

CNC: Okuma OSP-5000**CNC Parameters**

The OSP5000 controls have several generations of software available. Older OSPs frequently have trouble with RS232 communications because of internal software bugs, a slow processor, or incomplete documentation. Newer OSPs are fairly easy to communicate with.

There are several types of parameters in an OSP control. There is a PARAMETER button near the mode select buttons on the main panel. Press this button, then press the ITEM (up) or ITEM (down) soft keys to show the different parameter types. At each parameter type page, you can press the PAGE UP or PAGE DOWN keys. The page up/down keys usually are marked only with a symbol, and are near the cursor keys.

To change a parameter in the OSP, you must display the parameter page you want with the ITEM soft keys, then cursor to the parameter you want to change, press the SET soft key, then the new data, and press WRITE.

The following parameter settings are for 4800, 1 stop-bit, ISO/even parity, DC codes enabled (Xon/Xoff). If the OSP doesn't receive data within 30 seconds of pressing the READ button, an alarm will occur. Additional descriptions of these important parameters for RS232 communications are in the Okuma maintenance manual:

OPTION PARAMETERS (WORD)

1 (number of feed holes punched in leader) Set to: 1
#34 (timeout setting for device CN0) Set to: 30
#39 (baudrate of device CN0) Set to: 4800
#44 (device number used when punching) Set to: 0 (means CN0)
#54 (device number used when reading) Set to: 1 (means CN0)

OPTIONAL PARAMETERS (BIT)

01: 0 0 0 0 0 0 1 1
12: 1 0 1 0 1 0 1 1 (CN0:)

PC DNC Settings

Baud: 4800
Code: 7 data bits / ASCII Even
Stop Bits: 1
EOB: LF

Okuma Osp 5000 Parameter Manual

A Loxley



Okuma Osp 5000 Parameter Manual:

Control numèric II. Programació Joan Vivancos Calvet,1997 **Control numèric I. Conceptes, característiques i elements bàsics** Joan Vivancos Calvet,1997 L objectiu d aquest text s introduir el lector en els conceptes i les tecnologies que envolten el control num ric CN des d un punt de vista d aplicaci i d utilitzaci Es fa una introducci al CN tant a nivell hist ric com a nivell d aplicaci comparant la m quina convencional amb la m quina amb CN S exposen les caracter stiques i els elements b sics de les m quines amb CN a fi d entendre el seu funcionament i con ixer les seves possibilitats i s introdueixen els conceptes previs que cal tenir clar abans de programar amb CN **Machinery Buyers' Guide** ,1999 *Japanese Technical Abstracts* ,1987 **Metalworking News** ,1987-10 *American Machinist & Automated Manufacturing* ,1986
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