

HUST CNC

HMI Factory Setting:

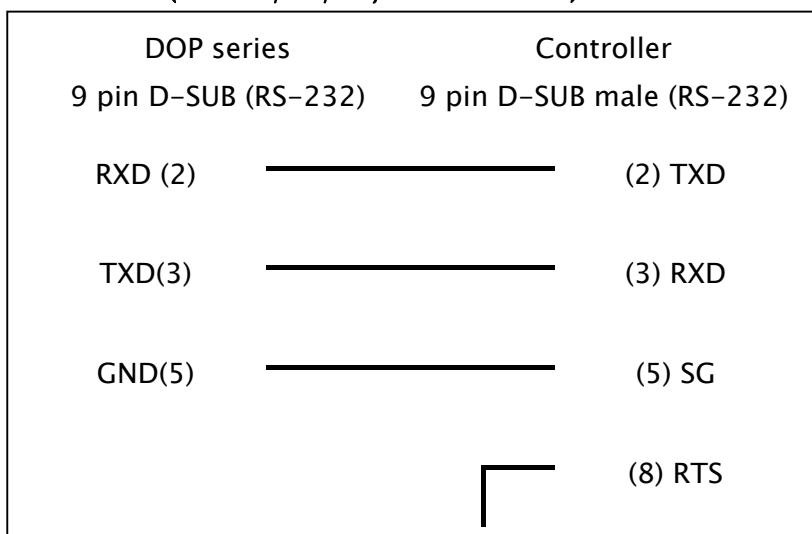
Baud rate: 9600, 7 ,Even, 2

Controller Station Number: 1

Control Area / Status Area: W0 / W10

Connection

a. RS-232 (DOP-A/AE/AS, DOP-B Series)



Definition of PLC Read/Write Address

a. Registers

Type	Format	Read/Write Range	Data Length	Note
	Word No. (n)			
Word Register	Wn	W0 - W13500	Word	
Double Word Register	Dn	D0 - D13500	Double Word	

b. Contacts

Type	Format	Read/Write Range	Note
	Word No. (n)		
	Bits No. (b)		
BIT_DEVICE_B	Bn.b	B0.0 - B13500.31	
BIT_DEVICE_I	Ib	I0 - I255	8 DW
BIT_DEVICE_O	Ob	O0 - O255	8 DW
BIT_DEVICE_C	Cb	C0 - C255	8 DW

Type	Format	Read/Write Range	Note
	Word No. (n) Bits No. (b)		
BIT_DEVICE_S	Sb	S0 - S255	8 DW
BIT_DEVICE_A	Ab	A0 - A1023	32 DW