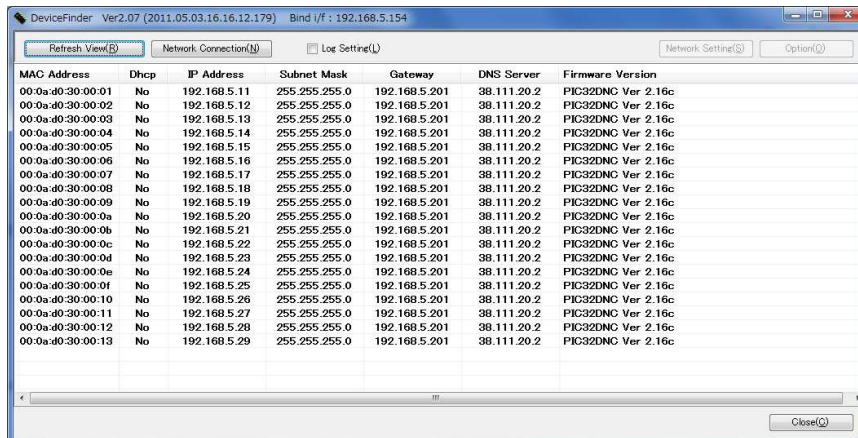


## VISI-HUB installation steps.

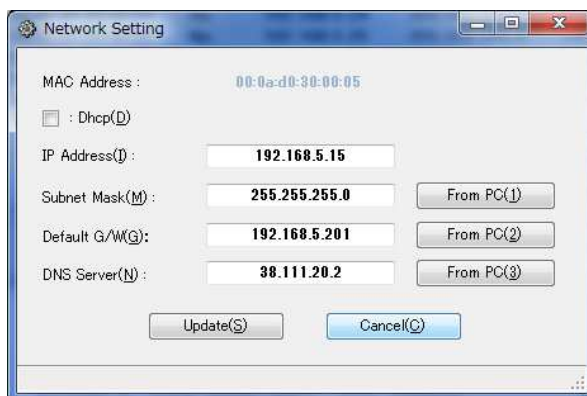
1. Cabling. RS232C and LAN.
2. Turn on the VISI-HUB.
3. On default mode, it will boot by DHCP.
4. In some cases, such as there isn't DHCP server, there is no leasable IP-Address, VISI-HUB need a few minutes until it boots. In the worst case, 5 minutes.
5. On DeviceFinder, you will see the target VISI-HUB.



The screenshot shows the DeviceFinder application window. The title bar reads "DeviceFinder Ver2.07 (2011.05.03.16.12.179) Bind I/f : 192.168.5.154". The window contains a table with the following columns: MAC Address, Dhcp, IP Address, Subnet Mask, Gateway, DNS Server, and Firmware Version. The table lists 13 devices, all with MAC addresses starting with 00:0a:d0:30:00 and IP addresses in the 192.168.5.x range. The firmware version for all devices is PIC32DNC Ver 2.16c.

MAC Address	Dhcp	IP Address	Subnet Mask	Gateway	DNS Server	Firmware Version
00:0a:d0:30:00:01	No	192.168.5.11	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:02	No	192.168.5.12	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:03	No	192.168.5.13	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:04	No	192.168.5.14	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:05	No	192.168.5.15	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:06	No	192.168.5.16	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:07	No	192.168.5.17	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:08	No	192.168.5.18	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:09	No	192.168.5.19	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0a	No	192.168.5.20	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0b	No	192.168.5.21	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0c	No	192.168.5.22	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0d	No	192.168.5.23	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0e	No	192.168.5.24	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:0f	No	192.168.5.25	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:10	No	192.168.5.26	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:11	No	192.168.5.27	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:12	No	192.168.5.28	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c
00:0a:d0:30:00:13	No	192.168.5.29	255.255.255.0	192.168.5.201	38.111.20.2	PIC32DNC Ver 2.16c

6. If the target VISI-HUB doesn't appear on the list, please click the "Refresh view".
7. If there isn't it even though after clicking it, check the LAN cabling and the power, or wait a few more minutes.
8. If you can't see it on the list now, please call us.
9. Check the IP-Address of your target VISI-HUB.
10. Point the target VISI-HUB and click the "Network Setting" button.



The screenshot shows the "Network Setting" dialog box. It contains the following fields and controls:

- MAC Address: 00:0a:d0:30:00:05
- Dhcp(D)
- IP Address(I): 192.168.5.15
- Subnet Mask(M): 255.255.255.0 (with "From PC(1)" button)
- Default G/W(G): 192.168.5.201 (with "From PC(2)" button)
- DNS Server(N): 38.111.20.2 (with "From PC(3)" button)
- Update(S) and Cancel(C) buttons at the bottom.

11. If "Dhcp" is checked, uncheck it.
12. Assign new IP-Address according to your network configuration.
13. Subnet Mask, Default G/W, and DNS Server can be configured by "From PC" buttons.
14. Click "Update" button, the dialog box will be closed, and wait a moment.
15. You will see the target VISI-HUB with new IP-Address you specified.

## DeviceFinder TCP/IP, UDP ports

UDP 10004 for device configuration.

UDP 10003 for device lookup.

## Drive Mapping on VISI-DNC Server

There is UAC on Windows Vista, Windows 7.

When you map some shared volumes on your PC as drives, in some case you have to change the UAC configuration.

