PC-DNC FAQs

**Making our customers' lives easier.**

Quickstart Guide for PC DNC Editor

Login as Administrator

Important: On **Windows 7** or **8** computers, turn off USER ACCOUNT CONTROL. To turn off User Account Control, go to Control Panel/System & Security/Action Center/Change User Account Control Settings. Move bar all the way to bottom, Click Save. You may be prompted to reboot your computer.

On **Windows 7 or 8** computers, CLICK SAVE when downloading the file NOT RUN. Then find the downloaded executable, right click and choose RUN AS ADMINISTRATOR. Here is the link to the download:

http://www.pc-dnc.com/downloads/ and choose PC-DNC Editor

Click **NEXT** at InstallShield Wizard
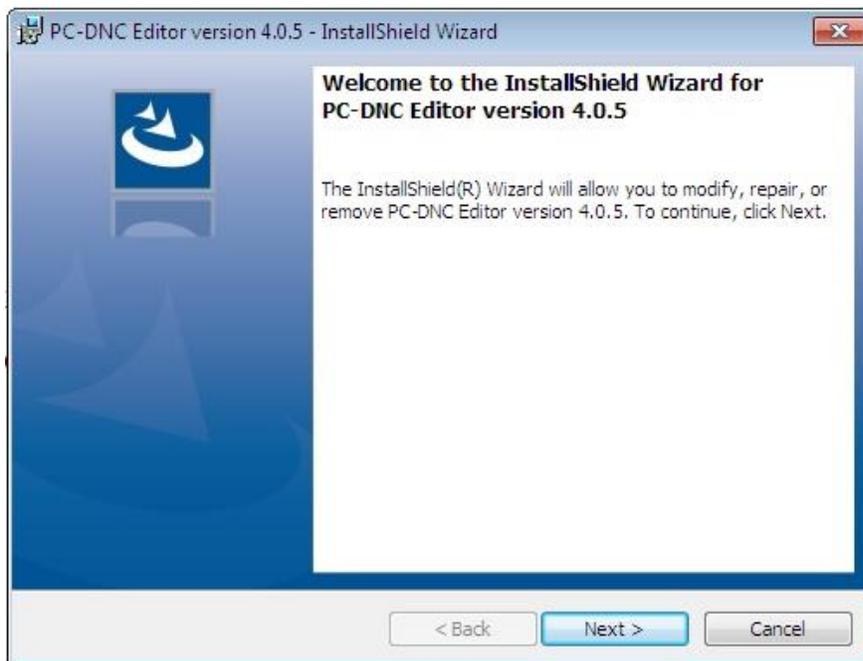
Click **NEXT**
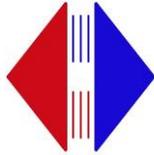
Confirm the Destination folder is c:\RYM\PC-DNC Editor.   For Windows 7 and Windows 8, the default installation location **must be** c:\RYM\PC-DNC Editor. If it is not, click Change and remove \program files from the default directory path.
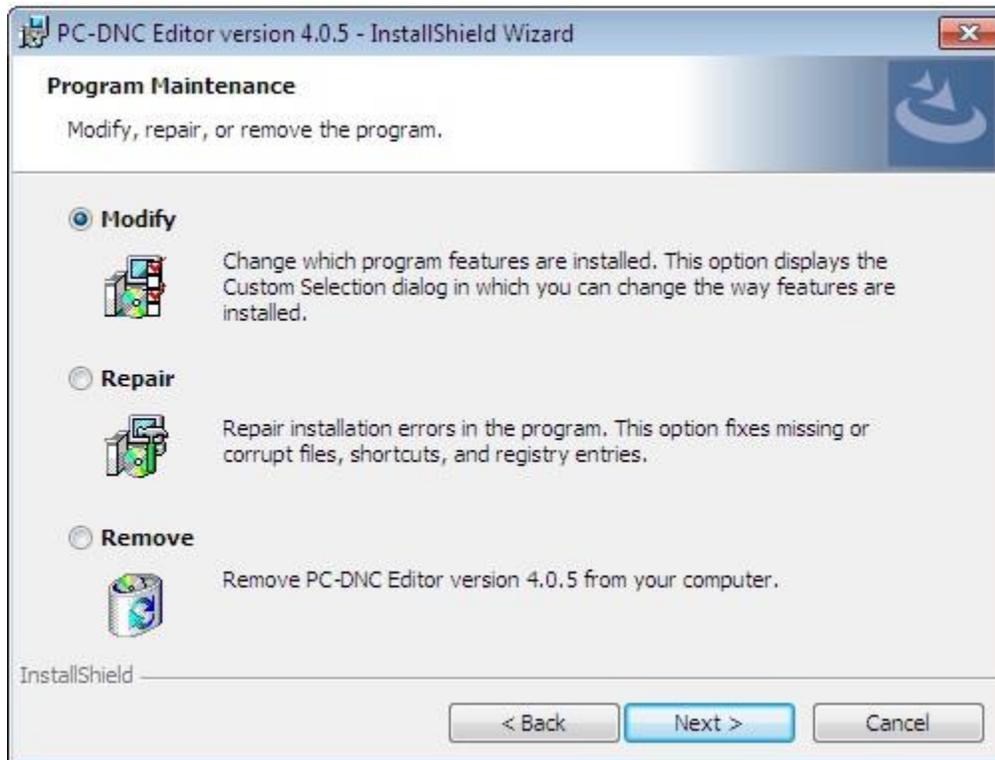

