

Please call and have your questions answered. 941-322-2286.

## **Quick Start**

Read and or print out the ShopLinkFlashManual.pdf located on the supplied flash drive in the \IMAGE folder.

Typical Haas serial settings for ShopLink FLASH that will match the default settings in config.ini.

9600, Even parity, 7 data bits, 1 stop bit, **SYNCHRONIZATION DC CODES** (this is essential)

CHANGING MACHINE PARAMETERS

1. PRESS SETTING/GRAPH KEY.
  2. PRESS PAGE DOWN UNTIL RS232 PORTS ARE DISPLAYED ON THE TOP OF THE SCREEN.
  3. USE UP DOWN CURSOR TO HIGHLIGHT PARAMETER TO CHANGE THE LEFT, RIGHT ARROW TO CHOOSE OPTIONS, THEN PRESS WRITE KEY TO MAKE PERMANENT.
- PARAMETERS

11 BAUD RATE SELECT 9600

12 PARITY SELECT EVEN

13 STOP BIT 1

14 **SYNCHRONIZATION DC CODES**

37 RS-232 DATA BITS 7

24 LEADER PUNCH NONE

25 EOB PATTERN CR LF

41 ADD SPACES RS232 OUT ON



Insert the supplied flash drive into your computer. Open your desired GCODE program in your favorite editor. Then follow this procedure, FILE, SAVE AS, navigate to the FOLDER0 on the flash drive, select the SEND.TXT file already present and then click SAVE, when the dialog "overwrite" appears click YES. Note, you are always going to be overwriting the SEND.TXT file in FOLDER0 with the file you desire to load into the CNC. Close the editor and any open windows showing the supplied flash drive (it won't eject properly if you do not close all windows that have displayed the flash drive) then Use the SAFELY REMOVE HARDWARE (green arrow icon in lower right hand bar) to remove the flash drive.

Attach the ShopLink FLASH to the Haas serial port 1, plug in the FLASH box power, turn OFF power if ON. Note, insure the FLASH box is OFF when inserting or removing the flash drive.

Insert the flash drive and select "0" on the panel switch.

Power up the FLASH and observe the POWER (green LED) then the FILE (amber LED) lights.

Now the FLASH box is listening to your Haas waiting for the RECEIVE command to send the SEND.TXT file.

At the Haas operator panel

1. Press "Program list" button
2. Cursor down to "ALL"
3. Press the "Receive" or "Receive RS232" button
4. Observe the loading of the file