



DNC - Networking

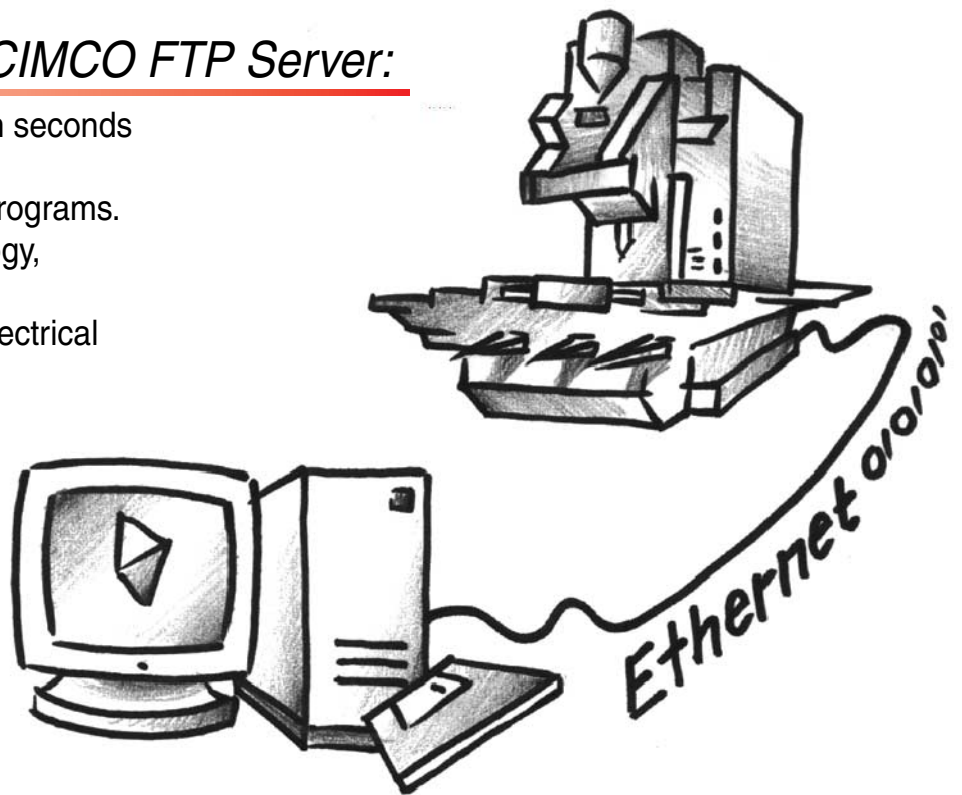
Using standard Ethernet connections with FTP or NFS

Modern CNC Machine Tools are equipped with a standard Ethernet connection, frequently using the FTP or NFS Server Software.

The speed and flexibility of Ethernet connections will make this way of transferring NC programs the choice of most - if not all - companies using CNC machines in the future.

CIMCO NFS Server / CIMCO FTP Server:

- Transfer large NC programs in seconds rather than minutes.
- More reliable transfer of NC programs.
- Standard networking technology, software and hardware.
- Further distances, and less electrical noise disturbances.



NC Programs

Most implementations are configured so that all NC programs for a specific CNC Machine Tool are located in a certain directory on the PC. On the CNC control, when requesting a program from the PC all the NC programs are listed and can be selected by the operator. An NC program is transferred from the PC to the CNC control in seconds rather than minutes.

CNC controls

using FTP or NFS
Deckel Dialog 112,
Millplus, Heidenhain,
and other CNC controls
use either FTP or NFS
for standard Ethernet
networking connection.

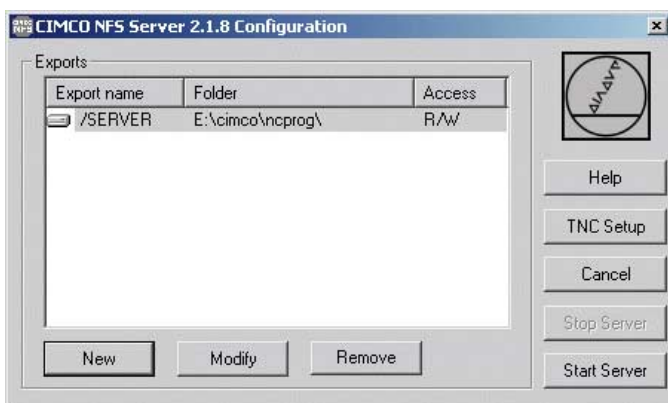
Networking with NFS and CNC Machines

The CIMCO NFS Server enables a CNC Machine to access the files in a shared folder on a server, using a standard network.

The shared folders on the server are called exports. When a CNC Machine connects to the NFS Server, it must specify which export to use. If the CNC Machine is allowed to access the export, it can read and write (if allowed) files in the exported folder.

The NFS Server can handle multiple exports, so it is possible to export more than one folder on the same computer.

It is also possible to export the same folder with different export names and access rights. This way, you can create a setup where some machines have read access to the exported folder while other machines have both read and write access.



CIMCO NFS Server 2.1 Configuration

Access control

You can configure the IP addresses of the machines that are allowed to access each export. If you do not specify any IP addresses, all machines are allowed access.

Furthermore, it is possible to make an export read-only, in which case the machines that access the folder can not modify or delete any files in the exported folder.

Configuring the NFS Server

You use the CIMCO NFS Configuration program to set up and start the NFS Server. On Windows 95/98 computers, the NFS Server runs as a normal program in the background. It is possible to start the NFS Server automatically each time the computer starts. On Windows NT/Windows 2000 computers, the server runs as a service. You must login with administrator privileges when configuring and starting the CIMCO NFS Server in Windows NT/Windows 2000.

Security

It is not recommended to start the NFS Server on a computer on a network connected to the Internet, without specifying an access control list. Otherwise, it may be possible for intruders on the Internet to access the exported files.

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