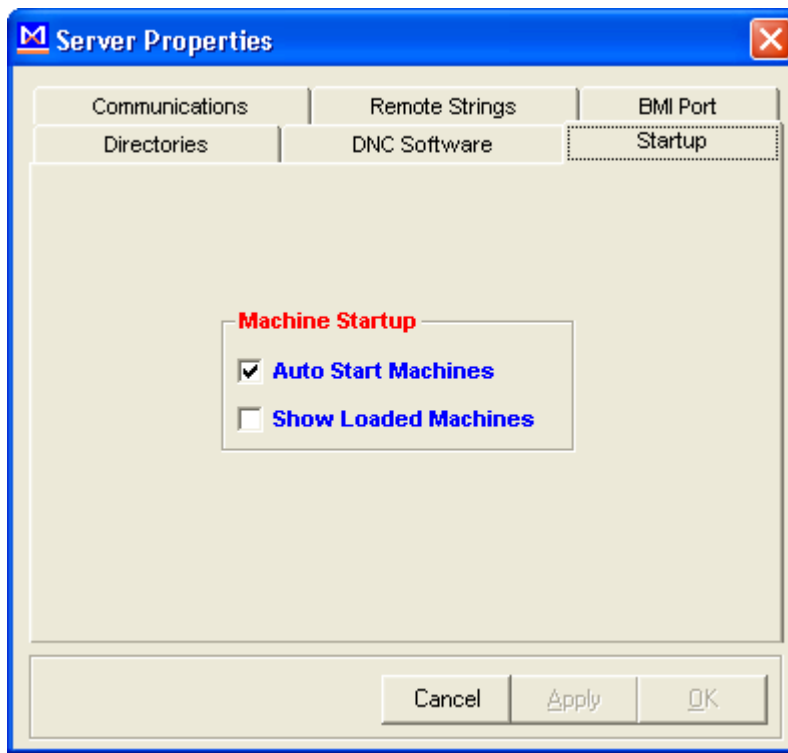
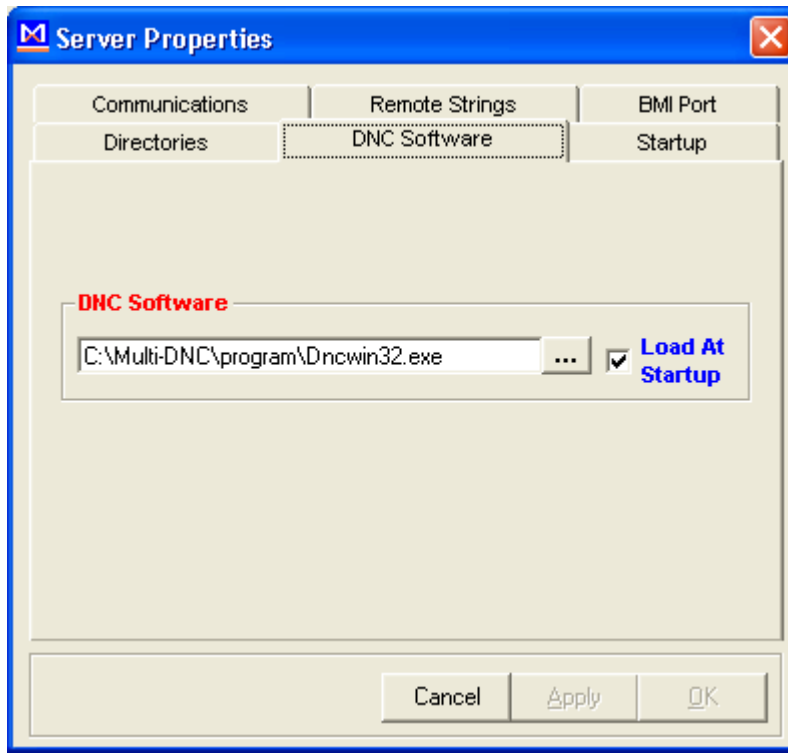
Select the machine then hit the yellow IP button to configure the virtual port.

