

CNC: Okuma OSP-5000**CNC Parameters**

The OSP5000 controls have several generations of software available. Older OSPs frequently have trouble with RS232 communications because of internal software bugs, a slow processor, or incomplete documentation. Newer OSPs are fairly easy to communicate with.

There are several types of parameters in an OSP control. There is a **PARAMETER** button near the mode select buttons on the main panel. Press this button, then press the **ITEM** (up) or **ITEM** (down) soft keys to show the different parameter types. At each parameter type page, you can press the **PAGE UP** or **PAGE DOWN** keys. The page up/down keys usually are marked only with a symbol, and are near the cursor keys.

To change a parameter in the OSP, you must display the parameter page you want with the **ITEM** soft keys, then cursor to the parameter you want to change, press the **SET** soft key, then the new data, and press **WRITE**.

The following parameter settings are for 4800, 1 stop-bit, ISO/even parity, DC codes enabled (Xon/Xoff). If the OSP doesn't receive data within 30 seconds of pressing the **READ** button, an alarm will occur. Additional descriptions of these important parameters for RS232 communications are in the Okuma maintenance manual:

OPTION PARAMETERS (WORD)

1 (number of feed holes punched in leader) Set to: 1
#34 (timeout setting for device CN0) Set to: 30
#39 (baudrate of device CN0) Set to: 4800
#44 (device number used when punching) Set to: 0 (means CN0)
#54 (device number used when reading) Set to: 1 (means CN0)

OPTIONAL PARAMETERS (BIT)

01: 0 0 0 0 0 0 1 1
12: 1 0 1 0 1 0 1 1 (CN0:)

PC DNC Settings

Baud: 4800
Code: 7 data bits / ASCII Even
Stop Bits: 1
EOB: LF

Okuma Osp 5000 Parameter Manual

David Kirk



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