

WebAccess/CNC



TCP/IP & RS232

STEP 0: Confirm the version after WebAccess/CNC

V2.0.12 has been installed

The HAAS TCP/IP connection setting options will appear when the CNC Explorer driver is set as follows

Device Selection :

HAAS

HAAS Setting

Device Name

HAAS01

IP

192.168.1.1

Port

5051

Add

Search List

<input type="checkbox"/>	Device Name	IP	Port
<input type="checkbox"/>	HAAS01	192.168.1.1	5051

<<

<

1

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>>

Showing 1 to 1 of 1 entries

Delete

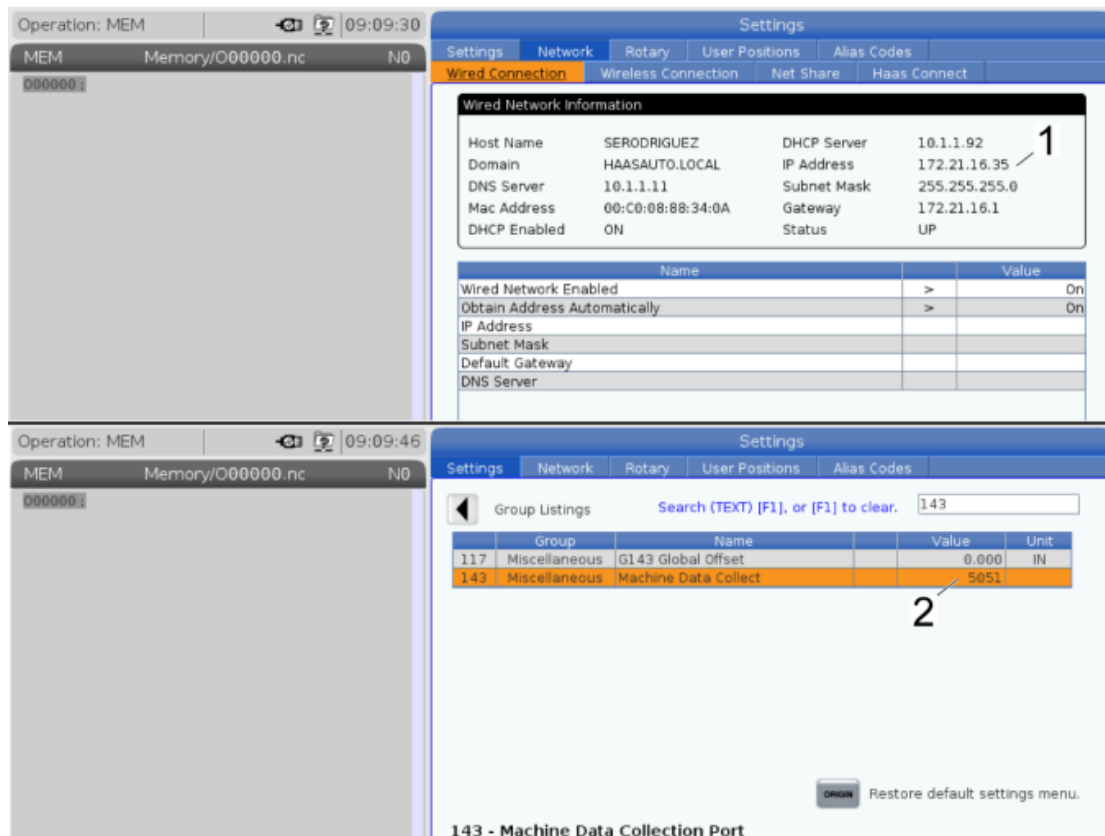
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Next >

Users can choose the connection method of TCP/IP or RS232 according to the Haas CNC machine. The default open port for TCP/IP is 5051. If RS232 is used, please add the COM Port of RS232 by yourself through the WebAccess/SCADA configuration interface, and select Haas driver and blocks and tags.

