

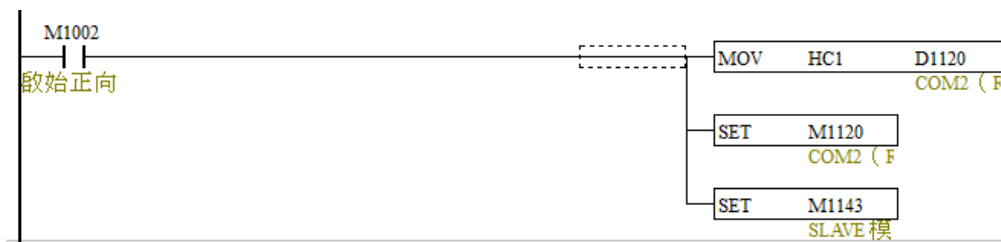
20PM G-Code Download Function Instruction

PLC Setting

- 1 In this document, HMI and PLC all use COM2 RS485 for communication.
- 2 G-Code download function only support RTU mode, so you need to change PLC communication setting first.

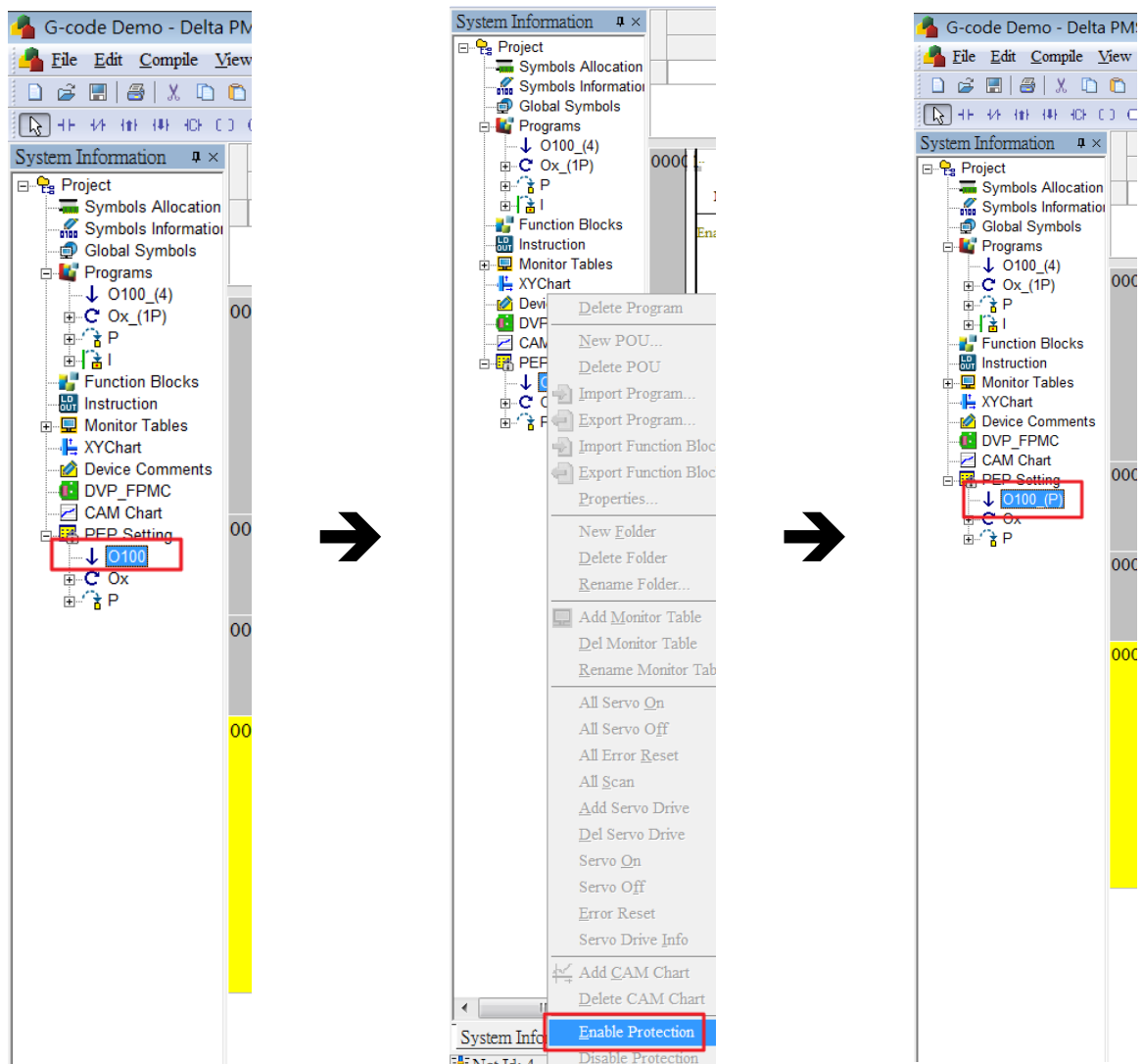
2.1 Open PMSoft

2.2 Set 20PM COM2 to Modbus RTU, 115200, 8, N, 1 as follow command.

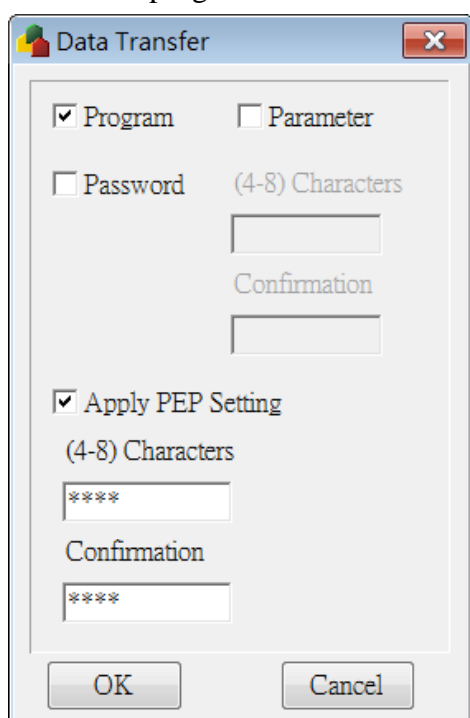


