

Philips CNC – 432 (Maho)

NCnet 7.0 settings



Set these parameters on the machine

116 = 2400
117 = 2400

To set the controller in the Drip-feed mode

Drip feed is not available on this controller.



Set these parameters on the PC

Machine details

Machine name	MCH-1
Control system	Maho
Machine ID	01
Communication Channel	Serial Port
Port Number	Any free COM port)
Folder for PC to Machine transfer	Transmit directory
Folder for Machine to PC transfer	Receive directory
Baud rate	2400
Data bits	7
Parity	Even
Stop bits	2
Handshake	Hardware

General settings

Ignore this. Leave all data as it is.

Transmit settings

Wait period at start of transmission	10.00
Wait period after transmitting program	5.0
Size of transmit packet	0
Delay period after each packet	0
Wait for XON before transmitting program	No
Transmit comments?	Yes
Comment start character	(
Comment end character)
Translation mode for CR	Transmit as CR
Translation mode for LF	Transmit as LF
Acknowledgement and error (Mode of transmission)	Transmit descriptive message
ACK/ERR Message start text	% PM N9001
ACK/ERR Message start text	M30 %
Filter Null Character	Yes

NC Program settings

Program start string			
Program end string			
Characters to transmit at start		Number of Characters	
Characters to transmit at start		Number of Characters	

Receive settings

Wait period before receiving program	45.0
Wait period after receiving program	5.0
Transmit XON before transmitting program	No
Auto compare and save	Yes
Acknowledgements and errors	Transmit descriptive messages
Translation mode for CR	Ignore
Translation mode for LF	Save as CRLF
Ignore control characters other than CR-LF	Yes
Save Program between Start Characters and End Characters	No
Start Program reception after these characters are received	
End Program reception after these characters are received	

To set the PC in the Drip-feed mode

Drip feed is not available on this controller.



Cable connections

If the PC has 9 pin connector

Null modem		Full Handshake	
PC 9 pin	CNC 25 pin	PC 9 pin	CNC 25 pin
1	8	1	8
2	2	2	2
3	3	3	3
4	20	4	6
5	7	5	7
6	6	6	20
7	4	7	5
8	5	8	4

If the PC has 25 pin connector

Null modem		Full Handshake	
PC 25 pin	CNC 25 pin	PC 25 pin	CNC 25 pin
8	8	8	8
2	3	2	3
3	2	3	2
20	20	20	6
7	7	7	7
6	6	6	20
4	4	4	5
5	5	5	4