STEP 1: Ethernet IP & Port or RS232 Setting

- /Network/Wired Connection



Set the relevant setting parameters required for networking such as IP address, subnet mask, gateway and the port number of the Machine Data Collect of 143 (default port number is 5051). Among them, please do not use 8082 and 9090~9999 and other system used numbers for port labels

EX:

IP address: 172.21.16.35

Port number: 5051

Subnet Mask: 255.255.255.0

- /I/O/RS-232 or Press<SETNG GRAPH>

Please set the relevant setting to the corresponding number

11 BAUD RATE SELECT: 38400

12 PARITY SELECT: NONE

13 STOP BIT: 1

14 SYNCHRONIZATION: XON/XOFF

37 RS-232 DATA BITS: 8

143 MACHINE DATA COLLECT: ON

GENERALPROGRAMI/OCONTROL PANELSYSTEMMAINTENANCEPOWER SETTINGS

RS-232 PORTS

11	BAUD RATE SELECT	38400
12	PARITY SELECT	EVEN
13	STOP BIT	1
14	SYNCHRONIZATION	XON/XOFF
37	RS-232 DATA BITS	7
24	LEADER TO PUNCH	NONE
25	EOB PATTERN	CR LF
41	ADD SPACES RS232 OUT	ON
50	AUX AXIS SYNC	XON/XOFF
54	AUX AXIS BAUD RATE	4800
69	DPRNT LEADING SPACES	OFF
70	DPRNT OPEN/CLOS DCODE	ON
143	MACHINE DATA COLLECT	ON
187	MACHINE DATA ECHO	OFF
155	LOAD POCKET TABLES	OFF
156	SAVE OFFSET WITH PROG	OFF
157	OFFSET FORMAT TYPE	A

Setting 11 - Baud Rate Select

FULL DESCRIPTION:

HELP

 SEARCH TEXT : <TEXT> +

F2

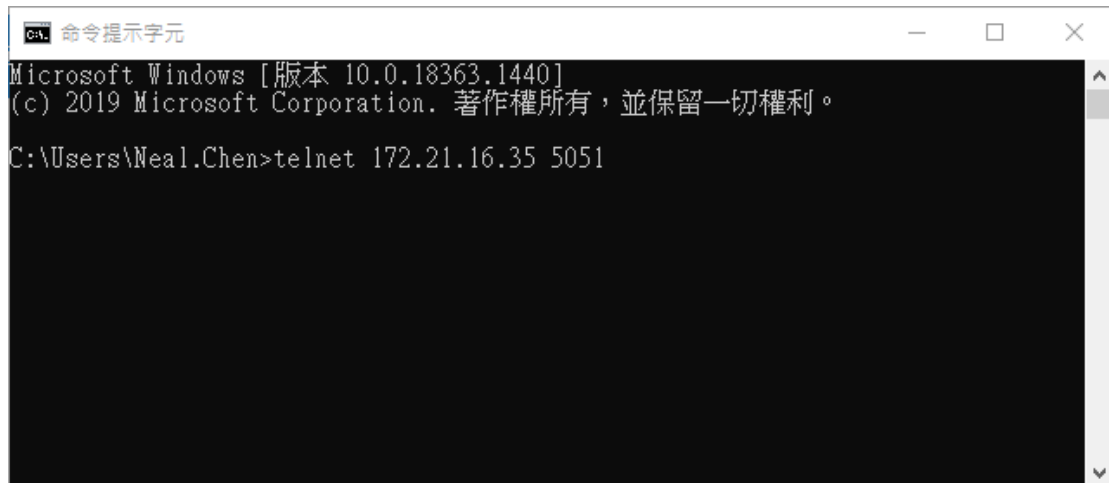
 SEARCH NUMBER: <#> +

STEP 2: Haas Network Connection Test

- Using Telnet tool to test whether the connection port to the CNC is normal

telnet IP address port number

EX: telnet 172.21.16.35 5051



A screenshot of a Windows Command Prompt window. The title bar reads '命令提示字元' (Command Prompt). The window content shows the following text: 'Microsoft Windows [版本 10.0.18363.1440]', '(c) 2019 Microsoft Corporation. 著作權所有，並保留一切權利。', and 'C:\Users\Neal.Chen>telnet 172.21.16.35 5051'. The command prompt is currently at the end of the command line, waiting for input.