Notice : When using RTU mode, communication data length must be 8, don't use 7.

2.3 Enable PEP protection for O100.



2.4 Download program to 20PM and enable "Apply PEP setting"。



The 'Data Transfer' dialog box contains the following elements:

- ☒ Program ☐ Parameter
- ☐ Password (4-8) Characters

Confirmation
- ☒ Apply PEP Setting
(4-8) Characters

Confirmation

- OK Cancel

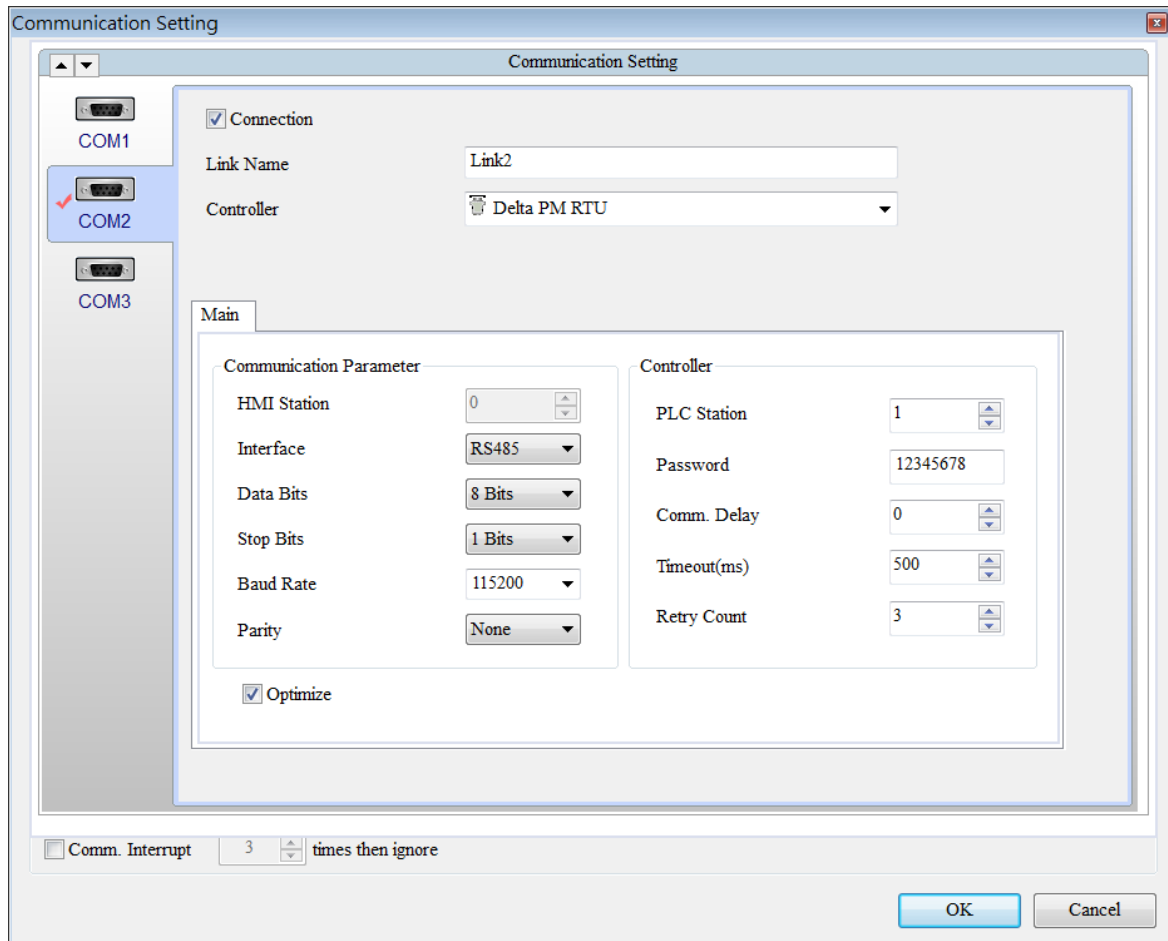
2.5 Re-power 20PM after download.