Select **"Modify"**

Click **NEXT**
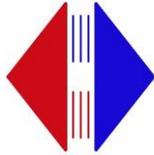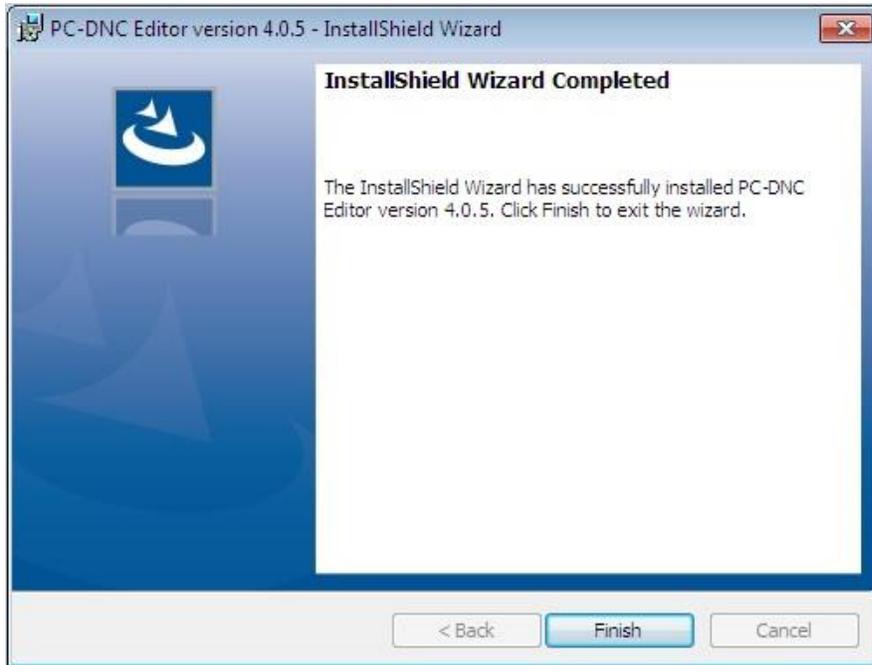
Click **FINISH**

To license your product go to the About/Purchasing Information menu. Note 9-digit security number, then contact Suburban Machinery Software by phone or email to request you licensing password. Our phone number is (440) 951-8974 and our email address is suburbanmachinery@gmail.com

PC-DNC Editor will run with no restrictions for 30 days, after which time the File/Save and File/Send functions are disabled.

We do charge a modest re-licensing fee, which you can pay for by credit card or company PO. When we register your purchase, we will give you the new PCs licensing password.

To enter the password, click the "About/Purchasing information" menu on your new PC and press the Ctrl + Alt + "L" keys at the same time. Enter your company name and city/state, then the 9 LETTER password that we give you. The password must be entered as ALL CAPS, and you must not leave the company name or City/State fields blank. Close and reopen the Editor to complete the license process.