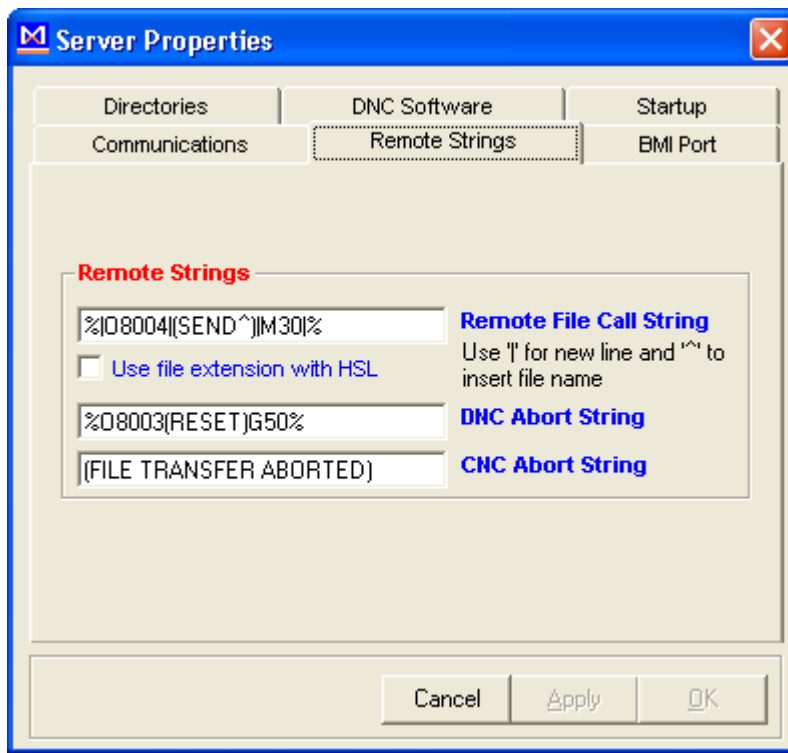
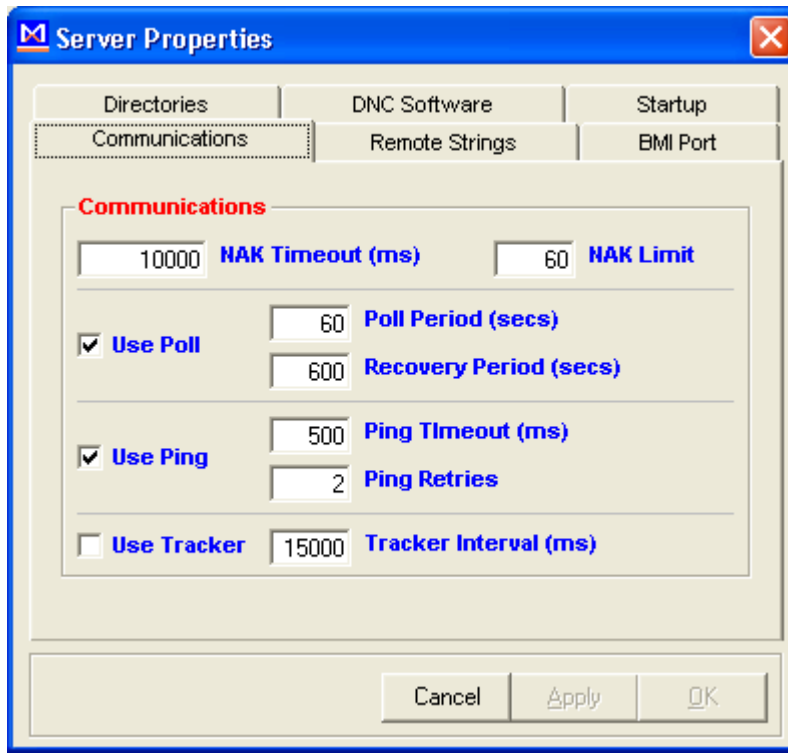


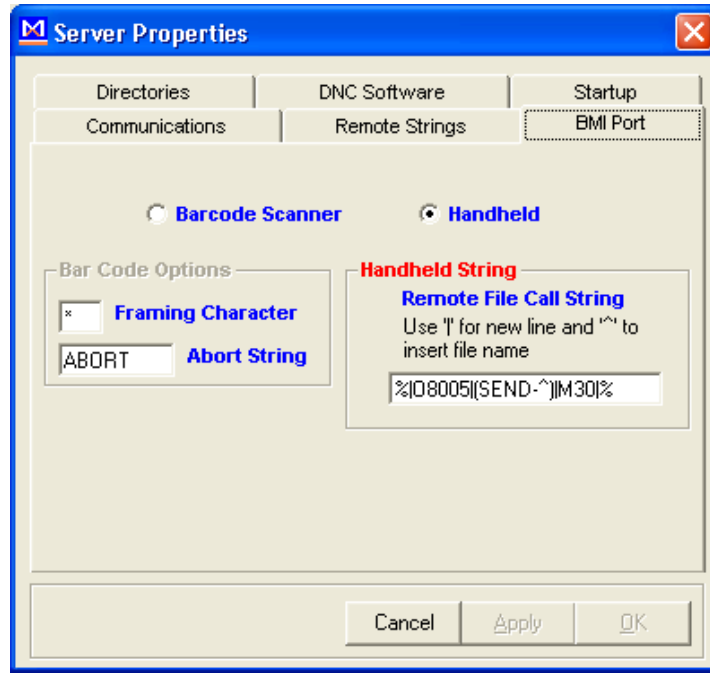
Mx2000 Terminal is in COM 2 (Middle) which is seen as Port 4321. The data port is COM1 and is seen as Port 4444 in LocatelP.

Back at the main MxServer screen. Select "IP Properties" button to the right of the yellow IP button to see...