HMI 設定

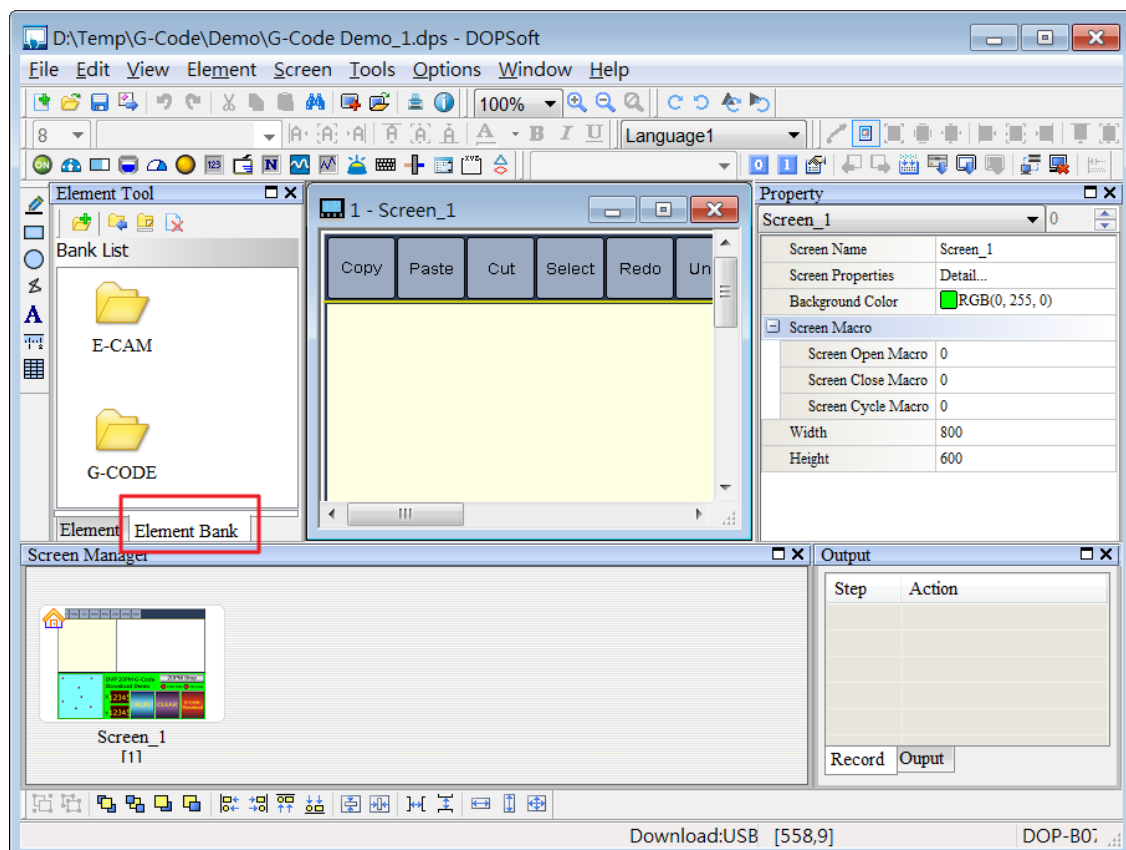
- 20PM G-Code download function only supports DOP-B07PS415 and DOP-B07PS515 at this time.

