

Delta CNC Controller ASCII

HMI Factory Setting:

Baud Rate: 9600. 7. Even. 1

Controller Station Number: 1

Control Area / Status Area: DT0/DT10

Applicable models: DOP-B / DOP-W / DOP-H / HMC series 、 DOP-100

Connection

a. RS-485

DOP 9 pin D-sub (RS-485)	Controller RS-485 Terminal
D+ (1)	D+
D- (6)	D-

Definition of PLC Read/Write Address

a. Registers

Type	Format	Read/Write Range	Data Length	Note
	Word No.(n); Bit No.(b) ; Axis No.(a) ; Code No.(c) ; Group No.(g); Parameter No.(p)			
T_Register	Tn	T0 - T255	Word	
C_Register	Cn	C0 - C63	Word	
D_Register	Dn	D0 - D1535	Word	
WRMEM_Register	WRMEMn	WRMEM0 - WRMEM1023	Word	Read Only
WRWMEM_Register	WRWMEMn	WRWMEM0 - WRWMEM1023	Word	
VRWMEM_Register	VRWMEMn	VRWMEM0 - VRWMEM1023	Word	
HC_Register	HCn	HC64 - HC77	Double Word	
G_Register	Gc/g	G0/0 - G8/19	Double Word	
MV_Register	MVn	MV10001 - MV11100	Double Word	

P_Register	Pn/a	P0/0 - P75/9	Double Word	
PAR_Register (AH)	WPARn.b/a	WPAR0.0/0 - WPAR9999.31/9	Double Word	
CUT_Register (AH)	CUTn/a	CUT1/0 - CUT100/9	Double Word	
SS_Register (AH)	SSn/a	SS12/0 -SS15/9	Double Word	
		SS41/0 -SS41/9		
BC_Register	BCn	BC0 - BC1279	Word	1
SP	SPn.a/g.p	SP0.0/0.0 - SP0.9/7.99	Word	Read Only

b. Contacts

Type	Format	Read/Write Range	Note
	Bit No. (b)		
X_Coil	Xb	X0 - X511	
Y_Coil	Yb	Y0 - Y511	
T_Coil	Tb	T0 - T255	
C_Coil	Cb	C0 - C77	
M_Coil	Mb	M0 - M3071	
A_Coil	Ab	A0 - A511	唯讀
RMEM_Coil	RMEMn.b	RMEM0.0 - RMEM1023.15	唯讀
RWMEM_Coil	RWMEMn.b	RWMEM0.0 - RWMEM1023.15	
VRWMEM_Coil	VWMEMn.b	VWMEM0.0 - VWMEM1023.15	



- 1) Device address must be the multiple of 64.