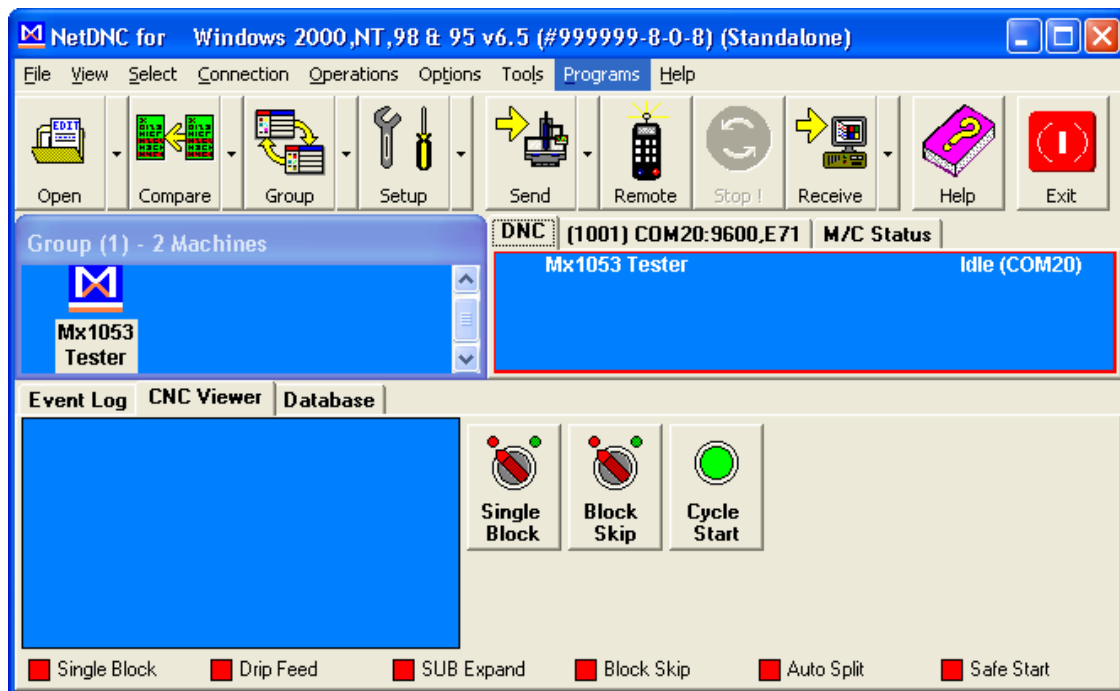




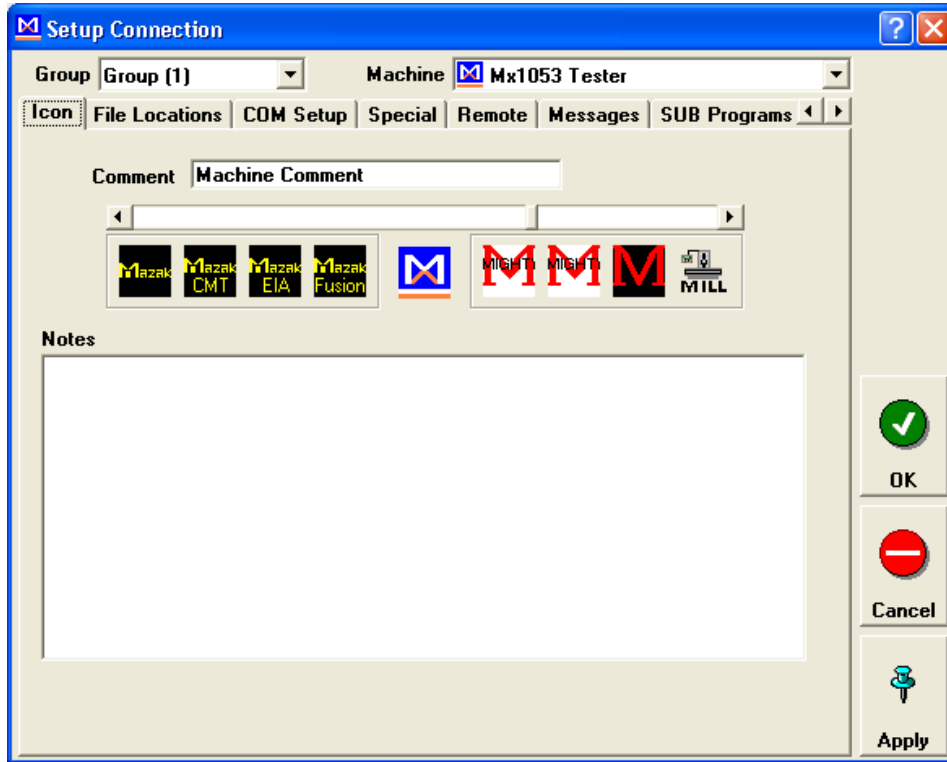
Run MxServer First to Call NetDNC

Step 4:

