

**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

**AW Chickering**



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## **Table of Contents Okuma Osp 5000 Parameter Manual**

1. Understanding the eBook Okuma Osp 5000 Parameter Manual
  - The Rise of Digital Reading Okuma Osp 5000 Parameter Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Okuma Osp 5000 Parameter Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Okuma Osp 5000 Parameter Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Okuma Osp 5000 Parameter Manual
  - Personalized Recommendations
  - Okuma Osp 5000 Parameter Manual User Reviews and Ratings
  - Okuma Osp 5000 Parameter Manual and Bestseller Lists
5. Accessing Okuma Osp 5000 Parameter Manual Free and Paid eBooks
  - Okuma Osp 5000 Parameter Manual Public Domain eBooks
  - Okuma Osp 5000 Parameter Manual eBook Subscription Services
  - Okuma Osp 5000 Parameter Manual Budget-Friendly Options
6. Navigating Okuma Osp 5000 Parameter Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Okuma Osp 5000 Parameter Manual Compatibility with Devices
  - Okuma Osp 5000 Parameter Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Okuma Osp 5000 Parameter Manual
  - Highlighting and Note-Taking Okuma Osp 5000 Parameter Manual
  - Interactive Elements Okuma Osp 5000 Parameter Manual
8. Staying Engaged with Okuma Osp 5000 Parameter Manual

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Okuma Osp 5000 Parameter Manual
- 9. Balancing eBooks and Physical Books Okuma Osp 5000 Parameter Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Okuma Osp 5000 Parameter Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Okuma Osp 5000 Parameter Manual
  - Setting Reading Goals Okuma Osp 5000 Parameter Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Okuma Osp 5000 Parameter Manual
  - Fact-Checking eBook Content of Okuma Osp 5000 Parameter Manual
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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