To configure a new machine:

Go to **I/O** Menu

Click on **Configure I/O device**

Enter a machine name next to Add to List:

Click the **Add to List** button
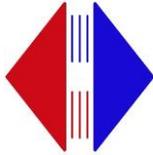
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If using an external serial device server such as a Quatech, Comtrol or Moxa hub, click on **Advanced** and check "**Handshake using device driver**." Click **OK**

Advanced IO configuration menu

When sending ...

Leader: `%LFCR`
Trailer: `%`

☐ Send man-readable leaders
Check handshake every `5` characters
Skip data that starts with:
Skip lines that contain:
Mask out these characters:
Skip data up to & including:
Skip data after & including:
Replace: with:
Switchbox select codes:
Delay between characters: `0` ms.
Delay between blocks: `0` ms.
Delay after receiving Xon: `0` ms.
☐ Delete blank lines
☐ Add spaces for vertical (TV) parity
☑ Handshake using device driver
☐ Send Xon every 2 seconds
ASCII value of Xon: `17` Xoff: `19`

When receiving ....

☑ Ignore data before first EOB
☑ Ignore data after last EOB
☑ Use auto code recognition
☐ Separate files by O-numbers
☐ Receive until I/O is aborted
☑ Receive until timeout of: `3` sec
Mask out these characters:
☐ Send Xon every 2 seconds

OK
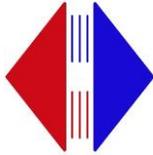
If you want to set up a default directory to store files sent and received, click on **Options/Set Directories**. Enter the default location in the **Default file path**. Click **Apply**.

Set directories

Default file path:	\\servername\program dir
Path for CALC.EXE:	
Scratchpad directory:	C:\RYM\PC-DNC Editor
Code clip directory:	C:\RYM\PC-DNC Editor
Utility program #1:	
Utility program #2:	

☐ Pass active file name to Utility programs

File types listed in File/Open dialog: *.*   *.TXT   PROG*.   *.NC   **Delete**

Add file type to list:

Default file type: *.*

☐ Add extension when saving file

Apply   **Cancel**

You are ready to test communication to the machine. Below are some basic communications tests you can conduct to make sure your Editor is communicating properly with your machine.
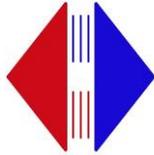
1. First test (Receive file in Terminal Window)

   Select machine by clicking **I/O** menu

   Then click **Select I/O Device**

   Click on machine you want to test

   Click **Select**.

   Then click **I/O** menu again

   Then click **Terminal Window**

   Leave terminal window open and go to machine and send a file.

   You should see ne of four things in the terminal window:

   1) Intelligible data - Your program is there and in recognizable G-code format with some extra information at the end of every line (line feeds(<LF>and carriage returns <CR>)..

   2) Nothing - indicates wrong port on machine, wrong COM port on computer, incorrectly wired cable, or in rare cases a bad port on either the computer or machine

   3) Garbled data - indicates one of the basic settings (baud rate, data bits, stop bits, or parity) is mismatched. NO other settings in the DNC software affect the terminal window. If you are sure these match, see if your CNC has the option to transfer in ISO/ASCII or EIA. If the CNC is set to EIA you will need to change it.

      Note: Terminal Window does not capture the G-code file for sending back to the CNC. See test #3 to do that. It will allow you to save the file as a Rich Text File for further troubleshooting.
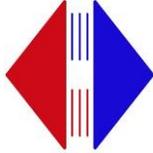
2.   Second test (Receive file in PC DNC Editor)

Click **I/O** menu

Then click **Receive File**. A window should open in Editor that will receive the file when it is sent from the machine.

Go to machine and send a file. It should appear on the Editor screen.

(From this point you can also do a File/Save As and save the file to your network)

3.   Third Test (Send file to machine)

First, change the O number of the file you just received to one that is not being used by a program on the machine. (Not necessary to save the file at this point in the testing)

Click **I/O** menu

Click **Send File**

Choose how you want to send file:

DNC for drip feeding long files

XON will prepare file to be sent to machine. Then you have to go out to the machine to get the machine ready and receive the file at the machine

Send Now will send the program now. Your machine must already be in a READY state to receive the file.