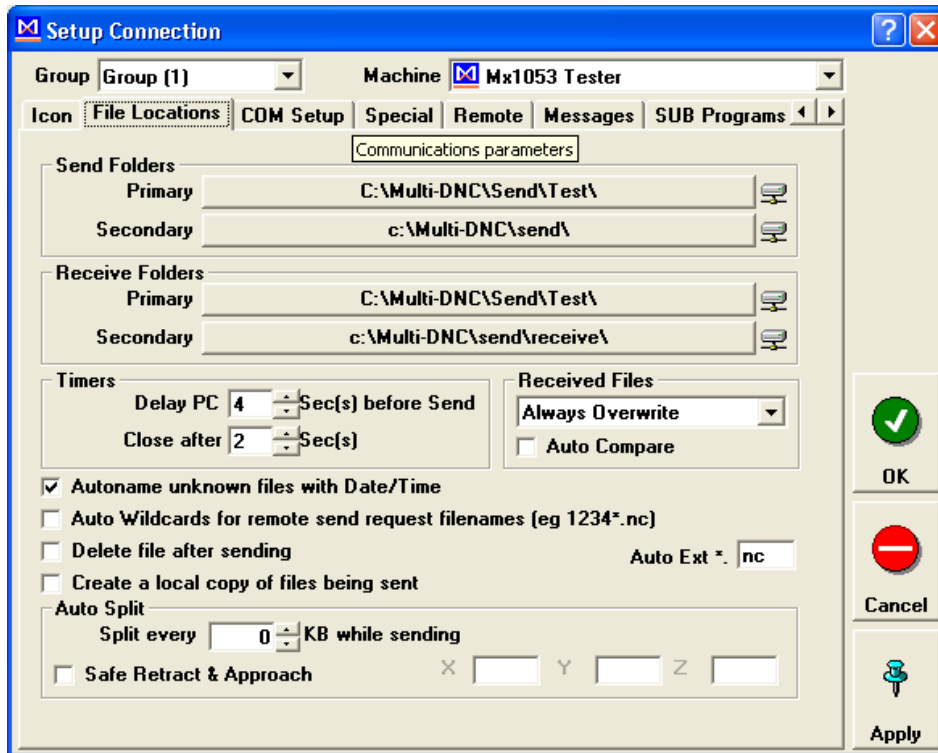
Install NetDNC Ver 6.5H software and set up the machine as follows.



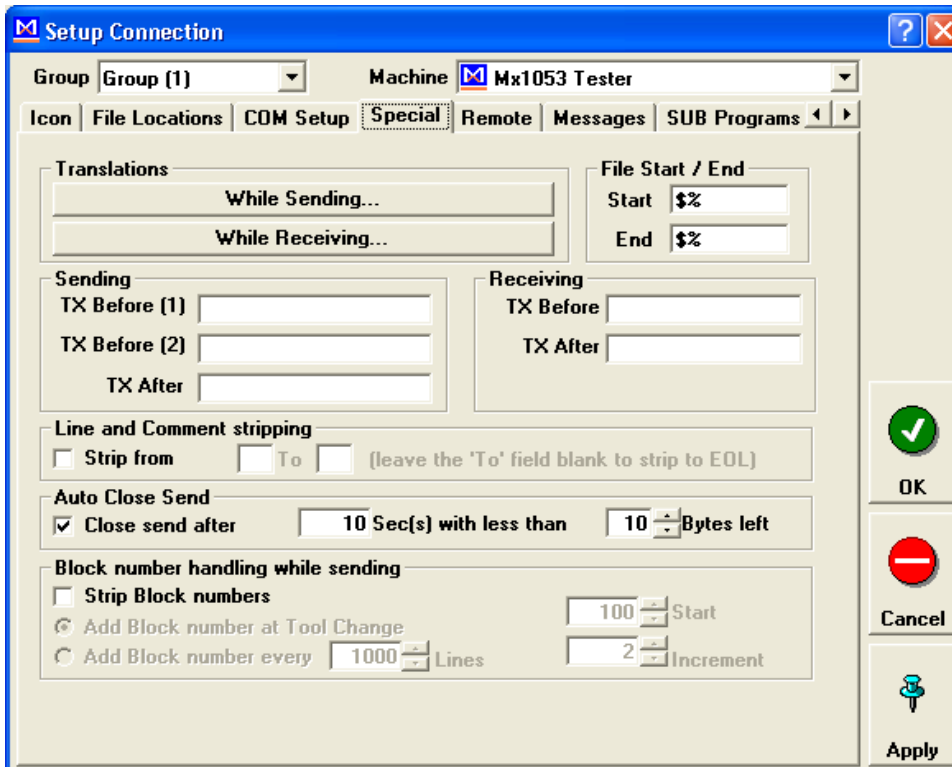
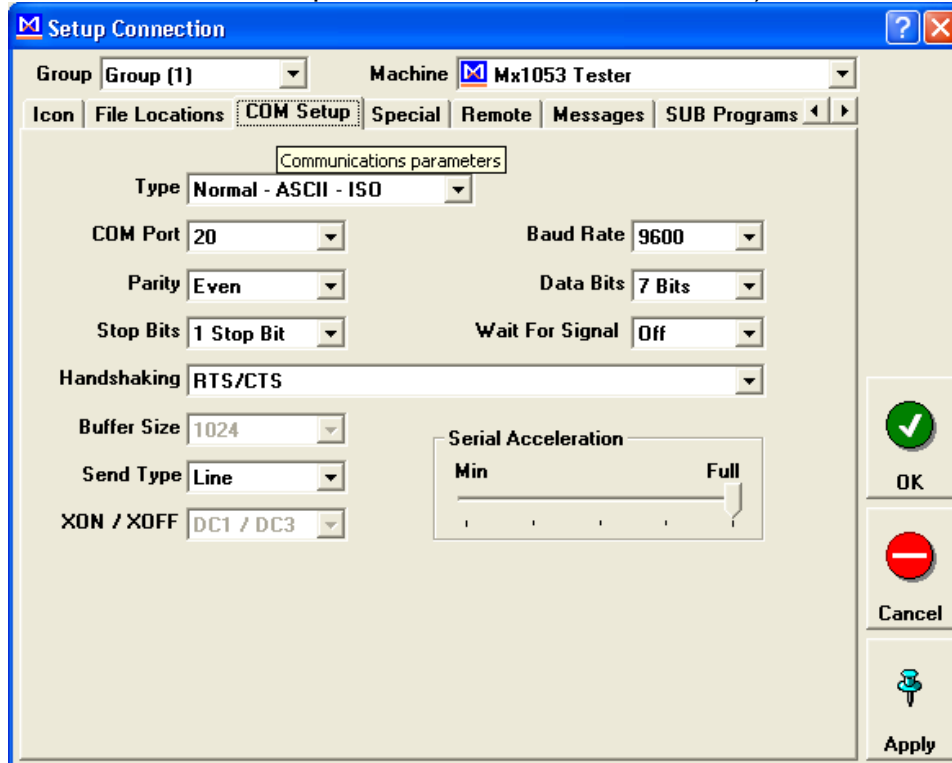
Select the NetDNC Setup tab to set up the DNC software as such. See the data in the following tabs in Setup then.

