**20PM G-Code Download Function Instruction**

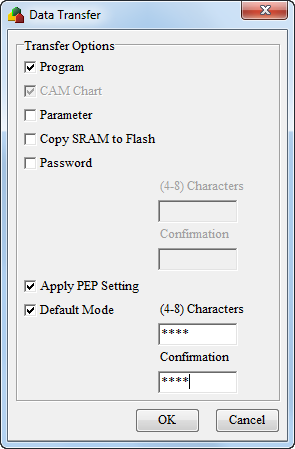
**PLC Setting**

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.
   1. Open PMSoft
   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.

* 1. Download program to 20PM, enable the “Apply PEP setting” and “Default Mode”.



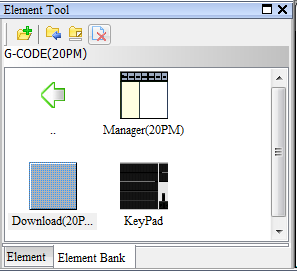
Notice：The “Default Mode” will be protected all the POU (expect OX0) which don't be erased when download the G-code from HMI. All G-code download from HMI will be saved only in the OX0.

**HMI** Setting

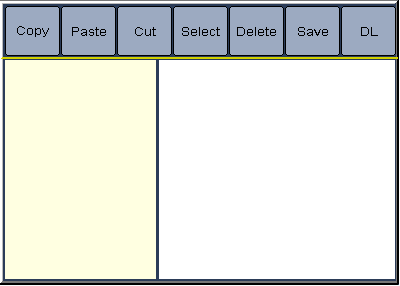
1. 20PM G-Code download function only supports DOP-B07PS415 and DOP-B07PS515 at this time   
   
2. HMI controller must select ”Delta PM RTU”.   
   
3. Choose G-Code folder in Element Bank



1. There are 3 elements in the G-Code folder, explanation of elements as following:

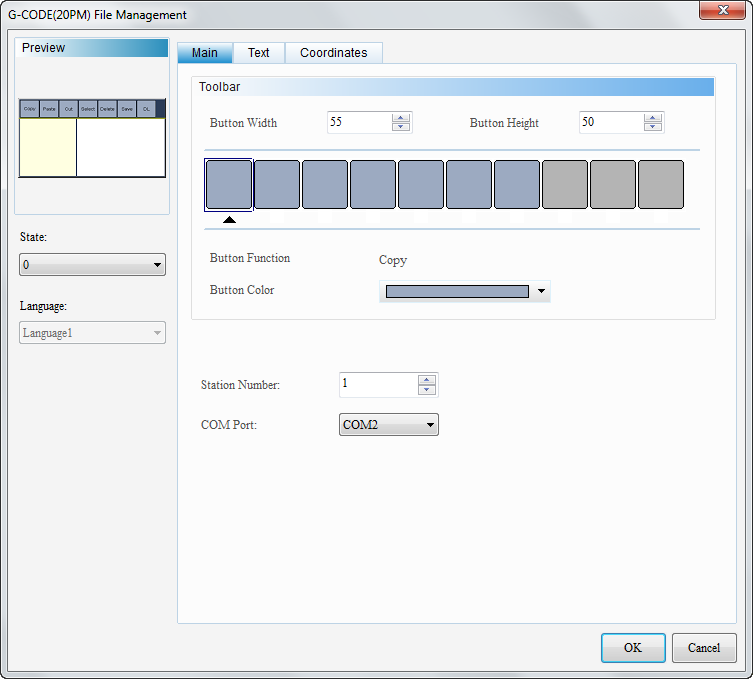


1. G-Code file manager  
   This element provide preview ,select file and download (DL) function and also has the edit function including save, copy, paste, cut, select and delete.



Double-click the manager, you can set the communication comport and station number.  
Supported station number range is 1~255.

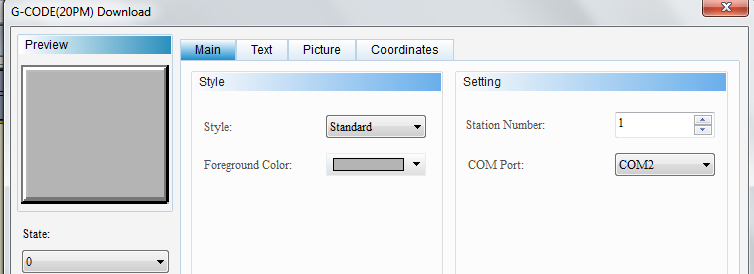
COM must set same as the Delta PM RTU setting in the Communication setting.



1. G-Code download

The functionality of download element is same as the DL button of manage element

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

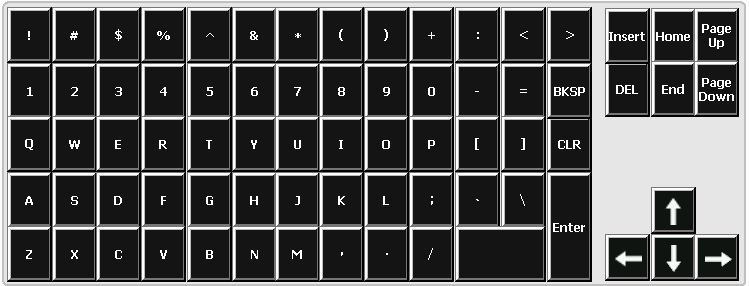


Supported station number range is 1~255；

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

1. Keypad element

You can use the keypad element for edit and select the G-code file.



Notice: Currently, G-Code supported the format including txt, nc and fgc .