



Mazatrol T-1 or M-1



Figure 1: Mazatrol T-1 Control



Figure 2: Data output options



Figure 3: DATA IN and DATA OUT soft keys, INPUT hard key and the display showing END indicating the completion of DATA IN

Refer to the figures above when following the instructions to send or receive files from the Mazatrol on a M-1 or T-1 control.

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To Send CMT programs out to the USB-CNC:

On the USBCNC unit:

1. Choose the CNC to USB option on the USBCNC unit
2. Press the key under Start on the USBCNC unit (press DIR to choose a different file name to save to).

On the Mazatrol:

3. Press Menu Select on Mazatrol
4. Press PROGRAM Softkey
5. Press PROGRAM FILE Softkey
6. Press DATA IN OUT Softkey on Mazatrol
7. Press CMT I/O Softkey on Mazatrol
8. Press SAVE CMT Softkey
9. Enter Work #
9. Press INPUT
10. Press START on Mazatrol
11. When it shows “END” on screen it is complete

On the USBCNC unit:

12. Select Done on the USBCNC unit

To receive CMT programs into the Mazatrol from USB-CNC:

On the USBCNC unit:

1. Choose the USB to CNC option on the USBCNC unit
2. Choose the file to be sent to the CNC
3. Press button under Start on the USBCNC unit

On the Mazatrol:

4. Press Menu Select on Mazatrol
5. Press PROGRAM Softkey
6. Press PROGRAM FILE Softkey
7. Press DATA IN OUT Softkey on Mazatrol
8. Press CMT I/O Softkey on Mazatrol
9. Press LOAD CMT Softkey
10. Enter Work #
11. Press the INPUT button
12. Press START



Mazatrol T-2, M-2, M Plus or M32



Figure 4: Mazatrol M Plus



Figure 5: LANCNC on Mazatrol M Plus



Figure 6: Save or Load programs on a Mazatrol M Plus control



Figure 7: Parameters on M Plus control



Figure 8: Input button the M Plus

Figure 10: M-2 control screen



Figure 9: Mazatrol will probably have two DB25 female connectors, the one labeled Cassette must be used to save and load Mazatrol conversational programs. Sometimes the port is label with a picture of a cassette tape. The other DB25 is used only for EIA G code programs

Refer to the figures above when following the instructions to send or receive files from the Mazatrol on a M-2, T-2, M Plus, T Plus, M32 or T32 control.



To Send CMT programs out to the USB-CNC:

On the USBCNC unit:

1. Choose the CNC to USB option on the USBCNC unit
2. Press the key under Start on the USBCNC unit (press DIR to choose a different file name to save to).

On the Mazatrol:

3. Press Menu Select on Mazatrol
4. Press PROGRAM Softkey
5. Press PROGRAM FILE Softkey
6. Press DATA IN OUT Softkey on Mazatrol
7. Press CMT I/O Softkey on Mazatrol
8. Press SAVE CMT Softkey
9. Enter Work #
9. Press INPUT
10. Press START on Mazatrol
11. When it shows “END” on screen it is complete

On the USBCNC unit:

12. Select Done on the USBCNC unit

To receive CMT programs into the Mazatrol from USB-CNC:

On the USBCNC unit:

1. Choose the USB to CNC option on the USBCNC unit
2. Choose the file to be sent to the CNC
3. Press button under Start on the USBCNC unit

On the Mazatrol:

4. Press Menu Select on Mazatrol
5. Press PROGRAM Softkey
6. Press PROGRAM FILE Softkey
7. Press DATA IN OUT Softkey on Mazatrol
8. Press CMT I/O Softkey on Mazatrol
9. Press LOAD CMT Softkey
10. Enter Work #
11. Press the INPUT button
12. Press START



For Mazak machines that are going to use the CMT protocol the parameters should be:

Baud Rate: 4800

Data/Parity/Stop: 8, N, 2

Flow Control:

CMT Ver 1 (Typically for the older controls, if doesn't verify use Ver 2)

CMT Ver 2 (Typically for the newer controls, if doesn't verify use Ver 1)

End of Block Delay: No delay

End of Block Char: none/binary

Start of Tx: none

End of Tx: none

Start Rx: Automatic