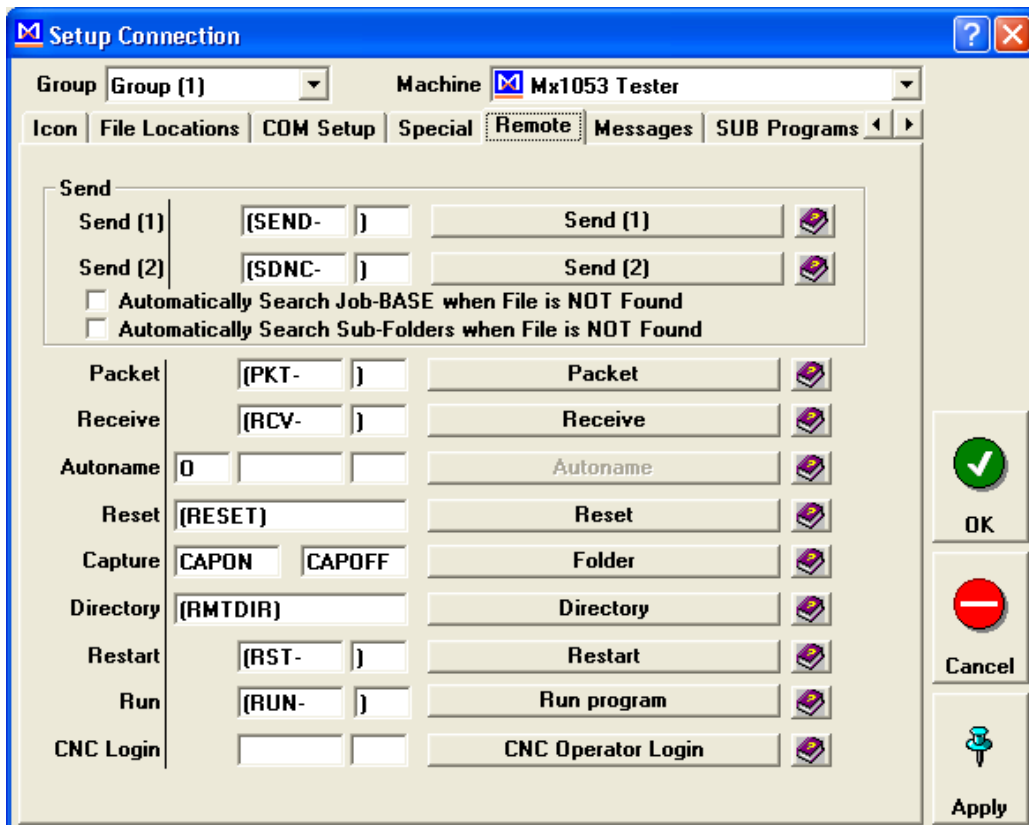
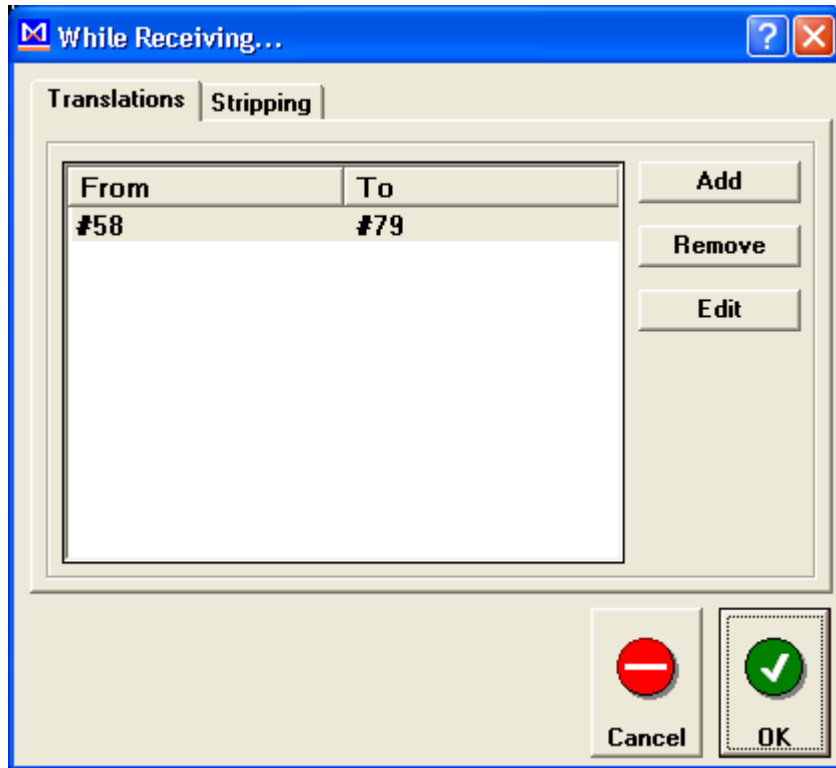


