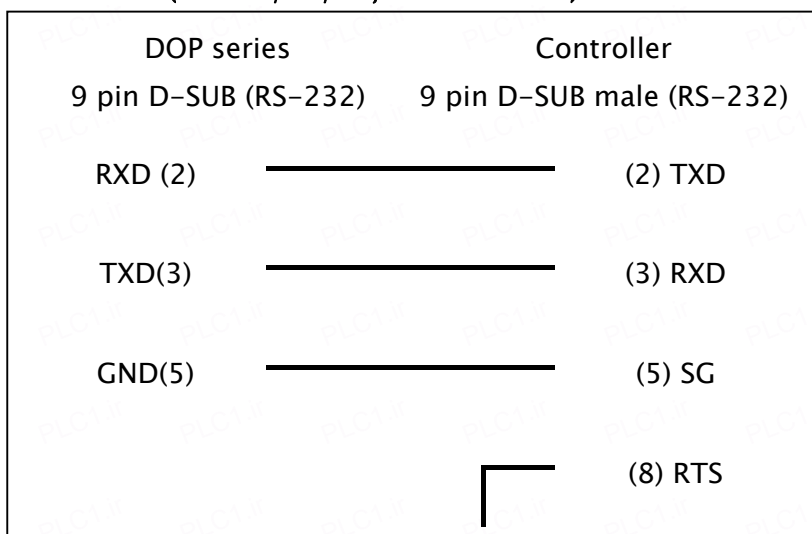# HUST CNC

HMI Factory Setting:

Baud rate: 9600, 7 ,Even, 2

Controller Station Number: 1

Control Area / Status Area: W0 / W10

Connection

a. RS-232 (DOP-A/AE/AS, DOP-B Series)

```
           DOP series              Controller
        9 pin D-SUB (RS-232)   9 pin D-SUB male (RS-232)


           RXD (2) ──────────────── (2) TXD


           TXD(3) ──────────────── (3) RXD


           GND(5) ──────────────── (5) SG


                              ┌──── (8) RTS
```

Definition of PLC Read/Write Address

a. Registers

Type	Format Word No. (n)	Read/Write Range	Data Length	Note
Word Register	Wn	W0 – W13500	Word	
Double Word Register	Dn	D0 – D13500	Double Word	

b. Contacts

Type	Format Word No. (n) Bits No. (b)	Read/Write Range	Note
BIT_DEVICE_B	Bn.b	B0.0 – B13500.31	
BIT_DEVICE_I	Ib	I0 – I255	8 DW
BIT_DEVICE_O	Ob	O0 – O255	8 DW
BIT_DEVICE_C	Cb	C0 – C255	8 DW

Type	Format Word No. (n) Bits No. (b)	Read/Write Range	Note
BIT_DEVICE_S	Sb	S0 – S255	8 DW
BIT_DEVICE_A	Ab	A0 – A1023	32 DW