

Configuring the Deckel Maho MillPlus

You have to configure the MillPlus to run with CIMCO NFS Server

Switch of the MillPlus and wait for 10 secs. Then switch on the controller again. When the controller starts up, then press the 'S' button before the MillPlus software starts up. This starts the Service menu. Select 'Ethernet' this opens the file TCPIP.CFG in the DOS editor. Alter the entries to suit your network. When done exit the editor saving the changes. Leave the Service menu with 'E'. Reboot the controller.

TCP/IP configuration file

More sections of [remote] are allowed --> more NFS servers to choose

More sections of [hardware] are allowed --> actually used hw is defined in [local] section
The keywords with an ';' placed in front can be omitted. The value shown is the default value

[hardware]

type = smc
irq = 9
i0 = 9
i1 = 3
i2 = 10
i3 = 11
iobase = 0x300

LE412 HARDWARE

this hw is an smc network device
irq used by network device driver
hardware connections of network device to irq's

io base address of network device

[hardware]

type = at-lantic

irq = 5
i0 = 3
i1 = 5
i2 = 9
i3 = 15
iobase = 0x240

VMEBUS HARDWARE

this hw is a ne2000 compatible network device
the VMEbus at/lantic is used in ne2000 compatible mode
irq used by network device driver
hardware connections of network device to irq's

io base address of network device

[local]

type = smc
connector = 10baseT
hostName = MillPlus
ipAddress = 192.168.1.200
subnetMask = 255.255.255.0
defaultRouter = 0.0.0.0

protocol = rfc
timezone = -1
summerTime = y

[remote]

ipAddress = 192.168.1.100
deviceName = PC
rootPath = /ncprog
timeOut = 1000

rwtimeOut = 600

readSize = 4096

writeSize = 4096
hardMount = y

autoMount = y
useUnixId = y
userId = 100
groupId = 100
dirCreateMode = 0777
fileCreateMode = 0777

configuration of CNC

the type of network device used must match a [hardware] type
10baseT: RJ45 (twisted pair), 10base2: bnc (coax)
CNC network name, maximum of 17 characters
tcp/ip address of the CNC ==> ask your network administrator for values
subnet mask of network ==> administrator for values
internet address of default router, 0.0.0.0: no router ==> ask your network administrator for value
Link layer protocol used rfc: Ethernet, ieee: IEEE 802
+ 1 hour of gmt :gmt + tz == local-> gmt=local - tz!
use automatic summertime correction (daylight saving)

configuration of a remote server

more than one remote sections allowed
TCP/IP address of the NFS server
Server name used inside CNC
Export name, for example /ncprog
units in milliseconds for timeout in server connection
0..100 000, 0: timeout set to 700 ms
timeout used for retry at read/write of NFS-files (time is doubled for each retry of same packet until timeOut)
packet size for data reception: 512 to 4096, or 0 = use server reported packet size
packet size for data transmission
yes/no continue mounting until successful
don't use 'y' if you're uncertain server is running
yes/no automatically mount when CNC initialises
use UserId/groupId to identify to the server

Unix style access right for dir-create: Octal number

Unix style access rights for file-create: Octal number