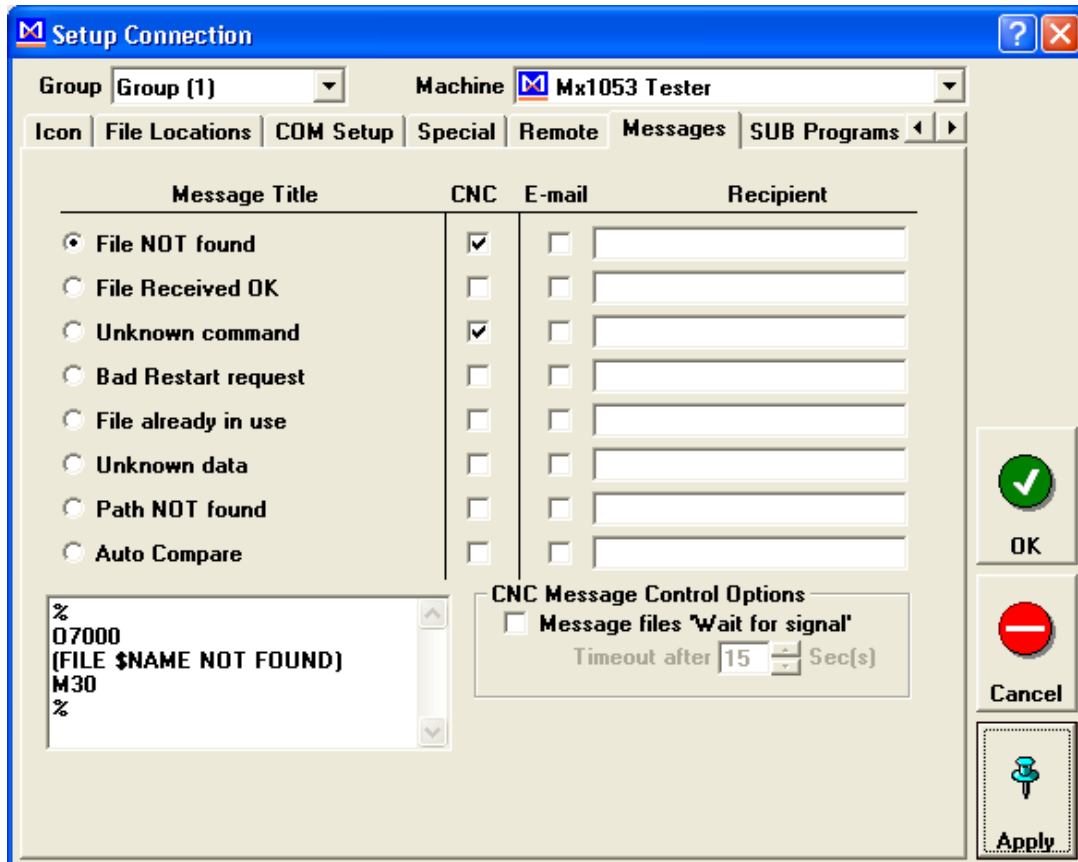
ICON Tab – Setup how NetDNC will show the CNC File Location Tab is below.