STEP 3: CNC Explorer Setting

Run CNC Explorer

CNC Driver select HAAS setting

Device Selection :

HAAS

HAAS Setting

Device Name
HAAS02_TCP

IP
172.21.16.35

Port
5051

Add

Search List

<input type="checkbox"/> Device Name	IP	Port
<input type="checkbox"/> HAAS02_TCP	172.21.16.35	5051

«

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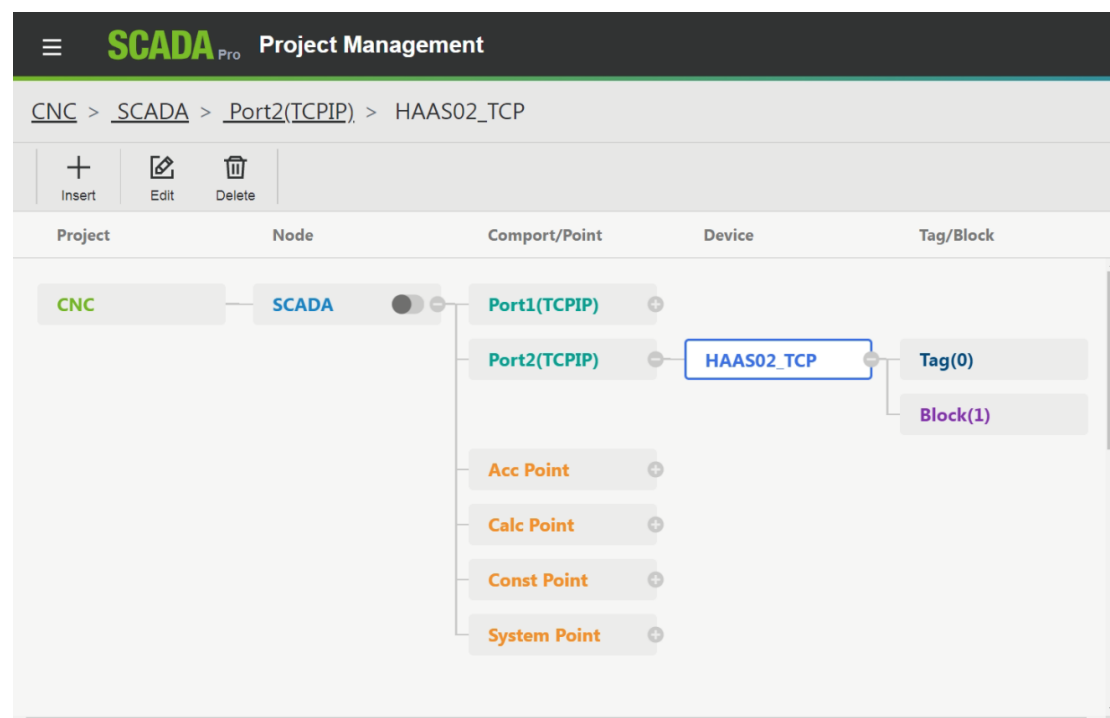
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Delete

< Previous

Next >



You can refer to the user manual of WebAccess CNC to add or delete tags to meet the actual needs

If the connection is a Haas RS232 device, please use WebAccess SCADA directly to set the corresponding COM, driver, device and block parameters

SCADA Pro

Project Management

POWERED BY WebAccess

CNC > SCADA > Port2(SERIAL)

+

Insert

✎

Edit

🗑

Delete

Project	Node	Comport/Point	Device	Tag/Block	Comport Property
CNC	SCADA	Port1(TCPIP)			
		Port2(SERIAL)	Haas01	Tag(0) Block(1)	<div>Interface Name SERIAL</div> <div>Comport Number 2</div> <div>Description Description</div> <div>Baud Rate (Unit:bps) 38400</div> <div>Data Bit (Unit:bits) 8</div> <div>Stop Bit (Unit:bits) 1</div> <div>Parity</div>
		Acc Point			
		Calc Point			
		Const Point			
		System Point			