Series	HMI List			
DOP-B series ▼	Model Type	Resolution	Color	
	B07S411K	800 * 480	65536 Colors	
	B07S415	800 * 480	65536 Colors	
	B07PS415	800 * 480	65536 Colors	
	B07E415	800 * 480	65536 Colors	
	B07S515	800 * 600	65536 Colors	
	B07PS515	800 * 600	65536 Colors	
	B07E515	800 * 600	65536 Colors	
	B08S515	800 * 600	65536 Colors	
	B08E515	800 * 600	65536 Colors	
	B10S411	800 * 480	65536 Colors	
	B10S511	800 * 600	65536 Colors	
	B10S615	1024 * 600	65536 Colors	
	B10E615	1024 * 600	65536 Colors	

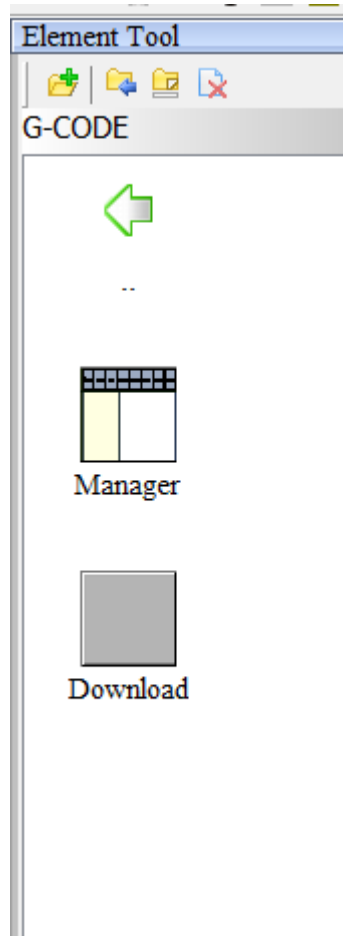
2. HMI controller must select "Delta PM RTU".



3. Choose G-Code folder in Element Bank

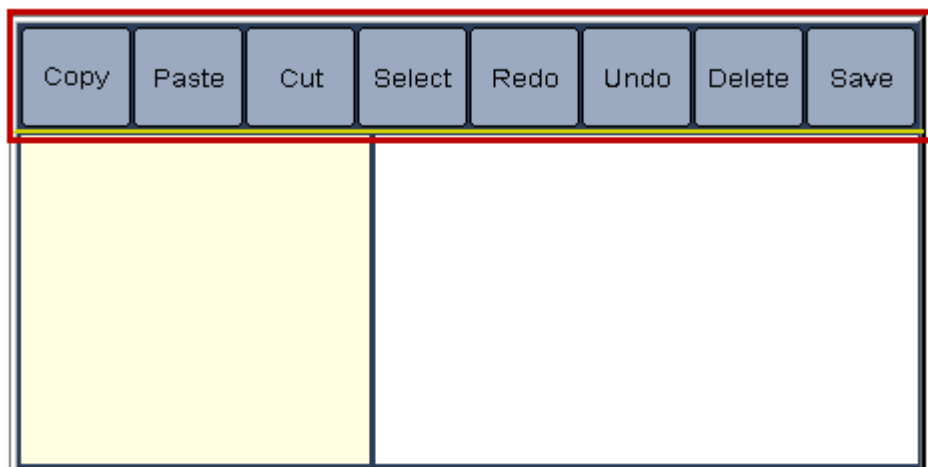


4. There are 2 elements in the G-Code folder, follow are explanation of elements.



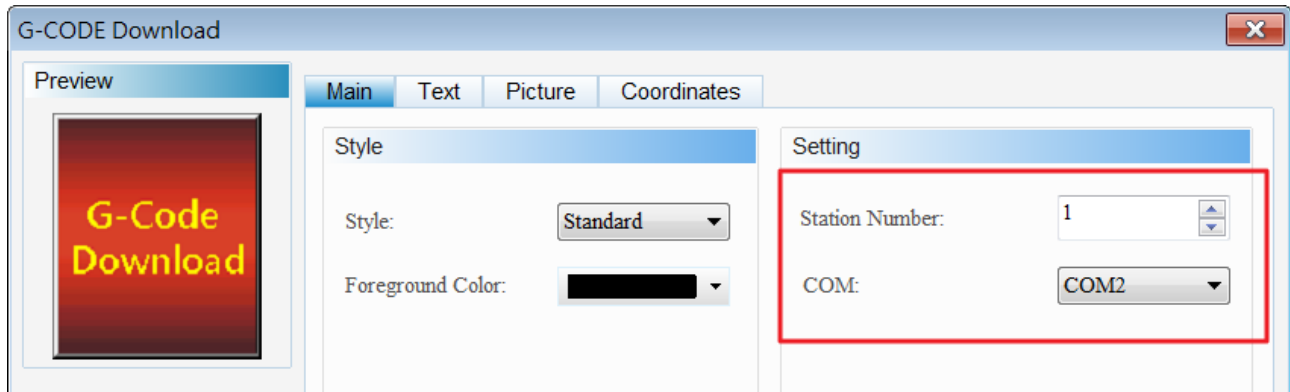
(1) G-Code file manager

This element only provide preview and select file function. The button in the red square doesn't work now.



(2) G-Code download

After select the G-code file, use this element to execute G-code download process.



Supported station number range is 1~255 ;

COM must set same as the Delta PM RTU setting in the Communication setting.

(3) G-Code supported format

Support nc and fgc format now.