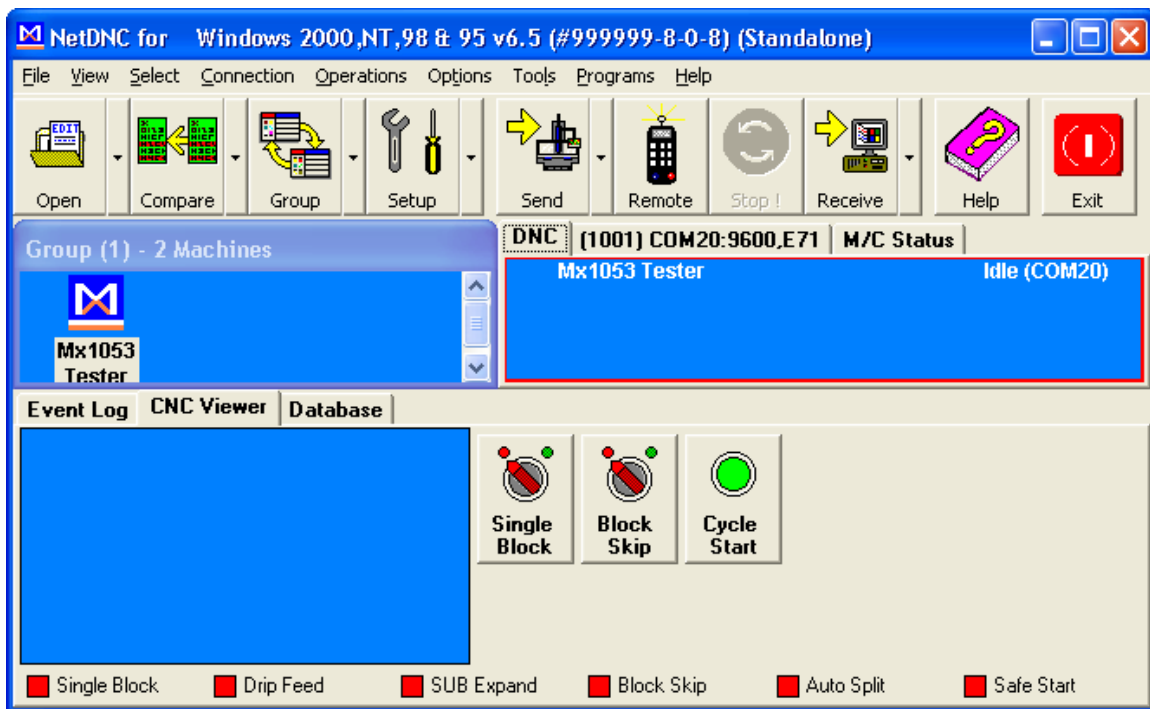
Set the Baud Rate to match your CNC (note that the Mx1053 COM1 port D is the most important to have match the CNC).