1. Control Panel -> User Account -> Change Setting
2. Never notify. (UAC is disabled.)

## ipdnc32i TCP/IP, UDP ports

TCP 10005

UDP 10005

TCP 21 (depends on FTP configuration)

## Firewall, Virus Protection

VISI-DNC server will open some TCP, and UDP port.

When windows system asks you some UAC alert, please permit them.

It is recommended that the server execution file (ipdnc32i.exe) is permitted.

How to check the ports ipdnc32i uses,

“netstat -ab” on Command Prompt.

## FTP server on ipdnc32i

In default, the emvedded FTP server is disabled.

To enable it, follow the steps below.

1. Open a file "ipdnc32.properties".
2. It's located on the ipdnc32.exe folder.
3. Add a line.  
`FtpServerPort=21`
4. Save a file.
5. Restart ipdnc32.exe.

note:

1. To disable it, remote the line or change the value to '-1'.  
`FtpServerPort=-1`
2. '21' is common port number for FTP server. (Well known port)
3. Before editing it, make sure that no programs are using the port.  
You can check it by entering 'netstat -a' on 'Command Prompt'.
4. On CNC side, FTP server IP address and port number must be specified according to this configuration.
5. Client user name must be "anonymous".
6. Client password must be "anonymous".

## Multi NIC on PC

In some case there might be 2 or more NICs, 1 of them is for office, and another is for shop.

In this case, you should specify which NIC should be uses by ipdnc32.exe.

1. Open a file "ipdnc32.properties".
2. It's located on the ipdnc32.exe folder.
3. Add a line.  
`host.ipaddress=123.456.789.012`
4. Save a file.
5. Restart ipdnc32.exe.

You can check it by entering 'ipconfig /all' on 'Command Prompt'.

## Logging on ipdnc32i

Editing as below, ipdnc32i.exe will make log file for the events.

system.log.file=True

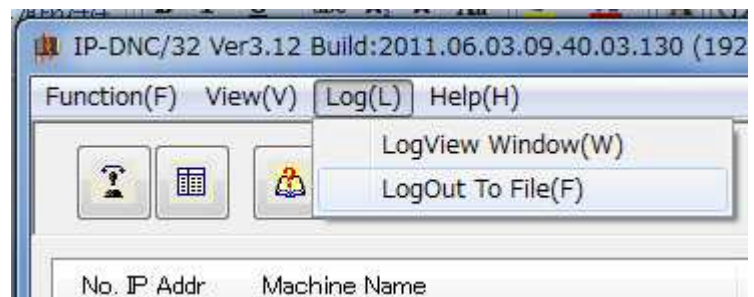
When it runs, 'log' folder will be created under the ipdnc32.exe folder.

The log file name will be assigned by date. 'yyyy.mm.dd.txt'.

The system holds recent 30 days log files.

note:

At the run time, you can arrange this switch from a menu as below.



## FANUC 16 configuration

Set bit5 of Parameter#100 to '1'. (ND3)

This makes "Faster" mode.

## FANUC parameters for Keyboard

#3204 bit 0 = 1 for "(" and ")"

#3204 bit 0 = 0 for "[" and "]"

Also, #3204 bit 2 = 1 enables [C-EXT] soft key

which gives you soft keys for "(", ")", and "@".

## FANUC 6M

FANUC 6M doesn't support the DNC thru RS232C without RemoteBuffer.

## Fadal CNC setting

1. "MANUAL" button to command mode.
2. "SETP" command to parameter mode.
3. PageUp or PageDown
4. Set "PU FORMAT" as "TAPE". (PUNCHED TAPE FORMAT)

Fadal Original:

Remote command is available.

In VISI-DNC, after command punch,

The read sequence will start automatically.

FORMAT2:

If you use DNC command, set it as "FORMAT2".

FORMAT2 is FANUC compatible mode.

-> Remote command is no longer available.

## Fadal important commands.

1. PA -> Call program.
2. PR -> Program
3. SETP -> Parameter mode.
4. CS -> Cold start.
5. PU -> PUNCH. 1:All, 2:Current program.
6. TA -> TAPE reading.
7. DNC -> Start DNC.

## Fadal read operation

1. "MANUAL" button to command mode.
2. "PR" (Enter) -> Program mode.
3. "TA,1" (Enter) -> DC1 code will be sent from CNC.  
"DNC" (Enter) will start DNC with VISI-HUB.

## Fadal punch operation

1. "MANUAL" button to command mode.
2. "PR" command -> Program mode.
3. "PA" + program number (Enter) -> call program.
4. "PU, 2" (Enter) -> DC2 + data + DC4 will be sent from CNC.  
PU, 1 -> Puch the all programs. (Don't use in VISI-DNC)  
PU, 2 -> Puch the current program.

## Haas CNC setting

Set parameter No.14 SYNCHRONIZATION to "DC CODE".

-> After select "DC CODE", press the "ENTER".

Note. If it is "xon/xoff", dc2 and dc4 will not be sent from CNC.

Note. After you change the parameters, in some cases, the parameters you updated will not work until you reboot the cnc.

## Fadal problem.

Some times, on Fadal cnc, "PU" and "TA" command doesn't work.

In this case, please reboot the CNC by "MANUAL" button or rewrite the parameter "PU FORMAT" to "TAPE".

After this, the CNC will respond, it will work.

## YASNAC setting

YASNAC. How to change the parameters.

\*INSRT -> CURSOR(Down arrow) -> "0" -> WR

\*\*Before changing a parameter, set rotary SYSTEMNO switch to "1". It's PWE.