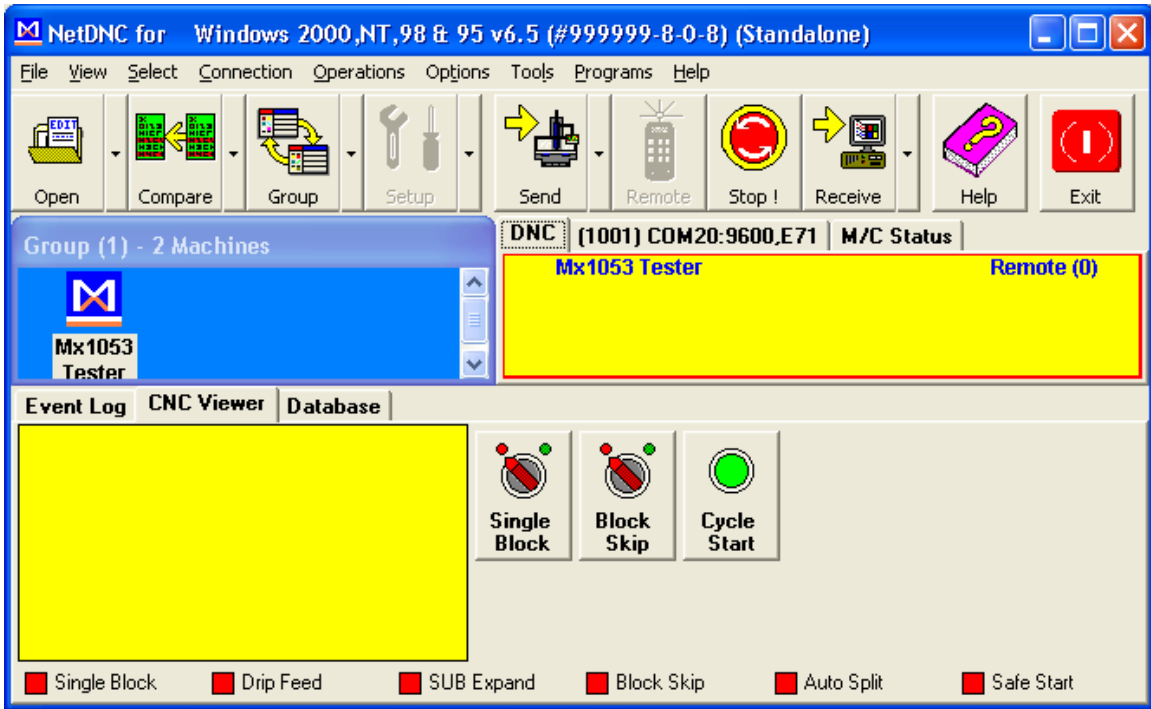




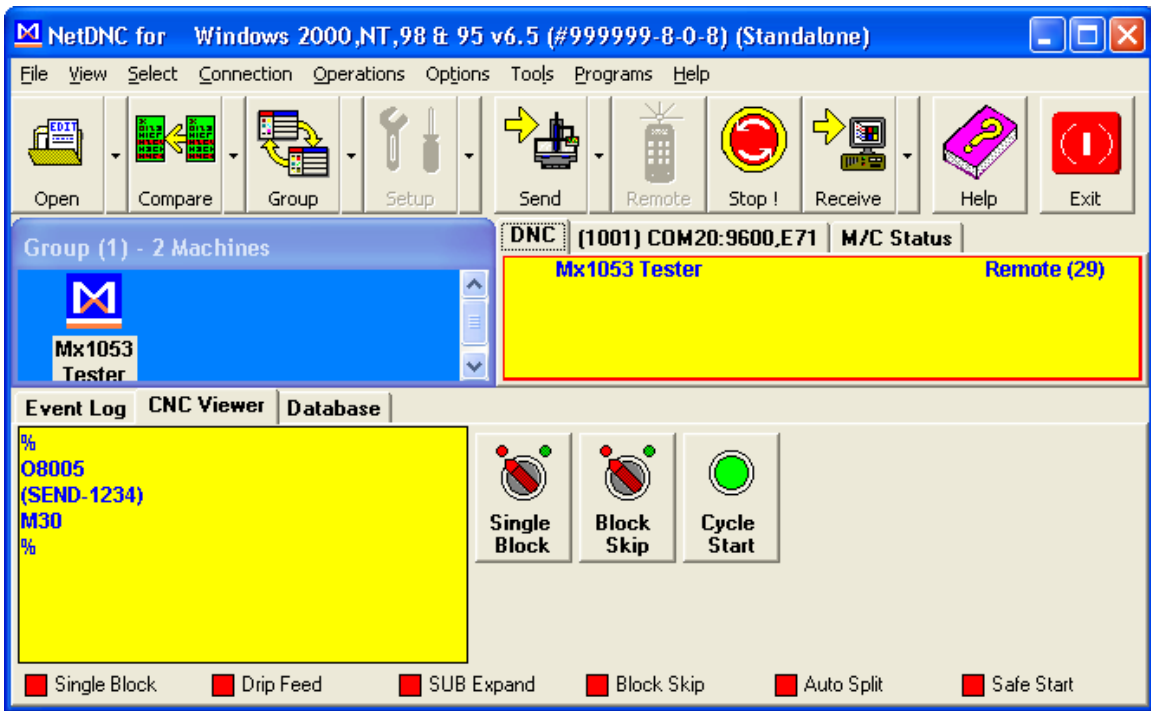


Hit OK and get back to the main DNC screen

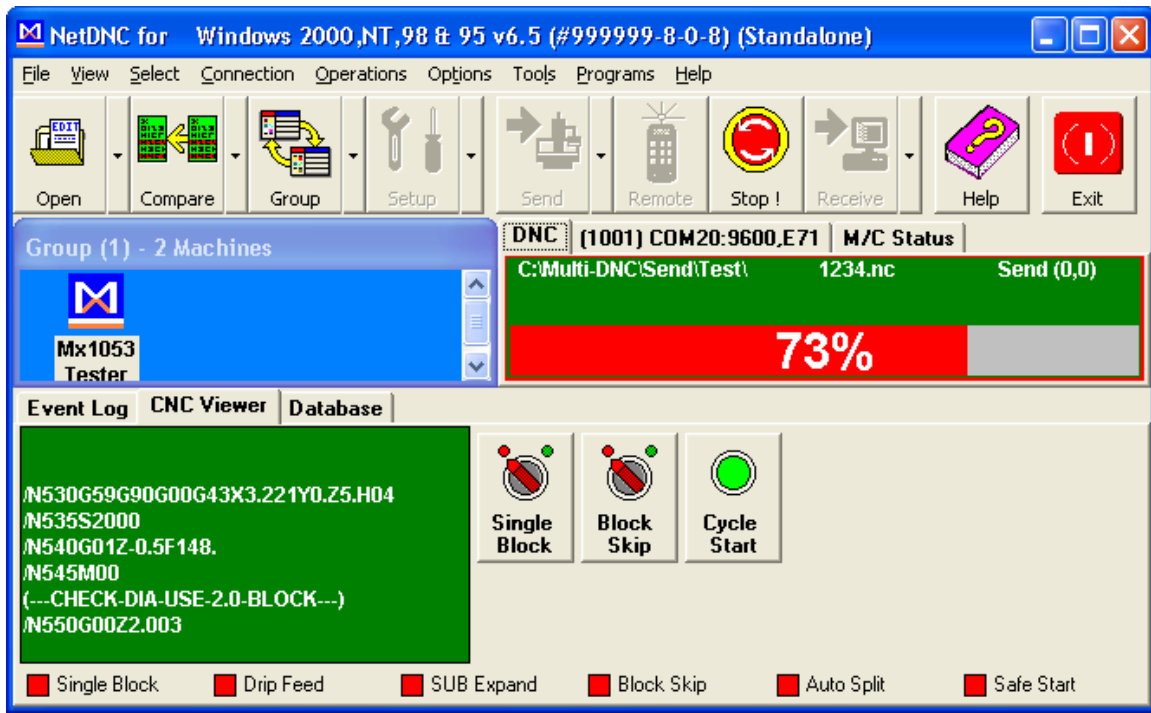




Put NetDNC into Remote mode as above.



When you ask for a file called 1234 using the Mx2000, you will see the above.



You are done.

Thank you for choosing Memex for your Shop Floor Networking Needs.

File: \\ISO9000\DOCs\Current Manuals\M100770 MAI Mx1053 Pictorial Manual With Mx2000.doc